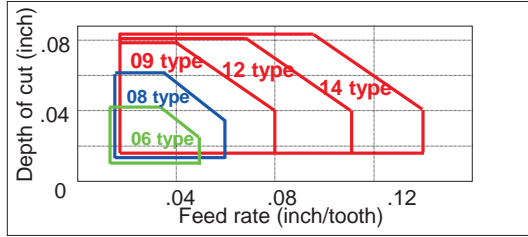


How to use AJX high feed radius cutter

1.Features



- ①The AJX can achieve high feed rates due to employing a double-phased straight main cutting edge with a minor edge.
- ②Even when using a large overhang stable machining can be conducted.
- ③The AJX can be use as a radius milling cutter.
- ④All items are standardized with through coolant holes.

2.How to locate the insert

- ①Prior to locating the insert, air blow the insert seat.
- ②Press firmly down on the insert when tightening the insert screw.
- ③Once the insert is firmly located, clamp the bridge down.
- ④To index the insert, the clamp bridge does not need to be completely removed.
- ⑤To prevent the screw from seizing, use anti-seize cream, additionally ensure that the clamping forces are not exceeded.
(※AJXU06 and 08type do not use clamp bridge.)

3. How to attach the tool

3.1 Arbor type

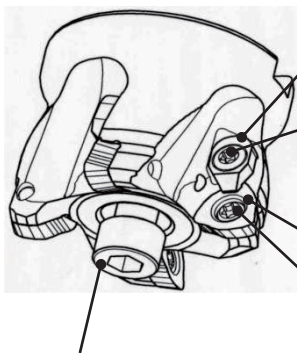
- ①Before attaching to an arbor , ensure that all locating faces have been cleaned and are free of any obstructions.
- ②Set the tool into the arbor, and locate using the set bolt provided with the tool.
- ③The set bolt provided with the AJX is specially designed for through coolant.
- ④To prevent the screw from seizing, use anti-seize cream, additionally ensure that the clamping forces are not exceeded.

3.2 Shank type

Before attaching to a milling holder , ensure that all locating faces have been cleaned and are free of any obstructions.

4. Various parts & torque settings

Arbor type



Set Bolt

HSCU37513H : 29(Ft.Lbs)

HSCU50014H : 59(Ft.Lbs)

HSCU75016H :110(Ft.Lbs)

MBA20040H : 236(Ft.Lbs)

MBA24045H : 383(Ft.Lbs)

MBAU75016H : 236(Ft.Lbs)

MBAU100016H : 383(Ft.Lbs)

Clamp bridge
(spring is inside)

Clamp bridge screw

AJS3010T10 : 1.1(Ft.Lbs)

AJS4012T15 : 2.6(Ft.Lbs)

AJS5014T25 : 5.5(Ft.Lbs)

Insert

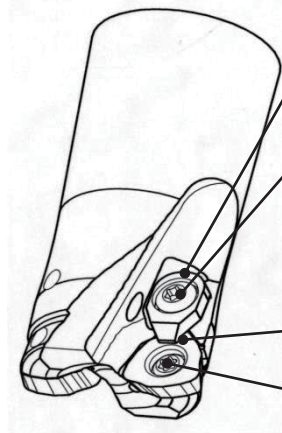
Insert screw

TS351 : 1.8(Ft.Lbs)

TS43 : 2.6(Ft.Lbs)

TS54 : 5.5(Ft.Lbs)

Shank type



Clamp bridge
(spring is inside)

Clamp bridge screw

AJS3010T10 : 1.1(Ft.Lbs)

AJS4012T15 : 2.6(Ft.Lbs)

AJS5014T25 : 5.5(Ft.Lbs)

Insert

Insert screw

TS25 : 0.7(Ft.Lbs)

TS33 : 1.1(Ft.Lbs)

TS351 : 1.8(Ft.Lbs)

TS407 : 2.6(Ft.Lbs)

TS43 : 2.6(Ft.Lbs)

TS54 : 5.5(Ft.Lbs)