

**1. Applicable inserts**

AXD4000 has two types of holder. A type is used for small corner radius insert, and B type for large corner radius insert.

Details are shown in the below table. Please use appropriate holder.

Holder	Insert corner radius
AXD4000*****A (A type holder)	0.4 – 3.2
AXD4000*****B (B type holder)	4 – 5

**2. How to locate the insert**

1. Prior to locating the insert, air blow the insert seat.
2. Press firmly down on the insert when tightening the clamp screw.
3. When tightening the clamp screws, follow the order in Figure 1.
4. To prevent the screw from seizing, use anti-seize lubricant, and tighten at the prescribed tightening torque.  
The prescribed tightening torque value is 1.5N·m (1.11ft·lb).
5. Use of the correct insert clamp screws is especially important to ensure overall tool safety.

Be sure to use clamp screws with the appropriate code number.

Clamp screw number	Tightening torque	Shape
TS3SB	1.5N·m (1.11ft·lb)	

6. Ensure that there is no space between the insert and the insert seat.

**3. Maximum allowable spindle speed**

1. The maximum allowable spindle speeds are shown in Table 1.

Ensure that the cutter operates under the maximum allowable spindle speed.

The maximum allowable spindle speeds for safety purposes are determined in accordance with ISO15641 (Milling Cutters for high speed machining–Safety requirements).

Table 1 Maximum allowable spindle speed (min<sup>-1</sup>)

Cutting edge diameter D1	φ 25	φ 32	φ 40
Max. allowable spindle speed	49,000	48,000	41,000

2. Even when operating under the maximum allowable spindle speed, if the spindle speed is equal to or higher than the values shown in Table 2, it is recommended that the balance quality (with the chuck) conforms to G6.3 or better based on ISO1940.

It is also recommended to replace the clamp screws with new ones when changing inserts.

Furthermore, ensure that the tools are used in an enclosed area for safety reasons.

\* The balance quality of the holder (without inserts and clamp screws) is G6.3 or better at 10,000min<sup>-1</sup>.

Table 2 Maximum spindle speed when balancing with the chuck has not been achieved (min<sup>-1</sup>)

Cutting edge diameter D1	φ 25	φ 32	φ 40
Max. spindle speed	12,000	9,500	7,600

**4. Other instruction**

1. When setting the spindle speed, take into consideration the maximum allowable spindle speed of milling chuck.
2. Only use the inserts and parts provided by Mitsubishi Materials for this tool.  
If other parts are used, the performance will be inferior and safety can not be assured.
3. Please replace the clamp screw periodically since they are consumption parts.  
Do not use damaged or worn clamp screws.
4. Please refer to catalog about cutting conditions.
5. When using AXD with a long overhang, please set the cutting conditions low ( feed, depth of cut, width of cut , etc..)
6. When using AXD for ramping and helical milling, the feed must be 0.05mm/tooth or under.
7. The inserts have sharp cutting edges and handling them with bare hands may cause injuries.  
Always wear safety gloves when handling the inserts.

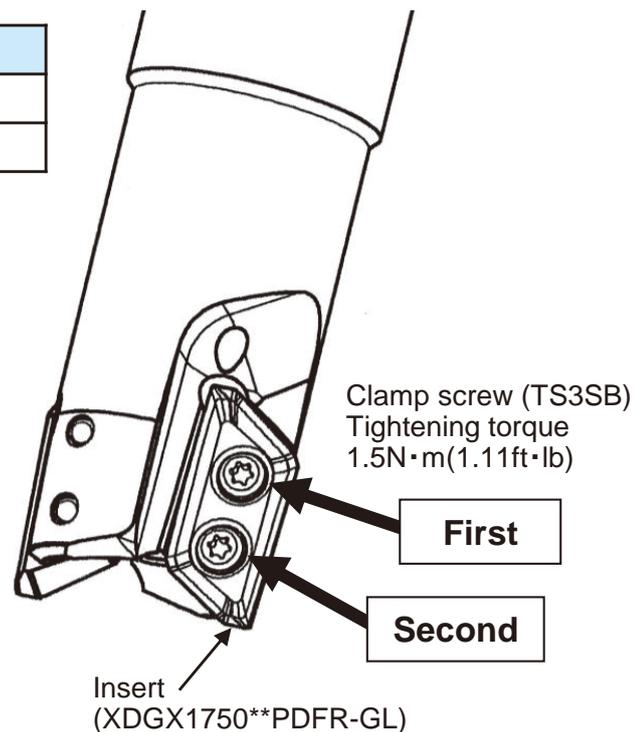


Fig. 1 Tightening order