

Instruction manual for APX3000 arbor type (mm)

1. Possible setting the insert

You can set the only insert which doesn't have bigger nose-radius than R1.6 with original holder without processing.

If you want to set the insert which has nose-R bigger than R1.6, you must process the holder because of extreme overhung.

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 clamping screw.
3. To prevent the screw from seizing, use anti-seize cream, additionally ensure that the clamping forces are not exceeded. (Clamp Torque=1.0Nm)
4. Ensure that there is no space between the insert and the insert seat.

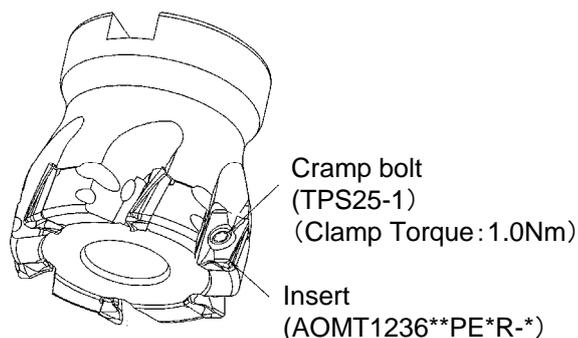


Fig1. Insert setting

3. How to attach the tool (arbor)

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

Table.1 Set bolt

| Figure | Order No. | Clamp Torque[Nm] | Holder |
|--------|-----------|------------------|-------------------|
| | HSC08030H | 24 | APX3000-032A05RA |
| | | | APX3000-040A06RA |
| | HSC10030H | 40 | APX3000-050A07ERA |
| | | | APX3000-063A08RA |
| | HSC12035H | 80 | APX3000R08009CA |
| | | | APX3000-080A09RA |
| | HSC16040H | 150 | APX3000R10011DA |
| | | | APX3000-100A11RA |

4. etc.

1. Please use original parts. If other parts are used, the performance will be inferior and safety can not be assured
2. Please replace the clamp screw periodically since they are consumption parts.
Don't use the clamping screw whose TORX-Plus hole is damaged and wear progresses.
3. Please refer to tools-news about the cutting conditions.
4. If you use APX with long arbor, you must set the cutting condition low (feed, depth of cut, width of cut , etc..)
5. In ramping , you must use APX in low feed condition.