

# Instruction manual for APX3000 screw-in type (mm)

## 1. Possible setting the insert

You can set the only insert which doesn't have nose-radius bigger 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.

Clamp screw	Adopted Diam.
TPS25	~ $\Phi$ 20
TPS25-1	$\Phi$ 25~

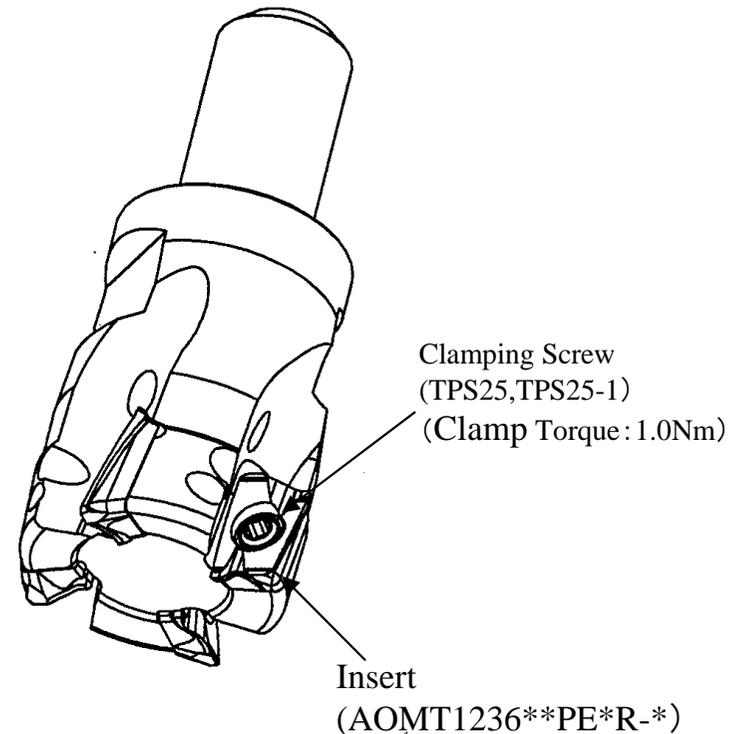


Fig1. Insert setting

### 3. Parts

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

### 4. etc

1. Please refer to tools-news about the cutting conditions.
2. There is a danger of burn, if it is touched soon after cutting is done.
3. Don't touch the cutting edge of the insert with bare hand to prevent injury.
4. Compared with standard shank, you must set the cutting conditions low ( feed, depth of cut, width of cut , etc..)
5. In ramping , you must use APX in a low feed condition.