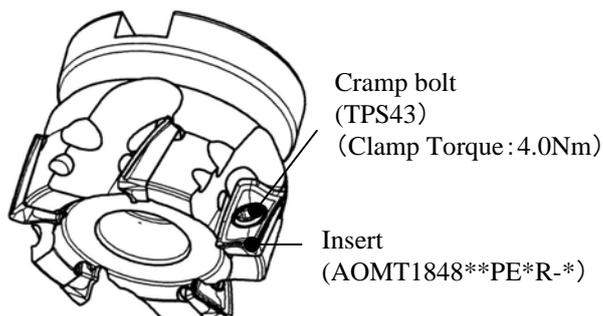


Instruction manual for APX4000 arbor type (mm)

Fig1. Insert setting

1. 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=4.0Nm)
4. Ensure that there is no space between the insert and the insert seat.



2.How to attach the tool (arbor)

1. Before attaching to an arbor, ensure that all locating faces 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	APX4000-040A04RA
	HSC10030H	40	APX4000-050A05RA
	HSC10030H	40	APX4000-063A06RA
	HSC12035H	80	APX4000R08007CA APX4000-080A07RA
	HSC16040H	150	APX4000R10008DA APX4000-100A08RA
	MBA20030H	320	APX4000R12509EA APX4000-125A09RA
	MBA24045H	520	APX4000R16010FA APX4000-160A10RA

3.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.