

Instruction manual for BAP3500-B type holder for large nose R insert

BAP3500-B type is for use with inserts with a nose R of 2.0mm and above.

If a smaller nose R , 1.6 mm or less, is used then there is a possibility that the corner of the insert may suffer from fracturing .

To avoid this, when using nose R of 1.6mm or less, please use BAP3500-A type

1. Process of clamping the inserts

①Cleaning the insert seats

Please clean the insert seats with high pressure air or a brush.

If foreign particles are clamped between the insert and the insert seat, problems may occur such as, run out of the cutting edges and movement of the inserts during cutting.

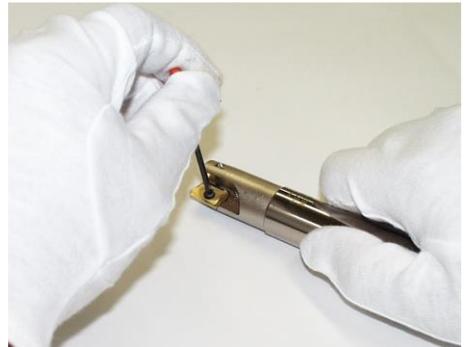


②Clamping the inserts

Ensure the flat locating face of the insert makes solid contact with the locating surface of the insert seat.

Clamp the insert tightly with the screw and wrench while pushing the insert toward the locating surface of the insert seat.

☆Clamping torque : 1. 0 (N · m)
 ≒ 1 0. 2 (k g f · c m)
 ≒ 0. 3 4 (f t · l b)



Please note the handling of the insert with G breaker.

Because The cutting edge of G breaker can be sharpened , you might be injured.

2. Wrench information

(Flag) shaped wrench

BAP3500 type uses the TORX type clamp screw.

To get the best performance of the TORX screw and to keep the wrench hole life of the screw head long, please use the attached wrench.

3. Caution

- A. Please use original parts. If other parts are used, the performance will be inferior and safety can not be assured .