®Floating Holder

ISO9001Certified

XEBEC products are manufactured in a plant certified by ISO9001, the international standard of quality control and assurance.

Patent Pending

XEBEC® Floating Holder is an optional tool for XEBEC® Cutting Fiber to stabilize the cutting load.

New!

*incl. low and high springs and bush

[Features]

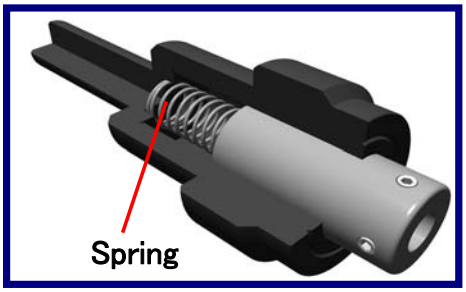
■Extend Tool Life!
- Reduce the amount of tool wear so as to stabilize processing conditions.

■Reduce Process Control!
- Prolongs time to adjust brush exposure from sleeve and cutting depth due to tool wear.

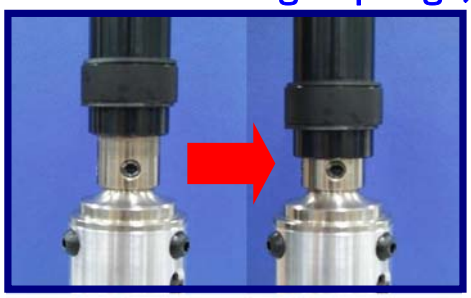
■Improve Quality!
- Delivers stable edge quality by adjusting for changes in cutting amount due to tool wear.

Ideal for Mass Productions!!!

- The tool holder floats by the action of the spring inside the holder, thus assuring stable processing under load control!
- Changing spring load is possible depending on materials and target quality!! (incl. standard with low and high springs)



spring expands and shrinks for 6mm

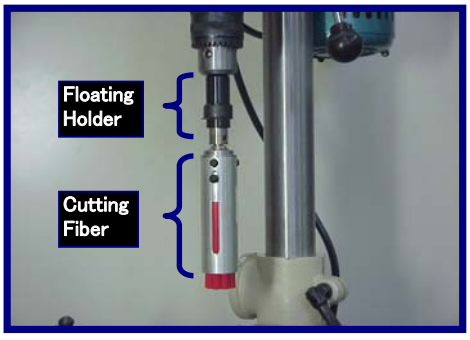

When spring expanded at most (Stroke 0 mm)

When spring shrinked at most (Stroke 6 mm)

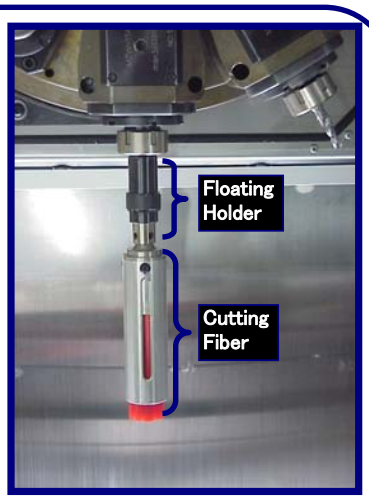
Ideal to be used in CNC machines for mass productions and can also be used in drill press to stabilize the cutting load!

～with various machines～
- Machining Center
- Custom Machine
- NC Lathe
- Drill Press
- Other CNC machines

Can be used with collett chuck and drill chuck.

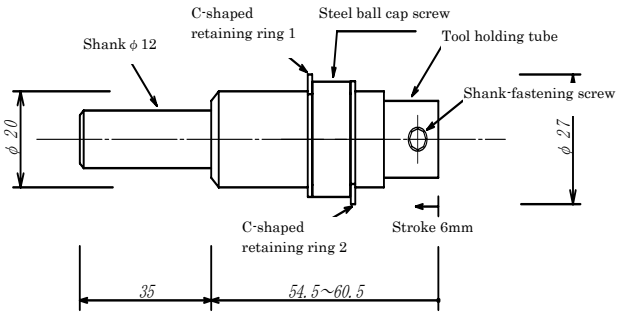


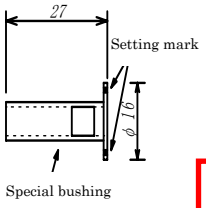
Drill Press



CNC Machine

[Specification]





Product Code	FH-ST12
Target shank diameter	ϕ 8 mm※1
	ϕ 6 mm (when special bushing is mounted)※2
Spring stroke	6 mm
Maximum rpm	5,000 rpm

Corresponding XEBEC Cutting Fiber Brush Size:
※1 ϕ 8mm shank: ϕ 25mm、ϕ 40mm
※2 ϕ 6mm shank: ϕ 6mm、ϕ 15mm

Spring Type	Spring Load	
	Stroke 0 mm	Stroke 6 mm
Standard	4.5N (0.45kgf)	6.3N (0.63kgf)
Low load	1.5N (0.15kgf)	3.3N (0.33kgf)
High load	7.2N (0.72kgf)	10.5N (10.5kgf)

■■Precautions in Use■■

[Pre-operation Inspection]
- When mounting tool on the machine, insert the shank all the way to the bottom of the chuck, then secure it tightly. In mounting the XEBEC Cutting Fiber, insert the shank all the way into the tool holding tube, and secure it tightly with shank-fastening screw.
- Conduct a test run for one minute or more before starting work, and three minutes or more after changing the tool, to confirm the absence of any abnormality such as tool vibration or looseness.
- Even if nothing abnormal occurs during the test run, stop operation immediately if you find anything unusual such as vibration; dangerous shank slipping out, breakage, deformation or even tool breakdown may occur.

[Tools that can be Mounted on]
- This floating holder is made for XEBEC Cutting Fiber with 25 mm and 40 mm diameter. Also XEBEC Cutting Fiber with 6 mm and 15 mm diameters can be mounted using the attached special bushing.

[How to Mount Special Bush]
- Align shank-fastening screw hole with aligning setting mark, insert special bushing as far as it will go, then secure the shank-fastening screw.

[Cutting load, floating stroke]
- The weight of the tool itself affects the cutting load, depending on the tool direction in processing.
- The floating stroke is 6 mm at the maximum.

[RPM]
- Operate at less than the maximum rpm of 5,000. Usage above the maximum rpm may result in breakage of the tool.
- Choose the ideal rpm carefully after reading the Instruction Manual for XEBEC Cutting Fiber.

[Dry or Wet Processing]
- Tool can be used for either wet or dry processing.
- For dry processing, use a dust collector to collect the dust that may be generated during the processing.
- During wet processing, make sure that the holder is not exposed to the coolant.
- If the dust or coolant gets inside the holder, the floating function will not work.

[When Attaching to Machining Center]
- When attaching the floating holder to a machining center, do not use a pull bolt with through-hole (center through pull bolt). If the coolant gets inside the holder, the floating portion will not operate.
- Use a spring load heavier or an attached spring that has heavier load when a horizontal machining center is used. If the spring load is light, the floating portion may not operate. Please check operation before in use.

[Replacement of Inside Spring]
- When replacing the inside spring of XEBEC Floating Holder, replace it carefully as instruction manual indicates.
- Use the spring with the specification XEBEC indicates or it may result in malfunction or breakage of the tool.

■Operator Safety Measures■

[For Protective Equipment]
- Always wear protective goggles, gloves and masks when operating the tool.
- Wear long sleeves, tight cuffs, and clothing to minimize your skin exposure.

Warning
- Please always follow the above instructions in order to use the tool safely. Failure to adequately familiarize yourself with instructions may result in slipping out, breakage or deformation of the shank.
- Read the XEBEC Cutting Fiber instruction manual carefully before use.