

*Applicable with various machine,  
from drilling machine to NC lathe.*

**ISO9001 Certified**

XEBEC products are manufactured in a plant certified by ISO 9001,  
the international standard of quality control and assurance.

**For XEBEC® Cutting Fiber®**

**Patent Pending**

# XEBEC® Floating Holder

*For consistently higher quality, simpler process control, and longer tool life!*



## Features

- The tool holder floats by the action of the spring inside the holder, thus assuring stable processing under load control.
- Applicable with machining center, NC lathe, drilling machine, special purpose machine, and other machine tool.
- Vary the cutting load just by changing the spring in terms of the desired processing quality.

## Performance

- Delivers stable edge quality by adjusting for changes in cutting amount due to tool wear.
- Prolongs time to compensate for cutting depth under tool wear and amount of fiber rod protrusion.
- Reduces the amount of tool wear so as to stabilize processing conditions.



## Comparison of edge finishing with and without XEBEC® Floating Holder.

### With floating holder

Change in cutting depth is absorbed by the floating function.  
Stable finishing assured even when cutting depth varies greatly.



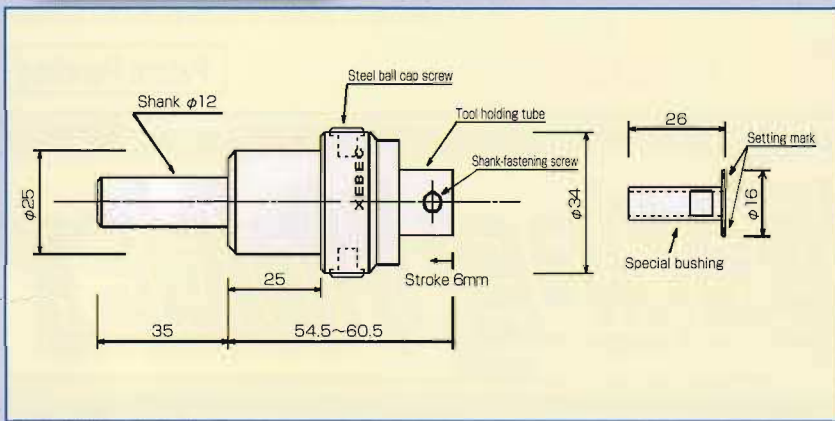
### Without floating holder

The change in cutting depth is directly  
reflected in the finished condition.





## Specification



Product Code		FH-XBC
Target shank diameter		φ8mm <sup>*1</sup>
		φ6mm (when special bushing is mounted) <sup>*2</sup>
Floating stroke		6mm
Spring load	When actuated for 0 mm stroke	Approx.4.5N(0.45kgf)
	When actuated for 6 mm stroke	Approx.6.3N(0.63kgf)
Maximum rpm		5,000rpm

Diameter of brushes for XEBEC Cutting Fiber

\*1. φ8mmshank diameter : φ40mm,φ25mm

\*2. φ6mmshank diameter : φ15mm,φ6mm

## 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 40 mm and 25 mm diameter. Also XEBEC Cutting Fiber with 15 mm and 6 mm diameters can be mounted using the attached special bushing.

### [How to Mount Special Bushing]

- 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.

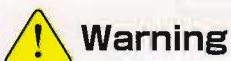
### [Replacement of Inside Spring]

- 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.

Please visit our homepage for details. ——— URL <http://www.xebec-tech.co.jp>

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