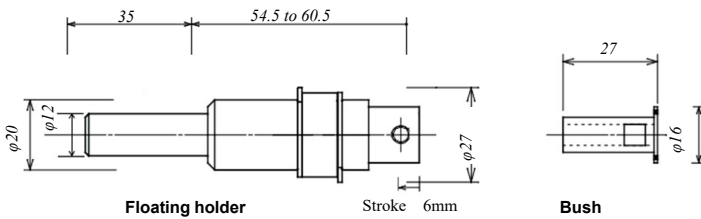


XEBEC Floating Holder Instruction Manual (FH-ST12-SL10)

Specifications

Dimensions



Tool specifications

Target brush diameter (mm)	Bush	Diameter of sleeve shank on the brush (mm)	Maximum rotational speed (min ⁻¹)	Floating stroke (mm)
φ6	XBS1006	φ6	10000*	6
φ15			6000*	
φ25	XBS1008	φ8	5000*	
φ40	Not required	φ10	3000*	

The maximum rotational speed is according to the XEBEC Brush™ Surface Instruction Manual.

Set the optimum rotational speed.

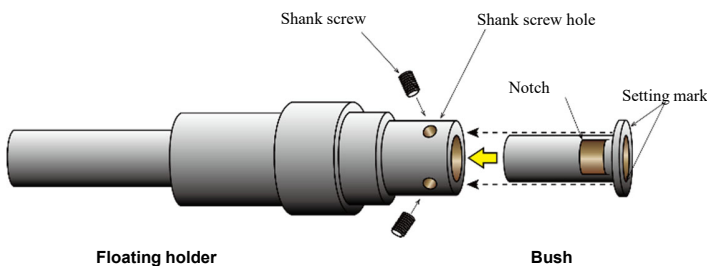
* The maximum rotational speed for this product as a stand-alone unit is 10000min⁻¹.

Spring specifications

Spring type		Spring load (N)		Diameter (mm)	Free length (mm)	Maximum deflection (mm)	Spring constant (N/mm)
		0mm stroke	6mm stroke				
Built in	Standard load	4.5	6.3	φ10	40	24	0.3
	Attached	Low load	1.5		3.3	30	18
	High load	7.2	10.5		39	22.6	0.55

Fitting the brush

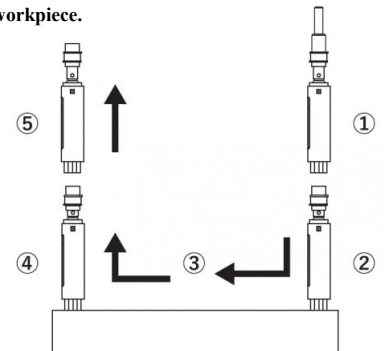
- When fitting the bush, align the shank screw holes with the setting mark, push the bush all the way in, then secure the shank screw.
- To fit the XEBEC Brush Surface, slide the shank all the way to the end of the tool holding tube, then firmly tighten the shank screws.



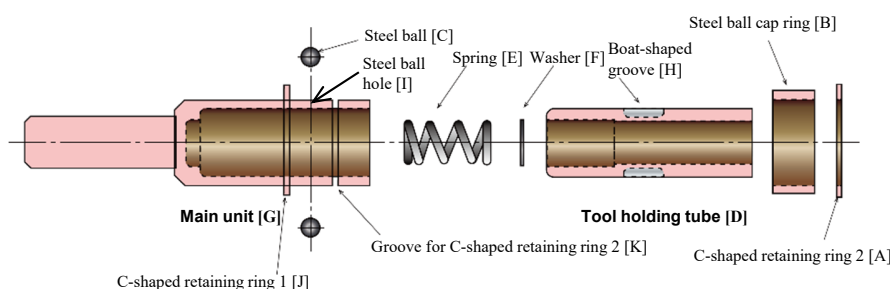
Effective use

The following describes effective use of the tool.

- Introduce the brush from above the workpiece while it is not in motion.
- Cut to the set value and compress the spring.
- After compressing the spring, rotate the brush and start feeding.
- When machining is completed, stop rotating the brush and stop feeding.
- Return the brush above the workpiece.



Maintenance and replacement of the spring



- Be careful not to get your fingers caught when attaching the steel ball cap ring.
- Tighten the screws, etc., with the standard torque.
- Use steel balls recommended by XEBEC.
- Regular maintenance is recommended. The interval between maintenance depends on the frequency of use.
- Sliding parts may seize when left unused for long periods. Make sure to perform maintenance before storing the product.
- When assembling or disassembling the C-shaped retaining ring, use snap ring pliers for C-shaped internal rings (ring size: 20 mm).

- Remove C-shaped retaining ring 2 [A].
- Remove the steel ball cap ring [B] and take out the steel balls [C] (2) from inside the main unit.
- Remove the tool holding tube [D] from the main unit and take out the spring [E] and washer [F].
- Wipe off the dirt inside of the main unit [G] and on the tool holding tube [D].
- Apply grease sparingly to the sliding section (tool holding tube [D]).
 - Recommended grease: Lithium soap grease (NLGI no.2)
- Confirm that there is no dirt on the tool holding tube [D] or inside the boat-shaped grooves [H].
- Fit the spring [E] and washer [F] to the tool holding tube.
 - Use springs recommended by XEBEC.
- Align the boat-shaped grooves [H] on the tool holding tube [D] and the steel ball hole [I] on the main unit.
- Insert the steel balls [C] (2), attach the steel ball cap ring [B], then fit the C-shaped retaining ring 2 [A] into the groove for the C-shaped retaining ring 2 [K].
- Press the bottom of the tool holding tube [D] with your finger and confirm that the tool holding tube [D] slides 6 mm.

F