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Accusize Industrial Tools 0250-0102

Accusize Industrial Tools AXA Quick Change Tool Post Holder 0250-0102 Instruction Manual

Model: 0250-0102

Introduction

This manual provides essential information for the safe and effective use of your Accusize Industrial Tools Style AXA Boring, Turning, and Facing Quick Change Tool Post Holder, Model 0250-0102. This tool holder is designed for lathes with a swing of 6-12 inches and is compatible with AXA style quick change tool posts. It is engineered to securely hold 1/2" turning tools, including boring bars and square tool bits, for various machining operations.

Safety Information

Always prioritize safety when operating machinery and using tools. Failure to follow safety guidelines can result in serious injury or damage to equipment.

- Always wear appropriate personal protective equipment (PPE), including safety glasses, hearing protection, and suitable work attire.
- Ensure the lathe is powered off and locked out before installing or removing tool holders or tool bits.
- Verify that the tool holder is securely seated and locked onto the quick change tool post before beginning any operation.
- Ensure tool bits are properly sharpened and securely clamped within the tool holder to prevent slippage or breakage.
- Maintain a clean and well-lit workspace to prevent accidents.
- Never operate machinery under the influence of drugs or alcohol.

Product Overview

The Accusize 0250-0102 tool holder is a robust accessory for quick change tool posts, designed for precision boring, turning, and facing operations.

Key Features

- **Lathe Swing Compatibility:** Designed for lathes with a 6-12 inch swing.
- **Functionality:** Supports boring, turning, and facing operations.

- **Dimensions:** A: 15/16", B: 1/2"; C: 7/16"; D: 1-1/2", Shank 1/2".
- **Construction:** All parts are hardened, ground, and completely sealed for maintenance-free operation. Made of high-strength steel for durability.
- **Clamping Mechanism:** Features a V-groove for firmly holding round shank boring bars and square tool bits.
- **Tool Bit Range:** Accommodates tool bits from 3/16" to 1/2" and a shank size of 7/16".

Components and Views



Accusize AXA Quick Change Tool Post Holder 0250-0102, front view.



Accusize AXA Quick Change Tool Post Holder 0250-0102, angled view with adjustment screw.



Accusize AXA Quick Change Tool Post Holder 0250-0102, top-down angled view.



Accusize AXA Quick Change Tool Post Holder 0250-0102, side view showing V-groove.



Accusize AXA Quick Change Tool Post Holder 0250-0102, top view.

Diagram showing the Accusize 0250-0102 AXA tool holder with key dimensions A, B, C, D, and shank diameter.

Diagram illustrating the V-groove design of the Accusize 0250-0102 AXA tool holder with dimensions L1, L2, and H.

Compatibility

The 0250-0102 tool holder is specifically designed for AXA model quick change tool posts. Ensure your lathe's quick change tool post is an AXA style for proper fit and function.

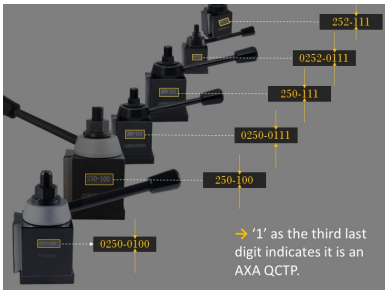


The 0250-0102 tool holder correctly mounted on an AXA Quick Change Tool

Post.



This tool holder is not compatible with Euro Style Quick Change Tool Posts.



Tip for identifying an AXA Quick Change Tool Post by model number.

Compatible Lathe Models

The following table lists common lathe brands and models known to be compatible with AXA Quick Change Tool Posts, for which this tool holder is suitable:

Lathe Brand	Lathe Model or Size
Nardini	TT1000
Nardini	TT1200
South Bend	9"
Atlas	10"
Delta	10"
Delta	11"
Colchester Bantam	Bantam 2000
Grizzley	G0752
Southbend	10"
Southbend lathe	NA
Craftex	B2700L
Atlas	3996
South Bend	13" x 7"
NUMOBAMS	WM210
Vevor	8.7x29
Sharp Industries	12x37
Craftsman	101

Setup

Mounting the Tool Holder

1. Ensure your lathe's quick change tool post is clean and free of debris.
2. Slide the 0250-0102 tool holder onto the dovetail of the AXA quick change tool post.
3. Position the tool holder to the desired orientation for your operation.
4. Engage the locking mechanism of your quick change tool post to secure the tool holder firmly in place.

Inserting Tool Bits

The 0250-0102 tool holder is designed to accommodate both round shank boring bars and square tool bits.

1. **For Round Shank Boring Bars:** Place the boring bar into the V-groove of the tool holder. Tighten the clamping screws evenly to secure the bar.
2. **For Square Tool Bits:** Insert the square tool bit into the square slot. Tighten the clamping screws evenly.
3. **Tool Bit Size:** This holder is capable of accommodating tool bits from 3/16" to 1/2" and a shank size of 7/16".
4. **Using Spacers:** For tool bits smaller than 1/2", use appropriate spacers to ensure the tool bit is held securely and at the correct height relative to the lathe's centerline.

5. **Height Adjustment:** Adjust the height of the tool bit using the fine adjustment screw on the tool holder to align the cutting edge precisely with the lathe's centerline.



Illustration of the AXA tool holder with a boring bar, tool bits, and spacers.

Operating Instructions

Once the tool holder and tool bit are securely mounted and aligned, you can proceed with your machining operations. Always refer to your lathe's instruction manual for specific operating procedures.

- **Boring:** Ensure the boring bar is rigid and extends minimally from the holder to reduce vibration. Set appropriate feed rates and depths of cut for the material.
- **Turning:** Position the turning tool to achieve the desired diameter and surface finish. Adjust feed and speed settings according to material and tool specifications.
- **Facing:** Set the tool to cut across the face of the workpiece. Ensure the tool is on the centerline for a clean, flat face.
- Always start with light cuts and gradually increase depth as needed, monitoring for chatter or excessive tool deflection.
- Use cutting fluid when appropriate to improve surface finish and extend tool life.

Maintenance

The Accusize 0250-0102 tool holder is designed for low maintenance due to its hardened, ground, and sealed construction.

- **Cleaning:** After each use, clean the tool holder to remove chips, coolant residue, and any other debris. Use a clean cloth and a suitable cleaning agent if necessary.
- **Inspection:** Periodically inspect the tool holder for any signs of wear, damage, or corrosion. Pay close attention to the dovetail surfaces and clamping screws.
- **Lubrication:** While sealed for maintenance-free operation, a light coat of machine oil on exposed metal surfaces can help prevent rust, especially in humid environments.
- **Storage:** Store the tool holder in a clean, dry place to protect it from moisture and impact.

Troubleshooting

- **Tool Holder Does Not Fit Tool Post:** Verify that your quick change tool post is an AXA style. This tool holder is not compatible with other styles (e.g., Euro Style). Check for any obstructions or debris on the dovetail surfaces of both the tool holder and the tool post.
- **Tool Bit Not Clamping Securely:** Ensure the clamping screws are tightened evenly and sufficiently. If using a smaller tool bit, ensure appropriate spacers are used to fill the gap and provide adequate clamping pressure.
- **Tool Bit Not Reaching Centerline:** Adjust the height adjustment screw on the tool holder. If the screw's range is insufficient, consider using a longer adjustment screw or additional shims under the tool bit (if applicable and safe).
- **Excessive Vibration/Chatter:** Ensure the tool holder is tightly clamped to the tool post and the tool bit is securely held. Reduce tool overhang, adjust cutting parameters (speed, feed, depth of cut), or consider a sharper tool bit.

Specifications

Specification	Value
Product Dimensions	3.94 x 1.57 x 3.15 inches
Item Weight	14.1 ounces
Item Model Number	0250-0102
Lathe Swing Compatibility	6-12 inches
Tool Bit Capacity	3/16" to 1/2"
Shank Size	7/16"
Material	High-strength steel

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For warranty information or technical support, please refer to the official Accusize Industrial Tools website or contact their customer service directly. Keep your purchase receipt for any warranty claims.

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