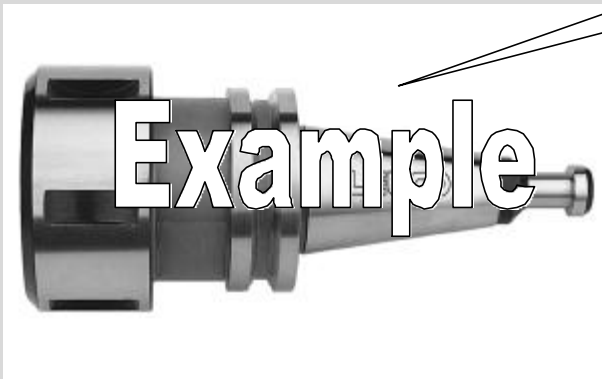


?

Name / trademark of the manufacturer / supplier.

**Betriebs-Anleitung
Instruction Handbook
Notice d'utilisation**

Real picture of the collet chuck(s) described in the instruction manual.

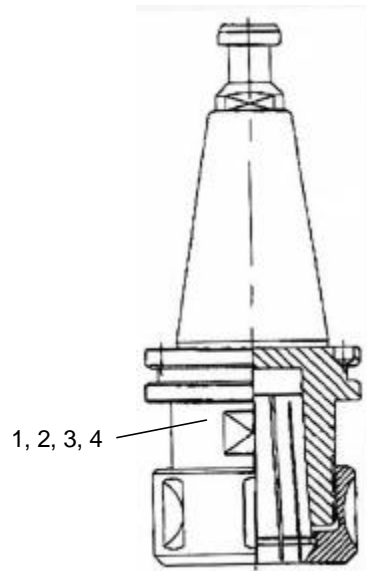


**Spannzangenfutter
Draw-in Collet Chuck
Mandrin à pince**

1 Common part

The clamping device corresponds to the requirements set out in EN 847-3

Principle sketch:



- 1 Manufacturer or supplier
- 2 Max. RPM and type of collet
- 3 Direction of rotation (if necessary)
- 5 Other marking of the manufacturer

1.1 Ordering details

Art.-No.
Ordering details: Order no..

1.2 Conventional application

1.2.1 RPM

n Do not exceed the maximum RPM "n max." marked on the clamping device.

n max. If the maximum RPM of the tool is lower, then the limit of the maximum RPM of the system is determined by the tool.

1.2.2 Type of application

The collet chuck only may be used on router machines and machining centres for machining wood, wood-based material or material with comparable cutting characteristics. The instructions of the machine manufacturer regarding the suitability of the clamping device have to be observed.

1.2.3 Direction of rotation

The direction of rotation marked on the clamping device has to be observed and followed. The direction of rotation of the tool and the clamping device has to be the same.

1.3 Safe handling

1.3.1 Application



NOTICE

All European and National safety regulations shall be adhered to including the safety requirements as set out in EN 847-1, EN 847-2 and EN 847-3.

The tool only is allowed to be used as described in section "1.2 Conventional Application".

1.3.2 Transport



CAUTION

Transport only in suitable packaging. Danger of damaging the cutting parts. Be very careful with packing! Danger of injuring

1.3.3 Assembling the tool/chuck and mounting in the machine



DANGER

The clamping device has to be mounted, secured and started up as per the instructions of the machine manufacturer.

Check the machine set-up and the direction of rotation! Danger of loosening of the clamping device.



DANGER

Observe the limits for the tool weight, -diameter and projection length recommended by the machine manufacturer.



DANGER

All clamping surfaces shall be free of pollution, grease, oil and water.
Tighten the clamping nut before using.
Danger of loosening of the tool.



DANGER

Damaged and worn parts (e.g. collets, tool bodies and cutting edges) immediately have to be exchanged.
After a tool-breakage the collets also have to be exchanged.

Danger of breaking and loosening of the tool.



CAUTION

Inspect the cutting edges, tool bodies and the collet chuck for damage before mounting in the machine.
Observe the handling instructions of the shank tool when mounting the system (collet adaptor - collet - tool)
Follow the minimum clamping length of the tool shank and the excentricity of the system.
Danger of tool breakage.
Improper excentricity or imbalance can result in damages on the system.
When using stacked tooling ensure that the cutting edges do not foul each other.



NOTICE

Carefully mount or demount the tool.
Danger of injuring by the cutting blades.
Wear protective gloves.

2 Specific part of the clamping device

2.1 Maintenance



NOTICE

Clean the collet and the tool holder regularly and before inserting the tool.
Regular cleaning increases the operational safety.



CAUTION

Detergents can irritate skin and eyes and damage the tool. Protect hands and eyes while cleaning. Only use appropriate detergents (see section "2.3 Detergents / Cleaning agents"). Follow the instructions of the detergent producer.

2.2 Repairs

Servicing and modification should be carried out by the manufacturer.
Only specialists are allowed to do repairs.
After servicing the part shall meet the requirements in the relevant European standard(s), i.e. EN 847-1, -2 and -3.

2.3 Detergents / Cleaning agents

The appropriate detergent can be obtained from the manufacturer of the clamping devices.

ALTERNATIVELY

“Name of the detergent”

2.4 Changing of the mounting parts



NOTICE

Observe section „1.3 Safe handling“.

2.4.1 Changing of the shank tools



DANGER

Tighten the clamping bolt at the taper before using.
Danger of loosening of the clamping device.



CAUTION



CAUTION

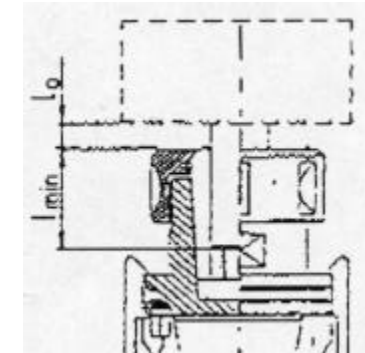


Chart 1
Minimum clamping length

Shank diameter (Tolerance as per EN 847-1)	min. clamping length l min.
$10 \text{ mm} \leq d$	20 mm
$10 \text{ mm} < d < 25 \text{ mm}$	2 x d
$25 \text{ mm} \geq d$	1,8 x d



NOTICE

The free shank length l_0 should be as short as possible.
This results in a higher rigidity and smaller risk of breakage.

Chart 2
Tightening torques for common clamping nuts

Thread	Spanner	Torque
M30x1,5 / M33x1,5	SW 40/42	60 Nm
M40x1,5	SW 45/50	80 Nm
M48x2 / M50x2	SW 58/62	100 Nm

Inserting the shank tool:

1. Fix the tool holder in the mounting device or counter with a spanner.
2. Untighten the clamping nut with a hook spanner.
Hint: Just use shank diameters that correspond to the nominal diameter of the collet. Do not clamp oversized shanks.
3. Insert the cylindrical part of the shank.
Hint: Observe the minimum clamping length (see chart 1). Avoid clamping directly on the radius transition to the cutter part.
4. Tighten the clamping nut with the required torque (see chart 2).

Demounting the shank tool:

1. Fix the holder in the mounting device or counter with a spanner to untighten the clamping nut.
2. Hold the tool on the shank.
3. Open the clamping nut with a hook spanner.
4. Pull the tool out.

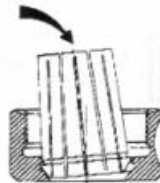
2.4.2 Changing of the collet



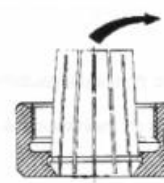
CAUTION

Only collets as per instructions of the collet manufacturer are allowed to be used.

Danger of tool getting out.



Place the collet diagonal to the clamping nut and lock laterally by pressure from top.



Release the collet from the clamping nut by lateral pressure.

Address

Name and address of the manufacturer or supplier

Amendments reserved. Manufacturer-No. / Date of release

Symbols

	General Mandatory Action
	Wear Safety Gloves
	General Prohibition
	Do Not Operate With Damaged Blade
	General Danger
	Cutting of Fingers or Hand / Rotating Blade
	Corrosive Material

Source:
ISO 3864-1: 2002-05 Safety Signs and Colours