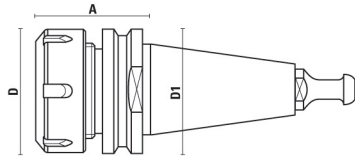


Small machining centres and CNC router machines are more and more common also for small/medium companies. It is very important to use these machines with the correct accessories and tooling, following the security instructions. Many other tool holders, spring collets and accessories for CNC router machines are available at Section 7 of our main Catalogue.

COLLET CHUCKS ISO 30

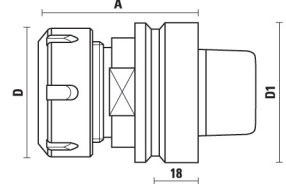


Supplied with nut (without collet) and retaining pawl.
Balanced to 24.000 RPM.

These tool holders ensure a maximum error of concentricity between the conical part and the tool's seat of 0.003mm (Runout: 0.0001"). The "A" measure is determined with clamped router bits' shanks.

Item	A	D	D1	Spring collets	Nut	Rot.
	For Biesse (after il 09/09/92), Masterwood - Bulleri (motor H.S.D.)					
T118.800.R	50	50	50	Ø 2÷20 (Art. T119/ER32)	Z091.001.R	Rh
T118.830.R	60	63	50	Ø 2÷30 (Art. T123/ER40)	Z091.002.R	Rh
	For Alberti, Vitap, Masterwood (motor G. Colombo)					
T118.810.R	68	50	50	Ø 2÷20 (Art. T119/ER32)	Z091.001.R	Rh
T118.814.R	68	63	50	Ø 2÷30 (Art. T123/ER40)	Z091.002.R	Rh
	For Busellato, Weeke, Ima, Bulleri, Maka, Cosmec, Reichenbacher					
T118.820.R	68	50	50	Ø 2÷20 (Art. T119/ER32)	Z091.001.R	Rh
T118.824.R	68	63	50	Ø 2÷30 (Art. T123/ER40)	Z091.002.R	Rh

COLLET CHUCKS HSK63F



Supplied with nut (without collet)
Balanced to 24.000 RPM.

These tool holders ensure a maximum error of concentricity between the conical part and the tool's seat of 0.003mm (Runout: 0.0001"). The "A" measure is determined with clamped router bits' shanks.

Item	A	D	D1	Spring collets	Nut	Rot.
T118.976.R	75	50	63	Ø 2÷20 (Art. T119/ER32)	Z091.001.R	Rh
T118.980.R	75	63	63	Ø 2÷30 (Art. T123/ER40)	Z091.002.R	Rh
T118.983.R	78	60	63	Ø 3÷26 (Art. T124/E0C25)	Z091.202.R	Rh
T118.984.R*	78	60	63	Ø 3÷26 (Art. T124/E0C25)	Z091.203.R	Rh

* with ball bearing nut

SET CHUCK AND SPRING COLLETS



Item

X118.800.R

Complete with collet chuck ISO30
+ 8 spring collets ER32

Wooden box

SET CHUCK AND SPRING COLLETS



Item

X118.976.R

X118.980.R

X118.984.R

Description

HSK63F/ER32 + no° 8 collets ER32

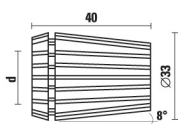
HSK63F/ER40 + no° 8 collets ER40

HSK63F/E0C25 + no° 8 collets E0C25

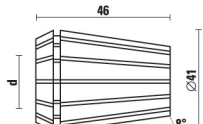
Plastic box

SPRING COLLETS

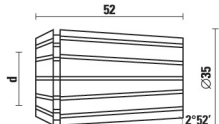
ER32 - DIN 6499



ER40 - DIN 6499



E0C25 - DIN 6388



Item	d	Item	d	Item	d
T119.040.N	Ø 4	T123.040.N	Ø 4	T124.040.N	Ø 4
T119.060.N	Ø 6	T123.060.N	Ø 6	T124.060.N	Ø 6
T119.080.N	Ø 8	T123.080.N	Ø 8	T124.080.N	Ø 8
T119.100.N	Ø 10	T123.100.N	Ø 10	T124.100.N	Ø 10
T119.120.N	Ø 12	T123.120.N	Ø 12	T124.120.N	Ø 12
T119.140.N	Ø 14	T123.140.N	Ø 14	T124.140.N	Ø 14
T119.160.N	Ø 16	T123.160.N	Ø 16	T124.160.N	Ø 16
T119.180.N	Ø 18	T123.180.N	Ø 18	T124.180.N	Ø 18
T119.200.N	Ø 20	T123.200.N	Ø 20	T124.200.N	Ø 20
		T123.250.N	Ø 25	T124.250.N	Ø 25

Precision =0,01 (0.0004" T.I.R.) They are built in spring steel and grounded both internally and externally for best accuracy and precision. **Klein**® high precision spring collets allow to reduce vibrations on tools and motors during routing operations, ensuring a longer life of the tool and electrosplindles.

Imperial sizes and other diameters are available in the main Catalog or visit our website.

WIPE OFF KIT



For cleaning boring machines and CNC router machines. Ensures extreme cleanliness of tapered spindles and it maintains the precision and prolongs the life of your expensive machines, cutting tools and toolholders. Carton box.

Item	
X137.000.N	HSK63F/ER32
X137.001.N	ISO30/ER32
X137.002.N	HSK63F/E0C25
X137.005.N	HSK63F/ER40
X137.006.N	ISO30/ER40



Spindle wiper

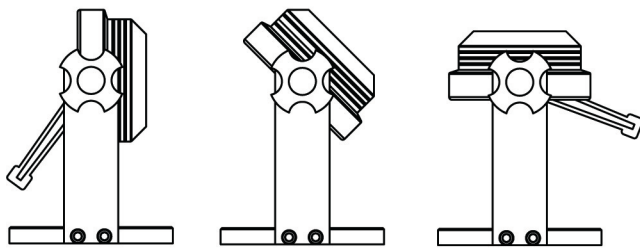


Cone and collet wiper



Brushes for collet bore

ADJUSTABLE DEMOUNT DEVICES



Light (the basement is made in anodized light alloy) and easy to use. It is adjustable from 0° to 90°. Auto-locking roller bearing design for the fastest tool changes and no slippage. Fastest and easiest tool change. Available for HSK32, HSK40, HSK50, HSK63, ISO30 and ISO40 spindles. It is essential near a CNC router, point-to-point machine and CNC centres. Easy to be mount near the machine thanks to four holes on the basement. Demount device must be fixed before using.

Item		
T139.150.N	For ISO 30 tool holder Ø 50	
T139.163.N	For HSK63 tool holder Ø 63	



TORQUE WRENCHES FOR “STANDARD” NUTS



Item	D	L	Nm (Dr. 1)	Nm (Dr. 2)	Threaded nut
Z052.713.N	50	400	66-70	120-130	ER32
Z052.714.N	63	450	110-120	190-200	ER40

TORQUE HOOK WRENCHES

Item	D	L	Nm (Dr. 1)	Nm (Dr. 2)	Threaded nut
Z052.732.N	58-62	380	110-120	190-200	DIN6388 (EOC25)



WHY SHOULD I USE A TORQUE WRENCH?

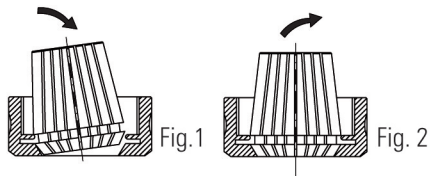
While setting a tool it is extremely important to tighten it appropriately. If not effectively tight indeed a cutting tool could slide away from the tool holder during the working process. On the other side, an excessive tightening can cause damages to the tool holder or spring collet or the tool itself. Use demount device and torque wrench every time you change out a collet or pull stud. Proper torque is essential for having best performance and maintain shop safety and prevent premature damage to collets due to over-tightening.

USEFUL INFORMATION

HOW TO INSERT THE SPRING COLLET IN THE NUT

Follow the right procedure to assemble the collet in the nut: place the collet diagonal to the clamping nut and lock it from the side by pressing it from top (see Fig. 1). At the end, release the collet from the clamping nut by lateral pressure (see Fig. 2). Do not place the spring collet in the collet chuck before you have it properly assembled in the nut.

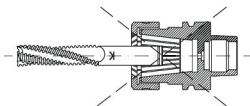
DID YOU KNOW? Collets are manufactured from spring steel and regular usage causes a loss of elasticity. Therefore, collets need to be replaced regularly as part of on-going maintenance while the average **collet should be replaced every 400-600 hours of run time**. Avoiding regular replacement can lead to brittle collets, which may crack or break, and cause permanent damage to the spindle. Replacement of collets is more economical than replacing router bits or expensive spindles. Rigidity and concentricity are the key elements in any routing application. Periodically, tool holders should be examined for wear and if necessary replaced to maintain great cutting performance. The simple process of collecting router tools, maintaining collets, and regularly replacing them - safeguards productivity and ensures a perfect finish.



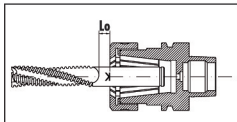
HOW TO INSERT THE ROUTER BITS IN THE TOOL HOLDER

Follow the minimum clamping length marked on the tool shank with the symbol **L_o**. The free shank length (**λ**) should be as short as possible; this results in a higher rigidity and smaller risk of breakage.

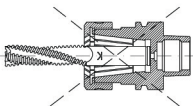
WRONG ASSEMBLING



OPTIMIZED CLAMPING LENGTH



WRONG ASSEMBLING



PREVENTIVE MAINTENANCE

Clean collets and tool holders regularly before inserting the cutting tool. Regular cleaning increases the operation safety and ensures great performance. We recommend a regular preventive maintenance of the spindle mouth, collet pocket and spring collets using the right wipers and brushes (see our item X137). In order to prevent the formation of corrosion and rust, tool holders and spring collets have to be treated with a protective lubricant before storing them (see our item KleinPROTECT). Any dirt, dust, oil or other contaminant left on the spindle, taper, flange or collet can cause poor TIR (runout) and premature wear. It is necessary to protect your investments in machines with a regular cleaning.



61, Shah Industrial Estate
B - Block, Deonar Village Road
Deonar, Mumbai - 400 088
Tel : (022) 2551 2548 / 2556 4967
ntmfrs@gmail.com - office@newtechtool.in

Authorised Suppliers & Distributors for India
new-tech
tool manufacturers
ntmfrs@gmail.com | office@newtechtool.in