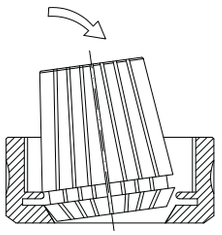
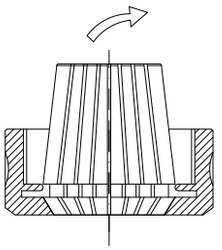
SPRING COLLETS

HOW TO INSERT THE SPRING COLLET IN THE NUT



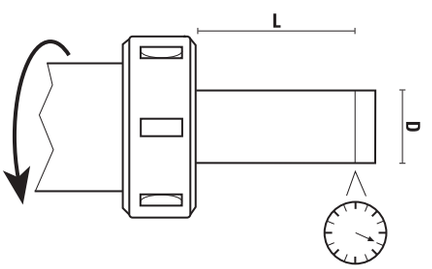
Right procedure to assemble the collet in the nut:
- place the collet diagonal to the clamping nut and lock it from the side by pressing it from top
- screw the nut and be sure the shank is correctly inserted in the spring collet.

Tighten the nut using the apposite key on the proper demount device (Art. T139, see page 7.34)
Do not place the spring collet in the collet chuck before you have it properly inserted in the nut.



Correct procedure for tool and spring collet change:
- place the collet chuck in the mounting device
- untighten the clamping nut
- open the clamping nut and pull the cutting tool out holding it on the shank
- release the collet from the clamping nut by lateral pressure

Klein OFFERS ONLY HIGH PRECISION SPRING COLLETS:



D	L	Standard Precision	High Precision Klein
∅3 - ∅4 - ∅5	16	0,015	**> 0,010**
∅6 ÷ ∅9,5	25	0,015	**> 0,010**
∅10 ÷ ∅17	40	0,020	**> 0,010**
∅18 ÷ ∅26	50	0,020	**> 0,010**

Using high precision spring collets, vibrations on the tools and motors are reduced, assuring better results and a longer life of the tools and electrospindles.

COLLET LIFE SPAN:

Spring collets have a life span of approximately 3 months if used 8 hours a day.
Replacing the collets will ensure your operation runs consistency and prevents from tool breakage.

MAINTENANCE:

Keeping spring collets and tools clean is essential for a longer life.
The worked material produces chips and dirt which can cause an elliptical tool rotation.
The seats of collet chucks and electrospindles should be cleaned daily with the correct tapers
(see our items **T137** and **X137** at the page 7.33)