

TOOL HOLDERS

Useful information:

SISTEMI has always been known for the high quality of the products offered. Keywords of this success are the **attention to production materials** and the use of the most modern construction techniques together with more accurate controls and the continuous research of innovative products.

A large complete stock helps even more our customers to be more competitive in the market.

The tool holders made of stainless steel (see page 7.18) allow to solve permanently any possibility of oxidation.

All our standard collet chucks are balanced at G 6.3 (24.000 RPM) and, on request, can be also at G 2.5 (36.000 RPM).

The new collet chucks Klein^{OVERLINE} (see page 7.16) are balanced at G 2.5 36.000 RPM for performing special executions.



Use instructions:

- 1) The collect chuck may be used only on router machines and machining centers for processing wood and wood-based material with comparable cutting characteristics.
- 2) The instructions of the machine manufacturer regarding the suitability of the clamping device have to be observed.
- 3) The direction of rotation marked on the clamping device has to be observed and followed. The direction of rotation of the tool and the collet chuck have to be the same.
- 4) Do not exceed the maximum RPM "n max" marked on the collet chuck. The maximum RPM of the system is determined by the tool, if the RPM of the tool is lower than that of the chuck.

Safety regulations:

- 1) All European and national safety regulations shall be adhered to include the safety requirements as set out in **EN 847-1, EN 847-2 e EN 847-3**.
- 2) The clamping device has to be mounted, secured and started up as per instructions of the machine manufacturer. Check the machine set-up and the direction of the rotation.

Maintenance:

A regular and **proper cleaning** of mechanical components is critical to avoid jamming during processing operations and the consequent risk of a poor finishing of the piece or even tool breakage.

The worked pieces leave impurities and debris in the collets holes, in the seats of tool holders or electro-spindles. These should be therefore cleaned daily using the **right wipers** (see items T137 and X137 at the page 7.33)



In order to avoid the risk of tool breakage during the job, make sure you answered the following questions:

- 1- Are you using the proper tool for the desired job?
- 2- Collets and tool holders are clean and the tool is inserted properly?
- 3- RPM and feed speed are correct?
- 4- Is the depth cut not too excessive for the material processed?
- 5- Are there any evident vibrations of the mechanical parts?
- 6- No right answer to your problem? Stop running parts and check with your "**Klein**" distributor.

If you have to contact your distributor of technical support, have ready the following information:

- a- Type of machine being used
- b- Type of material being cut
- c- Part number of tool, "**Klein**" item
- d- RPM/feed speed/depth of cut
- e- How long did the tool worked before it broke/damaged?
- f- Have you done this operation in the past using the same tool?