

# Integral, Thermal Chucks with Standard Taper Adaptation

## Integral SHRINKIN Toolholders With Various Shanks.

The integral SRKIN SHRINKIN toolholder line was designed for milling applications requiring higher rigidity - the generation of integral SRKIN toolholders. These toolholders actually integrate the SHRINKIN ER SRK... collets with standard taper shanks to form a single, solid piece toolholder. These integral units may be used for solid carbide, steel and HSS shanks.

Max Runout  
T.I.R. .00012"

Slim Design  
4.5°

High Power  
HSK Clamping



Short Insertion  
Clearance

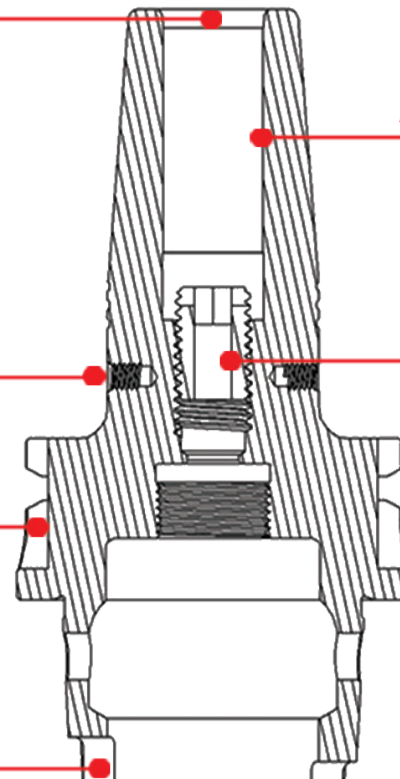
Balancing  
Screws

Symmetrical  
Design

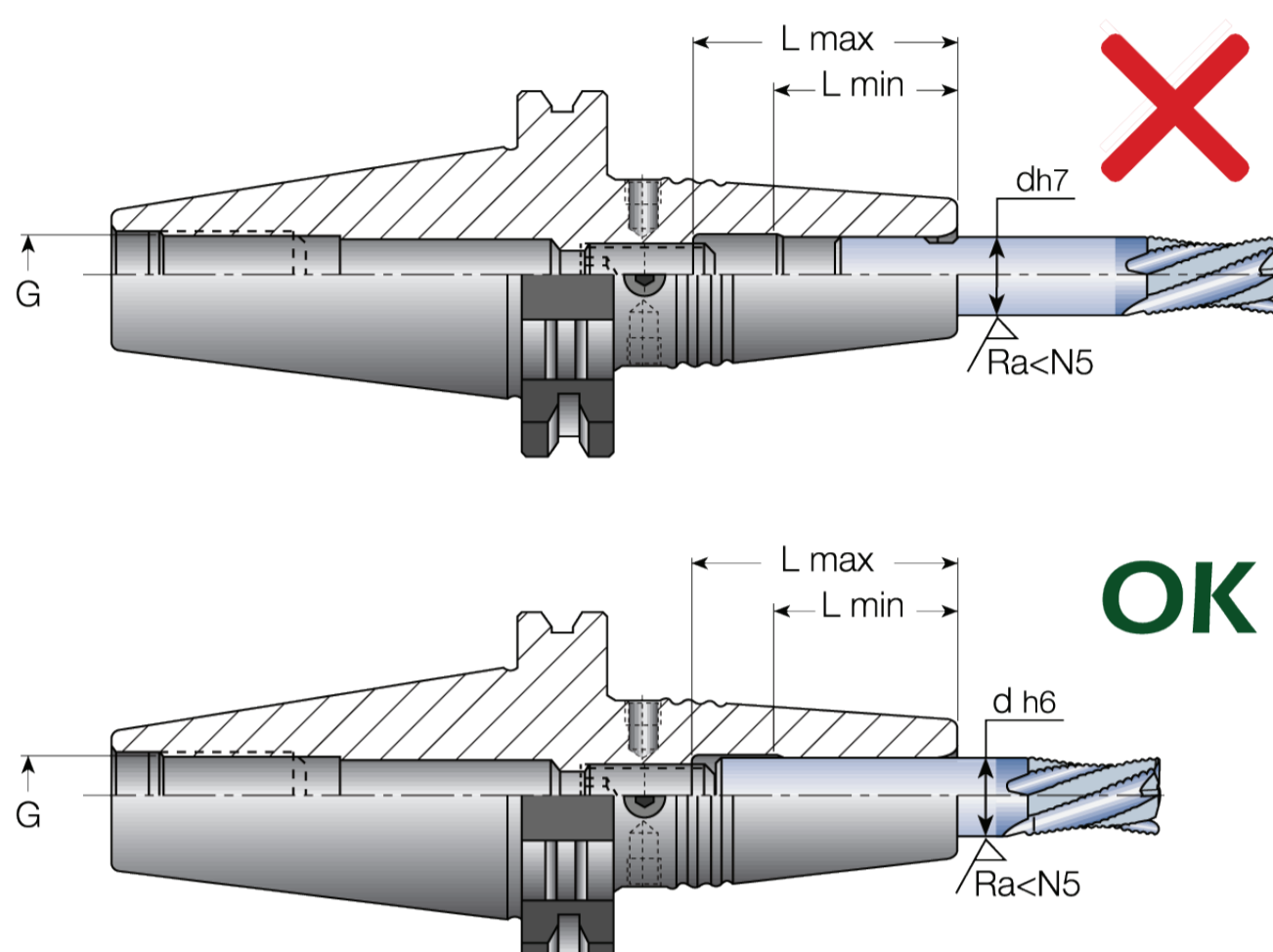
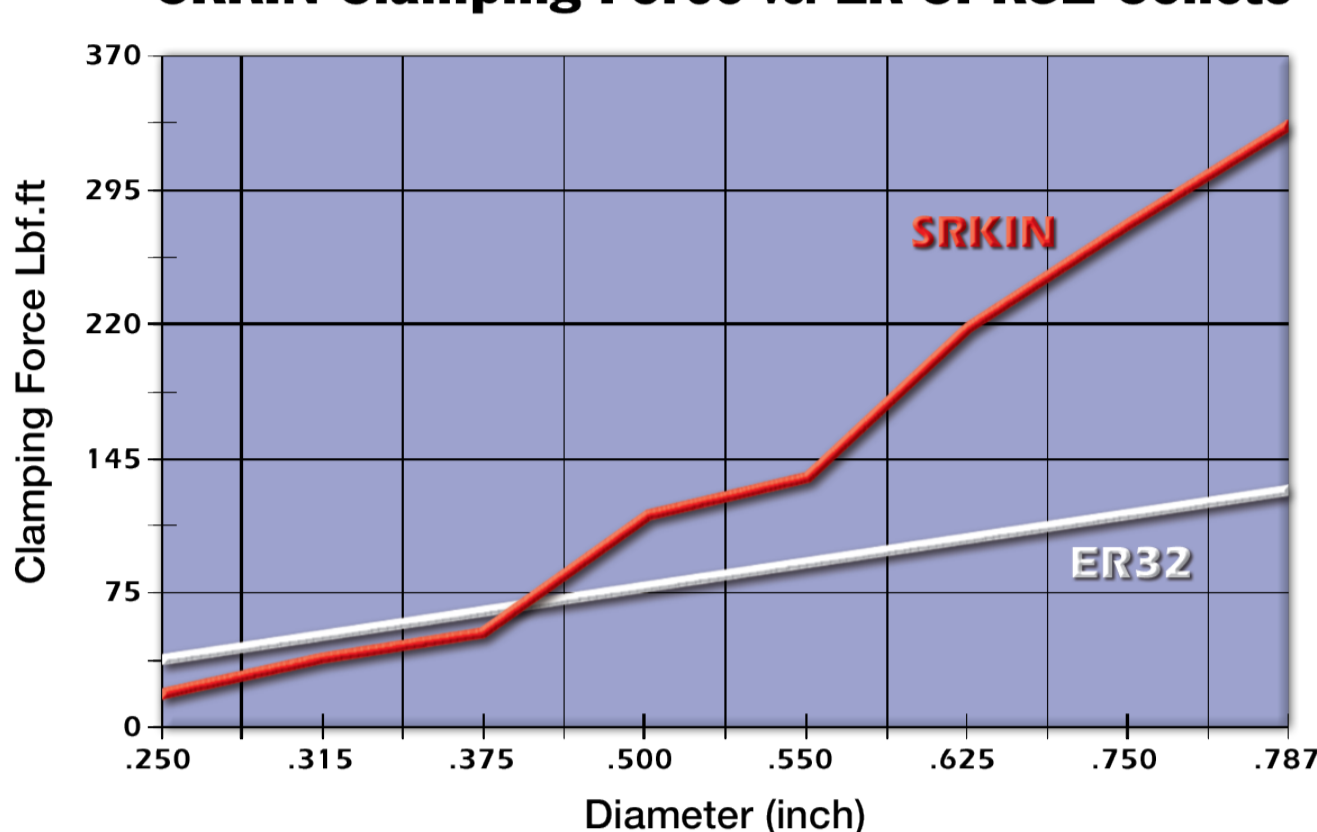
Made from a  
Durable H13  
Steel

Long  
Clamping  
Area

Preset  
Screw



## SRKIN Clamping Force vs. ER SPR32 Collets

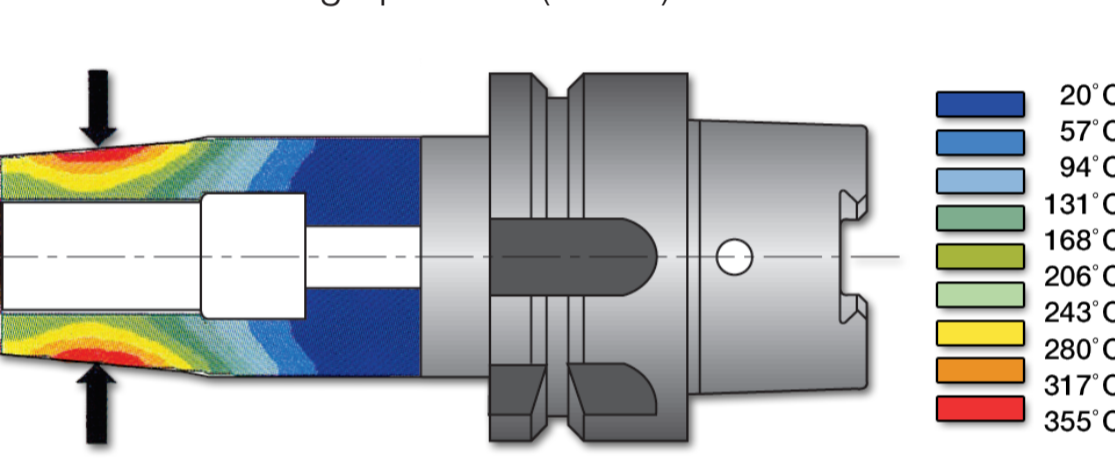


1. Do not use Weldon type shanks.
2. Insert shank at least Lmin into the chuck.
3. In order to maintain a firm grip, shank's surface finish should have a roughness of at least N5.

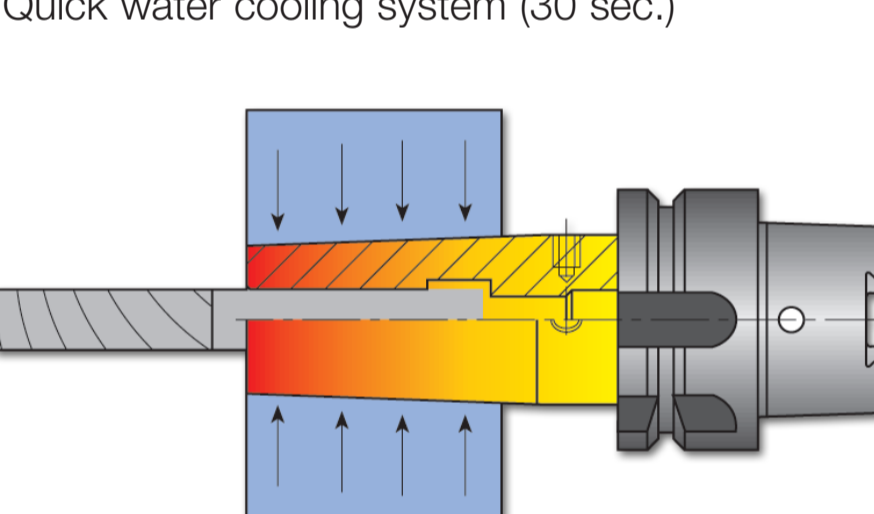
## Important Note

The new tools should be used with an induction shrinking system.

Temperature gradient during quick induction shrinking operation (5 sec.)



Quick water cooling system (30 sec.)



## Features

- High accuracy runout OD-ID 120 µin
- Powerful clamping with high friction force
- High stiffness due to one solid piece Symetric, balanced design for high speed G2.5, 25,000 RPM. (An optional balancing correction may be accomplished by 4 threaded holes in the nose circumference)
- Prolonged tool life due to its low heating temperature and better rigidity, accuracy and stiffness
- Slim design with a 4.5° clamping chuck angle, according to DIN69882-8 standard
- Preset screws in all sizes to adjust the required length for fixed position 3/8" range
- Special high alloy H13 steel with high thermal shock resistance over 930° F
- Toolholder life exceeds 5000 mounting cycles

The INTEGRAL SRKIN holders are designed for tools in the diameter range of 1/4 - 1 1/4" for heavy milling operations. The ER... SRK are intended for high speed machining using tools in the 1/8 - 1/2" diameter range on a standard collet chuck or milling heads on turning centers. They are available with 3 different projection lengths: 1.5, 2.5 and 3.5".

## Adaptation Type

## SHRINKIN Collets

## Heating Unit

Induction

**FLEXFIT**



SRK



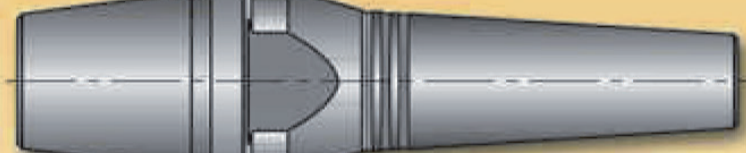
ER COLLET



SRK



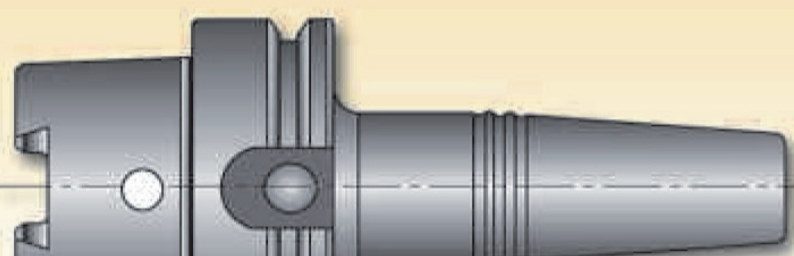
**CLICKIN**



SRF



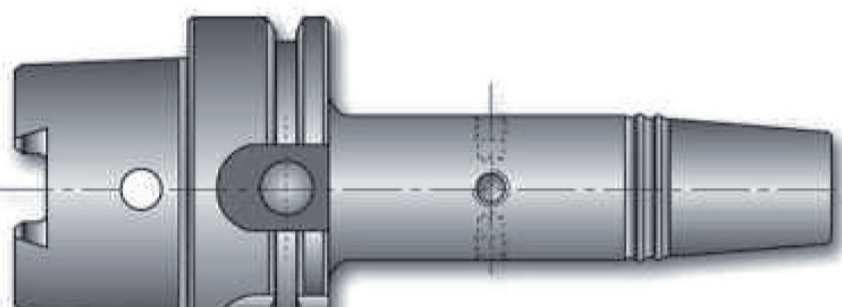
DIN 69871 40  
HSK E32.40.50.63  
HSK A63, BT40



SRK



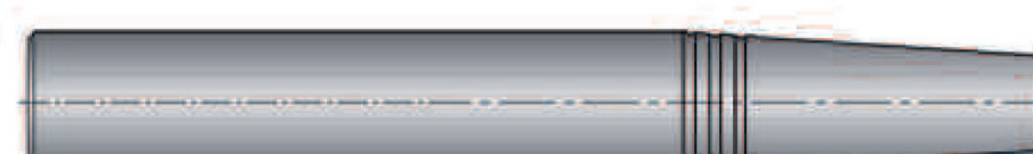
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HSK A63.100  
BT40.50  
CAMFIX C5.C6



SRKIN



ST...SRK



SRK

