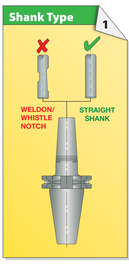
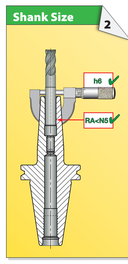
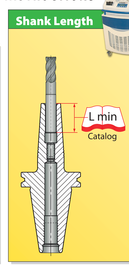
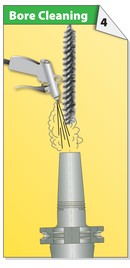
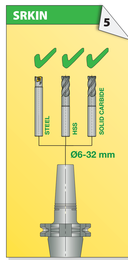
SHRINKIN INDUCTION UNIT INSTRUCTIONS

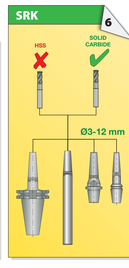










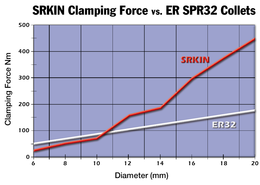


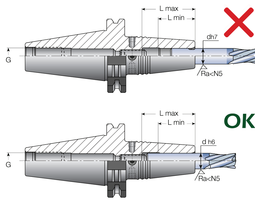
Integral, Thermal Chucks with Standard Taper Adaptation

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.

SRKIN Clamping Force vs. ER SPR32 Collets



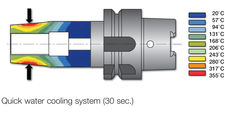


1. Do not use Weldon type shanks.
2. Insert shank at least Lmin into the chuck.
3. In order to maintain a firm grip, shank's surface finish should have a roughness of at least N5.

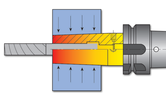
Important Note

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

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



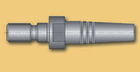
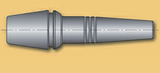
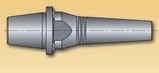
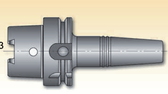
Quick water cooling system (30 sec.)



Features

- High accuracy runout OD-ID 3 µm
- 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 10 mm range
- Special high alloy H13 steel with high thermal shock resistance over 500° C
- Toolholder life exceeds 5000 mounting cycles

The INTEGRAL SRKIN holders are designed for tools in the diameter range of 6-32 mm for heavy milling operations. The ER... SRK are intended for high speed machining using tools in the 3-12 mm diameter range on a standard collet chuck or milling heads on turning centers. They are available with 3 different projection lengths: 35, 60 and 85 mm.

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	
DIN 69871 40.50 HSK A63,100 BT40,50 CAMFIX C5.C6		SRKIN	
ST...SRK		SRK	