



Operating instructions

AFC – Adjustable Finishing Chuck

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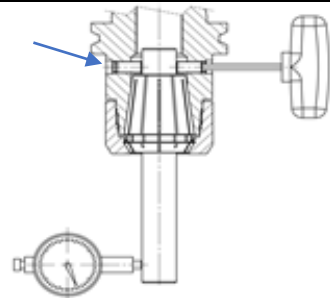
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2. Quick start guide

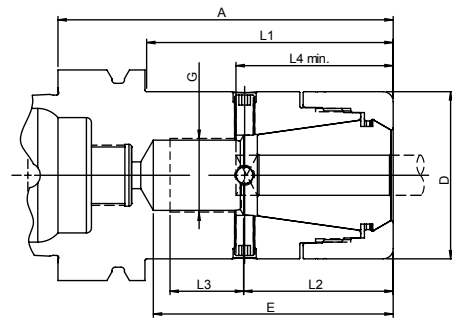
- Before inserting the tool, turn the threaded pins outwards as far as they can go (to the left, counter clockwise).
- Click the collet into the nut.
- Screw the nut with collet onto the chuck.
- Insert the tool so far that the shaft end is in the area of the adjusting screws (threaded pins) (see Fig. 1 to 3). Minimum insertion depth: see table
- Tighten the nut to the specified torque Tightening torque: see table.
- Clamp the chuck into the machine with the tool clamped.

Adjustment in μm increments up to the desired concentricity result:

1. By turning the tool holder, determine the point with the worst concentricity.
2. Turn clockwise on the threaded pins opposite the point of maximum deflection (Fig. 4). With increasing (progressive) torque, adjust the concentricity in μm increments.
3. After adjustment, loosen the screw again and check the concentricity.
4. Repeat points 1 to 3 until the desired concentricity is set.
5. When the desired result has been achieved, tighten all screws; the chuck is then ready for use.

Mount the nut with the collet	Determine the insertion depth	Insert the tool and tighten the nut by hand	Adjusting screw (threaded pin)
			
Fig.1	Fig.2	Fig.3	Fig.4

3. Technical advice



Collet Ø	Minimum insertion depth L4 min.	Designation	Tightening torque clamping nut Nm	D = Key Ø	E
10	43	AFC25	50-60	40	71
12	43	AFC25	50-60	40	71
16	43	AFC25	50-60	40	71
12	47	AFC32	60-70	50	72
16-20	47	AFC32	90-100	50	72

4. Safety

In order to ensure the reliable use, the following instructions and technical data must be observed!

During the assembly:



The tools may have sharp cutting edges and can cause cuts.

Wear protective gloves for tool change!

When used under rotation, protective covers according to EC Machinery Directive must be considered.



Only use pull studs and holders that are suitable for the machine spindle.

During machining:



Observe the recommended cutting speeds of the tool manufacturers.



Be aware of the safety instructions of the machine or other tools used! Never work with open machine door, especially at high speed or when using HSK tapers.

Collisions at high speed could result in breakage of the cutting tool or collet chuck causing serious injury. The maximum speed must never be exceeded.



Do not continue machining if vibrations or chattering can be noticed.



Never touch the chuck or the cutting tool while the spindle is running.



In cases where the balancing quality is relevant to safety or is prescribed by the machine manufacturer, the complete clamping system including the cutting tool must be checked for unbalance and rebalanced if necessary.

General notes



Intended use

CENTRO|P is a precision tool and must be handled carefully accordingly. Avoid mechanical, chemical or thermal influences beyond the loads of the intended use.



Clamping tools and inserting the collet into the clamping chuck may only be performed by technically trained personnel. In this connection, the technical data of the clamping chuck must be observed.

5. Care and storage



Store CENTRO|P and its components in a cleaned and slightly oil condition. The factory-provided lubricant/preservation film must not be removed on the inside of the clamping nut. In order to maintain the nut, we recommend to rub it using a soft cloth without solvent-containing cleaning agents.



As a rule, in the event of strong scaling, the chuck bodies and collets can also be cleaned in solvents. If the clamping nut is cleaned in solvents, the trapezoid thread must subsequently be treated with suitable lubricant. We recommend Hölterol LW 1362.



When cleaning, avoid permanent contact with aggressive and solvent-containing chemicals/ cleaning agents. Solvents are, for example, contained in: Benzine, thinner, brake cleaner etc.

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