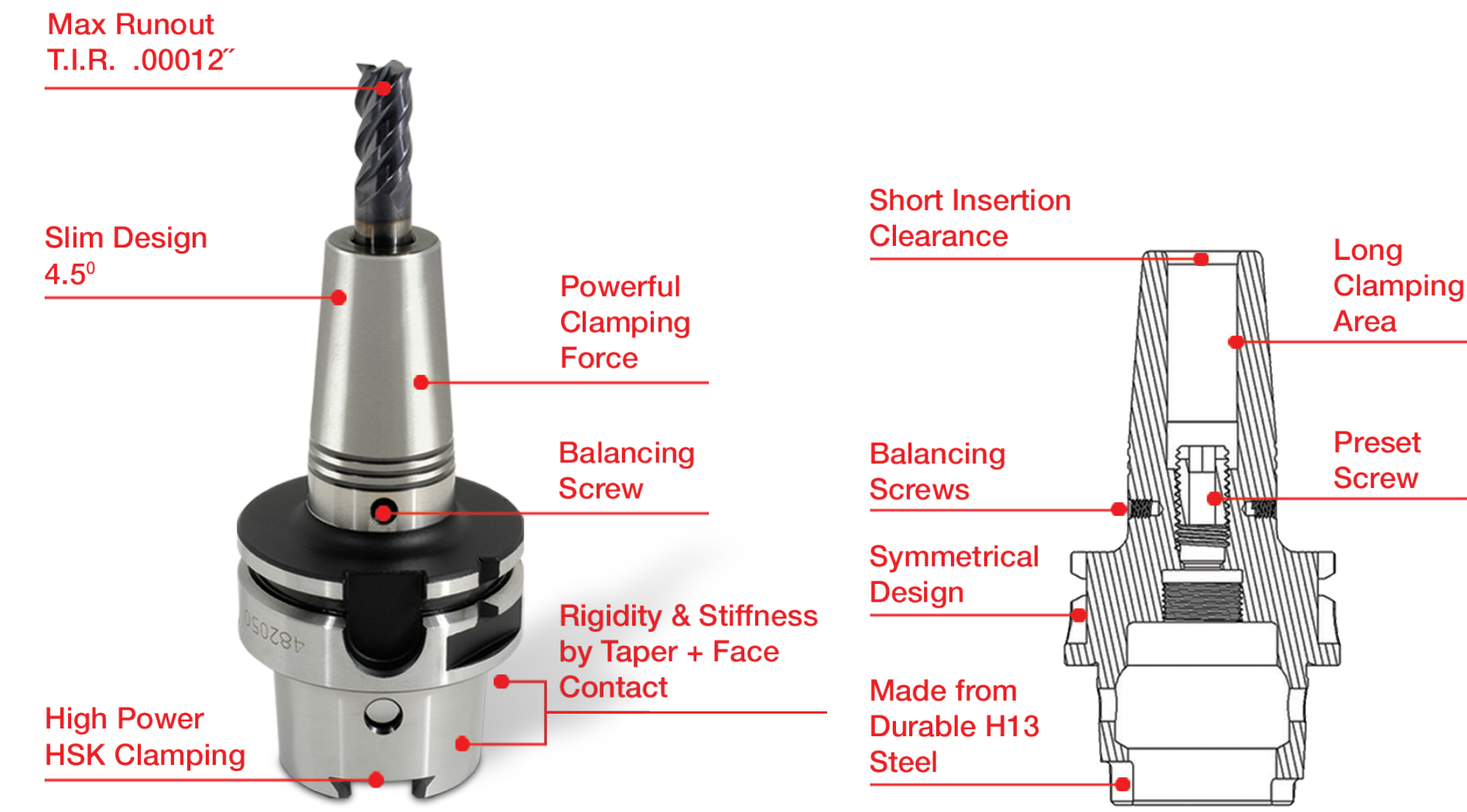


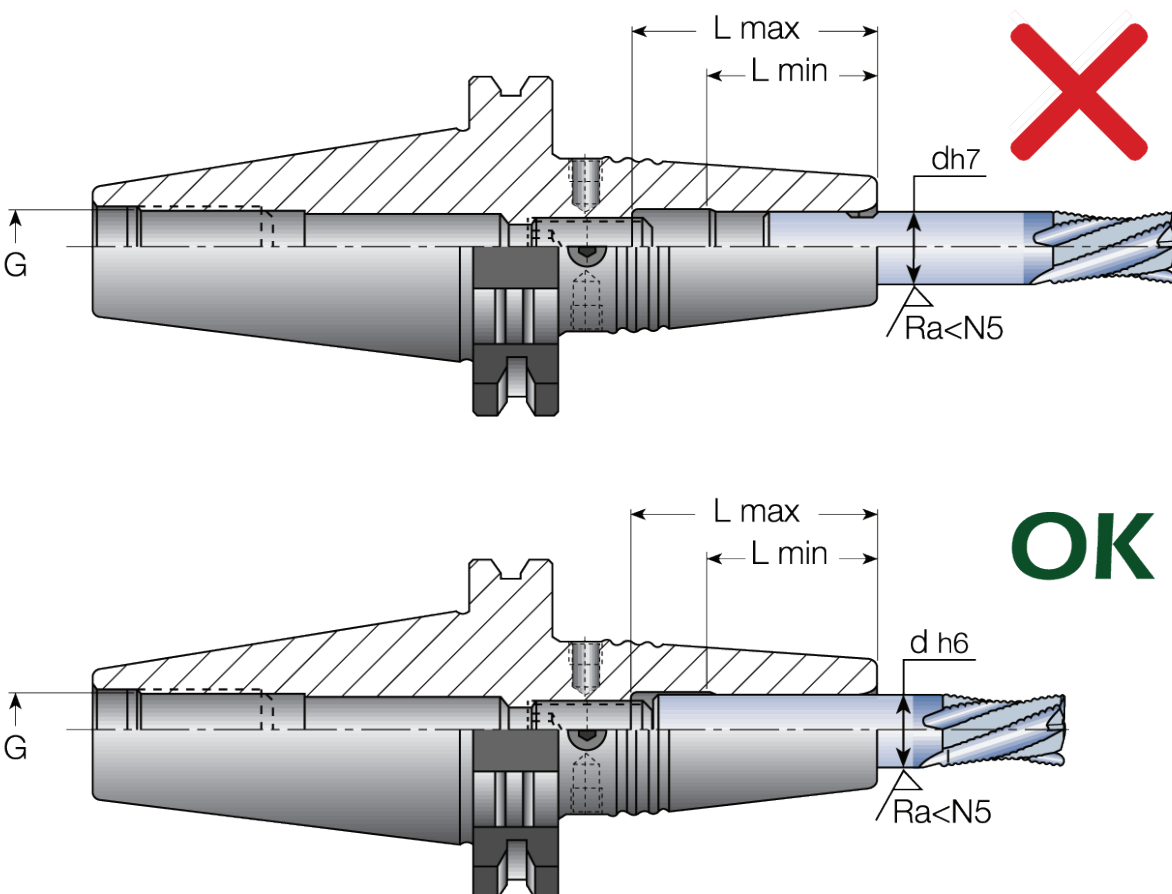
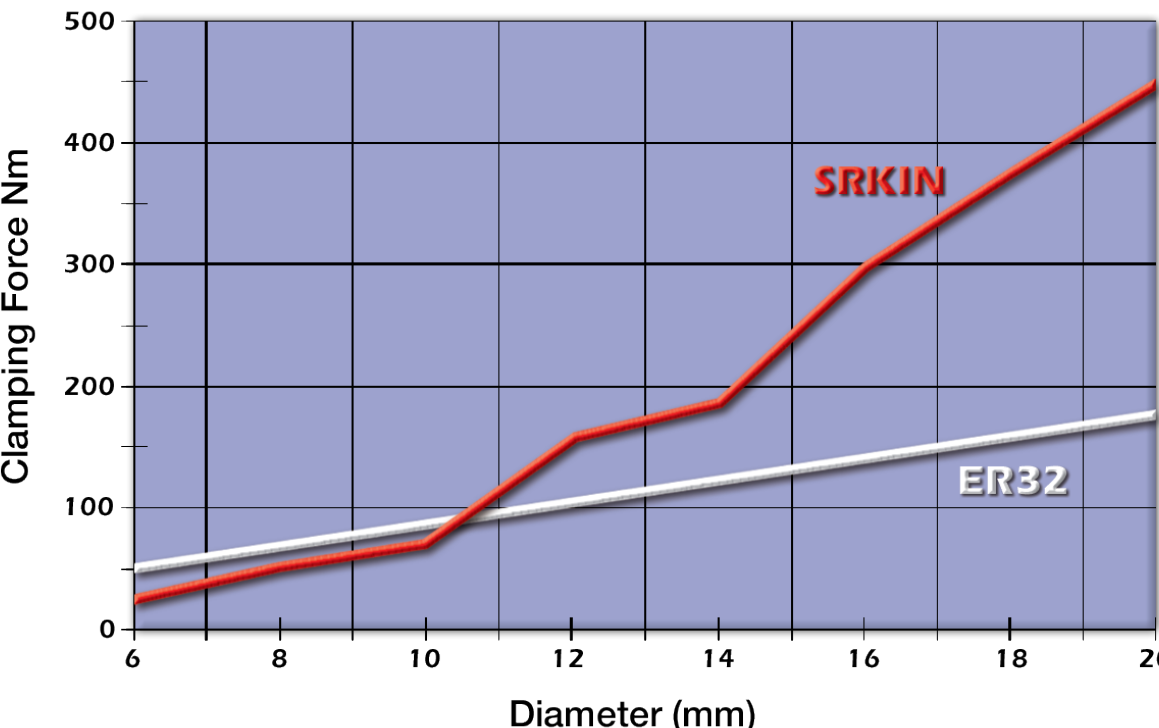
Integral, Thermal Chucks with Standard Taper Adaptation

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

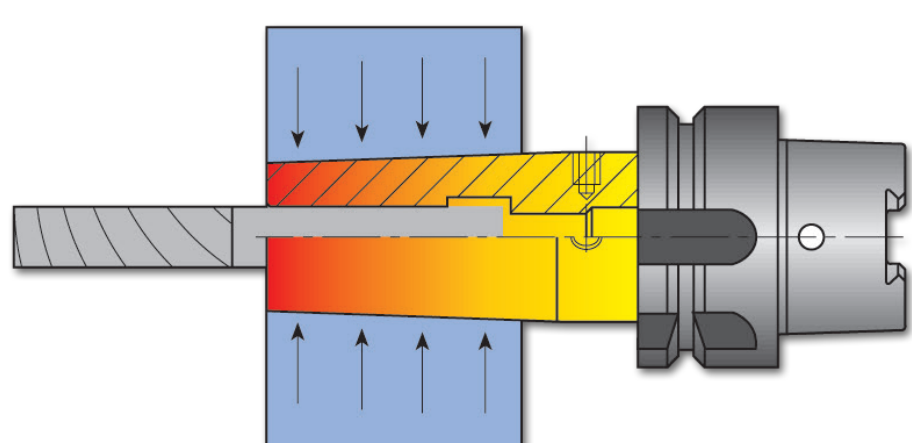
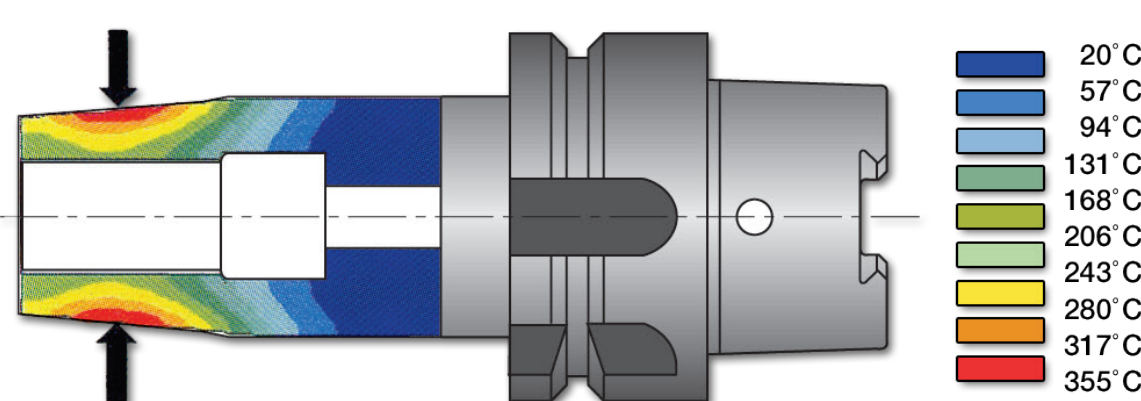


- 1. Do not use Weldon type shanks.
- 2. Insert shank at least Lmin into the chuck.
- 3. In order to maintain a firm grip, shank's surface finish should have a roughness of at least N5.

Important Note

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

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



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".



Thermal Chuck Adaptation Options

Adaptation Type	SHRINKIN Collets	Heating Unit
<b>FLEXFIT</b>	SRK	Induction
ER COLLET	SRK	Induction
<b>CLICKIN</b>	SRF	Induction
DIN 69871 40 HSK E32.40.50.63 HSK A63, BT40	SRK	Induction
DIN 69871 40.50 HSK A63.100 BT40.50 CAMFIX C5.C6	SRKIN	Induction
ST...SRK	SRK	Induction

Features

- Increased coolant velocity is obtained due to flow rate conservation and a smaller coolant discharge area
- Coolant directed to cutting edges
- Prolonged tool life
- Eliminates chip sticking at the cutting edges
- Suitable for High Speed Milling
- Effective chip evacuation prevents chip re-cutting

Applications and Advantages

- Cnc milling machines with poor external coolant flow
- Cavity and pocket milling applications
- Semi-finishing and finishing profile milling titanium blisk blades
- Milling applications that generate high temperatures, such as very hard alloy steels, high temperature alloys etc.

Note: Preset CX screw allows coolant supply via jet channels - do not remove!

