FORM
Quick-Change

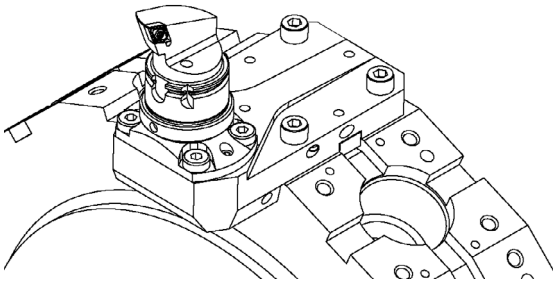
Our Quick-Change tool holders are individually designed to meet customer requirements as well as achieve the most efficient and flexible solutions for your specific machine. This form requires completion in order to identify the correct tool holder. Not all fields need to be filled out. In most cases, a drawing can only be created after receipt of this basic information.

1 Tool selection

If you already know which type of holder you require, please fill in the quantity below. All the tools listed below are able to be designed with a half-index position. If this is required, please mark the corresponding box. (Half- index is explained on page 4)

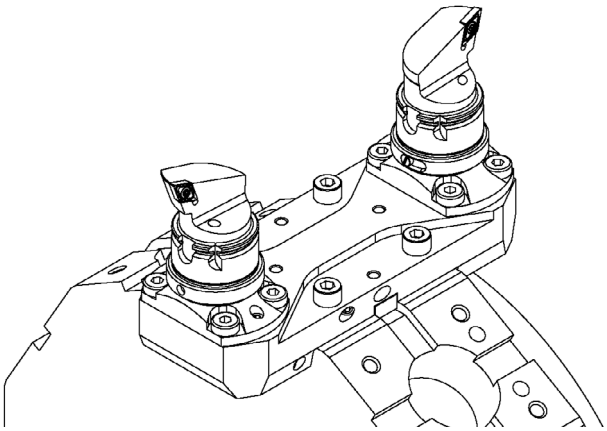
Tool holder straight

These holders are exclusively for external turning.



Quantity: ..... pieces

☐ with half-index

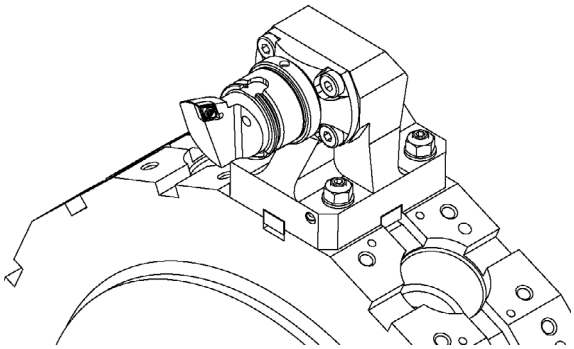


Quantity: ..... pieces

☐ with half-index

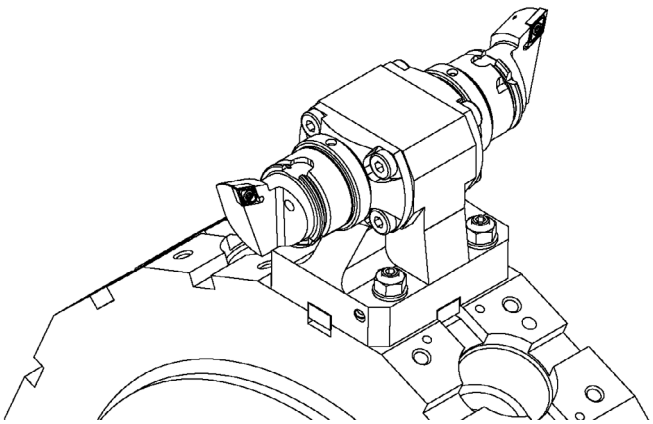
Tool holder angled

These holders can be used for external and internal turning.



Quantity: ..... pieces

☐ with half-index



Quantity: ..... pieces

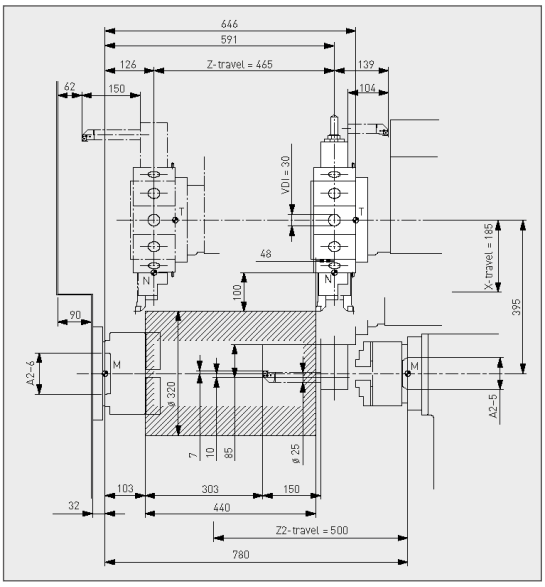
☐ with half-index

Clamping Unit	HSK-T	PSC with front clamping	PSC with segment clamping
	◯ HSK Ø 40	◯ PSC Ø 40	◯ PSC Ø 40
	◯ HSK Ø 63	◯ PSC Ø 50	◯ PSC Ø 50
	◯ HSK Ø 100	◯ PSC Ø 63	◯ PSC Ø 63

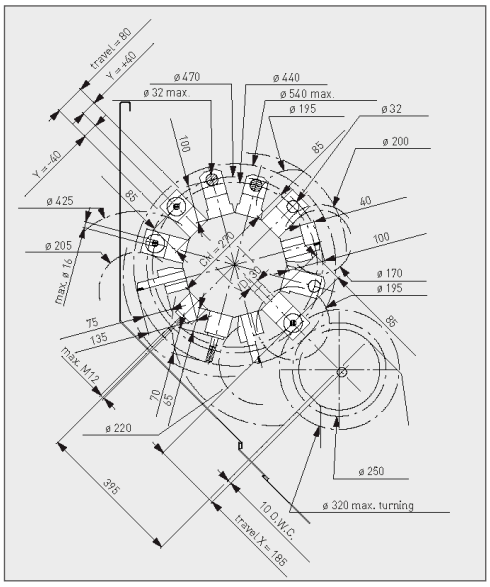
2 Required machine data

To ensure correct tool function we require machine diagrams. Important requirements are the interference diagram, a drawing of the turret interface and a working range diagram. These are usually included in the machine documentation, available directly on the manufacturers website, or supplied to the end-user upon request.

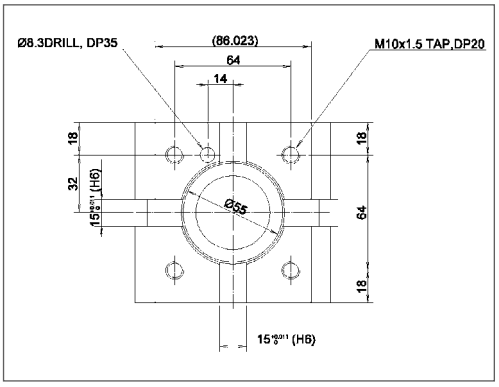
Following are examples of the diagrams we require.



Work range diagram



Interference diagram



Turret Interface

The quickest solution will be provided if we receive all required data with your initial inquiry.
If there is no way to collect all data, please contact us.

3 Machine data

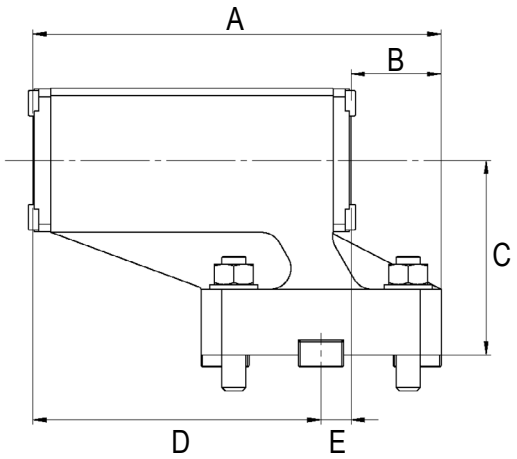
The machine diagrams usually include multiple models. To avoid complications, please fill out the questionnaire below to define your exact make and model.

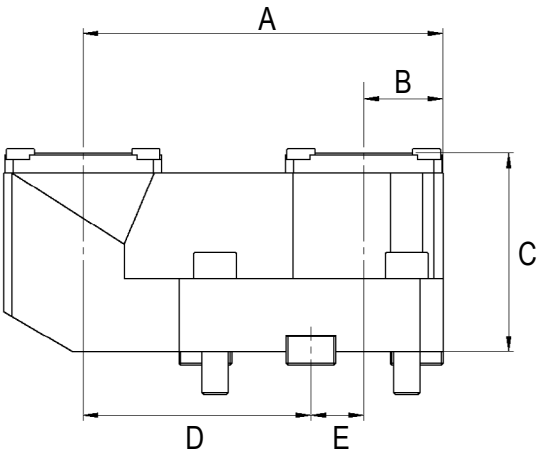
Machine manufacturer	.....			
Machine model	.....			
Interface	Type:		Size:	
Tailstock	◯ yes	◯ no		
Dual spindle	◯ yes	◯ no		
Y-axis	◯ yes	◯ no		
Disc or star type turret	◯ disc type turret	◯ star type turret		
Turret count	◯ 1	◯ 2	◯ 3	◯ 4
Interface count per turret	.....			

Additional, unusual Features that may impact the work range can be noted below.

4 Preferred dimensions and customer notes

If you have specific dimensions you would like us to work with, you can fill in the drawings below or add your own sketch.



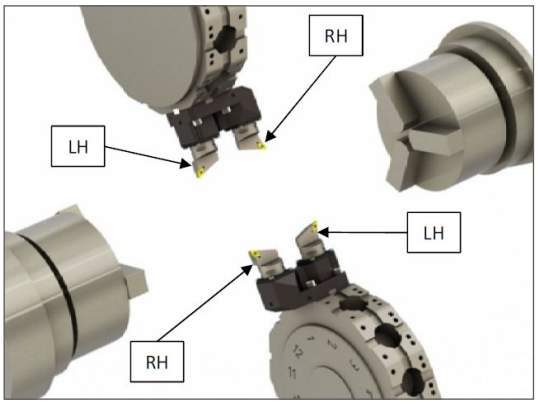


If you have any other remarks which could help us regarding the machine or the tool you would like us to design, please write them down here:

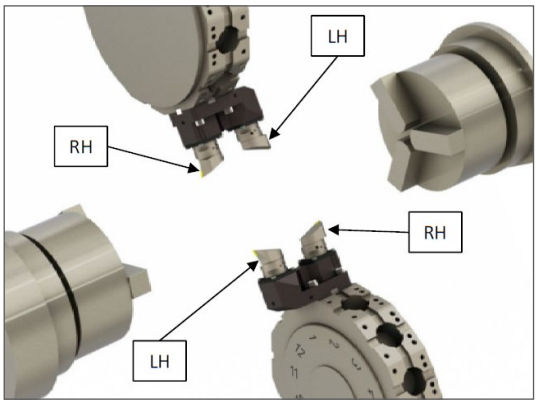
5 Tool orientation

All tool holders manufactured consist of a basic body and the corresponding clamping unit. The installation position of the clamping bush defines whether left (LH) or right (RH) handed tools can be used. The tools that can be used are indicated in the graphics below. The clamping units can be converted at any time by the customer. The information below only serves to define the mounting position on delivery. In the graphic below, please mark which installation position, machining type or tools you would like to use.

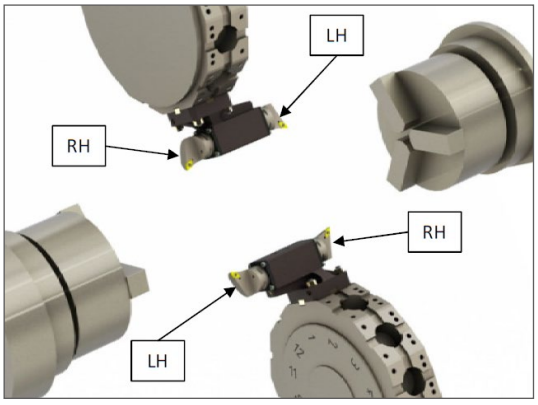
Tool holder straight



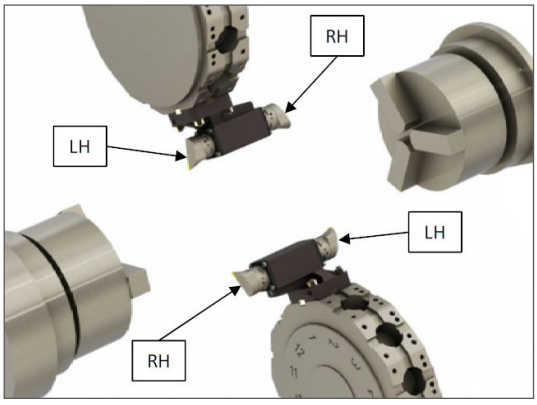
Straight tool holder for overhead turning



Tool holder angled



Angled tool holder for overhead turning

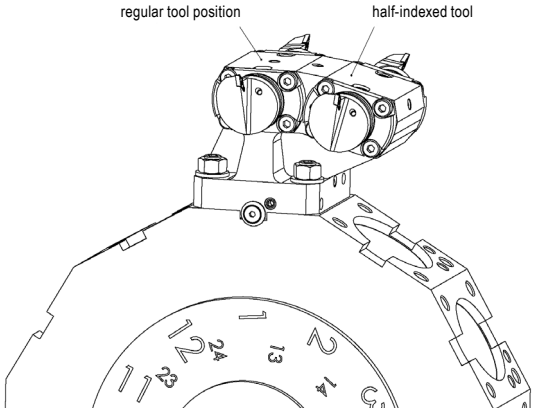


6 Reference guide

Half-index

Half-index describes the capability to rotate the turret to the midpoint of two regular tool positions. Doing this doubles the amount of possible tools mounted to the turret at once. If you have a 12 position turret, the half indexed tool numbers would be 13-24.

Not all machines have the capability to use half indexed tools. Tool holders with half indexing are usually built with a higher offset. This might lead to a decrease of the maximum turning diameter. (If this is the case we will notify you before you approve the manufacturing process)



PSC with front clamping or segment clamping

Both systems are designed to work with the widely available PSC interface (DIN ISO 26623). The biggest difference is the pull stud which has to be screwed into the tool you want to mount. PSC with segment clamping does not require a Pull stud and can be mounted directly, without any modifications.

Rotating the clamping unit can be done with both systems by the end-user with relative ease. The front clamping unit requires less steps and time to complete.

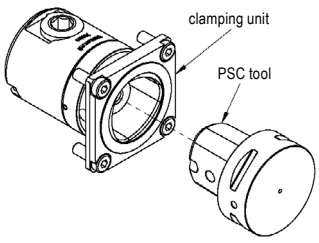
A big advantage of the front clamping units is their comparatively short length. Especially for machines required to turn large diameters or with a small X-axis travel.

As a rule of thumb for straight tool holders: while switching from front clamping to segment clamping units, the size of your clamping unit decreases by one (e.g. PSC63 to PSC50) to achieve the same level of flexibility. However, every case is unique.

Benefits of each system

PSC with segment clamping

- ▲ no pull stud is needed
- ▲ quick mounting and dismounting of tools
- ▲ withstands higher coolant pressures



PSC with front clamping

- ▲ smaller required size
- ▲ easier rotation of clamping unit
- ▲ higher clamping force