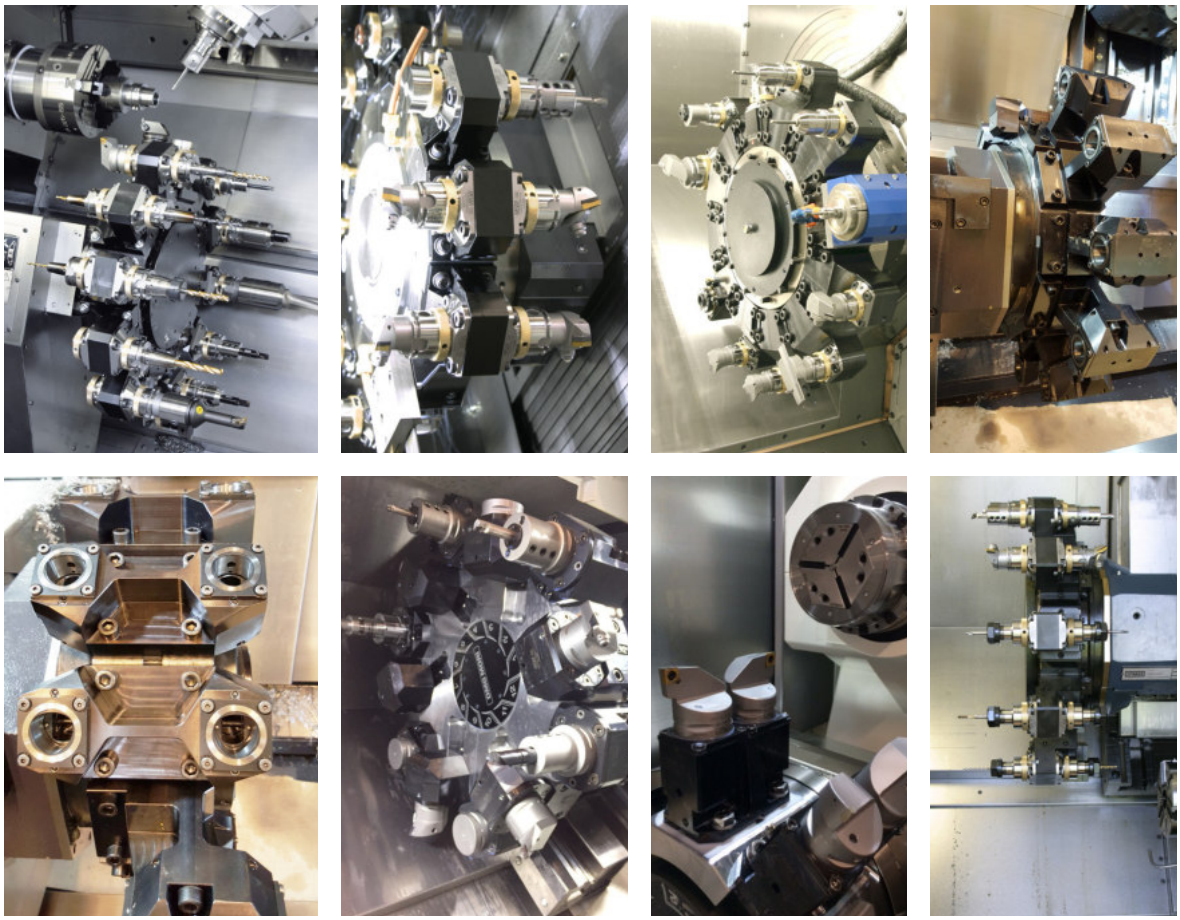
QUICK-CHANGE Anfrageformular /

QUICK-CHANGE Inquiry form

QUICK-CHANGE Werkzeugsysteme für Multi-Task und Drehmaschinen

QUICK-CHANGE tool system for multi-tasking and turning lathes



Quick-Change Inquiry form

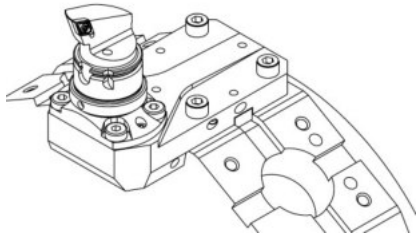
Our Quick-Change tool holders are individually designed to meet costumer wishes as well as achieve the most efficient and flexible solutions for your specific machine. The following form is designed to inform us of what kind of tool holder you are looking for. The form does not have to be filled in completely. A draft can usually be designed with the most basic information.

If you have questions or need assistance, please feel free to contact your technical support.

Tool selection

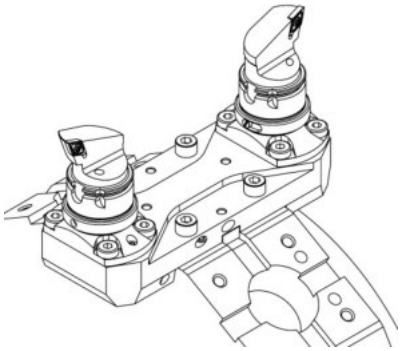
If you already know which type of holder you require, please fill in the amount below. All the listed tools below are able to be designed with a half-index position. If this is required, please mark the corresponding box.
(Half- index is explained on page 4)

Tool holder straight
These holders are exclusively for external turning.



Amount: _____ pieces

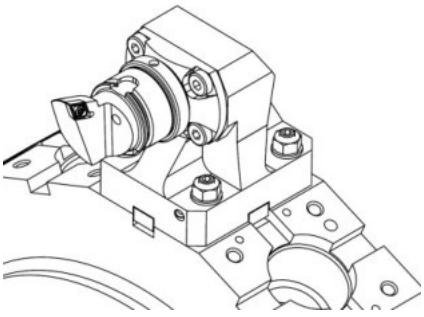
□ with half-index



Amount: _____ pieces

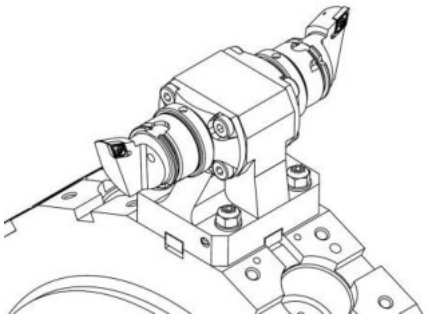
□ with half-index

Tool holder angled
These holders can be used for external and internal turning.



Amount: _____ pieces

□ with half-index



Amount: _____ pieces

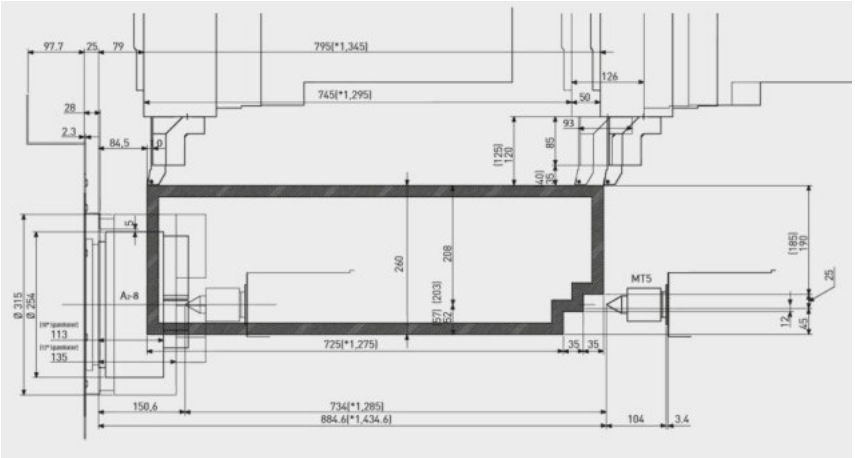
□ with half-index

Clamping unit	HSK-T	PSC with front clamping	PSC with segment clamping	KM
	□ HSK Ø40 □ HSK Ø63 □ HSK Ø100	□ PSC Ø40 □ PSC Ø50 □ PSC Ø63	□ PSC Ø40 □ PSC Ø50 □ PSC Ø63	□ KM32 □ KM40 □ KM50 □ KM63

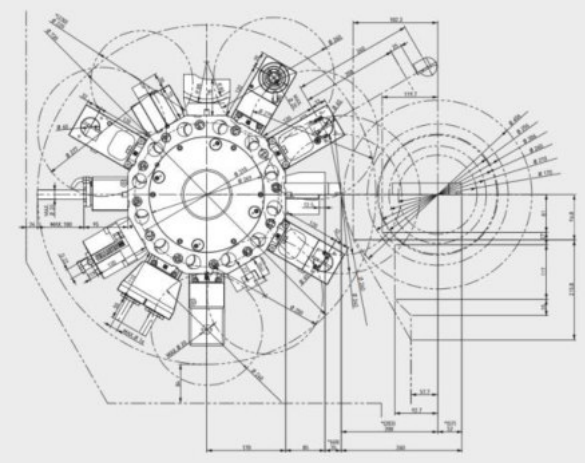
Required machine data

To ensure the tool functioning properly we require the machine diagrams. Important is the interference diagram, a drawing of the revolver 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.

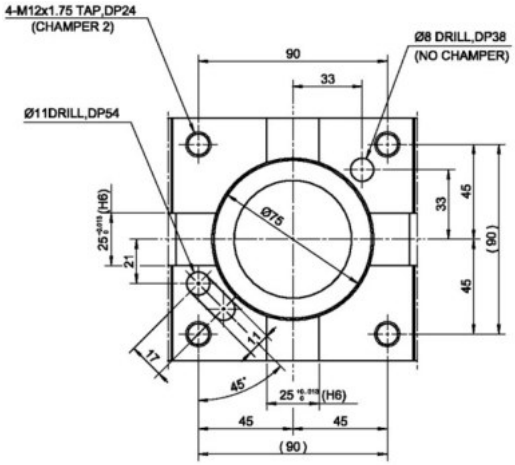
Following are examples of the diagrams we require.



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.

Machine data

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

Machine manufacturer: _____

Machine model: _____

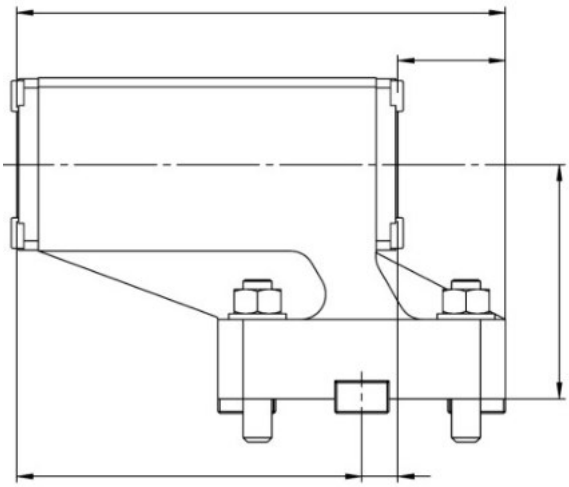
Tailstock:	□ yes		□ no	
Dual spindle:	□ yes		□ no	
Y-axis:	□ yes		□ no	
Disc or star type turret:	□ disc type turret		□ star type turret	
Turret count:	□ 1	□ 2	□ 3	□ 4

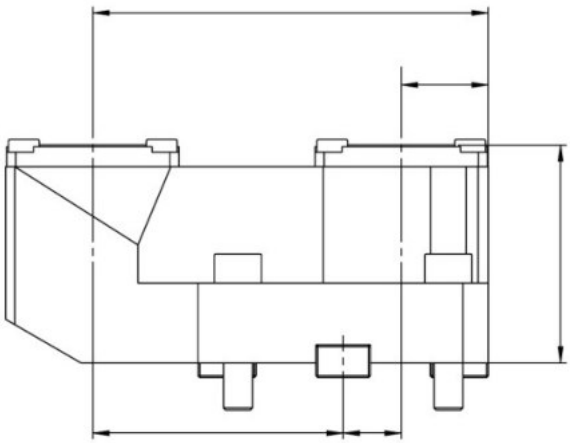
Interface count per turret: _____

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

Preferred dimensions and costumer 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:

_____

_____

_____

_____

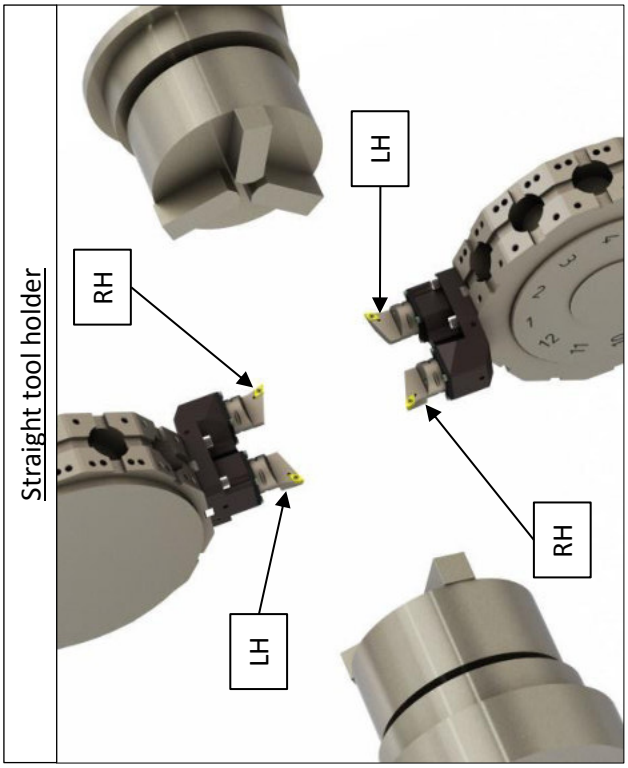
_____

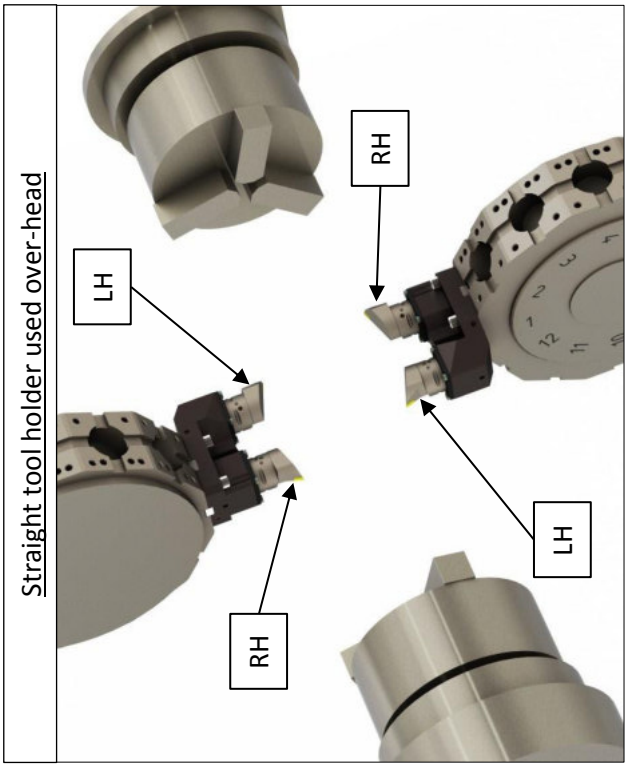
Tool Orientation

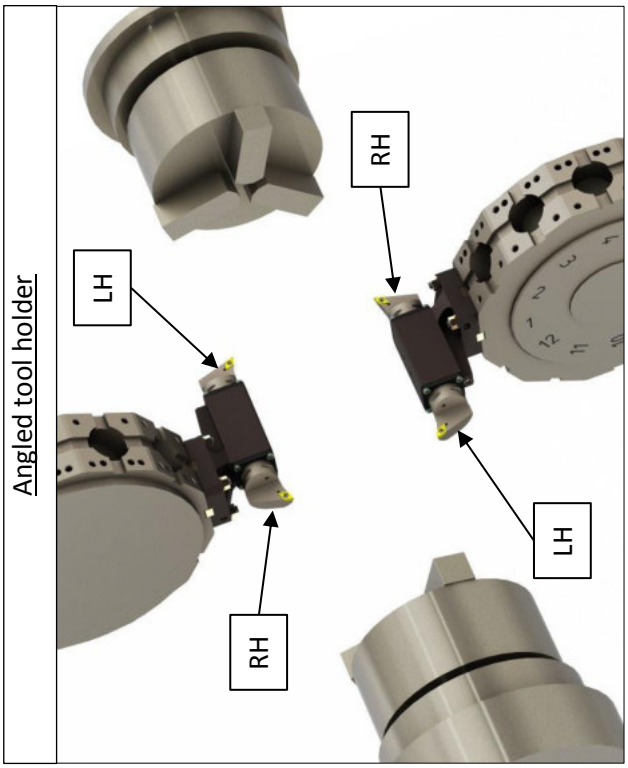
All our tools are designed as base bodies with different clamping units attached. The orientation of the Camping unit defines which type of tools can be mounted to the tool holder: left hand (LH) or right hand (RH) tools. All possible clamping unit orientations and their required tool orientation are visualized below.

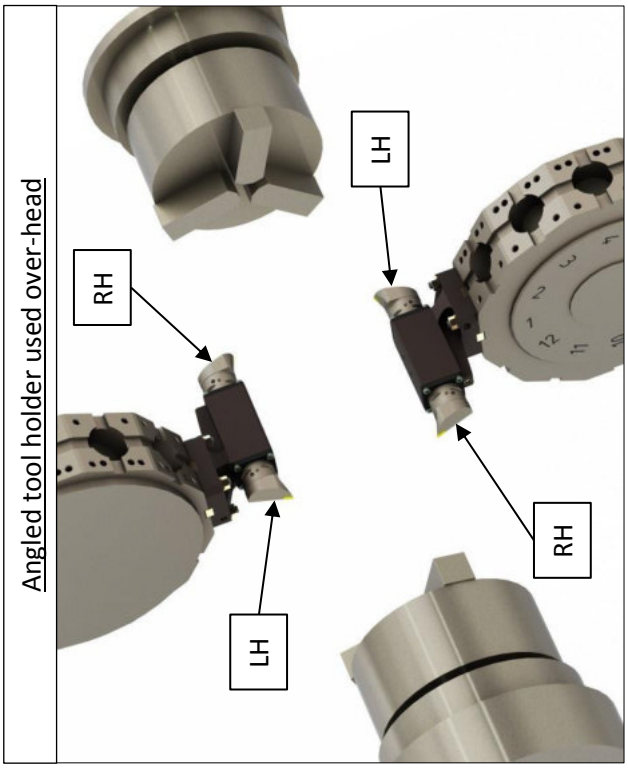
All our clamping units can be flipped 180° by the end costumer with relative ease. The information you provide below only defines how the tool holder will be delivered.

Please Mark the orientation or tools you would like to work with below.





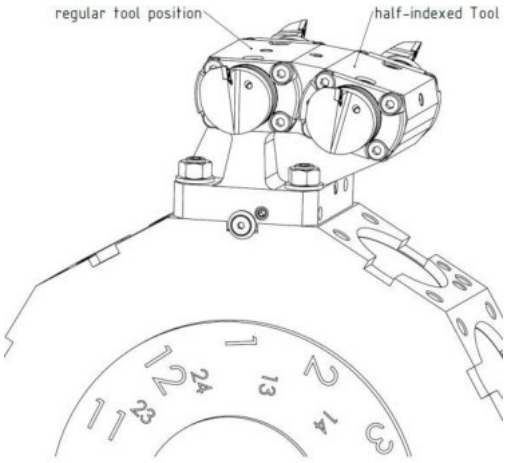




Reference guide

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 usually have to be built higher. 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 (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.

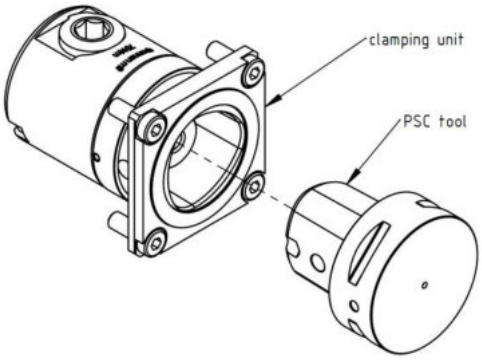
Big advantages of the front clamping units are also there comparatively small length. Especially for machines required to turn big diameters or have a small X-axis travel.

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. But it always has to be looked at on a case by case basis.

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