EPPINGER Manual (Assembling and Handling) for Driven BMT-Tool holder (4 Key-Tooling-System)

Eppinger BMT - tool holder have got 3 outstanding technical characteristics:

- 4 Preset Keys
- Our PRECI-FLEX® Adapter-System
- The Compensation Clutch (CC)

GENERALLY

1. Each driven tool holder has got his own test protocol, that documents the proven geometrical accuracy.
2. Our tools are completely maintenance-free owing to the used Long-Life-Grease. Bearings and gears are greased with: Make Klüber, NBU15 Isoflex.
3. Every driven unit was checked for temperature and ride disturbance. This means, that the tool holder are immediately ready for working processes!
4. Technical information and individual equipment for each tool are available at our online-database: (http://katalog.eppinger.de).

INSTRUCTIONS FOR TOOLHOLDER CHANGE

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<th>Basically:</th>
<th>To guarantee an optimal function of the toolholder we require a clean tooling interface. Only this ensures the highest possible precision of the handling process.</th>
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- The position of the holes from the coolant supply have to be equal between tool and turret.
- Adjust the CC-coupling: The main flat (1) has to be 90 degrees oriented to the Z-axis
- Insert the driven unit in the turret until the tool contacts the surface of the turret.
- Tighten the four clamping-screws (2) with a key and notice the maximum torque! (see the sign for the torque (3) on the tool holder)
- The 4 preset and patented keys are guaranteeing an automatical accuracy of the tool holder in the Y-axis even an exact parallelism to the Z-axis of +/- 10 micron. That implies that there is no further adjustment of tool holder necessary!

(Picture 1)

Caution: You are not allowed to misplace the sealed adjusting-screws (4) of the keys!
TOOL CHANGE

Attention: - Remove or tighten collet nut or PRECI-FLEX® adapter on working position!
- Do not remove or tighten collet nut without hook wrench!

Instructions for adapter change (PRECI-FLEX® - interface)

1. Remove the four screws (a) from the base holder.
2. Clean the taper and flat mounting surface from the adapter and the base holder.
3. Install and tighten the four screws (b) with the T-wrench (c)
4. Use the hook wrench (d) to detain the spindle from rotating

→ The conical and flat face planar interface ensures highest accuracy and rigidity!

![Diagram of adapter change](Picture 2)

TECHNICAL FEATURES COMPENSATION CLUTCH (CC)

1. Better power transmission owing to lower tolerances between the couplings of tool holder and machine.
2. Lower vibrations from the machine up to the tool.
3. Extended lifetime of machine and coupling.

Important: The floating of the compensation clutch is a part of the function. Therefore you are not allowed to misplace or tighten the “Radial-Screw” (5) (see Pic 1)! Otherwise we cannot ensure the functionality!

TECHNICAL INFORMATION FOR DRIVEN UNITS WITH INTERNAL COOLANT SUPPLY

1. Don’t run the tool holder without coolant! → Danger of overheating!
2. Permitted coolant pressure = 25 bar / 360 psi at standard – 100 bar / 1450 psi at high pressure.
3. Coolant fluid has to be filtered with minimum 50 micron!
4. In general you are able to modify the tool holder into external coolant supply.
5. Coolant tubes, sealing rings for collet nuts and spindle-sealings are available at our online-database: [http://katalog.eppinger.de](http://katalog.eppinger.de).

BASIC NOTES FOR USAGE

Remove all resources for the assembling (Spanner-Wench, etc.) from the tool holder even from the working area of the CNC-lathe, BEFORE you start the working process!

MAINTENANCE AND SERVICE

To reach a long lifetime of the driven units, please don’t use strong chemical cleaning agents. Even don’t use compressed air for wiping the tools and protect all the surfaces with oil or other anticorrosives.