

SHRINKIN^{IN} INDUCTION UNIT INSTRUCTIONS



Shank Type 1

Shank Size 2

Shank Length

Bore Cleaning 4

SRKIN 5

SRK 6

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.

Max Runout T.I.R. 3 µm

Slim Design 4.5°

Powerful Clamping Force

Balancing Screw

Rigidity & Stiffness by Taper + Face Contact

High Power HSK Clamping

Short Insertion Clearance

Long Clamping Area

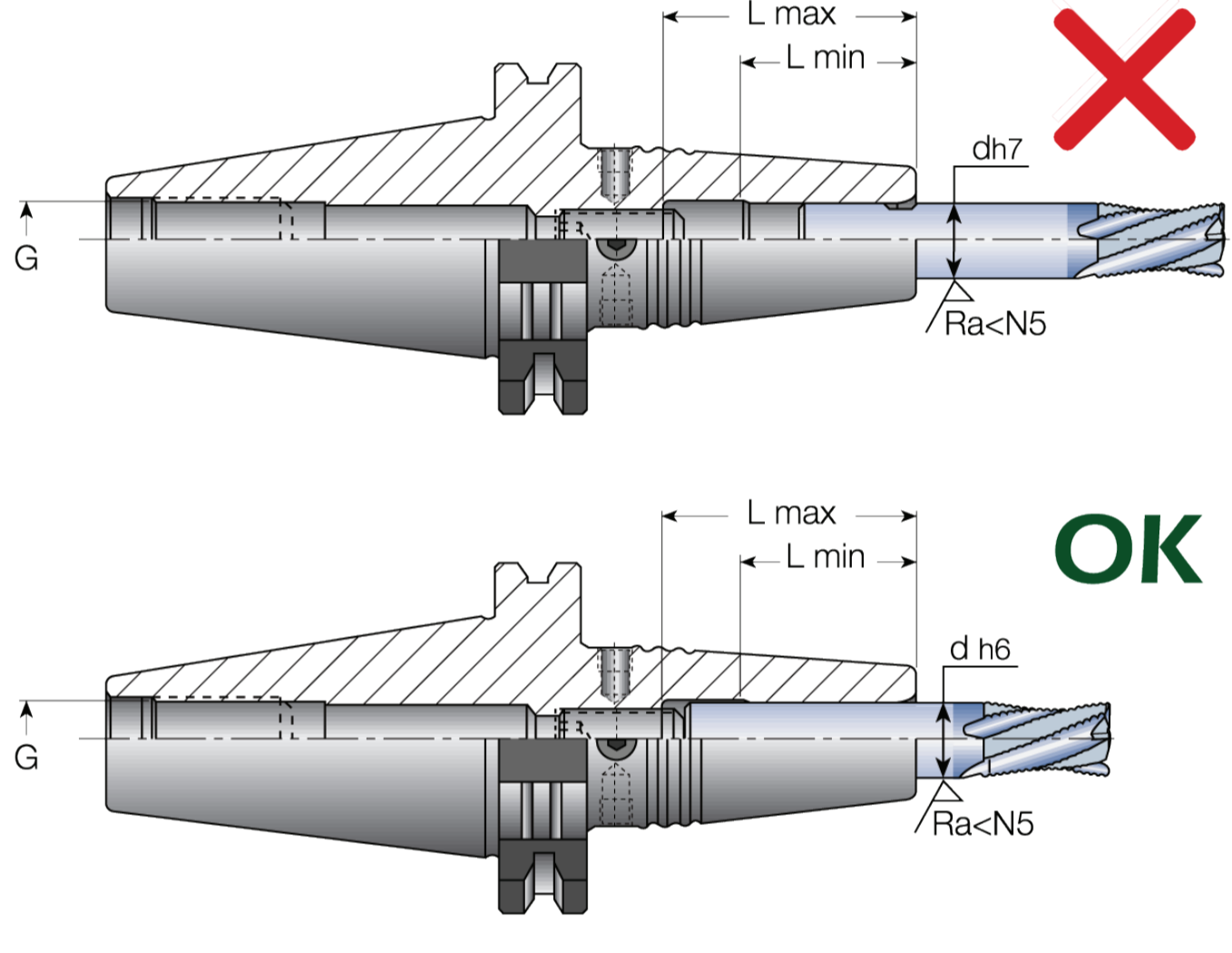
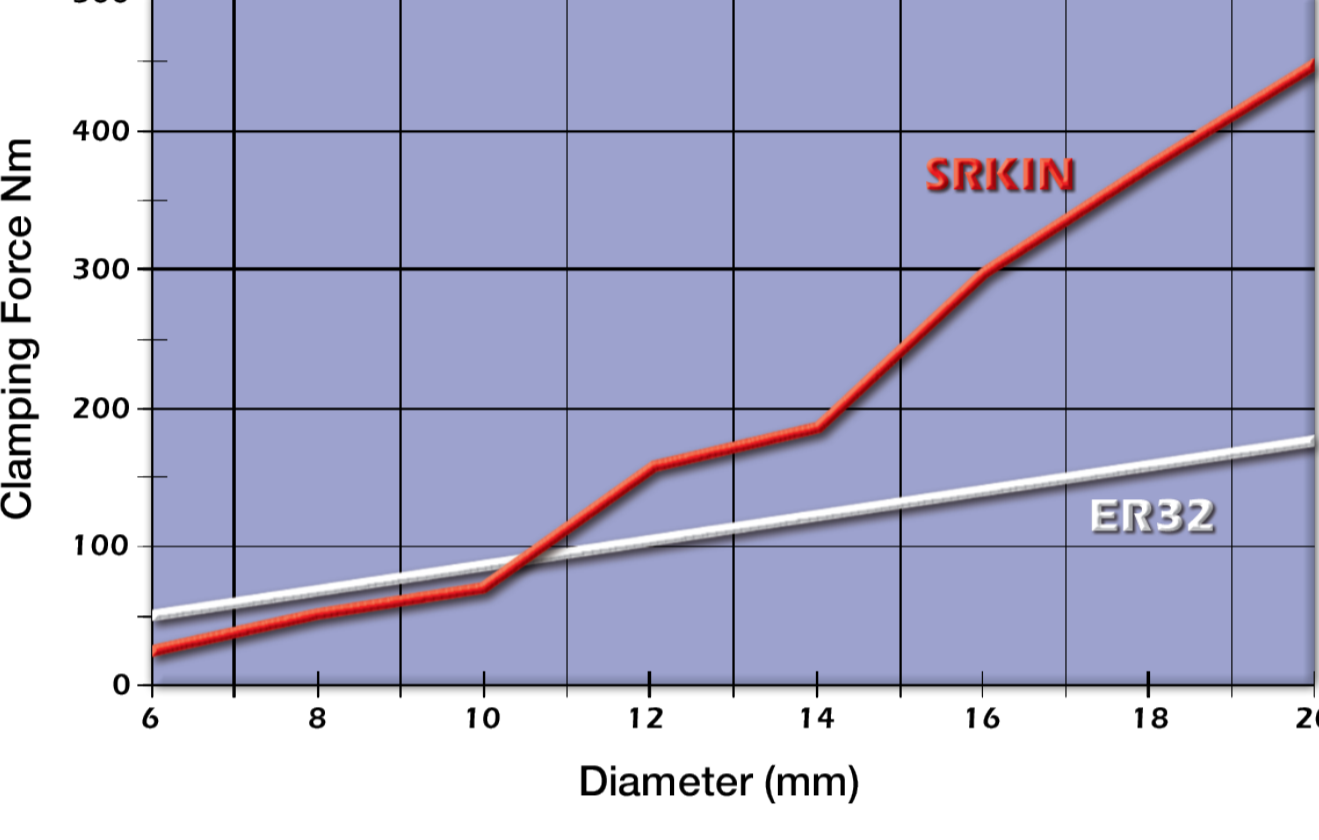
Balancing Screws

Preset Screw

Symmetrical Design

Made from Durable H13 Steel

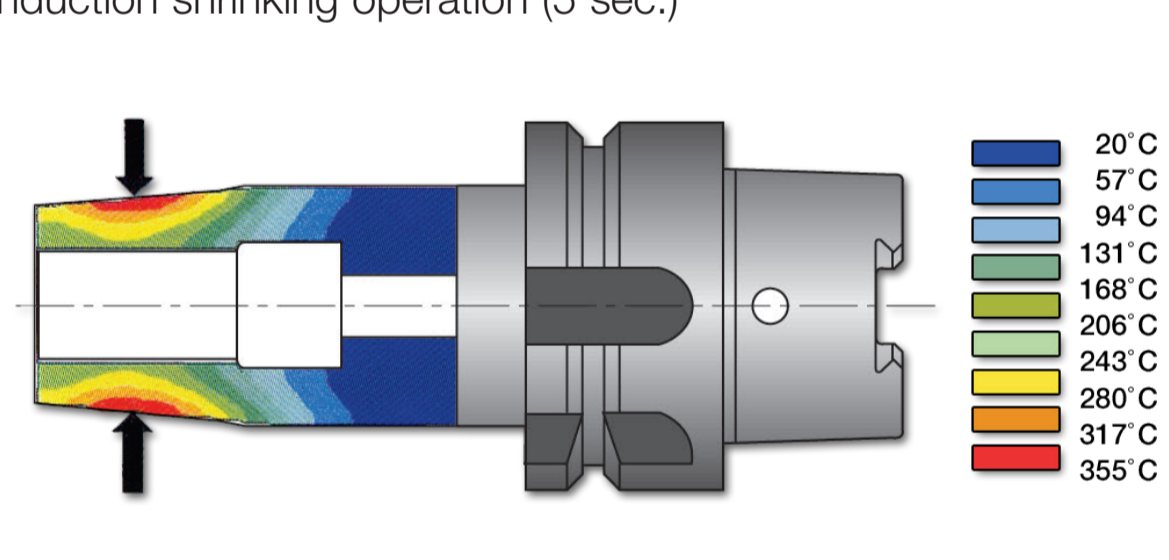
SRKIN Clamping Force vs. ER SPR32 Collets



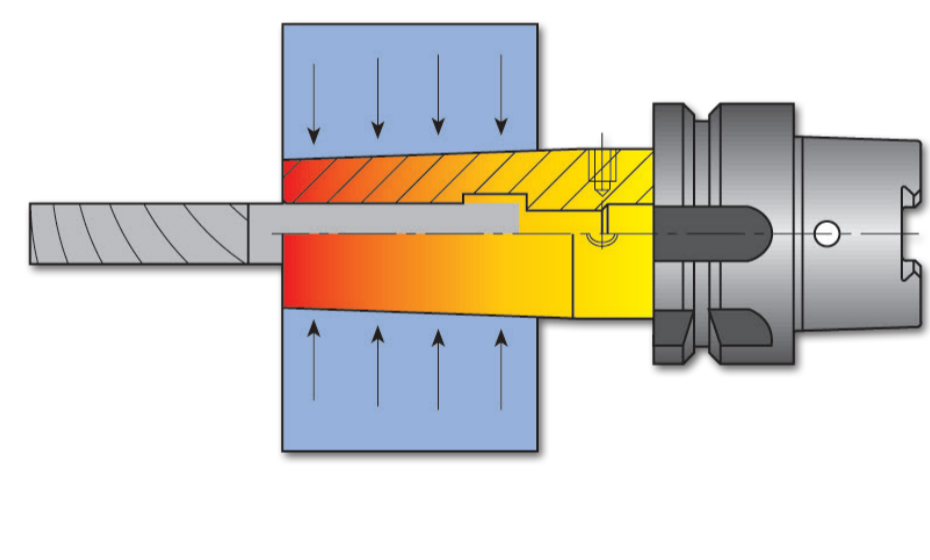
Important Note

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

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



Quick water cooling system (30 sec.)



Features

- High accuracy runout OD-ID 3 µm
- 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 10 mm range
- Special high alloy H13 steel with high thermal shock resistance over 500° C
- Toolholder life exceeds 5000 mounting cycles

The INTEGRAL SRKIN holders are designed for tools in the diameter range of 6-32 mm for heavy milling operations. The ER... SRK are intended for high speed machining using tools in the 3-12 mm diameter range on a standard collet chuck or milling heads on turning centers. They are available with 3 different projection lengths: 35, 60 and 85 mm.

Thermal Chuck Adaptation Options

Adaptation Type	SHRINKIN Collets	Heating Unit
FLEXFIT	SRK	Induction
ER COLLET	SRK	Induction
CLICKIN	SRF	Induction
DIN 69871 40.50 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.

