# Notes on setting and handling hydraulic clamping arbor

The hydraulic clamping arbors impress with their easy handling with good stability and damping. The hydraulic clamping arbors are optimally suited to finish and face milling.

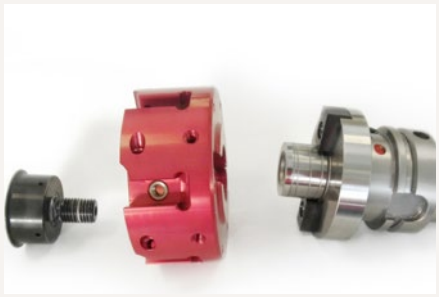
Tools with fit tolerances of H6 can be precisely, permanently and reliably clamped with high accuracy of repetition. Overtightening is not possible.

**NOTE**

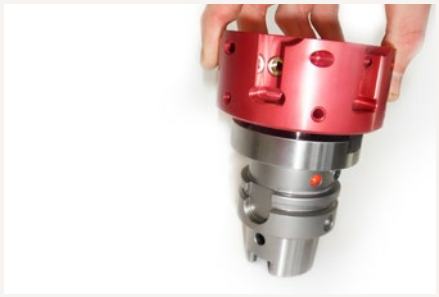
During each tool change make sure that all components of the hydraulic clamping arbor and the tool are free of dirt and grease and are also free of damage.

**Note:**
Only for trained personnel.

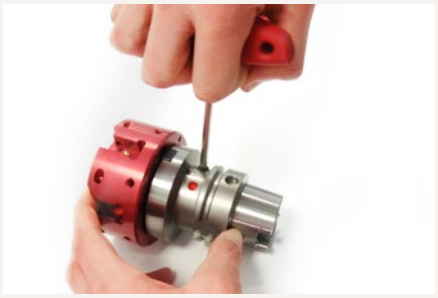
## Changing and clamping the tool



1. Clean the mounting area of the tool and the hydraulic clamping arbor using a cloth.

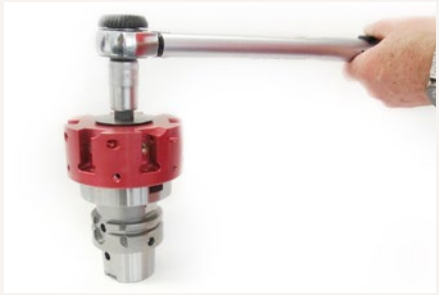


2. Place the tool, with bore and face connection first, on the face connection of the hydraulic clamping arbor.



3. Note:
The centring screws is not secured against falling out.

Turn the centring screw to the stop with the aid of a suitable hexagonal T-key. During this process pay attention to the minimum turns (see table below).



4. Set the torque wrench to the tightening torque of 7 Nm. Tighten the milling cutter clamping screw to the stop with the aid of the torque wrench. Mount the tool in accordance with the information from the manufacturer or using the milling cutter clamping screw in accordance with DIN 6367.

**Result:**
The tool is centred, fully clamped in the hydraulic clamping arbor and ready for use.

| Clamping diameter [mm]* | Minimum turns for centring | Transferable torque [Nm] | Spindle speed n max. [min-1] |
|---|---|---|---|
| 22 | 0,5 | Only centring | 22.000 |
| 27 | 0,5 | Only centring | 22.000 |
| 32 | 1 | Only centring | 22.000 |
| 40 | 1 | Only centring | 10.000 |
| 60 | 1,5 | Only centring | 10.000 |

*Tool clamping with bore tolerance H7