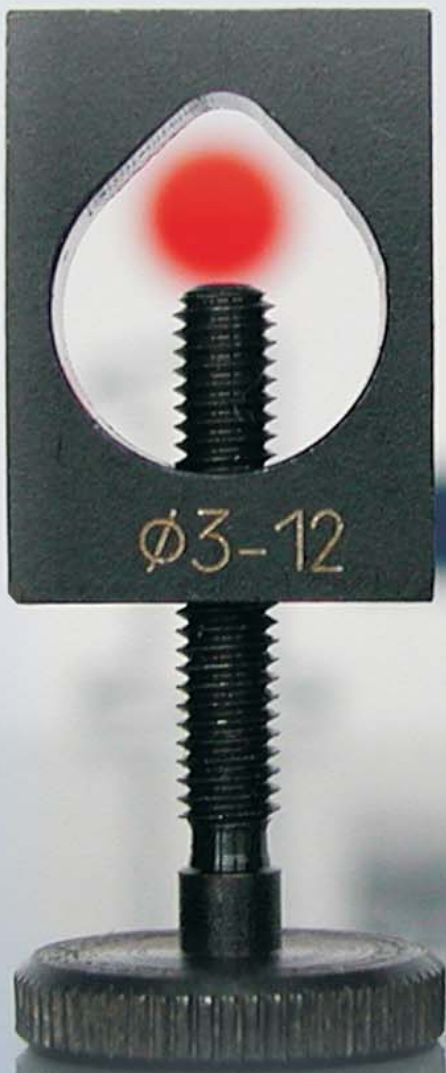


i-tec[®] - Accessories: Practical Aids for Shrinking in and out

NEW

- Ejection device
- Stop clamps
- Shrink-out set



Three new aids
- making it simple -
this way shrinking is even more user friendly

① Ejection device



Use
For the simple ejection of a broken
cutter shank

Ejection device	Ref.no.
Flange with damping disk and ejection pin	313.750

So easy it goes....



Broken cutting tool



Determine the length up to the stop of the tool cutting edge.



Adjust the length of the pin of the ejection device (up to the stop + approx. 2 cm)



Place the shrink fit chuck on the pin.



Heat the shrink fit chuck. As soon as the shrink fit chuck achieves shrink-out



temperature, it drops on to the damping disk.



The broken cutter shank can then be removed easily.

2 Stop clamps



Use
The cutting tool shall be shrunk to a given projection length.

Set of two stop clampgs	Ref.no.
For ø 3 - 12 and ø 14 - 32	313.803

So easy it goes....



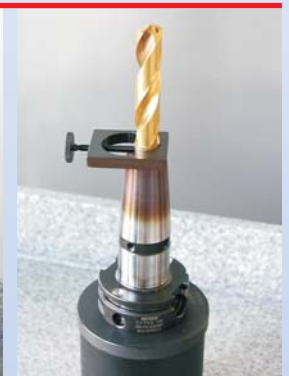
Determine the projection length of the cutting tool (accuracy approx. 0.5 mm).



Heat the shrink fit chuck.



Insert the cutting tool up to the stop.



Let the shrink fit chuck cool down.

3 Shrink-out set



Use
To remove tools at the optimum moment at which the cutting tool releases from the tool holder.

Shrink-out set	Ref.no.
1 shrink-out pliers and 2 shrink-out springs ø 3-12 and ø 14-32	313.801

Advantages:

- The tool holder is heated no longer than necessary (very important for HSS!)
- No risk of burning even without gloves
- Reduces energy consumption and cooling time

So easy to remove....



The pressure spring is clamped, the cutting tool is held by the pliers. Heat the shrink fit chuck.

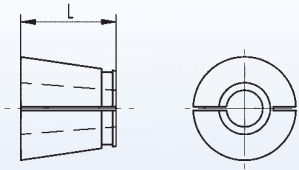


The pressure spring is released as soon as the shrink fit chuck has achieved the right "release heat".



The pliers are gripped with the cutting tool upwards. The induction coil is then lifted clear.

Cooling inserts for shrink fit chucks extensions and shrink fit chucks in extremely slim version 2,5°



Shank diameter d1	Ref.no.
3 and 4	313.121
5	313.122
6	313.123
8	313.124
10	313.125
12	313.126
16	313.127

Expandable

i-tec®-L tower extension for specially long A dimensions



Advantages:

- Simple reconstruction
- Tools up to 1400 mm can be shrunk in and out reliably
- The working range of the tower extension is individually adjustable
- The induction coil remains in position during the shrinking process
- The tool is fixed during the shrinking process
- Simple operation similar to the standard device

Ref.no. 313.810

Unerring

**KELCH CoolStream -
The accurate cooling stream**



On request, i-tec® shrink fit chucks are available with CoolStream coolant feed holes, which are specifically designed to direct coolant to the cutting edge. We are glad to work out an offer for you.

Advantages

- Extended cutting edge service life
- Higher process reliability
- Optimum chip flow
- Better dimensional accuracy
- Improved surface finish