

# Product note

## Hydraulic expansion tool holder

Y adjustment for multiple-spindle lathes

## **Note on applicability**

Illustrations in this publication may deviate from the product supplied. Errors and omissions due to technical progress expected.

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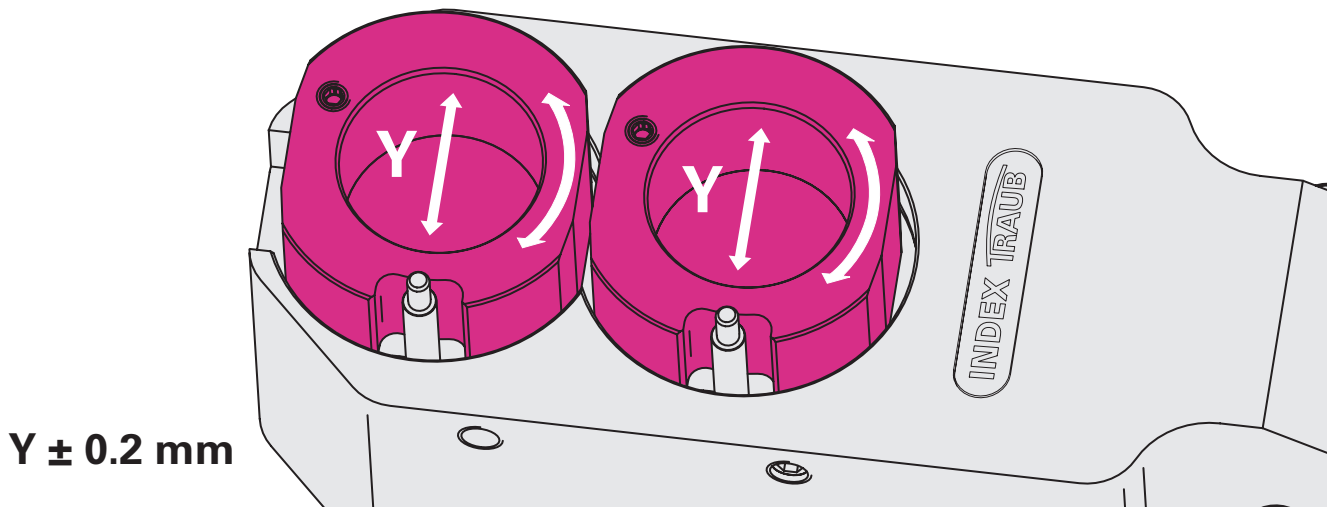
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# Hydraulic expansion tool holder

Y adjustment for multiple-spindle lathes

## Optimum conditions

- Easy and quick adjustment of the tool's Y-orientation by means of the eccentric bush ( $\pm 0.2$  mm)



## Cleaning

- Check cleanliness of the mounting bore and quill

## Clamping

- The quill is clamped by turning the clamping screw up to its stop
- Do not clamp without a part
- Use only original INDEX quills
- Clamp only over the entire length of sleeve

## Temperature

- Optimal temperature range between  $10^{\circ}$  and  $50^{\circ}$
- Do not use at temperatures above  $80^{\circ}$

## Storage

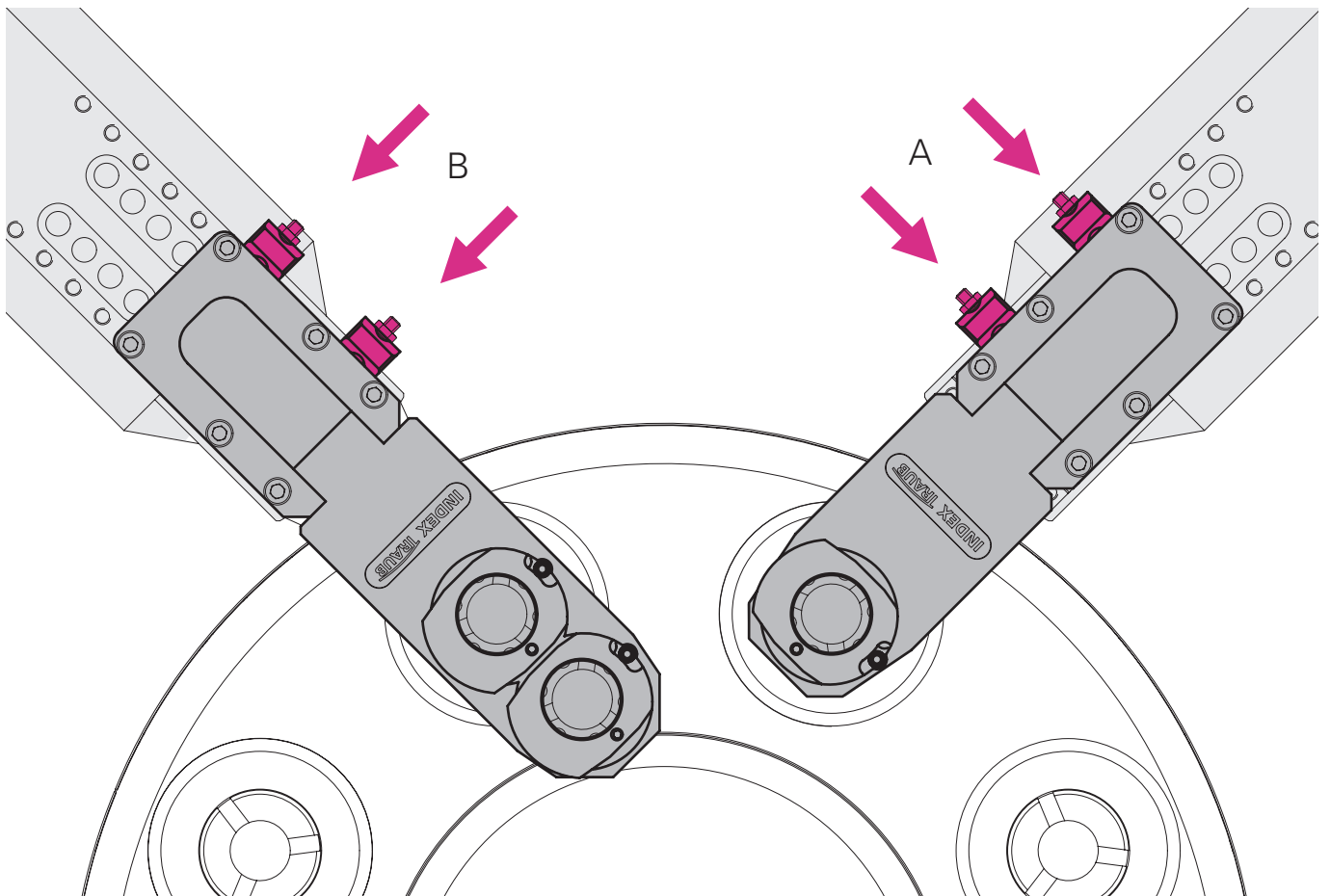
- Store hydraulic expansion chucks unclamped, cleaned and lightly oiled

# Hydraulic expansion tool holder

Y adjustment for multiple-spindle lathes

## Checking the stop position

- The stops should always be on the top of the slide
- The figure shows the stop situation for installation in a right-hand spindle position (A) and for a left-hand spindle position (B)

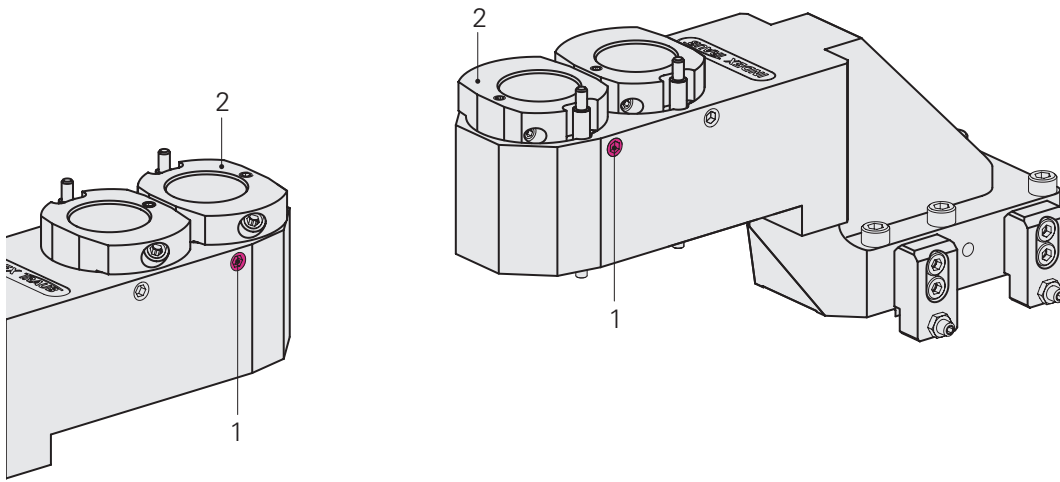


# Hydraulic expansion tool holder

Y adjustment for multiple-spindle lathes  
The installation in the LH spindle position is shown

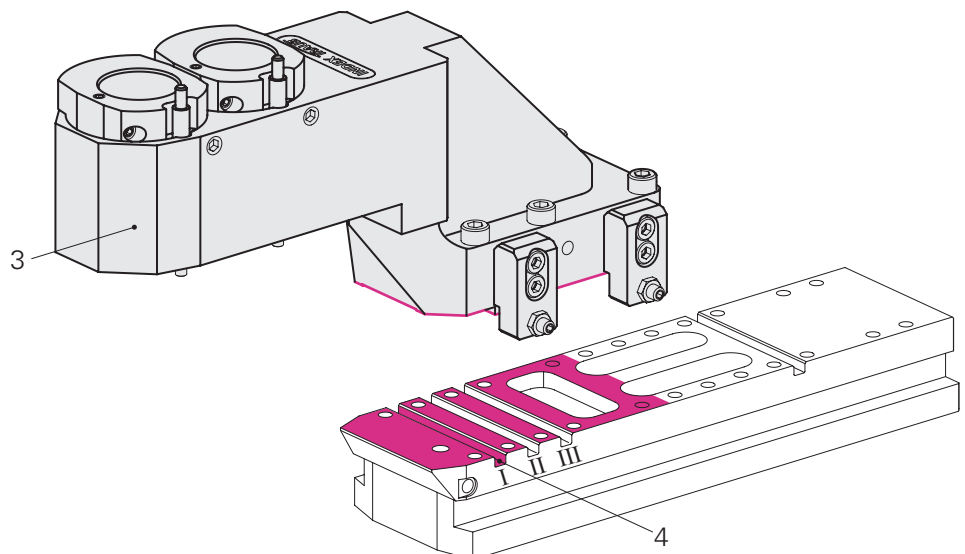
## Preparing the screws

- Lightly tighten ball-ended thrust screws (1) to prevent the hydraulic expansion clamping sleeves (2) from falling out



## Installation and cleaning

- Cleaning of the contact surface
- Mounting holder (3) in slide slot (4) No.I

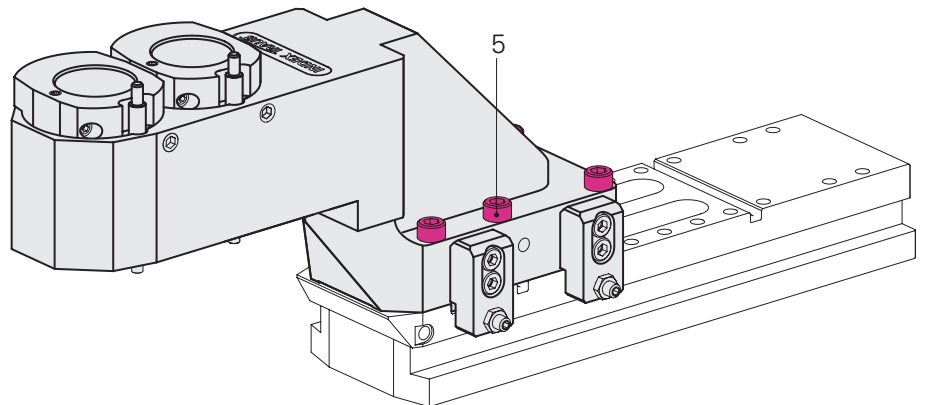


# Hydraulic expansion tool holder

Y adjustment for multiple-spindle lathes  
The installation in the LH spindle position is shown

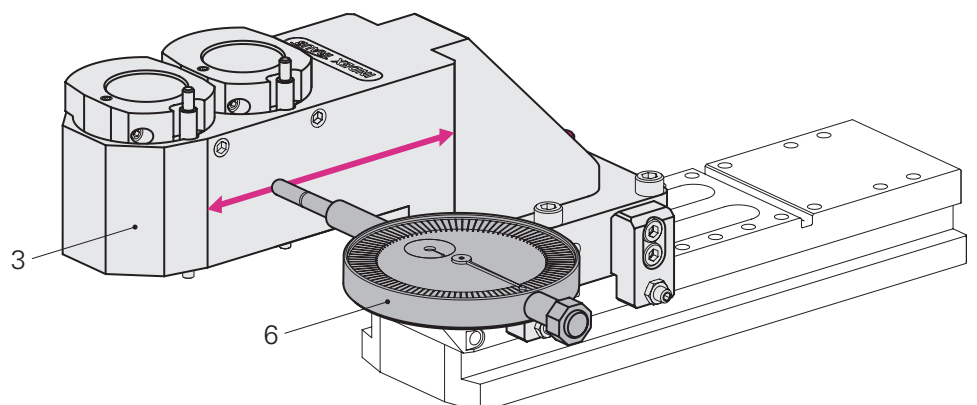
## Mounting

- Tighten the mounting screws (5) with a torque wrench  
M6 with 18 NM  
M8 with 43 NM



## Alignment, checking the position

- Attach dial indicator (6)
- Measure along the holder (3) on a length of approx. 60 mm
- Allowed deviation max 0.05 mm
- If deviation is larger, check mounting of holder (3)



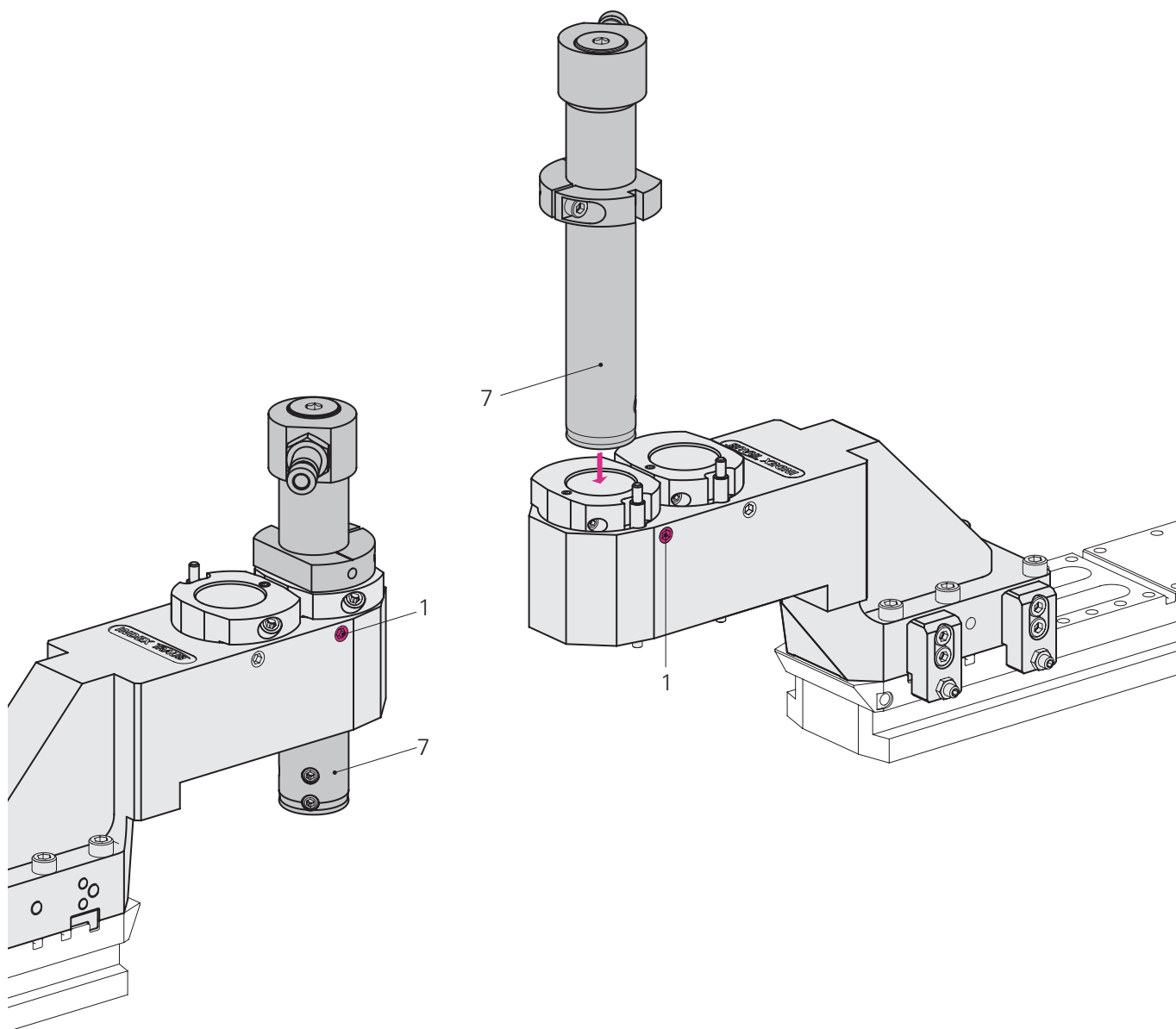
# Hydraulic expansion tool holder

Y adjustment for multiple-spindle lathes

The installation in the LH spindle position is shown

## Inserting quill

- Loosen ball-ended thrust screws (1)
- Insert quill (7)



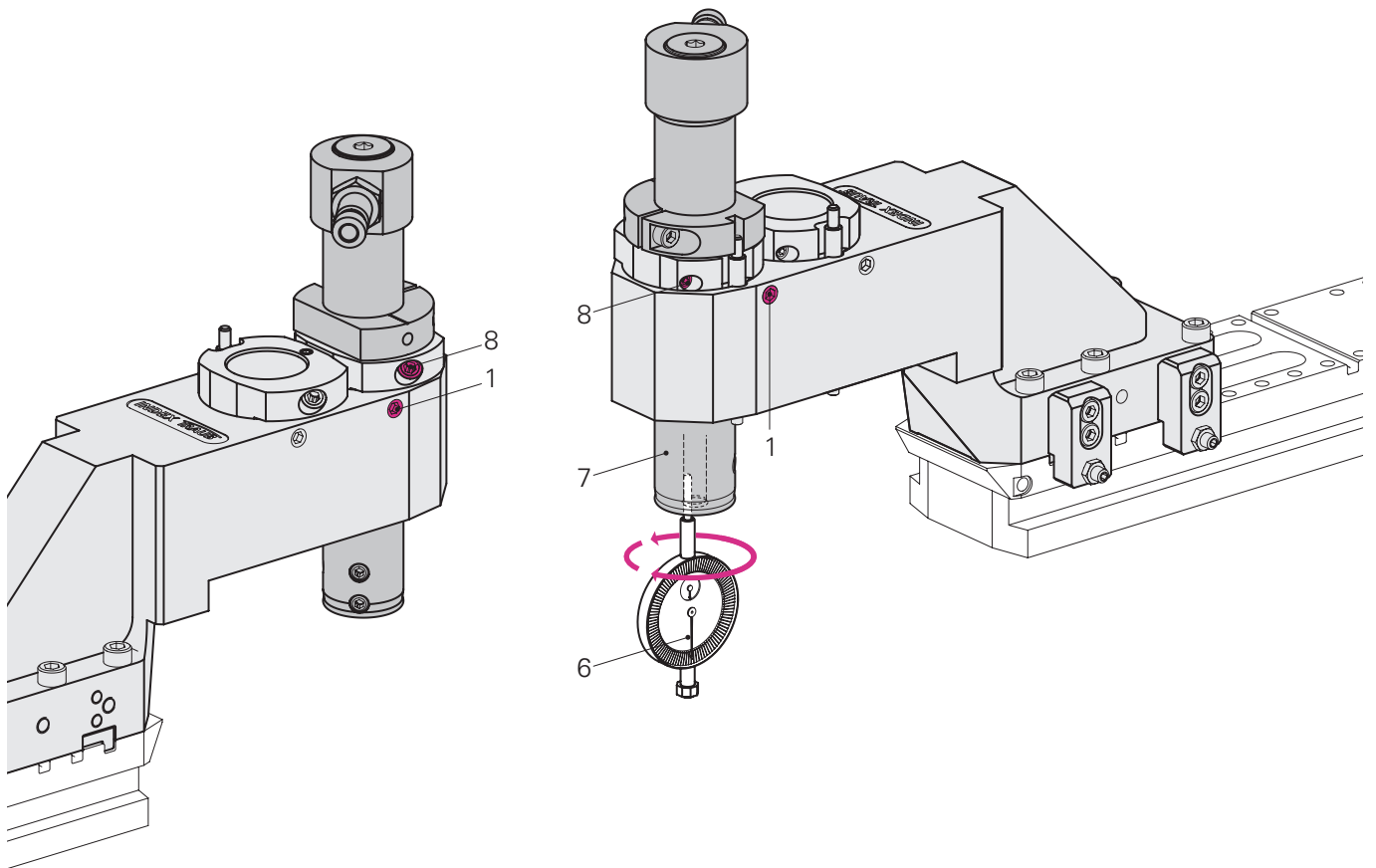


# Hydraulic expansion tool holder

Y adjustment for multiple-spindle lathes  
The installation in the LH spindle position is shown

## Adjustment

- Attach dial indicator (6)
- Center quill (7)
- Lightly tighten ball-ended thrust screws (1)
- Screw in hydraulic expansion clamping screw (8) until it stops
- Check runout



### Product note

Hydraulic expansion tool holder  
W9800012EN-02.02.18

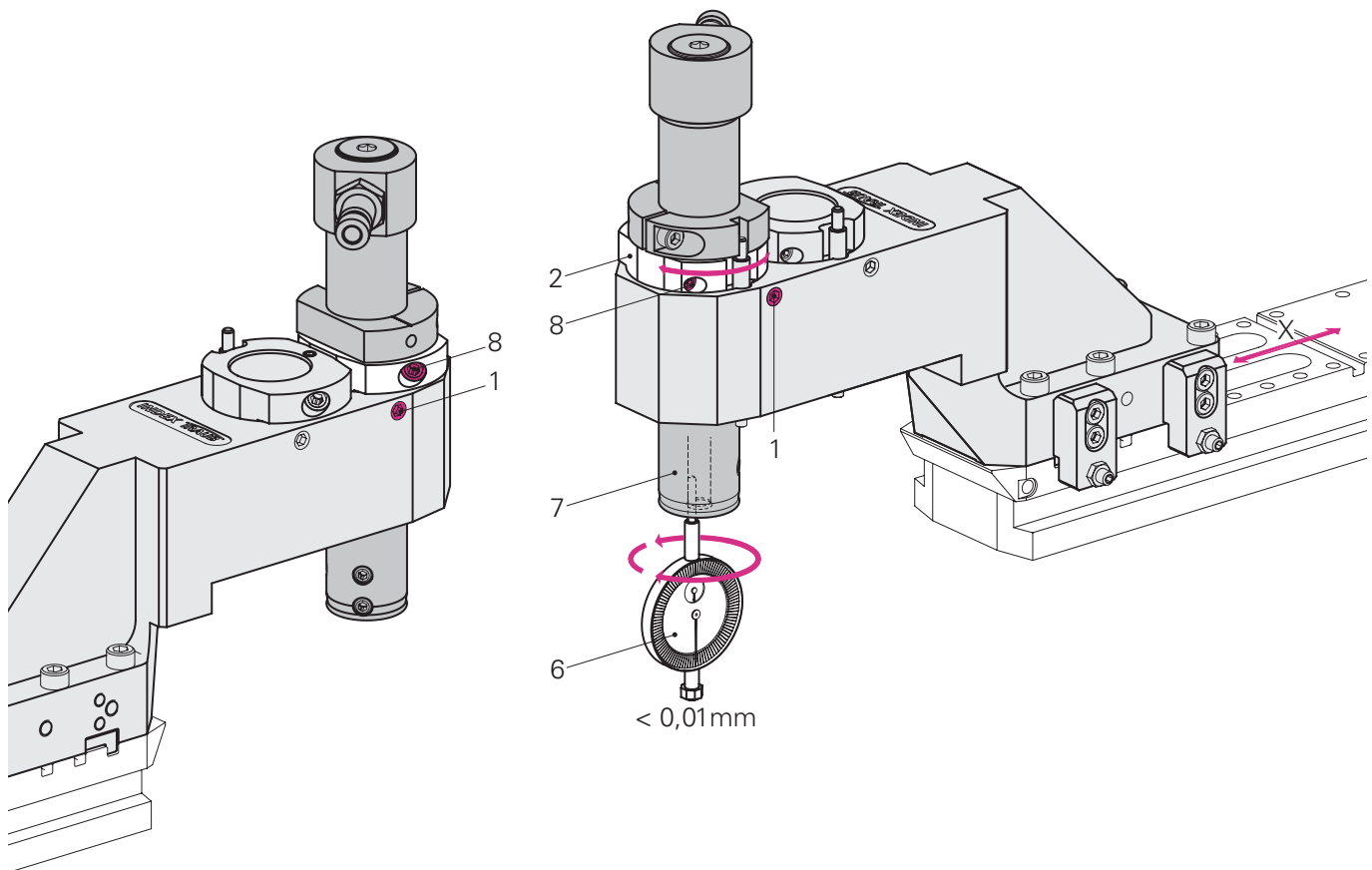
# Hydraulic expansion tool holder

Y adjustment for multiple-spindle lathes

The installation in the LH spindle position is shown

## Adjusting concentricity

- Loosen hydraulic expansion clamping screw (8)
- Adjust the concentricity
  - by turning the hydraulic expansion clamping sleeve (2) using the ball-ended thrust screws (1)
  - by moving slide in X
- Repeat the steps until the runout is  $< 0.01$  mm
- Tighten the hydraulic expansion clamping screw (8)
- Tighten ball-ended thrust screws (1) to max. 1 Nm

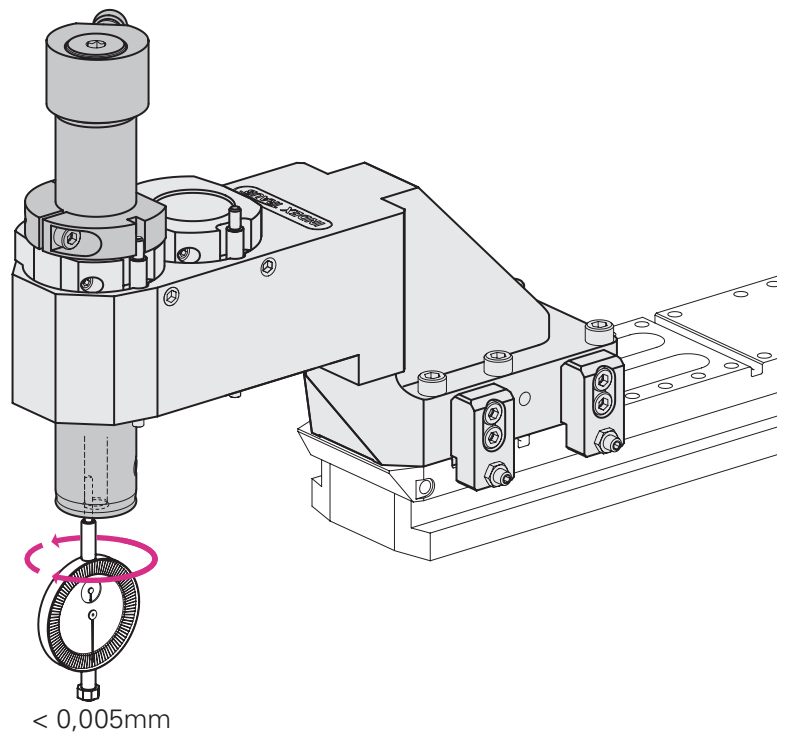


# Hydraulic expansion tool holder

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The installation in the LH spindle position is shown

## Adjustment to below 0.005 mm

- Check the adjustment after warm-up of the machine





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