

## Operating manual



Illustration shows similar product

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## **Foreword**

This operating manual will enable you to use the CENTRO|P.WD collet

- for its intended purpose
- safely

## **Target group for this operating manual**

The operating manual is intended for users of the CENTRO|P.WD collet. We assume that these persons possess general technical skills.

Every person who carries out the following tasks with the CENTRO|P.WD collet should read and understand the entire contents of this operating manual.

- Operation
- Maintenance

If you do not understand the information in this operating manual, or if you feel that information is missing, please inform the respective contact person.

# 1 Safety

To ensure reliable operation, pay attention to the following important information.

## 1.1 Safety information



The tools may have sharp cutting edges and can cause cuts. Wear protective gloves when changing the tool!



When used with rotational motion, protective covers should be used in accordance with the EU Machinery Directive.

## 1.2 Intended use

CENTRO|P.WD is a precision tool and must be handled with appropriate care. Avoid mechanical, chemical or thermal effects that exceed the stress levels normally encountered in proper use.



Only technically trained personnel should clamp tools and insert the CENTRO|P.WD collet into the chuck while observing the technical data for the chuck.



Avoid long-term contact with corrosive and solvent-based chemicals.



In order to avoid damage, the brass pin may not be actuated without a tool. The brass pin serves exclusively as a travel limiter, not for locking/unlocking.

## 2 Clamping / unclamping

### 2.1 Usable shaft types

Cylindrical shape B as per DIN 1835 Part 1 and DIN 6535 HB shape B with lateral driving planes.



### 2.2 Inserting the tool into the CENTRO|P.WD collet



Risk of injury!

Wear gloves when inserting the tool.



Clean all components before use!



The brass pin serves as a travel limiter, not for unlocking or as an ejector!

- a) Insert the tool into the collet.  
(Clamping surface of the tool parallel to the key).



- b) Push the tool into the collet until the key lifts and then engages.



### 2.3 Inserting the CENTRO|P.WD collet into the chuck

- a) Insert the collet with the clamped tool into the clamping nut so that the clamping slope contacts.



- b) Turn the assembled components upright and hold by the tool. Then insert into the chuck.



- c) Tighten the clamping nut by hand to the stop (gap between nut and chuck  $< 2$  mm). Backlash can be eliminated by pulling the tool in an axial direction (important for backlash-free extraction prevention). Then tighten the nut by hand.
- d) Tighten to the specified torque using the appropriate wrench.

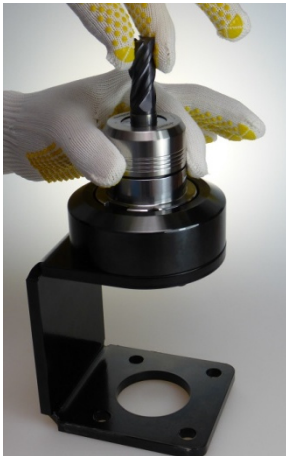


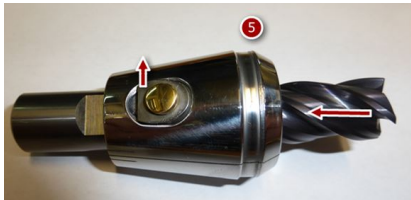
Fig. 1: c)



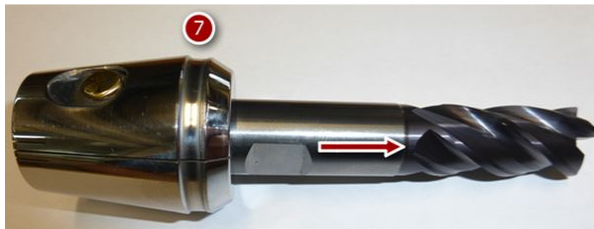
Fig. 2: d)

## 2.4 Removing the tool from the CENTRO|P.WD collet

- a) Push the tool into the collet until the key lifts. Then rotate the tool by 90°.



- b) Pull the tool straight out of the collet.



### 3 Care and storage

Clean and lightly oil the CENTRO|P.WD collet before putting into storage.



Avoid long-term contact with corrosive and solvent-based chemicals/cleaning agents when cleaning. These solvents include, but are not limited to: petroleum ether, thinners, brake cleaner, etc.



Use only mineral-based oils, e.g. Ballistol




Protect against direct sunlight



In case of long-term storage, ensure that the CENTRO|P.WD collet key is in the relaxed position. Do not store with a tool inserted into the collet.

### 4 Technical data

#### 4.1 CENTRO|P.WD tightening torques

GER32-WD	 Nm
Ø12 mm   1/2"	140
Ø14, 16, 18 mm   5/8"	180

#### 4.2 Versions

Description	Concentricity	D	L	Bore sizes
GER32-WD	5 µm	33	40	Ø12, 14, 16, 18 mm Ø1/2", 5/8"