

Metalworking

ETP
HYDRO-GRIP



ETP HYDRO-GRIP & ECOGRIP

OPERATING INSTRUCTION

Description

HYDRO-GRIP and ECOGRIP high precision toolholders are your guarantee of secure clamping for milling, drilling and reaming tools. Their unique strength provides precision and rigid-tool stability to improve machining performance for the largest number of applications. With the extensive range of high precision toolholders all application areas, from finishing to heavy roughing, is covered. Bore diameters 6 – 32 mm available.

Benefits and features

- Easy handling and tool change
- Minimum tool run-out ensures good surface and extends tool life
- High speed capability
- Dampens noise and vibration

Technical Specification

Tools

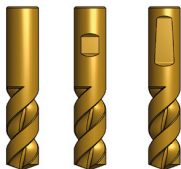
Tools should be of correct dimension and tolerance, h6 or h7, and well cleaned.

ETP-HYDRO-GRIP / ETP-HYDRO-GRIP PENCIL

We recommend the use of cylindrical tools for optimal performance and precision.

However all types of tools such as Weldon, Whistle Notch can be clamped.

Note: exclusive of dimension 6 - 10 mm!

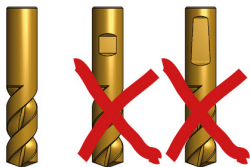


d_{mt} 12 - 32 mm.

ETP-HYDRO-GRIP HD / ETP ECOGRIP

We recommend the use of cylindrical tools for optimal performance and precision.

Non cylindrical tools are preferably used together with a reduction sleeve.



d_{mt} 6 - 10 mm.



Balancing grade

HYDRO-GRIP: G 2.5 at 25 000 rpm for PSK C4-C6, HSK 63 and ISO40

G 2.5 at 14 000 rpm for PSK C8, HSK 100 and ISO50

ECOGRIP: G 6.3 at 15 000 rpm for all shank types.

Pressure screw

Recommended tightening torque	Nm
ETP HYDRO-GRIP	6
ETP HYDRO-GRIP PENCIL	6
ETP ECOGRIP	6
ETP HYDRO-GRIP HD	10

Assembly instructions



1. The tool and holder must be thoroughly cleaned, removing all traces of grease and other impurities.



2. Place the tool in the chuck.



3. Mount the tool by tightening the pressure screw to the recommended tightening torque, marked on the holder. Use a fixed torque wrench.



4. The holder and tool unit is now ready to be installed on the metalworking machine.

Handling

ETP HYDRO-GRIP and ETP ECOGRIP are high precision toolholders and should be handled with care for optimal performance

- Before inserting tool, check for damages on tool and holder.
- Tools should be of correct dimension and tolerance (h6 or h7), and cleaned.
- Do not use force to insert tool, it should easily slide in position.
- All HYDRO-GRIP and ECOGRIP holders can be used with reduction sleeves when needed.
- Mount the tool by tightening the pressure screw to the recommended tightening torque, marked on the holder. Use a fixed torque wrench.
- When stored lubricate the holder with a thin oil for corrosion resistance.
- Do not use HYDRO-GRIP/ECOGRIP at working temperatures above 85 degrees C / 185 degrees F.
Do not use HYDRO-GRIP HD at working temperatures above 70 degrees C / 158 degrees F.
(This may increase the pressure in the holder and influence it negatively).



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