

The maximum speed must be reduced if longer, overhanging or heavy tools and extensions are used. The amount of reduction can be individually determined and is the operators responsibility.
In case of special designs, deviation indications on the drawings must be considered
(The ID marked on the toolholder has to match the one on the drawing.)

- ## Clamping / Unclamping

The tool shank must be burr-free and free of dirt. The clamping screw must be turned in manually with an Allen key to the limit stop. Tightening torque: 88-106 lbf·in (Ø .625": 97-115 lbf·in).

Never actuate the actuation screw with a power screwdriver! Do not combine several extensions. The clamping screw is not secured against dropping out!

At more than 77 °F the expansion tool should not be clamped without a tool or workpiece.

Usable shank types



(DIN 6535 HA and form A according to DIN 6535 part 1)

Type AB with one Weldon flat.
(DIN 1835 part 1 and DIN 6535 HB)

Type B with two Weldon flats.
(DIN 1835 part 1)

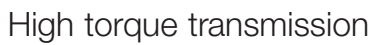
Type E with Whistle-Notch flat.
(DIN 1835 part 1 and DIN 6535 HE)

Run-Out Accuracy



- To secure the clamping force, clean the clamping bore and groove after every tool change. Use a cleaning agent that contains solvents.
- Before storage, the whole surface of the Expansion Toolholder should be oiled slightly.
- Always stock the Hydraulic Expansion Toolholder in an unclamped position and protected against corrosion.
- Depending on environmental conditions, it may be necessary to adjust cleaning and lubrication of the actuation screw correspondingly, particularly in cases of a high number of clamping cycles, high operating temperature, abrasive dirt or swarf. For optimal lubrication of the actuation screw, we recommend the use of copper paste MOLYKOTE CU 7439 (.22 lb tube).
- Basic repairs should be performed at **ISCAR Technical data**

Operating temperature: 68-122 °F
Max. coolant pressure: 1160 PSI
Adjustment range of the length adjustment: .394"



- Best surface finish - no chatter marks
- Excellent vibration damping
- Runout accuracy $<.00012''$
- Fast tool change
- Suitable for all all types of shanks, including shanks with flat surfaces

Applications Milling

Suitable for difficult high-volume machining, with up to 17701 lbf·in torque with Ø1.25" (in dry clamping conditions).

Reaming

Outstanding vibration damping for best workpiece surfaces and long-lasting runout for high dimensional accuracy.

Drilling

Excellent performance due to vibration damping and runout accuracy < .00012"

Tapping

Ideal for tapping with its high torques and outstanding vibration damping.