

930-Test-Gauge

Manual

1. Disclaimer

- a. These "Test-Gauges" are designed and suitable to use exclusively for tests of "CoroChuck® 930-Adaptors", manufactured by Sandvik Coromant.
- b. It is forbidden to use the Test-Gauges with reduction collets

2. Equipment needed

- a. The CoroChuck® 930 adaptor to be tested
- b. The matching Test-Gauge according to the diameter and type
- c. An h6-tool-shank with the nominal diameter associated with the CoroChuck® 930 (for preliminary clamping processes)
- d. Cleaning cloth

3. Pretreatment

- a. Visual inspection:

Both, the Test-Gauge and the CoroChuck® 930 (in the clamping area) must be visually inspected for any damage. The test is only valid with damage-free Test-Gauges and CoroChuck® 930 adaptors!
- b. Temperature:

The Test-Gauge and the CoroChuck® 930 adaptor to be tested, must both be brought to a temperature of 20-25°C. Valid test results can only be obtained in this temperature range during the test.

 - i. Attention! Testing the CoroChuck® 930 adaptor immediately after using it in the machine is not recommended, as it is probably still too warm.
- c. Cleaning:

The Test-Gauge, the CoroChuck® 930 and the h6-tolerated tool shank, must be cleaned in the clamping area/the mutual contact surface with a cloth (purely mechanically, without chemical additives), so that they are free of contamination, oil and grease.
- d. Preparation:

A fully inserted, h6-tolerated tool shank, must be clamped several times (2-3 times) in the CoroChuck® 930 - screw the clamping-screw completely in, wait 10 seconds and unscrew it again.
- e. Add. note:

During pretreatment, the Test-Gauge must not be held on the

contact surface, otherwise it could heat up due to the body temperature of the hand. The Test-Gauge and the CoroChuck® 930 adaptor must remain in the above-mentioned temperature-range of about 20-25°C, or must be cooled down to this temperature-range again, if they have warmed up during the cleaning-procedure.

4. Execution

- a. The clamping-screw of the CoroChuck® 930 adaptor must be opened completely
- b. If existing, the length-adjustment-screw must be fully screwed-in, to use the maximum clamping length of the CoroChuck® 930 adaptor.
- c. The Test-Gauge must be inserted completely/as far as it will go into the clamping hole of the CoroChuck® 930 adaptor; the Test-Gauge should be turnable easily.
- d. The clamping-screw of the CoroChuck® 930 adaptor must be screwed-in completely, according to the instructions.
- e. Now, the CoroChuck® 930 adaptor must be fixed manually or with the help of a device/vise.
- f. Finally, the Test-Gauge is pulled with two fingers and moderate force (if necessary, using a tensile force tester).

Danger! In order to protect the Test-Gauge from damage, it should be prevented from falling to the ground, if it is pulled out!

If a tensile force tester is used, the Test-Gauges of the sizes

Ø ≤ 12 mm should be pulled with **15 N**

Ø > 12 mm should be pulled with **20 N**

5. Result

- a. If the Test-Gauge cannot be pulled-out of the CoroChuck® 930 adaptor with two fingers and moderate force (if necessary, with a tensile force tester), the CoroChuck® 930 adaptor can still be used.
- b. If the Test-Gauge is no longer fully held by the CoroChuck® 930 adaptor, i.e. if the Test-Gauge can be pulled out of the CoroChuck® 930 adaptor, the CoroChuck® 930 has a loss of clamping force, it should no longer be used and, if necessary, sent-in for service.

6. Storage

- a. The Test-Gauge must be stored oiled - to prevent rusting.