



Tooling – state of the art and unique
operating instruction
check device
BA-1282


SAUTER

... more information at www.sauter-feinmechanik.com
and the complete standard tooling program at www.sauter-tools.com

Product description / parts designation

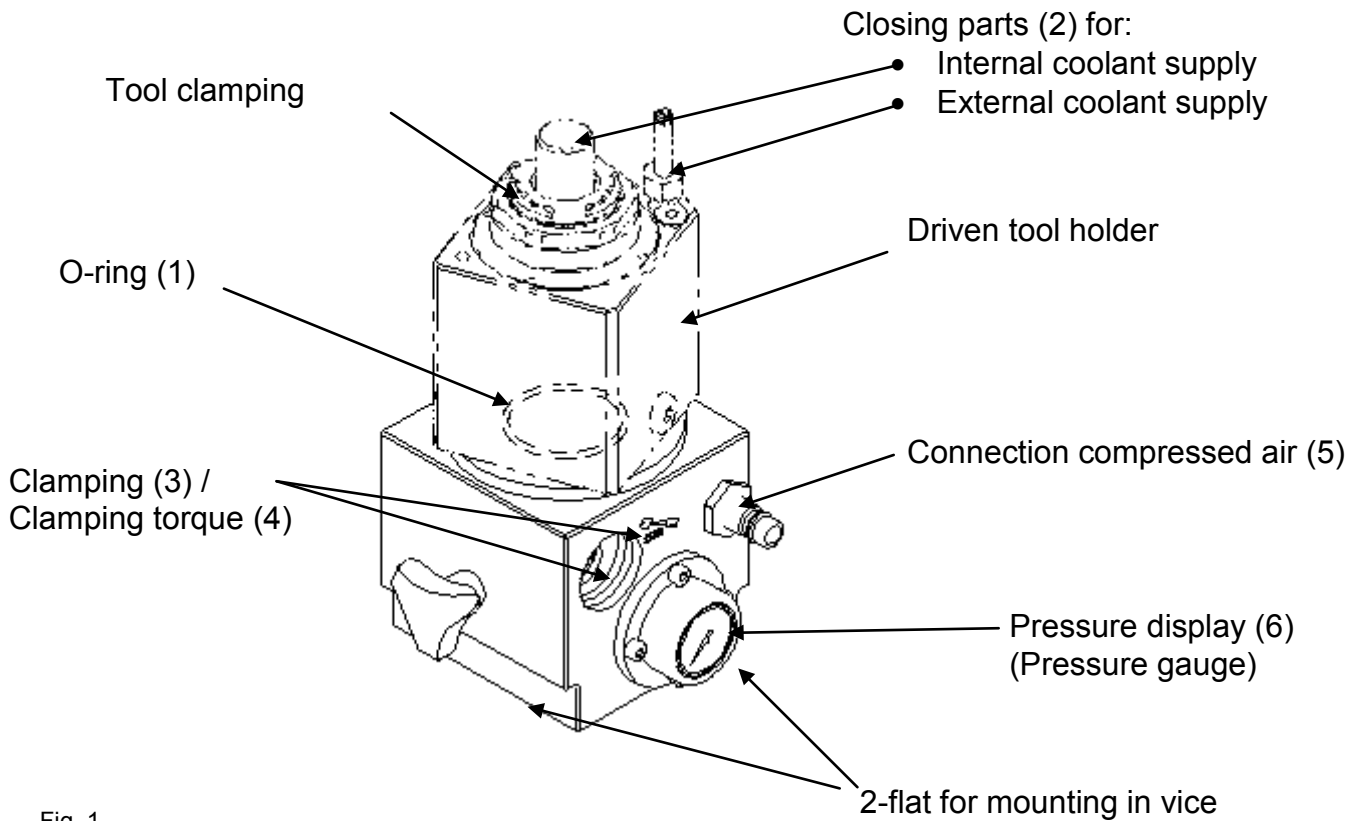


Fig. 1
 (Shown check device for VDI40; your design may differ in detail)

Versions

Id.Nr.	Interface driven tool holder
172697	VDI50
172684	VDI40
172617	VDI30
172593	VDI25
166203	BMT Mori Seiki 60
166200	BMT Mori Seiki 40
166195	BMT Doosan 65
166193	BMT Doosan 55
166157	BMT Doosan 45

Usage

The test device is used to check a driven tool with internal coolant supply for leakage of the internal cooling lubricant in the direction of the turret disc.

- Interface DIN ISO 10889 (VDI) und BMT
- Operating pressure 2 bar
- Permitted media Compressed air

Application:

Warning

Risk of injury due to pneumatic pressure



safety information

Only assemble and disassemble driven toolholders when the
Check device depressurized.

Prepare / Clean:

- Check the factory-fitted O-ring (1) on the tool shaft for damage, replace if necessary.
- Check shank and contact surfaces of driven tool holder and test fixture for cleanliness, remove contamination if necessary.
- Seal all coolant outlet points (internal outlet / external outlet) on the driven tool tightly with the sealing parts (2) provided in the scope of delivery.

Mount:

- Insert the driven tool holder into the test fixture as shown in Fig.1.
- Tighten the clamp (3) to the prescribed torque (4).
- Connect compressed air (2 bar) to the connection of the testing device (5). Allow the pressure to build up for 1 minute and turn the tool holder by hand.

Check pressure:

- Observe the pressure display (6) when turning the tool holder!

Control:

- Pressure display on pressure gauge:

p ≥ 1bar
Driven tool holder- ok

p ≤ 1bar
Recommendation: driven tool holder must be technically verified



IMPORTANT:

To remove the driven tool from the test equipment, the system must be depressurized. Release the clamp and remove the driven tool.

