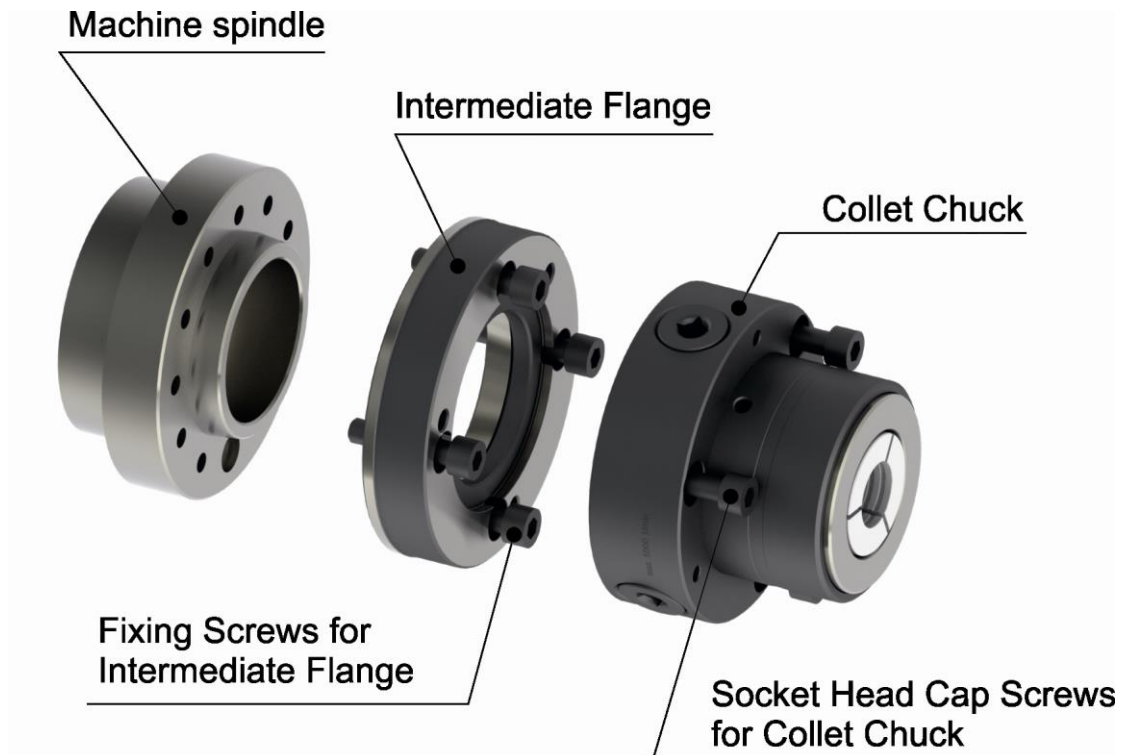


**Assembling Instruction for the intermediate flange for the  
Manually Operated Collet Chucks****Type HSPF**

Cleaning of the machine spindle and the intermediate flange. Degreasing of the clamping thread in the flange.

Mounting of the intermediate flange onto the spindle. Tightening of the fixing screws DIN 55026, DIN 55027 or DIN 55029 (Camlock) for intermediate flange with max. torque.

Lay on the collet chuck onto the intermediate flange and tighten it with the 3 degreased socket head cap screws for collet chuck DIN 912 M10x40-12.9 (HSPF40) resp. DIN 912 M12x50-12.9 (HSPF60).

TIR Check in the collet chuck (collet closing taper).

If the TIR is  $< 0,02$ , please secure the 3 socket head cap screws with screw adhesive. Tightening of the socket head cap screws for collet chuck M10-12.9 with max. torque (84 Nm) resp. M12-12.9 (146 Nm).

