

Metalworking

ETP[®]
HYDRO-GRIP



Description

Make your ER holder hydraulic and enjoy multiple benefits

With the ETP ECOGRIP ER hydraulic sleeves you can easily turn your standard ER collet holder into a high precision hydraulic holder. Thus you can easily enjoy all the positive benefits of hydraulic clamping such as easy handling and precision. With the use of the axial screws an adjustability of the runout is achieved.

Benefits and features

- Turning ER holders hydraulic
- Easy handling and precision
- Adjustability of run-out

ETP ECOGRIP ER
OPERATING INSTRUCTION

Assembly instructions

First clean all contact areas on ER holder and ETP ECOGRIP ER with a solvent. This to ensure a good contact surface and minimum run out.

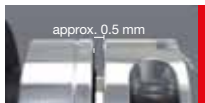
Note: Never tighten the pressure screw on ECOGRIP ER before mounting it in a ER-holder. Follow the steps below:



1. Mount the ring nut on the ER holder.



2. Mount the ETP ECOGRIP ER into the ER holder. Make sure to reach a good conical contact surface by twisting the parts together.



3. Adjust the position of the ring nut to fit with the mounting screws. Make sure to leave a gap of approx. 0.5 mm between the ring nut and ECOGRIP ER, which will allow for adjusting of the runout.



4. Apply some threadlocking adhesive to the mounting screws (we recommend Loxeal 55-03 or similar). Mount the mounting screws and lightly tighten to approx. 3 Nm. (For ECOGRIP 6/ER16 tighten to approx. 2 Nm).

Supplement instructions (for inner threaded driven tools)



First mount adaptor unit in your ER holder. Recommended tightening torque (T_t) for the external thread nut can be found in the tables below. We recommend the use of a socket wrench.

ER Size	Part no.	Item description	External thread nut	
			Thread	T_t , Nm
25	687310	ETP ECOGRIP-12/ER20-25	M32x1,5	50
32	687320	ETP ECOGRIP-12/ER25-32	M40x1,5	104
	687330	ETP ECOGRIP-16/ER25-32	M40x1,5	104
40	687340	ETP ECOGRIP-20/ER32-40	M50x1,5	128

ER Size	Part no.	Item description	External thread nut	
			Thread	T_t , Nm
25	687410	ETP ECOGRIP-1/2"/ER20-25	M32x1,5	50
32	687420	ETP ECOGRIP-1/2"/ER25-32	M40x1,5	104
	687430	ETP ECOGRIP-5/8"/ER25-32	M40x1,5	104
40	687440	ETP ECOGRIP-1"/ER32-40	M50x1,5	128

Adjusting runout

When cleaning all surfaces and mounting according to Assembly instructions, a runout within approx. 0.020 mm should be reached. If the runout is higher than 0.030 mm we recommend taking the parts apart and re-assemble.

A flexing will occur when adjusting the runout and releasing the hydraulic pressure but this flexing becomes smaller and smaller. Follow the short instruction below to adjust the runout of your holder.



1. Mount a runout measure bar, or a tool, in the holder and tighten the pressure screw fully (Max. 6 Nm).



2. Set up the holder and check the runout which should be approx. 0.020 mm.



3. Adjust the runout by lightly tightening on the mounting screws in steps of approx. 0.5 Nm. For ETP-ECOGRIP 6/ER16 also use the 2 additional adjusting screws located in the ring nut. In the first run, adjust to about half the original level (no need to spend more time), that is in the case of approx. 0.020 mm runout - adjust to approx. 0.010 mm.



4. Release the hydraulic pressure, clamp again and check the runout.



5. Adjust the runout again, release, clamp and check again until you reach your desired level. You reach a good repeatability if this is done 2-3 times. If your desired runout level can not be reached, we recommend taking the parts apart and re-assemble.

Handling

ETP ECOGRIP ER is a high precision toolholder 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 ECOGRIP ER 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 ETP ECOGRIP ER at working temperatures above 85 degrees C / 185 degrees F. (This may increase the pressure in the holder and influence it negatively).

Disassembly instructions (for inner threaded driven tools)



To disassemble the ETP ECOGRIP ER from your ER holder, release pressure and remove the 3 adjustment screws. ETP-ECOGRIP ER can now be removed.



Unwind the external thread nut approx. 2-3 revolutions.



In order to release the adaptor unit, there is an **M8** thread in the center of the adaptor unit. Mount a suitable screw and washer against the thread nut. Tighten the screw to release the adaptor unit.



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