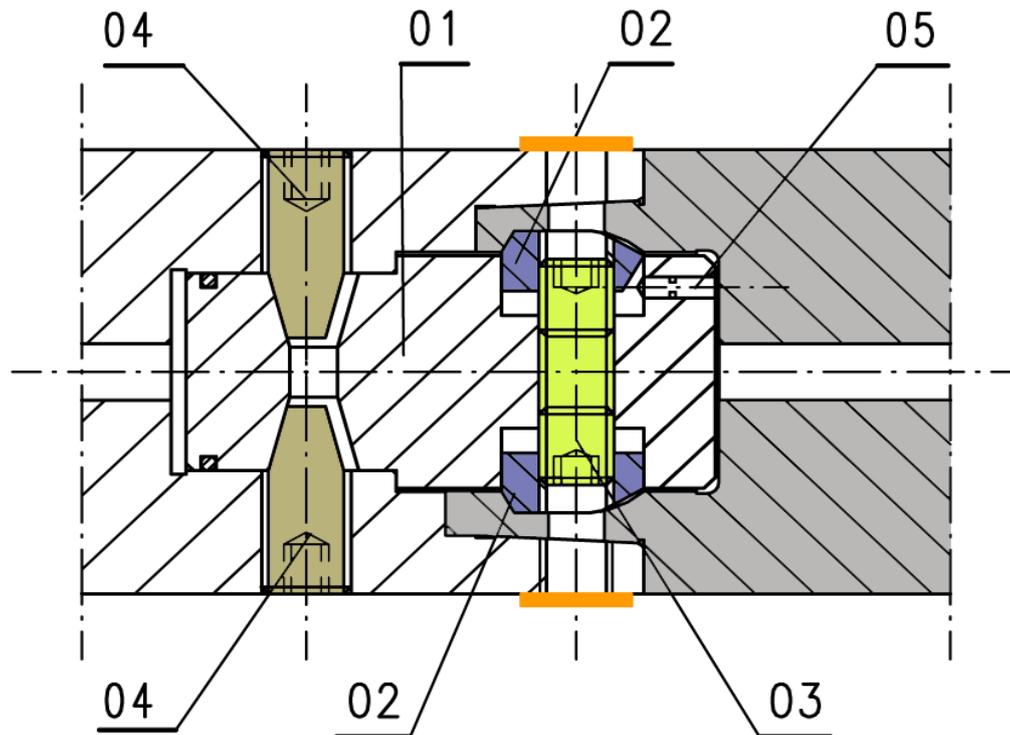




# T E S S M A

Thomas Esswein ☎ Römerweg 33 ☎ D-73642 Welzheim  
[www.tessma.de](http://www.tessma.de) ☎ [info@tessma.de](mailto:info@tessma.de)

## HSK-clamping cartridge Instructions on assembly and operation



Put clamping cartridge (01) into adapter shaft respectively into spindle and fix it with taper screws (04).

During the clamping process the two chuck jaws (02) are driven outward radially by rotating a left-/right-hand threaded screw (03). As a result the 30° slopes of the chuck jaws touch the 30° slope of the hollow shank and generate axial and radial clamping forces.

To release the hollow shank you have to turn the left-/right-hand threaded screw (03) into the opposed direction whereby the chuck jaws are driven inward radially. Thereby the ejector pin (05) is moved which pulls out the tool.

HSK-size	25	32	40	50	63	80	100
Tightening Torque (Nm)	2,8	8	8	15	20	30	40
Wrench Size	3	3	3	4	5	6	8
Clamping force (kN)	3	5	6,8	11	18	28	45