

Troubleshooting

(HSK flange)

	Details of the trouble	Cause	Pulled out of holder. Unable to attach fast to spindle or holder in case of MT shank.
1	Holder will not fit.	① Clamp unit is clamped. ② Holder with coolant hose is used.	① Turn clamp bolt to unclamp side. ② •Removal of coolant hose •Selection of HSK-C type
2	Special clamp wrench will not fit.	① Phase of holder's drive groove is shifted by 180 degrees with that of key. ② Holder with no manual clamp hole is used. ③ Different wrench size	① Align the phase of holder's drive groove with that of key. ② Selection of HSK-C type ③ Use of special clamp wrench
3	Cover ring will not turn.	① Wrench other than special wrench is used. ② Chips or dust seizing ③ Adhesion caused by coolant ④ Deformation due to work interference	① Use of special clamp wrench ② Removal of chips and dust ③ Cleaning of sliding portion ④ Ask NT for repair.
4	Poor surface attachment	① Dust adhesion to holder, HSK flange taper and surface portion ② Scratches on holder, HSK flange taper and surface portion	① Cleaning of holder and HSK flange ② Grinding with oilstone and sand paper (#3000) as an intermediate procedure
5	Unable to unclamp	① Ingress of dust or chips into clamp unit ② Unclamp pin will not push up holder surface. •Unclamp pin abrasion •HSK-A type H specification is in use.	① Cleaning of clamp unit ② •Replacement of unclamp pin •Close up screw hole for coolant hose locking screw with special screw.
6	Special clamp wrench will not come off.	① Wrench interfered with holder's manual clamp hole due to excessively loosened clamp bolt	① Reverse clamp bolt half turn to clamp.
7	Failure to attain runout accuracy when mounting	① Scratches on holder, HSK flange taper and surface portion ② Dust adhesion to holder, holder support taper, surface portion	① Cleaning of holder and HSK flange ② Grinding with oilstone and sand paper (#3000) as an intermediate procedure
8	Rubber ring will come off or get ripped.	① Rubber ring deterioration or abrasion ② High coolant pressure	① •Replacement of rubber ring •Ask NT for repair. ② Use under less than allowable coolant pressure (6MPa)
9	Unclamp pin will come off.	① O ring deterioration or abrasion	① Ask NT for repair.