

# 930-Test-Gauge

Manual

## 1. Disclaimer

- a. These "Test-Gauges" are designed and suitable to use exclusively for tests of "CoroChuck® 930-Adaptors", manufactured by Sandvik Coromant.
- b. It is forbidden to use the Test-Gauges with reduction collets

## 2. Equipment needed

- a. The CoroChuck® 930 adaptor to be tested
- b. The matching Test-Gauge according to the diameter and type
- c. An h6-tool-shank with the nominal diameter associated with the CoroChuck® 930 (for preliminary clamping processes)
- d. Cleaning cloth

## 3. Pretreatment

- a. Visual inspection:  
Both, the Test-Gauge and the CoroChuck® 930 (in the clamping area) must be visually inspected for any damage. The test is only valid with damage-free Test-Gauges and CoroChuck® 930 adaptors!
- b. Temperature:  
The Test-Gauge and the CoroChuck® 930 adaptor to be tested, must both be brought to a temperature of 20-25°C. Valid test results can only be obtained in this temperature range during the test.
  - i. Attention! Testing the CoroChuck® 930 adaptor immediately after using it in the machine is not recommended, as it is probably still too warm.
- c. Cleaning:  
The Test-Gauge, the CoroChuck® 930 and the h6-tolerated tool shank, must be cleaned in the clamping area/the mutual contact surface with a cloth (purely mechanically, without chemical additives), so that they are free of contamination, oil and grease.
- d. Preparation:  
A fully inserted, h6-tolerated tool shank, must be clamped several times (2-3 times) in the CoroChuck® 930 - screw the clamping-screw completely in, wait 10 seconds and unscrew it again.

e. Add. note:

During pretreatment, the Test-Gauge must not be held on the contact surface, otherwise it could heat up due to the body temperature of the hand. The Test-Gauge and the CoroChuck® 930 adaptor must remain in the above-mentioned temperature-range of about 20-25°C, or must be cooled down to this temperature-range again, if they have warmed up during the cleaning-procedure.

## 4. Execution

- a. The clamping-screw of the CoroChuck® 930 adaptor must be opened completely
- b. If existing, the length-adjustment-screw must be fully screwed-in, to use the maximum clamping length of the CoroChuck® 930 adaptor.
- c. The Test-Gauge must be inserted completely/as far as it will go into the clamping hole of the CoroChuck® 930 adaptor; the Test-Gauge should be turnable easily.
- d. The clamping-screw of the CoroChuck® 930 adaptor must be screwed-in completely, according to the instructions.
- e. Now, the CoroChuck® 930 adaptor must be fixed manually or with the help of a device/vise.
- f. Finally, the Test-Gauge is pulled with two fingers and moderate force (if necessary, using a tensile force tester).

Danger! In order to protect the Test-Gauge from damage, it should be prevented from falling to the ground, if it is pulled out!

If a tensile force tester is used, the Test-Gauges of the sizes

**Ø ≤ 12 mm** should be pulled with **15 N**

**Ø > 12 mm** should be pulled with **20 N**

## 5. Result

- a. If the Test-Gauge cannot be pulled-out of the CoroChuck® 930 adaptor with two fingers and moderate force (if necessary, with a tensile force tester), the CoroChuck® 930 adaptor can still be used.
- b. If the Test-Gauge is no longer fully held by the CoroChuck® 930 adaptor, i.e. if the Test-Gauge can be pulled out of the CoroChuck® 930 adaptor, the CoroChuck® 930 has a loss of clamping force, it should no longer be used and, if necessary, sent-in for service.



## 6. Storage

- a. The Test-Gauge must be stored oiled - to prevent rusting.

## 7. Recommended inspection interval

- a. Regular checks with a Test-Gauge are recommended to ensure consistent clamping performance of the CoroChuck® 930. As a general guideline, verify the chuck at least every two months or after approximately 100 clampings. Service intervals may need to be adjusted in case of deviating environmental or operating conditions and depending on product load.