



NORIS SHANK EXTENSION

**NORIS SHANK EXTENSION for Taps and Cold-Forming Taps**

Operating instruction

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## Warning signs, symbols

This operating instruction uses the following symbols:



### Attention

Marks special instructions, rules and prohibitions, which are important in order to avoid any damage.

▶ Please observe these instructions!



### Note

Marks application instructions and other useful information.

## 1 Application range, safety instructions and technical data

### 1.1 Application range, determined use

The NORIS SHANK EXTENSION are mainly used on CNC-machines and conventional thread cutting machinery. They are used for clamping threading tools and are used for thread production.

As Standard, the NORIS SHANK EXTENSIONS are available in the following designs:

- Short design
- Long design
- Short design with internal coolant-lubricant supply
- Long design with internal coolant-lubricant supply
- Short design E-Lock with internal coolant-lubricant supply
- Long design E-Lock with internal coolant-lubricant supply

Depending on the design, the tool is clamped via clamping segments or form-fitting in a groove on the square of the tool shank.

The NORIS SHANK EXTENSIONS for internal coolant-lubricant supply are designed up to 50 bar.

**The non-determined use exempts the manufacturer from any liability.**

### 1.2 Specifications

Due to the slim design, the NORIS SHANK EXTENSIONS allow the use of standard threading tools for deeper threads or to get past interface contour on the component or clamping device.

The torque generated during the thread production process is transmitted via the square in the NORIS SHANK EXTENSION.

A separate NORIS SHANK EXTENSION is required for each clamping diameter.

The special shaft extensions are available in DIN, JIS and inch dimensions.

## 1.1 Safety instructions and hints

For all works, i.e. putting into operation, production or maintenance, please observe the details given in the operating instruction.

All relevant safety regulations as well as local instructions are to be observed when working.

Below please find some basic rules:



### Attention



▶ Please wear gloves during tool change to avoid injury.

▶ Basically change the tool yourself to avoid the sudden start of the spindle caused by mis-operating.



▶ Hold the tool when loosening the tool clamping to avoid it falling down and damaging the tool and the work piece.

▶ Keep the tool adaptation clean.

▶ There are maximum values for cutting speeds and feeds for every kind of machining. Please observe such data.

▶ Please observe the maximum tool dimensions.

▶ Furthermore, the instructions of the tool manufacturers are valid!

## 1.2 Proprietary rights

The entire contents of these operating instructions are subject to German proprietary rights legislation.

Any form of multiplication, processing, broadcasting, passing on to third parties - also in the form of extracts - and any kind of use outside the boundaries of proprietary rights requires the written consent of REIME NORIS GmbH.

## 2 Putting the NORIS SHANK EXTENSION into operation

### 2.1 Unpacking

- Take the NORIS SHANK EXTENSION from the packing
- Clean the NORIS SHANK EXTENSION with a duster to remove any conservation oil



#### Note

- ▶ Do not use any aggressive solvents.
- ▶ Do not use fibrous materials i.e. steel wool.

✓ The NORIS SHANK EXTENSION is now ready for operation.

### 3 Insert and remove of the tap/cold-forming tap

#### 3.1 NORIS SHANK EXTENSION short or long design

**!** Note

These versions are not designed for internal coolant-lubricant supply.



##### 3.1.1 Clamping of the tap/cold-forming tap

- Loosen knurled clamping cap by hand
- Insert tap/cold-forming tap and bring the square into the correct position by turning the tap/cold-forming tap
- Tighten knurled clamping cap hand-tight, without auxiliary tool

##### 3.1.2 Remove of the tap/cold-forming tap

- Loosen knurled clamping cap by hand
- Remove tap/cold-forming tap

### 3.2 NORIS SHANK EXTENSION short or long design for internal coolant-lubricant supply



**Attention**



▶ The maximum internal coolant-lubricant pressure is **50 bar**.



#### 3.2.1 Clamping of the tap/cold-forming tap

- Loosen hexagon clamping nut
- Insert tap/cold-forming tap and bring the square into the correct position by turning the tap/cold-forming tap
- Tighten hexagon clamping nut

To guarantee the safe operating, especially when using internal coolant supply, we recommend the following tightening torques of the hexagon clamping nut:

$\varnothing d_5$	SW	$M_d$		
[mm]	[mm]	[Nm]		
6,5	6	2	9953VK01	9954VK01
9	8	2	9953VK02	9954VK02
10	9	2,5	9953VK03	9954VK03
10	9	3	9953VK04	9954VK04
13,5	12	3,5	9953VK05	9954VK05
13,5	12	5	9953VK06	9954VK06
14,5	13	6	9953VK07	9954VK07
16,5	15	8	9953VK08	9954VK08
16,5	15	11	9953VK09	9954VK09
20	18	15	9953VK10	9954VK10
20	18	20	9953VK11	9954VK11
25	22	25	9953VK12	9954VK12
25	22	33	9953VK13	9954VK13
29	26	45	9953VK14	9954VK14
32	28	60	9953VK15	9954VK15
34	30	77	9953VK16	9954VK16
41	36	100	9953VK17	9954VK17



**Note**

To adjust the correct torque, we recommend to use a torque wrench. Please refer to the table for the according torque wrench with appropriate socket wrench.

### 3.2.2 Loosen of the tap/cold-forming tap

- Loosen hexagon clamping nut with torque wrench
- Remove tap/cold-forming tap


## 4 Maintenance

### 4.1 Maintenance schedule

What?	When?	Who?
External cleaning	Periodically, depending on the degree of dirt.	Operator

### 4.2 External cleaning

Clean the NORIS SHANK EXTENSION at periodic intervals depending on how dirty it is.

 **Note**

- ▶ Do not use any aggressive solvents.
- ▶ Do not use fibrous materials i.e. steel wool.

## 5 Storage when not in use

If the NORIS SHANK EXTENSION is taken out of service, please go through the following working steps:

1. Clean the NORIS SHANK EXTENSION with a duster.
2. Spray the NORIS SHANK EXTENSION with a preservation oil to avoid rusting and to preserve the easy running of the extension



### Attention

Before storage all evidence of coolant-lubricant and machining residues must be removed!

## REIME NORIS SHANK EXTENSION

### Operating instruction

Status 2022, Version 1.1

Please keep this for future use!

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