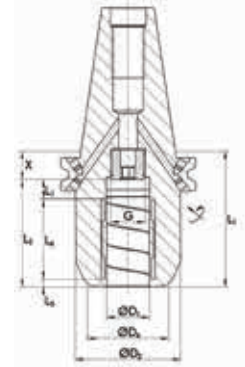


Hydraulic



CAT50 Hydraulic Chucks (Balanced to G2.5@25,000 RPM)

- Used for milling, drilling, reaming, and boring
- Can be run up to 25,000 RPM
- Concentric to .00012"
- Wide range of coolant sealed or coolant flush reduction sleeves available
- **Collet Sleeves can be found on pages 620-621.**



CAT50 Hydraulic Chuck

Bore ø	D2	D4	X	Gage Length (L1)	L2	L3	L5	L6	G	Part #
1-1/4	69.9MM	55.5MM	20.0MM	81.0MM	61.0MM	10.0MM	4.2MM	47.7MM	M16X1MM	RC5HC1250

Successful Use and Care for RedLine Hydraulic Chucks

- RedLine Hydraulic Chucks can accept tools with a smooth cylindrical shank, Weldon Shank or a Whistle Notch without the use of reduction sleeves. Tools must have a H6 shank tolerance or better.
- To clamp a tool in the Hydraulic Chuck, turn the clamping screw with an Allen Key with 7-8.5 ft. lbs. torque completely to the limit stop. **Never use a Power Screwdriver to turn the actuation screw!**
- Testing of the clamping force should be done before the first use and after approximately 100 tool changes or every 3 months. A test shaft should be inserted at least to the minimum clamping depth into the toolholder. Tighten the clamping screw to a dead stop. If the test shaft can be easily removed from the toolholder manually and without any effort, the clamping force is not high enough. The Hydraulic Chuck shouldn't be used and sent in for repair.
- When using intermediate sleeves, they must be inserted completely into the Hydraulic Chuck, so the edge of the sleeve makes contact with the face of the Hydraulic Chuck. Failure to do this will result in poor run-out and lower grip force.
- Tools with Weldon Shanks or Whistle Notches influence balance and will affect the max rpm the tools can run.
- If tools are not clamped to minimum clamping depth there is a risk of damaging the expansion sleeve and will result in a loss of accuracy.
- The vent screw of the hydraulic system is protected with a pin or resin. **Don't remove it!**
- The axial length stop is set with an Allen Key via the length adjustment screw. There is 10MM (.393") adjustment. Never actuate the length adjustment screw when tools are clamped. Axial adjustment screws maximum tightening torque is 2.2 ft. lbs.

Clamping / Unclamping

- The tool shank must be burr-free and free of dirt.
- Always insert the tool down to the minimum clamping depth into the toolholder.
- **Do not combine several extensions. The clamping screw is not secured against dropping out!**
- Hydraulic Chucks must not be clamped without a tool or workpiece.

Shanks to be used in hydraulic expansion toolholders

- **Type A** with straight cylindrical shaft. Cylindrical shaft acc. to DIN 6535 HA and form A according to DIN 6535 part 1
- **Type AB** with one Weldon flat Cylinder shank Form B according to DIN 1835 part 1 and DIN 6535 HB
- **Type B** with two Weldon flats Cylinder shank B according to DIN 1835 part 1
- **Type E** with Whistle-Notch flat Cylinder shank E according to DIN 1835 part 1 and DIN 6535 HE

Care, Storage and Maintenance

- For optimum clamping force, the clamping bore and groove must be cleaned after every tool change with a solvent.
- Before storage, oil the entire surface of the Hydraulic Chuck and store in an unclamped position.
- Warranty is void if repairs are by anyone other than RedLine Tools.
- It may be necessary to adjust and lubricate the actuation screw, especially with a high number of clamping cycles, high operating temperatures or where abrasive dirt or swarf are present. For optimum lubrication of the actuation screw, we are recommending the use of copper paste MOLYKOTE CU 7439 (100 g tube, Id.-No. 9247204).
- Adjustment range of the length adjustment: 10 mm
- Operating temperature: 20 – 50°C
- Max. coolant pressure: 1160 P.S.I.