



# Collet chuck 5° D4 for Zfx™ Inhouse5x

ZFX02010001

# Remove the Blankholder



Zfx Inhouse5x

11/24/2016  
11:52:36 AM

Tool-changer 100%

Tool Cabinet 100%

Active job 100%

Camera 0%

Messages

Job list

waiting:

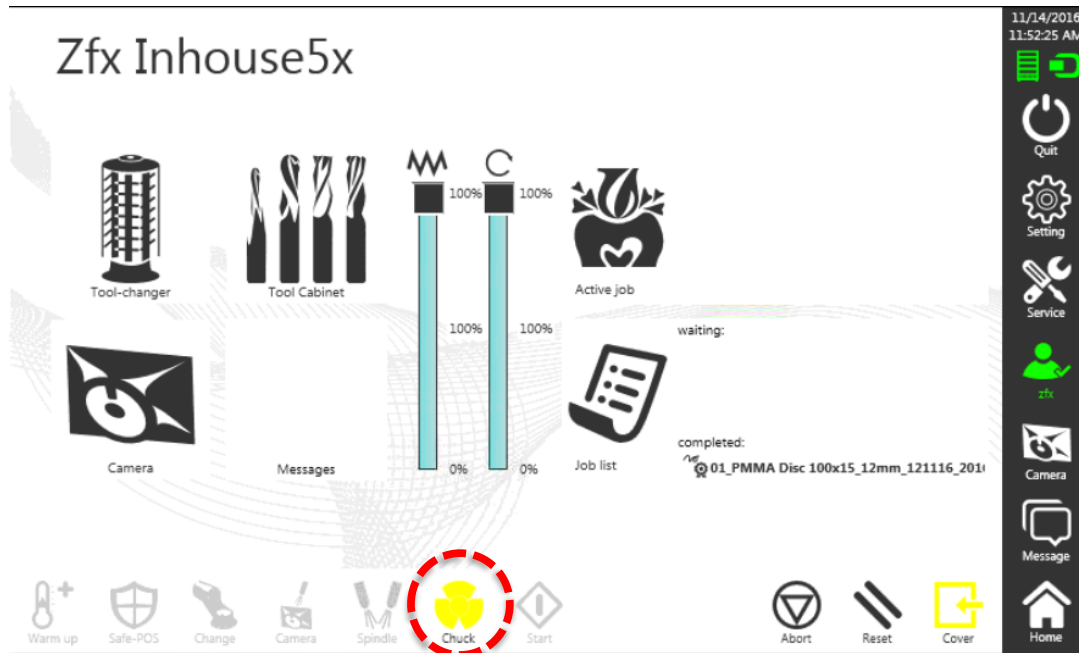
completed:  
01\_PMMA Disc 100x15\_12mm\_121116\_201

Warm up Safe-POS Change Camera Spindle **Chuck** Start

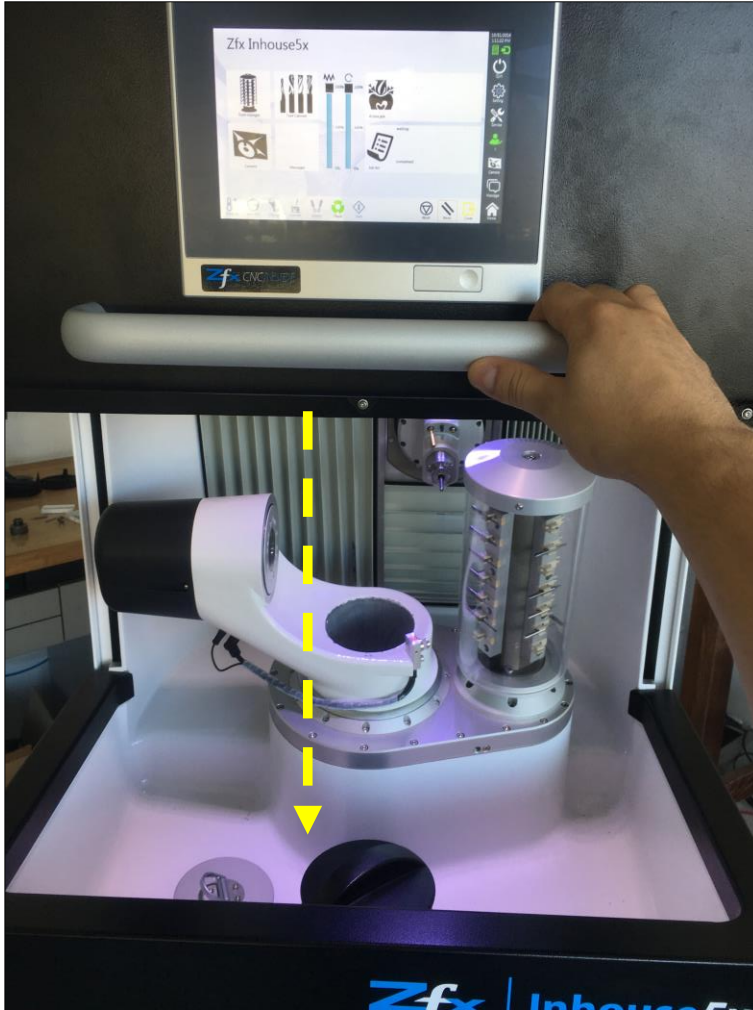
Quit Setting Service zfx Camera Message Home

Abort Reset Cover

# Close the clamping system



# Close the door



# Load the T0 into the spindle

## Zfx Inhouse5x

8/23/2016 5:42:42 PM

**Tool-changer** (highlighted)

**Tool Cabinet**

**Active job**

**Job list**

waiting:

completed:

Warm up Safe-POS Change Camera Spindle Chuck Start Abort Reset Cover Home

Quit Setting Service zfx Camera Message Home

# Load the T0 into the spindle

## ← Tool changer

|  |   |   |   |
|--|---|---|---|
| AB-RF-D1,5-L8-SR <b>6</b><br>T151<br>Lifetime: 350/350 min | TI-KF-D1,5 <b>13</b><br>T511<br>Lifetime: 700/700 min | AB-RF-D1,5-L8-SL <b>20</b><br>T251<br>Lifetime: 350/350 min | HMB-D2.6 <b>27</b><br>T413<br>Lifetime: 220/220 min   |
| AB-RF-D2-L20 <b>5</b><br>T155<br>Lifetime: 300/300 min     | TI-KF-D2 <b>12</b><br>T621<br>Lifetime: 799/800 min   | AB-SF-D1,5-L4 <b>19</b><br>T171<br>Lifetime: 250/250 min    | PMMA-KF-D2 <b>26</b><br>T21<br>Lifetime: 400/400 min  |
| AB-SF-D1,5-L16 <b>4</b><br>T156<br>Lifetime: 200/200 min   | TI-KF-D1,5 <b>11</b><br>T614<br>Lifetime: 700/700 min | AB-SF-D1,0-L2,5 <b>18</b><br>T170<br>Lifetime: 250/250 min  | Leer <b>25</b>  |
| AB-RF-D2-L16 <b>3</b><br>T154<br>Lifetime: 300/300 min     | TI-KF-D1 <b>10</b><br>T601<br>Lifetime: 700/700 min   | AB-SF-D1-L5 <b>17</b><br>T176<br>Lifetime: 200/200 min      | CC-KF-D1,5 <b>24</b><br>T111<br>Lifetime: 400/400 min |
| Leer <b>2</b>  | TI-KF-D0,6 <b>9</b><br>T589<br>Lifetime: 700/700 min  | AB-RF-D2 <b>16</b><br>T153<br>Lifetime: 400/400 min         | CC-KF-D1 <b>23</b><br>T100<br>Lifetime: 400/400 min   |
| PMMA-KF-D2 <b>1</b><br>T21<br>Lifetime: 399/400 min        | AB-KF-D0,5 <b>8</b><br>T190<br>Lifetime: 300/300 min  | AB-RF-D1-L4 <b>15</b><br>T260<br>Lifetime: 350/350 min      | GCER-KF-D2 <b>22</b><br>T123<br>Lifetime: 400/400 min |
| <b>T0</b> <b>0</b><br>T0<br>Lifetime: ∞                    | AB-KF-D0,3 <b>7</b><br>T180<br>Lifetime: 250/250 min  | TI-KF-D1 <b>14</b><br>T500<br>Lifetime: 700/700 min         | Leer <b>21</b>  |

Bar 1  
 Bar 2  
 Bar 3  
 Bar 4

Abort  
 Reset  
 Cover

10/28/2016  
8:13:15 AM

- Quit
- Setting
- Service
- zfx
- Camera
- Message
- Home

# Load the T0 into the spindle

10/28/2016  
8:18:56 AM

## ← Tool place 0

### Tool place

**T0**    **T0**  

Serial number:        3  
 Length at the beginning: 39.898 mm  
 Length at the end:    39.898 mm

### Tool Cabinet

| ID   | Name<br>Serial number | Lifetime    | Status |
|------|-----------------------|-------------|--------|
| T201 | CC-KF-D1<br>66        | 400/400 min |        |
| T221 | CC-KF-D2<br>72        | 800/800 min |        |
| T409 | HMB-D1,5<br>65        | 220/220 min |        |
| T411 | HMB-D2,2<br>6         | 220/220 min |        |

### Management

Empty
 Lock
 Reset
 Insert
 Unload
 Load

Bar 1
Bar 2
Bar 3
Bar 4

Abort
Reset
Cover

Quit
Setting
Service
zfx
Camera
Message
Home

# Load the T0 into the spindle

Zfx Inhouse5x

8/23/2016 5:42:42 PM

The screenshot displays the Zfx Inhouse5x control interface. It features several main sections: a 'Tool-changer' icon, a 'Tool Cabinet' icon showing four drill bits, a 'Camera' icon, and a 'Messages' icon. In the center, there are two vertical progress bars for 'M' and 'C' components, both showing 100% completion. To the right, there is an 'Active job' icon and a 'Job list' section with 'waiting:' and 'completed:' labels. A bottom toolbar contains icons for 'Warm up', 'Safe-POS', 'Change', 'Camera', 'Spindle', 'Chuck', 'Start', 'Abort', 'Reset', 'Cover', and 'Home'. A vertical sidebar on the right contains icons for 'Quit', 'Setting', 'Service', 'zfx', 'Camera', 'Message', and 'Home'. The 'Service' icon is highlighted with a red dashed circle.

Tool-changer

Tool Cabinet

Camera

Messages

Active job

Job list

waiting:

completed:

Warm up

Safe-POS

Change

Camera

Spindle

Chuck

Start

Abort

Reset

Cover

Home

Quit

Setting

Service

zfx

Camera

Message

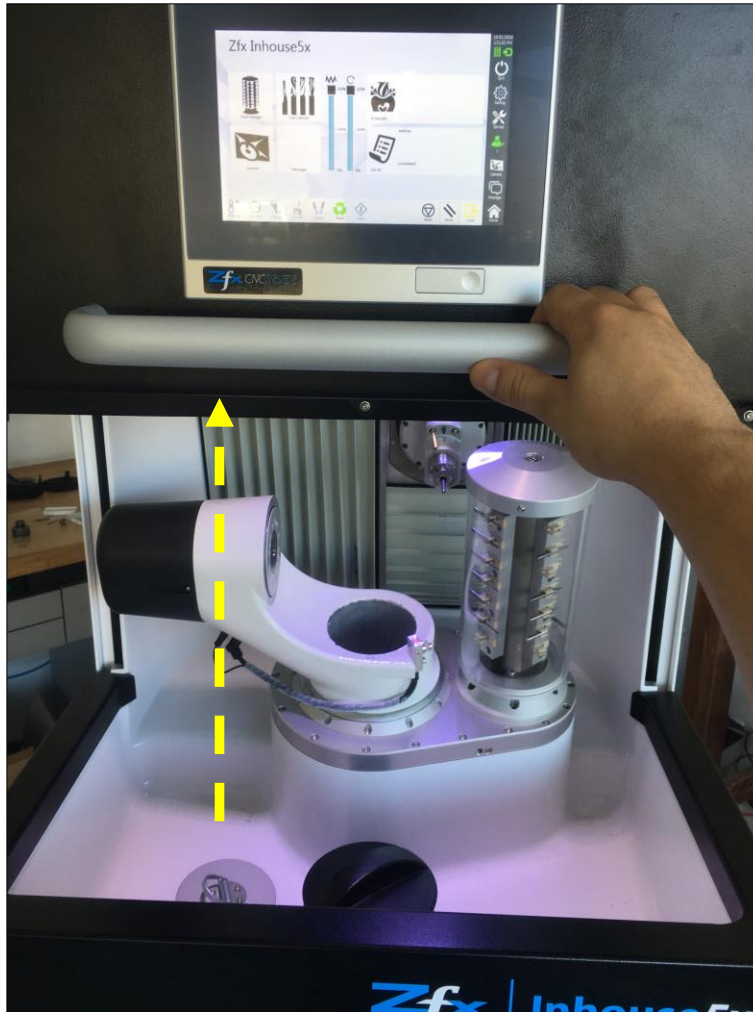
Home



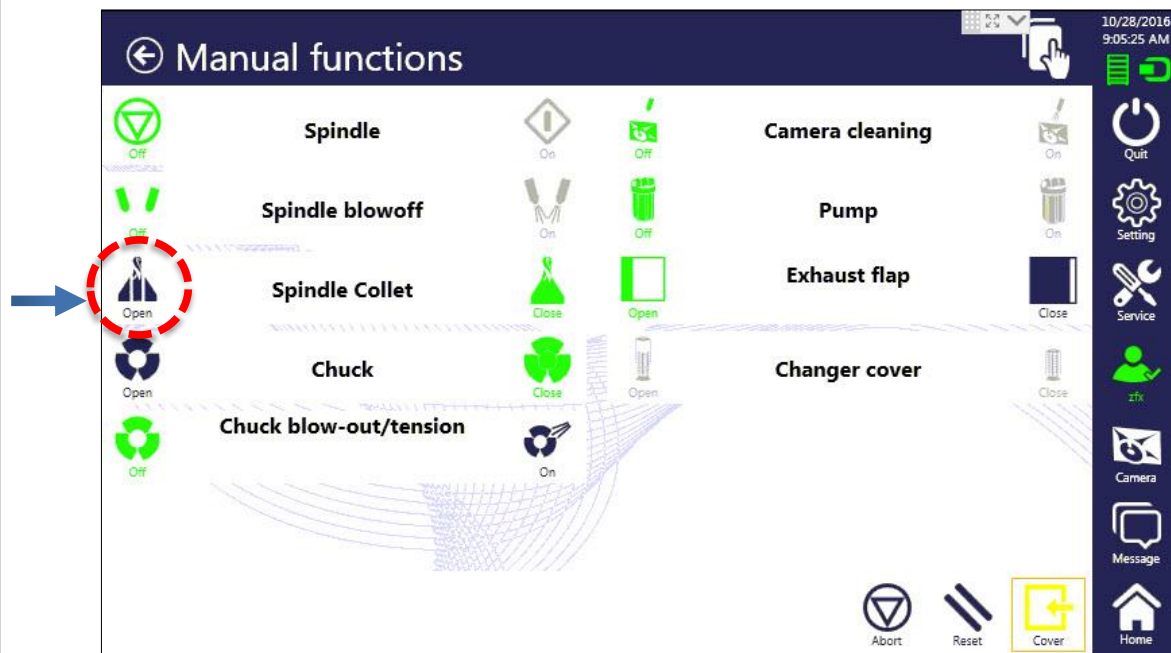
# Load the T0 into the spindle



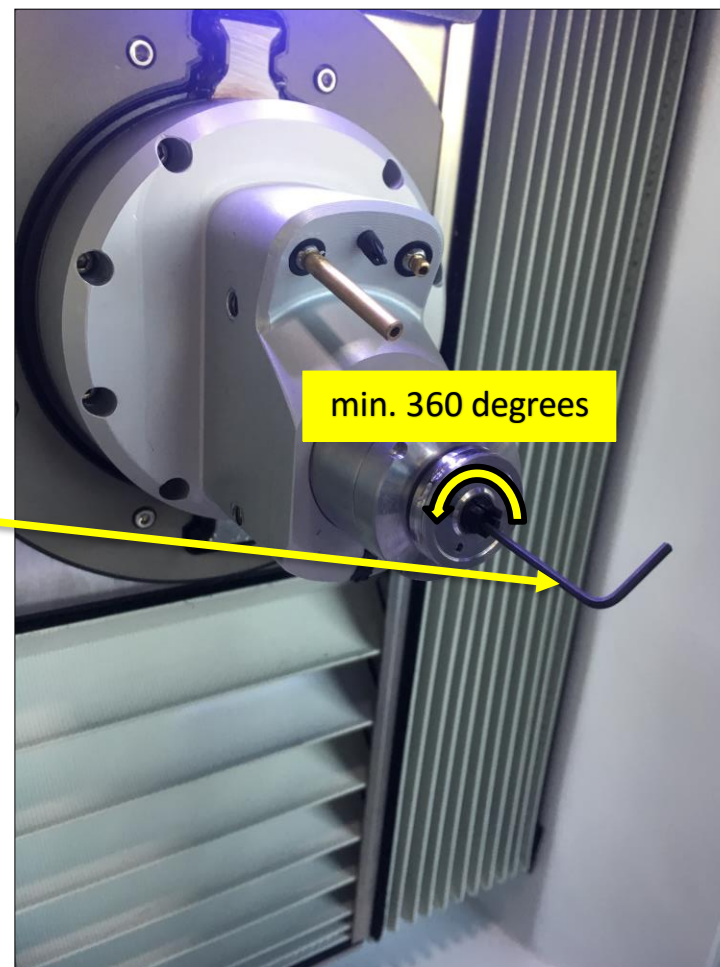
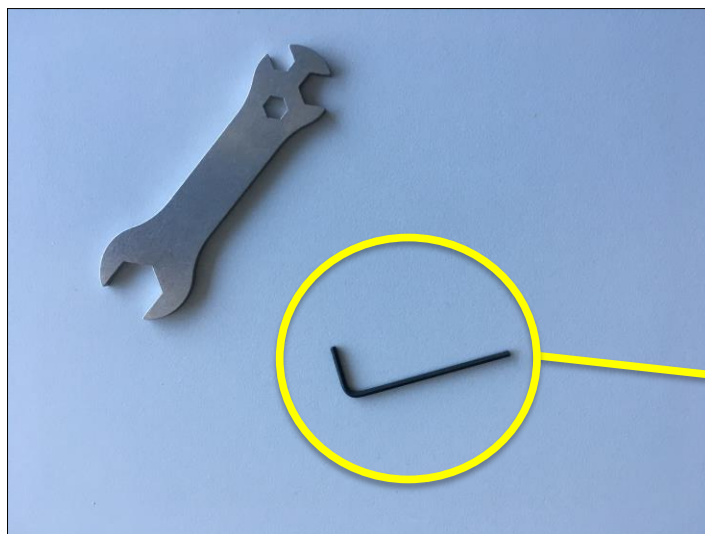
# Open the door



# Remove the T0 from the spindle



# Open the grub screw inside the collet



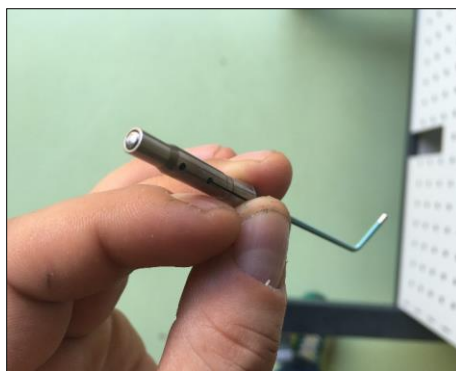
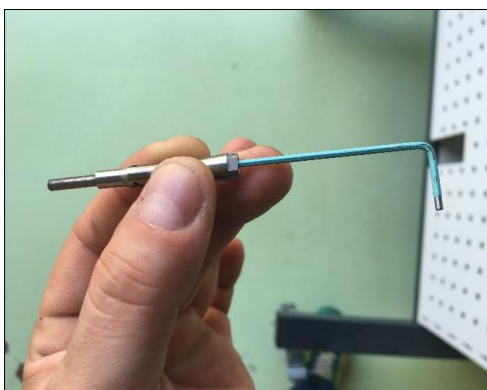
# Unscrew the collet from the spindle

Zfx



# Clean the collet.

## Pay attention of the grub screw!

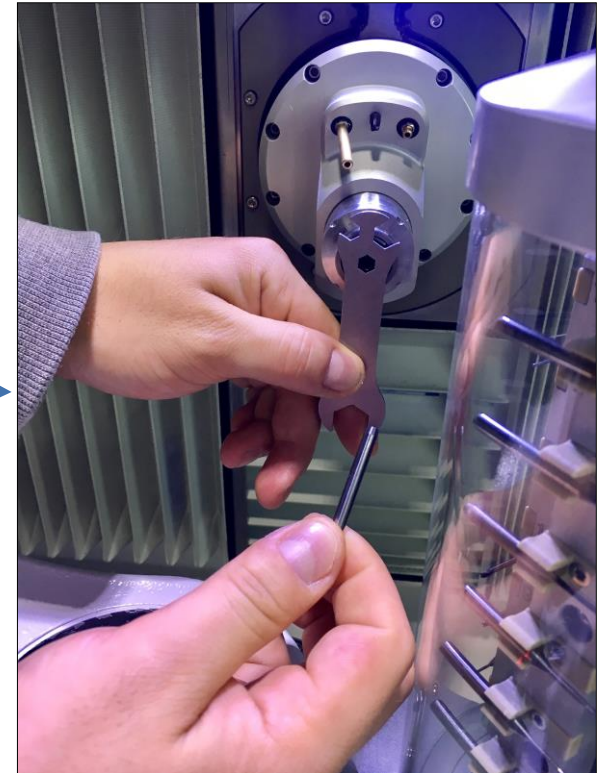
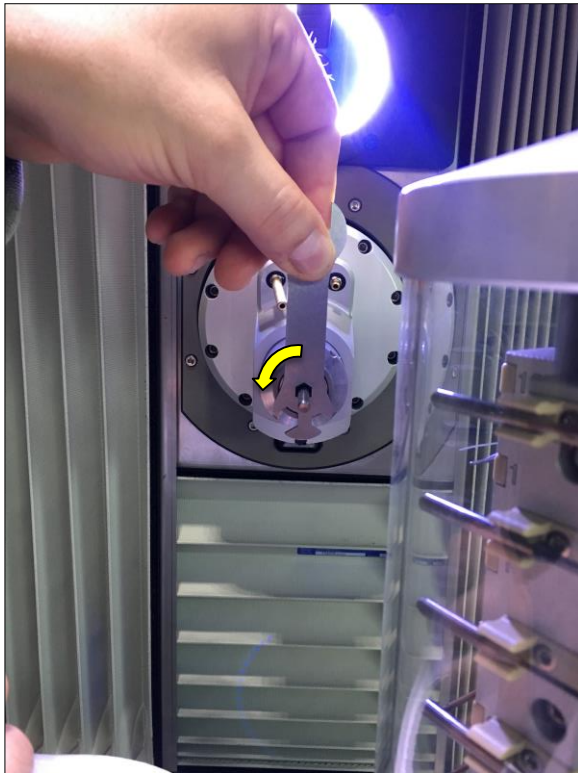


# Screw in the collet into the spindle



Screw in the cleaned collet chuck by hand including the tool T0 as long as the tool T0 is tighten in the collet.

# Adjust the correct clamping force of the collet





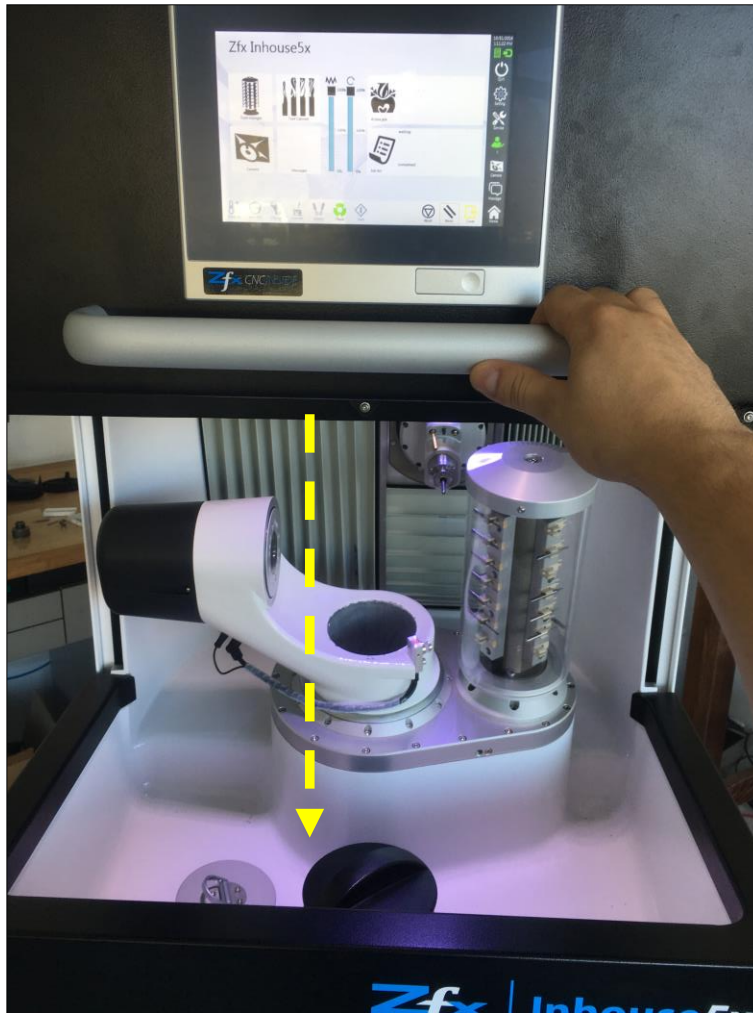
# Adjust the correct clamping force of the collet



Tighten the grub screw with the allen wrench (1,5 mm) exactly on this position.



# Close the door



# Load the T0 back into the magazine



## Zfx Inhouse5x

8/23/2016 5:42:42 PM

**Tool-changer** (highlighted with a red dashed box)

**Tool Cabinet**

**Active job**

**Camera**

**Messages**

**Job list**

waiting:

completed:

100% 100%

100% 100%

0% 0%

Quit

Setting

Service

zfx

Camera

Message

Home

Warm up

Safe-POS

Change

Camera

Spindle

Chuck

Start

Abort

Reset

Cover

# Load the T0 back into the magazine



10/28/2016  
4:43:16 PM

## Tool changer

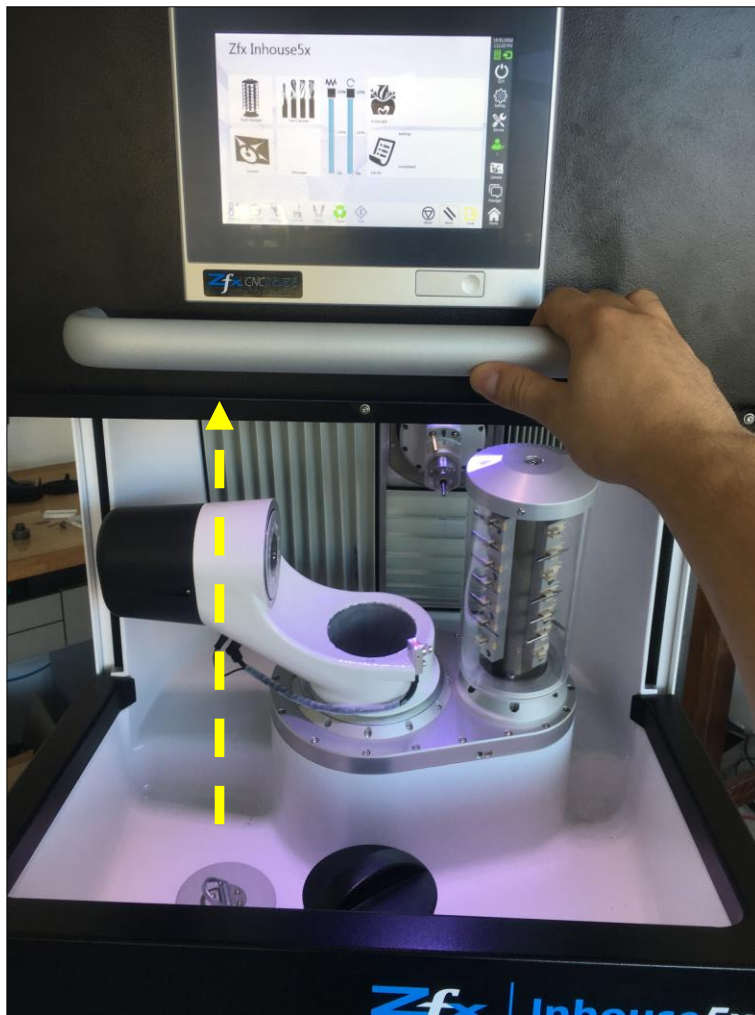
|  |   |   |   |
|--|---|---|---|
| <b>AB-RF-D1,5-L8-SR 6</b><br>Lifetime: 350/350 min<br>T151 | <b>TI-KF-D1,5 13</b><br>Lifetime: 700/700 min<br>T511 | <b>AB-RF-D1,5-L8-SL 20</b><br>Lifetime: 350/350 min<br>T251 | <b>HMB-D2.6 27</b><br>Lifetime: 220/220 min<br>T413   |
| <b>AB-RF-D2-L20 5</b><br>Lifetime: 300/300 min<br>T155     | <b>TI-KF-D2 12</b><br>Lifetime: 799/800 min<br>T621   | <b>AB-SF-D1,5-L4 19</b><br>Lifetime: 250/250 min<br>T171    | <b>PMMA-KF-D2 26</b><br>Lifetime: 400/400 min<br>T21  |
| <b>AB-SF-D1,5-L16 4</b><br>Lifetime: 200/200 min<br>T156   | <b>TI-KF-D1,5 11</b><br>Lifetime: 700/700 min<br>T614 | <b>AB-SF-D1,0-L2,5 18</b><br>Lifetime: 250/250 min<br>T170  | <b>Leer 25</b>  |
| <b>AB-RF-D2-L16 3</b><br>Lifetime: 300/300 min<br>T154     | <b>TI-KF-D1 10</b><br>Lifetime: 700/700 min<br>T601   | <b>AB-SF-D1-L5 17</b><br>Lifetime: 200/200 min<br>T176      | <b>CC-KF-D1,5 24</b><br>Lifetime: 400/400 min<br>T111 |
| <b>Leer 2</b>  | <b>TI-KF-D0,6 9</b><br>Lifetime: 700/700 min<br>T589  | <b>AB-RF-D2 16</b><br>Lifetime: 400/400 min<br>T153         | <b>CC-KF-D1 23</b><br>Lifetime: 400/400 min<br>T100   |
| <b>PMMA-KF-D2 1</b><br>Lifetime: 399/400 min<br>T21        | <b>AB-KF-D0,5 8</b><br>Lifetime: 300/300 min<br>T190  | <b>AB-RF-D1-L4 15</b><br>Lifetime: 350/350 min<br>T260      | <b>GCER-KF-D2 22</b><br>Lifetime: 400/400 min<br>T123 |
| <b>T0 0</b><br>Lifetime: ∞<br>T0                           | <b>AB-KF-D0,3 7</b><br>Lifetime: 250/250 min<br>T180  | <b>TI-KF-D1 14</b><br>Lifetime: 700/700 min<br>T500         | <b>Leer 21</b>  |

Bar 1 Bar 2 Bar 3 Bar 4

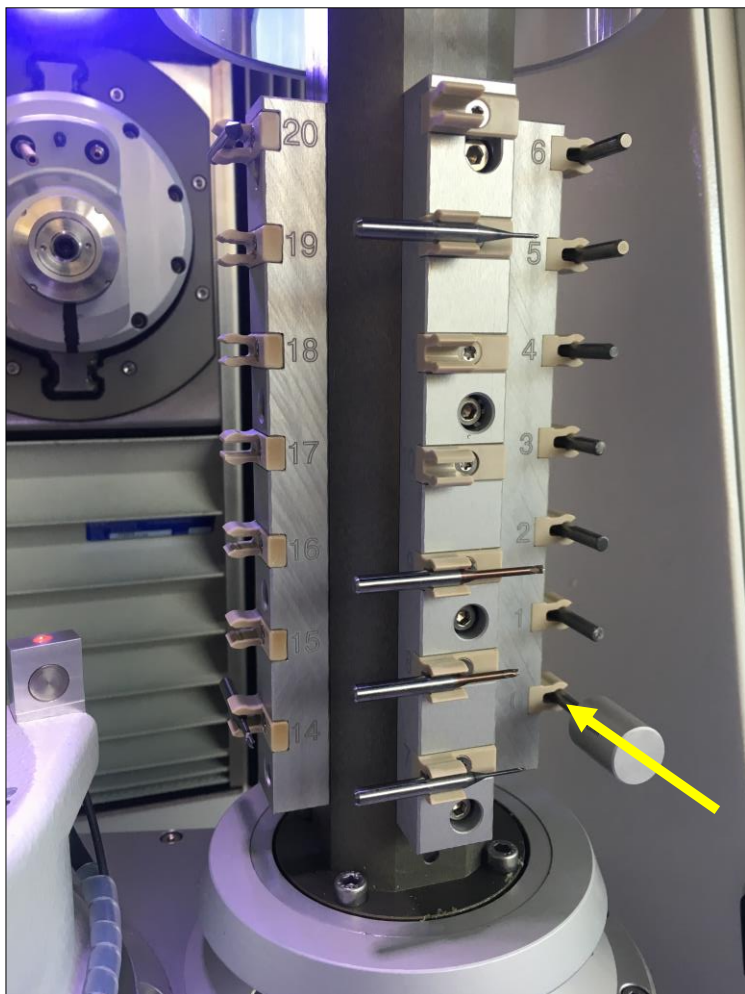
Abort Reset Cover

Quit Setting Service zfx Camera Message Home

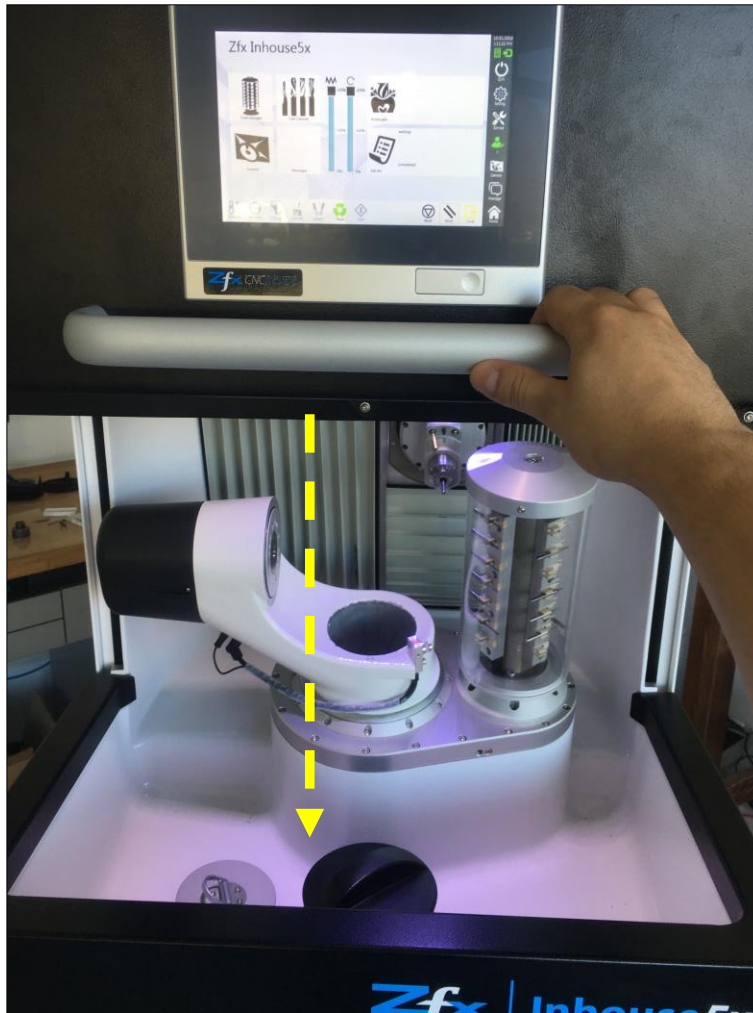
# Open the door



# Load the T0 back into the magazine



# Close the door



# Load the T0 back into the spindle



## Tool changer

10/28/2016  
4:43:16 PM

|   |  |  |  |
|---|--|--|--|
| AB-RF-D1,5-L8-SR 6<br>Lifetime: 350/350 min<br>T151 | TI-KF-D1,5 13<br>Lifetime: 700/700 min<br>T511 | AB-RF-D1,5-L8-SL 20<br>Lifetime: 350/350 min<br>T251 | HMB-D2.6 27<br>Lifetime: 220/220 min<br>T413   |
| AB-RF-D2-L20 5<br>Lifetime: 300/300 min<br>T155     | TI-KF-D2 12<br>Lifetime: 799/800 min<br>T621   | AB-SF-D1,5-L4 19<br>Lifetime: 250/250 min<br>T171    | PMMA-KF-D2 26<br>Lifetime: 400/400 min<br>T21  |
| AB-SF-D1,5-L16 4<br>Lifetime: 200/200 min<br>T156   | TI-KF-D1,5 11<br>Lifetime: 700/700 min<br>T614 | AB-SF-D1,0-L2,5 18<br>Lifetime: 250/250 min<br>T170  | Leer 25  |
| AB-RF-D2-L16 3<br>Lifetime: 300/300 min<br>T154     | TI-KF-D1 10<br>Lifetime: 700/700 min<br>T601   | AB-SF-D1-L5 17<br>Lifetime: 200/200 min<br>T176      | CC-KF-D1,5 24<br>Lifetime: 400/400 min<br>T111 |
| Leer 2  | TI-KF-D0,6 9<br>Lifetime: 700/700 min<br>T589  | AB-RF-D2 16<br>Lifetime: 400/400 min<br>T153         | CC-KF-D1 23<br>Lifetime: 400/400 min<br>T100   |
| PMMA-KF-D2 1<br>Lifetime: 399/400 min<br>T21        | AB-KF-D0,5 8<br>Lifetime: 300/300 min<br>T190  | AB-RF-D1-L4 15<br>Lifetime: 350/350 min<br>T260      | GCER-KF-D2 22<br>Lifetime: 400/400 min<br>T123 |
| T0 0<br>Lifetime: ∞<br>T0                           | AB-KF-D0,3 7<br>Lifetime: 250/250 min<br>T180  | TI-KF-D1 14<br>Lifetime: 700/700 min<br>T500         | Leer 21  |

Bar 1 Bar 2 Bar 3 Bar 4

Abort Reset Cover

Quit Setting Service zfx Camera Message Home



11/14/2016  
12:04:26 PM

## ← Tool place 0

### Tool place

**T0** **T0**

Serial number: 5  
Length at the beginning: -0.001 mm  
Length at the end: -0.001 mm

### Management

Empty
 **Unlock**
 Reset
 Insert
 Unload
 Load

### Tool Cabinet

| ID | Name          | Lifetime | Status |
|----|---------------|----------|--------|
|    | Serial number |          |        |

Bar 1
Bar 2
Bar 3
Bar 4
Abort
Reset
Cover

- 
- Quit
- Setting
- Service
- zfx
- Camera
- Message
- Home


# Load the T0 back into the spindle



10/28/2016  
4:42:41 PM

## ← Tool place 0

### Tool place



**T0 T0**

Serial number: 3  
Length at the beginning: -0.001 mm  
Length at the end: -0.001 mm

### Tool Cabinet

| ID   | Name     | Serial number | Lifetime    | Status |
|------|----------|---------------|-------------|--------|
| T201 | CC-KF-D1 | 66            | 400/400 min |        |
| T221 | CC-KF-D2 | 72            | 800/800 min |        |
| T409 | HMB-D1,5 | 65            | 220/220 min |        |
| T411 | HMB-D2,2 | 6             | 220/220 min |        |

### Management

Empty Lock Reset Insert Unload **Load**

Bar 1 Bar 2 Bar 3 Bar 4 Abort Reset Cover Home

# Load the T0 back into the spindle

Zfx

