

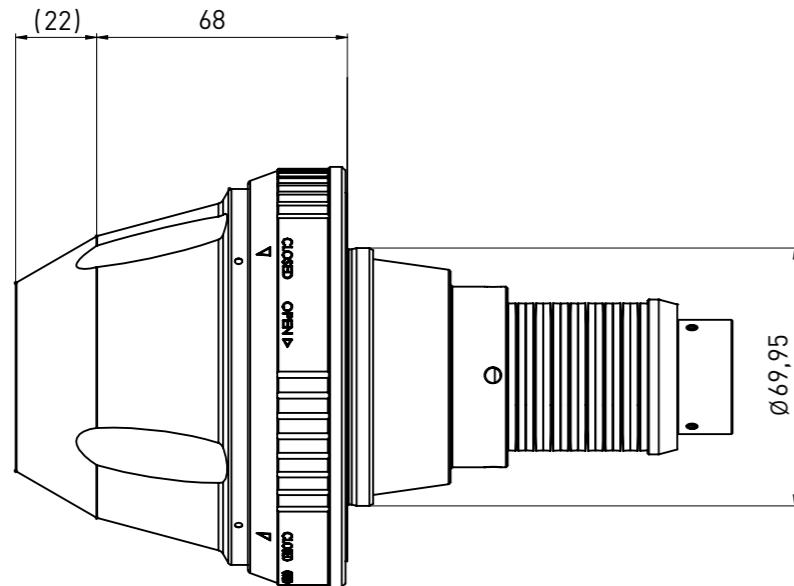
# Commissioning // Instruction manual

**VIPER L**  
Nann 3718E

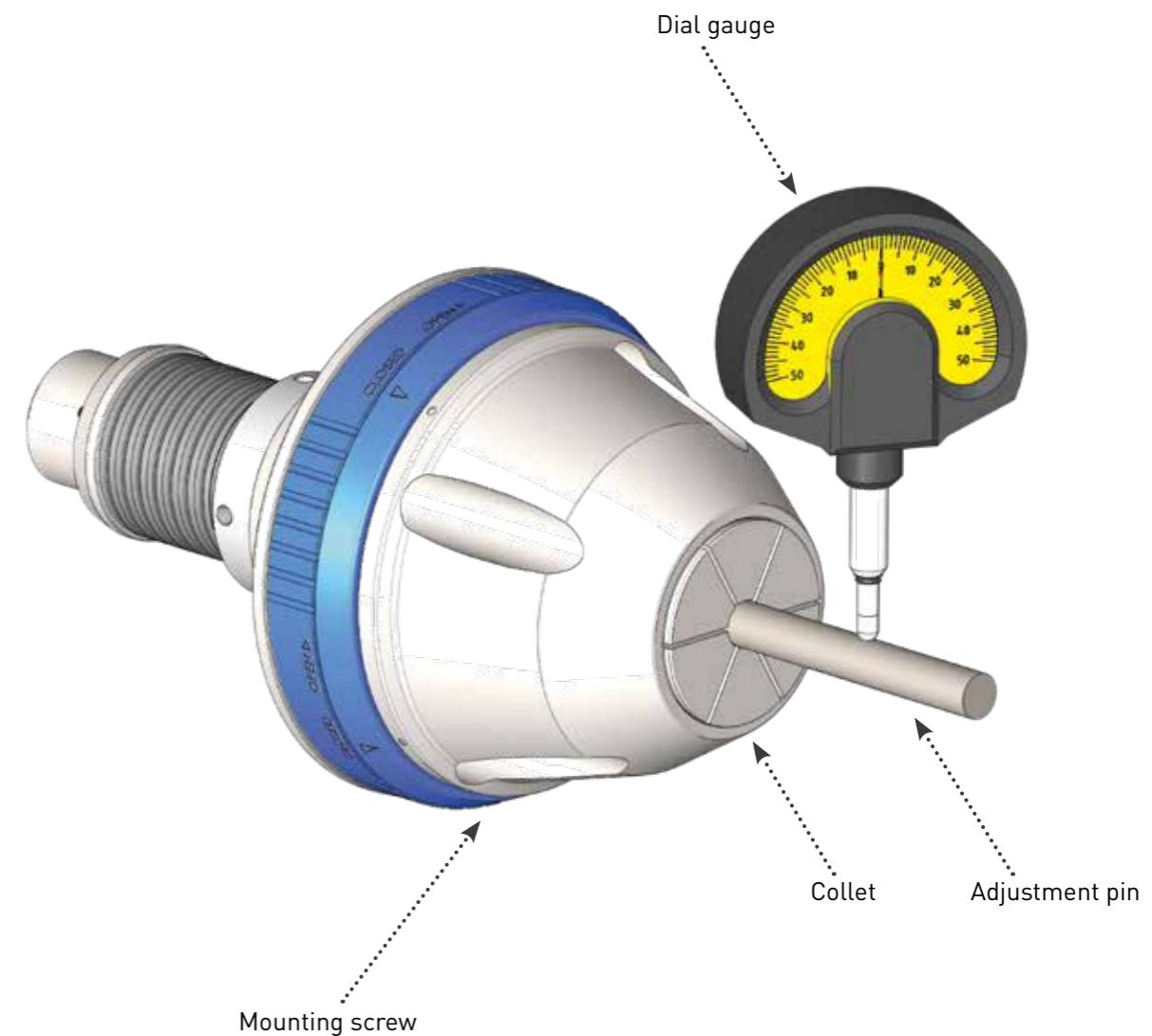
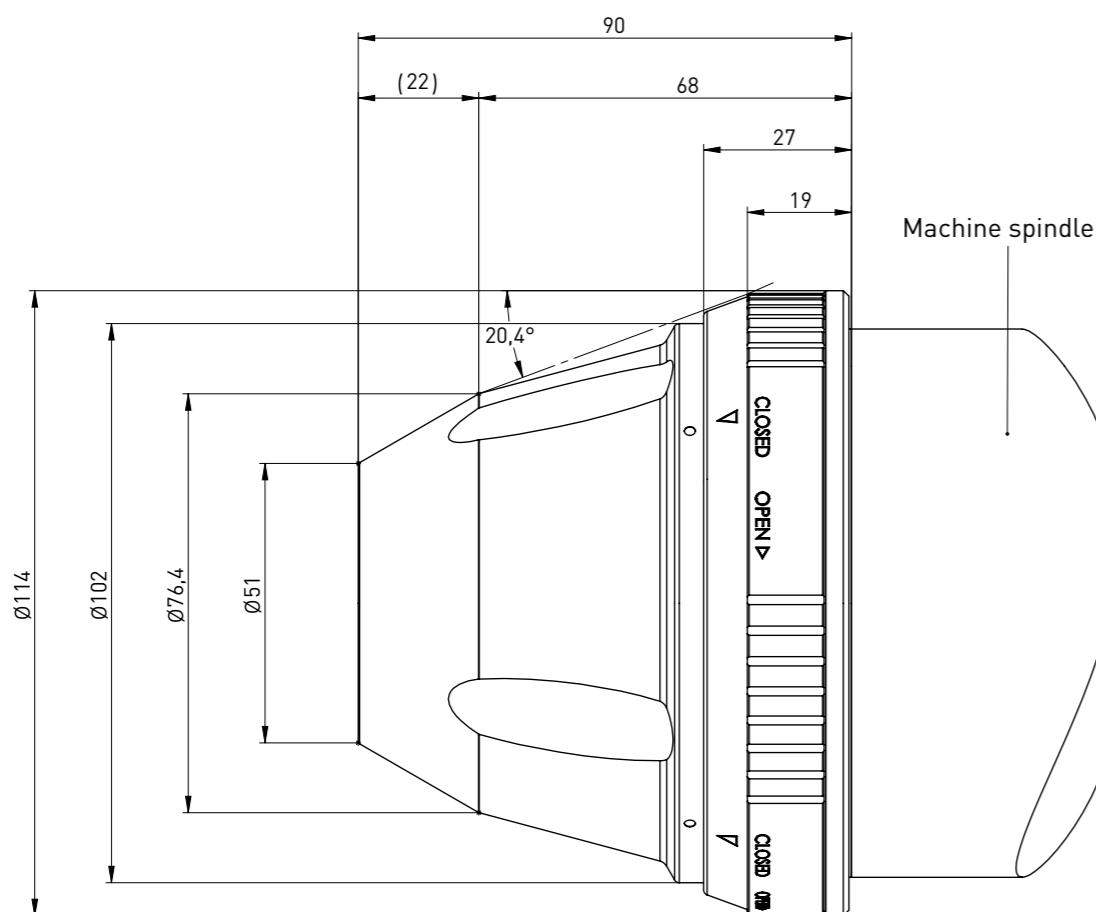


grinding deserves **SOLUTIONS**

**GDS**  
Made in Germany

VIPER L Nann 3718E **NANN** Collet - maximum bore  $\varnothing 27$ 

For the dimensions of the collets, please refer to the manufacturer's information.



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## Step 1: Preparation

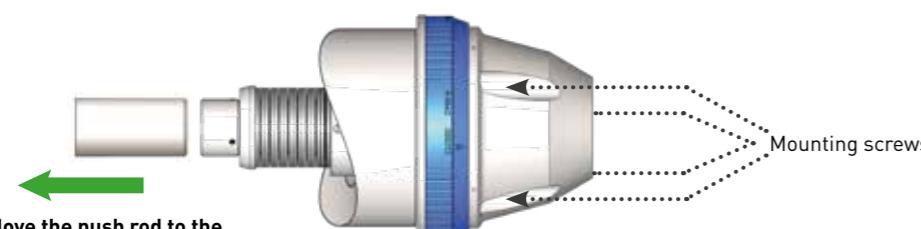
1. Clean all contact surfaces of the chuck.
2. Make sure that the face of the machine interface is flat and clean.
3. The VIPER chuck should be at ambient temperature.

## Step 2: Screw in push rod

1. Screw the push rod into the machine spindle and tighten it firmly.
2. Move the push rod with the machine control to the rear.

## Step 3: Mount chuck

1. Screw the chuck onto the facing unit using the screws supplied. When doing so, please tighten the mounting screws only slightly. (The mounting screws will be tightened later during run-out adjustment).



**ATTENTION:** Move the push rod to the rear before mounting the chuck.

## Step 4: Preparation for collet

1. Move the push rod forward with the machine control. The chuck opens automatically.
2. Turn the blue ring to OPEN (Fig. 1).

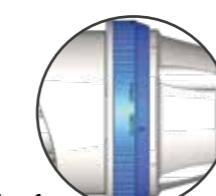
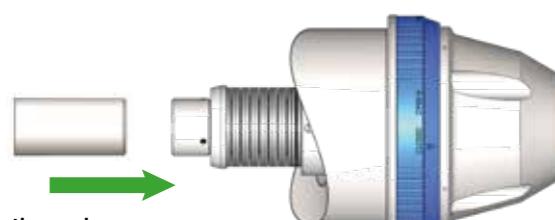


Fig. 1  
View: Blue ring open



**ATTENTION:** Move the push rod forward to open.

## Step 5: Screw in collet with adjusting pin

Screw in the collet chuck as follows:

1. Slowly turn the collet clockwise until the clamping pin engages in the groove of the collet.
2. Slide a suitable adjustment pin into the collet, turn the collet with the cofix clockwise until you feel resistance and the adjustment pin is tight.
3. Turn the cofix over and rotate the collet two notches counterclockwise. **One detent  $\triangleq$  one detent noise.**
4. Turn the blue ring to CLOSE (Fig. 2).
5. Move the pressure bar with the machine control to the rear. This operation clamps the adjustment pin. Use the machine control to make sure that the chuck properly clamps and releases the setting pin.

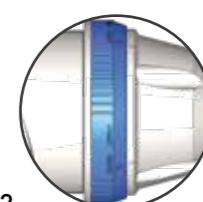
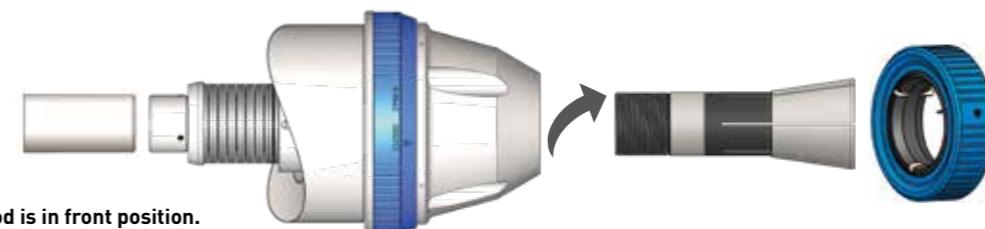


Fig. 2  
View: Blue ring closed



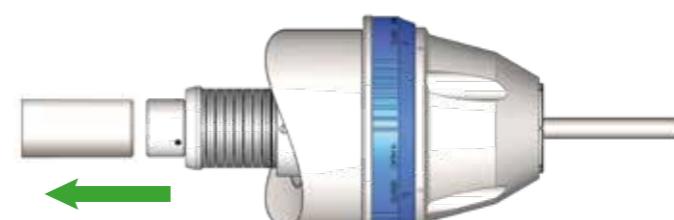
Push rod is in front position.



**Collet must NEVER be clamped empty.**



To avoid injury, rotate the collet in and out with our CoFix screw-in aid.



**ATTENTION:** Move the push rod to the rear to tighten the adjustment pin.

**ATTENTION:** Before each shutdown of the machine, make sure that a tool remains in the chuck.

## Setting concentricity and repeatability

Please take the time to adjust the concentricity. The more accurately the chuck is set, the more accurately it will behave.



**Use precision dial gauges when adjusting. Pay attention to the quality of the setting pin.**



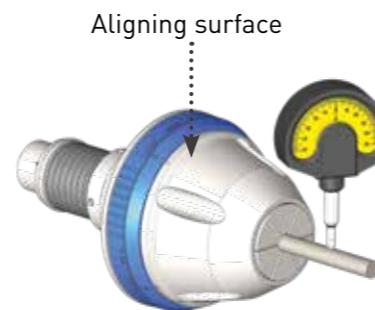
To ensure proper function, disassemble and clean the chuck once a month.



**ATTENTION:**  
Do not knock on the blue locking ring.

### Step 1: Set

1. Align the chuck with an alignment hammer (made of plastic or copper) by tapping lightly on the alignment surface.
2. After achieving the desired concentricity, tighten the mounting screws crosswise with 12Nm.
3. Done, now you can start grinding.



## Change collet

### Step 1:

- Advance the push rod to open the chuck. Remove the blank.

### Step 2:

- Turn the blue locking ring from CLOSE to OPEN and turn out the collet with the Cofix.

### Step 3:

- Turn the new collet into the chuck as described on page 5.

### Step 4:

- Clamp a new adjustment pin and check the runout error with the dial gauge.

## Remove chuck

### Step 1:

- Advance the push rod to open the chuck. Remove the blank.

### Step 2:

- Turn the blue locking ring from CLOSE to OPEN and turn out the collet with the Cofix.

### Step 3:

- Move the push rod to the rear.
- Loosen the four mounting screws.
- Remove the chuck from the machine and pack it in the original bag. **Pay attention to corrosion protection.**



**Note:**

When you remove the chuck with collet, the blank must be in the collet.

## GDS VIPER safety instructions

### To note:

- The VIPER series (chuck) was designed for loading and changing rotationally symmetrical blanks and tools with shank tolerance h6 or more accurate.
- For shank tools, all shanks according to DIN 1835 Form A, B, E or DIN 6535 Form HA, HB, HE can be clamped.
- The VIPER series (chucks and collets) may only be used within the scope of their technical data.
- This product is intended for industrial use.
- Intended use includes compliance with all the information in these instructions.
- Faultless function and warranty claims can only be guaranteed with original GDS accessories.

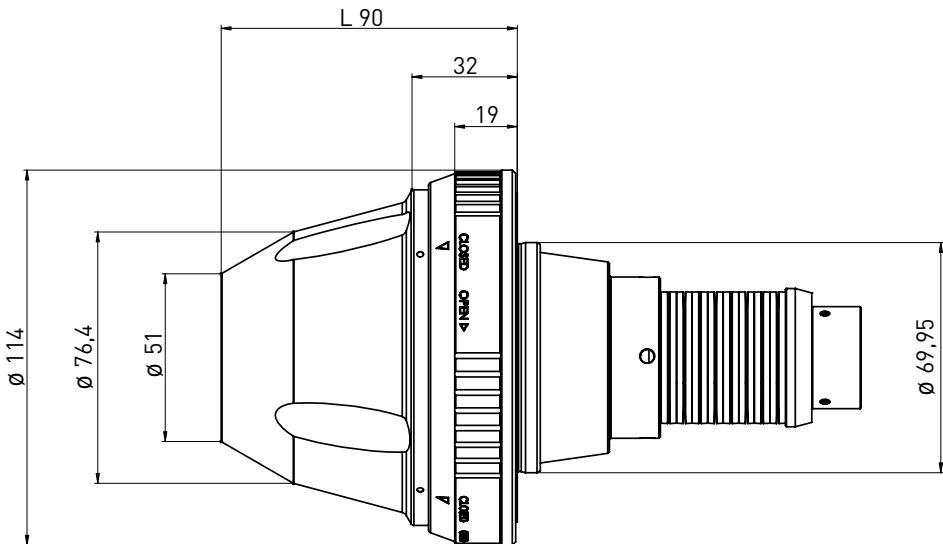


## GDS VIPER error causes and solutions

### Check the following points:

- Check clamping pressure
- Check blank
- Contamination
- Locking mechanism (blue ring) correctly closed
- All mounting screws correctly tightened
- Chuck requires room temperature
- Open everything again, clean and start again step by step

**VIPER L Nann 3718E**  for SK50 tool grinding machines  
Collet - maximum bore  $\varnothing 27$



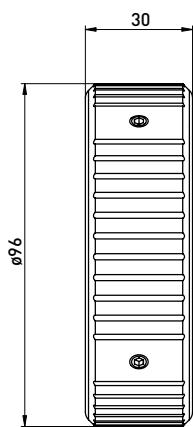
#### Delivery includes:

Push rod

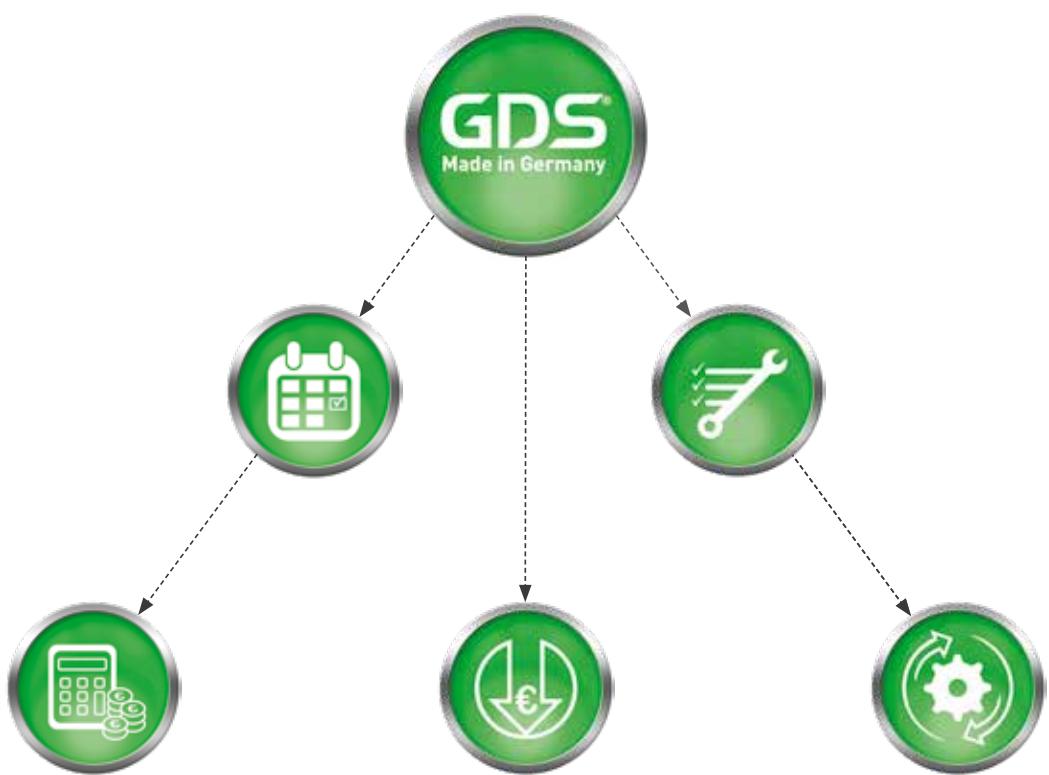
Item no.	Name	D	L
400004012	VIPER L Nann 3718E	69,95	90

#### Accessories:

Item no.	Name
350060014	Cofix 32 (for Nann 3718E) Screw-in tool for collets



# REVOLUTION IN TOOLGRINDING



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