

Shrinkfix

pokolm

Instruction manual

Discover Shrinkfix Basic, the shrink-fit technology for a secure connection.

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1. IMPORTANT NOTES AND INSTRUCTIONS

The Shrinkfix Basic is equipped with the latest technology and is extremely safe and easy to use. However, there is still a certain risk if this device is operated incorrectly and/or by untrained personnel. Pay particular attention to the following precautions and warnings, which are marked with the "Attention" and "Danger" symbols. Failure to follow safe operating procedures can result in injury, death, or damage to the device and may VOID your manufacturer's warranties.



- Before using the device, you must have read and understood this user manual in its entirety. Keep this user manual within easy reach of the operating personnel.
- Before putting the device into service, visually inspect the device, the power cord, and the accessories for signs of wear or damage. Do not use the device if it shows signs of damage or is not functioning normally.
- Never operate the device if the appropriate induction heat-focusing stopper is not attached to the induction head. Make sure that no part of the induction head comes into contact with the tool holder or the cutting tool during operation, as this can cause damage to the device
- The holder and the tool must be clean, free of grease, and dry before they are attached to the device.
- Required tolerance for the tool shank: Ø 3 to 5 mm (Ø 0.118" to 0.1968"), maximum h5. The tool shank must be made of carbide or heavy metal (e.g., Densimet). Ø 6 to 32 mm (Ø 0.236" to 1.25") maximum h6. The tool shank may be made of steel, HSS, hard metal, or heavy metal. Using h5 for Ø 6 to 32 mm (Ø 0.236" to 1.2598") ensures a more reliable minimum clamping torque.
- Do not wear rings, bracelets, or other metal objects while operating the device. During operation, metal objects near the induction head can heat up very quickly.
- Use the heat-resistant gloves and pliers provided when handling tools or tool holders. Never attempt to touch hot tools or tool holders before the cooling cycle is complete.
- If the device is moved from a cold environment to a warm one, wait three hours before turning it on to prevent condensation and malfunctions in the electronic system.
- People with pacemakers must not operate the device and must always maintain a safe distance of at least 2 meters (6 feet) from it.

- Cutting tools have sharp edges. Handle them with care.
- The included power cord must be plugged into a standard three-phase outlet suitable for your country. Using the device with an improper connection or the wrong voltage can damage the device and result in injury or even death.
- Route the power cord so that it cannot be damaged by forklifts or other equipment and does not pose a tripping hazard to staff.
- Do not use the device in a damp environment where it is likely to come into contact with coolant or spilled liquids. This could result in electric shock or damage to the device.
- Never use the device near flammable materials or vapors. Do not use flammable liquids or aerosols to clean the tool holders. Never expose the device or hot tools to flammable materials.
- Never open the device or attempt to repair it, as doing so will VOID the manufacturer's warranty. The interior of the device contains dangerous residual voltage that can cause serious injury or death.
- Unauthorized modifications or alterations to the Shrinkfix Basic unit will VOID your manufacturer's warranty. Do not attempt to service the unit yourself. Customer service technicians can perform all necessary repairs or maintenance. Do not modify or disable the unit's built-in safety features.
- Turn off the device and unplug the power cord from the outlet before cleaning, maintaining, or storing the device.

2. GENERAL OVERVIEW



3. ACCESSORIES AND REPLACEMENT PARTS

Minimum requirements for shrinking and expanding processes

- Blade holders and adapter rings for any type of machine-side taper mount used with Shrinkfix Basic tool holders. Available for all types of tool holders (HSK/DIN & DIN TF/BT & BT TF/CAT & CAT TF/Capto). Enables the tool holder to be positioned on the mounting module.

Replacement Parts

- Protective cone: Directs the airflow for cooling to the front of the holder.
- Stop washer: Available for shrink-fit and shrink-release tool holders with diameters from 3 to 32 mm (0.118" to 1.26"). Magnetic isolator that concentrates the magnetic field on the front of the tool holder, thereby optimizing heating.

4. BASIC FUNCTIONS

Smart coil
Faster and optimized cycle for shrinking and expanding steel, HSS, heavy-metal, or carbide tools with standard DIN tool holders.

Pillar
Enables the shrinking and expanding of tool holders with a maximum length of:
- 400 mm (15.748") with a multifunction adapter
- 450 mm (17.716") with an SA50 lamella holder
- 510 mm (20.078") with other lamellar holder interfaces
  via a Wi-Fi connection or RJ45 cable
- Compatible with TDM systems
- Special programs are easy to program
- Comprehensive overview of system status

Stop washer
Enables the shrinking or expanding of carbide or HSS tools with diameters ranging from 3 to 32 mm (0.118" to 1.260").
Note: A split stop washer is available as an accessory for larger head tools.

Interface
- Simple control panel with LED display
- 3 standard programs for all DIN 4.5° and DIN 3° tool holders
- 1 programmable mode for other tool holders (specific shape or ball head)
- 1 manual mode

Smart
- Small computer that enables an intelligent web interface via a Wi-Fi connection or RJ45
- Compatible with TDM systems
- Custom program is easy to program
- Comprehensive overview of the system status



5. PRODUCT RANGE OVERVIEW

Package contents
- Multifunction adapter for SK/BT/CAT 40 & 50; HSK 63/100; C6
- Smart coil with interchangeable stop washers
- Fans
- Protective cones
- Gloves
- Pi Interface 4.0
- Online support interface

Connections
The device accepts only the following voltage:
AC 3 x 400 V (+/-10%) + PEN / 23.8 A / 50-60 Hz
AC 3 x 400 V (+/-10%) + N + PE / 23.8A / 50-60 Hz
AC 3 x 440-480 V + GND / 23.8 A / 50-60 Hz

For other voltage ratings, a transformer is required, which must be purchased separately:
- Input voltage: 3 x 208/240/480/600 VAC + GND / 28 A / 50-60 Hz
- Output voltage: AC 3 x 400 V + N + PE / 28 A / 50-60 Hz
- 2.5-meter cable included
- Compressed air from 3 to 6 bar / 10 mm diameter line required

6. OPTIONS AND ACCESSORIES

- Adapter positioning ring for SK/BT/CAT30 & C3/C5/C8
- Cabinet
- Tool holder with air-cooling box
- Air-powered cooling









7. ACCEPTANCE OF DELIVERY

The device you received from us was inspected and tested at our factory in accordance with ISO 9001 specifications. If the device is stored or transported under unsuitable conditions, it may sustain permanent damage. In this case, the manufacturer excludes all warranty claims and obligations. Unpacking must be done carefully to prevent damage. There is a tilt indicator on the packaging that ensures the pallet has not been tipped over.

8. OPERATING ENVIRONMENT OF THE DEVICE

The Shrinkfix Basic unit must be placed in a dry and clean work area on a stable and sturdy surface that can withstand hot tool holders (+/-100 °C (212 °F)).

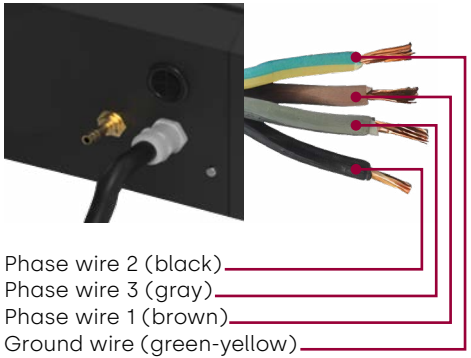
Connections
Note: The voltage converter for the U.S. or Canada is available as an optional accessory.

Power Supply: Be sure to use the correct power adapter.
AC 3 x 400 V (+/-10%) + PEN / 16 A / 50-60 Hz
AC 3 x 400 V (+/-10%) + N + PE / 16 A / 50-60 Hz
AC 3 x 440-480 V + GND / 20 A / 50-60 Hz

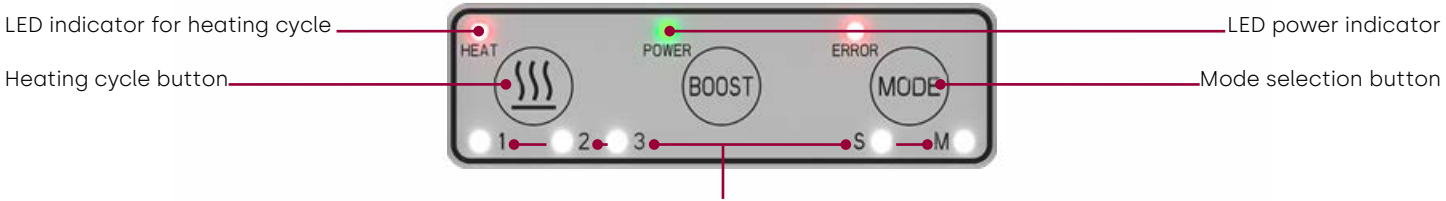
For other voltage values, a transformer is required, which must be purchased separately:

- Input voltage: 3 x 208/240/480/600 VAC + GND / 28 A / 50-60 Hz
- Output voltage: AC 3 x 400 V + PE / 28 A / 50-60 Hz

Air supply: 3 to 6 bar (43 to 87 psi)/tube outer diameter 10 mm (Ø 0.393") (Tube not included)



9. KEYBOARD AND DISPLAY



10. START THE DEVICE

- ❶ Set the Shrinkfix Basic device to OFF.
- ❷ Set the Shrinkfix Basic device to ON.
- ❸ The power LED lights up.
- ❹ After 10 seconds, the power LED and the "Mode 1" LED light up, indicating that the device is ready for use.

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11. SHRINKING AND EXPANDING



Always wear protective gloves when handling Shrinkfix Basic holders, tools, accessories, and replacement parts.



People with medical implants are not permitted to use or operate this device. People with a pacemaker must follow the guidelines for their pacemaker, which were developed based on the standards: NF EN 60601-1-2 (September 2017).



Risk of electric shock when disassembling module components.



Do not use hydraulic tool holders with this device, as there is a risk of explosion and third-degree burns. Please inform all employees who may use this device and train them in its proper use.

Shrinkfix Basic Tool Holders and Cutting Tools

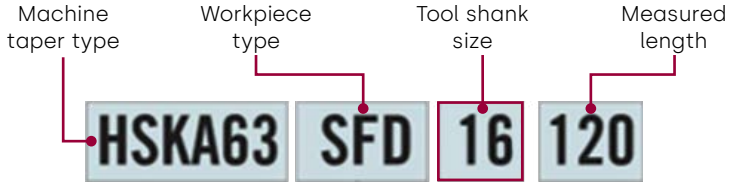
The Shrinkfix Basic device allows for easy and safe shrink-fit tool changes without damaging the tool holder or the cutting tool, provided the device is installed correctly and operating procedures are followed. Shrinkfix Basic is designed for use with all types of Shrinkfix Basic standard tool holders and for efficient use with tools made of steel, HSS, heavy metal, or carbide.
The diameter tolerance of the tool shank is critical.
Required tolerance for the tool shank:
Ø 3 to 5 mm (Ø 0.11" to 0.19"), maximum h5; the tool shank must be made of carbide or heavy metal (e.g., Densimet).
Ø 6 to 32 mm (Ø 0.23" to 1.25") maximum h6; the tool shank may be made of steel, HSS, carbide, or heavy metal.
Using h5 for Ø 6 to 32 mm (Ø 0.23" to 1.25") provides a more secure minimum clamping torque.
When inserting the tool shank into the holder, ensure that the minimum shrink depth LSC specified on the product pages for each holder is observed.
Ensure that the tool holders and tools are clean, grease-free, and dry before mounting them in the machine.

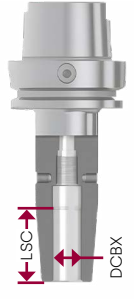
12. MINIMUM SHRINKAGE VALUES TO BE OBSERVED

We recommend the following shrink depth to ensure the minimum transmissible torque and the service life of the tool.

Example of an SFD DIN 4.5° tool holder:
The DCBX diameter (tool connection size) is specified in the tool holder specifications.
The shrink depth (depending on the position of the stop screw) must be set to at least LSC.
In this case, the table shows LSC = 39 mm (1.54").

Description:



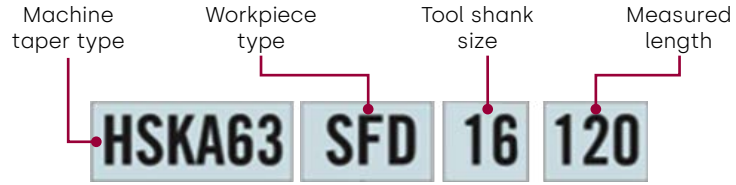


Minimum shrinking depth

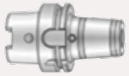
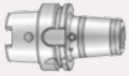
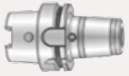
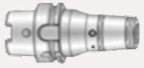
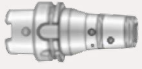
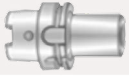
Metric		Inch	
DCBX	LSC Min	DCBX	LSC Min
3	13	1/8"	1/2"
4	15	-	-
5	18	3/16"	3/4"
6	26	1/4"	7/8"
8	30	5/16"	1"3/16
10	32	3/8"	1"1/4
12	34	1/2"	1"3/8
14	34	-	-
16	39	5/8"	1"1/2
18	39	3/4"	1"5/8
20	42	7/8"	1"5/8
25	47	1"	1"7/8
32	52	1"1/4	2

13. MODE SELECTION

Description:



Heating mode selection according to marking of:

Workpiece type	DIN type	Designation	Mode	Normal
	DIN: 4.5°	SFD	1	
	DIN: 4.5°	SFD...-L1	1	
 MQL	DIN: 4.5°	SFD...M SFD...M1 SFD...M2	1	
	Special short*	Special short*	1	
	DIN: 4.5° Reinforced	SFR	2	
	DIN: 4.5° Safe-Lock™	SFR	2	
	DIN: 3°	SFS	2	
	Zylindrical	Power program	3	
Custom tool holders	Special program	Special program	S	

14. SHRINK PROCESS

- ❶ Attach the positioning ring and the adapter ring to the cooling tube according to the type of tool holder.
- ❷ Select the appropriate heating mode, which must be used according to the type of tool holder, as specified in the table above.
- ❸ Place the cooling tube, along with the positioning ring and the adapter ring, over the hole in the base plate.
  Place the tool holder on the adapter ring. The cooling tube, along with the positioning ring and the positioning adapter, can be used in place of a fin holder.
- ❹ Take the stop washer that matches the diameter of your tool shank and position it in the Smart coil.
  Secure the stop washer by turning it a quarter turn into the smart coil.
- ❺ Slide the smart coil housing down on the holder by pressing the button on the handle.
  The stop washer must touch the tool holder housing.
- ❻ Press the mode button until you reach the corresponding mode that was previously shown in the table.
- Put on the protective glove, pick up the cutting tool, and hold it firmly with the glove.
- ❼ Press the heating cycle button once and wait until the heating cycle LED goes out.
- Quickly slide the "Smart coil" housing upward.
- Quickly insert the tool into the tool holder and wait until the tool is properly clamped.
- Move the cooling tube, along with the tool holder, to the other hole on the base plate.
  (Without a water cooling system: Place the protective cone ❽ in position.)



15. SHRINK RELEASE (EXPANDING)

The process for expanding is the same as that for shrinking.

16. AUDIBLE FEEDBACK

While in use, the device's power source emits an audible feedback tone whose frequency varies depending on the size and temperature of the tool holder. It is not unusual for the pitch to change as the temperature of the tool holder rises. There is no need to be concerned about this sound; it is normal.

17. BOOST MODE

The Boost function was developed to prevent problems when:
- The cutting tool is outside the H5/H6 tolerance range
- There is debris between the toolholder and the tool
- Slight overheating of the toolholder
- Competitors' toolholders with shrink-fit and expansion-fit functions that have the same shape as our standard shape but with different diameter tolerances

Before activating the Boost function, please make sure that your tool holder is not already hot (< 30°C (86°F)).
The Boost function works for only one cycle.

- ❶ Press the mode button until you reach the corresponding mode that was previously shown in the table.
- ❷ Press the Boost button once; the LED indicator for the selected mode will flash.
- You can now begin the heating cycle. Follow the same instructions as in step 9 of the shrinking process.

The Boost function can be configured via the web interface. By default, the Boost function increases the heating time by 20%.

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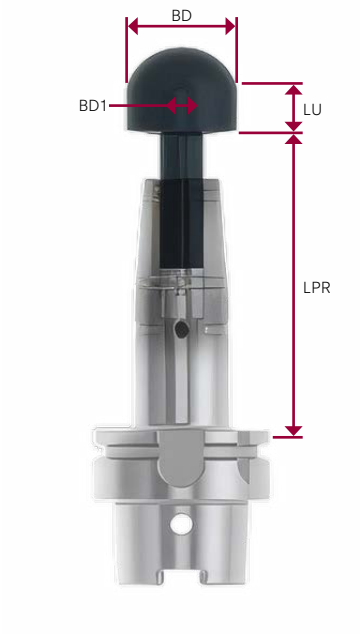


18. SHRINKING FOR SPECIAL TOOLS

Split stop washers are available for special tools, such as those with a front end that is larger than the shank.
Using a split stop washer requires space between the tool head and the front of the tool holder.
To successfully shrinking or expanding special tools, the following conditions must be met:

- The maximum diameter of the cutting tool (BD) is 3 x BD1
- Maximum BD diameter = 63 mm (2.48") (maximum bore diameter of the induction unit)
- LPR dimension = 70 mm (at least 2.76") due to the dimensions of the inductor housing
- LU dimension varies depending on the tool shank diameter BD1

Tool shank Ø mm:	3 (0.12")	4 (0.16")	5 (0.2")	6 (0.24")	8 (0.31")	10 (0.4")	12 (0.47")
LU dimension (mm)	6 (0.24")	6.5 (0.24")	7 (0.27")	7.5 (0.27")	7.5 (0.27")	9 (0.35")	10 (0.39")
Tool shank Ø mm:	14 (0.55")	16 (0.63")	18 (0.71")	20 (0.79")	25 (1")	32 (1.26")	
LU dimension (mm)	11.5 (0.43")	10 (0.39")	11.5 (0.27")	12 (0.47")	9 (0.35")	9 (0.35")	



19. SHRINKFIX BASIC FOR SPECIAL TOOLS

- ❶ Place the tool holder in the vane holder or in the adapter ring on the cooling tube.
- ❷ Install the split stop washer that matches the diameter of the tool shank (see table on the previous page) into the positioning hole in the Smart coil housing. (Secure the stop washer by turning it a quarter turn into the Smart coil.)
- ❸ Push the Smart Coil housing down onto the holder by pressing the button on the handle. The stop washer must touch the tool holder housing.

Five split clamping discs for a tool shank diameter of Ø 3 to 32 mm (Ø 0.118" to 1.26") are available as accessories with the following capacities: Ø 3-6 mm (Ø 0.118"-0.236"), Ø 8-14 mm (Ø 0.314"-0.551"), Ø 16-18 mm (Ø 0.629"-0.708"), Ø 20-25 mm (Ø 0.787"-0.984"), Ø 32 mm (Ø 1.26").

- ❹ Press the mode button until you reach the corresponding mode shown earlier in the table.
- ❺ Press the heating cycle button once and wait until the heating cycle LED turns off.
- ❻ Insert the tool into the tool holder.
- ❼ After shrinking, slide the Smart Coil housing slightly upward and removethe split stop washer. (Caution – it may be hot.)
- ❽ Slide the Smart Coil housing upward to remove the tool holder.

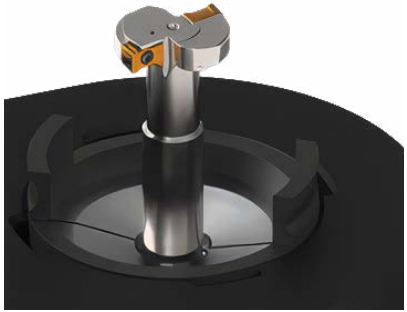
Note:
The total height of the Smart Coil housing limits the "LPR" dimension to a minimum of 70 mm (2.76"). If the height is less than this, it is not possible to lower the Smart Coil housing sufficiently to gain access to the split stop washer.



20. SHRINK RELEASE OF SPECIAL TOOLS

- ❶ Insert the tool holder into the lamella holder or the multifunction adapter.
- ❷ Slide the Smart Coil housing under the front of the tool holder and place the corresponding split stop washer around the shank of the cutting tool. The stop washer must touch the tool holder housing.
- ❸ Press the mode button until the corresponding mode is displayed, as indicated in the table.
- ❹ Press the heating cycle button once and wait until the heating cycle LED goes out.
- ❺ Remove the tool from the tool holder. (Caution – it may be hot.)
- ❻ Slide the Smart coil housing upward to remove the tool holder.

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21. SHRINKAGE CAPACITY

Shrinkfix Basic mount type	Cylindrically reinforced	Mold maker DIN 3°	Standard DIN 4.5°	Standard DIN 4.5° reinforced
Average shrinkage time	6 sec.	2.5 sec.	4 sec.	6 sec.
Minimum shrink diameter (Tool shank)	6 mm	3 mm	6 mm	6 mm
Maximum shrink diameter (Tool shank)	32 mm	16 mm	32 mm	32 mm
Maximum diameter of the tool when the front end is larger than the shank	63 mm			
Average cooling time with ambient air cooling	25 - 35 min.	15 - 25 min.	20 - 30 min.	25 - 35 min.
Average cooling time for fan-assisted air cooling	10 min.	5 min.	8 min.	10 - 15 min.
Average cooling time for water cooling	2 min.	1 min.	1.5 min.	2 min.
Average air-power cooling time	3 min.	1.5 min.	2.5 min.	3.5 min.

22. SHRINKING/EXPANDING OF CUSTOMIZED TOOL HOLDERS OR TOOL HOLDERS FROM OTHER MANUFACTURERS

The Shrinkfix Basic allows you to set up manual heating programs via a dedicated web interface.
Please contact your usual representative at Pokolm Frästechnik GmbH & Co. KG for detailed information.

23. WEB INTERFACE

Accessing the web interface:
With Shrinkfix Basic, you can use the web interface to start a manual program or create a custom automated program.

Manual program:
A single heating cycle with a specific heating time and diffusion time at a certain percentage of the heating power.

Special program:
A mode that can be launched directly from the device's user interface and allows you to configure 15 types of tool holders with different heating and time parameters. The only difference from the manual program is the automatic detection of the resistance of your custom tool holders. The device applies the permissible parameters that correspond to the size and shape of your tool holders and configures them in the table.

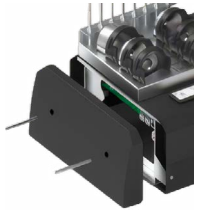
This requires: a computer, smartphone, or tablet with a Wi-Fi or Ethernet (RJ45) connection

For a Wi-Fi connection:
- When the device is turned on, a Wi-Fi network is automatically created.
- Connect your computer to it

Example:
SSID/Wi-Fi name: Evoset-D7-6F-E3
Default password: wifievoset

For an Ethernet connection (RJ45):
- Turn off the device using the power switch.
- Unscrew the plastic cover 1 on the left side of the device.
- There is an access hole on the back of the device. Feed the RJ45 cable through it 2.
- Connect the other end of the RJ45 cable to your computer.

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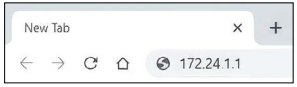


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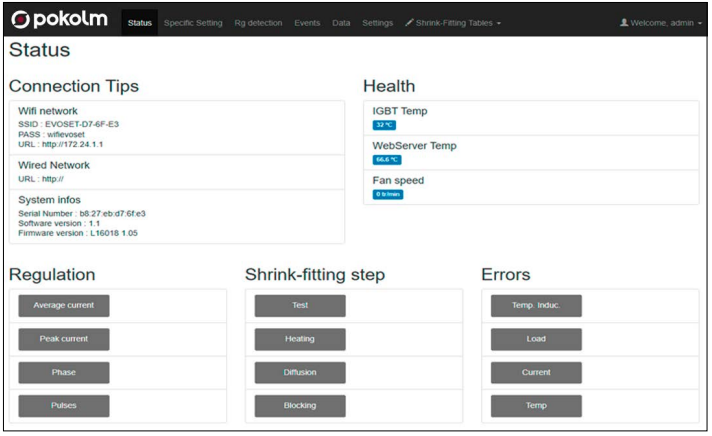


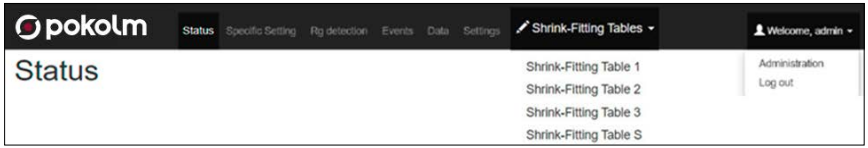
For both types of connections:

- Open a web browser (e.g., Google Chrome, Internet Explorer, Edge, Firefox, etc.).
- In the address bar (URL), enter the IP address: 172.24.1.1
- Press the enter key.
- The login page will appear (as shown below).
  Default username: admin
  Default password: admin
- You will now be taken to the main page.
- All of the software's menu options are available in the menu bar.









Status: Condition of the unit

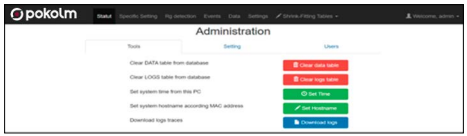
Specific setting: Heating program without resistance measurement
Rg detection: Measurement of the tool holder's resistance value
Events: All software actions in a log file
Data: The heating process log
Settings: Inductor settings that can only be configured by the supplier
Shrink Fitting Tables: Access to all parameters in the Shrinkfix Basic table

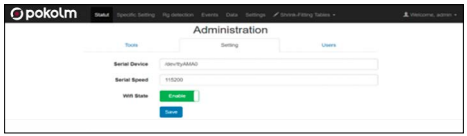
Shrink Fitting Table 1: Standard DIN 4.5° Mode 1 settings
Shrink Fitting Table 2: Standard DIN 3°; Standard DIN 4.5°; enhanced Mode 2 settings
Shrink Fitting Table 3: Cylindrically reinforced, power program mode with 3 settings
Shrink Fitting Table 5: Settings for custom toolholders with automatic size detection

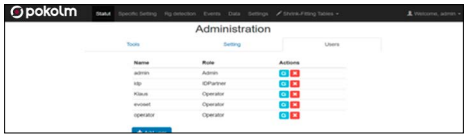
Welcome: Access to administrator settings
Administration: Managing administrative settings

There are 3 menus for managing all administrative tasks on the web interface

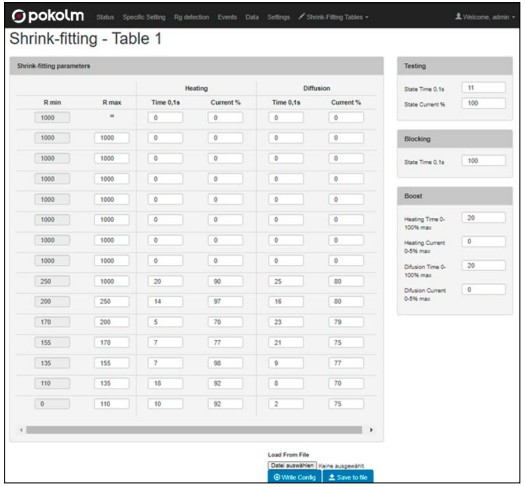
Log Out: End the user's current session







24. SETTING VALUES FOR THE SHRINKAGE PROCESS



Parameters for the shrinking process:

- **R min/R max:** Allows for the classification of shrinking tool holders of various diameters and shapes based on their measured resistance.
- **Heating time:** Time required for shrinking tool holders to shrink or unshrink based on the measured resistance (expressed in tenths of a second; e.g., 1.1 sec. = 11).
- **Heating current:** Power required for shrink tool holders for shrinking or unshrinking, based on the measured resistance (in %).
- **Diffusion time/current:** Following the same principle as in heating, the diffusion current is normally lower than the heating current. These parameters make it possible to achieve a specific temperature distribution in the tool holders over time.

Testing:
- NEVER CHANGE THIS SETTING. This is where the system measures the resistance.

Blocking:
- The time between heating the previous tool and the next tool.

Boost:
Settings for the boost process.
- **Heating time:** Additional heating time in the shrink settings, in %.
- **Heating current:** Additional heating power in the shrink settings, in %.
- **Diffusion time:** Additional diffusion time in the shrink settings, in %.
- **Diffusion current:** Additional diffusion force in the shrink settings, in %.

25. CHECKING THE RESISTANCE OF THE TOOL HOLDER

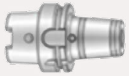
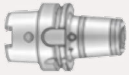
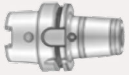
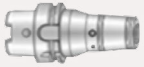
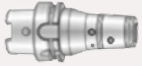
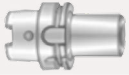
- Place your toolholder on the Shrinkfix Basic and set everything up as you would for a standard toolholder.
- Push the Smart Coil housing down using the appropriate stop washer.
- Select the "Rg-detection" menu from the menu bar of the web interface.



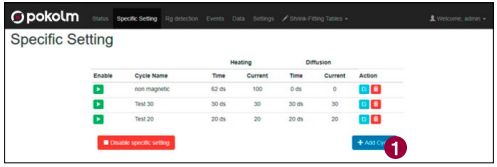
- LED 1 automatically flashes on the device's user interface.
- Start the heating cycle.
- The Rg value is normally calculated and displayed.



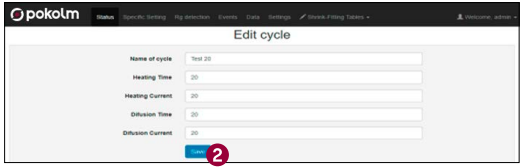
- Using the "Standard Tool Holders" table, compare the shape of your customer's tool holder with the image in the table and find the corresponding tool.
- Based on the comparison, note the mode that corresponds to the shape.

Workpiece type	DIN type	Designation	Mode	Normal
	DIN: 4.5°	SFD	1	
	DIN: 4.5°	SFD...-L1	1	
 MQL	DIN: 4.5°	SFD...M SFD...M1 SFD...M2	1	
	Special short*	Special short*	1	
	DIN: 4.5° Reinforced	SFR	2	
	DIN: 4.5° Safe-Lock™	SFR	2	
	DIN: 3°	SFS	2	
	Zylindrical	Power program	3	
Custom tool holders	Special program	Special program	S	

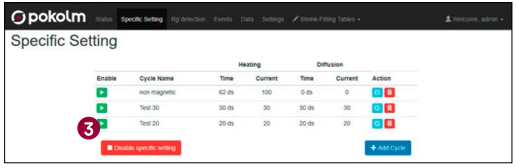
26. ADD A SPECIAL TOOL HOLDER



- Add a cycle ❶, define the heating/diffusion parameters, and save ❷.
  Example:

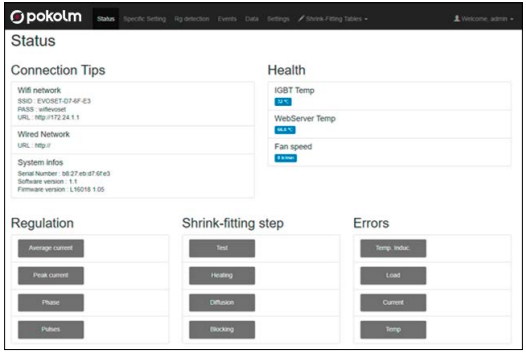


- When you're ready, click the Start icon to activate the function.
  ❸ After activation, you can start the heating cycle on the device.
- Normally, shrinking or expanding is easy to do. If this is not the case, adjust the parameters by gradually increasing the value.



27. ERROR MESSAGES

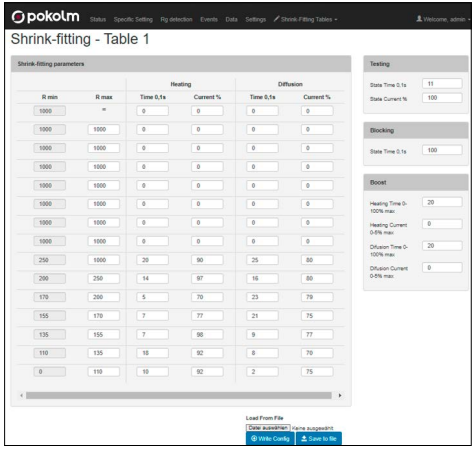
If the error LED on the interface is lit or the device is not functioning properly.
You can see what type of error the device has detected on the “Status” tab of the web interface.

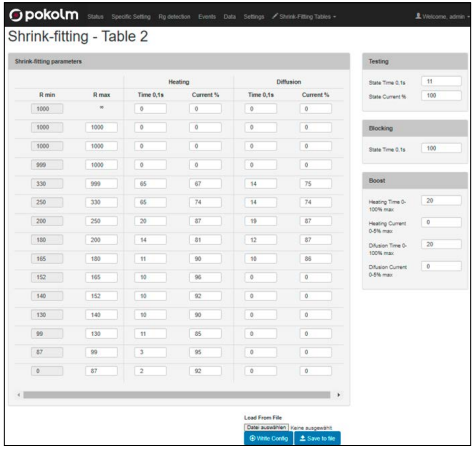


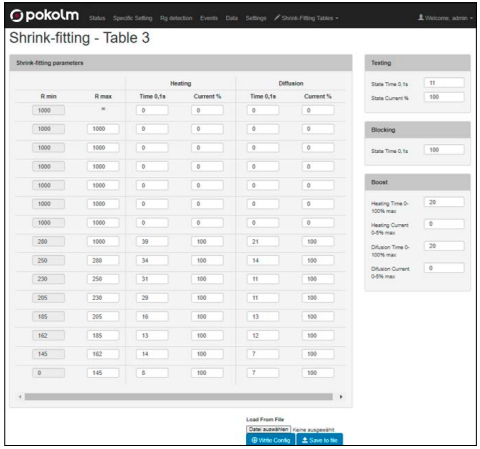
Error type:

	Supervising	If Red	Do
Temp. Induct.	Temperature in the smart coil	Temperature too high > 70°C	Please wait 10 minutes and try again.
Load	The material in the smart coil	Wrong material or wrong tool holder in the smart coil	Insert a new tool holder and try again. If the problem persists, the power board is damaged.
Current	Electrical connection	Short circuit in the inductor	Check the electrical connection and try again. If the problem persists, the power board is damaged.
Temp.	Temperature of the circuit board	Temperature too high > 70°C	Please wait 10 minutes and try again.

28. DEFAULT VALUES IN THE TABLES







29. FREQUENCY OF MAINTENANCE

Daily maintenance:

- Clean the device
- Check that the device is functioning properly and is in good condition.
- ❶ Check the condition of the smart coil.
- ❷ Check the condition of the stop washers.



30. PRECAUTIONS

Shrinkfix is intended for professional use only.
Ensure that the power supply is correct:

Power supply:
Be sure to use the correct power supply.
AC 3 x 400 V (+/-10%) + PEN / 16 A / 50-60 Hz
AC 3 x 400 V (+/-10%) + N + PE / 16 A / 50-60 Hz
AC 3 x 440-480 V + GND / 20 A / 50-60 Hz

For other voltage values, a transformer is required, which must be purchased separately:
- Input voltage: 3 x 208/240/480/600 VAC + GND / 28 A / 50-60 Hz
- Output voltage: AC 3 x 400 V + PE / 28 A / 50-60 Hz

The power supply for the cooling unit is: 1 x 230 V + N + PE / 16 A / 50 Hz.

The power supply for the cooling unit is: 1 x 110 V +PE / 15A / 60Hz. US industrial cooler.
The Shrinkfix Basic holder gets very hot during operation. Touching this area can cause severe burns.
Always wear gloves when handling Shrinkfix Basic holders.

People with medical implants are not permitted to use or operate this device.
People with pacemakers must follow the guidelines for their pacemaker, which are based on NF EN 60601-1-2 (September 2007).

Repairs to the shrinking machines should only be performed by trained personnel.
Please contact your sales partner.

Only trained and authorized personnel may use the shrink units equipment.

31. RECOMMENDATIONS FOR USE AND MAINTENANCE

Always make sure the holder has cooled down before shrinking or unshrinking it.
The holder and the tool must be clean, grease-free, and dry before they are attached to the device.

Before you begin the shrinking process, please always check that:
- The power supply is sufficient.
- The length is set correctly using the appropriate stop rod.
- The correct stop washer has been selected.
- The recommended tolerance for cylindrical tool shanks is h5 or h6 (maximum h5 for Ø 3 to 5 mm (Ø 0.118" to 0.196"), maximum h6 for Ø 6 to 32 mm (Ø 0.236" to 1.26").
- The tool shank is not damaged.

Keep the device and its surroundings clean to ensure a long service life.
The device may only be used for the purposes specified in this user manual.
For information on liability in the event of improper use, please see '34. Improper Use'.
Maintenance is limited to regularly cleaning the device and its accessories with suitable products.

Safety feature of the heating module
- The smart coil is equipped with a sensor to prevent it from overheating. When the temperature limit is reached, the interface will become unavailable.
- To extend the service life of the holders, the device's electronics have been programmed to allow only one main heating cycle, which automatically shuts off after use. A programmed delay is then activated before the heating cycle function can be repeated.

32. ATTACHMENTS

- Technical specifications
- Declaration of conformity for heating modules, mounts, and coolers (to be filled out)
- Certificate

33. TECHNICAL SPECIFICATIONS

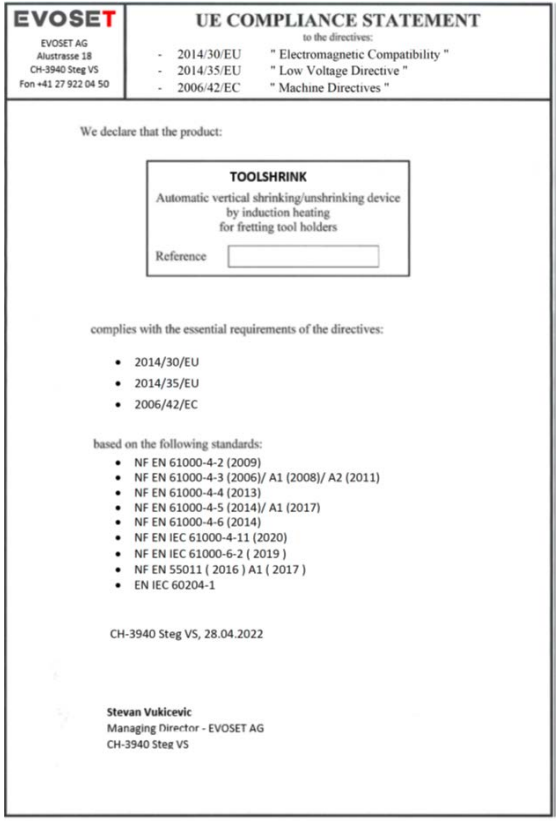
Shrinkfix Basic US

- **Voltage:**
  AC 3 x 400 V (+/-10%) + PEN / 23.8 A / 50-60 Hz
  AC 3 x 400 V (+/-10%) + N + PE / 23.8 A / 50-60 Hz
  AC 3 x 440-480 V + GND / 23.8 A / 50-60 Hz
- **Electric power:** 16.000 VA
- **Resonant frequency:** 50/60 Hz
- **Weight:** 46.2 kg (102 lbs)

- Prevent condensation and frost.
- Humidity when the unit's temperature rises slowly to 40°C (104°F) or changes rapidly from - 20°C (- 4°F) to + 30°C (86°F).
- At an altitude of no more than 2,000 m (6,500 feet) above sea level.

34. IMPROPER USE

The shrink-wrapping machine may only be used in accordance with the operating instructions and with the tool holders approved for this purpose. Deviating settings, unauthorized modifications, and operation by untrained persons are considered improper use.
This poses a particular risk of burns and fire. The manufacturer and seller assume no liability for damage resulting exclusively from improper use. Statutory liability claims remain unaffected.



EVOSET

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UE COMPLIANCE STATEMENT

to the directives:

- 2014/30/EU " Electromagnetic Compatibility "
- 2014/35/EU " Low Voltage Directive "
- 2006/42/EC " Machine Directives "

We declare that the product:

TOOLSHRINK
Automatic vertical shrinking/unshrinking device
by induction heating
for fretting tool holders

Reference

complies with the essential requirements of the directives:

- 2014/30/EU
- 2014/35/EU
- 2006/42/EC

based on the following standards:

- NF EN 61000-4-2 (2009)
- NF EN 61000-4-3 (2006)/ A1 (2008)/ A2 (2011)
- NF EN 61000-4-4 (2013)
- NF EN 61000-4-5 (2014)/ A1 (2017)
- NF EN 61000-4-6 (2014)
- NF EN IEC 61000-4-11 (2020)
- NF EN IEC 61000-6-2 (2019)
- NF EN 55011 (2016) A1 (2017)
- EN IEC 60204-1

CH-3940 Steg VS, 28.04.2022

Stevan Vukicevic
Managing Director - EVOSET AG
CH-3940 Steg VS

We are here for you!

If you have questions or need individual advice, our technical support team will be happy to assist you.

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