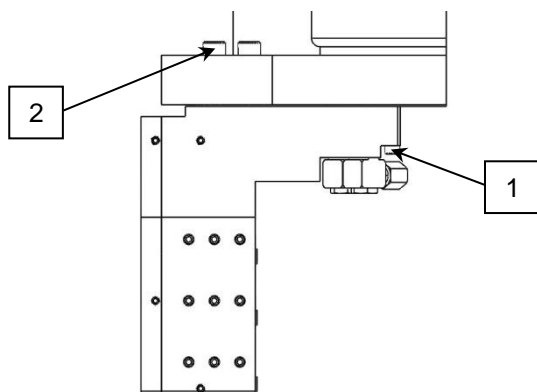


# GDF1502-IK

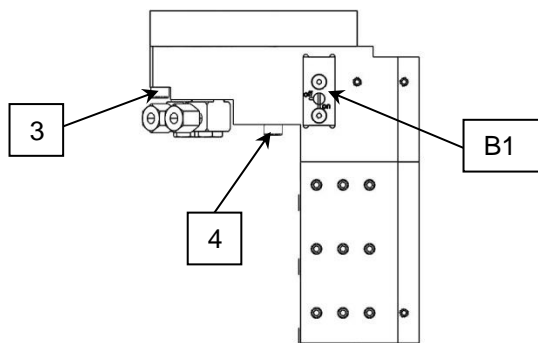
## Français

### 1. Fixation du porte-outil

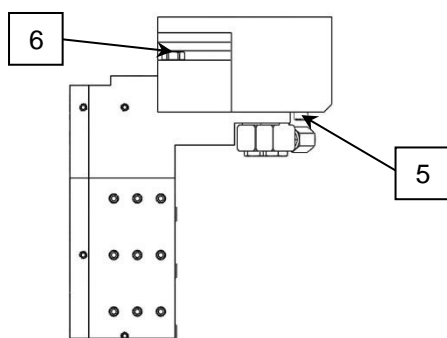
Citizen M32 type III-V-VII Gang Tools U34B  
=> Pos. T10 avec 2 vis M5x30 [1], 3 vis M8x40 [2], sans goupille.



Citizen M32 type VII-VIII Back Tools U152B  
=> Pos. T34-T37 avec 2 vis M6x35 [3], 2 vis M6x55 [4], goupille Ø8mm.

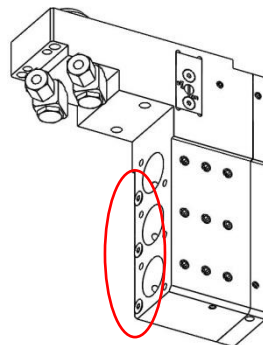


Citizen A32 Gang Tools U30B  
=> Pos. T10 avec 2 vis M5x30 [5], 1 vis M8x25 [6], goupille Ø10mm.

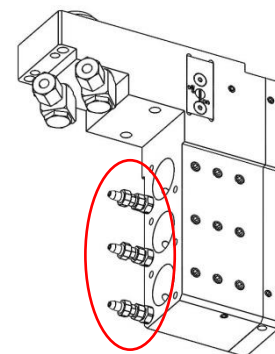


### 2. Système d'arrosage

Sans arrosage externe  
Bouchons M6



Avec arrosage externe  
Raccords et buses Hirt

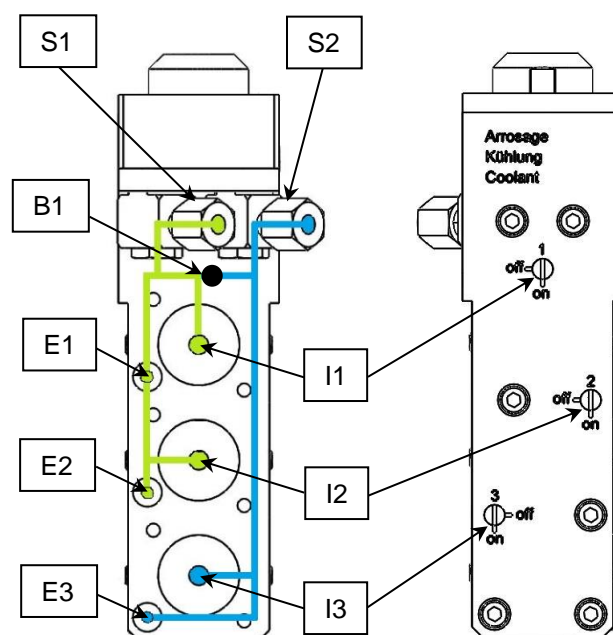


Système alimenté par deux raccords Ø6mm :

- S1 alimente les arrosages internes [I] et externes [E] 1 et 2.
- S2 alimente l'arrosage interne et externe 3.
- Les arrosages internes peuvent être coupés à l'aide des vannes manuelles à l'arrière du porte-outil.
- Si un seul des deux raccords S1 ou S2 est alimenté, les deux circuits peuvent être pontés avec la vanne [B1].



Pression max. pour l'arrosage interne : 200 bar  
Pression max. pour l'arrosage externe : 100 bar

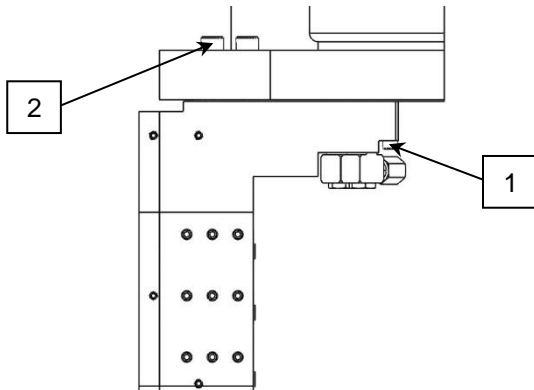


# GDF1502-IK

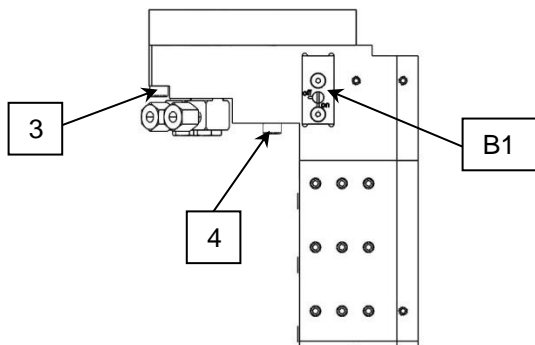
## English

### 1. Tool holder mounting

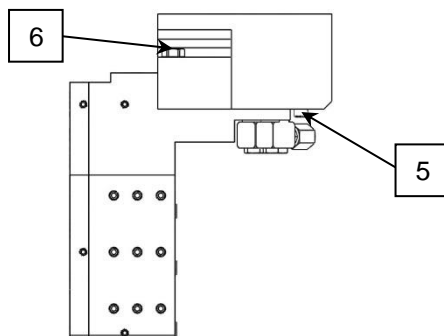
Citizen M32 type III-V-VII Gang Tools U34B  
=> Pos. T10 with 2 screw M5x30 [1], 3 screws M8x40 [2], without pin.



Citizen M32 type VII-VIII Back Tools U152B  
=> Pos. T34-T37 with 2 screws M6x35 [3], 2 screws M6x55 [4], pin Ø8mm.

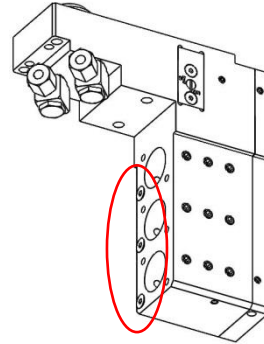


Citizen A32 Gang Tools U30B  
=> Pos. T10 with 2 screws M5x30 [5], 1 screw M8x25 [6], pin Ø10mm.

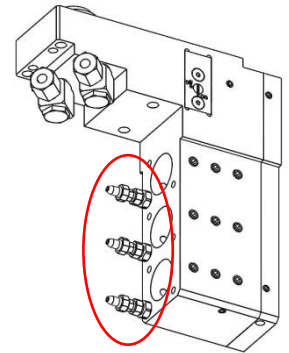


### 1. Coolant system

Without external coolant  
M6 plugs



With external coolant  
Fittings and nozzles Hirt

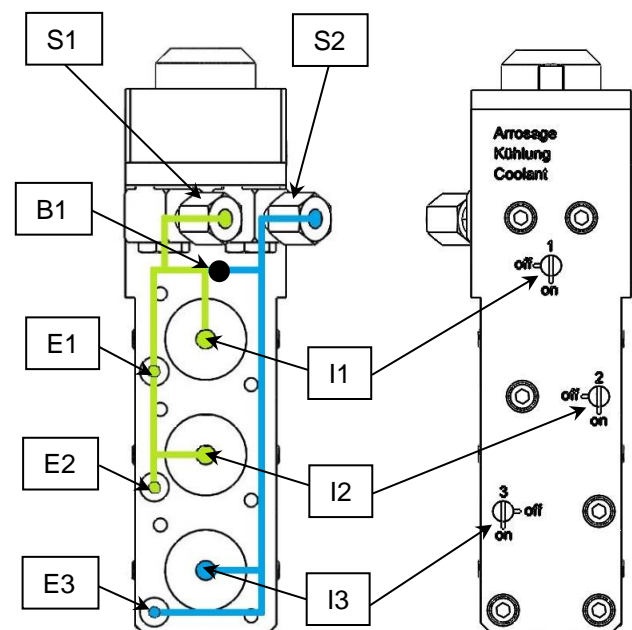


Coolant system is supplied by two Ø6mm unions :

- S1 supplies internal [I] and external [E] coolant 1 et 2.
- S2 supplies internal and external coolant 3.
- Internal coolant can be turned off with the manual valves in the back of the tool holder.
- If just one union is supplied by coolant, the two circuits can be combined with the manual valve [B1].



Max. pressure for internal coolant : 200 bar  
Max. pressure for external coolant : 100 bar

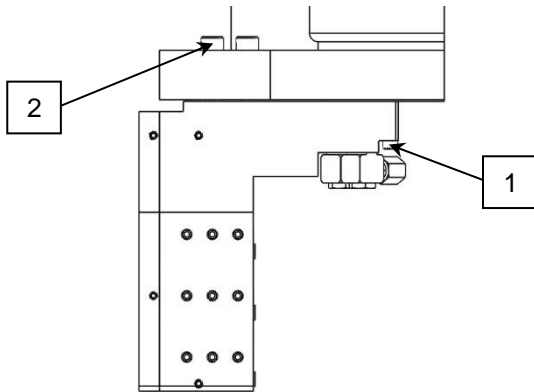


# GDF1502-IK

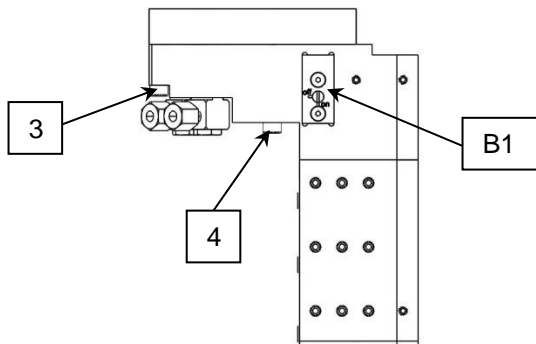
## Deutsch

### 1. Werkzeughalter Aufstellung

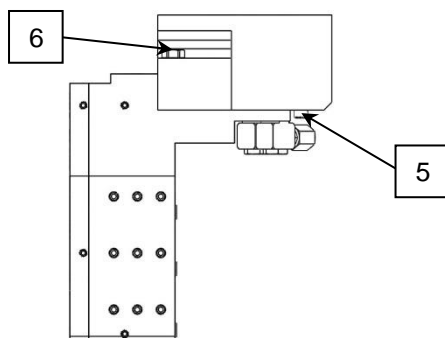
Citizen M32 type III-V-VII Gang Tools U34B  
=> Pos. T10 mit 2 Schrauben M5x30 [1], 3  
Schrauben M8x40 [2], keinen Stift.



Citizen M32 type VII-VIII Back Tools U152B  
=> Pos. T34-T37 mit 2 Schrauben M6x35 [3], 2  
Schrauben M6x55 [4], Stift Ø8mm.

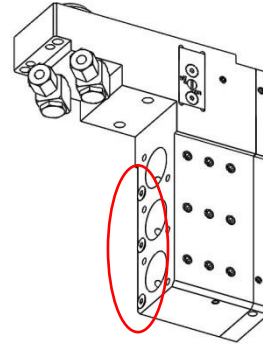


Citizen A32 Gang Tools U30B  
=> Pos. T10 mit 2 Schrauben M5x30 [5], 1  
Schraube M8x25 [6], Stift Ø10mm.

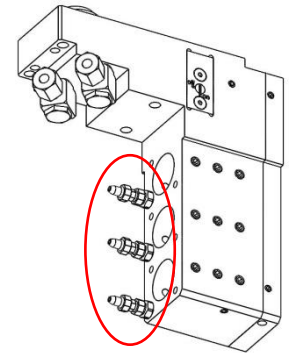


### 2. Kühlmittel

Ohne ausser Kühlung  
M6 Kappen



Mit ausser Kühlung  
Kupplungsstücke und Düsen von Hirt



Kühlungssystem durch zwei Anschlüsse :

- S1 versorgt inner [I] und ausser [E] Kühlung 1 und 2.
- S2 versorgt inner und ausser Kühlung 3.
- Inner Kühlungen können ausgeschaltet werden mit den Verschlüsse an der Rückseite des Werkzeugs.
- Wenn nur einen Anschluss (S1 oder S2) angeschlossen ist, die zwei Kühlsysteme können zusammengefügt werden mit dem Verschluss [B1].



Inner Kühlung : Maximaldruck = 200 bar  
Ausser Kühlung : Maximaldruck = 100 bar

