

ELECTRIC SPINDLE RUN-IN PROCEDURE

These is the correct run-in procedure in automatic cycle after the first installation on the machine with the system cooling connected, **with the tool-holder installed** and without applying load:

SPEED (rpm)	TIME (min.)	Δt (TRoom-TMotor)
3000	30'	max 10°C
6000	30'	max 10°C
12000	30'	max 20°C
15000	15'	max 20°C
18000	15'	max 20°C
24000	15'	max 20°C

The good result of that procedure will assure the correct grease distribution on the balls bearing and will allow a gradual increase of temperature of the bearings and therefore an equable thermal expansion of the bearings tracks.

Only for the HSK execution **do not run the electric spindle without the tool-holder installed.** Run the electric spindle HSK without tool-holder can get the electric spindle unbalanced and damage the clamping group HSK.