1) **Assembly of the Sealing Disk:** Insert the small diameter of the disk center into the center of the clamping nut and apply even finger pressure until the disk is properly seated and snaps into face of nut.

2) **Important:** The disk must be flush with the outside of the nut and the size marking on the disc face must be readable on the inside of the nut from the backside.

3) **Removing the Sealing Disk:** To remove the disk, simply press evenly on the outside face of the disk until it snaps out.
Assembly of ER-GB Collet and Clamping Nut

**Assembly:** Insert groove of collet into the eccentric ring of nut by tilting collet towards mark on bottom of nut. Then push collet towards opposite side of nut until it clicks into place. Hand screw nut with collet onto tap holder, then insert machine tap to proper seating depth. We recommend final tightening of the nut with torque wrench and tightening fixture.

**Disassembly:** After the nut assembly is unscrewed from the tap holder, press on the collet face while simultaneously pushing side ways on the back of the collet towards the mark on bottom of nut until it disengages from the clamping nut.
Torque Wrench Recommended for Tightening Clamping Nut

<table>
<thead>
<tr>
<th>Clamping Nut</th>
<th>Recommended Torque (Nm)</th>
<th>Maximum Torque (Nm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hi-Q/ERC 20</td>
<td>32 Nm</td>
<td>40 Nm</td>
</tr>
<tr>
<td>Hi-Q/ERC 32</td>
<td>90 Nm</td>
<td>113 Nm</td>
</tr>
<tr>
<td>Hi-Q/ERC 40</td>
<td>180 Nm</td>
<td>225 Nm</td>
</tr>
</tbody>
</table>

Important: Excessive tightening torque can result in permanent damage of the tap holder
Tightening Fixture Recommended for Assembly and Disassembly

Assembly device prevents wrench torque load on the clamping nut from damaging internal components of minimal length compensation system and collet body neck seal.

Assembly fixture supports holder body and neck.

Wrench Torque Protection:
1) Steel balls
2) Elastomer springs
3) Collet body neck seal
Alternative Assembly Method with 2 Wrenches

Incorrect Assembly

Correct Assembly
Preventive Maintenance

To insure proper performance of KSN Softsynchro tap holders, overall cleanliness of the tool holder, collet pocket, ER-GB collet, and clamping nut must be maintained on a regular basis before storage and assembly.

Any dirt, dust, oil, coolant residue, fine metal particles, chips, or other contaminants, left on the collet pocket, collet, clamping nut or shank, can cause poor runout.

- Do not use any aggressive solvent
- Do not use abrasive materials such as Scotch-Brite pads or steel wool.