

Tool Changing Block Instructions

Note: Instructions are for a typical Tool Changing Block. The tool holder and changing block shown may not look identical to your tool holder and changing block.

The tool changing blocks are designed to hold the tapered tool holders **BT 30, ISO 30, and HSK 63F** when mounting shapers, moulders, etc. (cutting tools). Listed below are the GLCT part numbers to order for the changing blocks.

Type of Tool Holder	Part Number
BT 30	955-10775-BT30
ISO 30	955-10775-ISO30
HSK 63F	955-10775-HSK63F

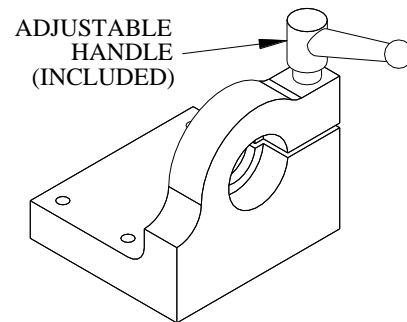
1. Great Lakes Custom Tool recommends the **use of safety glasses at all times.**
2. When cutter is mounted on the machine, be sure to follow **LockOut/TagOut** procedures and use all appropriate personal protection equipment.

Loading Tool Changing Block

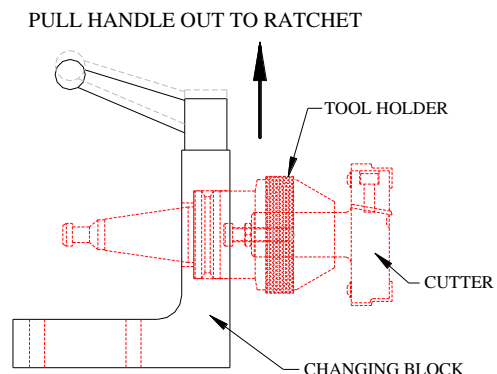
1. Bolt or securely fasten the changing block onto a sturdy table or work bench.
2. Place the tool holder **BT 30, ISO 30, or HSK 63F** with the taper into the Tool Changing Block. The straight portion of the tool holder beyond the taper will seat into the machined pocket in the changing block.
3. Clamp the tool holder in place by using the adjustable handle. Turn the handle clockwise (cw) to tighten. The handle has a ratchet type action. When facing the handle, pull back on the handle, this slides the handle axially towards you. While holding the handle up towards you, rotate the handle counter-clockwise (ccw) and then release the pressure. The handle will snap back into position. The handle can then be rotated clockwise to continue tightening. Continue this ratcheting type action until the tool holder is clamped tight in the block.
4. Mount cutting tool onto the tool holder following the instructions of the tool holder manufacturer. Fasten together securely. (Cutter already shown in tool holder)

Unloading Tool Changing Block

1. Loosen the clamp by turning the handle counter-clockwise. It may be necessary to ratchet the handle by pulling the handle towards you and then turning the handle clockwise to get another bite. Repeat until tool holder is loose.
2. Remove tool holder with tool.



TOOL CHANGING BLOCK



CHANGING BLOCK SHOWN WITH TOOL HOLDER AND CUTTER (SIDE VIEW)

