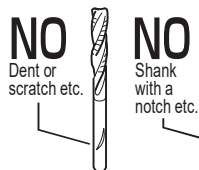


Thank you very much for purchasing NT products. This instruction manual provides the description of the correct usage and precautionary remarks on handling. Read this manual thoroughly and use the product in the correct manner.

⚠ Precautions on cutting tool shank

- Clean and remove all dust and oil on the cutting tool shank using waste cloth etc. Cutting tool slippage may occur if oil is remaining on the cutting tool shank.
- Dent or scratch on the cutting tool shank should be avoided.
- Cylindrical shank cutting tool only. Do not use a cutting tool with a notch.



Attaching And Removing The Cutting Tool

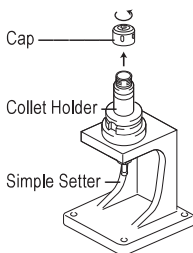
- ⚠ Do not touch tools with bare hands. When handling the tool, use a waste cloth or wear gloves.

- ⚠ Do not drop a collet holder when setting up or carrying it. It may result in injury.

1. Firmly fix the collet holder to NT's simple setter or a fixing jig. Attach a pull stud to the collet holder if necessary.

2. Remove the cap from the collet holder.

3. Clean the tool shank, collet, and the collet holder's inner bore and shank with a waste cloth.



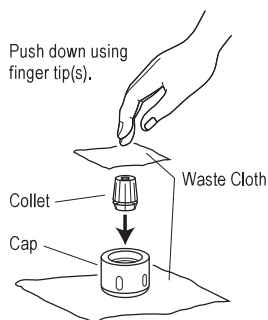
- ⚠ Please take care when handling a cap or collet to avoid cutting your finger(s) or hand(s) with sharp edges.

4. Lay a waste cloth on a leveled workbench and place a cap facedown.

5. Place a collet in the inner diameter of the cap. The wider side of the collet should be facing down.

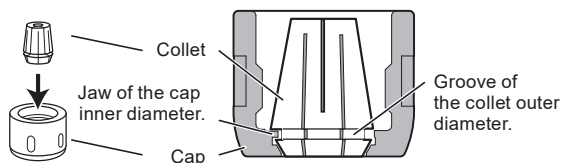
*To select a collet, please refer to "Parts, spanner and tightening torque chart".

6. Place a waste cloth on the narrower side of the collet. Push the collet down into the cap using your fingertip(s). Make sure the jaws of the cap and the groove of the collet are firmly fitted.



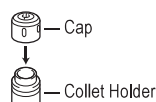
- ⚠ Never attach the cap to the collet holder if the jaws of the cap and groove of the collet are not firmly fitted. The collet may get stuck in the inner diameter of the collet holder even after the cap is removed.

- ⚠ Take care not to pinch your finger(s) between the cap and the collet.



7. Attach the cap to the collet holder. Slightly tighten the cap by hand.

8. Insert a cutting tool into collet.



- ⚠ The cutting tool shank must be inserted deeper than the length of the collet inner diameter. Insufficient insert length may result in deteriorated runout accuracy.

- ⚠ Never clamp the cutting edges with a collet. Inner diameter of the collet may be damaged.

9. When using a preset screw (sold separately) to adjust cutting tool projection length, please refer to the second half of this instruction manual.

10. Tighten the cap with NT's designated spanner (sold separately). *To select NT's designated spanner, please refer to the "Parts, spanner and tightening torque chart".

- ⚠ If any spanner other than NT's designated model is used, the cap and/or collet holder may be damaged.

11. To remove the cutting tool, fix the collet holder to NT's simple setter or a fixing jig, and reverse steps 10 and 8. To remove the cap, reverse step 7.

Parts, Spanner And Tightening Torque Chart

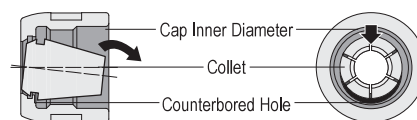
Holder size	Cap size	Collet size	Special spanner size (sold separately)	Recommended tightening torque
MDE11	MDEP-11	ER11	FK-0020	15~20Nm (117in/bf)
MDE16	MDEP-16	ER16	FK-0030	45~50Nm (442in/bf)
MDE20	MDEP-20	ER20	FK-0034	55~60Nm (531in/bf)
MDE25	MDEP-25	ER25	FK-0040	80~85Nm (752in/bf)
MDE32	MDEP-32	ER32	FK-0052	100~105Nm (885in/bf)

Removing The Collet

1. Clean the cap.

- ⚠ If the collet holder and its components are heavily contaminated with chips or debris, wash with wash oil and blow with compressed air.

2. Push and tilt the narrower side of the collet against the counterbored hole in the cap inner diameter. If the collet cannot be removed easily, rotate the collet while continuing to push and tilt it.



Adjust Cutting Tool Projection Length By Using A Preset Screw (Sold Separately)

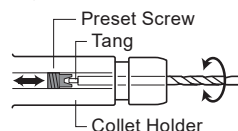
A preset screw is not included with MDE collet holders. Please purchased separately if necessary.

Install the preset screw in the threaded hole inside the collet holder (tighten clockwise).

- ⚠ Do not touch tools with bare hands. When handling the tool, use a waste cloth or wear gloves.

For cutting tool with a tang

Hold the cutting tool with waste cloth and turn the preset screw by using the tang.

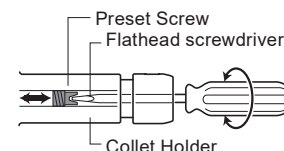


- Turn counterclockwise to extend the projection length of the cutting tool
- Turn clockwise to shorten the projection length of the cutting tool

Cutting tool without a tang

Remove the cutting tool from the collet holder. Turn the preset screw by using a flathead screwdriver.

- ⚠ Be careful not to damage inner diameter of the collet holder with the screwdriver when rotating the preset screw.



- Turn counterclockwise to extend the projection length of the cutting tool
- Turn clockwise to shorten the projection length of the cutting tool

If the collet holder and its components are heavily contaminated with chips or debris, wash with wash oil and blow with compressed air.

Holder size	Preset Screw size
MDE11	HDS-07A-ES11
MDE16	ES16
MDE20	HDS12A-ES20
MDE25	HDS16A-ES25
MDE32	HDS22A-ES32