RAMPA®
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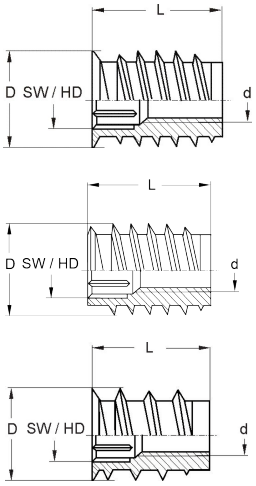
TYPE SKD330, SK330, SKD30

Assembling information RAMPA®-Inserts type SKD330 / SK330 / SKD30

The values in the table are applicable exclusively to **RAMPA®-Inserts** as listed below.

RAMPA®-Inserts | Type: SKD330, SK330, SKD30

Outer-Ø D (mm)	Threadsize d (mm)	Hex Drive	Steel zinc-plated
8	M4	4	✓
10	M5	5	✓
12	M6	6	✓
14	M8	8	✓
18,5	M10	10	✓



*1 For RAMPA inserts type SK330 applies: We hereby inform you according to Article 33 - REACH, that this article contains the following substance identified as SVHC: Lead (Pb); CAS: 7439-92-1 Date of Admission: 27.06.2018

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TYPE SKD330, SK330, SKD30

Assembling information RAMPA®-Inserts type SKD330 / SK330 / SKD30

Preparatory work:

- Outer-Ø D ≥ 12mm
- t= 2mm
- Tolerance range t_{tol1}
  D ≥12mm=+0,5mm

Preparatory work:

- Outer-Ø D ≤ 10mm
- t= 1mm
- Tolerance range t_{tol1}
  D ≤10mm=-0,5mm

Example: RAMPA®-Inserts | Type: SKD330 Art. No.: 420615001

- Standard pre-drill-Ø =**D - t = d → 12mm - 2mm = 10mm**
- Max./min. allowed-Ø = **D - (t-($t_{tol,1}$)) = d → 12mm - (2mm - (+0,5mm)) = 10,5mm**

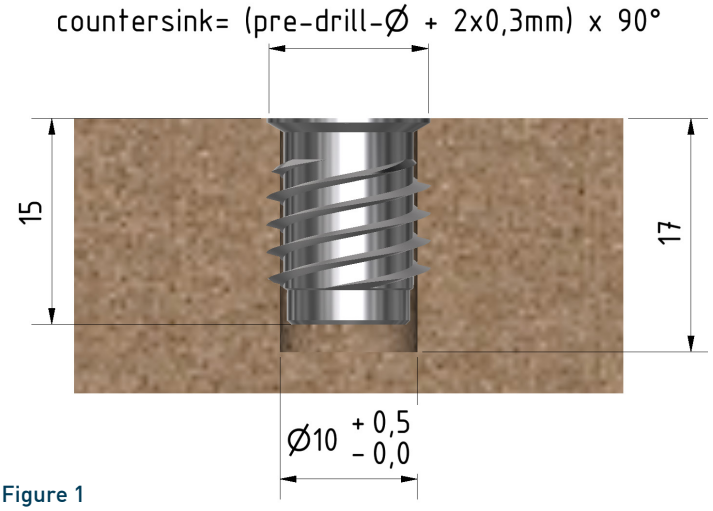

Figure 1
(The same applies to the inserts type SK330 without collar)

- Always use the minimum pre-drill-Ø for wood and wood materials.
- If any problem occurs during assembling process, the pre-drill-Ø can be adapted to the tolerance range $t_{tol,1}$ as mentioned above.
- As far as possible, drills in hardwoods (density < 500kg/m3) or plastics should have a countersink of s=min. 0,3mmx45°.
- Due to the very homogeneous mechanical properties, in plastics the highest permitted pre-drill-Ø can be used.
- The pre-drill-depth should be **t_{min} = total length of inserts + 2mm** (avoiding breaking through material).

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TYPE SKD330, SK330, SKD30

Assembling information RAMPA®-Inserts type SKD330 / SK330 / SKD30

Example: RAMPA®-Inserts | Type: SKD330 Art. No.: 420615001

- Outer-Ø D = 10mm
- Counterbore-Ø **(d_1) = D + (2 x s) → 10mm + (2 x 0,3mm) = 10,6mm**

Make sure that the pre-drilled hole is clean or free of chips.

Assembling:

The **RAMPA®-Inserts** must be completely put on the hexagon bit-socket (fig. 2) before starting the assembling process. For avoiding bulges, the inserts must be assembled in the pre-drilling with slight pressure (fig. 3). During processing, the screw-in speed should be increased step by step in order to have the best possible control over the screw-in depth.

- Assembling-speed =
  - SKD330: max. 175min^{-1}
  - SKD30: max. 250min^{-1}
  - SK330: max. 100min^{-1}

- The switch-off range of the assembling torque can be found in the relevant product data sheet from RAMPA GmbH & Co. KG. The indicated cut-off torques are guides that might vary.

Excessive cut-off torque can cause damage to the workpiece!

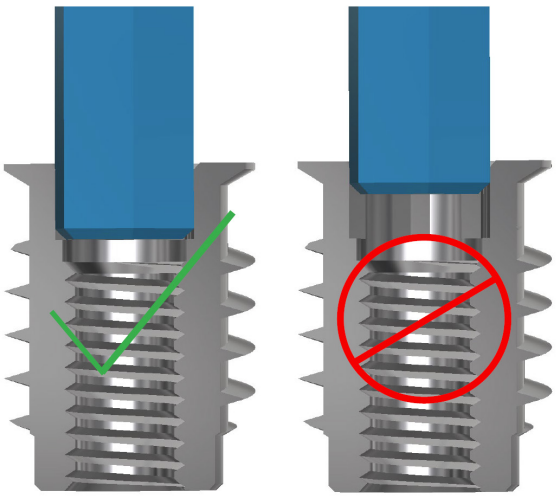

Figure 2
(The same applies to the inserts type SK330 without collar)

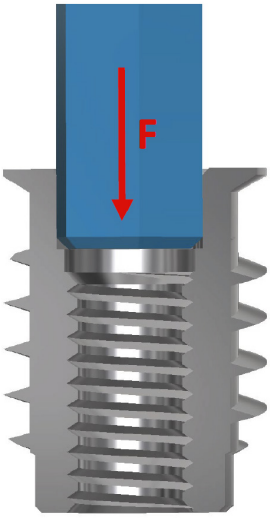

Figure 3
(The same applies to the inserts type SK330 without collar)

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