



Collet and Bit Maintenance for ALL Gerber Routing Systems

The two most important components of your Gerber routing system are the tool or bit that you use and the collet that holds it. If either of these components is neglected, the results of your finished product will be less than favorable. Here are a few tips for keeping your bits and collets working at peak performance.

Bits:

Solid carbide Gerber Gold bits are high quality tools. Being made of micro grain carbide they are extremely durable, but are also brittle. Misuse and/or mishandling will damage the tool and shorten its working life.

- ◆ Always store your Gerber Gold bits in their original factory containers. Bits left together in a drawer or toolbox will chip and fracture.
- ◆ Avoid excessive pressure when initializing tools. Too much pressure will chip the cutting edge resulting in poor plunging ability.
- ◆ Do not leave Gerber Gold bits in the collet when not in use. Immediately after use, remove the tool from the collet and return to the original container. This will prevent accidental damage to not only the tool, but material and the system as well.
- ◆ Always handle the bits with care. They are very sharp and are easily damaged if dropped.
- ◆ Always select a bit with a cutting edge length, or C.E.L., just slightly longer than the thickness of the material. Using a bit that is excessively longer than the thickness of the material will cause vibration during router operation and shorten the bit life.

Collets:

- ◆ Always use care when handling the router collets.
- ◆ Always ensure that bits are fully inserted into the collet. Collet damage will occur if bits are only partially inserted and tightened.
- ◆ Always ensure the collet is free from dirt and oil before use. During every tool change, remove the bit and clean the collet with compressed air to ensure maximum holding power. Dirt and material buildup in the slot will greatly reduce the holding power of the collet.
- ◆ Do not over tighten the bits in the collets.
- ◆ Avoid dropping collets, this can result in tiny fractures that reduce the holding power.
- ◆ Replace the collet if the tapered portion is rusted or pitted. Never attempt to clean the tapered portion by sanding or polishing it.

By following these few guidelines you will go a long way to increasing and maintaining peak performance from your Gerber routing system. If you have any questions please call the Gerber Service at 1-800-828-5406.

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