Clamping tools with HSK-A

Clamping tools with shanks and gripper elements in accordance with DIN 69893, Form HSK-A, are also suitable for manual tool changing along with automatic tool changing. They can be used not only directly in machining centres, but also combined manually. The uniform HSK shank form gives the HSK clamping tools a universal character.

The HSK clamping tool programme permits the selection of all the clamping elements necessary for fully equipping machining centres.

<table>
<thead>
<tr>
<th>Chucks</th>
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<tr>
<td>Chucks for cylindrical shanks with clamping surfaces</td>
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<tr>
<td>Chucks for collets</td>
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<tr>
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<td>Hydraulic chucks HydroChuck</td>
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<tr>
<td>Shrink chucks ThermoChuck</td>
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<td>Milling cutter arbors</td>
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<td>Tapping chucks</td>
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<td>Polygon chucks</td>
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Chucks for cylindrical shanks with lateral clamping surface in accordance with DIN 69882-4

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Dimensions in mm.
Chucks for cylindrical shanks with lateral drive area in accordance with DIN 69882-4
Shank HSK-A in accordance with DIN 69893-1

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Dimensions in mm.

Spare parts

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<th>For location bore d₁</th>
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<td>14</td>
<td>M12x14</td>
<td>30002947</td>
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</table>

Dimensions in mm.

Usage:
For mounting milling cutters and drills with cylindrical shank and lateral drive area in accordance with DIN 1835 Form B and in accordance with DIN 6535 Form HB. Supply includes:
Built-in clamping screw, does not include coolant tube.

Design:
Permissible run-out variation on the hollow taper shank in relation to the location bore d₁ = 0.003 mm. The bore tolerance is much tighter than DIN 1835 (d₁⁴) to obtain machining accuracies of the highest quality.

Note:
From location bore d₁ = 25 mm two clamping screws are provided. For coolant tubes see page 206.
Balancing quality: G 2.5 at 16,000 min⁻¹
Chucks for cylindrical shanks with angle clamping surface in accordance with DIN 69882-5
Shank HSK-A in accordance with DIN 69893-1

<table>
<thead>
<tr>
<th>Nominal size HSK-A</th>
<th>Dimensions</th>
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<th>Weight (kg)</th>
<th>Specification</th>
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<th>Order No. length adjustment screw</th>
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Dimensions in mm.

Clamping technology | Clamping tools with HSK-A
Chucks for cylindrical shanks with angle clamping surface in accordance with DIN 69882-5
Shank HSK-A in accordance with DIN 69893-1

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Dimensions in mm.

Spare parts

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<th>For location bore d₁</th>
<th>① Clamping screw in accordance with DIN 1835-B</th>
<th>② Clamping screw in accordance with DIN 1835-B</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Size</td>
<td>Order No.</td>
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<tr>
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</tr>
<tr>
<td>8</td>
<td>M8x9</td>
<td>10042517</td>
</tr>
<tr>
<td>10</td>
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</tr>
<tr>
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</tr>
<tr>
<td>14</td>
<td>M12x14</td>
<td>30002947</td>
</tr>
</tbody>
</table>

Dimensions in mm.

Usage:
For mounting milling cutters and drills with cylindrical shank and angled clamping surface (2°) in accordance with DIN 1835 Form E and DIN 6535 Form HE.

Supply includes:
Built-in clamping screw and length adjustment screw, does not include coolant tube.

Design:
Permissible run-out variation on the hollow taper shank in relation to the location bore d₁ = 0.003 mm. The bore tolerance is much tighter than DIN 1835 (d₁) to obtain machining accuracies of the highest quality.

Note:
From location bore d₁, 25 mm two clamping screws are provided.
The length adjustment screws have a through hole for coolant. For coolant tubes see page 206.

Balancing quality:
G 2.5 at 16,000 min⁻¹
Chucks for collets
in accordance with DIN 69882–6
Shank HSK-A in accordance with DIN 69893–1

Supply includes:
Complete with clamping nut in accordance with ISO 15488,
does not include length adjustment screw, coolant tube or collet.

Design:
Permissible run-out variation on the hollow taper shank in relation
to the internal taper 0.003 mm.

Spare parts

<table>
<thead>
<tr>
<th>For nominal size HSK-A</th>
<th>Length adjustment screw (with through hole for coolant) clamping diameter</th>
<th>Clamping nut in accordance with ISO 15488</th>
</tr>
</thead>
<tbody>
<tr>
<td>ø 2.8 – 5 Order No.</td>
<td>ø 4.8 – 7 Order No.</td>
<td>Nominal size Order No.</td>
</tr>
<tr>
<td>50, 63</td>
<td>30326191</td>
<td>ER-16 10013273</td>
</tr>
<tr>
<td>80, 100</td>
<td>30326201</td>
<td>ER-16 10013273</td>
</tr>
</tbody>
</table>

Dimensions in mm.

Note:
Chucks have a through hole with internal thread for length adjustment screws.
For suitable collets and tapping collets see page 208–213.
For coolant tubes see page 206.
For assembly tools see page 233.
Balancing quality:
G 2.5 at 16,000 min⁻¹

<table>
<thead>
<tr>
<th>Nominal size HSK-A</th>
<th>Clamping range</th>
<th>Nominal size</th>
<th>Dimensions</th>
<th>G</th>
<th>Weight kg</th>
<th>Specification</th>
<th>Order No.</th>
</tr>
</thead>
<tbody>
<tr>
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<td>ER-16</td>
<td>28 – 100 – 10 27</td>
<td>M10</td>
<td>0,5</td>
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<td>M10</td>
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<td>30319273</td>
</tr>
<tr>
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<td>0,5–10</td>
<td>ER-16</td>
<td>28 – 100 – 10 27</td>
<td>M12</td>
<td>1,2</td>
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</tr>
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<td>ER-16</td>
<td>28 45 160 85 10 27</td>
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<td>ER-16</td>
<td>28 – 100 – 10 27</td>
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</table>

Dimensions in mm.
## Chucks for collets
in accordance with DIN 69882–6
Shank HSK-A in accordance with DIN 69893–1

![Diagram of chuck design](image)

### Dimensions in mm.

<table>
<thead>
<tr>
<th>Nominal size HSK-A</th>
<th>Clamping range</th>
<th>Nominal size</th>
<th>Dimensions</th>
<th>G</th>
<th>Weight kg</th>
<th>Specification</th>
<th>Order No.</th>
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</thead>
<tbody>
<tr>
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<td>1,6</td>
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<td>2,2</td>
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<td>2,5</td>
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<td>3-26 ER-40</td>
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<td>3,1</td>
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</table>

### Spare parts

<table>
<thead>
<tr>
<th>For nominal size HSK-A</th>
<th>Clamping range</th>
<th>(\text{Ι}) Length adjustment screw (with through hole for coolant) clamping diameter</th>
<th>(\text{Ω}) Clamping nut in accordance with ISO 15488</th>
</tr>
</thead>
<tbody>
<tr>
<td>(d_1) l_1 l_2 l_3</td>
<td>Order No.</td>
<td>Order No.</td>
<td>Order No.</td>
</tr>
<tr>
<td>(\phi 3.8 - 7)</td>
<td>30326213</td>
<td>30326214</td>
<td>30326215</td>
</tr>
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<td>(\phi 6.8 - 10)</td>
<td>30326213</td>
<td>30326214</td>
<td>30326215</td>
</tr>
<tr>
<td>(\phi 9.8 - 13)</td>
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<td>30326214</td>
<td>30326215</td>
</tr>
<tr>
<td>(\phi 12.8 - 20)</td>
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<td>(\phi 19.9 - 26)</td>
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<td>30326215</td>
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</tbody>
</table>

### Dimensions in mm.

### Supply includes:
Complete with clamping nut in accordance with ISO 15488, does not include length adjustment screw, coolant tube or collet.

### Design:
Permissible run-out variation on the hollow taper shank in relation to the internal taper 0.003 mm.

### Note:
Chucks have through holes with internal thread for length adjustment screw. For suitable collets and tapping collets see page 208–213. For coolant tubes see page 206. For assembly tools see page 233. Balancing quality: \(G\ 2.5\) at 16,000 \(\text{min}^{-1}\).
Chucks for collets with clamping nut for internal coolant supply (HI-Q/ERC)
Shank HSK-A in accordance with DIN 69893-1

<table>
<thead>
<tr>
<th>Nominal size HSK-A</th>
<th>Clamping range</th>
<th>Nominal size</th>
<th>Dimensions</th>
<th>G</th>
<th>Weight (kg)</th>
<th>Specification</th>
<th>Order No.</th>
</tr>
</thead>
<tbody>
<tr>
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<td>0,5-10</td>
<td>ER-16</td>
<td>28 - 105 - 10 - 32</td>
<td>M10</td>
<td>1,2</td>
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</tr>
<tr>
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<td>0,5-10</td>
<td>ER-16</td>
<td>28 - 105 - 10 - 32</td>
<td>M10</td>
<td>1,0</td>
<td>MCC-HSK-A063-16-105-1-0-A</td>
<td>30319279</td>
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<tr>
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<td>0,5-10</td>
<td>ER-16</td>
<td>28 45 165 90 10 32</td>
<td>M10</td>
<td>1,4</td>
<td>MCC-HSK-A063-16-165-1-0-A</td>
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</tr>
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<td>0,5-10</td>
<td>ER-16</td>
<td>28 - 105 - 10 - 32</td>
<td>M12</td>
<td>1,7</td>
<td>MCC-HSK-A080-16-105-1-0-A</td>
<td>30319281</td>
</tr>
<tr>
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<td>0,5-10</td>
<td>ER-16</td>
<td>28 45 165 90 10 32</td>
<td>M12</td>
<td>1,9</td>
<td>MCC-HSK-A080-16-165-1-0-A</td>
<td>30319282</td>
</tr>
<tr>
<td>100</td>
<td>0,5-10</td>
<td>ER-16</td>
<td>28 - 105 - 10 - 32</td>
<td>M12</td>
<td>2,3</td>
<td>MCC-HSK-A100-16-105-1-0-A</td>
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</tr>
<tr>
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<td>0,5-10</td>
<td>ER-16</td>
<td>28 45 165 90 10 32</td>
<td>M12</td>
<td>2,6</td>
<td>MCC-HSK-A100-16-165-1-0-A</td>
<td>30319284</td>
</tr>
</tbody>
</table>

Dimensions in mm.

Spare parts

<table>
<thead>
<tr>
<th>For nominal size HSK-A</th>
<th>① Length adjustment screw (with through hole for coolant) clamping diameter</th>
<th>② Clamping nut HI-Q / ERC in accordance with ISO 15488</th>
</tr>
</thead>
<tbody>
<tr>
<td>50, 63</td>
<td>2.8 - 5 Ø Order No.</td>
<td>4.8 - 7 Ø Order No.</td>
</tr>
<tr>
<td>80, 100</td>
<td>30326191</td>
<td>30326192</td>
</tr>
<tr>
<td>80, 100</td>
<td>30326201</td>
<td>30326202</td>
</tr>
</tbody>
</table>

Dimensions in mm.

Supply includes:
Complete with clamping nut for internal coolant supply (HI-Q/ERC), does not include sealing disc, length adjustment screw, coolant tube or collet.

Design:
Permissible run-out variation on the hollow taper shank in relation to the internal taper 0.003 mm.

Note:
Chucks have a through hole with internal thread for length adjustment screws. For suitable collets, tapping collets and sealing discs for internal coolant supply see page 208-215. For coolant tubes see page 206. For assembly tools see page 233. Balancing quality: G 2.5 at 16,000 min⁻¹
Chucks for collets with clamping nut for internal coolant supply (HI-Q/ERC)

Shank HSK-A in accordance with DIN 69893-1

Supply includes:
Complete with clamping nut for internal coolant supply (HI-Q/ERC), does not include sealing disc, length adjustment screw, coolant tube or collet.

Design:
Permissible run-out variation on the hollow taper shank in relation to the internal taper 0.003 mm.

Note:
Chucks have through holes with internal thread for length adjustment screw. For suitable collets, tapping collets and sealing discs for internal coolant supply see page 208-215. For coolant tubes see page 206. For assembly tools see page 233. Balancing quality: G 2.5 at 16,000 min⁻¹
**HighTorque Chuck – for high torque transmission**

With axial tool length adjustment  
Shank HSK-A in accordance with DIN 69893-1

<table>
<thead>
<tr>
<th>Nominal size</th>
<th>Dimensions G</th>
<th>Weight</th>
<th>Specification</th>
<th>Order No.</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>d1</td>
<td>d2</td>
<td>d3</td>
<td>l1</td>
</tr>
<tr>
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<td>6</td>
<td>32</td>
<td>50</td>
<td>80</td>
</tr>
<tr>
<td>63</td>
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</tr>
<tr>
<td>63</td>
<td>18</td>
<td>44</td>
<td>52,5</td>
<td>95</td>
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<td>20</td>
<td>48</td>
<td>52,5</td>
<td>100</td>
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<tr>
<td>63</td>
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</tr>
<tr>
<td>63</td>
<td>32</td>
<td>63</td>
<td>53</td>
<td>125</td>
</tr>
</tbody>
</table>

Dimensions in mm.

**Usage:**
For clamping tools with smooth cylindrical shanks in accordance with DIN 1835 Form A and DIN 6535 Form HA up to ø 32 mm as well as with recesses in accordance with DIN 1835 Form B, E and DIN 6535 Form HB, HE directly and without intermediate sleeve in the clamping diameter.

The clamping diameter is designed for a shank tolerance of h6.

**Supply includes:**
- Complete with length adjustment screw, does not include coolant tube.
- Includes hexagonal T-key, does not include coolant tube.
- Balancing quality: G 2.5 at 25,000 min⁻¹
Hydraulic chuck HydroChuck in accordance with DIN 69882–7
With radial tool length adjustment
Shank HSK-A in accordance with DIN 69893-1

<table>
<thead>
<tr>
<th>Nominal size HSK-A</th>
<th>Dimensions</th>
<th>Weight kg</th>
<th>Specification Order No.</th>
</tr>
</thead>
<tbody>
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<td>l₃, l₄</td>
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<tr>
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<td>6</td>
<td>26</td>
<td>33,5</td>
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<td>28</td>
<td>33,5</td>
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<td>10</td>
<td>30</td>
<td>33,5</td>
</tr>
<tr>
<td>40</td>
<td>12</td>
<td>32</td>
<td>33,5</td>
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<td>32</td>
<td>64</td>
<td>52,5</td>
</tr>
</tbody>
</table>

Dimensions in mm.

Continued on next page.
Hydraulic chuck HydroChuck in accordance with DIN 69882–7
With radial tool length adjustment
Shank HSK-A in accordance with DIN 69893-1

Nominal size
<table>
<thead>
<tr>
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<th>d₁</th>
<th>d₂</th>
<th>d₃</th>
<th>l₁</th>
<th>l₂ max.</th>
<th>l₃</th>
<th>l₄</th>
</tr>
</thead>
<tbody>
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<td>33</td>
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<td>28</td>
<td>63</td>
<td>85</td>
<td>37</td>
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<td>33</td>
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<td>30</td>
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<td>40</td>
<td>63</td>
<td>100</td>
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<td>75</td>
<td>115</td>
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<tr>
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Dimensions in mm.

Usage:
For clamping tools with smooth cylindrical shanks in accordance with DIN 6535 Form A,
DIN 6535 Form HA up to ø 32 mm as well as with recesses in accordance with DIN 1835
Form B, E and DIN 6535 Form HB, HE directly and without intermediate sleeve in the
clamping diameter.
The clamping diameter is designed for a tool tolerance of h6.

Supply includes:
Complete with radial length adjustment, does not include coolant tube.
Includes hexagonal T-key.

Design:
Longest tool lives and highest manufacturing quality on usage of smooth cylindrical
shanks in accordance with DIN 1835 Form A and DIN 6535 Form HA.
With a projection length of 2.5 x d (max. 50 mm) radial run-out accuracy 0.003 mm.
On usage of cylindrical shanks with angled clamping surface (Form E and Form HE) the
accuracy may be affected.

Note:
Chuck with radial tool length adjustment. Coolant supply via central through-bore.
For intermediate sleeve for reducing the clamping diameter see page 216-218.
(The accuracy may be affected on the usage of the intermediate sleeve.)
For coolant tubes see page 206.
Balancing quality:
G 2.5 at 16,000 min⁻¹
Hydraulic chuck HydroChuck in accordance with DIN 69882–7

With axial tool length extension
Shank HSK-A in accordance with DIN 69893–1

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Dimensions in mm.

Dimensions in mm. Continued on next page.
Hydraulic chuck HydroChuck in accordance with DIN 69882–7
With axial tool length extension
Shank HSK-A in accordance with DIN 69893-1

Dimensions in mm.

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Hydraulic chuck HydroChuck in accordance with DIN 69882–7
With axial tool length extension
Shank HSK-A in accordance with DIN 69893-1

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<th>Nominal size HSK-A</th>
<th>Dimensions</th>
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| 100               | 12 32 50 95 46 10 47 | M10x1 | 2,5 | MHC-HSK-A100-12-095-1-0-A | 30251027
| 100               | 14 34 50 95 46 10 47 | M10x1 | 2,5 | MHC-HSK-A100-14-095-1-0-A | 30251028
| 100               | 16 38 50 100 49 10 53 | M12x1 | 2,6 | MHC-HSK-A100-16-100-1-0-A | 30251029
| 100               | 18 40 50 100 49 10 53 | M12x1 | 2,6 | MHC-HSK-A100-18-100-1-0-A | 30251030
| 100               | 20 42 50 105 51 10 59 | M16x1 | 2,7 | MHC-HSK-A100-20-105-1-0-A | 30251031
| 100               | 25 57 63 110 57 10 62 | M16x1 | 3,3 | MHC-HSK-A100-25-110-1-0-A | 30251032
| 100               | 32 63 67 110 61 10 60 | M16x1 | 3,5 | MHC-HSK-A100-32-110-1-0-A | 30251033

Dimensions in mm.

Usage:
For clamping tools with smooth cylindrical shanks in accordance with DIN 6535 Form A, DIN 6535 Form HA up to ø 32 mm as well as with recesses in accordance with DIN 1835 Form B, E and DIN 6535 Form HB, HE directly and without intermediate sleeve in the clamping diameter.

The clamping diameter is designed for a shank tolerance of h6.

Supply includes:
Complete with length adjustment screw, does not include coolant tube.
Includes hexagonal T-key.

Design:
Longest tool lives and highest manufacturing quality on usage of smooth cylindrical shanks in accordance with DIN 1835 Form A and DIN 6535 Form HA.
With a projection length of 2.5 x d (max. 50 mm) radial run-out accuracy 0.003 mm.
On usage of cylindrical shanks with angled clamping surface (Form E and Form HE) the accuracy may be affected.

Note:
Chuck with axial tool length adjustment. Coolant supply via central through-bore.
For intermediate sleeve for reducing the clamping diameter see page 216-218.
(The accuracy may be affected on the usage of the intermediate sleeve).
For coolant tubes see page 206.
Balancing quality: G 2.5 at 16,000 min⁻¹
Hydraulic chucks HydroChuck

With axial tool length extension
Shank HSK-A in accordance with DIN 69893-1

![Diagram of hydraulic chuck](image)

**Short heavy-duty design**

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<th>Dimensions</th>
<th>G</th>
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Dimensions in mm.

**Usage:**
For clamping tools with smooth cylindrical shanks in accordance with DIN 6535 Form A, DIN 6535 Form HA up to ø 32 mm as well as with recesses in accordance with DIN 1835 Form B, E and DIN 6535 Form HB, HE directly and without intermediate sleeve in the clamping diameter.

The clamping diameter is designed for a shank tolerance of h6.

**Supply includes:**
Complete with length adjustment screws, does not include coolant tube. Includes hexagonal T-key.

**Design:**
Longest tool lives and highest manufacturing quality on usage of smooth cylindrical shanks in accordance with DIN 1835 Form A and DIN 6535 Form HA.

With a projection length of 2.5 x d (max. 50 mm) radial run-out accuracies 0.0003 mm.

On usage of cylindrical shanks with angled clamping surface (Form E and Form HE) the accuracy may be affected.

**Note:**
Chuck with axial tool length adjustment. Coolant supply via central through-bore. For intermediate sleeve for reducing the clamping diameter see page 216-218. (The accuracy may be affected on the usage of the intermediate sleeve). For coolant tubes see page 206.

Balancing quality:
G 2.5 at 16,000 min⁻¹
Shrink chucks ThermoChuck in accordance with DIN 69882-8
Shank HSK-A in accordance with DIN 69893-1

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Dimensions in mm.

Dimensions in mm. Continued on next page.
## Shrink chucks ThermoChuck in accordance with DIN 69882-8

Shank HSK-A in accordance with DIN 69893-1

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Dimensions in mm.
## Shrink chucks ThermoChuck in accordance with DIN 69882-8

Shank HSK-A in accordance with DIN 69893-1

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Shrink chucks ThermoChuck in accordance with DIN 69882-8
Shank HSK-A in accordance with DIN 69893-1

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Dimensions in mm.
## Shrink chucks ThermoChuck in accordance with DIN 69882-8
Shank HSK-A in accordance with DIN 69893-1

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Dimensions in mm.
### Shrink chucks ThermoChuck in accordance with DIN 69882-8

Shank HSK-A in accordance with DIN 69893-1

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**Note:**

- For coolant tubes see page 206.
- For tool extensions see page 220.
- Length adjustment screw and fine balancing screws available on request.
- For notes on the coding system see technical notes.

**Balancing quality:**

G 2.5 at 16,000 min⁻¹
Shrink chuck ThermoChuck similar to DIN 69882–8
Shank HSK-A in accordance with DIN 69893-1

Supply includes:
Built-in length adjustment screw with through hole, does not include fine balancing screws or coolant tube.
Includes hexagonal T-key.

Design:
Standard design with two cooling duct bores.
Other cooling duct bores on request.
Permissible run-out variation on the hollow taper shank in relation to the clamping diameter \( d_1 = 0.003 \) mm.
The clamping diameter is designed for a shank tolerance of h6.

Dimensions in mm.

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<th>Nominal size HSK-A</th>
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Note:
For coolant tubes see page 206.
For tool extensions see page 220.
Length adjustment screw and fine balancing screws available on request.
For notes on the coding system see technical notes.
Balancing quality:
G 2.5 at 16,000 min⁻¹
Clamping technology | Clamping tools with HSK-A

Milling cutter arbors for milling cutters with longitudinal or cross slot in accordance with DIN 69882-2
Shank HSK-A in accordance with DIN 69893-1

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Dimensions in mm.

Supply includes:
Milling cutter clamping screw, feather key with jacking thread and driving ring, does not include coolant tube.

Design:
Permissible run-out variation on the hollow taper shank in relation to the arbor d1 = 0.008 mm.

Note:
Milling adapter rings in accordance with DIN 2084 on request.
For coolant tubes see page 206.
For assembly tools see page 233.
Balancing quality:
G 2.5 at 16,000 min⁻¹
Milling cutter arbors for milling cutters with longitudinal or cross slot in accordance with DIN 69882-2
Shank HSK-A in accordance with DIN 69893-1

Spare parts

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<th>For arbor diameter $d_1$</th>
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Dimensions in mm.
### Milling cutter arbors with enlarged face connection diameter in accordance with DIN 69882-3

Shank HSK-A in accordance with DIN 69893-1

#### Table: Dimensions, Weight, and Specifications

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<td>30329276</td>
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</tr>
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</table>

Dimensions in mm.

#### Notes:

- **Supply includes:**
  1. Key blocks attached and milling cutter clamping screw in accordance with DIN 6367.
  2. Key blocks attached, does not include milling cutter clamping screw.
  Does not include coolant tube.
- **Design:**
  Permissible run-out variation on the hollow taper shank in relation to the arbor \( d_2 \) = 0.008 mm.
  6 balancing bores on the periphery.
- **Note:**
  The sizes marked with * have 4 additional threaded bores for mounting cutter heads with tool fastening in accordance with DIN 2079.
  **\( *d_1 = 60 \) mm for nominal size HSK-A 63:**
  Max. milling head diameter D 250 mm, no balancing bores on the periphery.
  For assembly tools see page 233.
  For coolant tubes see page 206.
  Balancing quality:
  G 2.5 at 16,000 min\(^{-1}\)

---

62
Milling cutter arbors with enlarged face connection diameter in accordance with DIN 69882-3

Spare parts

<table>
<thead>
<tr>
<th>For arbor diameter d₁</th>
<th>¹ Milling cutter clamping screw in accordance with DIN 6367</th>
<th>² Milling cutter pull screw with internal coolant supply (e.g. for MAPAL WWS milling)</th>
<th>³ Key block (2x)</th>
<th>⁴ Fastening screw in accordance with ISO 4762 (2x)</th>
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</thead>
<tbody>
<tr>
<td>22</td>
<td>M10</td>
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<td>10005164</td>
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<td>M24</td>
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<td>10017544</td>
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Dimensions in mm.
**Precision-Drill Chuck**

Shank HSK-A in accordance with DIN 69893-1 without internal coolant supply

<table>
<thead>
<tr>
<th>Nominal size HSK-A</th>
<th>Clamping range d₁</th>
<th>Dimensions d₂ l₁ l₂</th>
<th>Weight kg</th>
<th>Spare parts Code</th>
<th>Specification</th>
<th>Order No.</th>
</tr>
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<tbody>
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<tr>
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</table>

Dimensions in mm.

**Usage:**
For clamping tools with smooth cylindrical shanks.
Supply includes:
Does not include sealing disc or coolant tube.
Includes hexagonal T-key.

**Design:**
No internal coolant supply.

**Note:**
You will find spare parts and accessories via the spare part code on page 222-223.
**Precision-DrillChuck**

Shank HSK-A in accordance with DIN 69893-1 with internal coolant supply

![Drill Chuck Diagram](image)

<table>
<thead>
<tr>
<th>Nominal size HSK-A</th>
<th>Clamping range</th>
<th>Dimensions</th>
<th>Weight kg</th>
<th>Spare parts Code</th>
<th>Specification</th>
<th>Order No.</th>
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<tbody>
<tr>
<td></td>
<td>d₁</td>
<td>d₂, l₁, l₂</td>
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Dimensions in mm.

**Usage:**
For clamping tools with smooth cylindrical shanks.

**Supply includes:**
Does not include sealing disc or coolant tube.
Includes hexagonal T-key.

**Design:**
With central coolant supply.

**Note:**
You will find spare parts and accessories via the spare part code on page 222-223.
### Precision-DrillChuck

**Shank HSK-A in accordance with DIN 69893-1 with internal coolant supply**

![DrillChuck Diagram](image)

<table>
<thead>
<tr>
<th>Nominal size HSK-A</th>
<th>Clamping range d1</th>
<th>Dimensions d2 l1 l2</th>
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<th>Order No.</th>
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<tr>
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</tbody>
</table>

**Dimensions in mm.**

**Usage:**
For clamping tools with smooth cylindrical shanks.

**Supply includes:**
Complete, does not include coolant tube.
Includes hexagonal T-key.

**Design:**
With central coolant supply and decentral coolant outlet for tools without coolant ducts.

**Note:**
You will find spare parts and accessories via the spare part code on page 222-223.
Softsynchro tapping chucks
Shank HSK-A in accordance with DIN 69893-1

Clamping technology | Clamping tools with HSK-A

Usage:
For clamping tap drills quickly and securely.
For compensating for any differences in pitch between the synchronous spindle and the tap drill.
Supply includes:
Complete with clamping nut for internal coolant supply and open-ended wrench.
Does not include collet, sealing disc or coolant tube.
Design:
With internal coolant supply.

Note:
Further designs on request.
For suitable tapping collets and sealing discs for internal coolant supply see page 210-213.
For coolant tubes see page 206.
For open-ended wrench see page 233.

<table>
<thead>
<tr>
<th>Nominal size HSK-A</th>
<th>For tap drill</th>
<th>Clamping range</th>
<th>Nominal size</th>
<th>Dimensions</th>
<th>Weight kg</th>
<th>Specification</th>
<th>Order No.</th>
</tr>
</thead>
<tbody>
<tr>
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<td>4,5 - 10</td>
<td>1-13 ER 20 (GB)</td>
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<td>M12 - M30</td>
<td>7 - 22</td>
<td>3-26 ER 40 (GB)</td>
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</tbody>
</table>

Dimensions in mm.
Polygon chucks TRIBOS-S

With axial tool length extension
for fine and light machining
Shank HSK-A in accordance with DIN 69893-1

Usage:
For fine and light machining. For clamping cylindrical shanks Form HA, HB, HE in accordance with DIN 6535.

Supply includes:
Length adjustment screw, does not include coolant tube.

Note:
For intermediate sleeves for clamping diameter reduction see page 219.
For tool extensions see page 228.
For necessary clamping fixture see page 238.
For reducing sleeves for clamping fixture see page 239.
For coolant tube see page 206.
Balancing quality:
HSK-A 63: G 2.5 at 16,000 min⁻¹

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Dimensions in mm.
### Polygon chucks TRIBOS-R

With axial tool length extension for heavy machining

Shank HSK-A in accordance with DIN 69893-1

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*Dimensions in mm.*
Polygon chucks TRIBOS-R
With axial tool length extension for heavy machining
Shank HSK-A in accordance with DIN 69893-1

Usage:
For heavy machining. For clamping cylindrical shanks
Form HA, HB, HE in accordance with DIN 6535.
Supply includes:
Complete with length adjustment screw.

Note:
For intermediate sleeves for clamping diameter reduction see page 219.
For tool extensions see page 228.
For necessary clamping fixture see page 238.
For reducing sleeves for clamping fixture see page 240.
For coolant tube see page 206.
Balancing quality:
G 2.5 at 16,000 min⁻¹

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Dimensions in mm.
HFS replaceable head holders with axial clamping system
Shank HSK-A in accordance with DIN 69893-1

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Dimensions in mm.

Supply includes:
Tool holder with threaded spindle, does not include coolant supply or hexagonal T-key.
Does not include coolant tube.

Note:
For coolant tube and assembly tools see page 206
For accessories and spare parts see page 225.
For assembly tools see page 231-235.
Balancing quality:
G 6.3 at 3,000 min⁻¹
HFS replaceable head holders with radial clamping system
Shank HSK-A in accordance with DIN 69893-1

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Dimensions in mm.

Supply includes:
Tool holder with pull stud, hexagonal T-key and open-ended wrench for pull stud. Does not include coolant tube.

Recommendation:
To make it possible to change reamers quickly using the radial clamping system, at least 1 additional pull stud should be ordered.

Note:
For coolant tube see page 206.
(not included).
For accessories, spare parts and assembly tools see page 225 and page 231-235.

Balancing quality:
G 6.3 at 3,000 min⁻¹
CFS replaceable head holders
CFS 101 (cylindrical design) with CFS connection, shank HSK-A in accordance with DIN 69893-1 with internal coolant supply

![Diagram of CFS replaceable head holders]

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Dimensions in mm.
HSK extensions
Shank HSK-A in accordance with DIN 69893-1

Supply includes:
Standard KS clamping cartridge. Complete with clamping cartridge and stop ring, does not include coolant tube.

Design:
Permissible run-out variation on the hollow taper shank in relation to the internal taper = 0.005 mm.

Note:
For clamping cartridges see section on manual HSK clamping units from page 19. For stop rings see page 202. For coolant tubes see page 206.

Balancing quality:
G 6.3 at 3,000 min⁻¹

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Dimensions in mm.
HSK reducers
Shank HSK-A in accordance with DIN 69893-1

Supply includes:
Complete with standard KS clamping cartridge and stop ring,
does not include coolant tube.

Design:
Permissible run-out variation on the hollow taper shank in relation
to the internal taper = 0.005 mm.

Dimensions in mm.

<table>
<thead>
<tr>
<th>Nominal size HSK-A</th>
<th>HSK-C d₁</th>
<th>Dimensions d₂</th>
<th>l₁</th>
<th>l₂</th>
<th>Weight kg</th>
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Note:
For clamping cartridges see section on manual HSK clamping units from page 19.
For stop rings see page 202.
For coolant tubes see page 206.
Balancing quality:
G 6.3 at 3,000 min⁻¹
HSK adapters
Shank HSK-A in accordance with DIN 69893-1

<table>
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<tr>
<th>Nominal size HSK-A</th>
<th>Module diameter D</th>
<th>Dimensions</th>
<th>Weight kg</th>
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Dimensions in mm.

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Dimensions in mm.

Supply includes:
Complete with threaded pins for aligning the radial run-out, do not include coolant tube.

Note:
For coolant tubes see page 206.
Balancing quality:
G 6.3 at 3,000 min⁻¹
**HSK blanks**

**Shank HSK-A in accordance with DIN 69893-1**

<table>
<thead>
<tr>
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<th>Dimensions</th>
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</table>

Dimensions in mm.

**Design 1:**
- Rough turned and milled.
- In the HSK area grinding allowance from HSK 32 to HSK 80 = 0.2 mm, from HSK 100 = 0.3 mm at the taper or 0.15 mm at the face surface.
- Not hardened and not ground.
- Front part of blank not hardened or ground for further processing.

**Design 2:**
- Taper including collar hardened and finish ground.
- Front part of blank not hardened or ground for further processing.

**Important note on design 2:**
- Excessive machining and any heat treatments of the completed blank may cause unacceptable distortion of the HSK shank.
- Claims against the warranty can therefore only be made for blanks that have not been processed.

**Supply includes:**
- Does not include coolant tube.

**Note:**
- In case of extensive machining on the blank, it is recommended to use design 1 and also to finish grind the HSK in the last machining step.
- Further dimensions on request.
- For coolant tubes see page 206.

**Material:**
- 42CrMo54