



Shrink chucks 4,5° for mounting of solid carbide and HSS-tool shanks

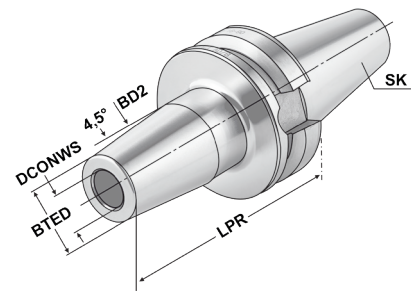
Mandrins de frettage 4,5° pour le serrage de queues d'outils carbures de type HM et HSS



Verwendung:
Zur Aufnahme von Werkzeugen mit Zylinderschaft.

Application:
For mounting straight-shank tools.

Application:
Pour le serrage d'outils avec queue cylindrique.



ISO 7388-2 DC Form JD/JF (AD/B) ≤ 3µm G2.5 25.000 min⁻¹ h6

| Bestell-Nr. Order no. Référence | SK | DCONWS | TDCON | LPR | BTED | BD | LSCN | LSCX | ADJRG | THID |
|---------------------------------------|----------|--------|-------|-----|------|----|------|------|-------|--------|
| DC.305.70.03* | BT-DC 30 | 3 | h4 | 80 | 11 | 15 | 6 | - | - | - |
| DC.305.70.04* | BT-DC 30 | 4 | h4 | 80 | 14 | 22 | 8 | - | 5 | - |
| DC.305.70.05* | BT-DC 30 | 5 | h4 | 80 | 16 | 22 | 10 | - | 5 | - |
| DC.305.70.06* | BT-DC 30 | 6 | h6 | 80 | 21 | 27 | 22 | 36 | 10 | M5x0,8 |
| DC.305.70.08* | BT-DC 30 | 8 | h6 | 80 | 21 | 27 | 26 | 36 | 10 | M6x1 |
| DC.305.70.10* | BT-DC 30 | 10 | h6 | 90 | 24 | 32 | 31 | 41 | 10 | M8x1 |
| DC.305.70.12* | BT-DC 30 | 12 | h6 | 90 | 24 | 32 | 36 | 46 | 10 | M10x1 |
| DC.305.70.14* | BT-DC 30 | 14 | h6 | 90 | 27 | 34 | 36 | 46 | 10 | M10x1 |
| DC.305.70.16* | BT-DC 30 | 16 | h6 | 90 | 27 | 34 | 39 | 49 | 10 | M12x1 |
| DC.305.70.18* | BT-DC 30 | 18 | h6 | 90 | 33 | 42 | 39 | 49 | 10 | M12x1 |
| DC.305.70.20* | BT-DC 30 | 20 | h6 | 90 | 33 | 42 | 41 | 51 | 10 | M16x1 |
| DC.406.70.03 | BT-DC 40 | 3 | h4 | 80 | 11 | 15 | 6 | - | - | - |
| DC.406.70.04 | BT-DC 40 | 4 | h4 | 80 | 14 | 22 | 8 | - | - | - |
| DC.406.70.05 | BT-DC 40 | 5 | h4 | 80 | 16 | 22 | 10 | - | - | - |
| DC.406.70.06 | BT-DC 40 | 6 | h6 | 90 | 21 | 27 | 22 | 36 | 10 | M5x0,8 |
| DC.406.70.08 | BT-DC 40 | 8 | h6 | 90 | 21 | 27 | 26 | 36 | 10 | M6x1 |
| DC.406.70.10 | BT-DC 40 | 10 | h6 | 90 | 24 | 32 | 31 | 41 | 10 | M8x1 |
| DC.406.70.12 | BT-DC 40 | 12 | h6 | 90 | 24 | 32 | 36 | 46 | 10 | M10x1 |
| DC.406.70.14 | BT-DC 40 | 14 | h6 | 90 | 27 | 34 | 36 | 46 | 10 | M10x1 |
| DC.406.70.16 | BT-DC 40 | 16 | h6 | 90 | 27 | 34 | 39 | 49 | 10 | M12x1 |
| DC.406.70.18 | BT-DC 40 | 18 | h6 | 90 | 33 | 42 | 39 | 49 | 10 | M12x1 |
| DC.406.70.20 | BT-DC 40 | 20 | h6 | 90 | 33 | 42 | 41 | 51 | 10 | M16x1 |
| DC.406.70.25 | BT-DC 40 | 25 | h6 | 100 | 44 | 53 | 47 | 57 | 10 | M16x1 |
| DC.406.70.32 | BT-DC 40 | 32 | h6 | 100 | 44 | 53 | 51 | 61 | 10 | M16x1 |
| DC.406.70.06.1 | BT-DC 40 | 6 | h6 | 120 | 21 | 27 | 22 | 36 | 10 | M5x0,8 |
| DC.406.70.08.1 | BT-DC 40 | 8 | h6 | 120 | 21 | 27 | 26 | 36 | 10 | M6x1 |
| DC.406.70.10.1 | BT-DC 40 | 10 | h6 | 120 | 24 | 32 | 31 | 41 | 10 | M8x1 |
| DC.406.70.12.1 | BT-DC 40 | 12 | h6 | 120 | 24 | 32 | 36 | 46 | 10 | M10x1 |
| DC.406.70.14.1 | BT-DC 40 | 14 | h6 | 120 | 27 | 34 | 36 | 46 | 10 | M10x1 |
| DC.406.70.16.1 | BT-DC 40 | 16 | h6 | 120 | 27 | 34 | 39 | 49 | 10 | M12x1 |
| DC.406.70.20.1 | BT-DC 40 | 20 | h6 | 120 | 33 | 42 | 41 | 51 | 10 | M16x1 |

* Form JD/AD

* Form JD/AD

* Form JD/AD

LSCX = Einspannlänge, max.

LSCX = Clamping depth, max.

LSCX = Profondeur d'insertion, max.

ADJRG = Verstellweg, max.

ADJRG = Length adjustment range, max.

ADJRG = Course de réglage, max.



Für Ø 3, 4 und 5 mm nur Hartmetallschäfte verwenden!

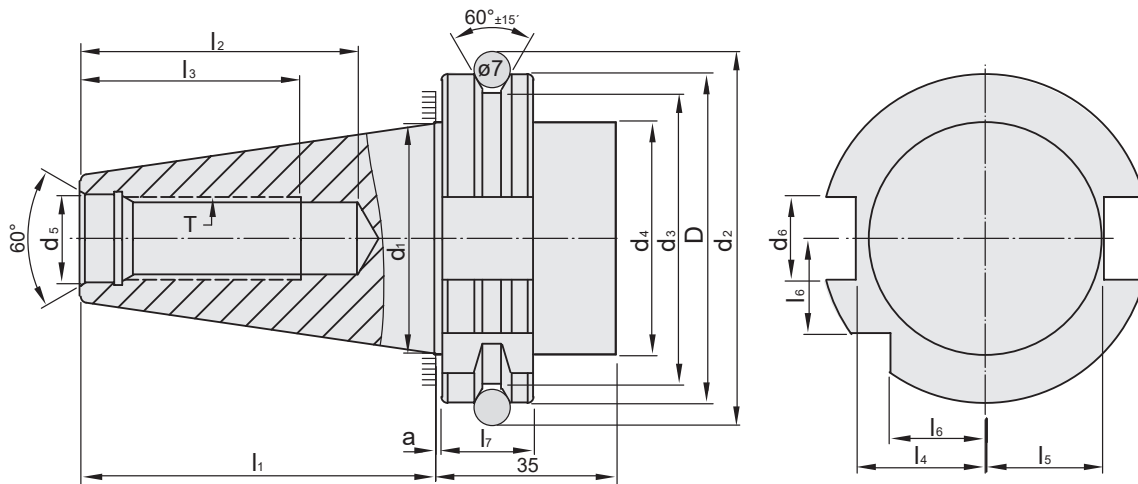
For Ø 3, 4 and 5 mm only solid carbide tool shanks must be used!

Pour Ø 3, 4 et 5 mm il faut seulement utiliser de queues d'outils carbures de type HM!

Toolholders similar DIN ISO 7388-1 (formerly DIN 69871) with face contact

Porte-outils similaire à DIN ISO 7388-1 (l'ancien DIN 69871) avec contact face

3



| SK | D | d ₁ | d ₂ | d ₃ | d ₄ | d ₅ | d ₆ | d ₉ | l ₁ | l ₂ | l ₃ | l ₄ | l ₅ | l ₆ | l ₇ | a | e ₁ | e ₂ | T |
|----|---|----------------|----------------|---|----------------|----------------|----------------|----------------|---|----------------|----------------|---|---|---|---|---|----------------|----------------|-----|
| | $\begin{matrix} 0 \\ -0,1 \end{matrix}$ | | $\pm 0,05$ | $\begin{matrix} 0 \\ -0,5 \end{matrix}$ | max | H7 | H12 | | $\begin{matrix} 0 \\ -0,3 \end{matrix}$ | min | min | $\begin{matrix} 0 \\ -0,4 \end{matrix}$ | $\begin{matrix} 0 \\ -0,4 \end{matrix}$ | $\begin{matrix} 0 \\ -0,3 \end{matrix}$ | $\begin{matrix} +0,1 \\ 0 \end{matrix}$ | $\begin{matrix} 0 \\ -0,005 \end{matrix}$ | $\pm 0,1$ | max | |
| 40 | 63,55 | 44,45 | 72,30 | 56,25 | 50 | 17 | 16,1 | 4 | 68,4 | 42,5 | 32 | 25 | 22,8 | 18,5 | 18,1 | 1 | 27 | 5 | M16 |
| 50 | 97,50 | 69,85 | 107,25 | 91,25 | 80 | 25 | 25,7 | 6 | 101,75 | 61,5 | 47 | 37,7 | 35,5 | 30 | 17,6 | 1,5 | 42 | 7 | M24 |

Vorgewuchtet G 6,3 15.000 min⁻¹
Pre-balanced
Pré-équilibré

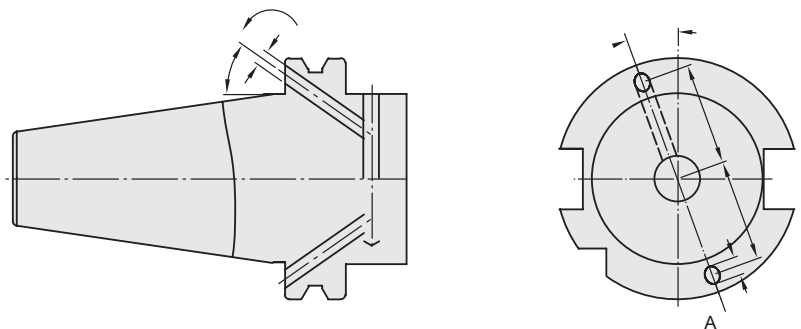
G 2,5 Feinwuchten gegen Aufpreis
G 2.5 Fine balancing at extra charge
G 2,5 Equilibrage fin contre un supplément

Mit innerer Kühlmittelzufuhr über den Bund - Form AD/AF (AD/B)

With internal coolant through the collar - form AD/AF (AD/B)

Avec arrosage interne par la collerette - forme AD/AF (AD/B)

Bei Lieferung mit Gewindestiften verschlossen
Delivery with headless screws in closed position
Livraison en état fermé avec de vis sans tête



Werkstoff: Legierter Einsatzstahl mit einer Zugfestigkeit im Kern von min. 950 N / mm². Einsatzgehärtet HRC 60 ± 2 (HV 700 ± 50), Härtetiefe 0,8 mm ± 0,2 mm, brüniert und präzisionsgeschliffen.

Form AD/AF: Lieferung in Ausführung AD, Form AF (B) mit lösbaren Gewindestiften verschlossen.

Genauigkeit: Kegelwinkel - Toleranzqualität < AT 3 nach DIN 7187 und DIN 2080.

Material: Alloyed case-hardened steel, tensile core strength of min. 950 N / mm². Case hardened HRC 60 ± 2 (HV 700 ± 50), hardening depth 0.8 mm ± 0.2 mm, black-finished and precisely grinded.

Form AD/AF: Delivery in form AD, type (B) closed with releasable headless screws.

Accuracy: Quality of taper < AT 3 according to DIN 7187 and DIN 2080.

Matière: Acier de cémentation allié. Résistance à la traction dans le noyau d'au moins 950 N / mm². Cémenté et trempé HRC 60 ± 2 (HV 700 ± 50), profondeur de trempé 0,8 mm ± 0,2 mm, brunie et rectifiée avec précision.

Forme AD/AF: Livraison en forme AD, forme AF (B) fermée avec de vis sans tête amovibles.

Précision: Angle de cône - qualité de tolérance < AT 3 selon DIN 7187 et DIN 2080



Example:

40 3 . 02 . 20 . 1

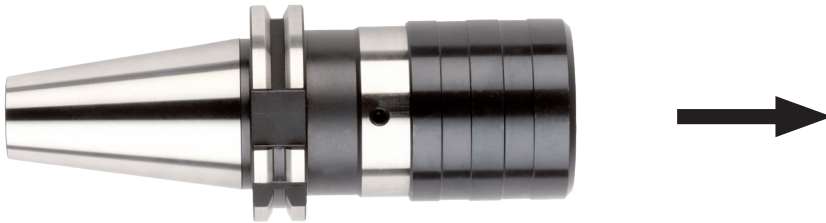




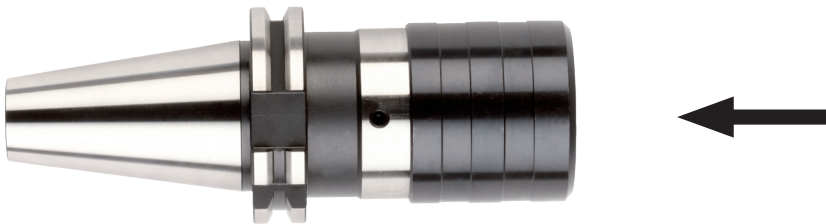
The process of tapping is a complex balance of rotational and axial movements of the tool. It is sometimes necessary to restrict the axial movements of the tool.

If the axial movement is not accurately controlled, the leading or trailing flanks of the tap may be forced to progressively “shave” one flank of the component thread, thus producing a thin and oversize thread in the component.

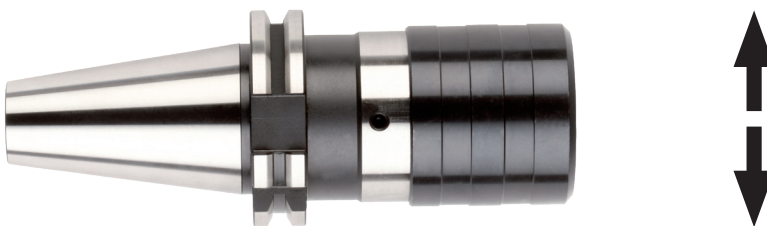
Tension – forward float capability allows the tap to progress into the component without interference from the axial feed of the machine spindle.



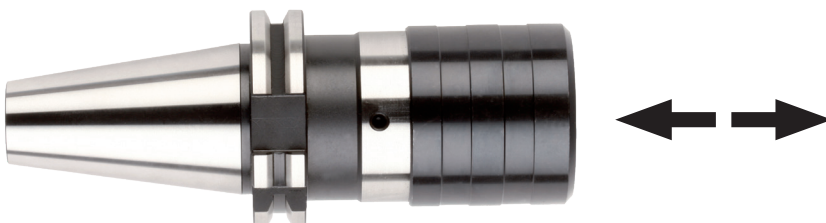
Compression – backward float capability, acts as a cushion and allows the tap to commence cutting at its own axial feed independent of the machine spindle.



Compression/Tension – float is designed to negate any external forces during the machining operation.



Radial float – allows for slight misalignment of the machine spindle axis and hole axis prior to tapping. This is not recommended manufacturing practice and should be avoided.





For a correct use of the tapping chuck, please check, during the first thread, not to exceed the max. axial stroke of the compensation values. This is to avoid damaging the thread or the tapping chuck.



Adjustment screw for amplification of chamfer edge pressure. Turning the screw clockwise amplifies the chamfer edge pressure.

Compensation in compression



Compensation in extension

| Code | Tap capacity | Adapters | Length adjustment in mm on | |
|-----------|--------------|---------------------|----------------------------|-----------|
| | | | Compression | Extension |
| xxx.16.12 | M 3 - M14 | 16.11.xx / 16.01.xx | 7 | 7 |
| xxx.16.20 | M 5 - M22 | 16.12.xx / 16.02.xx | 12 | 12 |
| xxx.16.36 | M14 - M36 | 16.14.xx / 16.03.xx | 17.5 | 17.5 |