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 English version.



HYDRO-LINE

Precision Hydraulic Expansion Toolholding System





HYDRO-LINE

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Grip perfect

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Company Profile



OUR MISSION PROFESSIONALISM

-GRIP is a team by professionals from all walks of life.
GRIP manufactures and distributes high-precision
Tool holding systems worldwide.
Our products perfectly fit together in the field of automotive,
aerospace, medical engineering, watchmaking, telecommunications,
and in the die and mold industry.

OUR GOAL GRIP TO PERFECT

-GRIP works for your fulfillment.
GRIP's first priority is providing optimal solutions for every
demand of each specific application.
Our goals are helping GRIP customers to improve quality
of their products and helping them to meet the finest end result
with our high-quality products. In order to achieve our goals,
GRIP always focuses on being in close contact with our customers
to recognize market needs and reflecting the demands based upon
our expert knowledge, know-how, and experiences.
GRIP sincerely believes that the GRIP will help you to be perfect.

Only Thinking of Excellency in Hydro **GRIP**

-  Trademark
-  Two Red Rings



HYDRO-LINE

Overview

- 1 HYDRO-MICRON** The standard. Various use. Optimal performance.
- 2 HYDRO-SLIM** Slim and high-precision. Optimized interfering contours.
- 3 HYDRO-ZERO FIT** Zero run-out setting for optimum machining.
- 4 HYDRO-PRESET** Radial Length Adjustment for micron precise positioning.
- 5 HYDRO-GRIND** Tool Grinding and Sharpening.
- 6 HYDRO-VS** Compact, very short type. For machine room space.
- 7 HYDRO-ZERO EXTENSION** Zero run-out setting connection holder.
- 8 HYDRO-CENTRO** CNC lathe, Center Calibration holder.
- 9 HYDRO-SWISS TURN** Precision, swiss type automatic lathe solution.



HSK	BT	SK	CAT	CYL
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HSK-A40,50,63,100 HSK-C40,50,63 HSK-E40,50	BT-30,40,50 BT/DC-30,40,50	SK-40,50	CAT-40,50	
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HSK-A40,50,63,100	BT-30,40,50	SK-40		
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HSK-A63,100	BT-30,40,50	SK-40,50		
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HSK-A63,100				
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Taper interface

	BT-50			
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	BT-40,50	SK-40,50		
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			ST-20	
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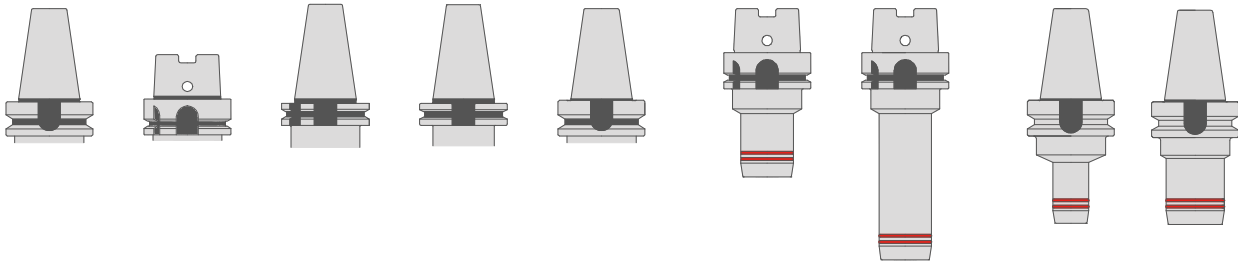
			ST-25,32,40	
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			ST-16,19,05,20 ST-22,25,4,32	
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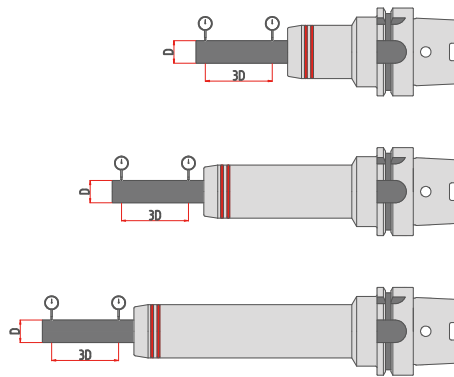
≡ A wide range of about 250 products.

Various tapers (BT, HSK, SK, CAT) and various lengths and inner diameters.



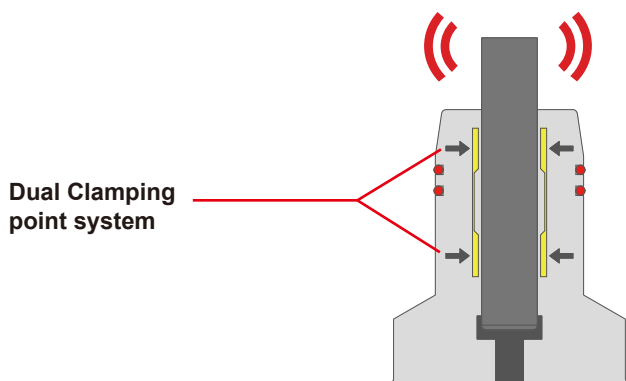
≡ Precision and Run-out Guaranteed.

Standard run-out 3 μm .
ID25/ ID32 run-out 5 μm .
Length 150mm or more, run-out 7 μm .



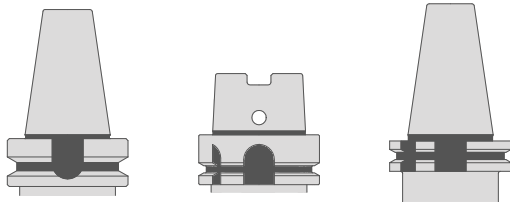
≡ Vibration damping effect.

Long tool life and Perfect surface finish.

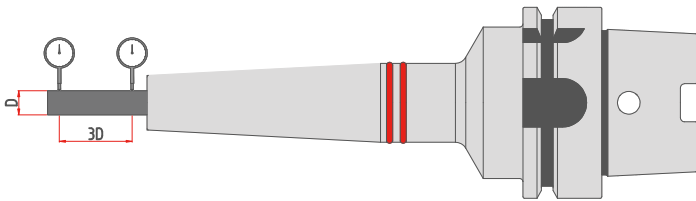


Optimized interfering contours, which results in excellent work piece accessibility.

ID6~20 size
Various types of tapers.



Standard Run-Out 3xd 3Micron.



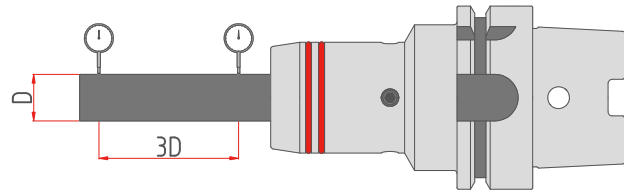
No expensive clamping device required.

	Tool setting time	Clamping device	User risk level
HYDRO-SLIM	10 sec	No need	No problem
Shrink fit holder	3 min	Expansive device	Danger of burns



Standard Run-Out 3xd 3Micron.

Standard run-out 3 μm .
ID25/ ID32 run-out 5 μm .



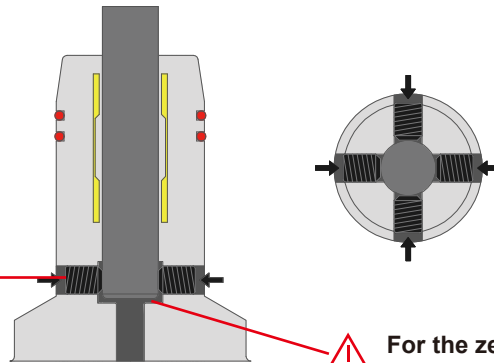
ZERO Run-Out setting.

4 screws in 90 degree directions
for Run-out setting for more precise work.



ZERO Run-Out
setting video.

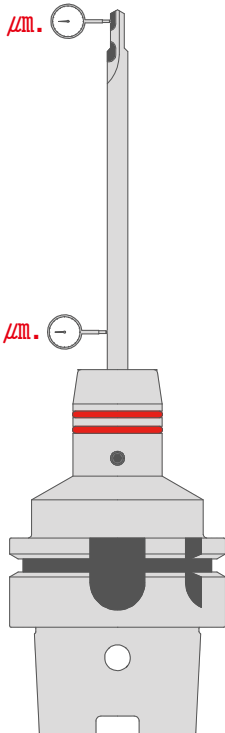
Run-out setting screw



For the zero-fit function to work properly,
the bottom of the holder must not be in
contact with the tool.

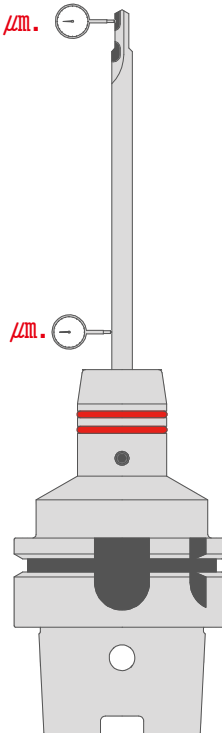
15 μm .

2 μm .



1 μm .

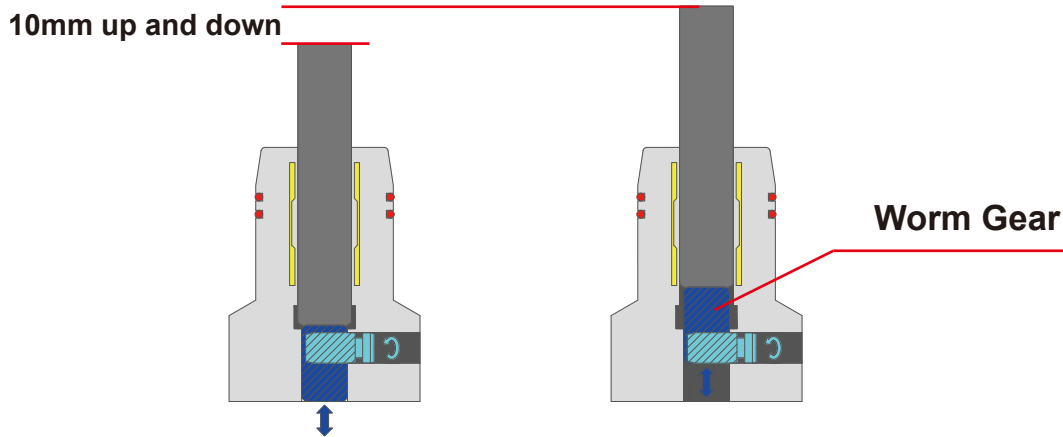
1 μm .



Run-out setting
for long tools.



- ≡ Micron precise radial length adjustment (10mm) of the tools.

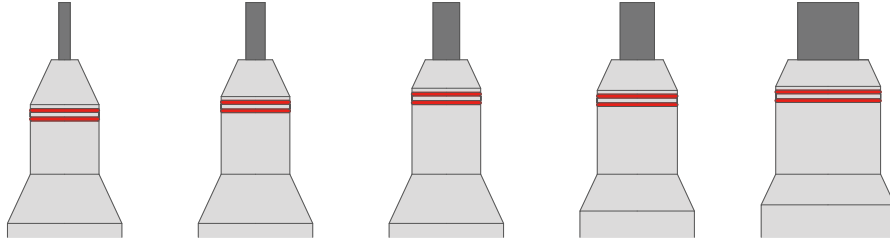


- ≡ Suitable for multi-axis spindle machine tool setting.



≡ A wide range of products from 6 to 32 bore diameters.

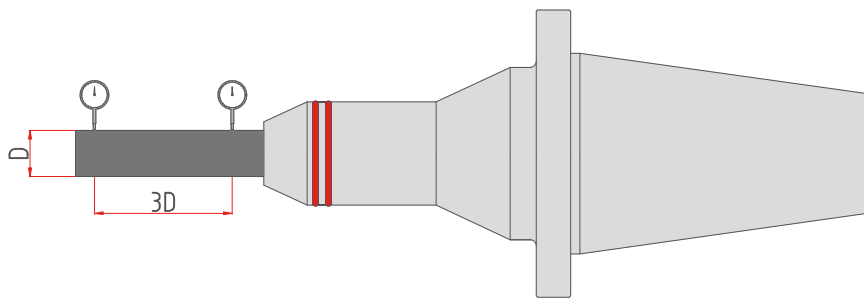
Optimization of work precision by direct fastening of workpieces.



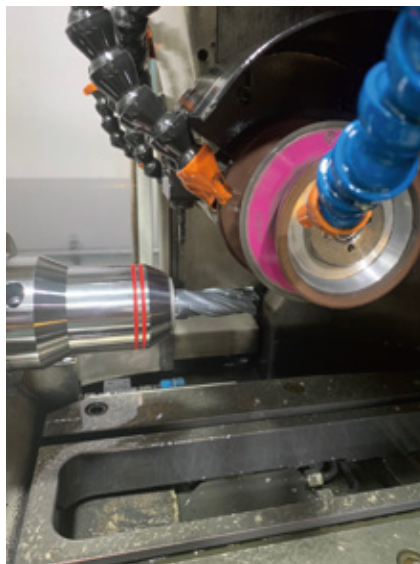
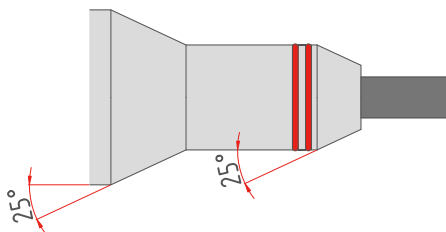
ID12, ID20, ID32 Hydro-sleeve can be used.

≡ Always keep the same run-out.

Standard run-out $3\mu\text{m}$.

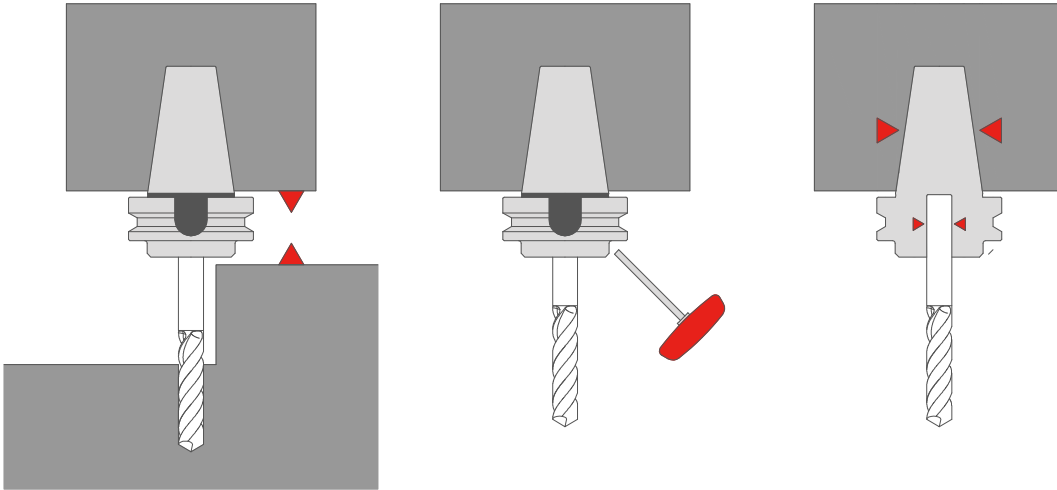


≡ Minimized wheel interference at an inlet angle of 25 degrees.



≡ Can secure maximum machine space.

Minimize interference. Long tools are available.



≡ Can be ideally combined with HYDRO-ZERO EXTENSION.

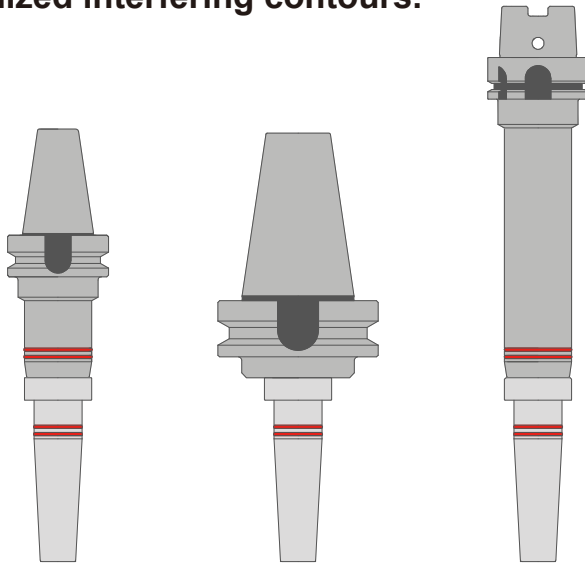


HYDRO-ZERO EXTENSION



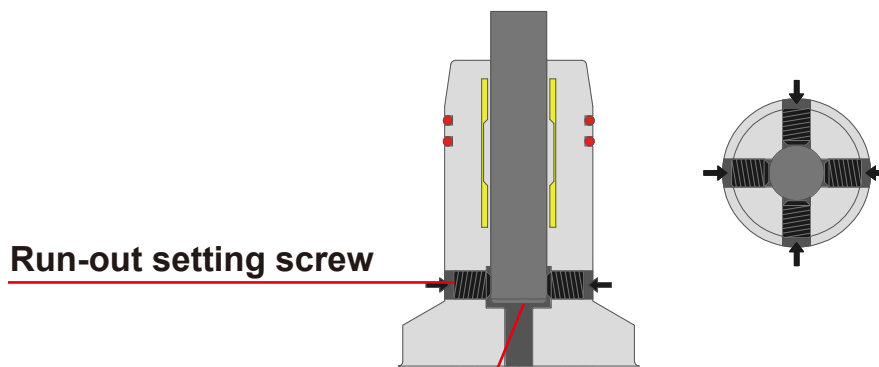
= A slim type connection holder.

Save costs on the fabrication of expensive special tools.
Optimized interfering contours.



= ZERO Run-Out setting.

4pcs screws in 90 degree direction
for Run-out setting for more precise work.

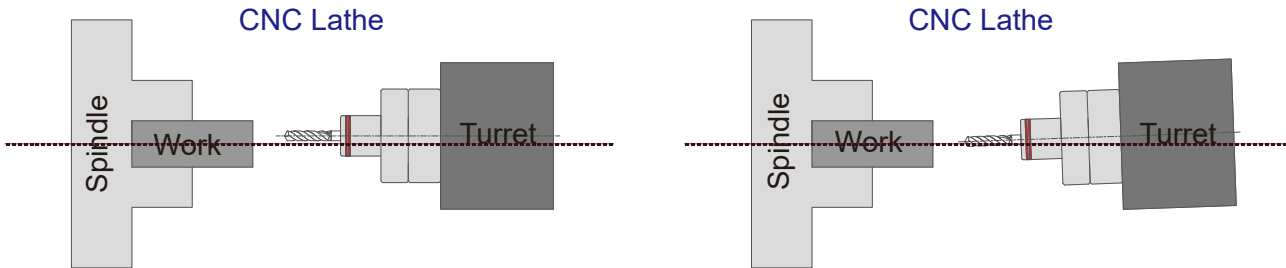


⚠ For the zero-fit function to work properly,
the bottom of the holder must not be in
contact with the tool.



Optimal machining is realized by correcting misalignment of turret and spindle on cnc lathes.

Before

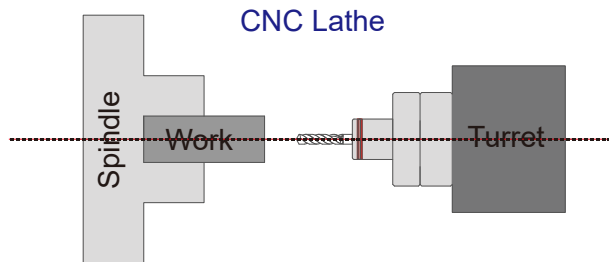


CENTO SETTING

After

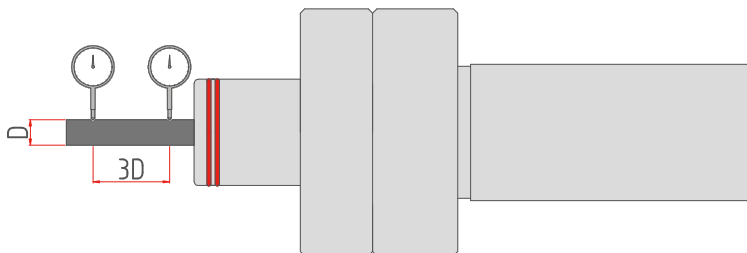


Centro setting video.



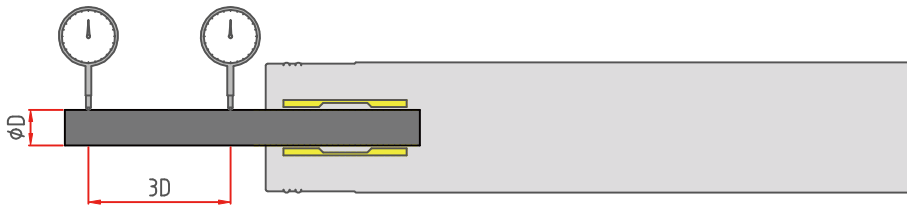
Guarantees the same runout when changing tools with one calibration.

Precision-always keep same run-out accuracy.



Ultra Precision.

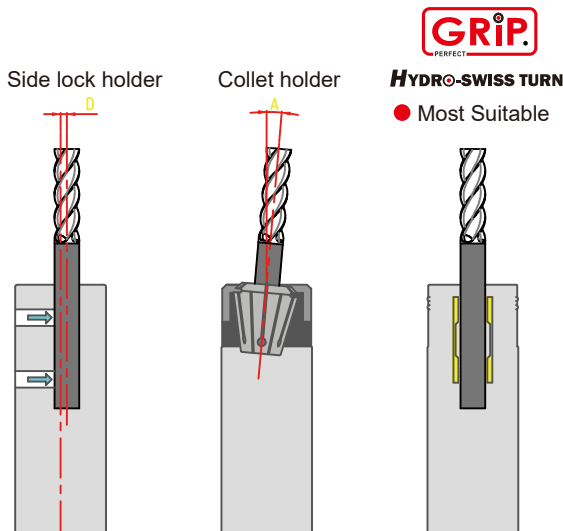
Hydraulic chuck always keeps the same run-out accuracy.



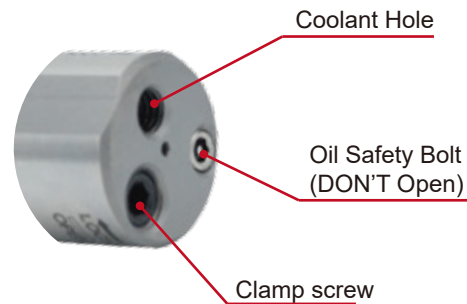
Standard type 0.003 T.I.R

UP type 0.001 T.I.R

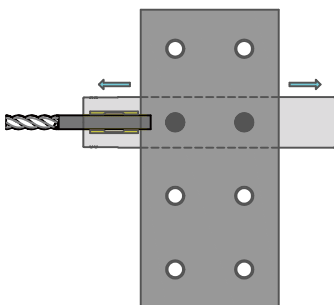
Hydraulic Chuck with Product Comparison.



Easy Clamping Hydraulic System.

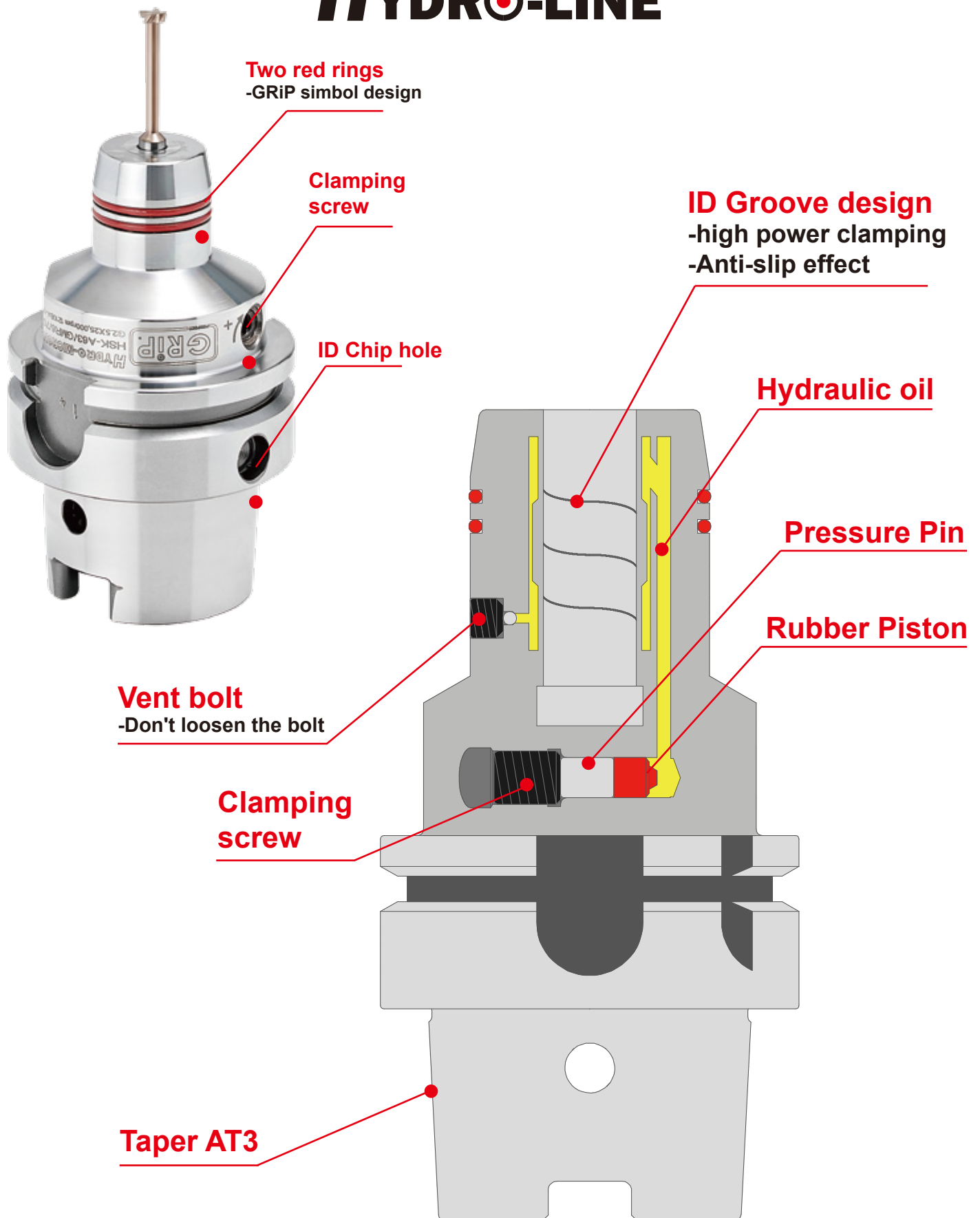


Easy and Free Axial Length Adjustment.



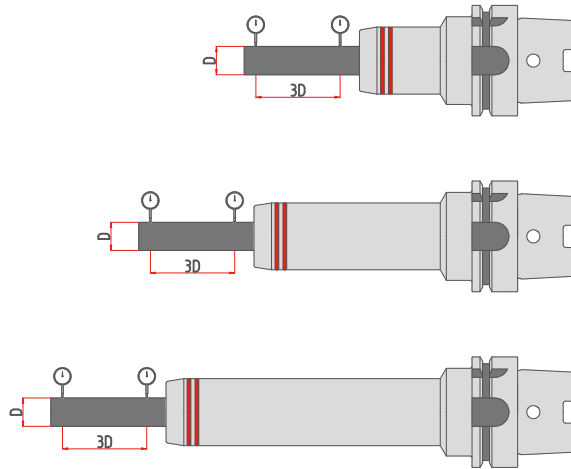


HYDRO-LINE



≡ Precision and Run-out Guaranteed.

Standard run-out 3 μm .
ID25/ ID32 run-out 5 μm .
Length 150mm or more, run-out 7 μm .



≡ Taper contact is better than AT3.

Optimum connection between machine and tool.

≡ All products are numbered.
A guarantee of quality
with this system.



≡ All products are checked
for oil leaks to guarantee
the Tool-life.



Balancing Grade

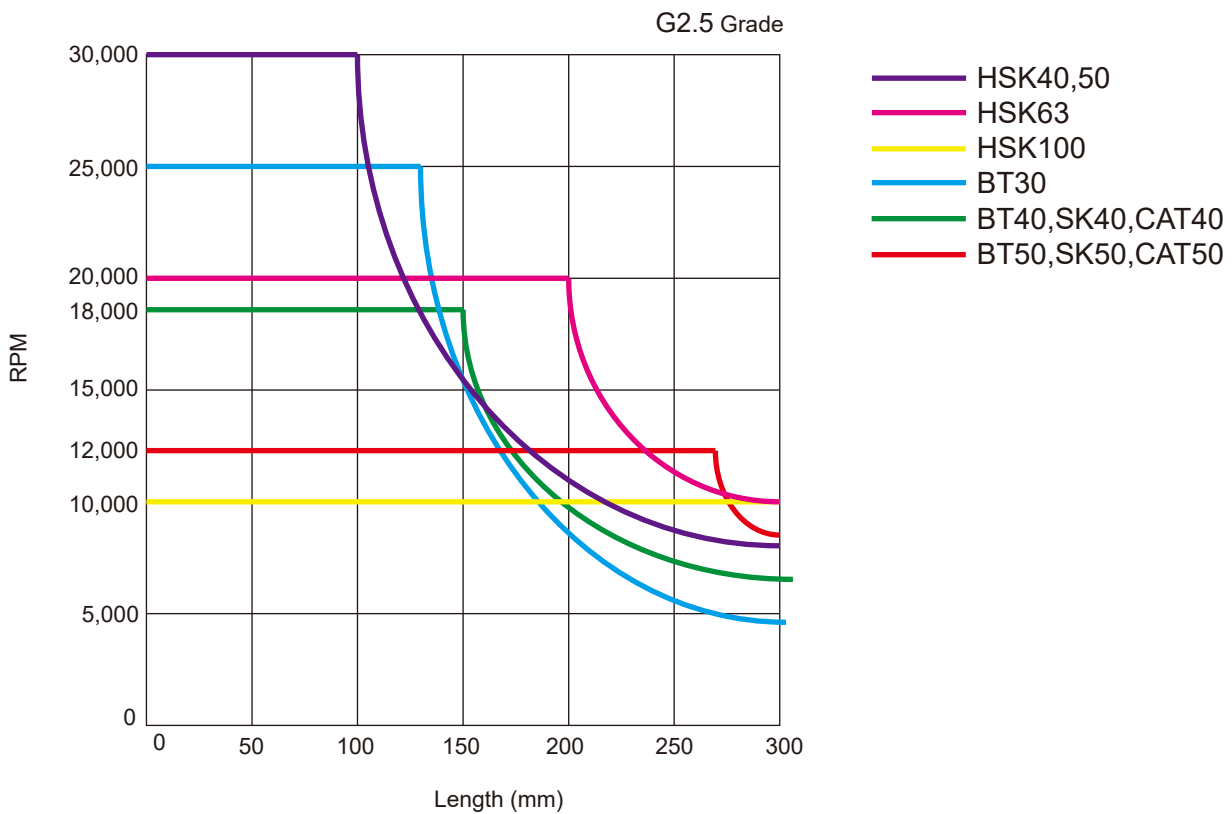


≡ All item Fine balancing.

All item G2.5 grade balancing quality.



≡ Grip products balancing grade.



Torque Test data



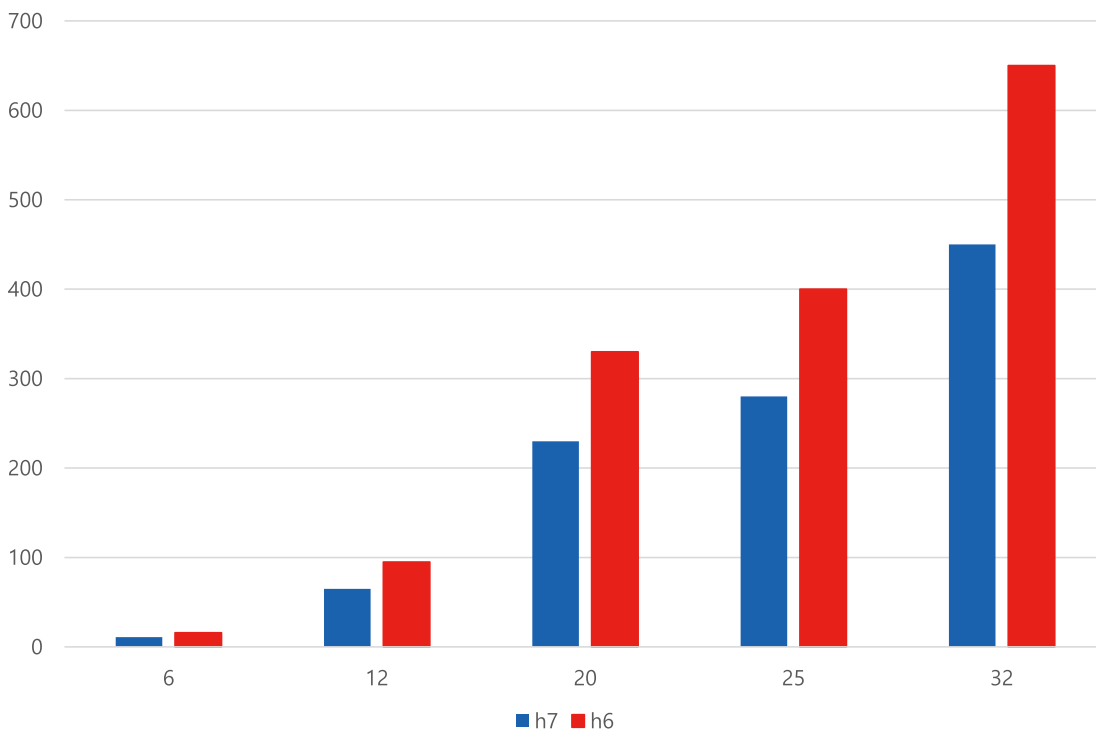
≡ Hydro-Line clamping force.

Ø6	16Nm	Ø16	185Nm
Ø8	23Nm	Ø18	280Nm
Ø10	45Nm	Ø20	430Nm
Ø12	95Nm	Ø25	650Nm
Ø14	110Nm	Ø32	900Nm

[Nm]



≡ Comparison table of clamping force per tool shank.



*Recommend to use tool of h6 tolerance for optimal accuracy and machinability, can be to use tool of h7 tolerance but, it make reduction of clamping force.

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HYDRO-MICRON

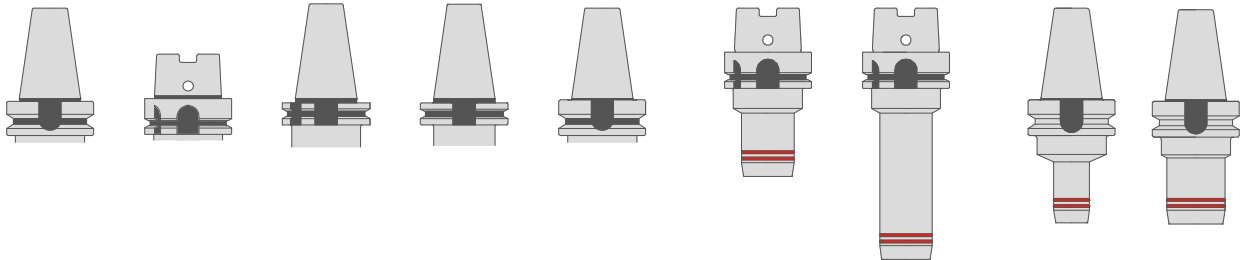
The standard. Various use. Optimal performance.



HYDRO-MICRON

= A wide range of about 250 products.

Various tapers (BT, HSK, SK, CAT) and various lengths and inner diameters.

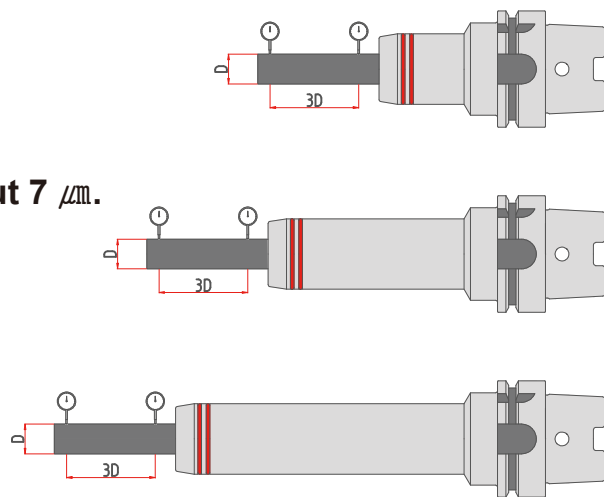


= Precision and Run-out Guaranteed.

Standard run-out 3 μm .

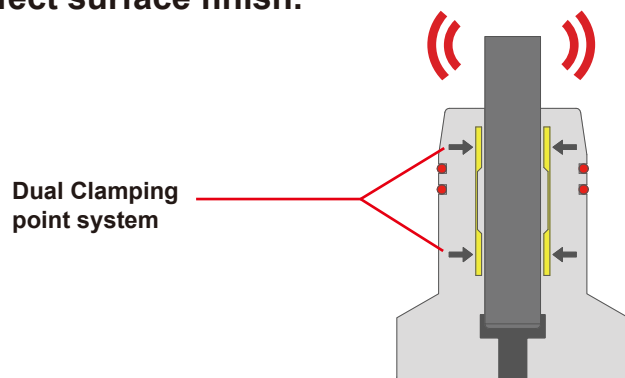
ID25/ ID32 run-out 5 μm .

Length 150mm or more, run-out 7 μm .



= Vibration damping effect.

Long tool life and Perfect surface finish.

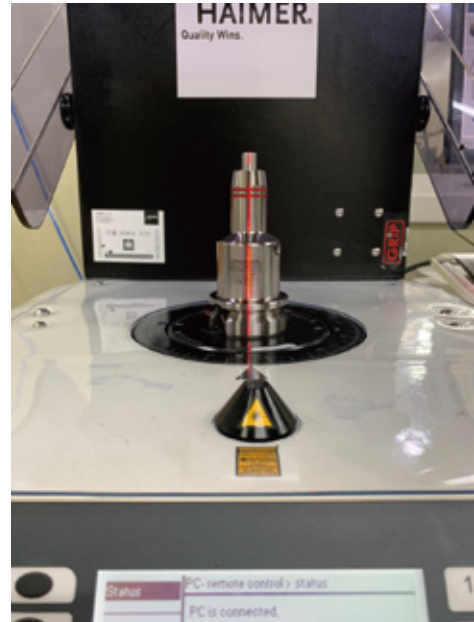


≡ Suitable for semi finishing and finishing work.

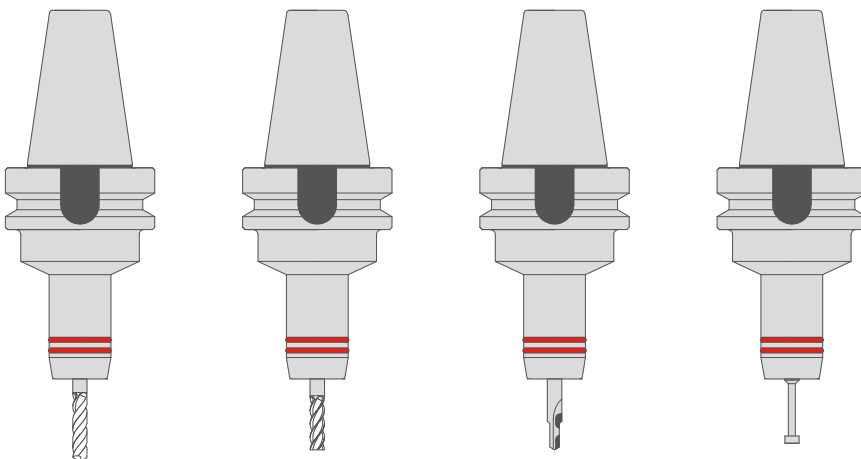


≡ All item Fine balancing.

All item G2.5 grade balancing quality



**≡ Reamer, Tap, Drill, Ball end mill, End mill, PCD tool, etc.
Many kinds of work possible.**



≡ Dimensions(mm)

HSK-A40		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A40/GMR6/70	●	6	23	26	33.5	70	37.5	27.5	36	TR-4.0	M5x0.8(T-2.5)	0.5
HSK-A40/GMR8/70	●	8	25	28	33.5	70	37.5	27.5	36	TR-4.0	M6x1.0(T-3.0)	0.5
HSK-A40/GMR10/75	●	10	27	30	33.5	75	42.5	32.5	42	TR-4.0	M6x1.0(T-3.0)	0.6
HSK-A40/GMR12/80	●	12	29	32	33.5	80	47.5	37.5	48	TR-4.0	M6x1.0(T-3.0)	0.6

HSK-A50		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A50/GMR6/70	●	6	23	26	40	70	37.5	27.5	28	TR-4.0	M5x0.8(T-2.5)	0.7
HSK-A50/GMR8/70	●	8	25	28	40	70	37.5	27.5	28	TR-4.0	M6x1.0(T-3.0)	0.7
HSK-A50/GMR10/75	●	10	27	30	40	75	42.5	32.5	34	TR-4.0	M6x1.0(T-3.0)	0.7
HSK-A50/GMR12/85	●	12	29	32	40	85	47.5	37.5	44	TR-4.0	M6x1.0(T-3.0)	0.8
HSK-A50/GMR14/85	●	14	31	34	40	85	47.5	37.5	44	TR-4.0	M6x1.0(T-3.0)	0.8
HSK-A50/GMR16/90	●	16	35	38	41.5	90	52.5	42.5	49	TR-4.0	M6x1.0(T-3.0)	0.9
HSK-A50/GMR18/90	●	18	37	40	41.5	90	52.5	42.5	49	TR-4.0	M6x1.0(T-3.0)	0.9
HSK-A50/GMR20/90	●	20	39	41.5	41.5	90	52.5	42.5	64	TR-4.0	M6x1.0(T-3.0)	1.0

HSK-A63		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A63/GMR6/70	●	6	23	26	50	70	37.5	27.5	24	TR-4.0	M5x0.8(T-2.5)	1.0
HSK-A63/GMR8/70	●	8	25	28	50	70	37.5	27.5	24	TR-4.0	M6x1.0(T-3.0)	1.0
HSK-A63/GMR10/80	●	10	27	30	50	80	42.5	32.5	35	TR-4.0	M8x1.0(T-4.0)	1.1
HSK-A63/GMR12/85	●	12	29	32	50	85	47.5	37.5	40	TR-4.0	M8x1.0(T-4.0)	1.2
HSK-A63/GMR14/85	●	14	31	34	50	85	47.5	37.5	40	TR-4.0	M8x1.0(T-4.0)	1.2
HSK-A63/GMR16/90	●	16	35	38	50	90	52.5	42.5	46	TR-4.0	M8x1.0(T-4.0)	1.3
HSK-A63/GMR18/90	●	18	37	40	50	90	52.5	42.5	47	TR-4.0	M8x1.0(T-4.0)	1.3
HSK-A63/GMR20/90	●	20	39	42	50	90	52.5	42.5	48	TR-4.0	M8x1.0(T-4.0)	1.3
HSK-A63/GMR25/120	●	25	46	50	-	120	61	51	-	TR-5.0	M16x1.0(T-6.0)	2.3
HSK-A63/GMR32/125	●	32	56	60	52.5	125	65	55	-	TR-5.0	M16x1.0(T-6.0)	2.8

Availability: ● Stock ▲ Short lead time ○ Made to order

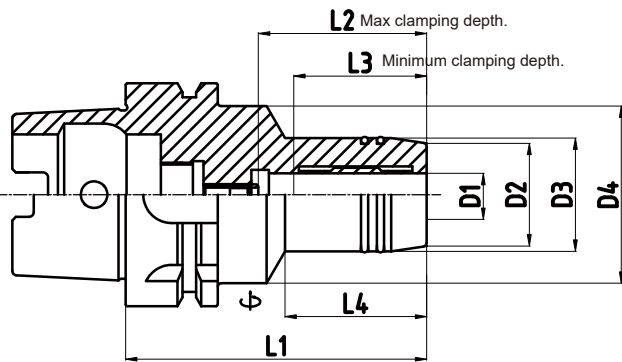
≡ Dimensions(mm)

HSK-A100		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A100/GMR6/75	●	6	23	26	50	75	37.5	27.5	26	TR-4.0	M5x0.8(T-2.5)	2.6
HSK-A100/GMR8/75	●	8	25	28	50	75	37.5	27.5	26	TR-4.0	M6x1.0(T-3.0)	2.7
HSK-A100/GMR10/90	●	10	27	30	50	90	42.5	32.5	42	TR-4.0	M8x1.0(T-4.0)	2.8
HSK-A100/GMR12/95	●	12	29	32	50	95	47.5	37.5	47	TR-4.0	M10x1.0(T-5.0)	2.8
HSK-A100/GMR14/95	●	14	31	34	50	95	47.5	37.5	47	TR-4.0	M10x1.0(T-5.0)	2.8
HSK-A100/GMR16/100	●	16	35	38	50	100	52.5	42.5	53	TR-4.0	M12x1.0(T-6.0)	2.9
HSK-A100/GMR18/100	●	18	37	40	50	100	52.5	42.5	53	TR-4.0	M12x1.0(T-6.0)	3.0
HSK-A100/GMR20/105	●	20	39	42	50	105	52.5	42.5	59	TR-5.0	M16x1.0(T-6.0)	3.0
HSK-A100/GMR25/110	●	25	53	57	63	110	61	51	62	TR-5.0	M16x1.0(T-6.0)	3.7
HSK-A100/GMR32/110	●	32	58	63	75	110	65	55	62	TR-5.0	M12x1.0(T-6.0)	3.9

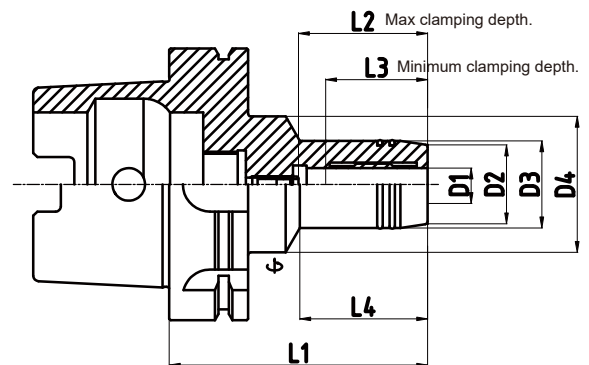
Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
- »Tool length can be adjusted up to 10mm.
- »T-wrench is must be ordered separately. (GRIP torque wrench is recommended.)
- »Data carrier and Coolant tube as an option.
- »All products center through coolant system.
- »Additional sizes and special designs available on request.

⚠ The minimum tool depth must be observed.



HSK-A40/A50/A63



HSK-A100

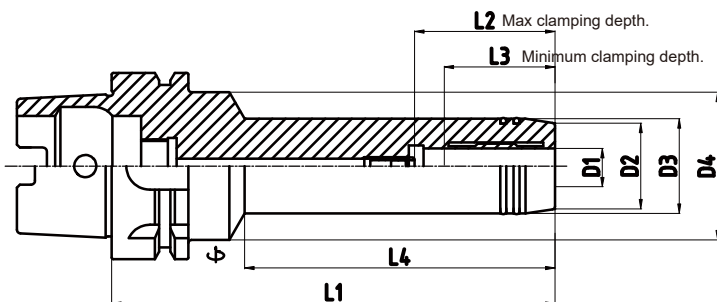
HSK Long Type

Dimensions(mm)

HSK-A63		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A63/GMR6/150	●	6	23	26	50	150	37.5	27.5	103	TR-4.0	M5x0.8(T-2.5)	1.4
HSK-A63/GMR8/150	●	8	25	28	50	150	37.5	27.5	104	TR-4.0	M6x1.0(T-3.0)	1.5
HSK-A63/GMR10/150	●	10	27	30	50	150	42.5	32.5	104	TR-4.0	M8x1.0(T-4.0)	1.6
HSK-A63/GMR12/150	●	12	29	32	50	150	47.5	37.5	105	TR-4.0	M10x1.0(T-5.0)	1.7
HSK-A63/GMR14/150	●	14	31	34	50	150	47.5	37.5	105	TR-4.0	M10x1.0(T-5.0)	1.7
HSK-A63/GMR16/150	●	16	35	38	50	150	52.5	42.5	106	TR-4.0	M12x1.0(T-6.0)	1.8
HSK-A63/GMR18/150	●	18	37	40	50	150	52.5	42.5	107	TR-4.0	M12x1.0(T-6.0)	1.9
HSK-A63/GMR20/150	●	20	39	42	50	150	52.5	42.5	108	TR-5.0	M16x1.0(T-6.0)	2.0

HSK-A63		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A63/GMR6/200	●	6	23	26	50	200	37.5	27.5	153	TR-4.0	M5x0.8(T-2.5)	2.3
HSK-A63/GMR8/200	●	8	25	28	50	200	37.5	27.5	154	TR-4.0	M6x1.0(T-3.0)	2.3
HSK-A63/GMR10/200	●	10	27	30	50	200	42.5	32.5	154	TR-4.0	M8x1.0(T-4.0)	2.4
HSK-A63/GMR12/200	●	12	29	32	50	200	47.5	37.5	155	TR-4.0	M10x1.0(T-5.0)	2.4
HSK-A63/GMR14/200	●	14	31	34	50	200	47.5	37.5	155	TR-4.0	M10x1.0(T-5.0)	2.4
HSK-A63/GMR16/200	●	16	35	38	50	200	52.5	42.5	156	TR-4.0	M12x1.0(T-6.0)	2.4
HSK-A63/GMR18/200	●	18	37	40	50	200	52.5	42.5	157	TR-4.0	M12x1.0(T-6.0)	2.5
HSK-A63/GMR20/200	●	20	39	42	50	200	52.5	42.5	158	TR-5.0	M16x1.0(T-6.0)	2.6

Availability: ● Stock ▲ Short lead time ○ Made to order



HSK-A63/A100

HSK Long Type

Dimensions(mm)

HSK-A100		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A100/GMR6/160	●	6	23	26	50	160	37.5	27.5	104	TR-4.0	M5x0.8(T-2.5)	3.0
HSK-A100/GMR8/160	●	8	25	28	50	160	37.5	27.5	104	TR-4.0	M6x1.0(T-3.0)	3.1
HSK-A100/GMR10/160	●	10	27	30	50	160	42.5	32.5	105	TR-4.0	M8x1.0(T-4.0)	3.1
HSK-A100/GMR12/160	●	12	29	32	50	160	47.5	37.5	105	TR-4.0	M10x1.0(T-5.0)	3.2
HSK-A100/GMR14/160	●	14	31	34	50	160	47.5	37.5	107	TR-4.0	M10x1.0(T-5.0)	3.2
HSK-A100/GMR16/160	●	16	35	38	50	160	52.5	42.5	107	TR-4.0	M12x1.0(T-6.0)	3.4
HSK-A100/GMR18/160	●	18	37	40	50	160	52.5	42.5	108	TR-4.0	M12x1.0(T-6.0)	3.5
HSK-A100/GMR20/160	●	20	39	42	50	160	52.5	42.5	108	TR-5.0	M16x1.0(T-6.0)	3.6
HSK-A100/GMR25/160	●	25	53	57	63	160	61	51	110	TR-5.0	M16x1.0(T-6.0)	4.7
HSK-A100/GMR32/160	●	32	58	63	75	160	65	55	110	TR-5.0	M16x1.0(T-6.0)	5.0

HSK-A100		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A100/GMR6/200	●	6	23	26	50	200	37.5	27.5	144	TR-4.0	M5x0.8(T-2.5)	3.2
HSK-A100/GMR8/200	●	8	25	28	50	200	37.5	27.5	144	TR-4.0	M6x1.0(T-3.0)	3.3
HSK-A100/GMR10/200	●	10	27	30	50	200	42.5	32.5	145	TR-4.0	M8x1.0(T-4.0)	3.3
HSK-A100/GMR12/200	●	12	29	32	50	200	47.5	37.5	145	TR-4.0	M10x1.0(T-5.0)	3.4
HSK-A100/GMR14/200	●	14	31	34	50	200	47.5	37.5	147	TR-4.0	M10x1.0(T-5.0)	3.5
HSK-A100/GMR16/200	●	16	35	38	50	200	52.5	42.5	147	TR-4.0	M12x1.0(T-6.0)	3.8
HSK-A100/GMR18/200	●	18	37	40	50	200	52.5	42.5	148	TR-4.0	M12x1.0(T-6.0)	3.9
HSK-A100/GMR20/200	●	20	39	42	50	200	52.5	42.5	148	TR-5.0	M16x1.0(T-6.0)	4.0
HSK-A100/GMR25/200	●	25	53	57	63	200	61	51	150	TR-5.0	M16x1.0(T-6.0)	5.4
HSK-A100/GMR32/200	●	32	58	63	75	200	65	55	150	TR-5.0	M16x1.0(T-6.0)	6.1

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
- »Tool length can be adjusted up to 10mm.
- »T-wrench is must be ordered separately.
(GRIP torque wrench is recommended.)
- »Data carrier and Coolant tube as an option.
- »All products center through coolant system.
- »Additional sizes and special designs available on request.

⚠ The minimum tool depth must be observed.

Dimensions(mm)

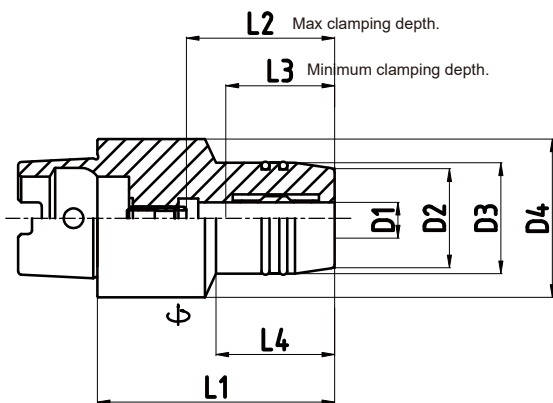
HSK-C40		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-C40/GMR6/60	○	6	23	26	40	60	37.5	27.5	35	TR-4.0	M5x0.8(T-2.5)	0.4
HSK-C40/GMR8/60	○	8	25	28	40	60	37.5	27.5	36	TR-4.0	M6x1.0(T-3.0)	0.4
HSK-C40/GMR10/65	○	10	27	30	40	65	42.5	32.5	41	TR-4.0	M6x1.0(T-3.0)	0.5
HSK-C40/GMR12/70	●	12	29	32	40	70	47.5	37.5	47	TR-4.0	M6x1.0(T-3.0)	0.5

HSK-C50		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-C50/GMR6/60	○	6	23	26	50	60	37.5	27.5	30	TR-4.0	M5x0.8(T-2.5)	0.7
HSK-C50/GMR8/60	○	8	25	28	50	60	37.5	27.5	30	TR-4.0	M6x1.0(T-3.0)	0.7
HSK-C50/GMR10/65	○	10	27	30	50	65	42.5	32.5	35	TR-4.0	M8x1.0(T-4.0)	0.7
HSK-C50/GMR12/75	●	12	29	32	50	75	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	0.8
HSK-C50/GMR14/75	○	14	31	34	50	75	47.5	37.5	46	TR-4.0	M10x1.0(T-5.0)	0.8
HSK-C50/GMR16/80	○	16	35	38	50	80	52.5	42.5	51	TR-4.0	M12x1.0(T-6.0)	0.9
HSK-C50/GMR18/80	○	18	37	40	50	80	52.5	42.5	51	TR-4.0	M12x1.0(T-6.0)	1.0
HSK-C50/GMR20/80	●	20	39	42	50	80	52.5	42.5	52	TR-4.0	M12x1.0(T-6.0)	1.2

Availability: ● Stock ▲ Short lead time ○ Made to order

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(GRIP torque wrench is recommended.)
- »Coolant tube as an option.
- »All products center through coolant system.
- »Additional sizes and special designs available on request.

⚠ The minimum tool depth must be observed.



HSK-C40/C50

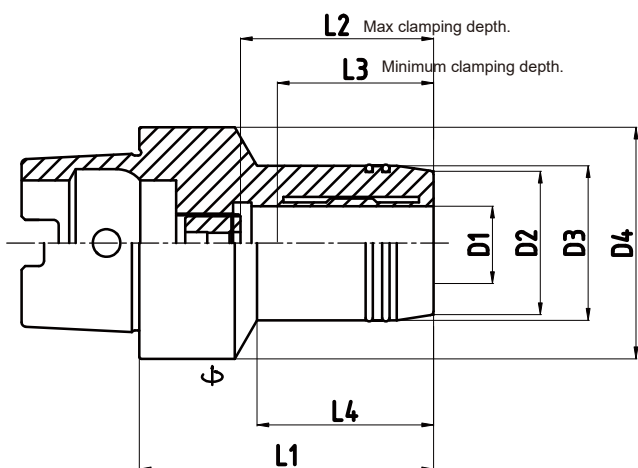
Dimensions(mm)

HSK-C63		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-C63/GMR6/60	○	6	23	26	63	60	37.5	27.5	24	TR-4.0	M5x0.8(T-2.5)	0.9
HSK-C63/GMR8/60	○	8	25	28	63	60	37.5	27.5	24	TR-4.0	M6x1.0(T-3.0)	1.0
HSK-C63/GMR10/65	○	10	27	30	63	65	42.5	32.5	35	TR-4.0	M8x1.0(T-4.0)	1.1
HSK-C63/GMR12/75	●	12	29	32	63	75	47.5	37.5	40	TR-4.0	M10x1.0(T-5.0)	1.1
HSK-C63/GMR14/75	○	14	31	34	63	75	47.5	37.5	40	TR-4.0	M10x1.0(T-5.0)	1.2
HSK-C63/GMR16/80	○	16	35	38	63	80	52.5	42.5	46	TR-4.0	M12x1.0(T-6.0)	1.2
HSK-C63/GMR18/80	○	18	37	40	63	80	52.5	42.5	47	TR-4.0	M12x1.0(T-6.0)	1.2
HSK-C63/GMR20/80	●	20	39	42	63	80	52.5	42.5	48	TR-5.0	M16x1.0(T-6.0)	1.3
HSK-C63/GMR25/95	○	25	53	57	63	95	61	51	59	TR-5.0	M16x1.0(T-6.0)	2.0
HSK-C63/GMR32/100	○	32	58	63	63	100	65	55	-	TR-5.0	M16x1.0(T-6.0)	2.1

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
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- »T-wrench is must be ordered separately. (GRIP torque wrench is recommended.)
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⚠ The minimum tool depth must be observed.



HSK-C63

Dimensions(mm)

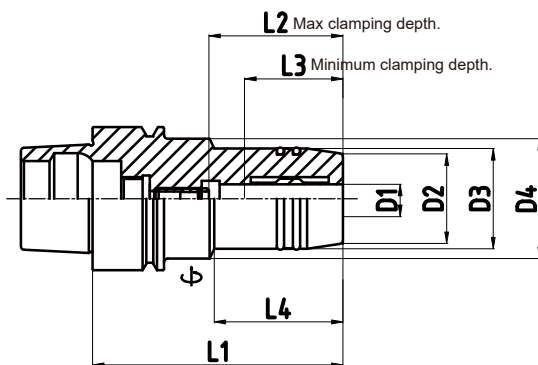
HSK-E40		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-E40/GMR6/70	●	6	23	26	33.5	70	37.5	27.5	36	TR-4.0	M5x0.8(T-2.5)	0.5
HSK-E40/GMR8/70	●	8	25	28	33.5	70	37.5	27.5	36	TR-4.0	M6x1.0(T-3.0)	0.5
HSK-E40/GMR10/75	●	10	27	30	33.5	75	42.5	32.5	42	TR-4.0	M6x1.0(T-3.0)	0.6
HSK-E40/GMR12/80	●	12	29	32	33.5	80	47.5	37.5	48	TR-4.0	M6x1.0(T-3.0)	0.6

HSK-E50		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-E50/GMR6/70	●	6	23	26	40	70	37.5	27.5	28	TR-4.0	M5x0.8(T-2.5)	0.8
HSK-E50/GMR8/70	●	8	25	28	40	70	37.5	27.5	28	TR-4.0	M6x1.0(T-3.0)	0.8
HSK-E50/GMR10/75	●	10	27	30	40	75	42.5	32.5	34	TR-4.0	M8x1.0(T-4.0)	0.8
HSK-E50/GMR12/85	●	12	29	32	40	85	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	0.9
HSK-E50/GMR16/90	●	16	35	38	41.5	90	52.5	42.5	49	TR-4.0	M12x1.0(T-6.0)	1.0
HSK-E50/GMR20/90	●	20	39	41.5	41.5	90	52.5	42.5	64	TR-4.0	M12x1.0(T-6.0)	1.1

Availability: ● Stock ▲ Short lead time ○ Made to order

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(GRIP torque wrench is recommended.)
- »Data carrier and Coolant tube as an option.
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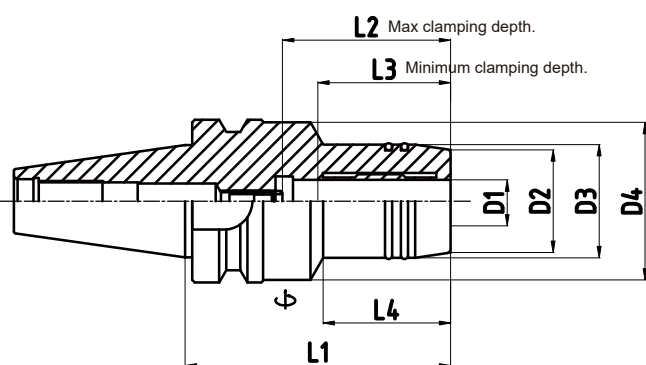
HSK-E40/E50

Dimensions(mm)

BT30		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT30/GMR6/70	●	6	23	26	44.5	70	37.5	27.5	28	TR-4.0	M5x0.8(T-2.5)	0.7
BT30/GMR8/70	●	8	25	28	44.5	70	37.5	27.5	28	TR-4.0	M6x1.0(T-3.0)	0.8
BT30/GMR10/75	●	10	27	30	44.5	75	42.5	32.5	36	TR-4.0	M8x1.0(T-4.0)	0.8
BT30/GMR12/75	●	12	29	32	44.5	75	47.5	37.5	36	TR-4.0	M10x1.0(T-5.0)	0.9
BT30/GMR14/85	●	14	31	34	44.5	85	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	0.9
BT30/GMR16/90	●	16	35	38	44.5	90	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.0
BT30/GMR18/90	●	18	37	40	44.5	90	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.0
BT30/GMR20/90	●	20	39	42	44.5	90	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.0

Availability: ● Stock ▲ Short lead time ○ Made to order

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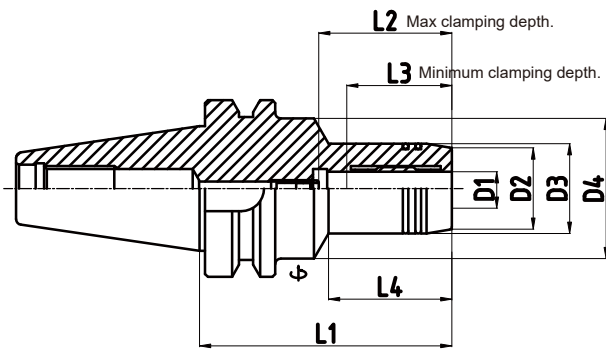
BT30

 Dimensions(mm)

BT40		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT40/GMR6/65	●	6	23	26	50	65	37.5	27.5	23	TR-4.0	M5x0.8(T-2.5)	1.3
BT40/GMR6/90	●	6	23	26	50	90	37.5	27.5	44	TR-4.0	M5x0.8(T-2.5)	1.4
BT40/GMR6/140	●	6	23	26	50	140	37.5	27.5	44	TR-4.0	M5x0.8(T-2.5)	2.2
BT40/GMR8/65	●	8	25	28	50	65	37.5	27.5	23	TR-4.0	M6x1.0(T-3.0)	1.3
BT40/GMR8/90	●	8	25	28	50	90	37.5	27.5	44	TR-4.0	M6x1.0(T-3.0)	1.5
BT40/GMR8/140	●	8	25	28	50	140	37.5	27.5	44	TR-4.0	M6x1.0(T-3.0)	2.3
BT40/GMR10/65	●	10	27	30	50	65	42.5	32.5	23	TR-4.0	M8x1.0(T-4.0)	1.3
BT40/GMR10/90	●	10	27	30	50	90	42.5	32.5	44	TR-4.0	M8x1.0(T-4.0)	1.5
BT40/GMR10/140	●	10	27	30	50	140	42.5	32.5	44	TR-4.0	M8x1.0(T-4.0)	2.3
BT40/GMR12/65	●	12	29	32	50	65	47.5	37.5	23	TR-4.0	M10x1.0(T-5.0)	1.3
BT40/GMR12/90	●	12	29	32	50	90	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	1.5
BT40/GMR12/140	●	12	29	32	50	140	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	2.3
BT40/GMR14/65	●	14	31	34	50	65	47.5	37.5	23	TR-4.0	M10x1.0(T-5.0)	1.4
BT40/GMR14/90	●	14	31	34	50	90	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	1.6
BT40/GMR14/140	●	14	31	34	50	140	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	2.4
BT40/GMR16/65	●	16	35	38	50	65	52.5	42.5	23	TR-4.0	M12x1.0(T-6.0)	1.4
BT40/GMR16/90	●	16	35	38	50	90	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.6
BT40/GMR16/140	●	16	35	38	50	140	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	2.4
BT40/GMR18/75	●	18	37	40	50	75	52.5	42.5	30	TR-4.0	M12x1.0(T-6.0)	1.5
BT40/GMR18/90	●	18	37	40	50	90	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.7
BT40/GMR18/140	●	18	37	40	50	140	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	2.4
BT40/GMR20/75	●	20	39	42	50	75	52.5	42.5	30	TR-5.0	M16x1.0(T-6.0)	1.5
BT40/GMR20/90	●	20	39	42	50	90	52.5	42.5	48	TR-5.0	M16x1.0(T-6.0)	1.7
BT40/GMR20/140	●	20	39	42	50	140	52.5	42.5	48	TR-5.0	M16x1.0(T-6.0)	2.4
BT40/GMR25/100	●	25	53	57	-	100	61	51	-	TR-5.0	M16x1.0(T-6.0)	2.2
BT40/GMR25/135	●	25	53	57	-	135	61	51	-	TR-5.0	M16x1.0(T-6.0)	2.9
BT40/GMR32/105	●	32	58	62	-	105	65	55	-	TR-5.0	M16x1.0(T-6.0)	2.4
BT40/GMR32/135	●	32	58	62	-	135	65	55	-	TR-5.0	M16x1.0(T-6.0)	3.1

Availability: ● Stock ▲ Short lead time ○ Made to order

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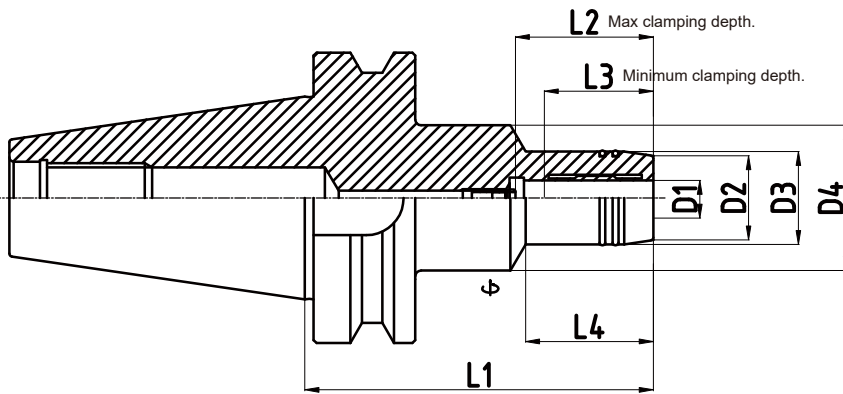
BT40

≡ Dimensions(mm)

BT50		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT50/GMR6/90	●	6	23	26	50	90	37.5	27.5	32	TR-4.0	M5x0.8(T-2.5)	4.2
BT50/GMR6/120	●	6	23	26	50	120	37.5	27.5	44	TR-4.0	M5x0.8(T-2.5)	4.5
BT50/GMR6/140	●	6	23	26	50	140	37.5	27.5	44	TR-4.0	M5x0.8(T-2.5)	4.8
BT50/GMR8/90	●	8	25	28	50	90	37.5	27.5	32	TR-4.0	M6x1.0(T-3.0)	4.2
BT50/GMR8/120	●	8	25	28	50	120	37.5	27.5	44	TR-4.0	M6x1.0(T-3.0)	4.5
BT50/GMR8/140	●	8	25	28	50	140	37.5	27.5	44	TR-4.0	M6x1.0(T-3.0)	4.8
BT50/GMR10/90	●	10	27	30	50	90	42.5	32.5	32	TR-4.0	M8x1.0(T-4.0)	4.2
BT50/GMR10/120	●	10	27	30	50	120	42.5	32.5	44	TR-4.0	M8x1.0(T-4.0)	4.5
BT50/GMR10/140	●	10	27	30	50	140	42.5	32.5	44	TR-4.0	M8x1.0(T-4.0)	4.8
BT50/GMR12/90	●	12	29	32	50	90	47.5	37.5	32	TR-4.0	M10x1.0(T-5.0)	4.3
BT50/GMR12/120	●	12	29	32	50	120	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	4.5
BT50/GMR12/140	●	12	29	32	50	140	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	4.8
BT50/GMR14/90	●	14	31	34	50	90	47.5	37.5	32	TR-4.0	M10x1.0(T-5.0)	4.3
BT50/GMR14/120	●	14	31	34	50	120	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	4.6
BT50/GMR14/140	●	14	31	34	50	140	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	4.8
BT50/GMR16/90	●	16	35	38	50	90	52.5	42.5	32	TR-4.0	M12x1.0(T-6.0)	4.3
BT50/GMR16/120	●	16	35	38	50	120	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	4.6
BT50/GMR16/140	●	16	35	38	50	140	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	4.9
BT50/GMR18/90	●	18	37	40	50	90	52.5	42.5	32	TR-4.0	M12x1.0(T-6.0)	4.4
BT50/GMR18/120	●	18	37	40	50	120	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	4.6
BT50/GMR18/140	●	18	37	40	50	140	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	4.9
BT50/GMR20/90	●	20	39	42	50	90	52.5	42.5	32	TR-5.0	M16x1.0(T-6.0)	4.4
BT50/GMR20/120	●	20	39	42	50	120	52.5	42.5	48	TR-5.0	M16x1.0(T-6.0)	4.7
BT50/GMR20/140	●	20	39	42	50	140	52.5	42.5	48	TR-5.0	M16x1.0(T-6.0)	4.9
BT50/GMR25/105	●	25	53	57	-	105	61	51	-	TR-5.0	M16x1.0(T-6.0)	4.8
BT50/GMR25/150	●	25	53	57	-	150	61	51	-	TR-5.0	M16x1.0(T-6.0)	5.6
BT50/GMR32/115	●	32	58	62	-	115	65	55	-	TR-5.0	M16x1.0(T-6.0)	5.1
BT50/GMR32/150	●	32	58	62	-	150	65	55	-	TR-5.0	M16x1.0(T-6.0)	5.8

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
 - »Tool length can be adjusted up to 10mm.
 - »T-wrench is must be ordered separately.
(GRIP torque wrench is recommended.)
 - »All products center through coolant system.
 - »Additional sizes and special designs available on request.
- ⚠ The minimum tool depth must be observed.



BT50

≡ Dimensions(mm)

SK40		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
SK40/GMR6/80.5	●	6	23	26	50	80.5	37.5	27.5	44	TR-4.0	M5x0.8(T-2.5)	1.3
SK40/GMR6/110	●	6	23	26	50	110	37.5	27.5	44	TR-4.0	M5x0.8(T-2.5)	1.7
SK40/GMR8/80.5	●	8	25	28	50	80.5	37.5	27.5	44	TR-4.0	M6x1.0(T-3.0)	1.3
SK40/GMR8/110	●	8	25	28	50	110	37.5	27.5	44	TR-4.0	M6x1.0(T-3.0)	1.7
SK40/GMR10/80.5	●	10	27	30	50	80.5	42.5	32.5	44	TR-4.0	M8x1.0(T-4.0)	1.3
SK40/GMR10/110	●	10	27	30	50	110	42.5	32.5	44	TR-4.0	M8x1.0(T-4.0)	1.8
SK40/GMR12/80.5	●	12	29	32	50	80.5	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	1.3
SK40/GMR12/110	●	12	29	32	50	110	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	1.8
SK40/GMR14/80.5	●	14	31	34	50	80.5	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	1.3
SK40/GMR14/110	●	14	31	34	50	110	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	1.8
SK40/GMR16/80.5	●	16	35	38	50	80.5	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.4
SK40/GMR16/110	●	16	35	38	50	110	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.9
SK40/GMR18/80.5	●	18	37	40	50	80.5	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.4
SK40/GMR18/110	●	18	37	40	50	110	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.9
SK40/GMR20/80.5	●	20	39	42	50	80.5	52.5	42.5	48	TR-5.0	M16x1.0(T-6.0)	1.4
SK40/GMR20/110	●	20	39	42	50	110	52.5	42.5	48	TR-5.0	M16x1.0(T-6.0)	2.0
SK40/GMR25/80.5	●	25	51	55	66	80.5	61	51	26	TR-5.0	M16x1.0(T-6.0)	1.8
SK40/GMR32/80.5	●	32	58	62	80	80.5	65	55	26	TR-5.0	M16x1.0(T-6.0)	2.2

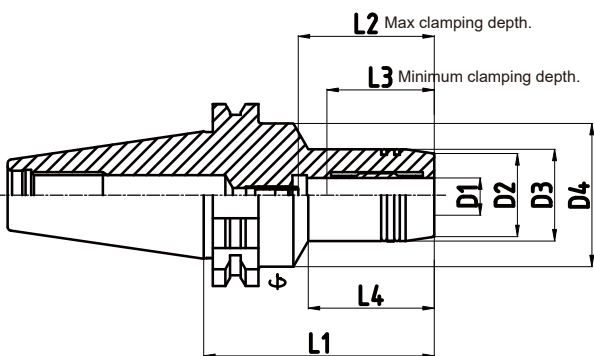
Availability: ● Stock ▲ Short lead time ○ Made to order

Dimensions(mm)

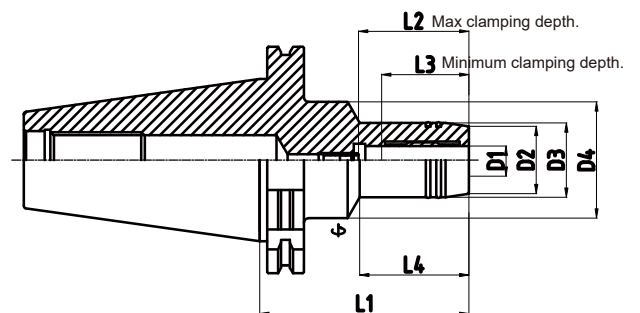
SK50		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
SK50/GMR12/90	●	12	29	32	50	90	47.5	37.5	47	TR-4.0	M6x1.0(T-3.0)	3.4
SK50/GMR12/140	●	12	29	32	50	140	47.5	37.5	47	TR-4.0	M6x1.0(T-3.0)	4.1
SK50/GMR20/90	●	20	39	42	50	90	52.5	42.5	48	TR-5.0	M16x1.0(T-6.0)	3.5
SK50/GMR20/140	●	20	39	42	50	140	52.5	42.5	48	TR-5.0	M16x1.0(T-6.0)	4.2
SK50/GMR32/115	●	32	58	63	-	115	65	55	-	TR-5.0	M16x1.0(T-6.0)	4.9
SK50/GMR32/140	●	32	58	63	-	140	65	55	-	TR-5.0	M16x1.0(T-6.0)	5.5

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
 - »Tool length can be adjusted up to 10mm.
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 - »All products center through coolant system.
 - »Additional sizes and special designs available on request.
- ⚠ The minimum tool depth must be observed.



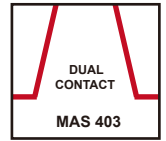
SK40



SK50

Dual Contact Type

BT-DC type holder can be used for BT double contact spindle and also used for BT standard spindle.



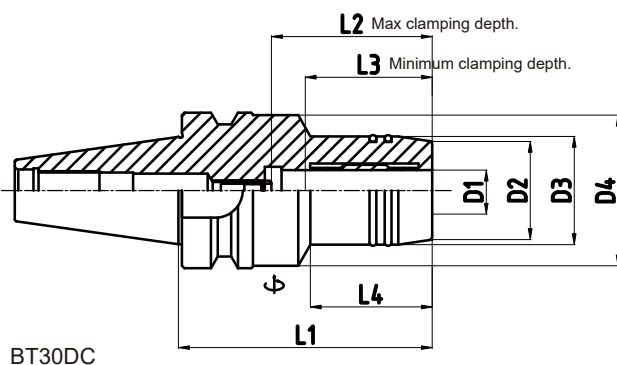
Dimensions(mm)

BT30DC		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT30DC/GMR6/70	●	6	23	26	44.5	70	37.5	27.5	28	TR-4.0	M5x0.8(T-2.5)	0.7
BT30DC/GMR8/70	●	8	25	28	44.5	70	37.5	27.5	28	TR-4.0	M6x1.0(T-3.0)	0.8
BT30DC/GMR10/75	●	10	27	30	44.5	75	42.5	32.5	36	TR-4.0	M8x1.0(T-4.0)	0.8
BT30DC/GMR12/75	●	12	29	32	44.5	75	47.5	37.5	36	TR-4.0	M10x1.0(T-5.0)	0.9
BT30DC/GMR14/85	●	14	31	34	44.5	85	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	0.9
BT30DC/GMR16/90	●	16	35	38	44.5	90	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.0
BT30DC/GMR18/90	●	18	37	40	44.5	90	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.0
BT30DC/GMR20/90	●	20	39	42	44.5	90	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.1

Availability: ● Stock ▲ Short lead time ○ Made to order

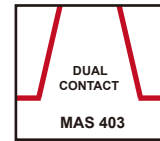
- »h6 shank tools must be used.
- »Tool length can be adjusted up to 10mm.
- »T-wrench is must be ordered separately.
(GRIP torque wrench is recommended.)
- »All products center through coolant system.
- »Additional sizes and special designs available on request.
- »BT-DC type holder can be used for BT double contact spindle and also used for BT standard spindle.

⚠ The minimum tool depth must be observed.



BT30DC

BT-DC type holder can be used for BT double contact spindle and also used for BT standard spindle.



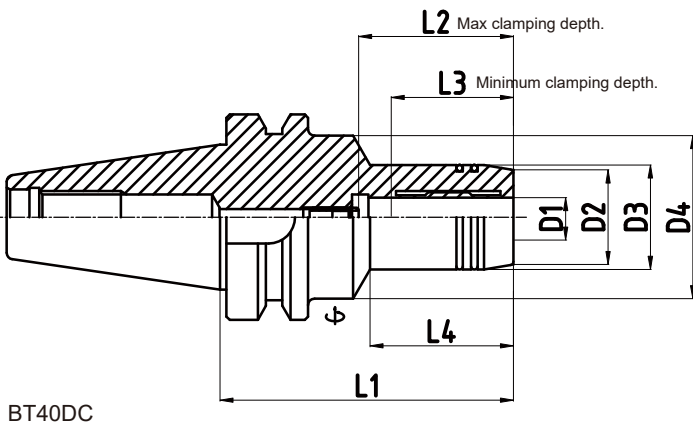
Dimensions(mm)

BT40DC		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT40DC/GMR6/90	●	6	23	26	50	90	37.5	27.5	44	TR-4.0	M5x0.8(T-2.5)	1.5
BT40DC/GMR8/90	●	8	25	28	50	90	37.5	27.5	44	TR-4.0	M6x1.0(T-3.0)	1.5
BT40DC/GMR10/90	●	10	27	30	50	90	42.5	32.5	44	TR-4.0	M8x1.0(T-4.0)	1.5
BT40DC/GMR12/90	●	12	29	32	50	90	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	1.5
BT40DC/GMR14/90	●	14	31	34	50	90	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	1.6
BT40DC/GMR16/90	●	16	35	38	50	90	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.6
BT40DC/GMR18/90	●	18	37	40	50	90	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	1.6
BT40DC/GMR20/90	●	20	39	42	50	90	52.5	42.5	48	TR-5.0	M16x1.0(T-6.0)	1.6
BT40DC/GMR25/100	●	25	53	57	-	100	61	51	-	TR-5.0	M16x1.0(T-6.0)	2.2
BT40DC/GMR32/105	●	32	58	63	-	105	65	55	-	TR-5.0	M16x1.0(T-6.0)	2.4

Availability: ● Stock ▲ Short lead time ○ Made to order

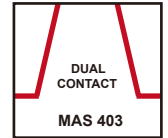
- »h6 shank tools must be used.
- »Tool length can be adjusted up to 10mm.
- »T-wrench is must be ordered separately. (GRIP torque wrench is recommended.)
- »All products center through coolant system.
- »Additional sizes and special designs available on request.
- »BT-DC type holder can be used for BT double contact spindle and also used for BT standard spindle.

⚠ The minimum tool depth must be observed.



BT40DC

Dual Contact Type



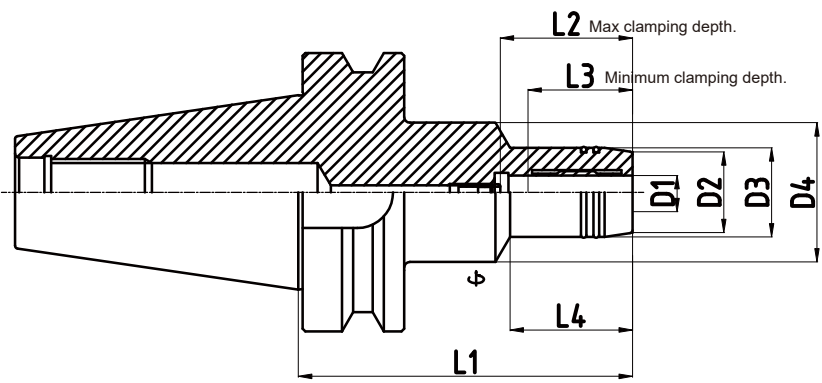
BT-DC type holder can be used for BT double contact spindle and also used for BT standard spindle.

Dimensions(mm)

BT50DC		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT50DC/GMR6/90	●	6	23	26	50	90	37.5	27.5	32	TR-4.0	M5x0.8(T-2.5)	4.2
BT50DC/GMR6/140	●	6	23	26	50	140	37.5	27.5	44	TR-4.0	M5x0.8(T-2.5)	4.8
BT50DC/GMR8/90	●	8	25	28	50	90	37.5	27.5	32	TR-4.0	M6x1.0(T-3.0)	4.2
BT50DC/GMR8/140	●	8	25	28	50	140	37.5	27.5	44	TR-4.0	M6x1.0(T-3.0)	4.8
BT50DC/GMR10/90	●	10	27	30	50	90	42.5	32.5	32	TR-4.0	M8x1.0(T-4.0)	4.3
BT50DC/GMR10/140	●	10	27	30	50	140	42.5	32.5	44	TR-4.0	M8x1.0(T-4.0)	4.9
BT50DC/GMR12/90	●	12	29	32	50	90	47.5	37.5	32	TR-4.0	M10x1.0(T-5.0)	4.3
BT50DC/GMR12/140	●	12	29	32	50	140	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	4.9
BT50DC/GMR14/90	●	14	31	34	50	90	47.5	37.5	32	TR-4.0	M10x1.0(T-5.0)	4.3
BT50DC/GMR14/140	●	14	31	34	50	140	47.5	37.5	44	TR-4.0	M10x1.0(T-5.0)	4.9
BT50DC/GMR16/90	●	16	35	38	50	90	52.5	42.5	32	TR-4.0	M12x1.0(T-6.0)	4.4
BT50DC/GMR16/140	●	16	35	38	50	140	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	5.0
BT50DC/GMR18/90	●	18	37	40	50	90	52.5	42.5	32	TR-4.0	M12x1.0(T-6.0)	4.4
BT50DC/GMR18/140	●	18	37	40	50	140	52.5	42.5	48	TR-4.0	M12x1.0(T-6.0)	5.0
BT50DC/GMR20/90	●	20	39	42	50	90	52.5	42.5	32	TR-5.0	M16x1.0(T-6.0)	4.4
BT50DC/GMR20/140	●	20	39	42	50	140	52.5	42.5	48	TR-5.0	M16x1.0(T-6.0)	5.0
BT50DC/GMR25/105	●	25	53	57	-	105	61	51	-	TR-5.0	M16x1.0(T-6.0)	4.9
BT50DC/GMR25/150	●	25	53	57	-	150	61	51	-	TR-5.0	M16x1.0(T-6.0)	5.5
BT50DC/GMR32/115	●	32	58	63	-	115	65	55	-	TR-5.0	M16x1.0(T-6.0)	5.1
BT50DC/GMR32/150	●	32	58	63	-	150	65	55	-	TR-5.0	M16x1.0(T-6.0)	5.9

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
 - »Tool length can be adjusted up to 10mm.
 - »T-wrench is must be ordered separately.
(GRIP torque wrench is recommended.)
 - »All products center through coolant system.
 - »Additional sizes and special designs available on request.
 - »BT-DC type holder can be used for BT double contact spindle and also used for BT standard spindle.
- ⚠ The minimum tool depth must be observed.



BT50DC

Inch size

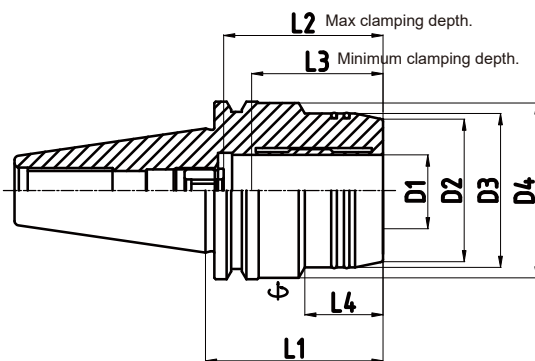
≡ Dimensions(mm)

CAT40		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
CAT40/GMR037/0250	●	9.525	27.3	40	-	63.5	42.5	32.5	44.45	TR-4.0	M8x1.0(T-4.0)	1.3
CAT40/GMR050/0254	●	12.7	32	42	-	64.5	46	36	45.45	TR-4.0	M8x1.0(T-4.0)	1.3
CAT40/GMR062/0250	●	15.875	34.6	44.5	-	63.5	52.5	42.5	44.45	TR-4.0	M12x1.0(T-6.0)	1.3
CAT40/GMR075/0254	●	19.05	38	49.25	-	64.5	51	41	45.45	TR-5.0	M8x1.0(T-4.0)	1.4
CAT40/GMR100/0250	●	25.4	51	55	62.5	63.5	57	47	28	TR-5.0	M16x1.0(T-6.0)	1.5
CAT40/GMR125/0400	●	31.75	58	62	-	101.6	61	51	82.55	TR-5.0	M16x1.0(T-6.0)	2.3

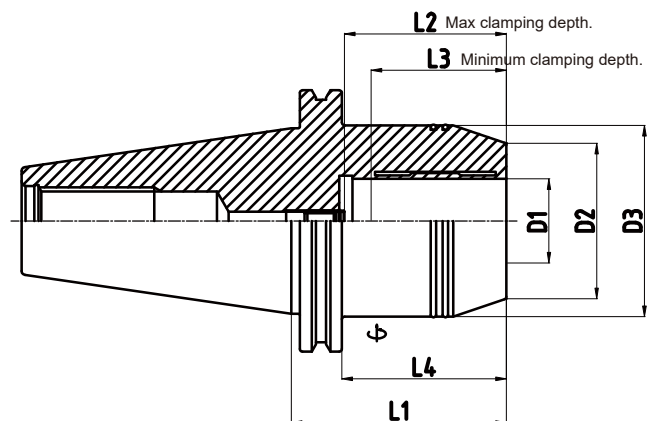
CAT50												
CAT50/GMR075/0319	●	19.05	38	49.25	-	81	51	41	61.95	TR-5.0	M8x1.0(T-4.0)	3.5
CAT50/GMR125/0319	●	31.75	58.5	72	-	81	61	51	61.95	TR-5.0	M8x1.0(T-4.0)	4.2

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
 - »Tool length can be adjusted up to 10mm.
 - »T-wrench is must be ordered separately.
(GRIP torque wrench is recommended.)
 - »All products center through coolant system.
 - »Additional sizes and special designs available on request.
- ⚠ The minimum tool depth must be observed.



CAT40



CAT50

Inch size

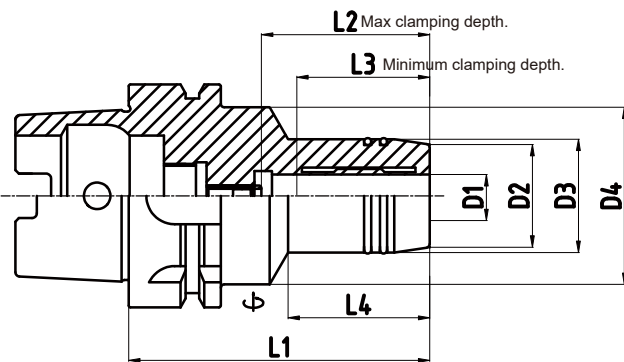
≡ Dimensions(mm)

HSK-A63		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A63/GMR050/0315	●	12.7	32	42	52.5	80	46	36	34	TR-4.0	M8x1.0(T-4.0)	1.3
HSK-A63/GMR075/0315	●	19.05	38	52.5	-	80	51	41	54	TR-5.0	M8x1.0(T-4.0)	1.4

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
- »Tool length can be adjusted up to 10mm.
- »T-wrench is must be ordered separately.
(GRIP torque wrench is recommended.)
- »Data carrier and Coolant tube as an option.
- »All products center through coolant system.
- »Additional sizes and special designs available on request.

⚠ The minimum tool depth must be observed.



HSK-A63

www.gripkorea.com



A graphic consisting of two parallel red horizontal lines.

HYDRO-SLIM

Slim and high-precision. Optimized interfering contours.

New!!

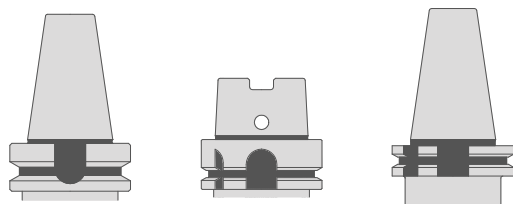
More Various product line-up



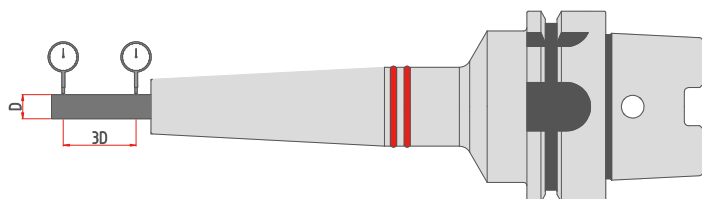
HYDRO-SLIM

Optimized interfering contours, which results in excellent work piece accessibility.

ID6~20 size
Various types of tapers.

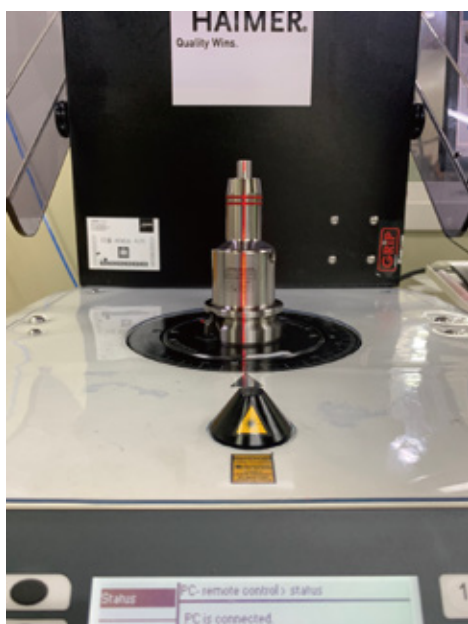


Standard Run-Out 3xd 3Micron.



All item Fine balancing.

All item G2.5 grade balancing quality



SLIM

⇒ No expensive clamping device required.

	Tool setting time	Clamping device	User risk level
HYDRO-SLIM	10 sec	No need	No problem
Shrink fit holder	3 min	Expansive device	Danger of burns

SLIMS

⇒ Reduce inventory amount of tool holder by using Sleeve.



GSL8 and GSL12 types can use various shanks by using hydro-sleeve.



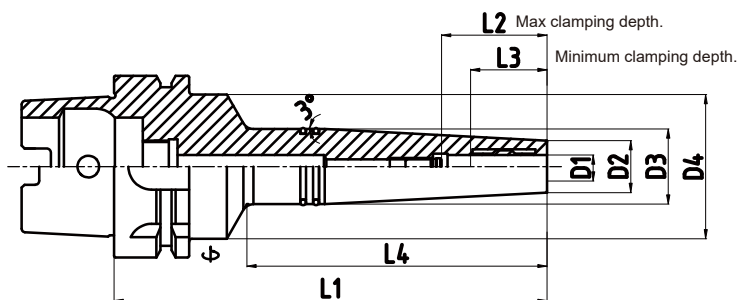
⇒ Easy clamping with just one wrench

Dimensions(mm)

HSK-A50		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A50/GSL6/110	▲	6	16	24	41.5	110	37.5	27.5	66	TR-4.0	M5x0.8(T-2.5)	0.7
HSK-A50/GSL8/110	▲	8	18	26	41.5	110	37.5	27.5	66	TR-4.0	M6x1.0(T-3.0)	0.7
HSK-A50/GSL10/110	▲	10	20	28	41.5	110	42.5	32.5	67	TR-4.0	M8x1.0(T-4.0)	0.8
HSK-A50/GSL12/110	▲	12	22	30	41.5	110	47.5	37.5	67	TR-4.0	M10x1.0(T-5.0)	0.9

HSK-A63		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A63/GSL6/150	●	6	16	24	50	150	37.5	27.5	103	TR-4.0	M5x0.8(T-2.5)	1.3
HSK-A63/GSL8/150	●	8	18	26	50	150	37.5	27.5	104	TR-4.0	M6x1.0(T-3.0)	1.3
HSK-A63/GSL10/150	●	10	20	28	50	150	42.5	32.5	104	TR-4.0	M8x1.0(T-4.0)	1.4
HSK-A63/GSL12/150	●	12	22	30	50	150	47.5	37.5	105	TR-4.0	M10x1.0(T-5.0)	1.5
HSK-A63/GSL14/150	●	14	24	32	50	150	47.5	37.5	105	TR-4.0	M10x1.0(T-5.0)	1.5
HSK-A63/GSL16/150	●	16	26	34	50	150	52.5	42.5	106	TR-4.0	M12x1.0(T-6.0)	1.6
HSK-A63/GSL18/150	●	18	28	36	50	150	52.5	42.5	107	TR-4.0	M12x1.0(T-6.0)	1.6
HSK-A63/GSL20/150	●	20	30	38	50	150	52.5	42.5	108	TR-4.0	M16x1.0(T-6.0)	1.7

Availability: ● Stock ▲ Short lead time ○ Made to order



HSK-A50/A63

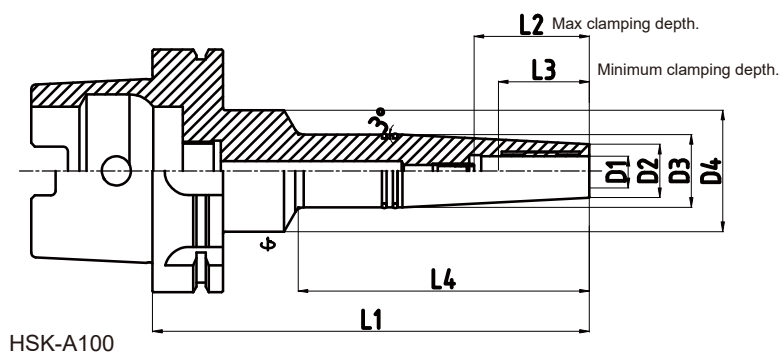
Dimensions(mm)

HSK-A100		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A100/GSL6/180	●	6	16	24	50	180	37.5	27.5	120	TR-4.0	M5x0.8(T-2.5)	3.0
HSK-A100/GSL8/180	●	8	18	26	50	180	37.5	27.5	120	TR-4.0	M6x1.0(T-3.0)	3.1
HSK-A100/GSL10/180	○	10	20	28	50	180	42.5	32.5	120	TR-4.0	M8x1.0(T-4.0)	3.1
HSK-A100/GSL12/180	●	12	22	30	50	180	47.5	37.5	120	TR-4.0	M10x1.0(T-5.0)	3.2
HSK-A100/GSL14/180	○	14	24	32	50	180	47.5	37.5	121	TR-4.0	M10x1.0(T-5.0)	3.2
HSK-A100/GSL16/180	○	16	26	34	50	180	52.5	42.5	121	TR-4.0	M12x1.0(T-6.0)	3.3
HSK-A100/GSL18/180	○	18	28	36	50	180	52.5	42.5	122	TR-4.0	M12x1.0(T-6.0)	3.4
HSK-A100/GSL20/180	●	20	30	38	50	180	52.5	42.5	122	TR-4.0	M16x1.0(T-6.0)	3.4

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
- »Tool length can be adjusted up to 10mm.
- »T-wrench is must be ordered separately. (GRIP torque wrench is recommended.)
- »Data carrier and Coolant tube as an option.
- »All products center through coolant system.
- »Additional sizes and special designs available on request.

⚠ The minimum tool depth must be observed.



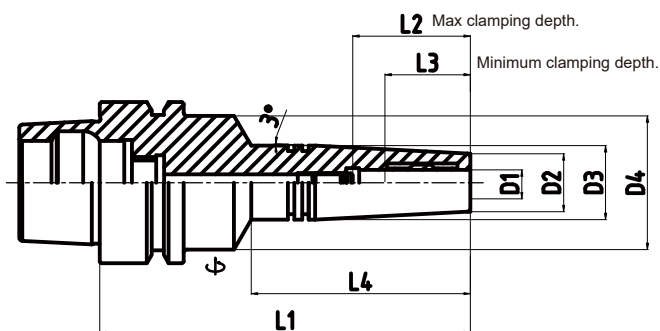
Dimensions(mm)

HSK-E50		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-E50/GSL6/110	○	6	16	24	41.5	110	37.5	27.5	66	TR-4.0	M5x0.8(T-2.5)	0.7
HSK-E50/GSL8/110	○	8	18	26	41.5	110	37.5	27.5	66	TR-4.0	M6x1.0(T-3.0)	0.8
HSK-E50/GSL10/110	○	10	20	28	41.5	110	42.5	32.5	67	TR-4.0	M8x1.0(T-4.0)	0.8
HSK-E50/GSL12/110	○	12	22	30	41.5	110	47.5	37.5	67	TR-4.0	M10x1.0(T-5.0)	0.9

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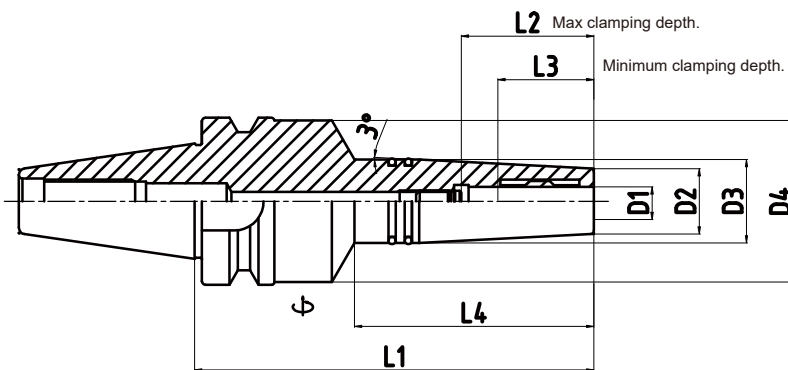
HSK-E50

Dimensions(mm)

BT30		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT30/GSL6/110	●	6	16	24	44.5	110	37.5	27.5	66	TR-4.0	M5x0.8(T-2.5)	0.9
BT30/GSL8/110	●	8	18	26	44.5	110	37.5	27.5	66	TR-4.0	M6x1.0(T-3.0)	0.9
BT30/GSL10/110	●	10	20	28	44.5	110	42.5	32.5	67	TR-4.0	M8x1.0(T-4.0)	1.1
BT30/GSL12/110	●	12	22	30	44.5	110	47.5	37.5	67	TR-4.0	M10x1.0(T-5.0)	1.2

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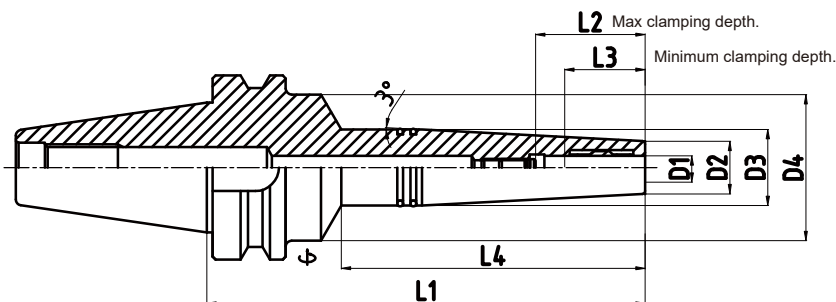
BT30

Dimensions(mm)

BT40		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT40/GSL6/150	●	6	16	24	50	150	37.5	27.5	103	TR-4.0	M5x0.8(T-2.5)	1.6
BT40/GSL8/150	●	8	18	26	50	150	37.5	27.5	104	TR-4.0	M6x1.0(T-3.0)	1.7
BT40/GSL10/150	●	10	20	28	50	150	42.5	32.5	104	TR-4.0	M8x1.0(T-4.0)	1.7
BT40/GSL12/150	●	12	22	30	50	150	47.5	37.5	105	TR-4.0	M10x1.0(T-5.0)	1.8
BT40/GSL14/150	●	14	24	32	50	150	47.5	37.5	105	TR-4.0	M10x1.0(T-5.0)	1.8
BT40/GSL16/150	●	16	26	34	50	150	52.5	42.5	106	TR-4.0	M12x1.0(T-6.0)	1.9
BT40/GSL18/150	●	18	28	36	50	150	52.5	42.5	107	TR-4.0	M12x1.0(T-6.0)	1.9
BT40/GSL20/150	●	20	30	38	50	150	52.5	42.5	108	TR-4.0	M16x1.0(T-6.0)	2.0

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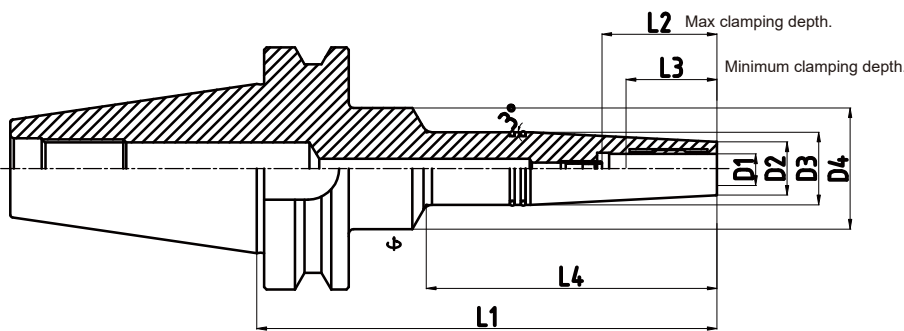
BT40

Dimensions(mm)

BT50		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT50/GSL6/190	○	6	16	24	50	190	37.5	27.5	120	TR-4.0	M5x0.8(T-2.5)	4.3
BT50/GSL8/190	○	8	18	26	50	190	37.5	27.5	120	TR-4.0	M6x1.0(T-3.0)	4.3
BT50/GSL10/190	○	10	20	28	50	190	42.5	32.5	120	TR-4.0	M8x1.0(T-4.0)	4.4
BT50/GSL12/190	○	12	22	30	50	190	47.5	37.5	120	TR-4.0	M10x1.0(T-5.0)	4.4
BT50/GSL14/190	○	14	24	32	50	190	47.5	37.5	121	TR-4.0	M10x1.0(T-5.0)	4.5
BT50/GSL16/190	○	16	26	34	50	190	52.5	42.5	121	TR-4.0	M12x1.0(T-6.0)	4.5
BT50/GSL18/190	○	18	28	36	50	190	52.5	42.5	122	TR-4.0	M12x1.0(T-6.0)	4.6
BT50/GSL20/190	○	20	30	38	50	190	52.5	42.5	122	TR-4.0	M16x1.0(T-6.0)	4.7

Availability: ● Stock ▲ Short lead time ○ Made to order

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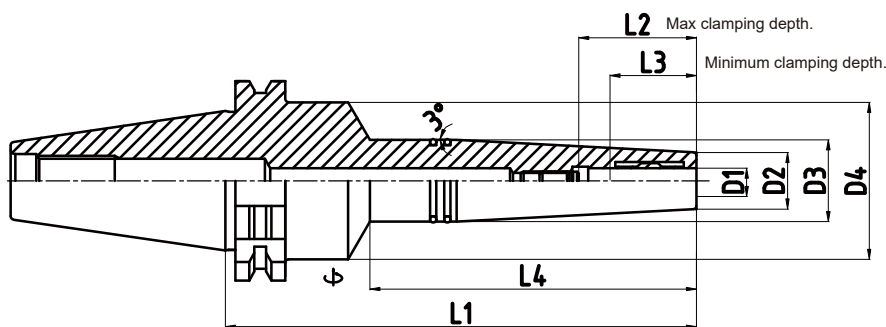
BT50

Dimensions(mm)

SK40		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
SK40/GSL6/150	●	6	16	24	50	150	37.5	27.5	103	TR-4.0	M5x0.8(T-2.5)	1.6
SK40/GSL8/150	●	8	18	26	50	150	37.5	27.5	104	TR-4.0	M6x1.0(T-3.0)	1.7
SK40/GSL10/150	●	10	20	28	50	150	42.5	32.5	104	TR-4.0	M8x1.0(T-4.0)	1.7
SK40/GSL12/150	●	12	22	30	50	150	47.5	37.5	105	TR-4.0	M10x1.0(T-5.0)	1.8
SK40/GSL14/150	●	14	24	32	50	150	47.5	37.5	105	TR-4.0	M10x1.0(T-5.0)	1.8
SK40/GSL16/150	●	16	26	34	50	150	52.5	42.5	106	TR-4.0	M12x1.0(T-6.0)	1.9
SK40/GSL18/150	●	18	28	36	50	150	52.5	42.5	107	TR-4.0	M12x1.0(T-6.0)	1.9
SK40/GSL20/150	●	20	30	38	50	150	52.5	42.5	108	TR-4.0	M16x1.0(T-6.0)	2.0

Availability: ● Stock ▲ Short lead time ○ Made to order

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SK40



www.gripkorea.com



A graphic consisting of two parallel red horizontal lines.

HYDRO-ZERO FIT

Zero run-out setting for optimum machining.

New!!

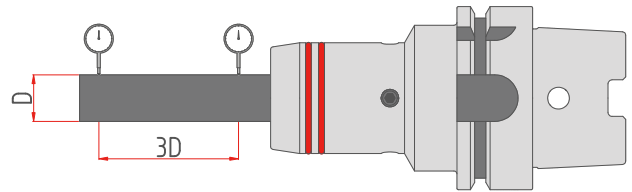
More Various product line-up



HYDRO-ZERO FIT

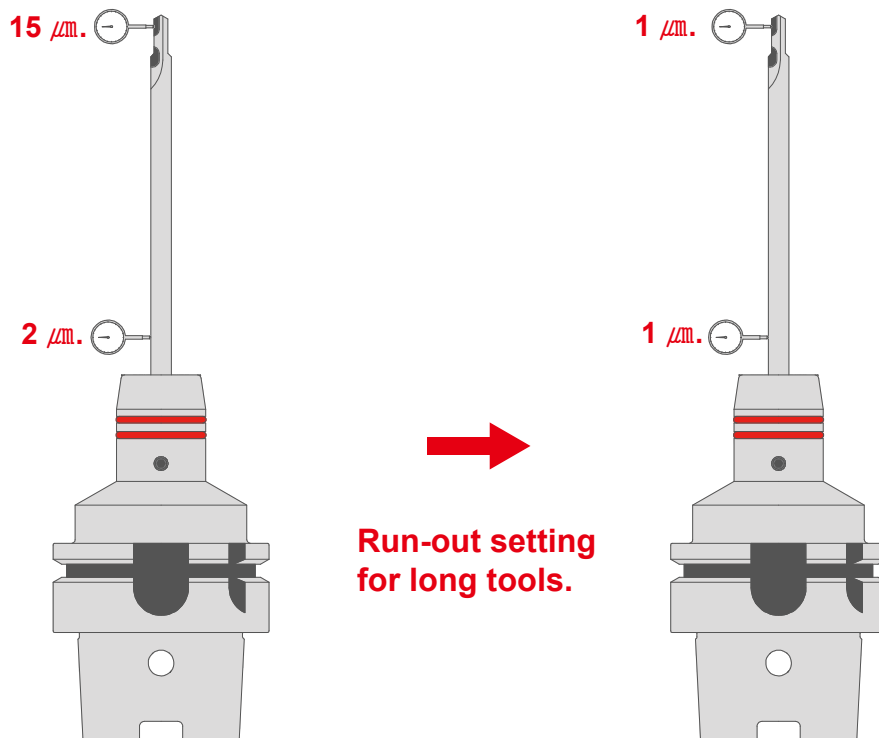
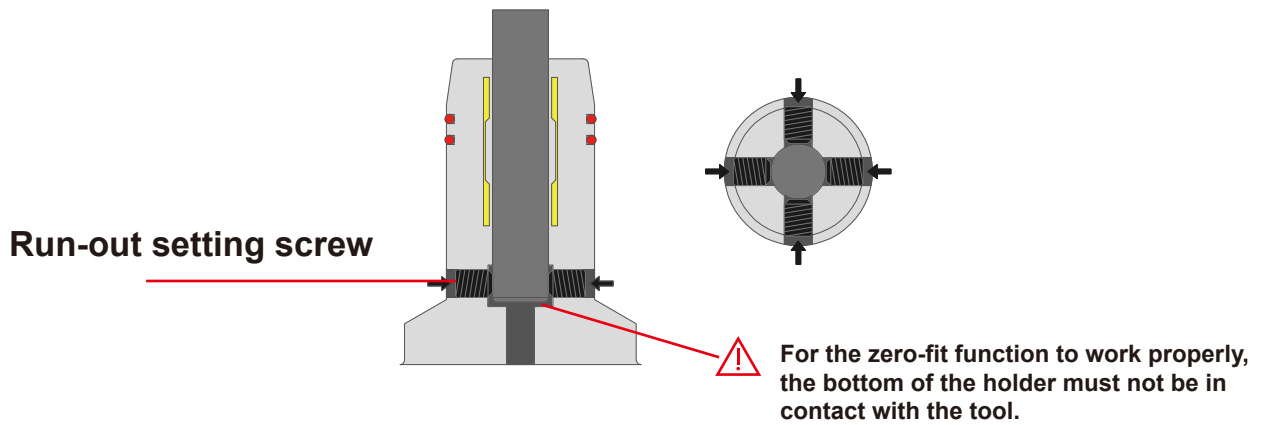
Standard Run-Out 3xd 3Micron.

Standard run-out 3 μm .
ID25/ ID32 run-out 5 μm .



ZERO Run-Out setting.

4pcs screws in 90 degree direction
for Run-out setting for more precise work.





ZERO Run-Out
setting video.



4pcs screws in 90 degree direction
for Run-out setting.

Clamping screw

How to use

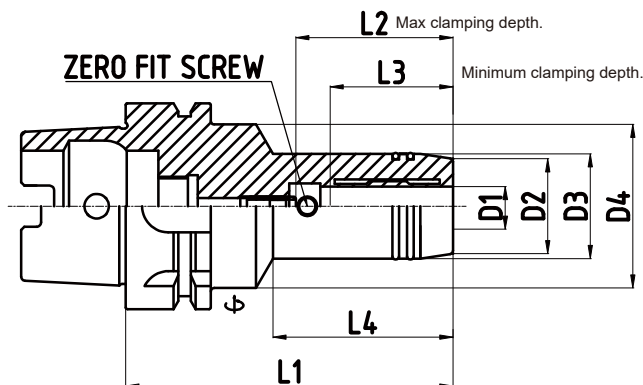
- 1step- Insert tool.
- 2step- Lock the clamping screw.
- 3step- Run-out check.
- 4step- Zero setting with 4-way run-out setting screw.

≡ Dimensions(mm)

HSK-A63		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A63/GZF6/90	●	6	23	26	50	90	41	31	44	TR-4.0	M5x0.8(T-2.5)	1.2
HSK-A63/GZF8/90	●	8	25	28	50	90	41	31	44	TR-4.0	M6x1.0(T-3.0)	1.2
HSK-A63/GZF10/95	●	10	27	30	50	95	48	38	50	TR-4.0	M8x1.0(T-4.0)	1.3
HSK-A63/GZF12/100	●	12	29	32	50	100	53	43	55	TR-4.0	M10x1.0(T-5.0)	1.3
HSK-A63/GZF16/105	●	16	35	38	50	105	58	48	61	TR-4.0	M12x1.0(T-6.0)	1.4
HSK-A63/GZF20/105	●	20	39	42	50	105	58	48	63	TR-5.0	M16x1.0(T-6.0)	1.5
HSK-A63/GZF25/115	●	25	46	50	-	115	66	56	89	TR-5.0	M16x1.0(T-6.0)	2.6
HSK-A63/GZF32/130	●	32	56	60	52.5	130	70	60	104	TR-5.0	M16x1.0(T-6.0)	3.2

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
- »Tool length can be adjusted up to 10mm.
(If you use the ZERO-FIT function, you cannot use the adjust screw.)
- »T-wrench is must be ordered separately.
(GRIP torque wrench is recommended.)
- »If you use the ZERO-FIT function, you cannot use the hydro-sleeve.
- »Data carrier and Coolant tube as an option.
- »All products center through coolant system.
- »Additional sizes and special designs available on request.
- ⚠ The minimum tool depth must be observed.



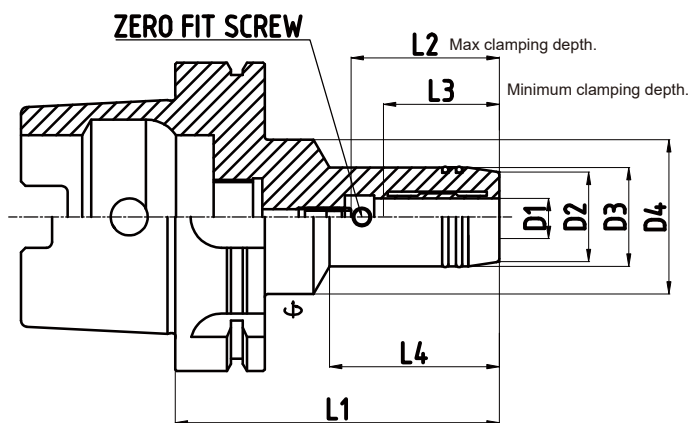
HSK63A

Dimensions(mm)

HSK-A100		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
HSK-A100/GZF6/95	○	6	23	26	50	95	41	31	46	TR-4.0	M5x0.8(T-2.5)	2.8
HSK-A100/GZF8/95	○	8	25	28	50	95	41	31	46	TR-4.0	M6x1.0(T-3.0)	2.8
HSK-A100/GZF10/100	○	10	27	30	50	100	48	38	52	TR-4.0	M8x1.0(T-4.0)	2.9
HSK-A100/GZF12/105	●	12	29	32	50	105	53	43	57	TR-4.0	M10x1.0(T-5.0)	3.0
HSK-A100/GZF16/110	○	16	35	38	50	110	58	48	63	TR-4.0	M12x1.0(T-6.0)	3.1
HSK-A100/GZF20/110	●	20	39	42	50	110	58	48	64	TR-5.0	M16x1.0(T-6.0)	3.4
HSK-A100/GZF25/120	○	25	53	57	63	120	67	57	72	TR-5.0	M16x1.0(T-6.0)	3.8
HSK-A100/GZF32/120	○	32	58	63	75	120	71	61	72	TR-5.0	M16x1.0(T-6.0)	4.2

Availability: ● Stock ▲ Short lead time ○ Made to order

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(GRIP torque wrench is recommended.)
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HSK100A

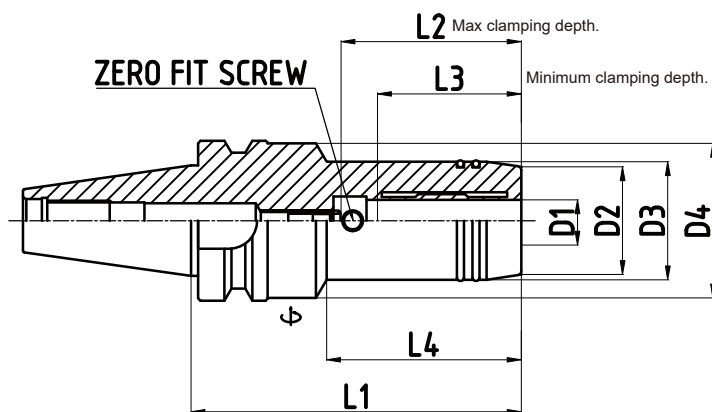
ZERO FIT

Dimensions(mm)

BT30		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT30/GZF6/90	●	6	23	26	44.5	90	41	31	48	TR-4.0	M5x0.8(T-2.5)	0.8
BT30/GZF8/90	●	8	25	28	44.5	90	41	31	48	TR-4.0	M6x1.0(T-3.0)	0.8
BT30/GZF10/90	●	10	27	30	44.5	90	48	38	51	TR-4.0	M8x1.0(T-4.0)	0.8
BT30/GZF12/95	●	12	29	32	44.5	95	53	43	56	TR-4.0	M10x1.0(T-5.0)	0.9
BT30/GZF16/100	●	16	35	38	44.5	100	58	48	58	TR-4.0	M12x1.0(T-6.0)	1.1
BT30/GZF20/105	●	20	39	42	44.5	105	58	48	63	TR-4.0	M12x1.0(T-6.0)	1.2

Availability: ● Stock ▲ Short lead time ○ Made to order

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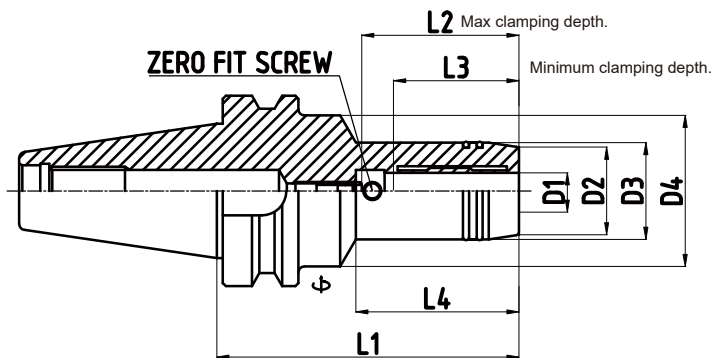
BT30

≡ Dimensions(mm)

BT40		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT40/GZF6/90	●	6	23	26	50	90	41	31	44	TR-4.0	M5x0.8(T-2.5)	1.4
BT40/GZF8/90	●	8	25	28	50	90	41	31	44	TR-4.0	M6x1.0(T-3.0)	1.4
BT40/GZF10/95	●	10	27	30	50	95	48	38	49	TR-4.0	M8x1.0(T-4.0)	1.5
BT40/GZF12/100	●	12	29	32	50	100	53	43	54	TR-4.0	M10x1.0(T-5.0)	1.6
BT40/GZF16/105	●	16	35	38	50	105	58	48	63	TR-4.0	M12x1.0(T-6.0)	1.7
BT40/GZF20/105	●	20	39	42	50	105	58	48	63	TR-5.0	M16x1.0(T-6.0)	1.8
BT40/GZF25/110	●	25	53	57	57	110	67	57	-	TR-5.0	M16x1.0(T-6.0)	2.3
BT40/GZF32/115	●	32	58	62	62	115	71	61	-	TR-5.0	M16x1.0(T-6.0)	2.6

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 - »If you use the ZERO-FIT function, you cannot use the hydro-sleeve.
 - »All products center through coolant system.
 - »Additional sizes and special designs available on request.
- ⚠ The minimum tool depth must be observed.



BT40

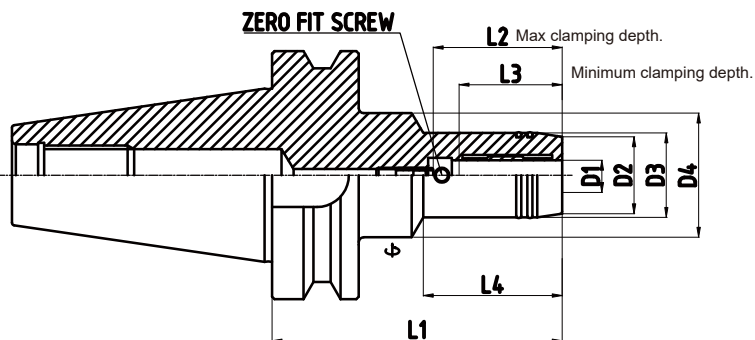
Dimensions(mm)

BT50		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT50/GZF6/105	▲	6	23	26	50	105	41	31	47	TR-4.0	M5x0.8(T-2.5)	4.2
BT50/GZF8/105	○	8	25	28	50	105	41	31	47	TR-4.0	M6x1.0(T-3.0)	4.2
BT50/GZF10/110	○	10	27	30	50	110	48	38	52	TR-4.0	M8x1.0(T-4.0)	4.3
BT50/GZF12/115	●	12	29	32	50	115	53	43	57	TR-4.0	M10x1.0(T-5.0)	4.3
BT50/GZF16/120	○	16	35	38	50	120	58	48	62	TR-4.0	M12x1.0(T-6.0)	4.5
BT50/GZF20/120	●	20	39	42	50	120	58	48	62	TR-5.0	M16x1.0(T-6.0)	4.6
BT50/GZF25/125	○	25	53	57	57	125	67	57	-	TR-5.0	M16x1.0(T-6.0)	5.2
BT50/GZF32/125	▲	32	58	62	62	125	71	61	-	TR-5.0	M16x1.0(T-6.0)	5.4

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
- »Tool length can be adjusted up to 10mm.
(If you use the ZERO-FIT function, you cannot use the adjust screw.)
- »T-wrench is must be ordered separately.
(GRIP torque wrench is recommended.)
- »If you use the ZERO-FIT function, you cannot use the hydro-sleeve.
- »All products center through coolant system.
- »Additional sizes and special designs available on request.

⚠ The minimum tool depth must be observed.



BT50

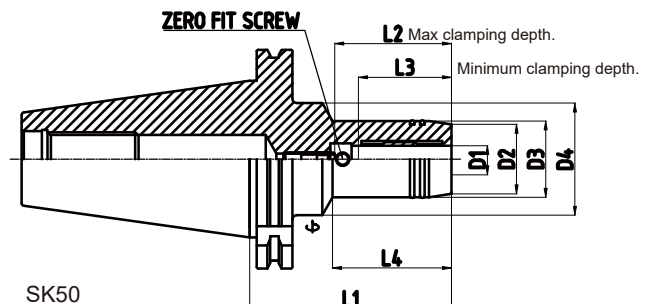
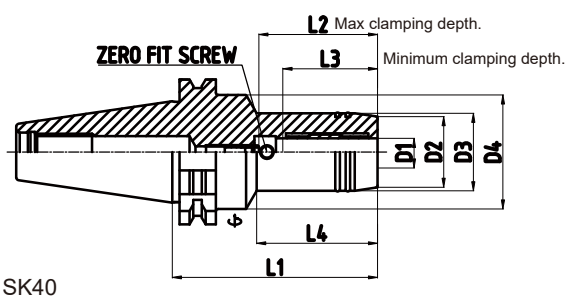
≡ Dimensions(mm)

SK40		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
SK40/GZF12/90	○	12	29	32	50	90	53	43	53	TR-4.0	M10x1.0(T-5.0)	1.4
SK40/GZF20/90	○	20	39	42	50	90	58	48	58	TR-4.0	M16x1.0(T-6.0)	1.5

SK50		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
SK50/GZF12/90	○	12	29	32	50	90	53	43	53	TR-4.0	M10x1.0(T-5.0)	3.4
SK50/GZF20/110	○	20	39	42	50	110	58	48	68	TR-5.0	M16x1.0(T-6.0)	3.6
SK50/GZF32/115	○	32	58	62	62	115	71	61	-	TR-5.0	M16x1.0(T-6.0)	4.9

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
 - »Tool length can be adjusted up to 10mm.
(If you use the ZERO-FIT function, you cannot use the adjust screw.)
 - »T-wrench is must be ordered separately.
(GRIP torque wrench is recommended.)
 - »If you use the ZERO-FIT function, you cannot use the hydro-sleeve.
 - »All products center through coolant system.
 - »Additional sizes and special designs available on request.
- ⚠ The minimum tool depth must be observed.



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HYDRO-PRESET

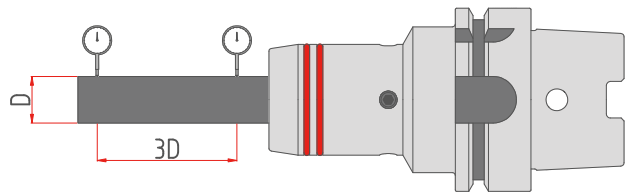
Radial Length Adjustment for micron precise positioning.



HYDRO-PRESET

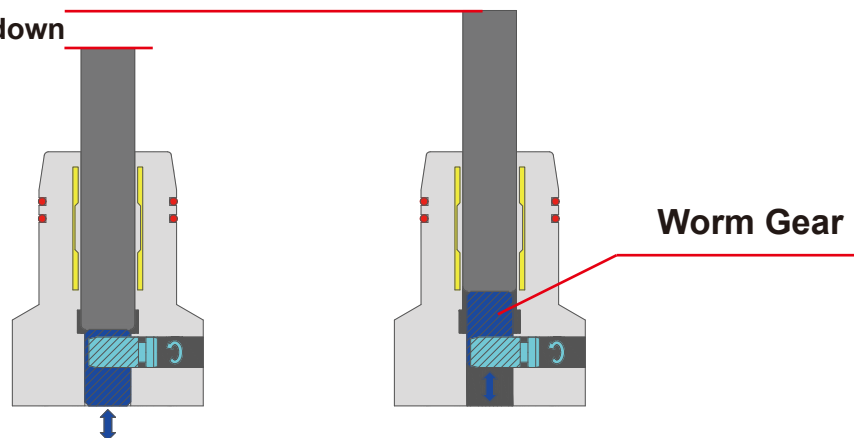
Standard Run-Out 3xd 3Micron.

Standard run-out 3 μm .
ID25/ ID32 run-out 5 μm .

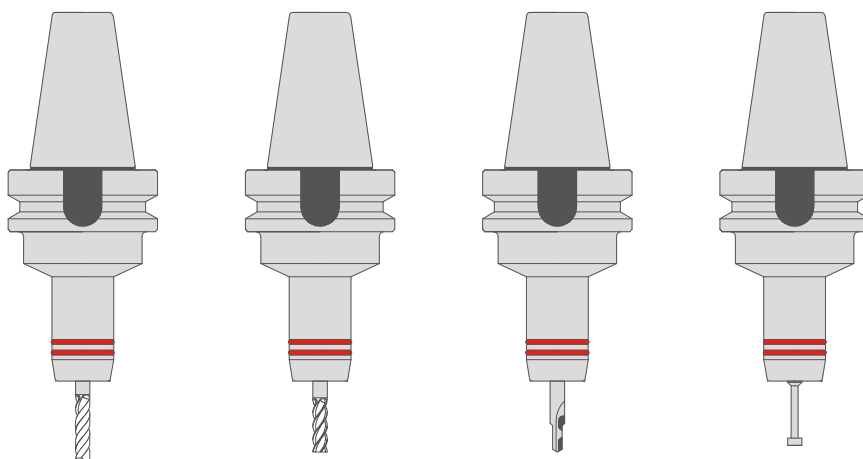


Micron precise radial length adjustment (10mm) of the tools.

10mm up and down



Reamer, Tap, Drill, Ball end mill, End mill, PCD tool, etc. Many kinds of work possible.



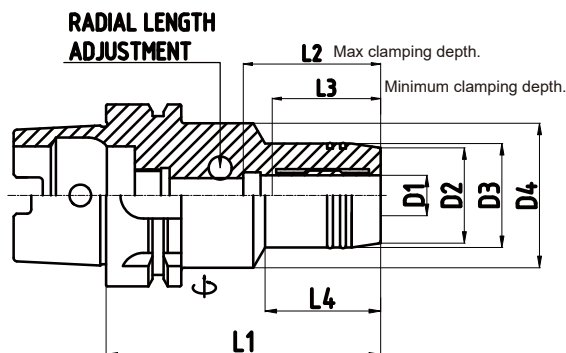
≡ Dimensions(mm)

HSK-A63		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Radial Adjustment (wrench)	Kg.
HSK-A63/GPS6/80	●	6	23	26	50	80	37.5	27.5	33	TR-4.0	T-2.0	1.2
HSK-A63/GPS8/80	●	8	25	28	50	80	37.5	27.5	33	TR-4.0	T-2.0	1.2
HSK-A63/GPS10/85	●	10	27	30	50	85	42.5	32.5	38	TR-4.0	T-2.0	1.3
HSK-A63/GPS12/90	●	12	29	32	50	90	47.5	37.5	40	TR-4.0	T-2.0	1.4
HSK-A63/GPS14/90	●	14	31	34	50	90	47.5	37.5	46	TR-4.0	T-3.0	1.4
HSK-A63/GPS16/95	●	16	35	38	50	95	52.5	42.5	51	TR-4.0	T-3.0	1.5
HSK-A63/GPS18/95	●	18	37	40	50	95	52.5	42.5	52	TR-4.0	T-3.0	1.6
HSK-A63/GPS20/100	●	20	39	42	50	100	52.5	42.5	53	TR-4.0	T-3.0	1.7
HSK-A63/GPS25/120	●	25	46	50	-	120	61	51	94	TR-5.0	T-3.0	2.4
HSK-A63/GPS32/125	●	32	56	60	-	125	65	55	99	TR-5.0	T-3.0	3.0

Availability: ● Stock ▲ Short lead time ○ On request

- »h6 shank tools must be used.
- »Tool length can be adjusted up to 10mm.
- »T-wrench is must be ordered separately.
(GRIP torque wrench is recommended.)
- »Data carrier and Coolant tube as an option.
- »All products center through coolant system.
- »Additional sizes and special designs available on request.

⚠ The minimum tool depth must be observed.



HSK-A63

Dimensions(mm)

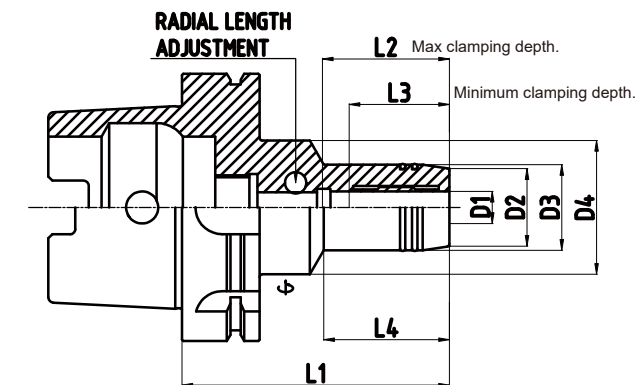
HSK-A100		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Radial Adjustment (wrench)	Kg.
HSK-A100/GPS6/85	●	6	23	26	50	85	37.5	27.5	33	TR-4.0	T-2.0	2.8
HSK-A100/GPS8/85	●	8	25	28	50	85	37.5	27.5	33	TR-4.0	T-2.0	2.8
HSK-A100/GPS10/90	●	10	27	30	50	90	42.5	32.5	36	TR-4.0	T-2.0	2.8
HSK-A100/GPS12/95	●	12	29	32	50	95	47.5	37.5	40	TR-4.0	T-2.0	2.8
HSK-A100/GPS14/95	●	14	31	34	50	95	47.5	37.5	46	TR-4.0	T-3.0	2.9
HSK-A100/GPS16/100	●	16	35	38	50	100	52.5	42.5	51	TR-4.0	T-3.0	2.9
HSK-A100/GPS18/100	●	18	37	40	50	100	52.5	42.5	52	TR-4.0	T-3.0	3.0
HSK-A100/GPS20/105	●	20	39	42	50	105	52.5	42.5	58	TR-5.0	T-3.0	3.0
HSK-A100/GPS25/115	●	25	53	57	63	115	61	51	60	TR-5.0	T-3.0	3.7
HSK-A100/GPS32/120	●	32	58	63	75	120	65	55	68	TR-5.0	T-3.0	4.1

PRESET

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
- »Tool length can be adjusted up to 10mm.
- »T-wrench is must be ordered separately. (GRIP torque wrench is recommended.)
- »Data carrier and Coolant tube as an option.
- »All products center through coolant system.
- »Additional sizes and special designs available on request.

⚠ The minimum tool depth must be observed.



HSK-A100

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HYDRO-GRIND

Tool Grinding and Sharpening.

New!!

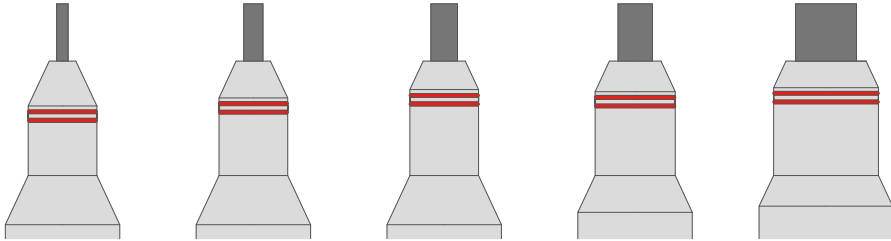
More Various product line-up



HYDRO-GRIND

≡ A wide range of products from 6 to 32 bore diameters.

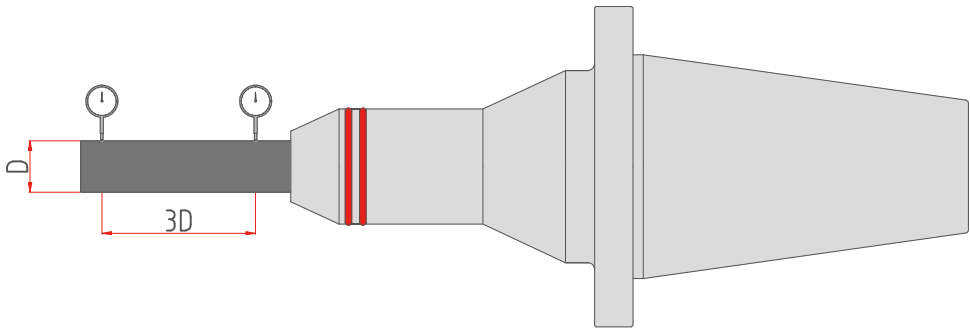
Optimization of work precision by direct fastening of workpieces.



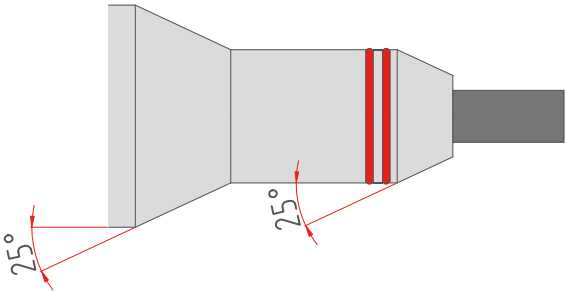
ID12, ID20, ID32 Hydro-sleeve can be used.

≡ Always keep the same run-out.

Standard run-out 3xd 3 μ m.



≡ Minimized wheel interference at an inlet angle of 25 degrees.



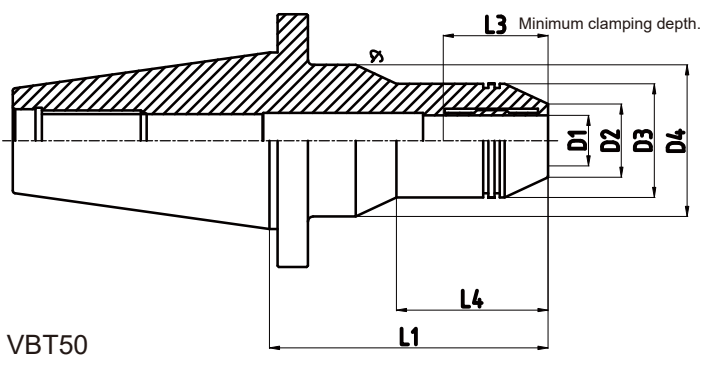
GRIND

Dimensions(mm)

VBT		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
VBT50/GR6/110	●	6	14	36	60	110	-	27.5	60	TR-4.0	-	3.6
VBT50/GR8/110	●	8	16	36	60	110	-	27.5	60	TR-4.0	-	3.6
VBT50/GR10/110	●	10	18	36	60	110	-	32.5	60	TR-4.0	-	3.6
VBT50/GR12/110	●	12	20	36	60	110	-	37.5	60	TR-4.0	-	3.6
VBT50/GR14/110	●	14	22	36	60	110	-	37.5	60	TR-4.0	-	3.7
VBT50/GR16/110	●	16	24	40	60	110	-	42.5	60	TR-4.0	-	3.7
VBT50/GR18/110	●	18	27	42	60	110	-	42.5	60	TR-4.0	-	3.8
VBT50/GR20/110	●	20	29	45	60	110	-	42.5	60	TR-5.0	-	3.8
VBT50/GR25/110	●	25	34	50	70	110	-	51	60	TR-5.0	-	3.9
VBT50/GR32/110	●	32	42	55	70	110	-	55	60	TR-5.0	-	4.0

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
- »Deep insertion depth.
- »T-wrench is must be ordered separately. (GRIP torque wrench is recommended.)
- »Additional sizes and special designs available on request.
- ⚠ The minimum tool depth must be observed.



GRIND

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A graphic consisting of two parallel red horizontal lines.

HYDRO-VS

Compact, very short type. For machine room space.

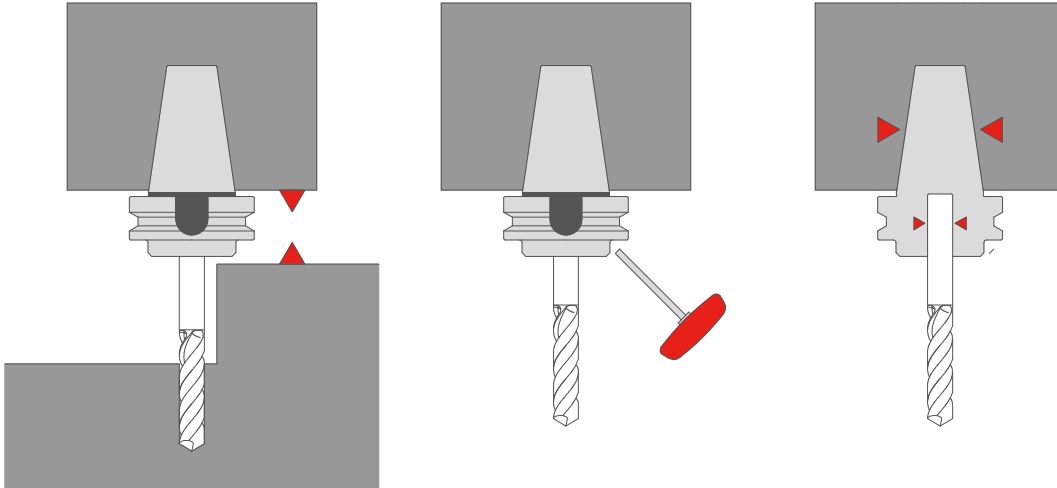
New!!

New design



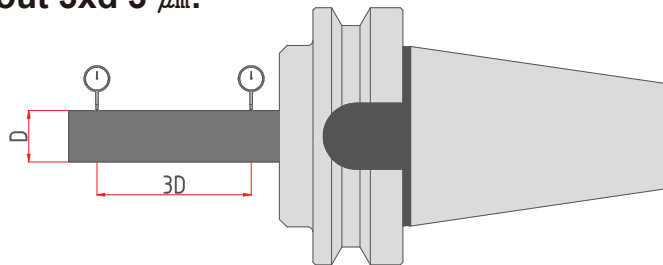
HYDRO-VS

- Hydro-vs can secure maximum machine space.
Minimize interference. Long tools are available.



- Precision and Run-out Guaranteed.

Standard run-out 3xd 3 μm .



- Can be ideally combined with hydro-zero extension.



VS

Dimensions(mm)

BT40		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT40/GVS20/40	●	20	50	-	-	40	51.5	41.5	13	TR-4.0	-	1.1

BT50		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
BT50/GVS32/51	●	32	70.5	-	-	51	65	55	13	TR-5.0	-	3.8

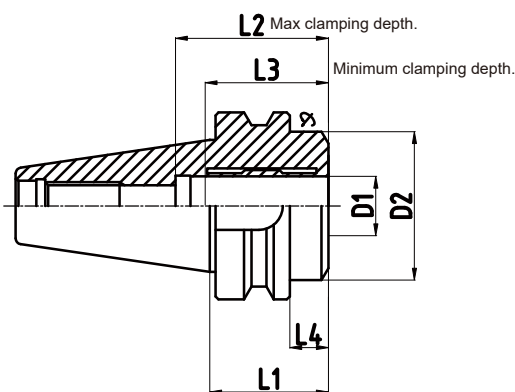
SK40		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
SK40/GVS20/32	●	20	50	-	-	32	47.5	37.5	12.9	TR-4.0	-	0.9

SK50		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
SK50/GVS32/32	●	32	70.5	-	-	32	65	55	12.9	TR-5.0	-	2.9

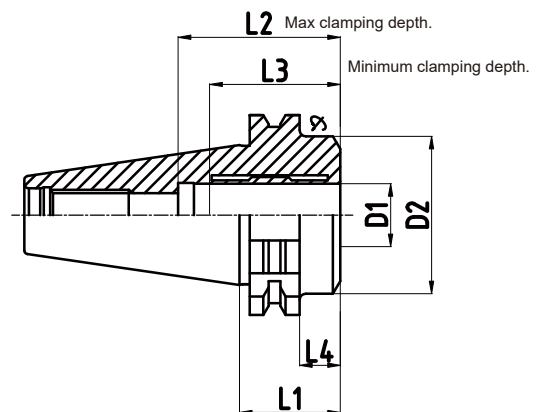
Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
- »Tool length can be adjusted up to 10mm.
- »T-wrench is must be ordered separately. (GRIP torque wrench is recommended.)
- »All products center through coolant system.
- »Additional sizes and special designs available on request.

⚠ The minimum tool depth must be observed.



BT40/BT50



SK40/SK50

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HYDRO-ZERO EXTENSION

Zero run-out setting connection holder.

New!!

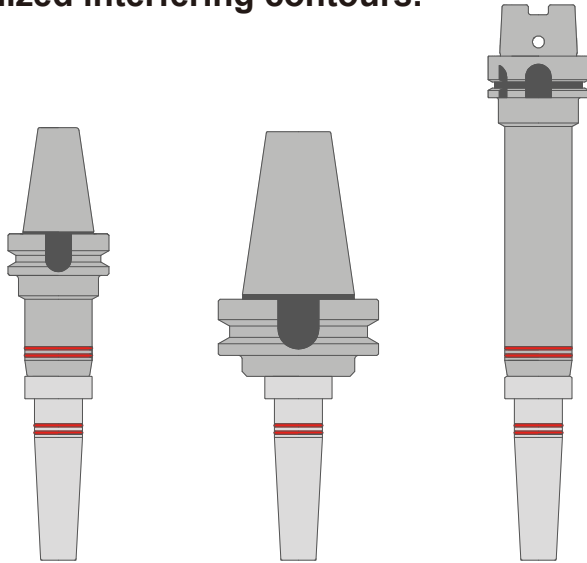
New product line-up



HYDRO-ZERO EXTENSION

= A slim type connection holder.

Save costs on the fabrication of expensive special tools.
Optimized interfering contours.

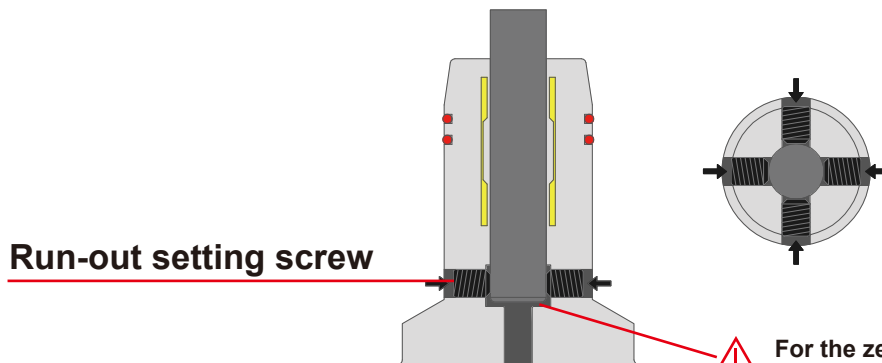


= Response various tool shank by using a Hydro-sleeve.



= ZERO Run-Out setting.

4pcs screws in 90 degree direction
for Run-out setting for more precise work.



⚠ For the zero-fit function to work properly,
the bottom of the holder must not be in
contact with the tool.



ZERO
EXTENSION

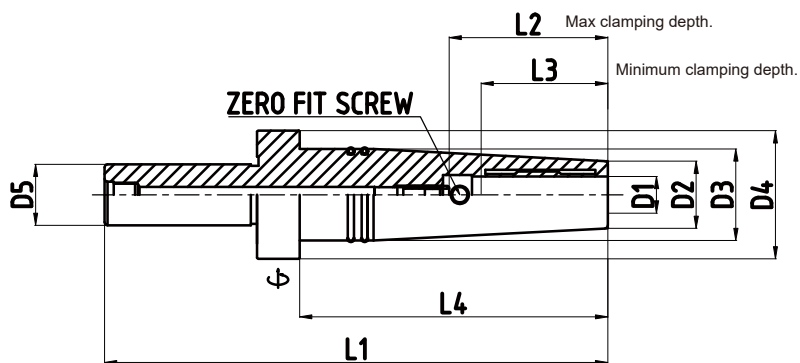
Dimensions(mm)

ST20		D1	D2	D3	D4	D5	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
ST20/ZEX6/165	●	6	16	24	42	20	165	41	31	101	TR-4.0	M5x0.8(T-2.5)	0.5
ST20/ZEX8/165	●	8	18	26	42	20	165	41	31	101	TR-4.0	M6x1.0(T-3.0)	0.5
ST20/ZEX10/165	●	10	20	28	42	20	165	48	38	101	TR-4.0	M8x1.0(T-4.0)	0.6
ST20/ZEX12/165	●	12	22	30	42	20	165	53	43	101	TR-4.0	M10x1.0(T-5.0)	0.7
ST20/ZEX16/165	●	16	26	28	42	20	165	58	48	101	TR-4.0	M12x1.0(T-6.0)	0.8
ST20/ZEX20/165	●	20	29	31.5	42	20	165	58	48	101	TR-5.0	M16x1.0(T-6.0)	0.8
ST20/ZEX20/215	●	20	29	31.5	42	20	215	58	48	151	TR-5.0	M16x1.0(T-6.0)	1.2

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
- »Tool length can be adjusted up to 10mm.
- »T-wrench is must be ordered separately. (GRIP torque wrench is recommended.)
- »If you use the ZERO-FIT function, you cannot use the hydro-sleeve.
- »All products center through coolant system.
- »Additional sizes and special designs available on request.

⚠ The minimum tool depth must be observed.



ST20

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HYDRO-CENTRO

CNC lathe, Center Calibration holder

New!!

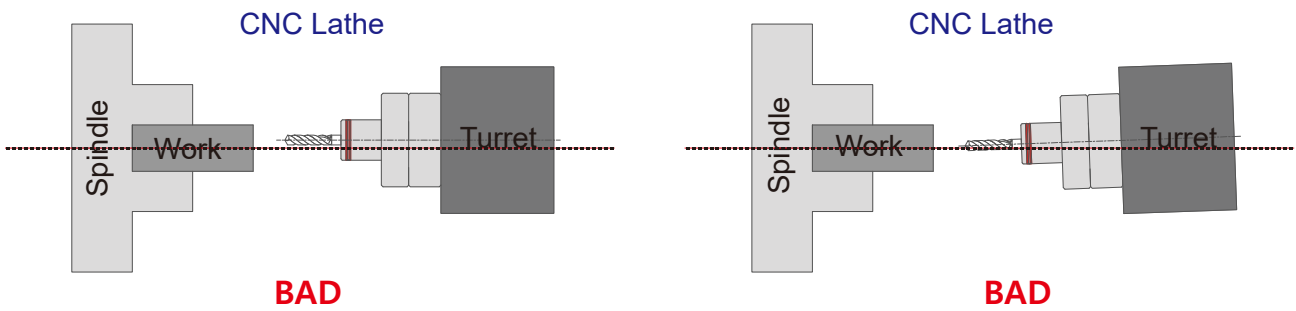
New hydro line-up



HYDRO-CENTRO

Optimal machining is realized by correcting misalignment of turret and spindle on CNC lathes.

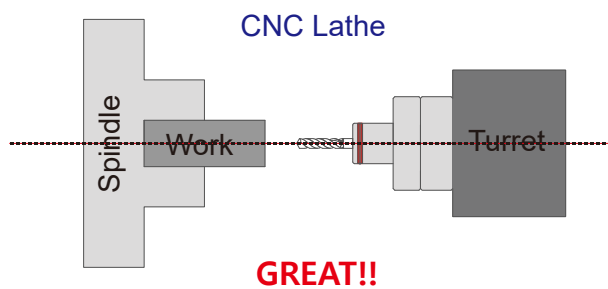
Before



CENTRO SETTING



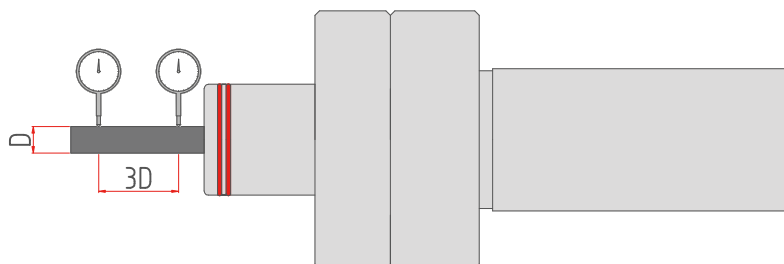
After



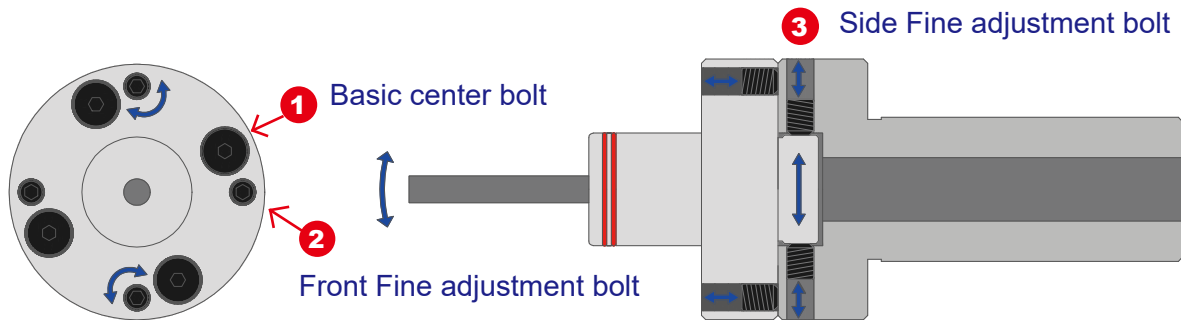
Centro setting video.

Guarantees the same runout when changing tools with one calibration.

Precision-always keep same run-out accuracy.



HYDRO-CENTRO Easy to use.



How to use

- 1step- Insert tool.(insert setting bar) and Lock the clamping screw.
- 2step- Run-out check.
- 3step- After setting the basic run-out using the foundation **1** basic center bolt, lock the 4 bolts.
- 4step- Check the run-out and make fine adjustments using the **2** front fine bolts and **3** side fine bolts.

Setting BAR

The setting bar is very precise.
It is used for accurate run-out setting when used as a hydro centro.



STB

STB-3/ 4/ 6/ 8/ 10/ 12

Applied product

ID 3/4/6/8/10/12

Setting Bar



≡ Dimensions(mm)

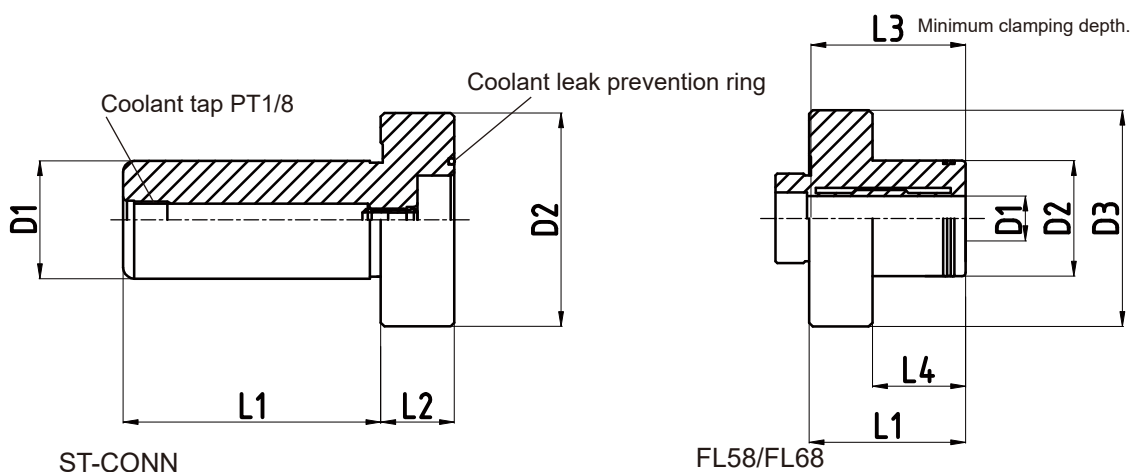
Centro flange		D1	D2	D3	D4	L1	L2	L3	L4	Clamping wrench	Adjustment bolt (wrench)	Kg.
FL58/GCT6	●	6	25	58	-	42	-	31	25	TR-4.0	-	0.4
FL58/GCT8	●	8	28	58	-	42	-	31	25	TR-4.0	-	0.4
FL58/GCT10	●	10	30	58	-	42	-	38	25	TR-4.0	-	0.4
FL58/GCT12	●	12	31	58	-	42	-	43	25	TR-4.0	-	0.4
FL68/GCT20	●	20	41.5	68	-	48	-	48	31	TR-4.0	-	0.7

Connection holder												
ST25/D58-CONN	●	25	58	-	-	60	20	-	-	-	M6x1.0(T-3.0)	0.6
ST25/D68-CONN	●	25	68	-	-	60	20	-	-	-	M6x1.0(T-3.0)	0.7
ST32/D58-CONN	●	32	58	-	-	70	20	-	-	-	M6x1.0(T-3.0)	0.8
ST32/D68-CONN	●	32	68	-	-	70	20	-	-	-	M6x1.0(T-3.0)	0.9
ST40/D58-CONN	●	40	58	-	-	70	20	-	-	-	M6x1.0(T-3.0)	1.0
ST40/D68-CONN	●	40	68	-	-	70	20	-	-	-	M6x1.0(T-3.0)	1.1

Availability: ● Stock ▲ Short lead time ○ Made to order

- »h6 shank tools must be used.
- »T-wrench is must be ordered separately.
(GRIP torque wrench is recommended.)
- »All products center through coolant system.
- »Additional sizes and special designs available on request.

⚠ The minimum tool depth must be observed.



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HYDRO-SWISS TURN

Precision, swiss type automatic lathe solution



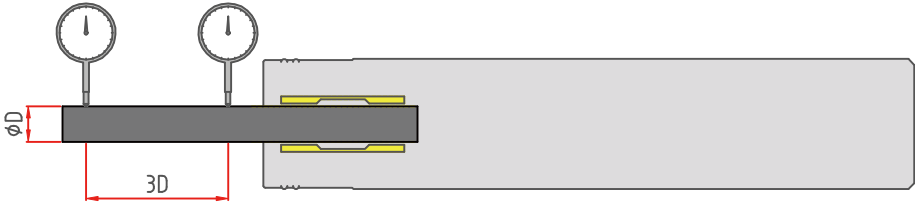
1 less than
micron



HYDRO-SWISS TURN

Ultra Precision.

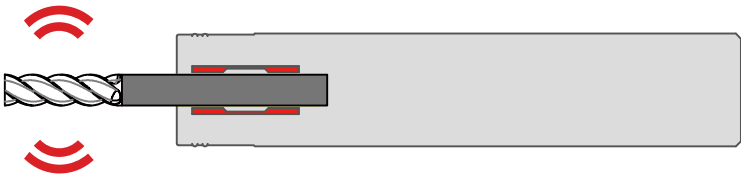
Hydraulic chuck always keeps the same run-out accuracy.



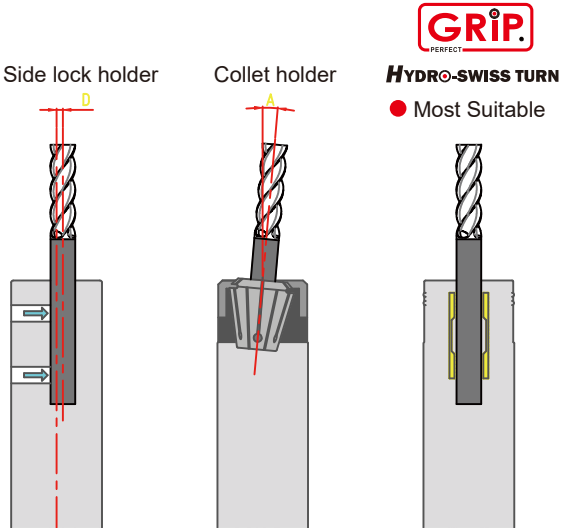
Standard type 0.003 T.I.R
UP type 0.001 T.I.R

Vibration Damping Function.

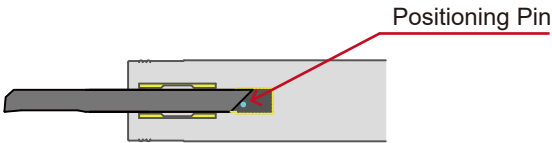
hydraulic chuck extends tool life



Hydraulic Chuck with Product Comparison



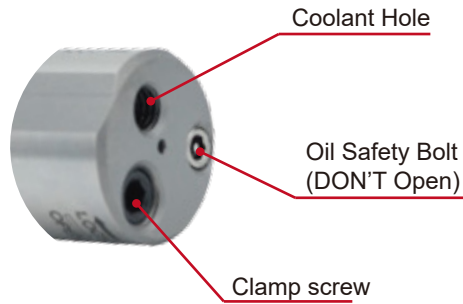
Boring for Precision High Positioning Accuracy



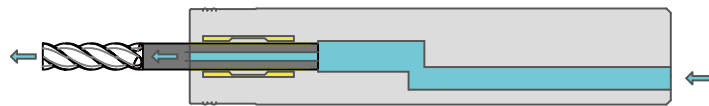
1 less than micron



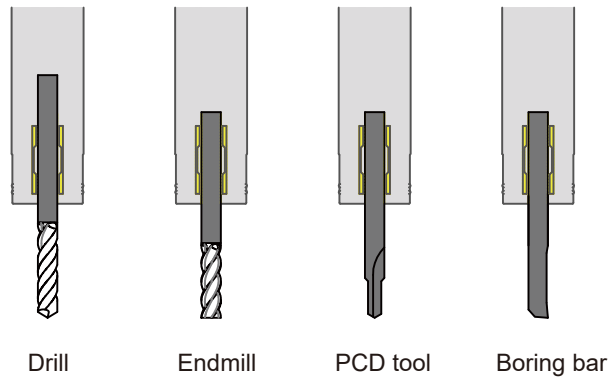
Easy Clamping Hydraulic System



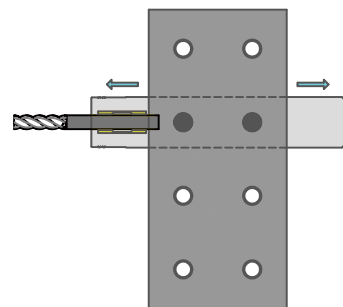
Coolant System



Various Operations



Easy and Free Axial Length Adjustment



SWISS TURN

Front Type



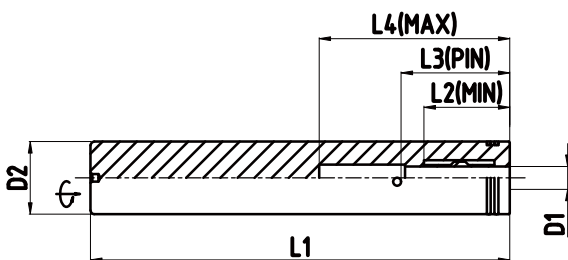
≡ Dimensions(mm)

ST19.05	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST19.05-GST3-110	3	19.05	-	110	17.5	24	40	-		TR-3.0	C/ M16/ L20
ST19.05-GST4-110	4	19.05	-	110	21	26	40	-		TR-3.0	
ST19.05-GST6-110	6	19.05	-	110	23	29	52	-		TR-3.0	
ST19.05-GST8-110	8	19.05	-	110	28	34	52	-		TR-3.0	

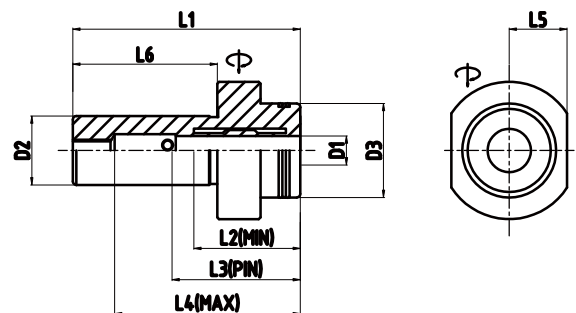
ST25.4	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST25.4-GST3-110	3	25.4	-	110	17.5	24	40	-		TR-4.0	C/ M/ L32
ST25.4-GST4-110	4	25.4	-	110	21	26	40	-		TR-4.0	
ST25.4-GST6-110	6	25.4	-	110	23	29	52	-		TR-4.0	
ST25.4-GST8-110	8	25.4	-	110	28	34	52	-		TR-4.0	
ST25.4-GST10-110	10	25.4	-	110	29.5	36	55	-		TR-4.0	
ST25.4-GST12-110	12	25.4	-	110	31.5	38	58	-		TR-4.0	

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- »T-wrench is must be ordered separately.
- »The inner diameter 8 and 12 can be used with various tools by using the hydro-sleeve.
- »All products center through coolant system.
- »Additional sizes and special designs available on request.

SWISS TURN



ST19.05/ ST25.4



ST19.05

Back Type

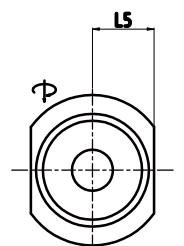
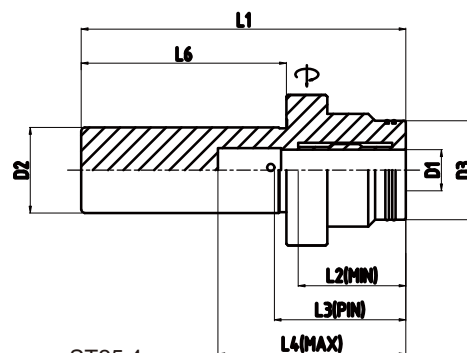
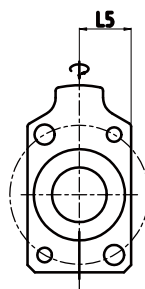
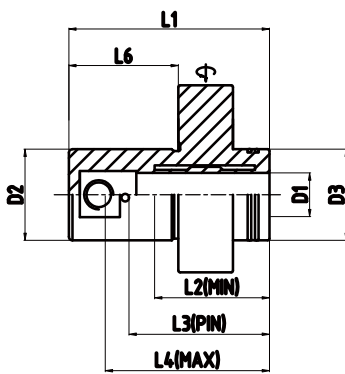
Citizen

≡ Dimensions(mm)

ST19.05	D1	D2	D3	L1	L2	L3	L4	L5	L6	Wrench	Type of machine
ST19.05-GST3-40/63	3	19.05	20	63	17.5	24	53	13.5	40	TR-4.0	
ST19.05-GST4-40/63	4	19.05	22	63	21	26	53	14	40	TR-4.0	
ST19.05-GST6-40/63	6	19.05	24	63	23	29	53	15	40	TR-4.0	C/ M16/ L20
ST19.05-GST8-40/63	8	19.05	26	63	28	34	53	16	40	TR-4.0	
ST19.05-GST10-40/63	10	19.05	28	63	29.5	36	53	17	40	TR-4.0	

ST25	D1	D2	D3	L1	L2	L3	L4	L5	L6	Wrench	Type of machine
ST25-GST4-30/55	4	25	25	55	21	26	45	14.2	30	TR-4.0	
ST25-GST6-30/55	6	25	25	55	23	29	45	14.2	30	TR-4.0	
ST25-GST8-30/55	8	25	25	55	28	34	45	14.2	30	TR-4.0	C/ L/ M20/32
ST25-GST10-30/55	10	25	25	55	29.5	36	45	14.2	30	TR-4.0	
ST25-GST12-30/55	12	25	25	55	31.5	38	45	14.2	30	TR-4.0	

ST25.4	D1	D2	D3	L1	L2	L3	L4	L5	L6	Wrench	Type of machine
ST25.4-GST4-40/75	4	25.4	19	75	21	26	46	14	40	TR-4.0	
ST25.4-GST6-40/75	6	25.4	20	75	23	29	51	15	40	TR-4.0	
ST25.4-GST8-40/75	8	25.4	23	75	28	36	51	16	40	TR-4.0	C/ L/ M32
ST25.4-GST10-40/75	10	25.4	27	75	29.5	36	56	17	40	TR-4.0	
ST25.4-GST12-40/75	12	25.4	29	75	31.5	38	56	18	40	TR-4.0	



SWISS TURN

Front Type

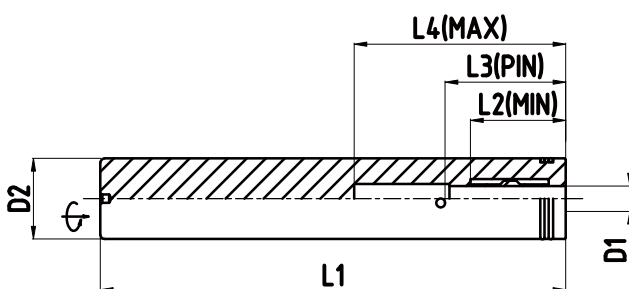


≡ Dimensions(mm)

ST16	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST16-GST3-90	3	16	-	90	17.5	24	40	-		TR-3.0	SR-10J
ST16-GST3.175-90	3.175	16	-	90	17.5	24	40	-		TR-3.0	
ST16-GST4-90	4	16	-	90	21	26	40	-		TR-3.0	
ST16-GST6-90	6	16	-	90	23	29	37	-		TR-3.0	

ST22	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST22-GST3-110	3	22	-	110	17.5	24	40	-		TR-4.0	12 / 20 SERIES
ST22-GST4-110	4	22	-	110	21	26	40	-		TR-4.0	
ST22-GST6-110	6	22	-	110	23	29	52	-		TR-4.0	
ST22-GST8-110	8	22	-	110	28	34	52	-		TR-4.0	
ST22-GST10-110	10	22	-	110	29.5	36	55	-		TR-4.0	

ST32	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST32-GST3-110	3	32	-	110	17.5	24	40	-		TR-4.0	32 SERIES
ST32-GST4-110	4	32	-	110	21	26	40	-		TR-4.0	
ST32-GST6-110	6	32	-	110	23	29	52	-		TR-4.0	
ST32-GST8-110	8	32	-	110	28	34	52	-		TR-4.0	
ST32-GST10-110	10	32	-	110	29.5	36	55	-		TR-4.0	
ST32-GST12-110	12	32	-	110	31.5	38	58	-		TR-4.0	



ST16/ ST22/ ST32

Back Type

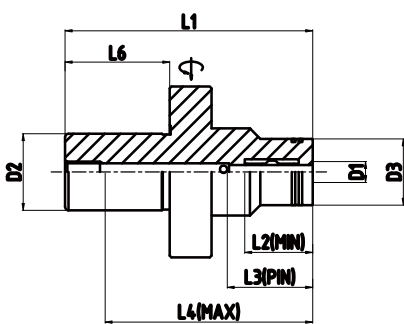


≡ Dimensions(mm)

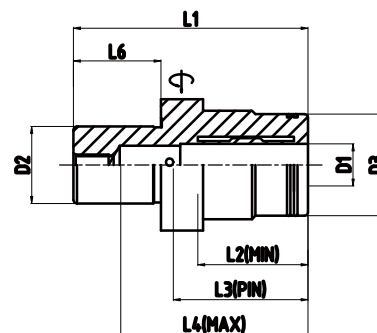
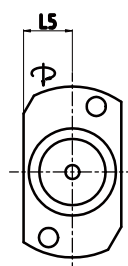
ST22	D1	D2	D3	L1	L2	L3	L4	L5	L6	Wrench	Type of machine
ST22-GST4-25/66A	4	22	19	66	21	25	56	14	25	TR-4.0	12/ 20 SERIES
ST22-GST6-25/66A	6	22	20	66	23	30	47	14	25	TR-4.0	
ST22-GST8-25/66A	8	22	23	66	28	34	51	15	25	TR-4.0	
ST22-GST10-25/66A	10	22	27	66	29.5	36	52	16	25	TR-4.0	
ST22-GST12-25/66A	12	22	29	66	31.5	42	52	17.25	25	TR-4.0	

ST22	D1	D2	D3	L1	L2	L3	L4	L5	L6	Wrench	Type of machine
ST22-GST4-25/66B	4	22	19	66	21	25	56	16.25	25	TR-4.0	SW20/ SR20IV
ST22-GST6-25/66B	6	22	20	66	23	30	47	16.25	25	TR-4.0	
ST22-GST8-25/66B	8	22	23	66	28	34	51	16.25	25	TR-4.0	
ST22-GST10-25/66B	10	22	27	66	29.5	36	52	16.25	25	TR-4.0	
ST22-GST12-25/66B	12	22	29	66	31.5	42	52	17.25	25	TR-4.0	

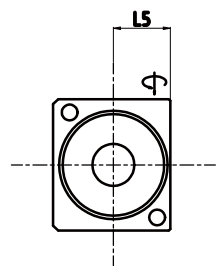
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ST22-A



ST22-B



SWISS TURN

Front Type

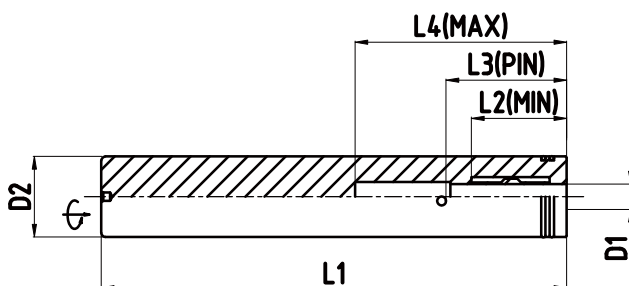


≡ Dimensions(mm)

ST16	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST16-GST3-50	3	16	-	50	17.5	24	28	-		TR-3.0	P01 /P03
ST16-GST3.175-50	3.175	16	-	50	17.5	24	28	-		TR-3.0	
ST16-GST4-50	4	16	-	50	21	26	28	-		TR-3.0	

ST20	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST20-GST3-110	3	20	-	110	17.5	24	40	-		TR-3.0	BO12 /20 /S20 SERIES
ST20-GST4-110	4	20	-	110	21	26	40	-		TR-3.0	
ST20-GST6-110	6	20	-	110	23	29	52	-		TR-3.0	
ST20-GST8-110	8	20	-	110	28	34	52	-		TR-3.0	

ST25	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST25-GST3-110	3	25	-	110	17.5	24	40	-		TR-4.0	32 SERIES
ST25-GST4-110	4	25	-	110	21	26	40	-		TR-4.0	
ST25-GST6-110	6	25	-	110	23	29	52	-		TR-4.0	
ST25-GST8-110	8	25	-	110	28	34	52	-		TR-4.0	
ST25-GST10-110	10	25	-	110	29.5	36	55	-		TR-4.0	
ST25-GST12-110	12	25	-	110	31.5	38	58	-		TR-4.0	



ST16/ ST20/ ST25

Back Type

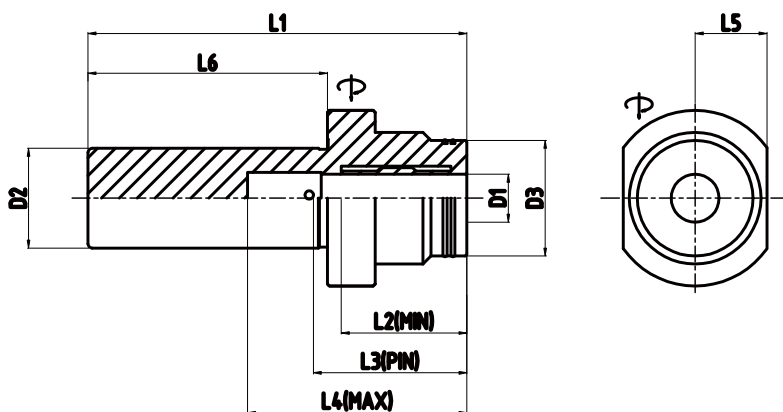


≡ Dimensions(mm)

ST20	D1	D2	D3	L1	L2	L3	L4	L5	L6	Wrench	Type of machine
ST20-GST4-40/75	4	20	19	75	21	26	46	14	40	TR-4.0	BO12 /20 /S20 SERIES
ST20-GST6-40/75	6	20	20	75	23	29	51	15	40	TR-4.0	
ST20-GST8-40/75	8	20	23	75	28	36	51	16	40	TR-4.0	
ST20-GST10-40/75	10	20	27	75	29.5	36	56	17	40	TR-4.0	

ST25	D1	D2	D3	L1	L2	L3	L4	L5	L6	Wrench	Type of machine
ST25-GST4-60/95	4	25	19	95	21	26	46	14	60	TR-4.0	32 SERIES
ST25-GST6-60/95	6	25	20	95	23	29	51	15	60	TR-4.0	
ST25-GST8-60/95	8	25	23	95	28	34	51	16	60	TR-4.0	
ST25-GST10-60/95	10	25	27	95	29.5	36	56	17	60	TR-4.0	
ST25-GST12-60/95	12	25	29	95	31.5	38	56	18	60	TR-4.0	

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ST20/ ST25

SWISS TURN

Front Type

TORNOS

≡ Dimensions(mm)

ST16	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST16-GST3-50	3	16	-	50	17.5	24	28	-		TR-3.0	MICRO 7/8
ST16-GST3.175-50	3.175	16	-	50	17.5	24	28	-		TR-3.0	
ST16-GST4-50	4	16	-	50	21	26	28	-		TR-3.0	
ST16-GST3-90	3	16	-	90	17.5	24	40	-		TR-3.0	SWISS NANO SERIES
ST16-GST3.175-90	3.175	16	-	90	17.5	24	40	-		TR-3.0	
ST16-GST4-90	4	16	-	90	21	26	40	-		TR-3.0	
ST16-GST6-90	6	16	-	90	23	29	37	-		TR-3.0	
ST20											
ST20-GST3-110	3	20	-	110	17.5	24	40	-		TR-3.0	GAMMA20
ST20-GST4-110	4	20	-	110	21	26	40	-		TR-3.0	
ST20-GST6-110	6	20	-	110	23	29	52	-		TR-3.0	
ST20-GST8-110	8	20	-	110	28	34	52	-		TR-3.0	
ST22											
ST22-GST3-110	3	22	-	110	17.5	24	40	-		TR-4.0	DELTA 20 GAMMA 20
ST22-GST4-110	4	22	-	110	21	26	40	-		TR-4.0	
ST22-GST6-110	6	22	-	110	23	29	52	-		TR-4.0	
ST22-GST8-110	8	22	-	110	28	34	52	-		TR-4.0	
ST22-GST10-110	10	22	-	110	29.5	36	55	-		TR-4.0	
ST25											
ST25-GST3-110	3	25	-	110	17.5	24	40	-		TR-4.0	DECO (7/10/13/20)
ST25-GST4-110	4	25	-	110	21	26	40	-		TR-4.0	
ST25-GST6-110	6	25	-	110	23	29	52	-		TR-4.0	
ST25-GST8-110	8	25	-	110	28	34	52	-		TR-4.0	
ST25-GST10-110	10	25	-	110	29.5	36	55	-		TR-4.0	
ST25-GST12-110	12	25	-	110	31.5	38	58	-		TR-4.0	

Back Type

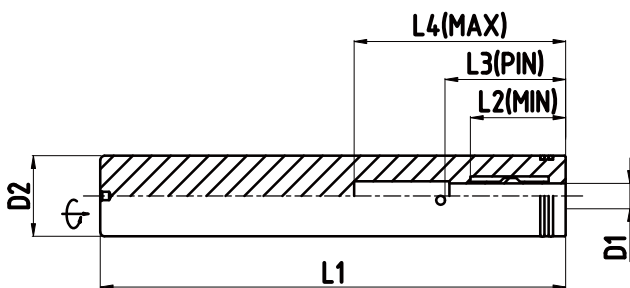
TORNOS

Dimensions(mm)

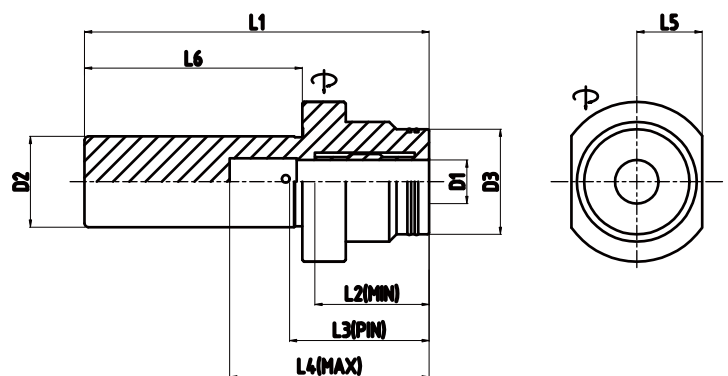
ST20	D1	D2	D3	L1	L2	L3	L4	L5	L6	Wrench	Type of machine
ST20-GST4-40/75	4	20	19	75	21	26	46	14	40	TR-4.0	GT13/ GT26 GAMMA20
ST20-GST6-40/75	6	20	20	75	23	29	51	15	40	TR-4.0	
ST20-GST8-40/75	8	20	23	75	28	36	51	16	40	TR-4.0	
ST20-GST10-40/75	10	20	27	75	29.5	36	56	17	40	TR-4.0	

ST25	D1	D2	D3	L1	L2	L3	L4	L5	L6	Wrench	Type of machine
ST25-GST4-60/95	4	25	19	95	21	26	46	14	60	TR-4.0	DECO (7/10/13/20)
ST25-GST6-60/95	6	25	20	95	23	29	51	15	60	TR-4.0	
ST25-GST8-60/95	8	25	23	95	28	34	51	16	60	TR-4.0	
ST25-GST10-60/95	10	25	27	95	29.5	36	56	17	60	TR-4.0	
ST25-GST12-60/95	12	25	29	95	31.5	38	56	18	60	TR-4.0	

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ST16/ ST20/ ST22/ ST25



ST20/ ST25

SWISS TURN

Front Type

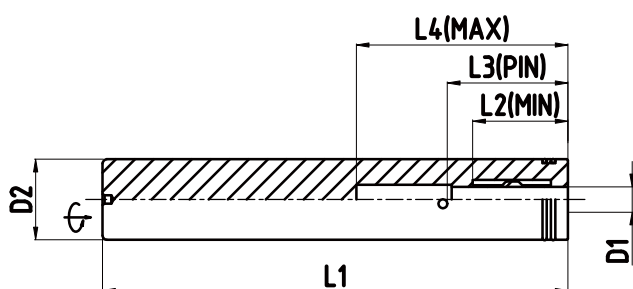


Dimensions(mm)

ST20	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST20-GST3-110	3	20	-	110	17.5	24	40	-		TR-3.0	SL12H
ST20-GST4-110	4	20	-	110	21	26	40	-		TR-3.0	
ST20-GST6-110	6	20	-	110	23	29	52	-		TR-3.0	
ST20-GST8-110	8	20	-	110	28	34	52	-		TR-3.0	

ST25	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST25-GST3-110	3	25	-	110	17.5	24	40	-		TR-4.0	20 SERIES
ST25-GST4-110	4	25	-	110	21	26	40	-		TR-4.0	
ST25-GST6-110	6	25	-	110	23	29	52	-		TR-4.0	
ST25-GST8-110	8	25	-	110	28	34	52	-		TR-4.0	
ST25-GST10-110	10	25	-	110	29.5	36	55	-		TR-4.0	
ST25-GST12-110	12	25	-	110	31.5	38	58	-		TR-4.0	

ST32	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST32-GST3-110	3	32	-	110	17.5	24	40	-		TR-4.0	32 SERIES
ST32-GST4-110	4	32	-	110	21	26	40	-		TR-4.0	
ST32-GST6-110	6	32	-	110	23	29	52	-		TR-4.0	
ST32-GST8-110	8	32	-	110	28	34	52	-		TR-4.0	
ST32-GST10-110	10	32	-	110	29.5	36	55	-		TR-4.0	
ST32-GST12-110	12	32	-	110	31.5	38	58	-		TR-4.0	



ST20/ ST25/ ST32

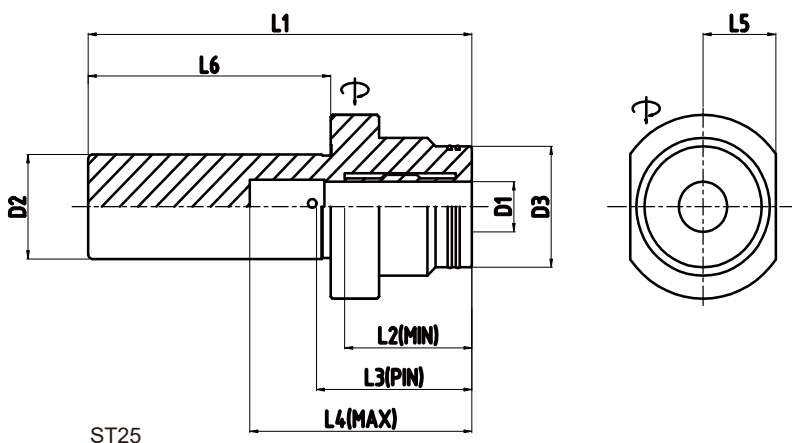
Back Type



≡ Dimensions(mm)

ST25	D1	D2	D3	L1	L2	L3	L4	L5	L6	Wrench	Type of machine
ST25-GST4-60/95	4	25	19	95	21	26	46	14	60	TR-4.0	12/ 20/ 32 SERIES
ST25-GST6-60/95	6	25	20	95	23	29	51	15	60	TR-4.0	
ST25-GST8-60/95	8	25	23	95	28	34	51	16	60	TR-4.0	
ST25-GST10-60/95	10	25	27	95	29.5	36	56	17	60	TR-4.0	
ST25-GST12-60/95	12	25	29	95	31.5	38	56	18	60	TR-4.0	

- »h6 shank tools must be used.
- »T-wrench is must be ordered separately.
- »The inner diameter 8 and 12 can be used with various tools by using the hydro-sleeve.
- »All products center through coolant system.(All item Coolant M6x1.0)
- »Additional sizes and special designs available on request.



SWISS TURN

HYDRO-SWISS TURN

ST | Cylindrical

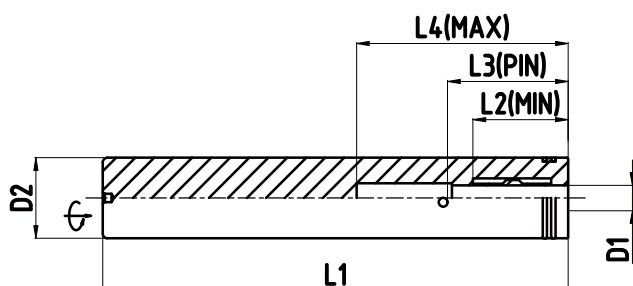
Front Type



≡ Dimensions(mm)

ST22	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST22-GST3-110	3	22	-	110	17.5	24	40	-		TR-4.0	NN-20 SERIES
ST22-GST4-110	4	22	-	110	21	26	40	-		TR-4.0	
ST22-GST6-110	6	22	-	110	23	29	52	-		TR-4.0	
ST22-GST8-110	8	22	-	110	28	34	52	-		TR-4.0	
ST22-GST10-110	10	22	-	110	29.5	36	55	-		TR-4.0	
ST32	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST32-GST3-110	3	32	-	110	17.5	24	40	-		TR-4.0	NN-32 SERIES
ST32-GST4-110	4	32	-	110	21	26	40	-		TR-4.0	
ST32-GST6-110	6	32	-	110	23	29	52	-		TR-4.0	
ST32-GST8-110	8	32	-	110	28	34	52	-		TR-4.0	
ST32-GST10-110	10	32	-	110	29.5	36	55	-		TR-4.0	
ST32-GST12-110	12	32	-	110	31.5	38	58	-		TR-4.0	

SWISS TURN



ST22/ ST32

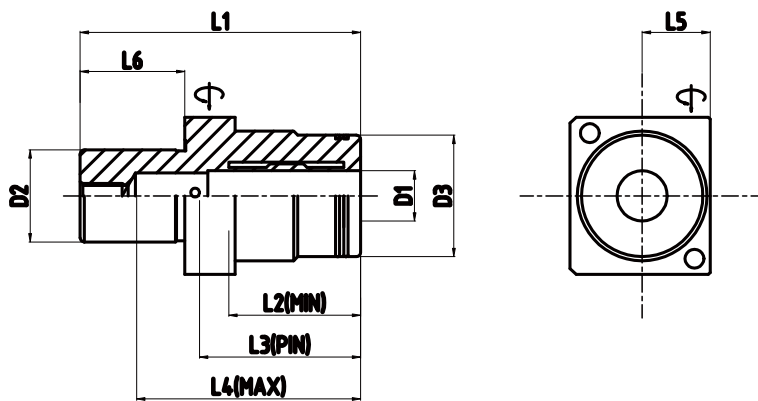
Back Type



≡ Dimensions(mm)

ST22	D1	D2	D3	L1	L2	L3	L4	L5	L6	Wrench	Type of machine
ST22-GST4-25/66B	4	22	19	66	21	25	56	16.25	25	TR-4.0	For common use
ST22-GST6-25/66B	6	22	20	66	23	30	47	16.25	25	TR-4.0	
ST22-GST8-25/66B	8	22	23	66	28	34	51	16.25	25	TR-4.0	
ST22-GST10-25/66B	10	22	27	66	29.5	36	52	16.25	25	TR-4.0	
ST22-GST12-25/66B	12	22	29	66	31.5	42	52	17.25	25	TR-4.0	

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- »All products center through coolant system.(All item Coolant M6x1.0)
- »Additional sizes and special designs available on request.



Front Type



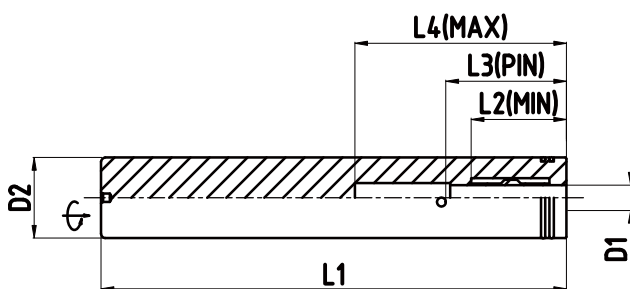
≡ Dimensions(mm)

ST19.05	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST19.05-GST3-110	3	19.05	-	110	17.5	24	40	-		TR-3.0	Depending on Machine
ST19.05-GST4-110	4	19.05	-	110	21	26	40	-		TR-3.0	
ST19.05-GST6-110	6	19.05	-	110	23	29	52	-		TR-3.0	
ST19.05-GST8-110	8	19.05	-	110	28	34	52	-		TR-3.0	

ST25	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST25-GST3-110	3	25	-	110	17.5	24	40	-		TR-4.0	Depending on Machine
ST25-GST4-110	4	25	-	110	21	26	40	-		TR-4.0	
ST25-GST6-110	6	25	-	110	23	29	52	-		TR-4.0	
ST25-GST8-110	8	25	-	110	28	34	52	-		TR-4.0	
ST25-GST10-110	10	25	-	110	29.5	36	55	-		TR-4.0	
ST25-GST12-110	12	25	-	110	31.5	38	58	-		TR-4.0	

ST32	D1	D2	D3	L1	L2	L3	L4	L5	Shape	Wrench	Type of machine
ST32-GST3-110	3	32	-	110	17.5	24	40	-		TR-4.0	Depending on Machine
ST32-GST4-110	4	32	-	110	21	26	40	-		TR-4.0	
ST32-GST6-110	6	32	-	110	23	29	52	-		TR-4.0	
ST32-GST8-110	8	32	-	110	28	34	52	-		TR-4.0	
ST32-GST10-110	10	32	-	110	29.5	36	55	-		TR-4.0	
ST32-GST12-110	12	32	-	110	31.5	38	58	-		TR-4.0	

SWISS TURN



ST19.05/ ST22/ ST32

Back Type

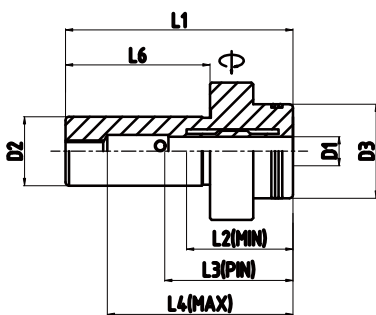
NEXTURN
SWISS TURN LEADER

Dimensions(mm)

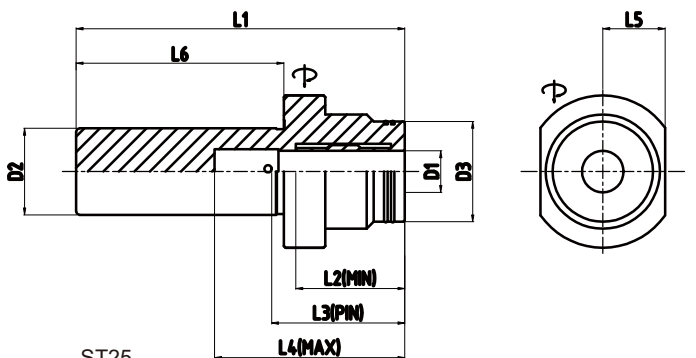
ST19.05	D1	D2	D3	L1	L2	L3	L4	L5	L6	Wrench	Type of machine
ST19.05-GST3-40/63	3	19.05	20	63	17.5	24	53	13.5	40	TR-4.0	Depending on Machine
ST19.05-GST4-40/63	4	19.05	22	63	21	26	53	14	40	TR-4.0	
ST19.05-GST6-40/63	6	19.05	24	63	23	29	53	15	40	TR-4.0	
ST19.05-GST8-40/63	8	19.05	26	63	28	34	53	16	40	TR-4.0	
ST19.05-GST10-40/63	10	19.05	28	63	29.5	36	53	17	40	TR-4.0	

ST25	D1	D2	D3	L1	L2	L3	L4	L5	L6	Wrench	Type of machine
ST25-GST4-60/95	4	25	19	95	21	26	46	14	60	TR-4.0	Depending on Machine
ST25-GST6-60/95	6	25	20	95	23	29	51	15	60	TR-4.0	
ST25-GST8-60/95	8	25	23	95	28	34	51	16	60	TR-4.0	
ST25-GST10-60/95	10	25	27	95	29.5	36	56	17	60	TR-4.0	
ST25-GST12-60/95	12	25	29	95	31.5	38	56	18	60	TR-4.0	

- »h6 shank tools must be used.
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ST19.05



ST25

SWISS TURN

Options

Hydro-sleeve



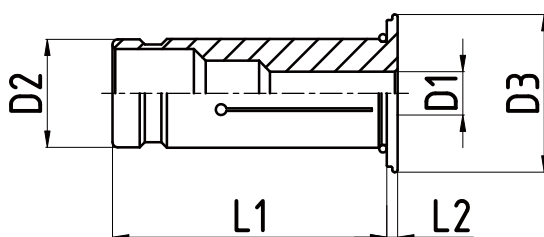
Coolant type

Dimensions(mm)

OD8	D1	D2	D3	L1	L2	Kg.
OD8-3	3	8	12.5	35.5	2	0.1
OD8-4	4	8	12.5	35.5	2	0.1
OD8-5	5	8	12.5	35.5	2	0.1
OD8-6	6	8	12.5	35.5	2	0.1

OD12	D1	D2	D3	L1	L2	Kg.
OD12-3	3	12	19	45	2	0.1
OD12-4	4	12	19	45	2	0.1
OD12-5	5	12	19	45	2	0.1
OD12-6	6	12	19	45	2	0.1
OD12-7	7	12	19	45	2	0.1
OD12-8	8	12	19	45	2	0.1
OD12-9	9	12	19	45	2	0.1
OD12-10	10	12	19	45	2	0.1


- »All shank tools must be used.
- »Internal Coolant type Run-out 3xd 3Micron all items.
- »Additional sizes and special designs available on request.
- »Applied when using oil hole type tools.
- »Recommended for use in precise work.
- »All types of shank can be used.(Stright, Flat, Whistle notch)



OD8/ OD12

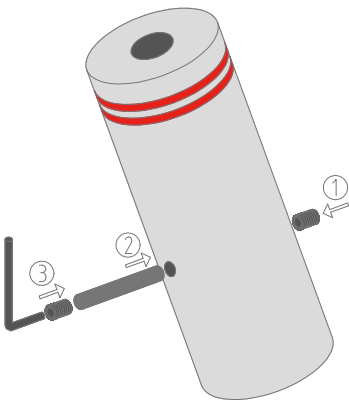
Torque T-wrench (5.5Nm)



TR		Applied product
TR-3.0	3mm	ST16 /ST19.05/ ST20
TR-4.0	4mm	ST22/ ST25/ ST25.4 /ST32

- »5.5Nm torque.
- »Extended hydraulic piston and parts life.
- »Capable of clamping with constant force.

Positioning PIN KIT



PP kit	Applied product
P2.5X8	ST16
P2.5X12	ST19.05 ST20
P2.5X14	ST22
P2.5X16	ST25 ST25.4 ST32

- »Kit Components
- M3x0.5 3mm, Bolt x 4pcs.
- Pin x 2pcs.
- 1.5mm L wrench X 1pcs.

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ACCESSORIES

Hydro-line options and spare parts



HYDRO-ACCESSORIES

Hydro-sleeve

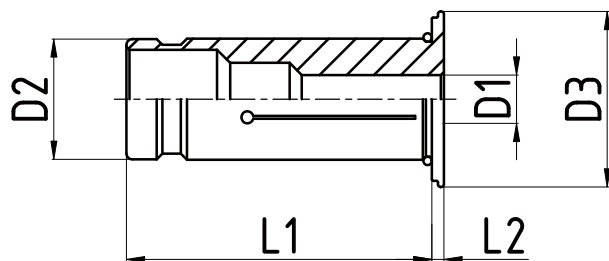


Coolant type

Dimensions(mm)

OD8	D1	D2	D3	L1	L2	Kg.
OD8-3	3	8	12.5	35.5	2	0.1
OD8-4	4	8	12.5	35.5	2	0.1
OD8-5	5	8	12.5	35.5	2	0.1
OD8-6	6	8	12.5	35.5	2	0.1

OD12	D1	D2	D3	L1	L2	Kg.
OD12-3	3	12	19	45	2	0.1
OD12-4	4	12	19	45	2	0.1
OD12-5	5	12	19	45	2	0.1
OD12-6	6	12	19	45	2	0.1
OD12-7	7	12	19	45	2	0.1
OD12-8	8	12	19	45	2	0.1
OD12-9	9	12	19	45	2	0.1
OD12-10	10	12	19	45	2	0.1



OD8/ OD12/ OD20/ OD32

≡ Dimensions(mm)

OD20	D1	D2	D3	L1	L2	Kg.
OD20-3	3	20	27	50.5	2	0.2
OD20-4	4	20	27	50.5	2	0.2
OD20-5	5	20	27	50.5	2	0.2
OD20-6	6	20	27	50.5	2	0.2
OD20-7	7	20	27	50.5	2	0.2
OD20-8	8	20	27	50.5	2	0.2
OD20-9	9	20	27	50.5	2	0.2
OD20-10	10	20	27	50.5	2	0.2
OD20-11	11	20	27	50.5	2	0.2
OD20-12	12	20	27	50.5	2	0.2
OD20-13	13	20	27	50.5	2	0.2
OD20-14	14	20	27	35.5	2	0.2
OD20-15	15	20	27	35.5	2	0.2
OD20-16	16	20	27	35.5	2	0.2
OD20-17	17	20	27	35.5	2	0.2
OD20-18	18	20	27	35.5	2	0.2

≡ Dimensions(mm)

OD32	D1	D2	D3	L1	L2	Kg.
OD32-3	3	32	39	60.5	2	0.3
OD32-4	4	32	39	60.5	2	0.3
OD32-5	5	32	39	60.5	2	0.3
OD32-6	6	32	39	60.5	2	0.3
OD32-7	7	32	39	60.5	2	0.3
OD32-8	8	32	39	60.5	2	0.3
OD32-9	9	32	39	60.5	2	0.3
OD32-10	10	32	39	60.5	2	0.3
OD32-11	11	32	39	60.5	2	0.3
OD32-12	12	32	39	60.5	2	0.3
OD32-13	13	32	39	60.5	2	0.3
OD32-14	14	32	39	60.5	2	0.3
OD32-15	15	32	39	60.5	2	0.3
OD32-16	16	32	39	60.5	2	0.3
OD32-17	17	32	39	60.5	2	0.3
OD32-18	18	32	39	60.5	2	0.3
OD32-19	19	32	39	60.5	2	0.3
OD32-20	20	32	39	60.5	2	0.2
OD20-25	21	32	39	60.5	2	0.2

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- »Internal Coolant type Run-out 3xd 3Micron all items.
- »Additional sizes and special designs available on request.
- »Applied when using oil hole type tools.
- »Recommended for use in precise work.
- »All types of shank can be used.(Stright, Flat, Whistle notch)

HYDRO-ACCESSORIES

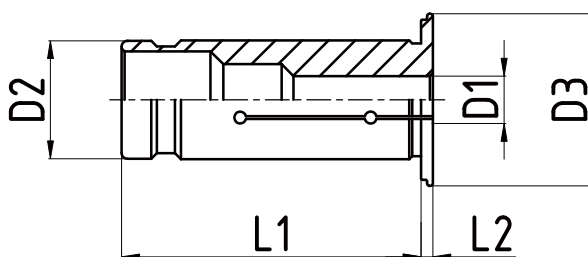
Hydro-sleeve



Non Coolant type

Dimensions(mm)

D12	D1	D2	D3	L1	L2	Kg.
D12-3	3	12	19	45	2	0.1
D12-4	4	12	19	45	2	0.1
D12-5	5	12	19	45	2	0.1
D12-6	6	12	19	45	2	0.1
D12-7	7	12	19	45	2	0.1
D12-8	8	12	19	45	2	0.1
D12-9	9	12	19	45	2	0.1
D12-10	10	12	19	45	2	0.1



D12/ D20/ D32

≡ Dimensions(mm)

D20	D1	D2	D3	L1	L2	Kg.
D20-3	3	20	27	50.5	2	0.2
D20-4	4	20	27	50.5	2	0.2
D20-5	5	20	27	50.5	2	0.2
D20-6	6	20	27	50.5	2	0.2
D20-7	7	20	27	50.5	2	0.2
D20-8	8	20	27	50.5	2	0.2
D20-9	9	20	27	50.5	2	0.2
D20-10	10	20	27	50.5	2	0.2
D20-11	11	20	27	50.5	2	0.2
D20-12	12	20	27	50.5	2	0.2
D20-13	13	20	27	50.5	2	0.2
D20-14	14	20	27	35.5	2	0.2
D20-15	15	20	27	35.5	2	0.2
D20-16	16	20	27	35.5	2	0.2
D20-17	17	20	27	35.5	2	0.2
D20-18	18	20	27	35.5	2	0.2

≡ Dimensions(mm)

D32	D1	D2	D3	L1	L2	Kg.
D32-3	3	32	39	60.5	2	0.3
D32-4	4	32	39	60.5	2	0.3
D32-5	5	32	39	60.5	2	0.3
D32-6	6	32	39	60.5	2	0.3
D32-7	7	32	39	60.5	2	0.3
D32-8	8	32	39	60.5	2	0.3
D32-9	9	32	39	60.5	2	0.3
D32-10	10	32	39	60.5	2	0.3
D32-11	11	32	39	60.5	2	0.3
D32-12	12	32	39	60.5	2	0.3
D32-13	13	32	39	60.5	2	0.3
D32-14	14	32	39	60.5	2	0.3
D32-15	15	32	39	60.5	2	0.3
D32-16	16	32	39	60.5	2	0.3
D32-17	17	32	39	60.5	2	0.3
D32-18	18	32	39	60.5	2	0.3
D32-19	19	32	39	60.5	2	0.3
D32-20	20	32	39	60.5	2	0.2
D32-25	21	32	39	60.5	2	0.2

- »All shank tools must be used.
- »Internal Coolant type Run-out 3xd 5Micron all items.
- »Additional sizes and special designs available on request.
- »All types of shank can be used.(Stright, Flat, Whistle notch)

HYDRO-ACCESSORIES

Coolant Tube

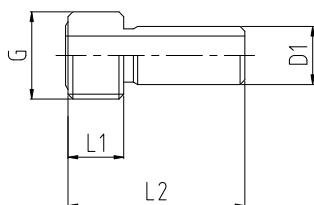
Coolant Tube is for optimum internal supply of HSK holder. It prevents spindle from being spoiled and rests the sealing system.



≡ Dimensions(mm)

CT	For		D1	L1	L2	G
CT40	HSK32	●	8.0	7.5	29.0	M12x1
CT50	HSK40	●	10.0	9.5	33.0	M16x1
CT63	HSK63	●	12.0	11.5	36.5	M18x1
CT100	HSK100	●	16.0	15.0	43.5	M24x1.5

Availability: ● Stock ▲ Short lead time ○ Made to order



Coolant Tube

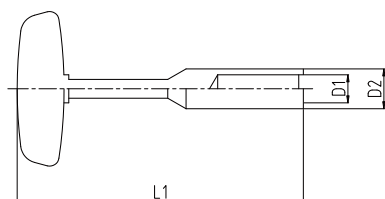
Coolant Tube Wrench



≡ Dimensions(mm)

CTR	For		D1	D2	L1
CTR40	HSK32	●	8.0	11.0	111.0
CTR50	HSK40	●	10.0	15.0	120.0
CTR63	HSK63	●	12.0	17.0	122.0
CTR100	HSK100	●	16.0	22.0	141.0

Availability: ● Stock ▲ Short lead time ○ Made to order



Coolant Tube Wrench

Torque T-wrench (5.5Nm)



TR		Applied product
TR-4.0	4mm	ID 6/8/10/12/14/16/18
TR-5.0	5mm	ID 20/25/32

- »5.5Nm torque.
- »Extended hydraulic piston and parts life.
- »Capable of clamping with constant force.

T-wrench



T			length
T-2.5	●	2.5	100
T-3.0	●	3	100
T-4.0	●	4	100
T-5.0	●	5	100
T-6.0	●	6	100

Availability: ● Stock ▲ Short lead time ○ Made to order

Setting BAR

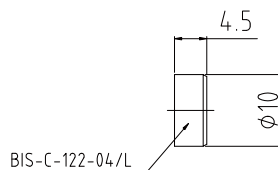
The setting bar is very precise. It is used for accurate run-out setting when used as a HYDRO-CENTRO.



STB	Applied product
STB-3/ 4/ 6/ 8/ 10/ 12	ID 3/4/6/8/10/12

HYDRO-ACCESSORIES

Data Carrier



Data Carrier

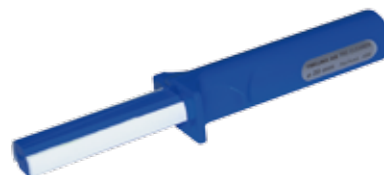
Dimensions(mm)

DTC10	
Dimensions	10x4.5mm
Housing material	Poly-A
Storing capacity	511 Byte
Matching reading and writing head	BIS-C-300/302/305/306/325
Max. reading/writing head	2.5mm
Mode of installation	Flush mounted
Min./Max. ambient temperature	0 / -70°C
Min./Max. stocking temperature	0 / -70°C
Protection class as per DIN 40050	IP 67
Programming cycles	500000 (<70°C)
Read cycles	Unlimited

ID Cleaner



Pic1



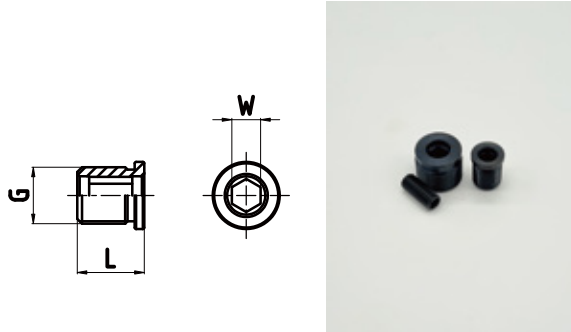
Pic2

Hydraulic chuck inner diameter oil removal cleaning tool.

IC	Pic.	Applied product
IC-6/ 8/ 10/ 12/ 14	Pic1	ID 6/8/10/12/14
IC-16/ 18/ 20/ 25/ 32	Pic2	ID 16/18/20/25/32

Spare Part (Screw)

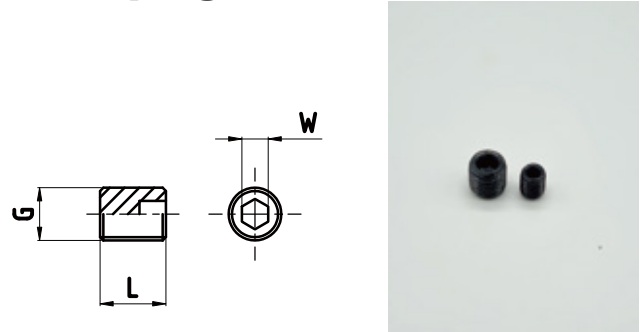
Adjustment screws



Dimensions(mm)

AJS	G	L	W
AJS-M5	M5x0.8	14	2.5
AJS-M6	M6x1.0	14	3.0
AJS-M8	M8x1.0	14	4.0
AJS-M10	M10x1.0	14	5.0
AJS-M12	M12x1.0	14	6.0
AJS-M16	M16x1.0	14	6.0

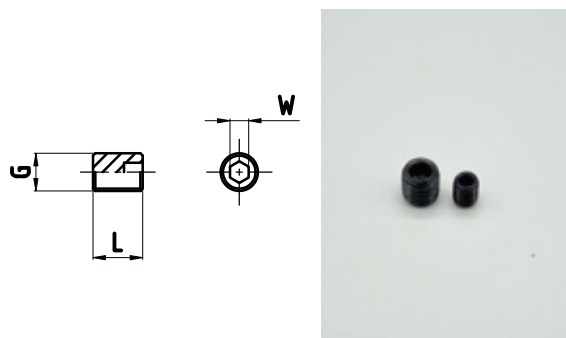
Clamping screw



Dimensions(mm)

CS	G	L	W
CS-M8	M8x1.25	14	4.0
CS-M10	M10x1.5	14	5.0

ZERO-FIT setting screw



Dimensions(mm)

ZSS	For	G	L	W
ZSS-M4	ID-6,8	M4x0.7	8	2.0
ZSS-M6	ID-10~32	M6x1.0	8	3.0

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TECHNICAL DATA



HYDRO-LINE

Proper use of hydraulic chucks.

- 1.**The clamping screw must be locked to the end and used.
-This may cause tool breakage, hydraulic oil loss, reduced run-out.

- 2.**Please observe the minimum insertion depth of the tool.
-It cannot be used due to the change in the inner diameter of the holder and hydraulic oil loss.

- 3.**The ambient temperature should lie between 20°C to 50°C.
-Above 85°C, normal operation may not be possible.

- 4.**Use tools with h6 tolerance.

- 5.**Cylindrical shank provides optimum performance.

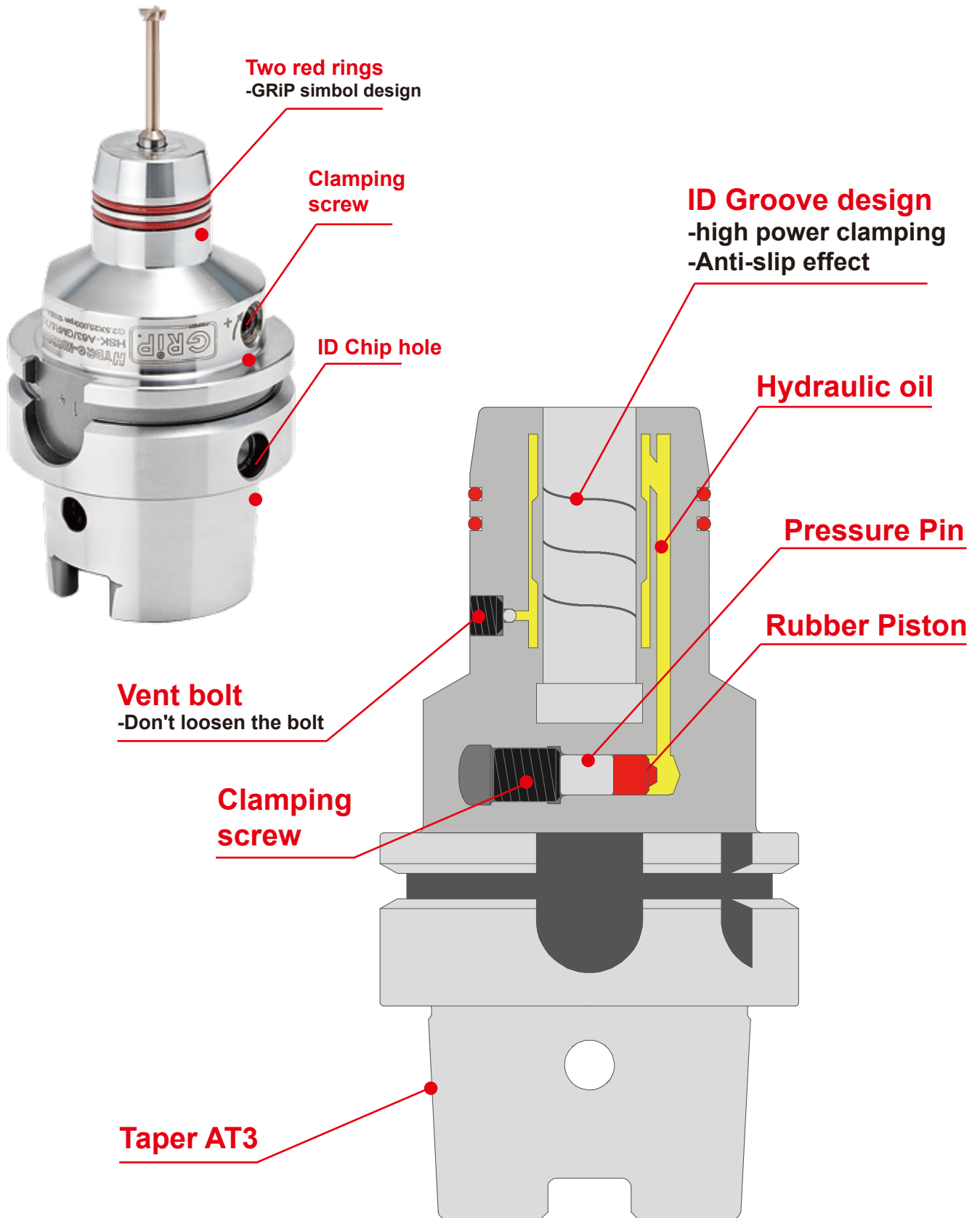
- 6.**Inner diameter cotton should always be used dry.

- 7.**HYDRO-SLEEVE allows you to use all shanks.

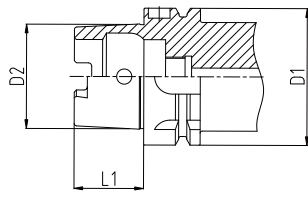
- 8.**Do not operate the clamping screw without the tool mounted.

- 9.**Hydraulic chuck simple instructions.
9-1.Insert the tool into the hydraulic chuck.
9-2.Tighten the clamping screw to the point where the tool cannot turn by hand.
9-3.From the point the tool doesn't turn by hand.
(ID6~ID8 = 2~2.5 turn, ID10~ID32 = 3~3.5 turn. you should be able to turn more.)

- 10.**Excessive radial machining is not recommended.

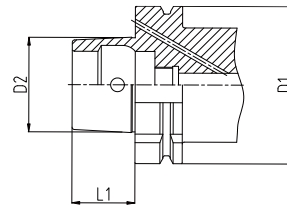


Technical Data



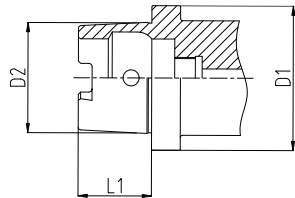
HSK-A	D1	D2	L1
32	32	24	16
40	40	30	20
50	50	38	25
63	63	48	32
80	80	60	40
100	100	75	50

HSK-A



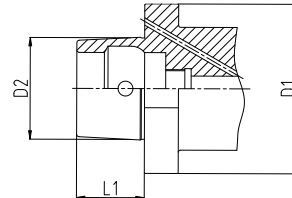
HSK-B	D1	D2	L1
-	-	-	-
40	40	24	16
50	50	30	20
63	63	38	25
80	80	48	32
100	100	60	40

HSK-B



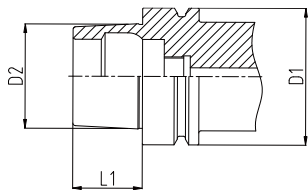
HSK-C	D1	D2	L1
32	32	24	16
40	40	30	20
50	50	38	25
63	63	48	32
80	80	60	40
100	100	75	50

HSK-C



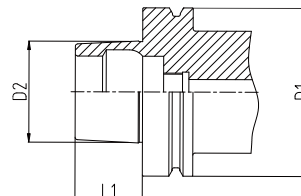
HSK-D	D1	D2	L1
-	-	-	-
40	40	24	16
50	50	30	20
63	63	38	25
80	80	48	32
100	100	60	40

HSK-D



HSK-E	D1	D2	L1
32	32	24	16
40	40	30	20
50	50	38	25
63	63	48	32
-	-	-	-

HSK-E

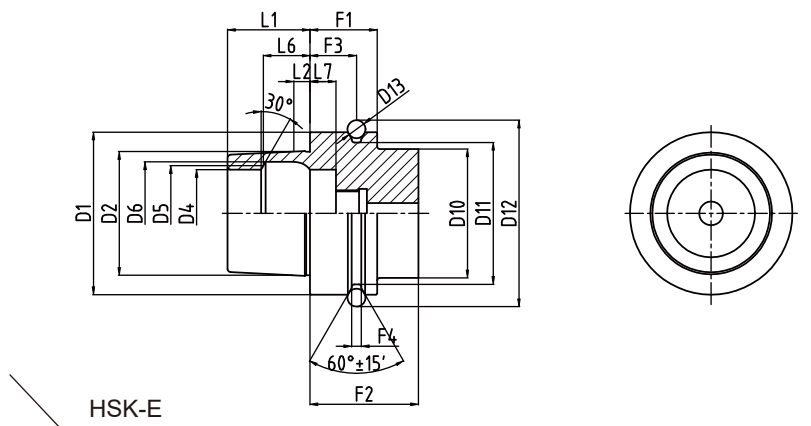
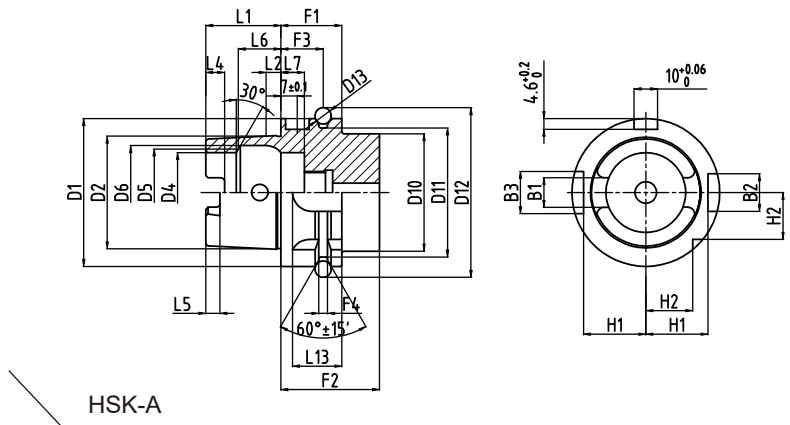


HSK-F	D1	D2	L1
-	-	-	-
-	-	-	-
50	50	30	20
63	63	38	25
80	80	48	32

HSK-F

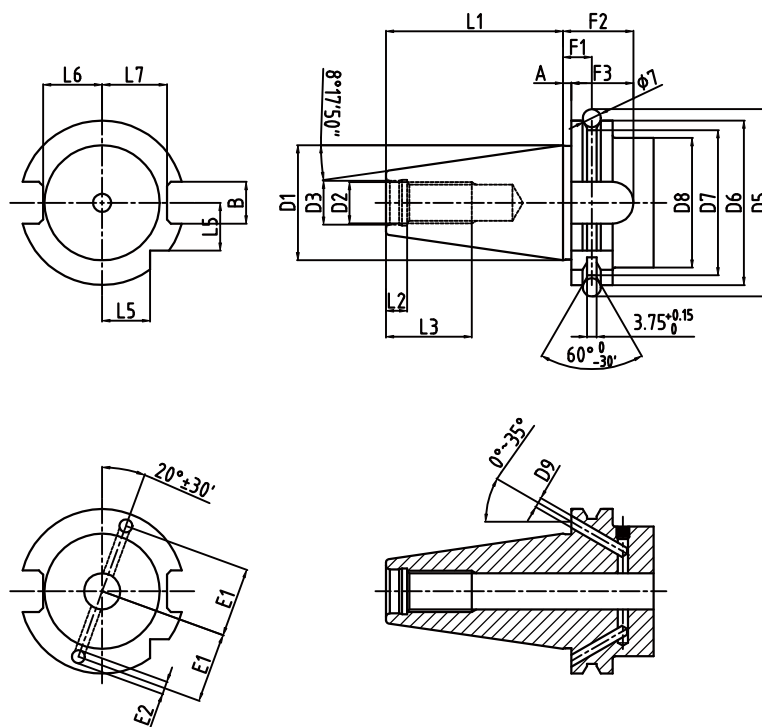
Technical Data

HSK	32	40	50	63	80	100
B1 ± 0.04	7.05	8.05	10.54	12.54	16.04	20.02
B2 $_{H10}$	7	9	12	16	18	20
B3 $_{H10}$	9	11	14	18	20	22
D1 $_{H10}$	32	40	50	63	80	100
D2	24 $^{+0.007}_{+0.005}$	30 $^{+0.007}_{+0.005}$	38 $^{+0.009}_{+0.006}$	48 $^{+0.011}_{+0.007}$	60 $^{+0.013}_{+0.008}$	75 $^{+0.015}_{+0.009}$
D4 $_{H10}$	17	21	26	34	42	53
D5 $_{H11}$	21	25.5	32	40	50	63
D6	19	23	29	37	46	58
D10 $_{max}$	26	34	42	53	67	85
D11 $^0_{-0.01}$	26.5	34.8	43	55	70	92
D12 $^0_{-0.01}$	37	45	59.3	72.3	88.8	109.75
D13	4			7		
F1 $^0_{-0.01}$	20			26		
F2 $_{min}$	35			42		
F3 ± 0.01	16			18		
F4 $^{+0.15}_0$	2			3.75		
H1 $^0_{-0.2}$	13	17	21	26.5	34	44
H2 $^0_{-0.13}$	9.5	12	15.5	20	25	31.5
L1 $^0_{-0.2}$	16	20	25	32	40	50
L2	3.2	4	5	6.3	8	10
L4 $^{+0.2}_0$	5	6	7.5	10	12	15
L5 $^{+0.2}_0$	3	3.5	4.5	6	8	10
L6 $_{JS10}$	8.92	11.42	14.13	18.13	22.85	28.56
L7 $^0_{-0.1}$	8		10	10	12.5	12.5
L13	12		19	21	22	24



Technical Data

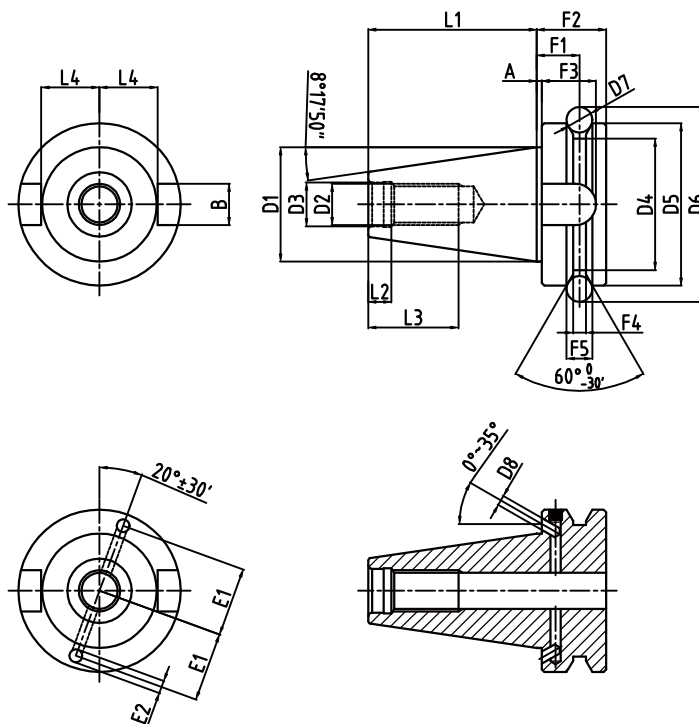
ISO	30	40	45	50	60
A ± 0.01			3.2		
B $H12$	16.1		19.3	25.7	
D1	31.75	44.45	57.15	69.85	107.96
D2	M12	M16	M20	M24	M30
D3 $H7$	13	17	21	25	32
D5 ± 0.05	59.3	72.3	91.35	107.25	164.75
D6 $\begin{smallmatrix} 0 \\ -0.1 \end{smallmatrix}$	50	63.55	82.55	97.50	155
D7 $\begin{smallmatrix} 0 \\ -0.5 \end{smallmatrix}$	44.3	56.25	75.25	91.25	147.70
D8 max	45	50	63	80	130
D9	4		5	6	8
E1 ± 0.1	21	27	35	42	66
E2 max	5		6	7	9.2
F1 ± 0.1			11.1		
F2 min.		35			38
F3 $\begin{smallmatrix} 0 \\ -0.1 \end{smallmatrix}$			19.1		
L1 $\begin{smallmatrix} 0 \\ -0.3 \end{smallmatrix}$	47.8	68.4	82.7	101.75	161.80
L2 $\begin{smallmatrix} +0.5 \\ 0 \end{smallmatrix}$	5.5	8.2	10	11.5	14
L3 min.	24	32	40	47	59
L5 $\begin{smallmatrix} 0 \\ -0.3 \end{smallmatrix}$	15	18.5	24	30	49
L6 $\begin{smallmatrix} 0 \\ -0.4 \end{smallmatrix}$	16.4	22.8	29.1	35.5	54.5
L7 $\begin{smallmatrix} 0 \\ -0.4 \end{smallmatrix}$	19	25	31.3	37.7	59.3



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Technical Data

ISO	30	35	40	45	50	60
A ± 0.04		2			3	
B H_{12}		16.1		19.3	25.7	25.7
D1	31.75	38.10	44.45	57.15	69.85	107.95
D2		M12	M16	M20	M24	M30
D3 H_8		12.5	17	21	25	31
D4	38	43	53	73	85	135
D5 H_8	46	53	63	85	100	155
D6	56.144	65.680	75.679	100.215	119.019	180.359
D7	8		10	12	15	20
D8		4		5	6	8
E1 ± 0.1	21	23	27	35	42	66
E2 $_{max}$		5		6	7	9.2
F1 ± 0.01	13.6	14.6	16.6	21.2	23.2	28.2
F2	22	24	27	33	38	48
F3 $_{min}$	17	20	21	26	31	34
F4	4		5	6	7	11
F5 $_{0}^{+0.1}$	8		10	12	15	20
L1 ± 0.2	48.4	56.4	65.4	82.8	101.8	161.8
L2 $_{0}^{+0.05}$		7	9	11	13	16
L3 $_{min}$		24	30	38	45	56
L4 $_{-0.2}^0$	16.3	19.6	22.6	29.1	35.4	60.1



MAS 403 BT A-B

Tap

Metric (M)

Tap Size	Drill Diameter	Tap Size	Drill Diameter	Tap Size	Drill Diameter	Tap Size	Drill Diameter
M1x0.25	0.75	M2.5x0.45	2.10	M9x1.25	7.80	M27x3	24.0
M1.1x0.25	0.85	M2.6x0.45	2.20	M10x1.5	8.50	M30x3.5	26.5
M1.2x0.25	0.95	M3x0.5	2.50	M11x1.5	9.50	M33x3.5	29.5
M1.4x0.3	1.10	M3.5x0.6	2.90	M12x1.75	10.3	M36x4	32.0
M1.6x0.35	1.25	M4x0.7	3.30	M14x2	12.0	M39x4	35.0
M1.7x0.35	1.35	M4.5x0.75	3.80	M16x2	14.0	M42x4.5	37.5
M1.8x0.35	1.45	M5x0.8	4.20	M18x2.5	15.5	M45x4.5	40.5
M2x0.4	1.60	M6x1.0	5.00	M20x2.5	17.5	M48x5	43.0
M2.2x0.45	1.75	M7x1.0	6.00	M22x2.5	19.5		
M2.3x0.4	1.90	M8x1.25	6.80	M24x3	21.0		

Metric fine (M)

Tap Size	Drill Diameter	Tap Size	Drill Diameter	Tap Size	Drill Diameter	Tap Size	Drill Diameter
M1x0.2	0.80	M11x1.0	10.0	M24x1.0	23.0	M38x1.5	36.5
M1.1x0.2	0.90	M11x0.75	10.3	M25x2.0	23.0	M39x3.0	36.0
M1.2x0.2	1.00	M12x1.5	10.5	M25x1.5	23.5	M39x2.0	37.0
M1.4x0.2	1.20	M12x1.25	10.8	M25x1.0	24.0	M39x1.5	37.5
M1.6x0.2	1.40	M12x1.0	11.0	M26x1.5	24.5	M40x3.0	37.0
M1.8x0.2	1.60	M14x1.5	12.5	M27x2.0	25.0	M40x2.0	38.0
M2x0.25	1.75	M14x1.0	13.0	M27x1.5	25.5	M40x2.5	38.5
M2.2x0.25	1.95	M15x1.5	13.5	M27x1.0	26.0	M40x1.5	38.0
M2.5x0.35	2.20	M15x1.0	14.0	M28x2.0	26.0	M42x1.0	39.0
M3x0.35	2.70	M16x1.5	14.5	M28x1.5	26.5	M42x2.0	40.0
M3.5x0.35	3.20	M16x1.0	15.0	M28x1.0	27.0	M42x1.5	40.5
M4x0.5	3.50	M17x1.5	15.5	M30x3.0	27.0	M45x1.0	41.0
M4.5x0.5	4.00	M17x1.0	16.0	M30x2.0	28.0	M45x3.0	42.0
M5x0.5	4.50	M18x2.0	16.0	M30x1.5	28.5	M45x2.0	43.0
M5.5x0.5	5.00	M18x1.5	16.5	M30x1.0	29.0	M45x1.5	43.5
M6x0.75	5.30	M18x1.0	17.5	M32x2.0	30.0	M48x1.0	44.0
M7x0.75	6.30	M20x2.0	18.0	M32x1.5	30.5	M48x2.0	45.0
M8x1.0	7.00	M20x1.5	18.5	M32x3.0	30.0	M48x1.5	46.0
M8x0.75	7.30	M20x1.0	19.0	M33x2.0	31.0	M48x3.0	46.5
M9x1.0	8.00	M22x2.0	20.0	M33x1.5	31.5	M50x3.0	47.0
M9x0.75	8.30	M22x1.5	20.5	M35x1.5	33.5	M50x2.0	48.0
M10x1.25	8.80	M22x1.0	21.0	M36x3.0	33.0	M50x1.5	48.5
M10x1.0	9.00	M24x2.0	22.0	M36x2.0	34.0		
M10x0.75	9.30	M24x1.5	22.5	M36x1.5	34.5		

Tap

(UNC)

Tap Size	Drill Diameter	Tap Size	Drill Diameter
NO.1-64 UNC	1.75	7/8-10 UNC	19.6
NO.2-56 UNC	1.86	1-9 UNC	22.5
NO.3-48 UNC	2.14	1 1/8-8 UNC	25.2
NO.4-40 UNC	2.36	1 1/4-7 UNC	28.4
NO.5-40 UNC	2.69	1 3/8-7 UNC	31.0
NO.6-32 UNC	2.86	1 1/2-6 UNC	34.2
NO.8-32 UNC	3.52	1 3/4-6 UNC	39.8
NO.10-24 UNC	3.91	2-5 UNC	45.3
NO.12-24 UNC	4.57	2 1/4-4 1/2 UNC	51.7
1/4-20 UNC	5.25	2 1/2-4 1/2 UNC	57.3
5/16-18 UNC	6.72	2 3/4-4 UNC	63.7
3/8-16 UNC	8.15	3-4 UNC	70.0
7/16-14 UNC	9.50	3 1/4-4 UNC	76.4
1/2-13 UNC	11.0	3 1/2-4 UNC	82.7
9/16-12 UNC	12.3	3 3/4-4 UNC	89.1
5/8-24 UNC	13.8	4-4 UNC	95.4
3/4-11 UNC	16.8	M20 x 2.0	18.0

(PF)

Tap Size	PF	reammer(use)	reammer(don't use)	PF
1/6-28	6.79	6.11	6.23	6.49
1/8-28	8.80	8.11	8.24	8.50
1/4-19	11.8	10.8	10.9	11.3
1/8-19	15.3	14.2	14.2	14.9
1/2-14	19.1	17.7	18.0	18.5
5/8-14	21.1			
3/4-14	24.6	23.1	23.3	24.0
7/8-14	28.3			
1-11	30.9	29.1	29.4	31.1
1 1/8-11	35.5			
1 1/4-11	39.5	37.5	38.0	38.8
1 1/2-11	45.4	43.4	43.8	44.5
1 3/4-11	51.4			
2-11	57.2	54.9	55.4	56.5
2 1/4-11	63.3			72.0
2 1/2-11	72.8	70.2	70.7	84.7

