

Design

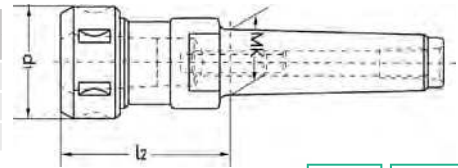
Morse taper with inner clamping threads.
With clamping nut.

Note:

For collet chucks, see art. no. 21552–21554.



Taper MK/ Clamping thread	Clamping range mm	For collet chuck type	l_2 mm	d_1 mm	21541	...
2/M 10	2–16	415 E	62	43		100
3/M 12	2–25	462 E	70	60		101
4/M 16	2–25	462 E	70	60		102

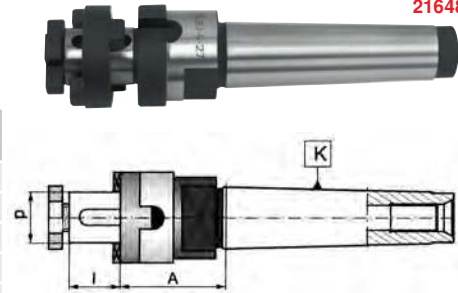
**Design**

Morse taper shank with inner clamping thread.

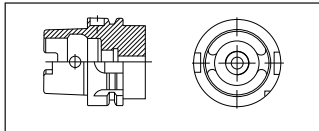
Applications

With key for cutters with longitudinal grooves such as DIN 841, and driver ring for cutters with lateral groove DIN 1880 and blade heads DIN 1830.

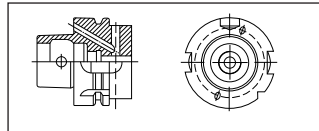
Taper MK	d mm	A mm	l mm	21648	...
3	16	48	17		101
3	22	48	19		102
3	27	48	21		103
4	22	55	19		106
4	27	55	21		107

**Info****Tool chucks in accordance with DIN 69893****Design**

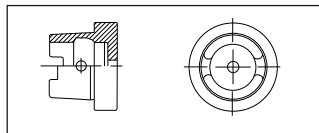
Alloyed case-hardening steel, min. tensile strength of 950 N/mm². Taper tolerance lower than AT3 in accordance with DIN 7187 and DIN 2080. The operating hardness and depth are adapted to the respective chuck. To prevent the risk of breaking or cracking, thin-walled HSK chucks are not fully hardened.

Various shapes of hollow shank taper in line with DIN 69893:**Hollow shank taper HSK for automatic tool changes with gripper groove.****Type A**

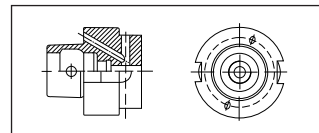
- Machining centre applications with automatic tool changes.
- Central coolant supply via coolant tube.

Type B

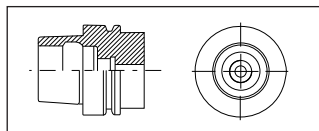
- Machining centre and lathe applications with automatic tool changes.
- Extended contact flange.
- Coolant supply via flange or central coolant tube.

HSK hollow shank taper for manual tool changes without gripper groove.**Type C**

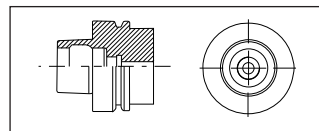
- Primarily for applications in transfer lines and special machines with manual tool changes.
- Central coolant supply.

Type D

- Suitable for machining applications that require good support from a flat face.
- Manual tool change.
- Extended contact flange.
- Coolant supply via flange or central coolant tube.

HSK hollow shank taper for high rotation speeds in high-speed cutting (HSC) with gripper groove.**Type E**

- HSC machining applications.
- Symmetrical without driver slots.
- Central coolant supply possible via coolant tube.

Type F

- Extended contact flange.
- Central coolant supply possible via coolant tube.



Shrink-fit chucks

21803

Shrink-fit chuck, 3°

ATORN®

Design

- Slim design
- High transmittable torques
- High concentricity
- Balluf chip bore

Scope of delivery:

- Built-in stop screw

Applications

For shrinking HSS and cemented-carbide tools with a shaft tolerance of h6 and more precise.

Quality

Made of special high-strength heat-resistant steel.

DIN
69893

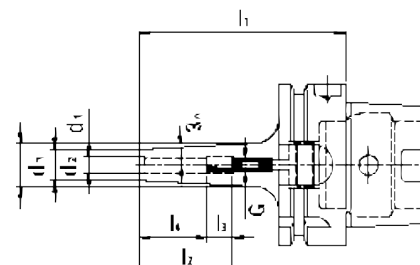
A



G 2.5
25000
1/min



21803



Short

Taper HSK	d ₁ mm	l ₁ mm	d ₂ mm	d ₃ mm	l ₂ mm	l ₃ mm	l ₄ mm	THD	21803	...
63	3	80	9	14	28	16	12	M 6		103
63	4	80	10	15	28	12	16	M 6		104
63	5	80	11	16	30	10	20	M 6		105
63	6	80	12	17	36	10	26	M 5		106
63	8	80	14	19	36	10	26	M 6		108
63	10	85	16	21	41	10	31	M 8 x 1		110
63	12	90	18	23	47	10	37	M 10 x 1		112
63	14	90	20	26	47	10	37	M 10 x 1		114
63	16	95	22	28	50	10	40	M 12 x 1		116
63	18	95	24	30	50	10	40	M 12 x 1		118
63	20	100	26	32	52	10	42	M 16 x 1		120

Medium length

Taper HSK	d ₁ mm	l ₁ mm	d ₂ mm	d ₃ mm	l ₂ mm	l ₃ mm	l ₄ mm	THD	21803	...
63	3	120	9	16	-	-	12	M 6		203
63	4	120	10	17	-	-	16	M 6		204
63	5	120	11	18	-	-	20	M 6		205
63	6	120	12	22	36	10	26	M 5		206
63	8	120	14	24	36	10	26	M 6		208
63	10	120	16	26	41	10	31	M 8 x 1		210
63	12	120	18	28	47	10	37	M 10 x 1		212
63	14	120	20	30	47	10	37	M 10 x 1		214
63	16	120	22	32	50	10	40	M 12 x 1		216
63	18	120	24	34	50	10	40	M 12 x 1		218
63	20	120	26	36	52	10	42	M 16 x 1		220

Long

Taper HSK	d ₁ mm	l ₁ mm	d ₂ mm	d ₃ mm	l ₂ mm	l ₃ mm	l ₄ mm	THD	21803	...
63	3	160	9	19	-	-	12	M 6		303
63	4	160	10	20	-	-	16	M 6		304
63	5	160	11	21	-	-	20	M 6		305
63	6	160	12	24	36	10	26	M 5		306
63	8	160	14	26	36	10	26	M 6		308
63	10	160	16	28	41	10	31	M 8 x 1		310
63	12	160	18	30	47	10	37	M 10 x 1		312
63	14	160	20	32	47	10	37	M 10 x 1		314
63	16	160	22	34	50	10	40	M 12 x 1		316
63	18	160	24	36	50	10	40	M 12 x 1		318
63	20	160	26	38	52	10	42	M 16 x 1		320

ATORN®**Design**

- Slim design
- Made of special high-strength heat-resistant steel
- Additional threads on the circumference
- For subsequent balancing
- Balluf chip bore
- Made in Germany

Scope of delivery:

- Built-in stop screw

Applications

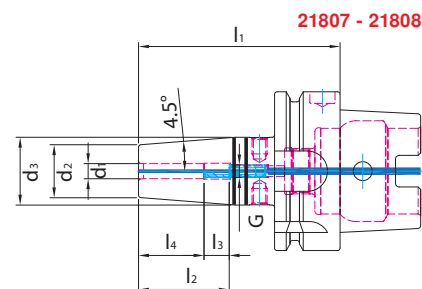
For inductive shrinking of HSS and cemented-carbide tools with a shaft tolerance of h6 and more precise.

21807

- With central coolant supply

21808

- With central coolant supply and additional resealable cooling channels



21807 - 21808

Short		Without KKB							With KKB			
Taper HSK	d ₁ mm	l ₁ mm	d ₂ mm	d ₃ mm	l ₂ mm	l ₃ mm	l ₄ mm	THD	21807	...	21808	...
63	3	80	10	15	28	16	12	M 6		101		101
63	4	80	15	22	28	12	16	M 6		102		102
63	5	80	15	22	30	10	20	M 6		103		103
63	6	80	21	27	36	10	26	M 5		104		104
63	8	80	21	27	36	10	26	M 6		105		105
63	10	85	24	32	41	10	31	M 8 x 1		106		106
63	12	90	24	32	47	10	37	M 10 x 1		107		107
63	14	90	27	34	47	10	37	M 10 x 1		108		108
63	16	90	27	34	50	10	40	M 12 x 1		109		109
63	18	95	33	42	50	10	40	M 12 x 1		110		110
63	20	100	33	42	52	10	42	M 16 x 1		111		111
63	25	115	44	53	58	10	48	M 16 x 1		112		112

Medium length		Without KKB							With KKB			
Taper HSK	d ₁ mm	l ₁ mm	d ₂ mm	d ₃ mm	l ₂ mm	l ₃ mm	l ₄ mm	THD	21807	...	21808	...
63	3	120	10	20	-	-	12	-		201		201
63	4	120	15	22	-	-	16	-		202		202
63	5	120	15	22	-	-	20	-		203		203
63	6	120	21	27	36	10	26	M 5		204		204
63	8	120	21	27	36	10	26	M 6		205		205
63	10	120	24	32	41	10	31	M 8 x 1		206		206
63	12	120	24	32	47	10	37	M 10 x 1		207		207
63	14	120	27	34	47	10	37	M 10 x 1		208		208
63	16	120	27	34	50	10	40	M 12 x 1		209		209
63	18	120	33	42	50	10	40	M 12 x 1		210		210
63	20	120	33	42	52	10	42	M 16 x 1		211		211

Long		Without KKB										
Taper HSK	d ₁ mm	l ₁ mm	d ₂ mm	d ₃ mm	l ₂ mm	l ₃ mm	l ₄ mm	THD	21807	...	21808	...
63	3	160	10	20	-	-	12	-		301		301
63	4	160	15	22	-	-	16	-		302		302
63	5	160	15	22	-	-	20	-		303		303
63	6	160	21	27	36	10	26	M 5		304		304
63	8	160	21	27	36	10	26	M 6		305		305
63	10	160	24	32	41	10	31	M 8 x 1		306		306
63	12	160	24	32	47	10	37	M 10 x 1		307		307
63	14	160	27	34	47	10	37	M 10 x 1		308		308
63	16	160	27	34	50	10	40	M 12 x 1		309		309
63	18	160	33	42	50	10	40	M 12 x 1		310		310
63	20	160	33	42	52	10	42	M 16 x 1		311		311

Extra long		Without KKB										
Taper HSK	d ₁ mm	l ₁ mm	d ₂ mm	d ₃ mm	l ₂ mm	l ₃ mm	l ₄ mm	THD	21807	...	21808	...
63	6	200	21	27	36	10	26	M 5		404		404
63	8	200	21	27	36	10	26	M 6		405		405
63	10	200	24	32	41	10	31	M 8 x 1		406		406
63	12	200	24	32	47	10	37	M 10 x 1		407		407
63	14	200	27	34	47	10	37	M 10 x 1		408		408
63	16	200	27	34	50	10	40	M 12 x 1		409		409
63	18	200	33	42	50	10	40	M 12 x 1		410		410
63	20	200	33	42	52	10	42	M 16 x 1		411		411

21807 101-112



21807 201-211



21807 301-311



21807 404-411



Shrink-fit chucks

21598

Shrink-fit chucks extension/reduction

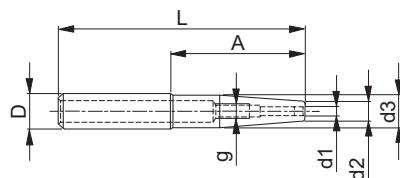
diebold

Applications

For extending and reducing to smaller shank diameters.

Note:

Other sizes deliverable on request.



21598



D	d1	d2	d3	A	L	g	21598	...
mm	mm	mm	mm	mm	mm			
12	3	9	11.8	63	110	-		101
12	4	10	11.8	63	110	-		102
12	5	11	11.8	63	110	-		103
12	6	12	17	63	110	M 5		104
12	8	14	19	63	110	M 6		105
16	3	9	13	60	110	M 6		201
16	4	10	14	60	110	M 6		202
16	5	11	15	58	110	M 6		203
16	6	12	15.8	60	110	M 5		204
16	8	14	19	60	110	M 6		205
20	3	9	13	58	110	M 6		301
20	4	10	14	58	110	M 6		302
20	5	11	15	58	110	M 6		303

D	d1	d2	d3	A	L	g	21598	...
mm	mm	mm	mm	mm	mm			
20	6	12	16	58	110	M 5		304
20	8	14	19	58	110	M 6		305
20	10	16	19.8	58	110	M 8 x 1		306
20	12	18	19.8	58	110	M 10 x 1		307
16	3	9	16	150	200	-		405
16	4	10	16	150	200	-		406
16	5	11	16	150	200	-		407
16	6	12	16	150	200	M 5		408
20	6	12	20	198	250	M 5		501
20	8	14	20	198	250	M 6		502
20	10	16	20	198	250	M 8 x 1		503
25	12	18	25	193	250	M 10 x 1		601
25	16	22	25	193	250	M 12 x 1		602

Intelligent shrink technology thanks to patented pre-widening (shrink-fit chucks art.-no. 21597 and 21599)

• Striking

• Simple

• Extremely effective



The patented pre-widening is used for automatic pre-centring of the tool and means more precision during the shrinking process without annoying tilting during the joining process. The shrinking process can take place automatically and without any assistance.

diebold

diebold**Design**

- **Highest level of concentricity** and taper tolerance
- Made in air-conditioned production

Advantages:

- High retention forces and long service life thanks to the use of **high-quality heat-resistant steels** and special heat treatment processes
- **Patented taper** allows automatic shrink processes and simplified handling

Use

For clamping of cemented carbide, HSS and steel shafts with a tolerance of h6.

Note:

Coolant tube, see art. no. 21864.

Key for coolant tube, see art. no. 21865.

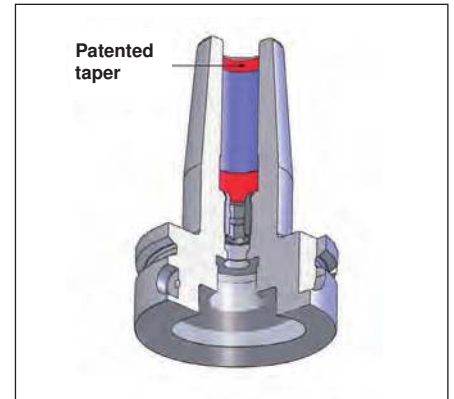
For shrinking equipment, see art. no. 21588–21595.

21597 501-525

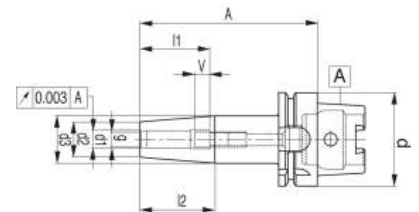
- Slim, **stainless coated**

HSK	d1 mm	d2 mm	d3 mm	l1 mm	l2 mm	A mm	V mm	g	21597	...
63	3	15	20	20	30	90	5	M 6		101
63	4	15	20	20	30	90	5	M 6		102
63	5	15	20	25	30	90	5	M 6		103
63	6	21	27	36	45	80	10	M 5		104
63	8	21	27	36	45	80	10	M 6		105
63	10	24	32	42	50	90	10	M 8 x 1		106
63	12	24	32	47	50	90	10	M 10 x 1		107
63	14	27	34	47	50	90	10	M 10 x 1		108
63	16	27	34	50	50	95	10	M 12 x 1		109
63	18	33	42	50	57	95	10	M 12 x 1		110
63	20	33	42	52	57	100	10	M 16 x 1		111
63	25	44	53	58	57	115	10	M 16 x 1		112
63	32	44	53	62	57	120	10	M 16 x 1		113
63 L	6	21	27	36	45	120	10	M 5		201
63 L	8	21	27	36	45	120	10	M 6		202
63 L	10	24	32	42	50	120	10	M 8 x 1		203
63 L	12	24	32	47	50	120	10	M 10 x 1		204
63 L	14	27	34	47	50	120	10	M 10 x 1		205
63 L	16	27	34	50	50	120	10	M 12 x 1		206
63 L	18	33	42	50	57	120	10	M 12 x 1		207
63 L	20	33	42	52	57	120	10	M 16 x 1		208
63 XL	6	21	32	36	45	160	10	M 5		301
63 XL	8	21	32	36	45	160	10	M 6		302
63 XL	10	24	34	42	50	160	10	M 8 x 1		303
63 XL	12	24	34	47	50	160	10	M 10 x 1		304
63 XL	14	27	42	47	50	160	10	M 10 x 1		305
63 XL	16	27	42	50	50	160	10	M 12 x 1		306
63 XL	18	33	51	50	57	160	10	M 12 x 1		307
63 XL	20	33	51	52	57	160	10	M 16 x 1		308
63 XL	25	44	53	58	57	160	10	M 16 x 1		309
63 XL	32	44	53	62	57	160	10	M 16 x 1		310

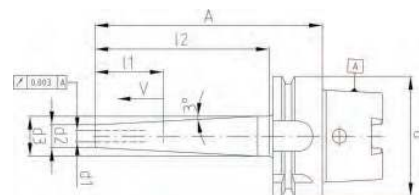
HSK	d1 mm	d2 mm	d3 mm	l1 mm	l2 mm	A mm	V mm	g	slim 21597	...
63	3	9	13	20	40	70	5	M 6		501
63	4	10	14	20	40	70	5	M 6		502
63	6	12	18	36	60	90	5	M 5		503
63	8	14	20	36	60	90	5	M 6		504
63	10	16	22	42	60	90	5	M 8 x 1		505
63	12	18	24	47	60	90	5	M 10 x 1		506
63	16	22	28	50	60	90	5	M 12 x 1		507
63 L	3	9	16	20	70	100	5	m 6		510
63 L	4	10	17	20	70	100	5	M 6		511
63 L	6	12	21	36	90	120	5	M 5		512
63 L	8	14	23	36	90	120	5	M 6		513
63 L	10	16	25	42	90	120	5	M 8 x 1		514
63 L	12	18	27	47	90	120	5	M 10 x 1		515
63 L	16	22	31	50	90	120	5	M 12 x 1		516
63 XL	3	9	19	20	100	130	5	m 6		519
63 XL	4	10	20	20	100	130	5	M 6		520
63 XL	6	12	24	36	120	150	5	M 5		521
63 XL	8	14	26	36	120	150	5	M 6		522
63 XL	10	16	28	42	120	150	5	M 8 x 1		523
63 XL	12	18	30	47	120	150	5	M 10 x 1		524
63 XL	16	22	34	50	120	150	5	M 12 x 1		525



21597 101-310



21597 501-525



21599

Shrink-fit chucks

DIN
69893

E

G 2,5
42000
1/min

HSC

HPC

diebold

Design

- **Highest level of concentricity** and taper tolerance
- Made in air-conditioned production

Advantages:

- High retention forces and long service life thanks to the use of **high-quality heat-resistant steels** and special heat treatment processes
- **Patented taper** allows automatic shrink processes and simplified handling

Applications

For clamping of cemented carbide, HSS and steel shafts with a tolerance of h6.

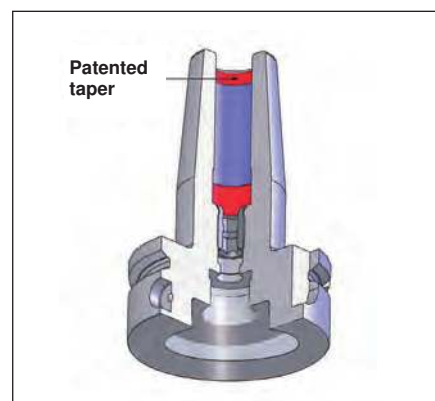
Note:

For shrinking equipment, see art. no. 21588 to 21595.

21599 201-223

Design

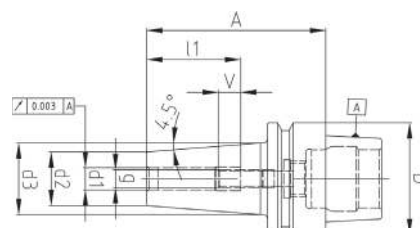
- Slim, **stainless coated**



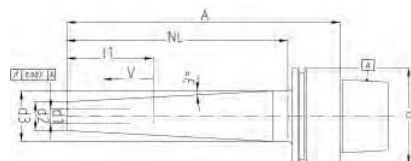
HSK	d1 mm	d2 mm	d3 mm	l1 mm	A mm	V mm	g	21599	...
40	3	15	20	20	60	5	M 6		101
40	4	15	20	20	60	5	M 6		102
40	5	15	20	25	60	5	M 6		103
40	6	21	27	36	65	-	-		104
40	8	21	27	36	65	-	-		105
40	10	24	30	42	65	-	-		106
40	12	24	30	47	65	-	-		107
40	14	27	34	47	65	-	-		108
40	16	27	34	50	65	-	-		109
40 L	3	15	20	20	80	5	m 6		110
40 L	4	15	20	20	80	5	m 6		111
40 L	5	15	20	25	80	5	M 6		112
40 L	6	21	27	36	80	10	M 5		113
40 L	8	21	27	36	80	10	M 6		114
40 L	10	24	32	42	80	10	M 8 x 1		115
40 L	12	24	32	47	90	10	M 10 x 1		116
40 L	14	27	34	47	90	10	M 10 x 1		118
40 L	16	27	34	50	90	10	M 12 x 1		119
40 XL	3	15	20	20	120	5	M 6		120
40 XL	4	15	20	20	120	5	M 6		121
40 XL	5	15	20	25	120	5	M 6		122
40 XL	6	21	27	36	120	10	M 5		123
40 XL	8	21	27	36	120	10	M 6		124
40 XL	10	24	32	42	120	10	M 8 x 1		125
40 XL	12	24	32	47	120	10	M 10 x 1		126
40 XL	14	27	34	47	120	10	M 10 x 1		127
40 XL	16	27	34	44	120	10	M 12 x 1		128

HSK	d1 mm	d2 mm	d3 mm	l1 mm	NL mm	A mm	V mm	g	slim 21599	...
40	3	9	12	20	24	50	5	M 6		201
40	4	10	13	20	24	50	5	M 6		202
40	6	12	15	34	24	50	-	-		203
40	6	12	16	36	38	60	-	-		204
40	8	14	18	36	38	60	-	-		205
40	10	16	20	42	38	60	-	-		206
40	12	18	22	42	38	60	-	-		207
40 L	3	9	13	20	40	64	5	M 6		208
40 L	4	10	14	20	40	64	5	M 6		209
40 L	6	12	18	36	60	84	5	M 5		210
40 L	8	14	20	36	60	84	5	M 6		211
40 L	10	16	22	42	60	84	5	M 8 x 1		212
40 L	12	18	24	47	60	84	5	M 10 x 1		213
40 XL	3	9	16	20	70	94	5	M 6		214
40 XL	4	10	17	20	70	94	5	M 6		215
40 XL	6	12	21	36	90	114	5	M 5		216
40 XL	8	14	23	36	90	114	5	M 6		217
40 XL	10	16	25	42	90	114	5	M 8 x 1		218
40 XL	12	18	27	47	90	114	5	M 10 x 1		219
40 XXL	6	12	24	36	120	144	5	M 5		220
40 XXL	8	14	26	36	120	144	5	M 6		221
40 XXL	10	16	28	42	120	144	5	M 8 x 1		222
40 XXL	12	18	30	47	120	144	5	M 10 x 1		223

21599 101-128



21599 201-223



21829

Short drill chuck

DIN
69893

A

G 6.3
12000
1/min
ATORN®

Design

- Short model
- Wear parts hardened and ground
- Clamped via worm gear

Scope of delivery:

Includes spanner with T-handle for high traction.

Applications

For clockwise/anti-clockwise rotation.

21829



HSK	Clamping range mm	A mm	D mm	21829	...
63	1-16	100	50		201

21830

CNC precision drill chuck

DIN
69893G 6.3
25000
1/min
HHW

Design

- Concentricity less than or equal to 20 µm
- High clamping force
- Very short design
- Max. rotation speed finely balanced 35,000 rpm
- Balluf chip bore

Scope of delivery:

- Delivered with hexagon key with T-handle
SW 6 mm

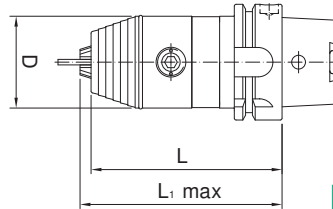
Applications

Suitable for clockwise/anti-clockwise rotation.

21830 201-202

Design

- Incl. **sealing washers** for the entire clamping range (1x installed, 1x in scope of delivery)



A

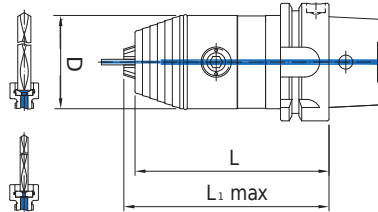
21830 101-102



AD



21830 201-202



Taper HSK	Clamping range mm	D mm	L mm	L ₁ Max. mm	Torque Nm	Retention force N	Weight kg	HSK-A 63 21830	HSK-A 63 with ICS 21830	...
63	0.5-13	50	104	110	20	80	1.7		101	
63	2.5-16	57	109	115	20	90	1.9		102	
63	0.5-13	50	104	110	20	80	1.7			201
63	2.5-16	57	109	115	20	90	1.9			202

21838

Quick-change tapping chuck

DIN
69893

A

HHW

Design

- Precision version with length compensation under compression and tension

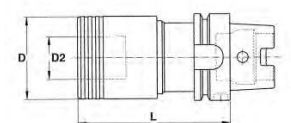
Note:

For quick-change inserts, see art. no. 21459-21460.

21838



HSK	For screw tap	Suitable inserts/size	Length compensation pressure/tension mm	L mm	D Ø mm	D ₂ diameter mm	21838	...
63	M 3-M 12	1	7.5/7.5	72	41	19		101
63	M 6-M 20	2	10/10	110	60	31		102



21837

Quick-change tapping chuck for synchronous spindles

DIN
69893

A



ATORN®

Design

- Minimum length compensation applied by damping element
- Secure clamping in quick-change inserts for ER collets
- Clamping screws to prevent rotation of the clamped screw tap

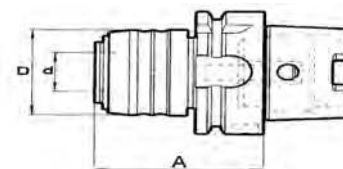
Applications

For use on drilling and machining centres with synchronous spindles.

Note:

For quick-change inserts, see art. no. 21465.

21837



HSK-A	d mm	D mm	A mm	Length compensation Pressure/tension mm	For screw tap	21837	...
63	20	43	64	0.2/1.0	M 3-M 12	101	
63	32	60	97	0.2/1.0	M 6-M 20	102	

21840

Hydraulic expansion chuck, short, heavy-duty design

DIN
69893

A



G 2.5
25000
1/min



ATORN®

Design

- High degree of concentricity and maximum torque transmission
- Vibration-damping tool clamping
- Easy to use
- High positioning accuracy and repetition accuracy
- Made in Germany

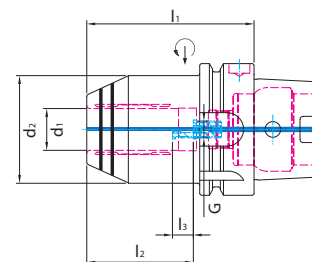
Applications

For finish, drilling and reaming.
 Can clamp all common shanks.

Note:

For reducing sleeves, see art. no. 21581.
 For pull studs, see art. no. 21733-21740.
 Key for coolant tube, see art. no. 21865.

21840



HSK	d1 mm	d2 mm	l1 mm	l2 mm	l3 mm	THD	SW mm	21840	...
63	20	52	80	51	10	M 8 x 1	3	050	

21866

Ultra-slim hydraulic expansion chuck 3°

DIN
69893

A



G 2.5
25000
1/min



HSC

ATORN®

Design

- Newly developed, **ultra-slim** hydraulic expansion chuck with 3° incline
- Increased clamping force
- For tight interference contours
- Very high temperature resistance up to 180 °C

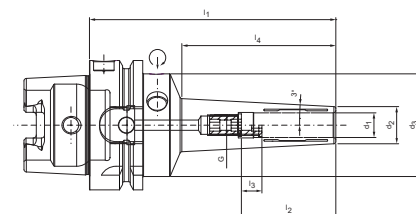
Advantages:

- Near-contour machining
- Expensive shrink-fit device no longer required

Applications

For drilling, reaming and milling.

21866



Taper HSK	d1 mm	d2 mm	d3 mm	l1 mm	l2 mm	l3 mm	l4 mm	THD	SW mm	21866	...
63	3	9	50	120	28	16	73	M 3	1.5	098	
63	4	10	50	120	28	12	73	M 3	1.5	099	
63	5	11	50	120	28	8	73	M 3	1.5	100	
63	6	12	50	120	37	10	73	M 5	2.5	101	
63	8	14	50	120	37	10	74	M 6	3.0	102	
63	10	16	50	120	41	10	74	M 8 x 1	3.0	103	
63	12	18	50	120	46	10	75	M 10 x 1	5.0	104	

21847

HHD hydraulic expansion roughing chuck

DIN
69893

A

G 2.5
25000
1/min**ATORN®****Design**

- Further development of the standard expansion chuck
- Best torque transmission
- High damping properties
- High temperature resistance

Advantage:

- Can clamp all common shanks

Applications

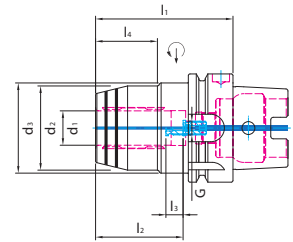
For heavy-duty machining in HSC, HPC and TF milling applications.

Note:

For reducing sleeves, see art. no. 21581.



21847



HSK	d ₁ mm	d ₂ mm	d ₃ mm	l ₁ mm	l ₂ mm	l ₃ mm	l ₄ mm	THD mm	SW mm	21847	...
63	12	42	52.5	80	46	10	34	M 8 x 1	3		101
63	20	49	52.5	80	51	10	36	M 8 x 1	3		102

21841

Mill arbors for screw-on mill cutters

DIN
69893

A

G 2.5
25000
1/min

HSC

hww**Design**

- Precision design
- Ground outer taper and fitting surface
- Balluf chip bore

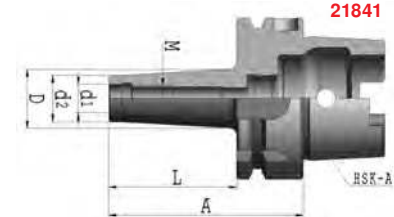
Applications

For mounting threaded screw-in mill cutters.

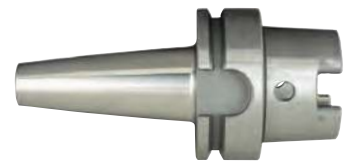
Note:

Coolant tube, see art. no. 21864.

Key for coolant tube, see art. no. 21865.



21841



Extra short							21841	...
HSK	d ₁ mm	d ₂ mm	D mm	A mm	L mm	M		
63	6.5	10	13	51	25	6		101
63	8.5	13	15	51	25	8		102
63	10.5	18	20	51	25	10		105
63	12.5	21	24	51	25	12		109
63	17.0	29	29	51	25	16		114

Short							21841	...
HSK	d ₁ mm	d ₂ mm	D mm	A mm	L mm	M		
63	8.5	13	23	76	50	8		103
63	10.5	18	23	76	50	10		106
63	12.5	21	24	76	50	12		110
63	17.0	29	34	76	50	16		115

Medium length							21841	...
HSK	d ₁ mm	d ₂ mm	D mm	A mm	L mm	M		
63	8.5	13	23	101	75	8		104
63	12.5	21	31	101	75	12		111
63	17.0	29	34	101	75	16		116

Long							21841	...
HSK	d ₁ mm	d ₂ mm	D mm	A mm	L mm	M		
63	10.5	18	32	126	100	10		107
63	12.5	21	33	126	100	12		112
63	17.0	29	36	126	100	16		117

Extra long							21841	...
HSK	d ₁ mm	d ₂ mm	D mm	A mm	L mm	M		
63	10.5	18	36.5	176	150	10		108
63	12.5	21	40.0	176	150	12		113
63	17.0	29	42.5	176	150	16		118

Clamping technology

Collet chucks

21843

ER collet chuck

DIN
69893

A



G 2.5
25000
1/min



21843



Design

- Precision design
- **Precision-balanced, grade 2.5 at 25,000 rpm**
- Size ER 16 with hexagonal nut
- Balluff chip bore
- Max. concentricity < 0.005 mm

Note:

For collet chuck sets, see art. no. 21519.
For collet chucks, see art. no. 21520–21525 and 21534–21539.
Coolant tube, see art. no. 21864.
Key for coolant tube, see art. no. 21865.

Applications

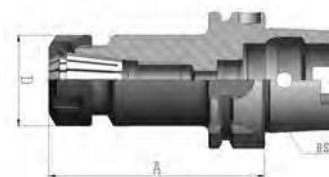
For clamping tools with straight shanks in collet chucks in accordance with DIN 6499, shape A and B.



Medium length

HSK - ER	Clamping range mm	Collet chucks type	A mm	D Ø mm	21843	...
63 - 16	1–10	ER 16	100	32		101
63 - 25	2–16	ER 25	100	42		103
63 - 32	2–20	ER 32	100	50		105
63 - 40	3–26	ER 40	120	63		107

NEW



Long

HSK - ER	Clamping range mm	Collet chucks type	A mm	D Ø mm	21843	...
63 - 16	1–10	ER 16	160	32		102
63 - 25	2–16	ER 25	160	42		104
63 - 32	2–20	ER 32	160	50		106
63 - 40	3–26	ER 40	160	63		108

21845

ER collet chuck, slim

DIN
69893

A



G 2.5
25000
1/min



HSC

21845



Design

- Finely balanced clamping nut for HSC
- Drilled ER11 through hole
- Hard-turned shank
- Balluff chip bore

Note:

For collet chuck sets, see art. no. 21519.
For collet chucks, see art. no. 21520–21525 and 21534–21539.
Coolant tube, see art. no. 21864.
Key for coolant tube, see art. no. 21865.

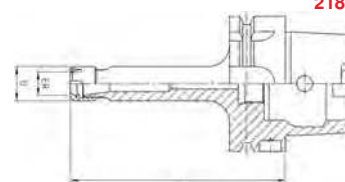
Applications

For clamping tools with straight shanks in collet chucks in accordance with DIN 6499, shape A and B.



Medium length

HSK - ER	Clamping range mm	Collet chucks type	A mm	D Ø mm	21845	...
63 - 11	1–7	ER 11	100	16		101
63 - 16	1–10	ER 16	100	22		103
63 - 25	1–16	ER 25	100	35		105



Long

HSK - ER	Clamping range mm	Collet chucks type	A mm	D Ø mm	21845	...
63 - 11	1–7	ER 11	160	16		102
63 - 16	1–10	ER 16	160	22		104
63 - 25	1–16	ER 25	160	35		106

ATORN®**Design**

- Highly accurate, **patented** precision chuck with the highest concentricity and repeatability
- High retention forces
- High rigidity
- Extremely robust
- Large tool aperture

Scope of delivery:

Incl. clamping nut.

Applications

For high-precision clamping during roughing and finishing, drilling, reaming, countersinking, thread cutting etc.

Caution:

Also suitable for HPC/HSC milling up to approx. 200°C.

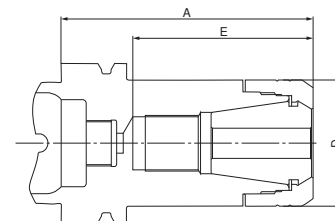
Note:

For spanner, see art. no. 21509.

For GERC-HP collet chucks, see art. no. 21546–21551.

For GERC-B collet chucks, see art. no. 21534–21539.

For replacement clamping nuts, see art. no. 21518.



21842



Short

Taper HSK	Clamping range mm	Collect chucks type	Dimension D mm	Dimension A mm	Max. insertion depth E without stop mm	Suitable clamping nut	Tightening torque of clamping nut Nm	21842	...
63	1–10	GERC 16	30	55	32	AER 16	55		101
63	2–20	GERC 32	50	70	46	AER 32	140		109



Medium length

Taper HSK	Clamping range mm	Collect chucks type	Dimension D mm	Dimension A mm	Max. insertion depth E without stop mm	Suitable clamping nut	Tightening torque of clamping nut Nm	21842	...
63	1–10	GERC 16	30	100	71	AER 16	55		102
63	1–16	GERC 25	40	100	70	AER 25	85		106
63	2–20	GERC 32	50	100	71	AER 32	140		110



Long

Taper HSK	Clamping range mm	Collect chucks type	Dimension D mm	Dimension A mm	Max. insertion depth E without stop mm	Suitable clamping nut	Tightening torque of clamping nut Nm	21842	...
63	1–10	GERC 16	30	160	106	AER 16	55		103
63	1–16	GERC 25	40	160	128	AER 25	85		107
63	2–20	GERC 32	50	160	129	AER 32	140		111

21844

Precision collet chuck CENTRO|P mini and tapered

FAHRION®
PRÄZISION**Design**

- Ground inner and outer taper
- Concentricity and repeatability 0.003 mm (with GERC-HP collet chucks)
- Supplied without clamping nut

Applications

For precision clamping of tools with straight shanks without any loss of concentricity or gripping force up to a shaft tolerance of h10.

Note:

Collet chucks with square drives for screw taps cannot be used.

For clamping nuts and spanners, see art. no. 21509.

GERC-HP/HPD collet chucks, see art. no. 21546 to 21566.

Coolant tube, see art. no. 21864.

Key for coolant tube, see art. no. 21865.

DIN
69893

A

G 2.5
25000
1/min

≤ 3 μm



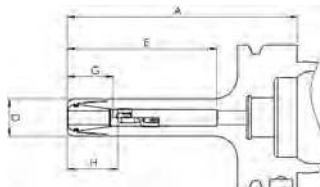
HSC

HPC

21844 101-102

Design

Extremely slim design.



21844 101-102

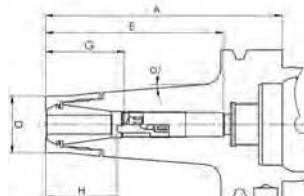


HSK Clamping range mm	Size mm	Collet chucks type	Dim. D mm	Dim. A mm	Insertion depth E mm	slim	
						21844	...
63	1-7	CP 11 M	GERC 11/4008 E	16	100	78	101
63	1-7	CP 11 M	GERC 11/4008 E	16	160	138	102

21844 201-202

Design

Tapered design.



21844 201-202



HSK Clamping range mm	Size mm	Collet chucks type	Dim. D mm	Dim. A mm	Insertion depth E mm	conical	
						21844	...
63	1-10	CPC16	GERC 16/426 E	24	100	75	201
63	1-10	CPC16	GERC 16/426 E	24	160	105	202

21862

CENTRO|P precision collet chuck

FAHRION®
PRÄZISION**Design**

- Ground inner and outer taper
- Concentricity and repeatability 0.003 mm (with GERC-HP collet chucks)
- Supplied without clamping nut

Applications

For precision clamping of tools with straight shanks without any loss of concentricity or gripping force up to a shaft tolerance of h10.

Note:

Collet chucks with square drives for screw taps cannot be used.

For clamping nuts and spanners, see art. no. 21509.

For sealing washers, see art. no. 21513

(only available online).

GERC-HP/HPD/HPDD collet chucks, see art. no. 21546 to 21569.

Coolant tube, see art. no. 21864.

Key for coolant tube, see art. no. 21865.

DIN
69893

A

G 2.5
25000
1/min

≤ 3 μm



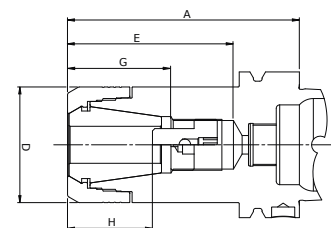
HSC

HPC

21862



HSK Clamping range mm	Size mm	Collet chucks type	Dim. D mm	Dim. A mm	Insertion depth E mm	21862	
						21862	...
63	1-10	CP 16	GERC 16/426 E	30	100	71	101
63	1-10	CP 16	GERC 16/426 E	30	160	106	102
63	2-16	CP 25	GERC 25/430 E	40	100	70	104
63	2-16	CP 25	GERC 25/430 E	40	160	128	105
63	2-20	CP 32	GERC 32/470 E	50	70	46	107
63	2-20	CP 32	GERC 32/470 E	50	100	71	108
63	2-20	CP 32	GERC 32/470 E	50	160	129	109



21846

Taper sleeves

DIN
69893

A



G 2.5
25000
1/min

≤ 8 μm



Design

- Precision design
- Balluf chip bore

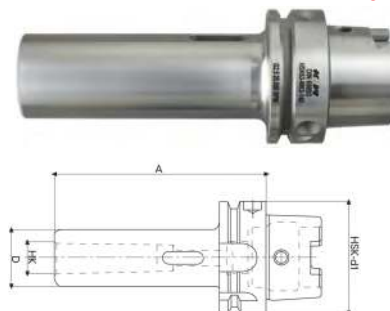
Applications

For mounting tools with MK shanks and flat tangs.

Note:

Coolant tube, see art. no. 21864.
Key for coolant tube, see art. no. 21865.

21846



Taper HSK	MK	A mm	D Ø mm	21846	...
63	1	100	25		101
63	2	120	32		102
63	3	140	40		103
63	4	160	48		104

21848

HG collet chucks

DIN
69893

A



G 6.3
15000
1/min

≤ 3 μm

HSC

Haimer

Design

- Highly accurate and precise chuck
- Stable tension
- High concentricity

Scope of delivery:

Including retaining screw and extractor hook.

Applications

Ideal for high-speed machining. For clamping tools with straight shanks.

Note:

For HG collets, see art. no. 21627.
Coolant tube, see art. no. 21864.
Key for coolant tube, see art. no. 21865.

21848



Taper HSK	Size	A mm	Ø D mm	For clamping Ø mm	21848	...
63	1	120	30	2/3/4/5/6/8		201
63	2	120	35	10/12/14		202
63	3	120	48	16/18/20		203

21849

Milling cutter holders

DIN
69893

A



G 2.5
25000
1/min

≤ 5 μm



Design

- Inner cooling, AD version
- Precision-balanced, grade 2.5 at 25,000 rpm
- Balluf chip bore
- Max. concentricity < 0.005 mm

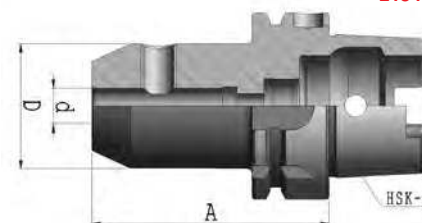
Applications

For clamping tools with side driving surfaces in accordance with DIN 1835 B and DIN 6535 HB.

Note:

Coolant tube, see art. no. 21864.
Key for coolant tube, see art. no. 21865.
For spare screws, see art. no. 21635.

21849



Short

Taper HSK	d mm	D mm	A mm	21849	...
63	6	25	65		401
63	8	28	65		404
63	10	35	65		407
63	12	42	80		410
63	14	44	80		413
63	16	48	80		416
63	18	50	80		419
63	20	52	80		422
63	25	63	110		425
63	32	72	110		427
63	40	80	125		429



Medium length

Taper HSK	d mm	D mm	A mm	21849	...
63	6	25	100		402
63	8	28	100		405
63	10	35	100		408
63	12	42	100		411 NEW



Long

Taper HSK	d mm	D mm	A mm	21849	...
63	6	25	160		403
63	8	28	160		406
63	10	35	160		409
63	12	42	160		412
63	14	44	160		415
63	16	48	160		418
63	18	50	160		421
63	20	52	160		424

21851

Milling cutter holders with KKB

DIN
69893

A

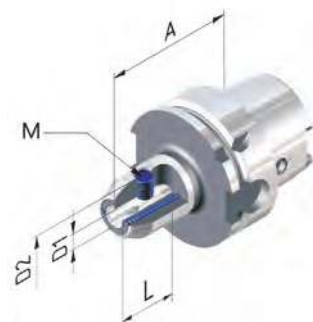

G 2.5
25000
1/min


HSC

HPC

Design

- Hard-turned shank
- Balluf chip bore
- With two coolant channel bores (= KKB)
- With clamping screw and bolts to close the KKB if necessary



Taper HSK	D1 mm	A mm	D2 mm	L mm	M	Short	
						21851	...
63	6	65	25	35	M 6		101
63	8	65	28	35	M 8		102
63	10	65	35	41	M 10		103
63	12	80	42	48	M 12		104
63	14	80	42	48	M 12		105
63	16	80	48	51	M 14		106
63	18	80	48	51	M 14		108
63	20	80	52	53	M 16		109
63	25	110	65	60	M 18 x 2		110
63	32	110	72	64	M 20 x 2		111

Taper HSK	D1 mm	A mm	D2 mm	L mm	M	Long	
						21851	...
63	6	120	25	35	M 6		201
63	8	120	28	35	M 8		202
63	10	120	35	41	M 10		203
63	12	120	42	48	M 12		204
63	14	120	42	48	M 12		205
63	16	120	48	51	M 14		206
63	18	120	48	51	M 14		207
63	20	120	52	53	M 16		208

21851
Short

21851
Long


21855

Combination mill arbors

HHW

Design

- Precision design
- Face-ground contact surface (< 0.003 mm)
- Precision-balanced, grade 2.5 at 25,000 rpm
- Balluf chip bore

Scope of delivery:

Including key, driver ring and retaining screws.

Applications

With key for cutters with longitudinal grooves such as DIN 841, and driver ring for cutters with lateral groove DIN 1880 and blade heads DIN 1830.

Note:

For driving rings, see art. no. 21655.

For retaining screws, see art. no. 21656 and 21659.

Retaining screw no. 21657. Coolant tube, see art. no. 21864.

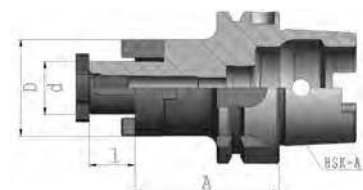
Key for coolant tube, see art. no. 21865.

DIN
69893

A


G 2.5
25000
1/min


21855



Short

Taper HSK	d mm	D mm	A mm	I mm	Short	
					21855	...
63	16	32	60	17		401
63	22	40	60	19		403
63	27	48	60	21		405
63	32	58	60	24		407
63	40	70	70	27		409



Medium length

Taper HSK	d mm	D mm	A mm	I mm	Medium length	
					21855	...
63	16	32	100	17		402
63	22	40	100	19		404
63	27	48	100	21		406
63	32	58	100	24		408
63	40	70	100	27		410

21858

Blade head supports

DIN
69893

A



G 2.5
25000
1/min



Design

- Precision version with enlarged and face-ground contact surfaces
- Short overhang for greater stability
- **Precision-balanced, grade 2.5 at 25,000 rpm**
- Balluf chip bore
- With KKB/coolant channel bore

Scope of delivery:

Includes retaining screw.

Applications

For face milling cutter heads and cutters with lateral grooves.

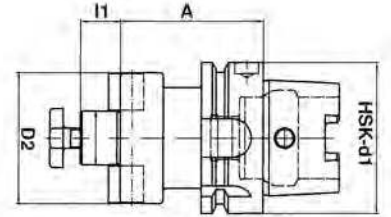
Note:

$d = 40$ and 60 mm also have 4 threaded holes for direct mounting.

For retaining screws, see art. no. 21656 and 21659.

Retaining screw no. 21657. Coolant tube, see art. no. 21864.

Key for coolant tube, see art. no. 21865.



Short with KKB

Taper HSK	D1 mm	A mm	D2 mm	L1 mm	21858	...
63	16	50	38	17	401	
63	22	50	48	19	403	
63	27	60	58	21	405	
63	32	60	78	24	407	
63	40	60	88	27	409	

Medium length with KKB

Taper HSK	D1 mm	A mm	D2 mm	L1 mm	21858	...
63	16	100	38	17	402	
63	22	100	48	19	404	
63	27	100	58	21	406	
63	32	100	78	24	408	
63	40	100	88	27	410	

Long with KKB

Taper HSK	D1 mm	A mm	D2 mm	L1 mm	21858	...
63	16	160	38	17	411	NEW
63	22	160	48	19	412	NEW
63	27	160	58	21	413	NEW
63	32	160	78	24	414	NEW
63	40	160	88	27	415	NEW

21858
Short



21858
Medium length



21858
Long



21859

Blade head supports with KKB

DIN
69893

A



G 2.5
25000
1/min



HPC

Design

- Ground taper shank, mounting spigot and contact surface
- Hard-turned shank
- Balluf chip bore
- With coolant channel bores (KKB)

Scope of delivery:

Cutter retaining screw.



21859



Taper HSK	D1 mm	A mm	D2 mm	L1 mm	21859	...
63	16	50	38	17	101	
63	22	50	48	19	102	
63	27	60	60	21	103	
63	32	60	78	24	104	

21864

Coolant tubes

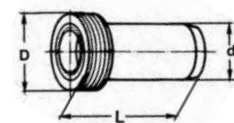
DIN
69893**ATORN®**

Applications

To optimise central coolant supply in hollow shank tapers in accordance with DIN 69893-HSK-A/E.

HSK	D	d mm	L mm	21864	...
32	M10 x 1	6	25.7		201
40	M12 x 1	8	29.2		202
50	M16 x 1	10	32.7		203
63	M18 x 1	12	36.2		204
80	M20 x 1.5	14	39.7		205
100	M24 x 1.5	16	43.6		206

NEW



21864

21865

Key for coolant tubes

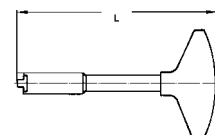
DIN
69893**ATORN®**

Applications

For coolant tube art. no. 21864.

HSK	L mm	21865	...
32	115		201
40	115		202
50	115		203
63	122		204
80	136		205
100	141		206

NEW



21865

Info

Multi-spindle heads for drilling, thread cutting, countersinking, reaming, milling, turning etc.

Multi-spindle drilling heads with a fixed drill pattern for machining centres with or without automatic tool changes. For the use of solid carbide tools with speeds up to 12,000 rpm with or without coolant supply.



Type SMSK 6/15

With 6 spindles and a maximum drilling capacity of 15 mm per spindle. Spindle head in accordance with DIN 55058 for adjustment sleeve size 20. Special holder with collet chuck holder for high rotation speeds when using solid-carbide drills or solid-carbide tools. Multi-spindle head mount, steep taper 50 with grip lock for machining centres.

Type SMSK 2/15

Steep taper mount 40 with continuous coolant supply, tapping chuck with length compensation under compression and tension.

Type KE

Characterised by simple and quick adjustment. Very sturdy construction, large adjustment range, narrowest spindle intervals, low weight, long service life, also suitable for smaller series in a medium tolerance range. Multi-spindle heads with drill patterns adjustable by replacing the spindle mount plate (matrix).

Type SMSK 4/15

Drilling performance of 15 mm per spindle or thread cutting performance of M 12. Spindle head in accordance with DIN 55058 for adjustment sleeve size 20. Quick-change thread-cutting chuck with tension and compression length compensation and spring-mounted countersink sleeve for chamfering the bore. Multi-spindle head mount, steep taper 50 with grip lock for machining centres. Multi-spindle head, easily adjustable, deliverable with two, three or four spindles, max. drilling performance per spindle of 3 mm to 32 mm depending on type.

Type KR

Featuring jointed spindles with high concentricity, good bearing stability and minimal spindle intervals. Simple alteration of drilling patterns and absolute dimensional accuracy thanks to spindle mount plates (matrices) produced in the co-ordinate system, large adjustment range of individual types up to 530 mm, max drilling capacity up to 40 mm in steel.

Please contact us! For the best possible advice, please add a dimensioned drawing of the drilling patterns.