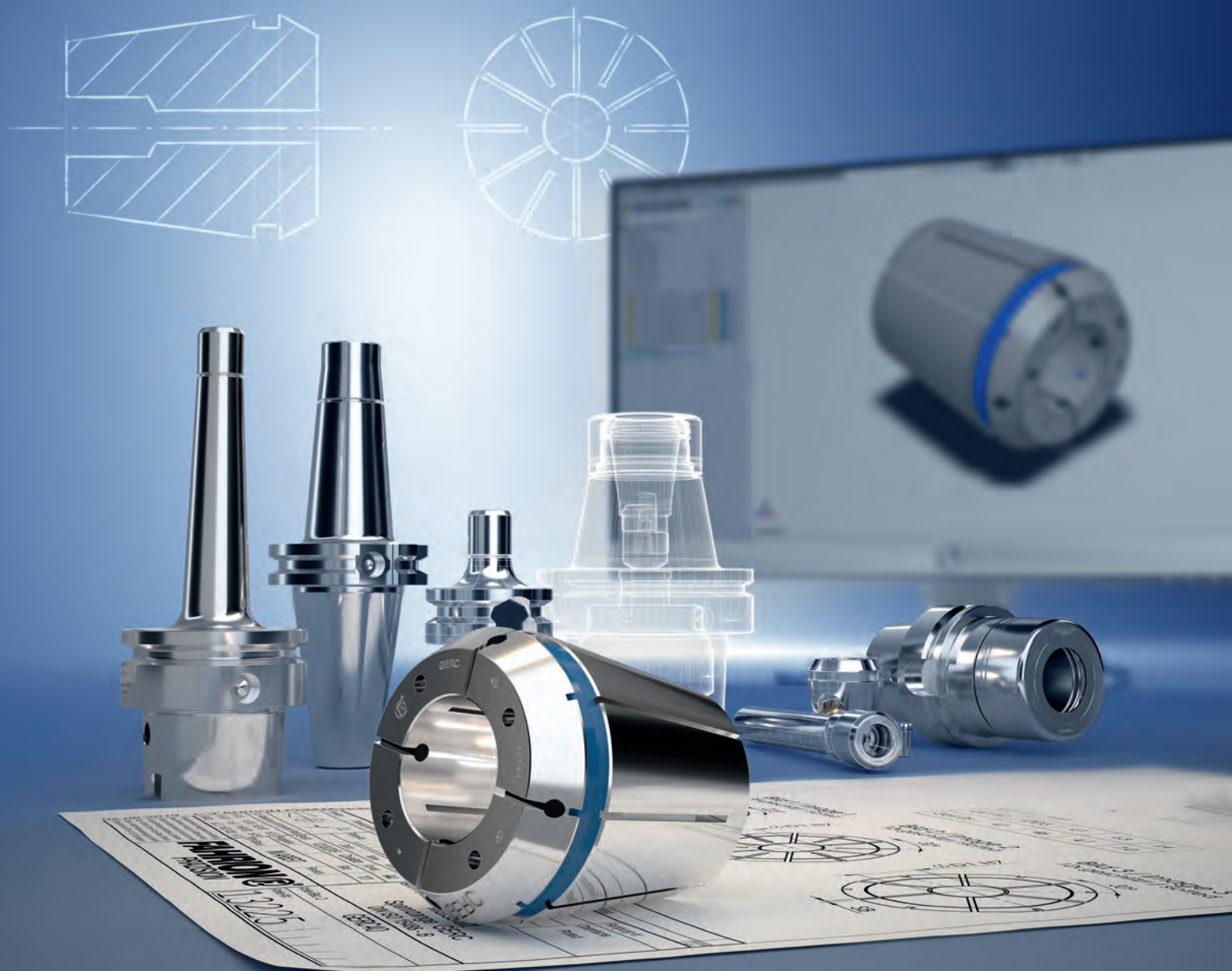




CENTRO | P premium CLAMPING SYSTEMS FROM FAHRION



QUICK FINDER

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CENTRO|P

Tangible Benefits of the System

CENTRO|P is a high-precision system of collets, clamping nuts and chucks far superior to conventional collet chucks in all respects. The technological performance of CENTRO|P can be compared with systems such as hydraulic expansion technology, shrink-fit technology or the power chuck. CENTRO|P offers the full range of these technologies all in one system.



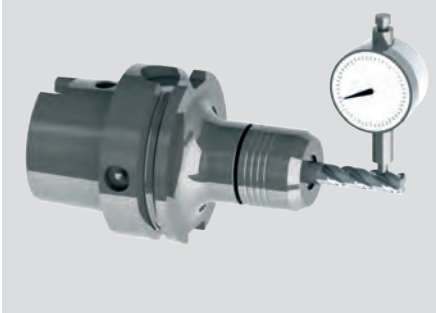
Precision clamping system consisting of:

- Precision Chuck CENTRO|P
- GERC-HP Precision Collet
- HPC Clamping Nut

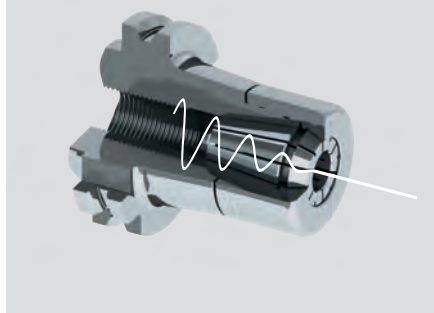
Clamping is applied mechanically via a cone fit, which means:

- A high concentricity of $< 3 \mu\text{m}$ due to special tuning of the cone tolerances
- System-based damping through the slots of the collet
- A constant clamping force, regardless of the tolerance position from bore to shaft, as the cone balances axially
- A maintenance-free solution, as neither media nor temperature are used for generating clamping force
- A long-lasting system, as neither leaks nor material changes take place

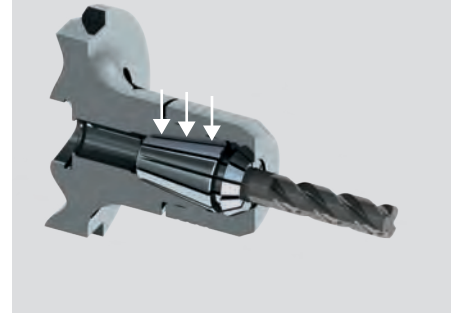
Concentricity of $< 3 \mu\text{m}$



System-based damping



Constant clamping force



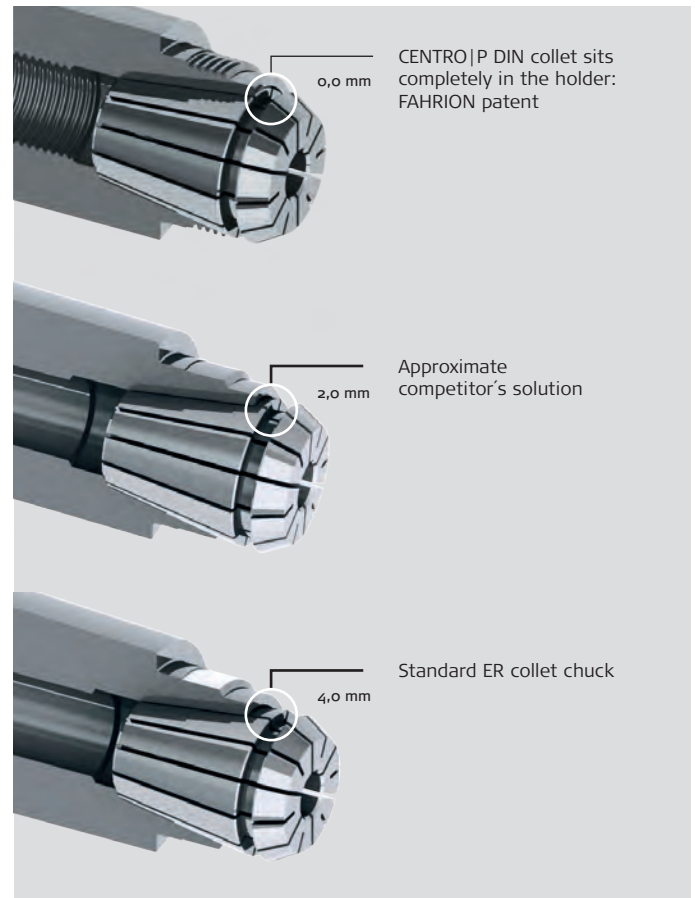
CENTRO|P

Proven Technology for your Benefit

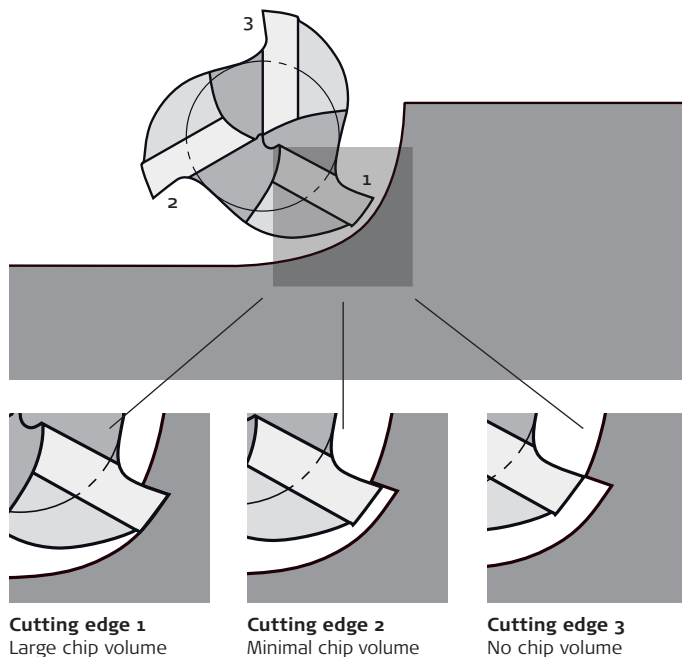
The patented precision clamping system CENTRO|P offers a variety of advantages and, thanks to its highly reliable precision and quality, makes a considerable contribution to more efficient processing while also reducing production costs.

The most important design features are:

- The collet sits completely inside the cone
- A precisely ground double guide for the clamping nut
- A stable trapezoidal thread for transferring of the clamping force
- A chuck body with continuous maximum diameter



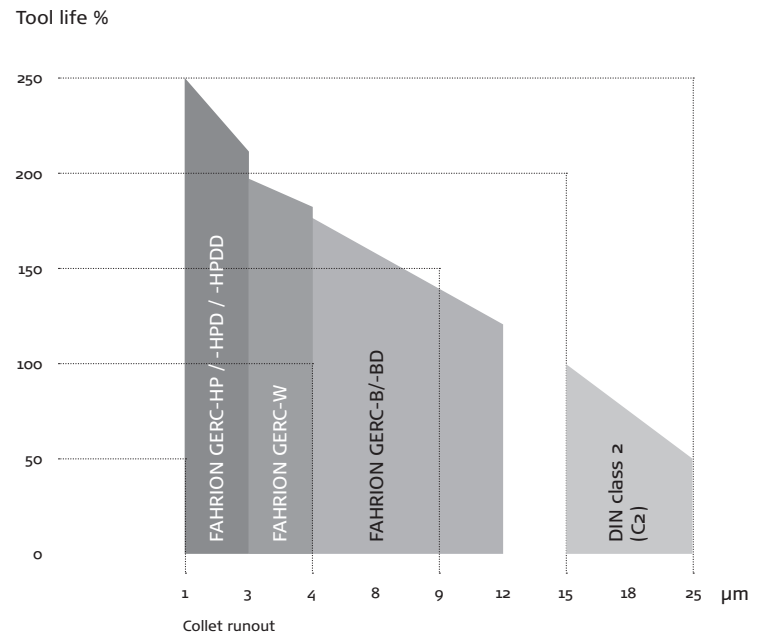
Effect of runout on the cutting edges



The problem

The higher the concentricity error, the greater the irregular load on the cutting edge. The consequences are increased tool wear and poorer surface finishes. For a good result, the feed must now be reduced.

Influence of collet accuracy on the life of carbide cutting tools



Cost example for a carbide drill Ø 12 mm with collet DIN ISO 15488 - form B, type 470 E

Example 1: system concentricity $\leq 10 \mu\text{m}$

Cost of a carbide drill	approx. 105.00 €
Cost FAHRION GERC32-B collet with concentricity $5 \mu\text{m}$	approx. 21.30 €

Cost on basis of tool life of approx. 150 %	approx 126.30 €
---	-----------------

Example 2: system concentricity $\leq 25 \mu\text{m}$

Cost of a carbide drill	approx. 105.00 €
Cost CER32-K2 collet DIN class 2 with concentricity $20 \mu\text{m}$	approx. 12.60 €

Cost on basis of tool life of approx. 55 %	approx 117.60 €
Cost for similar tool life of approx. 150 %	approx 299.00 €
More than two carbide drills necessary!	

Result: Cheap collets almost triple the cost!

CENTRO|P premium

Consistently One Step Ahead



Welcome to the world of high-precision machining with customer benefits, where we are always looking to improve.

As part of our CENTRO|P premium program, we offer you customised clamping systems, each with its own individual strengths and for a variety of applications.

Take advantage of other benefits, such as our FAHRION | Protect coating, tried and tested a million times, which is now also used on chucks and on clamping nuts. Pioneering technology that protects your complete tool clamping system and keeps it accurate and efficient for a long time.

CENTRO|P premium

Overview



CENTRO|P premium

MPC
Mini Precision
Page 10

DPC
Dynamic Performance
Page 14

UPC
Ultra Power
Page 18

Dimensions

Sizes	ER 8 - ER 16	ER 16 - ER 40	ER 32- ER 40
Clamping ranges	1 - 10 mm	1 - 26 mm	2 - 26 mm
Ø Clamping Nuts	10 - 24 mm	30 - 63 mm	53 - 63 mm
Lengths	35- 200 mm	50 - 200 mm	65 - 100 mm

Concentricity at 3xD

with HP / HPD / HPDD	0.003 mm	0.003 mm	0.003 mm
with B / BD	0.006 mm	0.006 mm	0.006 mm
with W	-	0.004 mm	0.004 mm
with GBD / GBDD	0.008 mm	0.008 mm	0.008 mm

Recommended applications

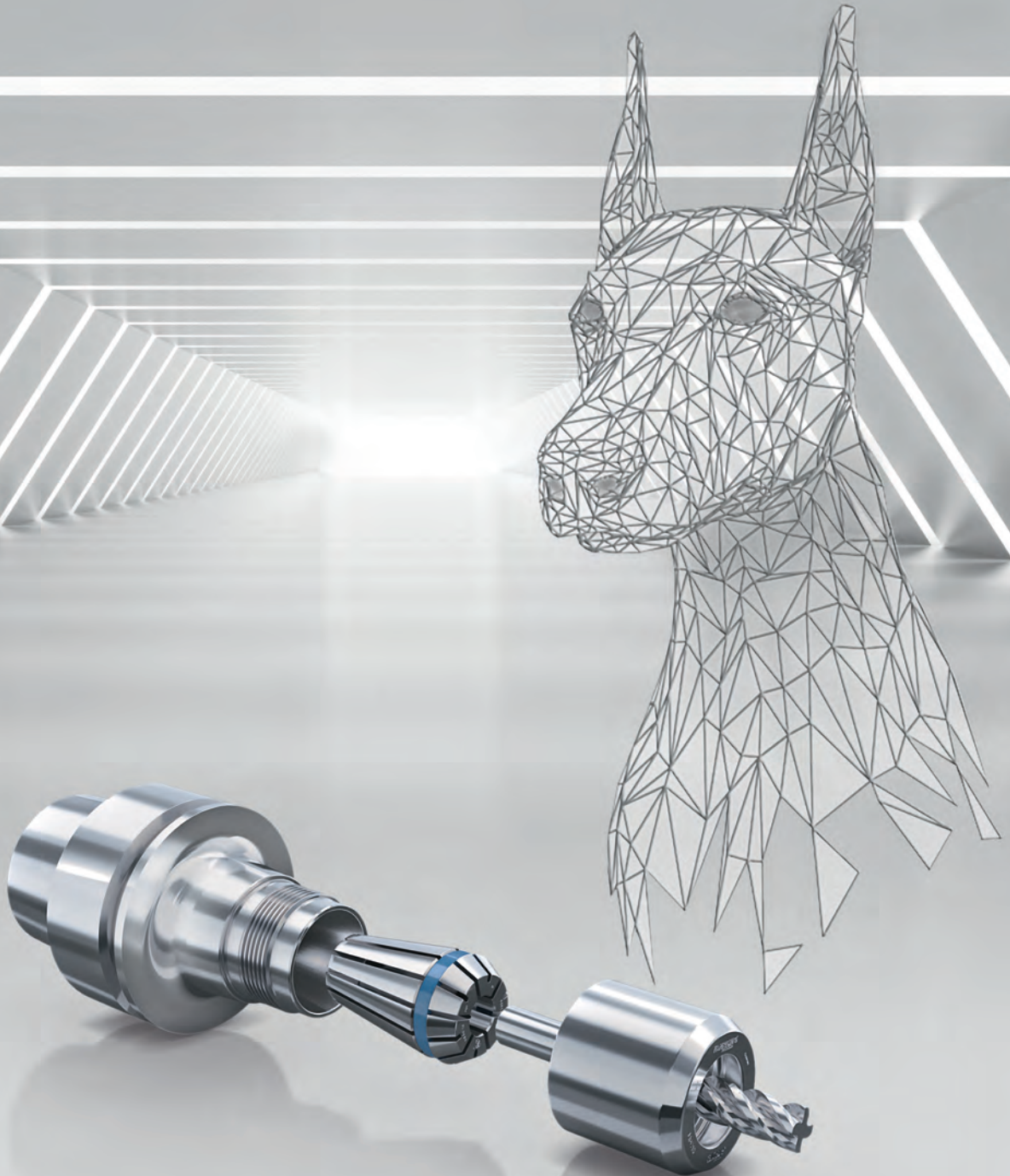
Drilling	•••	•••	•
Finishing	•••	•••	
Roughing		•	•••
HSC milling	•••	••	
HPC milling	•	••	•••
Trochoidal milling		••	•••
Reaming			
Threads	•	••	
Lathe			



FPC Full Performance Page 22	AFC Adjustable Finishing Page 26	MPC / DPC Tool Extensions Page 28	DPC / FPC Holders NC for Lathes Page 30
ER 32 - ER 40	ER 25 - ER 40	ER 8 - ER 20	ER 25 - ER 40
2 - 26 mm	7 - 26 mm	1 - 13 mm	1 - 26 mm
50 - 63 mm	40 - 63 mm	10 - 32 mm	40 - 63 mm
60 - 200 mm	ab 100 mm	80 - 350 mm	54 - 68 mm
0.003 mm	0.001 mm	0.003 mm	0.010 mm
0.006 mm	-	0.006 mm	0.015 mm
0.004 mm	-	-	0.010 mm
0.008 mm	-	0.008 mm	0.016 mm
•	••	•••	
•••			
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			•••

MPC, MINI PRECISION CHUCK

For High-Speed Spindles, Tight Spaces and Deep Immersion



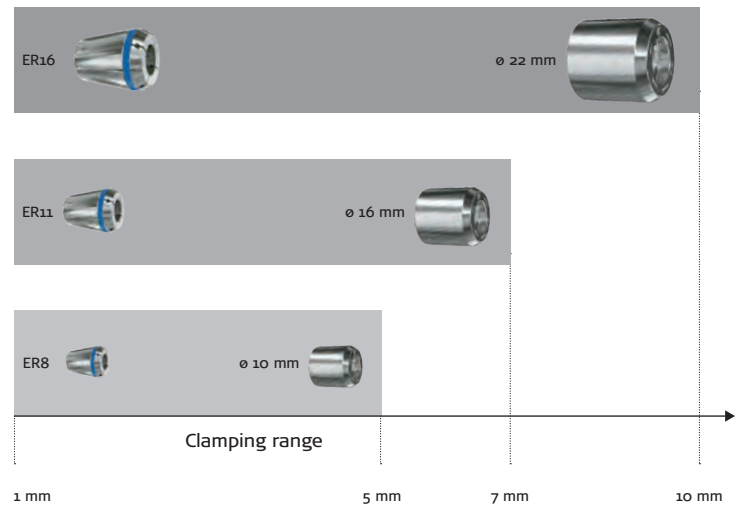
The **MPC Mini Precision Chucks** excel in deep cavities on high speed machines with smaller tapers. They provide excellent stability and flexibility in medical and mold making applications.

But even in tool and mould making or in the production of valves or manifolds, stable tool clamping at higher immersion depths is increasingly required - classic applications for the MPC system.

MPC, MINI PRECISION CHUCK

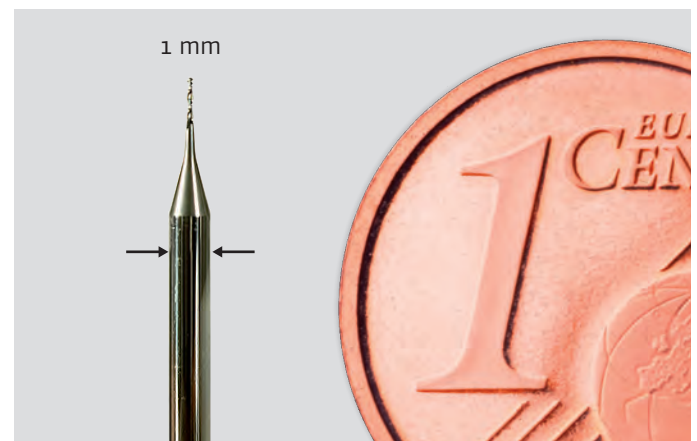
Features

The MPC Mini Precision chucks are very slim precision chucks with optimal interference contour and therefore, ideal for HSC processing.

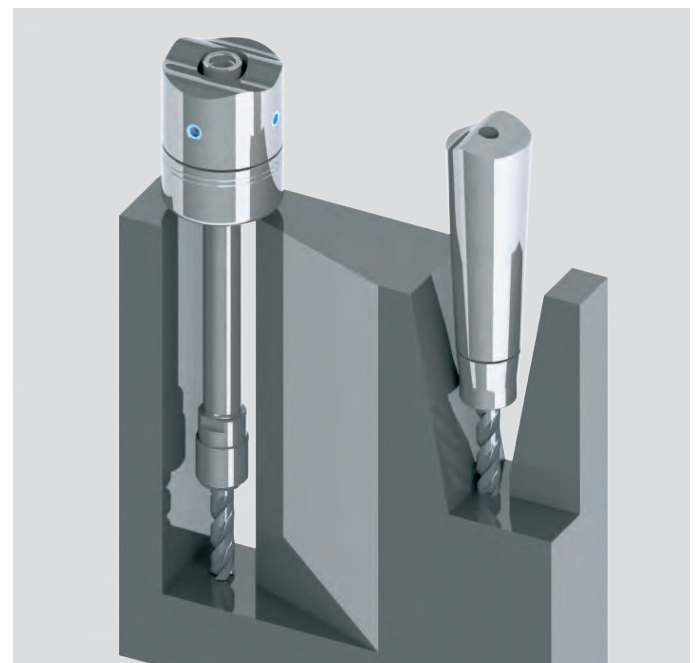


Cylindrical shafts can be reliably clamped from a shaft diameter of just 1 mm.

The outer diameter starts at 10 mm.



Alternatively, MPC chucks are also available in a slightly tapered yet slim design for more stability and deep immersion in components with draft angles in tool and mould making, for example.



MPC, MINI PRECISION CHUCK

Variants

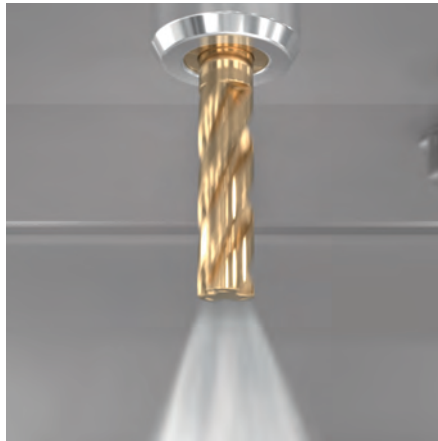
Coolant supply variants through the matching collet

One system, several variants. The choice of collet determines the type of coolant supply.
For you this means:

- Better surface quality
- Longer tool life
- Easy chip removal
- Cooling and lubricating of the tool cutting edge



Without coolant supply
GERC-HP
GERC-B



Coolant through the centre
GERC-HPD
GERC-BD
GERC-GBD



Peripheral cooling
GERC-HPDD
GERC-GBDD

NEW

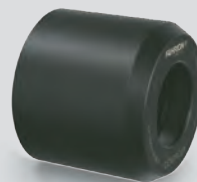
Process optimisation

Optimise your process and inquire about our collets with customised jet holes. Starting at 0.2 mm outlet diameter, jet holes can be designed for specific applications, e.g. for cryogen or aerosol cooling.

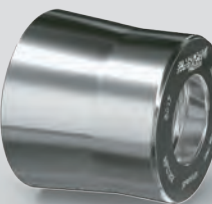
Variants with different clamping nuts for every application



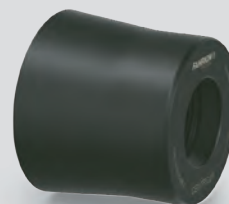
- Mini Clamping Nut MPC for
- Small outer diameter
 - High speeds
 - System accuracy up to 3 µm



- Mini Clamping Nut HSS for
- Collet collapse up to 0.4 mm



- Mini Clamping Nut MPC tapered for
- More stability
 - High speeds
 - System accuracy up to 3 µm

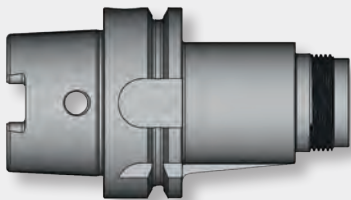


- Mini Clamping Nut HSS tapered for
- More stability
 - Collet collapse up to 0.4 mm

MPC, MINI PRECISION CHUCK

Overview

Interface:



Cylindrical or tapered version available

- HSK-A 32
- HSK-A 40
- HSK-A 50
- HSK-A 63
- HSK-E 25
- HSK-E 32
- HSK-E 40
- HSK-E 50
- SK 30
- SK 40
- BT 30 / BTP 30
- BT 40 / BTP 40
- CYL Ø 10
- CYL Ø 12
- CYL Ø 16
- CYL Ø 20

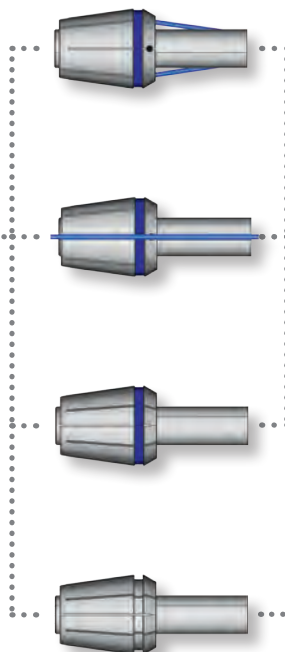
Execution:

- Cylindrical
- Tapered

Lengths:

- 35 mm to 75 mm
- 90 mm
- 100 mm / 105 mm
- 120 mm
- 130 mm
- 150 mm
- 160 mm
- 200 mm

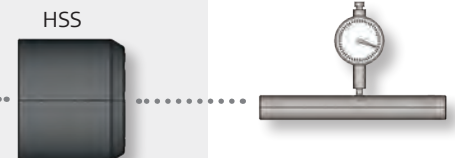
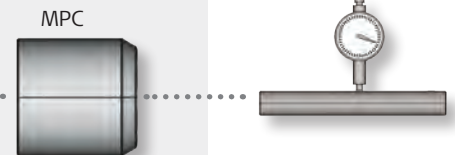
Collets:



- GERC8-B
- GERC8-HP
- GERC11-B / BD
- GERC11-HP / HPD
- GERC16-B / BD
- GERC16-HP / HPD / HPDD

Clamping Nuts:

3 µm at 3xD with HP collets and MPC clamping nut
6 µm at 3xD with B collets and MPC clamping nut



HSS clamping nut recommended for GERC-B collets for collet collapse up to max. - 0,4 mm

- MPC 8
- MPC 11
- MPC 16
- MPC 16 - HSS
- MPC 16 T
- MPC 16 T - HSS

DPC, DYNAMIC PERFORMANCE CHUCK

For Highly Dynamic Processes



The **DPC Dynamic Performance Chucks** are real universal all-rounders for demanding tasks, especially in HDC milling, but also for trimming, finishing and roughing. DPC holders are the first choice for high removal rates on

dynamic machines with modern milling strategies, such as components for the tool and mold-making industry, automotive, machine, plant construction, high-end part suppliers, and contract manufacturers.

DPC, DYNAMIC PERFORMANCE CHUCK

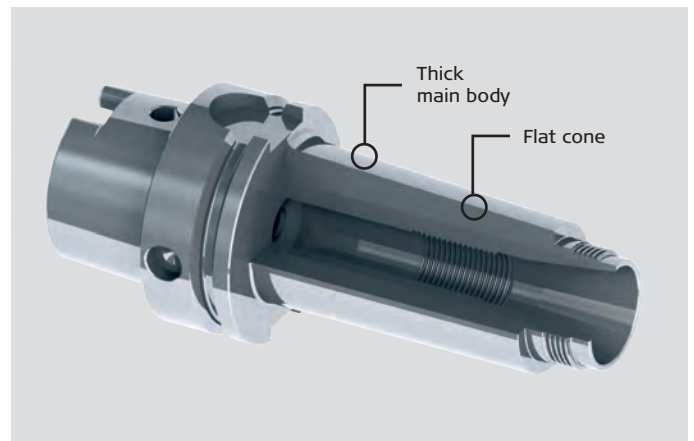
Features

DPC chucks optimally combine high stability with excellent concentricity and best dynamics, preferably for drilling and milling.



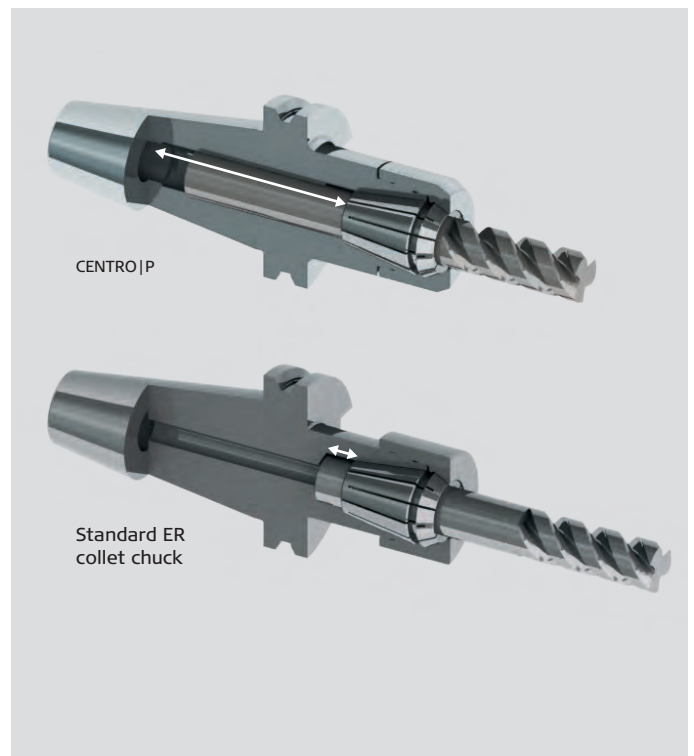
The outer contour

DPC chucks have a stable, cylindrical outer contour with a maximum diameter (diameter of the clamping nut). In addition, there are also tapered versions for even more rigidity and less vibration



The inner contour

Flexibility of projection is ensured by a large through diameter.



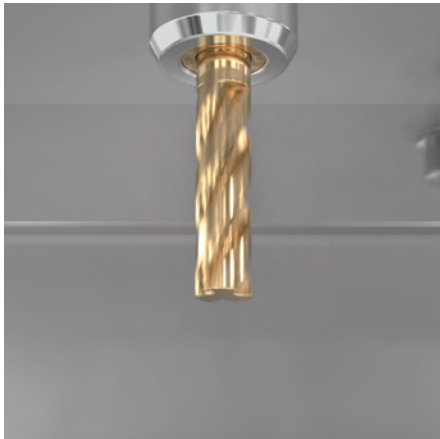
DPC, DYNAMIC PERFORMANCE CHUCK

Variants

Coolant supply variants through the matching collet

One system, several variants. The choice of collet determines the type of coolant supply. For you this means:

- Better surface quality
- Longer tool life
- Easy chip removal
- Cooling and lubricating of the tool cutting edge



Without coolant supply
GERC-HP
GERC-B



Coolant through the centre
GERC-HPD
GERC-BD
GERC-GBD



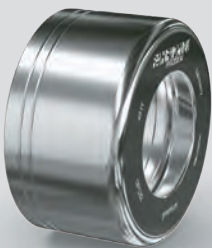
Peripheral cooling
GERC-HPDD
GERC-GBDD

Process optimisation

NEW

Optimise your process and inquire about our collets with customised jet holes. Starting at 0.2 mm outlet diameter, jet holes can be designed for specific applications, e.g. for cryogen or aerosol cooling.

Variants with different clamping nuts for every application



The Clamping Nut DPC

- Has a low friction coating
- Does not require grooves for the clamping wrench
- Has a stable trapezoidal thread and the FAHRION double guide for high clamping forces, optimum concentricity and minimal residual imbalance



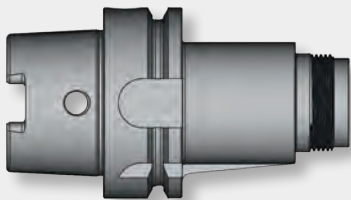
Clamping Nut HSS for

- Collet collapse up to 0.4 mm

DPC, DYNAMIC PERFORMANCE CHUCK

Overview

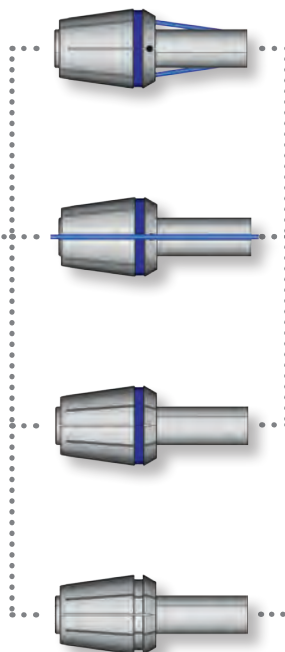
Interface:



Cylindrical or tapered version available

- HSK-A 32
 - HSK-A 40
 - HSK-A 50
 - HSK-A 63
 - HSK-A 100
 - HSK-E 40
 - HSK-E 50
 - HSK-F 50
 - HSK-F 63
 - SK 30
 - SK 40
 - SK 50
 - BT 30 / BTP 30
 - BT 40 / BTP 40
 - BT 50 / BTP 50
 - PSC 50
 - PSC 63
 - PSC 80
- CYL Ø 20
 - CYL Ø 25
 - CYL Ø 32
 - CYL Ø 40
- Execution:**
- Cylindrical
 - Tapered
- Lengths:**
- 50 mm to 75 mm
 - 90 mm
 - 100 mm / 105 mm
 - 120 mm
 - 130 mm
 - 160 mm / 165 mm
 - 200 mm

Collets:



- GERC16-B / BD
- GERC16-HP / HPD / HPDD
- GERC20-B / BD
- GERC20-HP / HPD
- GERC25-B / BD
- GERC25-HP / HPD / HPDD
- GERC32-B / BD
- GERC32-HP / HPD / HPDD
- GERC40-B / BD
- GERC40-HP / HPD / HPDD

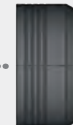
Clamping Nuts:

3 µm at 3xD with HP collets and DPC clamping nut
6 µm at 3xD with B collets and DPC clamping nut

DPC



HSS

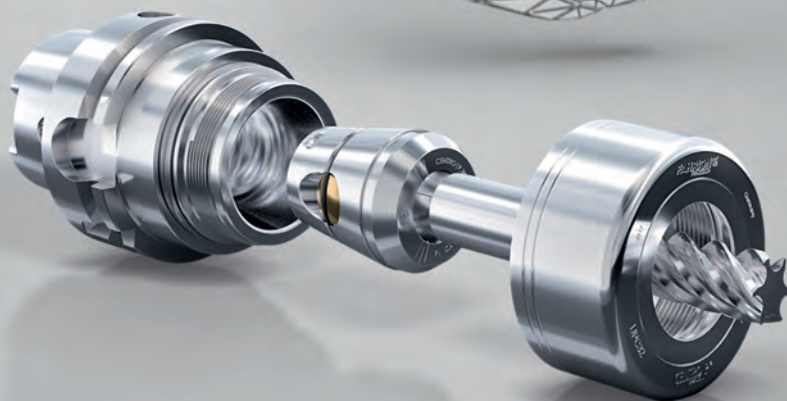


HSS clamping nut recommended for GERC-B collets for collet collapse up to max. - 0,4 mm

- DPC 16
- DPC 16 - HSS
- DPC 20
- DPC 20 - HSS
- DPC 25
- DPC 25 - HSS
- DPC 32
- DPC 32 - HSS
- DPC 40

UPC, ULTRA POWER CHUCK

For Maximum Material Removal Rates



The **UPC Ultra Power Chucks** are extremely stiff precision chucks for the most demanding tasks with predominantly radial load. This is a reinforced version with a multi-part

clamping nut for optimised damping and maximum stability. The wall thickness of the chuck body was increased to resolve more radial force and suppress vibration.

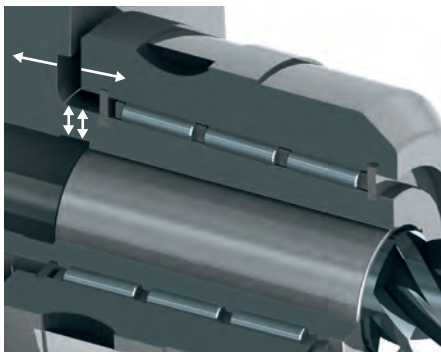
UPC, ULTRA POWER CHUCK

Features

- Optimal clamping force to eliminate collet twist
- Stable construction to reduce vibration build up
- Maximum dampening for vibration suppression
- Positive locking on the weldon surface to prevent micro creep
- New reinforced clamping nut with fine trapezoidal thread for improved locking
- The UPC reinforced chuck body for high radial loads is offered in a short version only. If longer reach is required use the FPC chuck

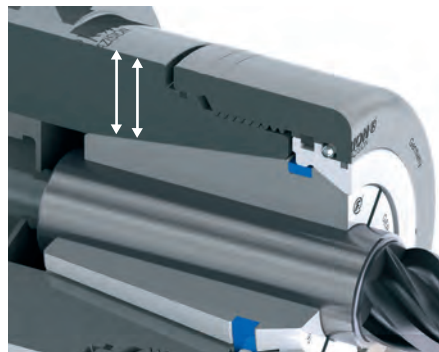


The problem

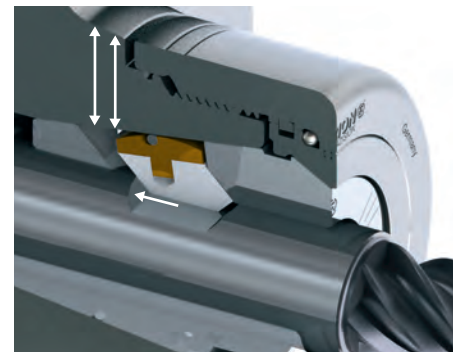


Conventional power chuck -
high radial transmittable torque -
unstable / weakened - only limited
radial load capacity

The solution



FAHRION UPC -
stable basic body for increased radial
load and additional safety due to
mechanical pull-out protection

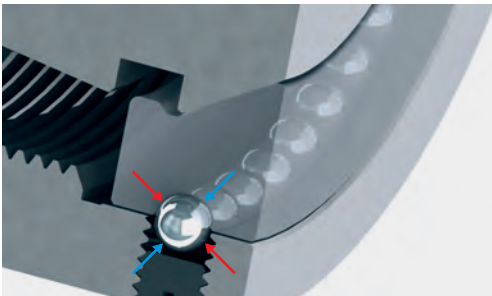


FAHRION UPC -
stable basic body for increased radial
load with GERC-HP collets

UPC, ULTRA POWER CHUCK

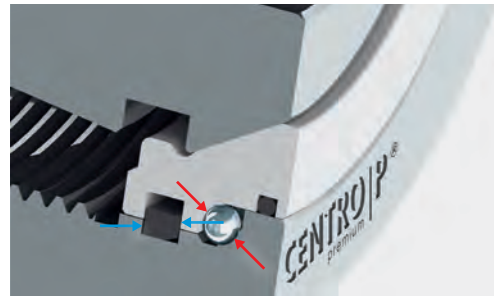
Ultra Power thanks to Angular Contact Ball Bearings and a Fine Thread

- New design of the clamping nut with an angular contact ball bearing and a compensating ring
- Special design with new trapezoidal fine thread and reinforced outer geometry for even better tightening of the clamping nut
- The ring allows clamping of the collet without radial forces. When tightening, the pressure on the collet is exerted only in the axial direction from top to bottom
- The multi-part nut increases the vibration damping.
- The tightening torques are identical to those of the PREMIUM DPC series
- As a result, the UPC clamping nut achieves a resultant clamping force of between 350 Nm and 380 Nm, more than sufficient, e.g. to secure a wedge collet with pull-out protection against twisting.



Conventional deep groove ball bearings:

Force flow during clamping (red) or release (blue) is transmitted exclusively via balls and bearing shells



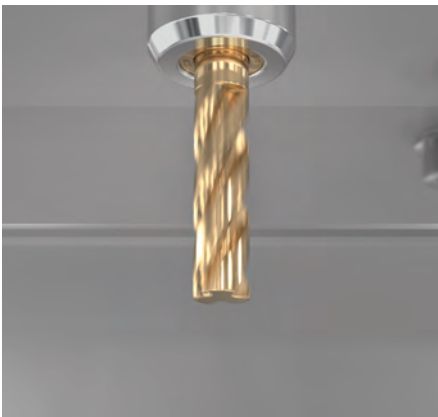
Angular contact ball bearings at UPC:

Power flow during clamping (red) is transmitted via the balls, when releasing (blue) via the circlip

Coolant supply variants through the matching collet

One system, several variants. The choice of collet determines the type of coolant supply. For you this means:

- Better surface quality
- Longer tool life
- Easy chip removal
- Cooling and lubricating of the tool cutting edge



Without coolant supply
GERC-HP
GERC-B



Coolant through the centre
GERC-HPD
GERC-BD
GERC-GBD



Peripheral cooling
GERC-HPDD
GERC-GBDD

Process optimisation

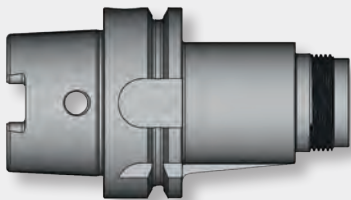
NEW

Optimise your process and inquire about our collets with customised jet holes. Starting at 0.2 mm outlet diameter, jet holes can be designed for specific applications, e.g. for cryogen or aerosol cooling.

UPC, ULTRA POWER CHUCK

Overview

Interface:



Cylindrical or tapered version available

- HSK-A 63
- HSK-A 100
- SK 40
- SK 50
- BT 40 / BTP 40
- BT 50 / BTP 50
- PSC 80

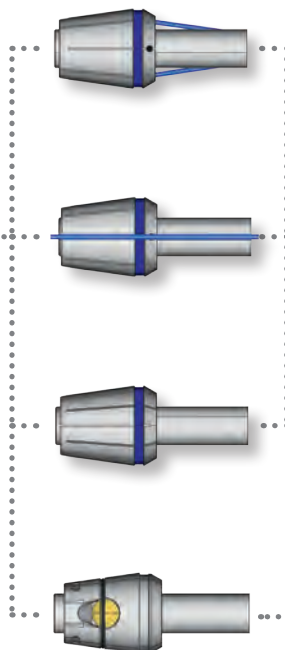
Execution:

- Cylindrical
- Tapered

Lengths:

- 65 mm to 80 mm
- 100 mm

Collets:



- GERC32-B / BD
- GERC32-HP / HPD / HPDD
- GERC32-W
- GERC40-B / BD
- GERC40-HP / HPD / HPDD
- GERC40-W

Clamping Nuts:

3 μ m at 3xD with HP collets and UPC clamping nut
6 μ m at 3xD with B collets and UPC clamping nut

UPC



UPC



4 μ m at 3xD with W collets and UPC clamping nut

- UPC 32
- UPC 40

FPC, FULL PERFORMANCE CHUCKS

Higher Damping and More Holding Power



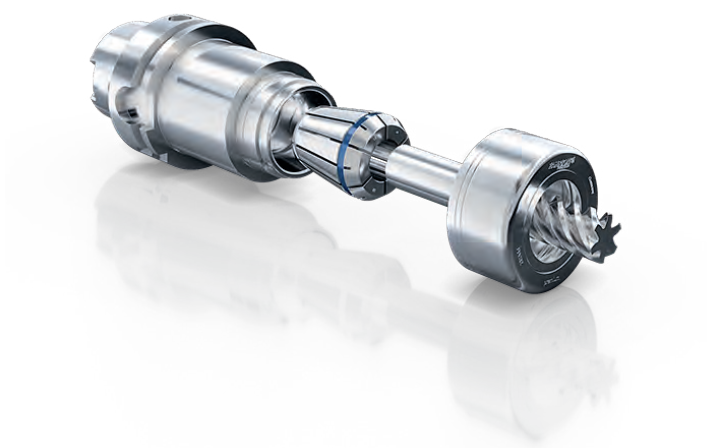
The **FPC Full Performance Chucks** are always the first choice, if the UPC cannot be used due to danger of collision.

The FPC chucks offer more holding power than the DPC and are leaner than the UPC.

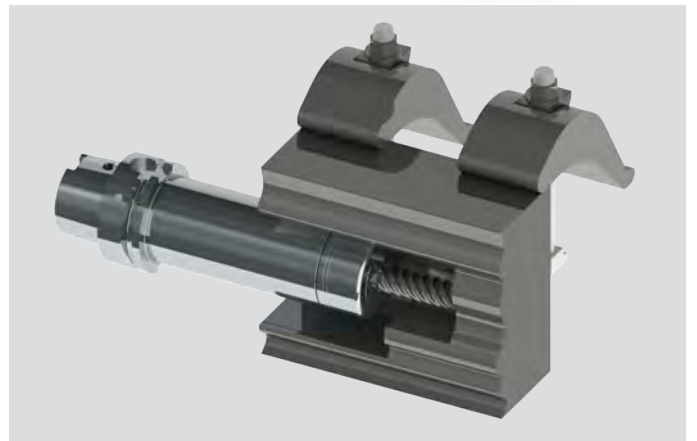
FPC, FULL PERFORMANCE CHUCKS

Features

FPC holders have a multi-part clamping nut for good damping properties and due to their length are particularly suitable for axial loads on stable machines with modern milling strategies, for components in the aerospace, medical, mould&die, high-end part, and contract manufacturing industries.

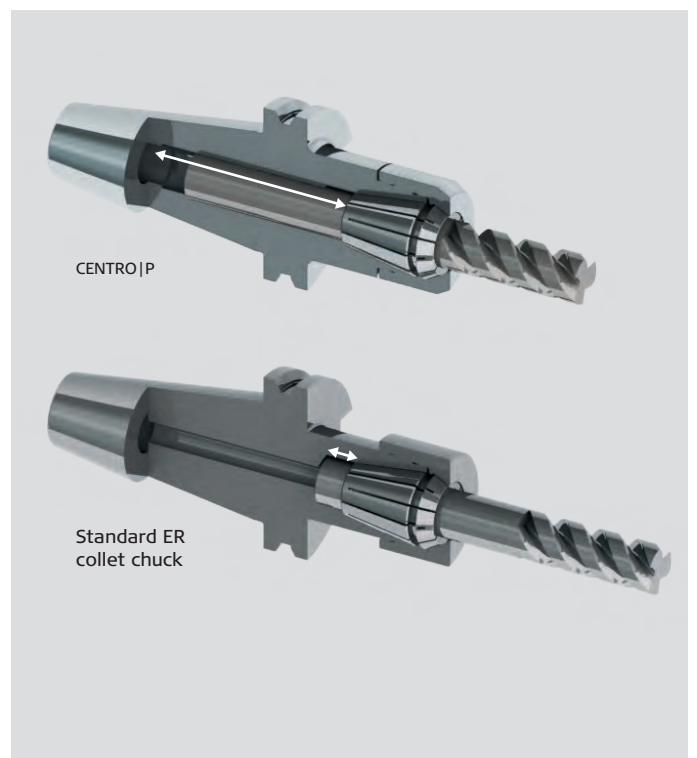


FPC chucks extend the range of application of the CENTRO|P chuck to heavy chipping with high axial forces. Different lengths ensure best access to the work piece, even over devices and other interference contours.



The inner contour

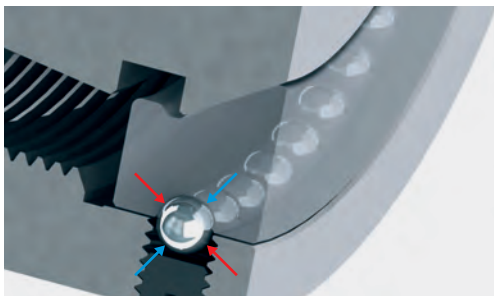
Flexibility of projection is ensured by a large through diameter.



FPC, FULL PERFORMANCE CHUCKS

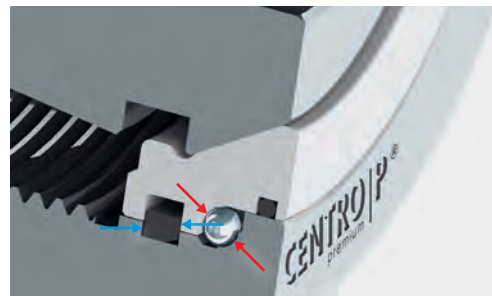
Full Performance thanks to Angular Contact Ball Bearings

- New design of the clamping nut with an angular contact ball bearing and a compensating ring
- Proven trapezoidal thread with CENTRO|P typical double guide
- The ring allows clamping of the collet without radial forces. When tightening, the pressure on the collet is exerted only in the axial direction from top to bottom
- The multi-part nut increases the vibration damping.
- The tightening torques are identical to those of the PREMIUM DPC series
- As a result, the FPC clamping nut achieves a resulting clamping force between 350 Nm and 380 Nm, which is higher than with hydraulic chucks



Conventional deep groove ball bearings:

Force flow during clamping (red) or release (blue) is transmitted exclusively via balls and bearing shells



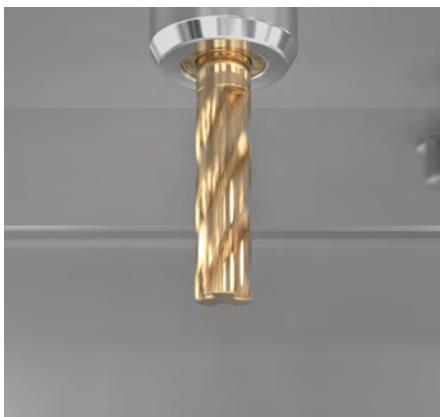
Angular contact ball bearings at FPC:

Power flow during clamping (red) is transmitted via the balls, when releasing (blue) via the circlip

Coolant supply variants through the matching collet

One system, several variants. The choice of collet determines the type of coolant supply. For you this means:

- Better surface quality
- Longer tool life
- Easy chip removal
- Cooling and lubricating of the tool cutting edge



Without coolant supply
GERC-HP
GERC-B



Coolant through the centre
GERC-HPD
GERC-BD
GERC-GBD



Peripheral cooling
GERC-HPDD
GERC-GBDD

Process optimisation

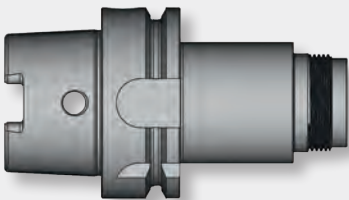
NEW

Optimise your process and inquire about our collets with customised jet holes. Starting at 0.2 mm outlet diameter, jet holes can be designed for specific applications, e.g. for cryogen or aerosol cooling.

FPC, FULL PERFORMANCE CHUCKS

Overview

Interface:



- HSK-A 63
- HSK-A 100
- HSK-F 63
- SK 40
- SK 50
- BT 40 / BTP 40
- BT 50 / BTP 50
- PSC 63
- PSC 80
- CYL 32
- CYL 40

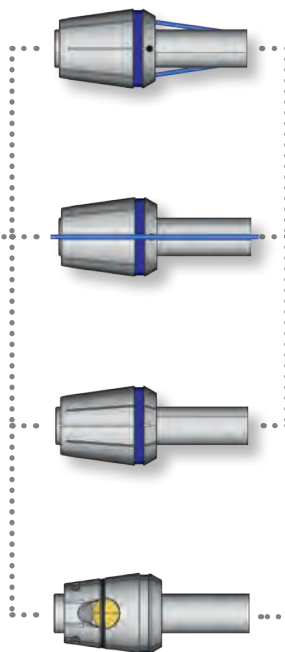
Execution:

- Cylindrical

Lengths:

- 60 mm to 75 mm
- 90 mm
- 100 mm / 105 mm
- 120 mm
- 130 mm / 135 mm
- 160 mm / 165 mm
- 200 mm

Collets:



- GERC32-B / BD
- GERC32-HP / HPD / HPDD
- GERC32-W
- GERC40-B / BD
- GERC40-HP / HPD / HPDD
- GERC40-W

Clamping nuts:

3 μ m at 3xD with HP collets and FPC clamping nut
6 μ m at 3xD with B collets and FPC clamping nut

FPC



FPC

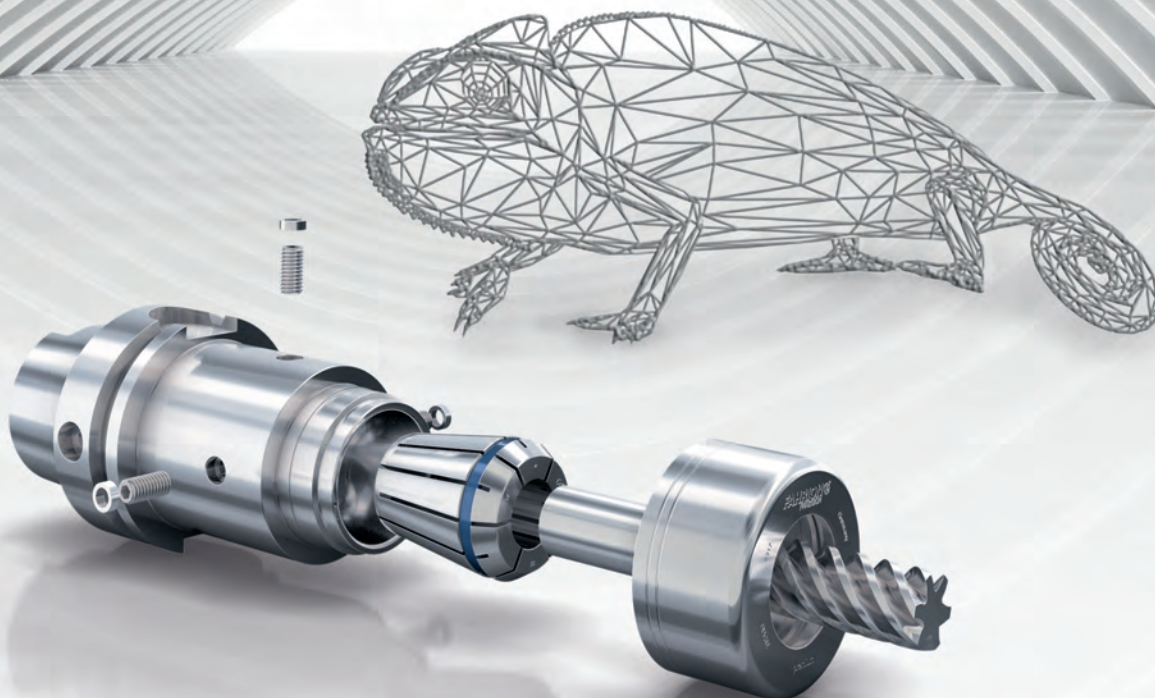


4 μ m at 3xD with W collets and FPC clamping nut

- FPC 32
- FPC 40

AFC, ADJUSTABLE FINISHING CHUCKS

Adjustable with Long Overhang



In order to achieve optimal machining results, e.g. during reaming, or also for other ultrafine machining, a perfect concentricity of the tool is essential. Adjustable chucks are used to eliminate concentricity errors of tool holder and machine spindle.

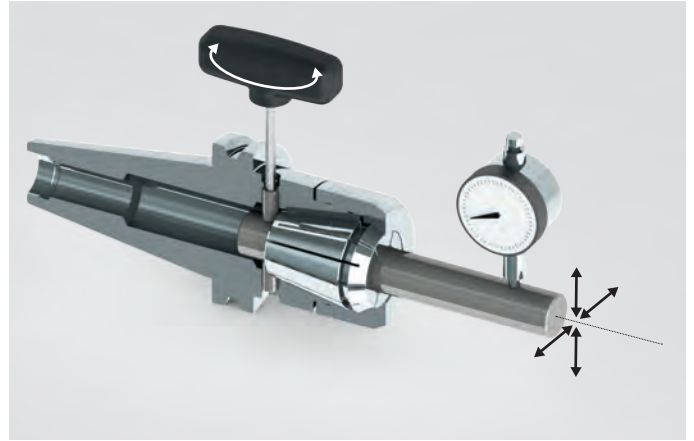
For the first time, the **AFC Adjustable Finishing Chucks** combine all the advantages of the CENTRO|P clamping system with the possibility of precisely adjusting the concentricity over four adjusting screws around the circumference of the chuck.

AFC, ADJUSTABLE FINISHING CHUCKS

Features

To ensure optimum concentricity, the AFC chuck must be adjusted in the machine spindle.

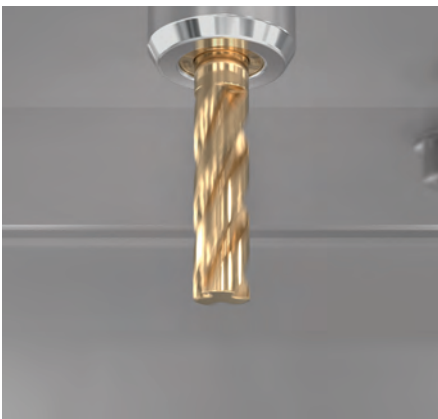
This is the only way to completely eliminate any concentricity deviations of the chuck, machine spindle, and or interface.



Coolant supply variants through the matching collet

One system, several variants. The choice of collet determines the type of coolant supply. For you this means:

- Better surface quality
- Longer tool life
- Easy chip removal
- Cooling and lubricating of the tool cutting edge



Without coolant supply
GERC-HP
GERC-B



Coolant through the centre
GERC-HPD
GERC-BD
GERC-GBD



Peripheral cooling
GERC-HPDD
GERC-GBDD

Process optimisation

NEW

Optimise your process and inquire about our collets with customised jet holes. Starting at 0.2 mm outlet diameter, jet holes can be designed for specific applications, e.g. for cryogen or aerosol cooling.

MPC / DPC, CYLINDRICAL TOOL EXTENSIONS

Slim, Long, and Accurate - the Perfect Complement to the System



MPC / DPC Cylindrical Tool Extensions are particularly suitable for precision machining in hard-to-reach places and set standards in the areas of concentricity, set-up time and flexibility.

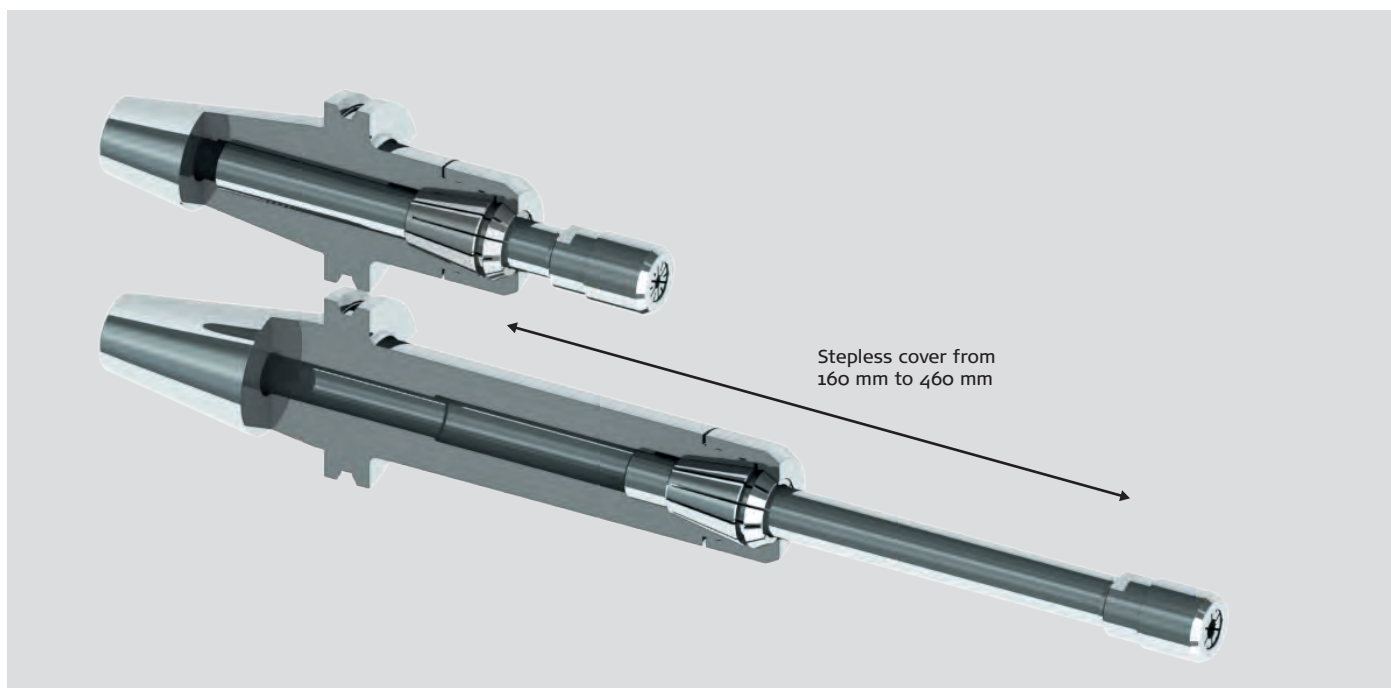
Instead of expensive special tools, a single change in length is often sufficient, which can be clamped more or less deeply into a CENTRO|P chuck as required.

MPC / DPC, CYLINDRICAL TOOL EXTENSIONS

Features

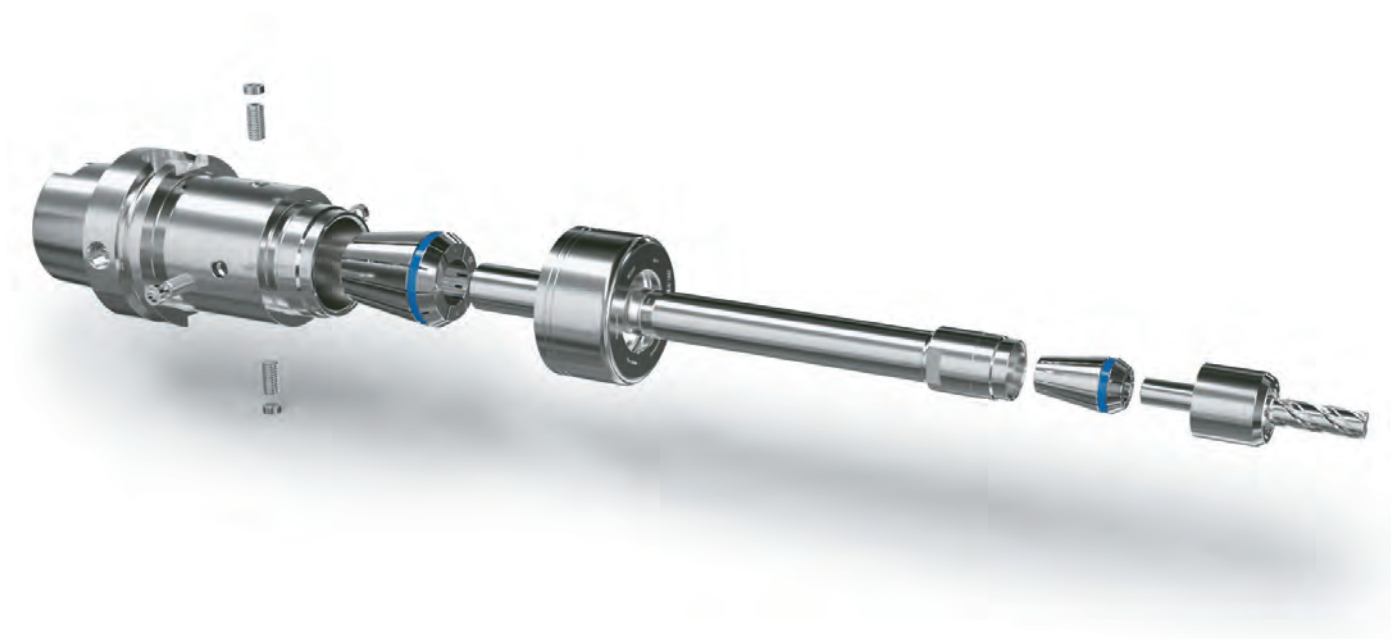
Cylindrical extensions are ideal for flexible lengths with existing holders.

This can easily save time and costs for complex special geometries.



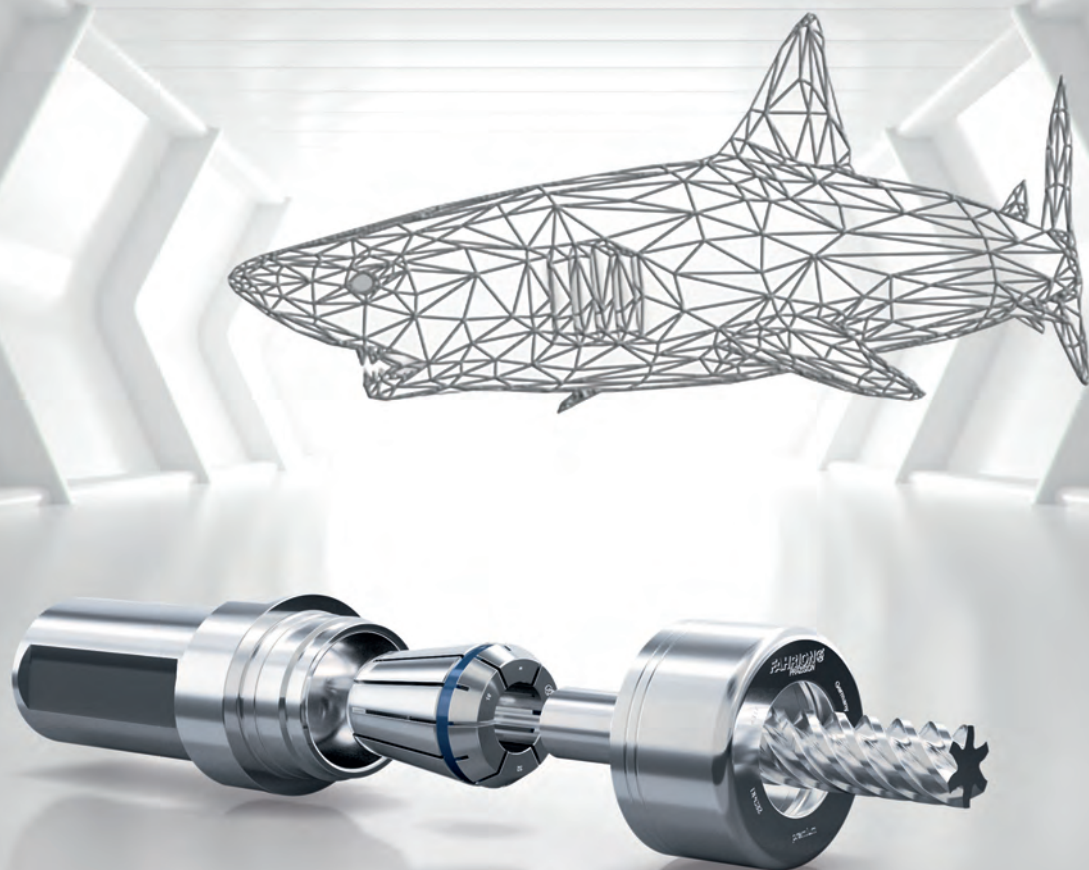
Basically, the longer the projection the more important the damping becomes with tool holders. Additional interfaces (extension in the basic chuck via high-precision collet chuck) mean additional damping.

However, additional interfaces also mean poorer concentricity. When using the AFC holders as a basis, the concentricity can be set and thus optimised.



DPC / FPC, PERFORMANCE HOLDERS NC FOR LATHES

Versatile and Highly Precise



Versatile **DPC / FPC Performance Holders** for drilling, threading and reaming on NC lathes. The high-precision CENTRO|P chuck is clearly superior to conventional ER chucks.

The flange as a stop allows for a quick pre-setting of the cutting tool also outside the machine. The shaft can be inserted directly into the drill holder of the tool turret. This also protects the surface on the shaft.

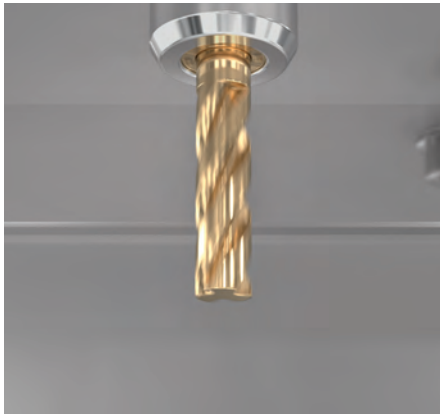
DPC / FPC, PERFORMANCE HOLDERS NC FOR LATHES

Versatile and Highly Precise

Coolant supply variants through the matching collet

One system, several variants. The choice of collet determines the type of coolant supply. For you this means:

- Better surface quality
- Longer tool life
- Easy chip removal
- Cooling and lubricating of the tool cutting edge



Without coolant supply
GERC-HP
GERC-B



Coolant through the centre
GERC-HPD
GERC-BD
GERC-GBD



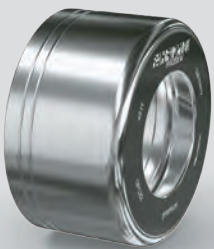
Peripheral cooling
GERC-HPDD
GERC-GBDD

Process optimisation

NEW

Optimise your process and inquire about our collets with customised jet holes. Starting at 0.2 mm outlet diameter, jet holes can be designed for specific applications, e.g. for cryogen or aerosol cooling.

Variants with different clamping nuts for every application



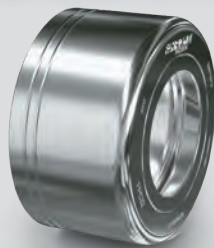
The Clamping Nut DPC

- Has a low friction coating
- Does not require grooves for the clamping wrench
- Has a stable trapezoidal thread and the FAHRION typical double guide for high clamping forces, optimum concentricity and minimal residual imbalance



Clamping Nut HSS for

- Collet collapse up to 0.4 mm



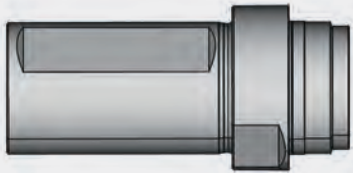
The Clamping Nut FPC

- With angular ball bearing and compression ring possesses all the characteristics of the DPC clamping nut while also increasing the vibration damping and holding force.

DPC / FPC, PERFORMANCE HOLDERS NC FOR LATHES

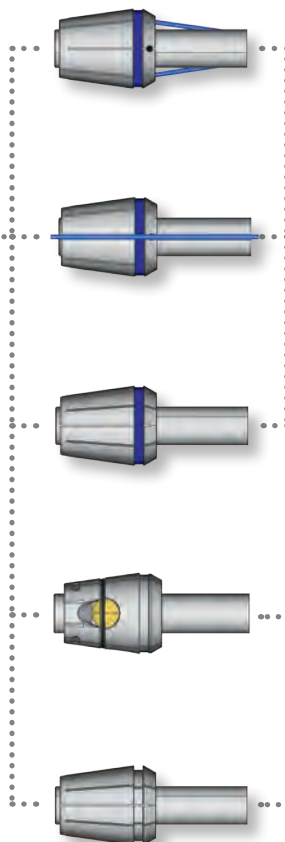
Overview

Interface:



- Cyl Ø 25
- Cyl Ø 32
- Cyl Ø 40

Collets:



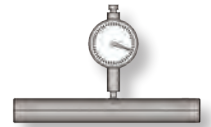
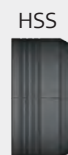
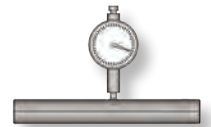
- GERC25-B/BD
- GERC25-HP/HPD/HPDD
- GERC32-B/BD
- GERC32-HP/HPD/HPDD
- GERC40-/BD
- GERC40-HP/HPD/HPDD

Clamping Nuts:

3 µm at 3xD with HP collets and DPC clamping nut
6 µm at 3xD with B collets and DPC clamping nut



4 µm bel 3xD with W collets
and FPC clamping nut



HSS clamping nut recommended for GERC-B collets
for collet collapse up to max. - 0,4 mm

- DPC25
- DPC25-HSS
- DPC32
- DPC32-HSS
- DPC40
- FPC32
- FPC40

CHUCKS



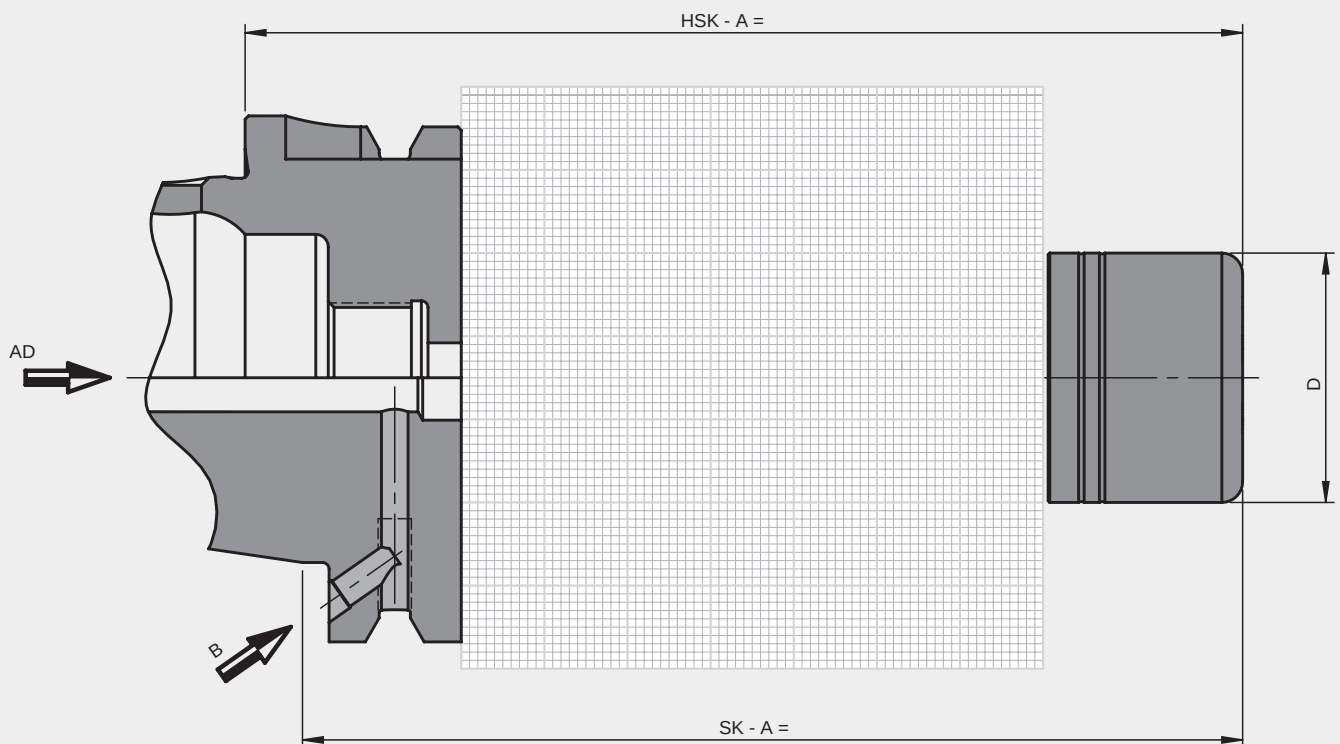
TAILOR MADE

FAHRION Chuck Configurator

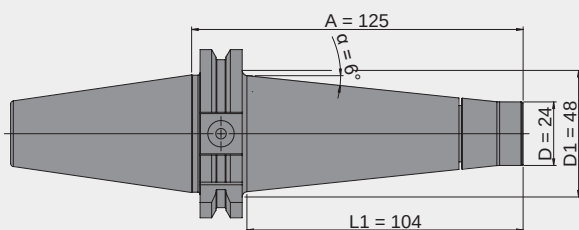
Use our special chuck configurator to significantly extend the service life of your cutting tools. Determine the optimal length and shape of your chuck. Sketch your idea and send it to us.

Tapered chucks, where space allows, tend to be more stable and stiffer than cylindrical chucks (example 1). Chucks that are tapered in the rear and cylindrical in the front (example 2) or cylindrical chucks in the optimal length – as short as possible or as long as necessary.

Design the desired chuck below and we will deliver it to you. It's as simple as that!

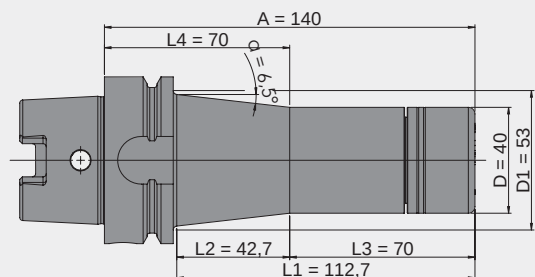


Example 1:



MPC16T-AD40-A=125 (tapered 6°)

Example 2:



DPC25-HSK-A63-A=140 (stepped - tapered 6,5°)

Please specify the following parameters and send them to us. You will receive a non-binding offer immediately:
Mail: sales@fahrion.de

Form for your individual CHUCK				
Spindle-Side Interface (see pages 170 / 171 in the Technical Section)				
Drilling for RFID chip	☐ Yes ☐ No			
Coolant Supply	☐ AD central ☐ B through the flange			
Shape	☐ cylindrical ☐ tapered ☐ stepped			
Dimension A (up to A = 300 mm)				
Clamping Nuts	D	Type	Collet	Clamping range
	☐ 10	MPC8	GERC8	1-5 mm
	☐ 16	MPC11	GERC11	1-7 mm
	☐ 22	MPC16	GERC16	1-10 mm
	☐ 24	MPC16T	GERC16	1-10 mm
	☐ 30	DPC16	GERC16	1-10 mm
	☐ 32	DPC20	GERC20	1-13 mm
	☐ 40	DPC25	GERC25	1-16 mm
	☐ 50	DPC32	GERC32	2-20 mm
	☐ 53	UPC32	GERC32	2-20 mm
	☐ 63	UPC40	GERC40	3-26 mm
	☐ 50	FPC32	GERC32	2-20 mm
	☐ 63	FPC40	GERC40	3-26 mm

Please select your desired version.

Minimum order quantity 5 pcs.
under- or over-supply of up to 10%
(but not less than 1 piece).



ONLINE SERVICE

Download the sketch template and the configuration form directly from our website at:

fahrion.de/downloads-en.html

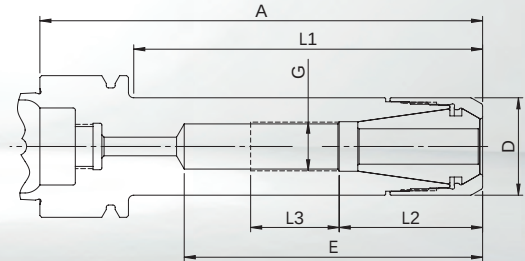
HSK-A32 MPC

MPC MINI PRECISION CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-HSK-A32-A=40	61131340405	---	16	50.000	24	20	---	---	---
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-HSK-A32-A=50	61133340505	61133340506	22	45.000	32	30	---	---	---
MPC16-HSK-A32-A=100	61133341005	61133341006	22	30.000	67	80	32	20	M11x1

Suitable Accessories

Collets



Page 135ff

Clamping Nuts



Page 162ff

Wrenches



Page 160

Mounting Devices



Page 161

Adjustable
Stop Screws



Page 165

Coolant Supply
Tubes and Wrenches



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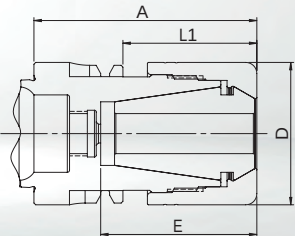
DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

HSK-A32
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-HSK-A32-A=50	63134300505	63134300506	32	35	30	---	---	---

Suitable Accessories

Collets



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Clamping Nuts



Page 162ff

Wrenches



Page 160

Mounting Devices



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Adjustable
Stop Screws



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Coolant Supply
Tubes and Wrenches



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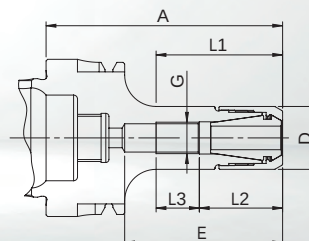
HSK-A40 MPC

MPC MINI PRECISION CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or $U \leq 1 \text{ gmm}$
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \text{ }\mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench $\varnothing$	max. 1/min	E	L1	L2	L3	G
Clamping range $\varnothing$ 1-7 mm - Collets GERC11								
MPC11-HSK-A40-A=60	61141340605	16	42.000	40	40	21	11	M8x1
MPC11-HSK-A40-A=130	61141341305	16	27.000	75	110	19	22	M8x1

Suitable Accessories

Collets



Page 135ff

Clamping Nuts



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Wrenches



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Mounting Devices



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Adjustable
Stop Screws



Page 165

Coolant Supply
Tubes and Wrenches



Page 165

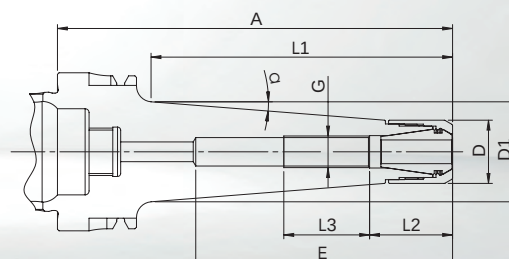
MPC MINI PRECISION CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

HSK-A40
MPC

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or $U \leq 1 \text{ gmm}$
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \text{ }\mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16										
MPC11C-HSK-A40-A=100	61141331005	16	40.000	65	25	4,5°	76	21	21	M8x1

Suitable Accessories

Collets



Page 135ff

Clamping Nuts



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Wrenches



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Mounting Devices



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Adjustable
Stop Screws



Page 165

Coolant Supply
Tubes and Wrenches



Page 165

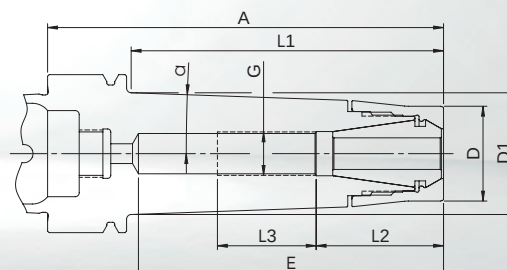
HSK-A40 MPC

MPC MINI PRECISION CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult cutting tasks and milling operations
Tapered design with tapered clamping nut for more stability and clamping force



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16T-HSK-A40-A=60	61143320605	61143320606	24	42.000	43	28	2°	40	---	---	---
MPC16T-HSK-A40-A=100	61143321005	61143321006	24	40.000	77	30	2°	80	32	25	M11x1

Suitable Accessories

Collets



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Clamping Nuts



Page 162ff

Wrenches



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Mounting Devices



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Adjustable Stop Screws



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Coolant Supply Tubes and Wrenches



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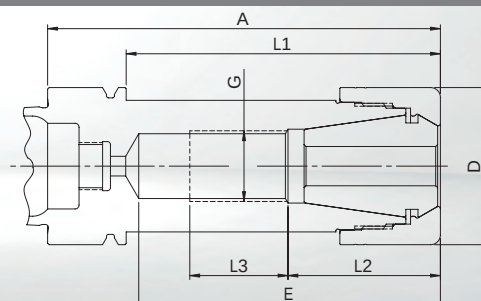
DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

HSK-A40
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm

- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-HSK-A40-A=60	63143300605	63143300606	30	41	40	---	---	---
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-A40-A=60	63145300605	63145300606	40	39	40	---	---	---
DPC25-HSK-A40-A=100	63145301005	63145301006	40	77	80	39	25	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-HSK-A40-A=61	63146300615	63146300616	50	44,5	41,5	---	---	---

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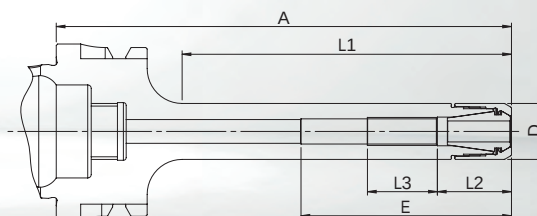
HSK-A50 MPC

MPC MINI PRECISION CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11								
MPC11-HSK-A50-A=130	61151341305	16	27.000	60	104	21	20	M8x1

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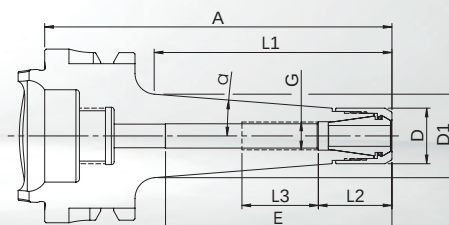
MPC MINI PRECISION CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

HSK-A50
MPC

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or $U \leq 1 \text{ gmm}$
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \text{ }\mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11										
MPC11C-HSK-A50-A=100	61151331005	16	30.000	60	24	4,5°	68	21	20	M8x1

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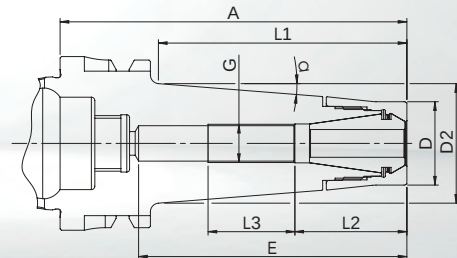
HSK-A50 MPC

MPC MINI PRECISION CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult cutting tasks and milling operations
Tapered design with tapered clamping nut for more stability and clamping force



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16T-HSK-A50-A=65	61153320655	61153320656	24	30.000	44	28,9	4,5°	36,5	---	---	---
MPC16T-HSK-A50-A=100	61153321005	61153321006	24	30.000	77	34,4	4,5°	71,5	32	25	M11x1
MPC16T-HSK-A50-A=130	61153321305	61153321306	24	30.000	102	39,4	4,5°	103	32	25	M11x1

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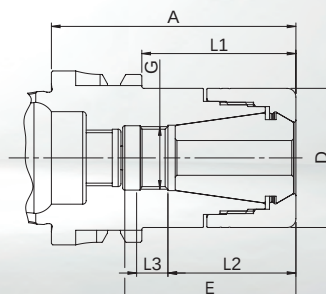
DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

HSK-A50 DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-A50-A=60	63155300605	63155300606	40	36,5	34,5	---	---	---
DPC25-HSK-A50-A=70	63155300705	63155300706	40	49,5	44	37	8	M18x1,5
DPC25-HSK-A50-A=100	63155301005	63155301006	40	76	74	39	25	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-HSK-A50-A=70	63156300705	63156300706	50	47,5	44	---	---	---

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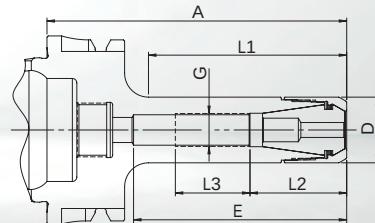
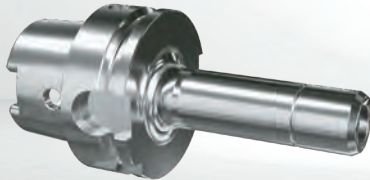
HSK-A63 MPC

MPC MINI PRECISION CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-HSK-A63-A=70	61161340705	---	16	25.000	48	34	19	20	M8x1
MPC11-HSK-A63-A=100	61161341005	---	16	25.000	78	64	19	25	M8x1
MPC11-HSK-A63-A=130	61161341305	---	16	25.000	108	94	19	20	M8x1
MPC11-HSK-A63-A=160	61161341605	---	16	25.000	138	124	19	25	M8x1
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-HSK-A63-A=70	61163340705	61163340706	22	25.000	47	39	32	10	M11x1
MPC16-HSK-A63-A=100	61163341005	61163341006	22	25.000	71	66	32	25	M11x1
MPC16-HSK-A63-A=130	61163341305	61163341306	22	25.000	102	96	32	28	M11x1
MPC16-HSK-A63-A=160	61163341605	61163341606	22	25.000	97	122	32	30	M11x1

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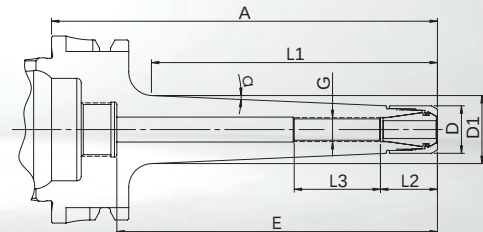
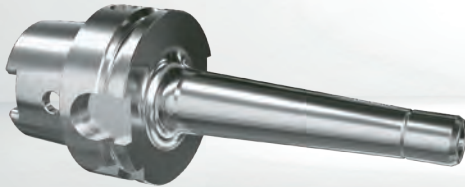
MPC MINI PRECISION CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

HSK-A63
MPC

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 μm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 μm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-HSK-A63-A=100	61161331005	---	16	25.000	78	21	2,5°	66	19	35	M8x1
MPC11C-HSK-A63-A=130	61161331305	---	16	25.000	108	23	2,5°	96	19	35	M8x1
MPC11C-HSK-A63-A=160	61161331605	---	16	25.000	138	25,5	2,5°	127	19	35	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-HSK-A63-A=100	61163331005	61163331006	22	25.000	71	26,5	2,5°	69	32	37	M11x1
MPC16C-HSK-A63-A=130	61163331305	61163331306	22	25.000	102	28,5	2,5°	99	32	37	M11x1
MPC16C-HSK-A63-A=160	61163331605	61163331606	22	25.000	97	31,5	2,5°	129	32	37	M11x1

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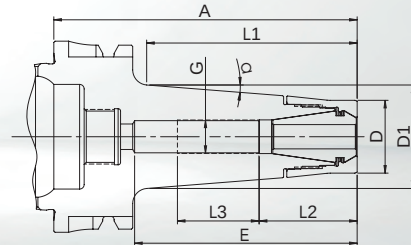
HSK-A63 MPC

MPC MINI PRECISION CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult cutting tasks and milling operations
Tapered design with tapered clamping nut for more stability and clamping force



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16T-HSK-A63-A=100	61163321005	61163321006	24	25.000	75	34,5	4,5°	67	32	27	M11x1
MPC16T-HSK-A63-A=130	61163321305	61163321306	24	25.000	103	39	4,5°	99	32	27	M11x1
MPC16T-HSK-A63-A=160	61163321605	61163321606	24	25.000	107	36	2,5°	127	32	27	M11x1

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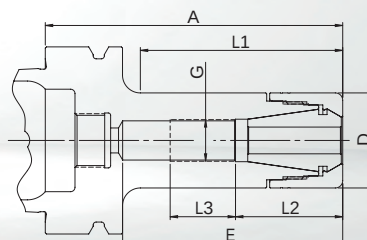
DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

HSK-A63 DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-HSK-A63-A=55	63163300555	63163300556	30	32	26,5	---	---	---
DPC16-HSK-A63-A=100	63163301005	63163301006	30	71	64	32	25	M11x1
DPC16-HSK-A63-A=130	63163301305	63163301306	30	97	94	32	28	M11x1
DPC16-HSK-A63-A=160	63163301605	63163301606	30	107	124	32	25	M11x1
DPC16-HSK-A63-A=200	63163302005	63163302006	30	137	164	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-HSK-A63-A=60	63164300605	63164300606	32	34,5	33	---	---	---
DPC20-HSK-A63-A=100	63164301005	63164301006	32	74	68	36	22	M14x1
DPC20-HSK-A63-A=130	63164301305	63164301306	32	104	98	36	25	M14x1
DPC20-HSK-A63-A=160	63164301605	63164301606	32	118	128	36	46	M14x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-A63-A=60	63165300605	63165300606	40	37	28	---	---	---
DPC25-HSK-A63-A=100	63165301005	63165301006	40	71	68	43	23	M18x1,5
DPC25-HSK-A63-A=130	63165301305	63165301306	40	89	98	43	28	M18x1,5
DPC25-HSK-A63-A=160	63165301605	63165301606	40	104	128	43	35	M18x1,5
DPC25-HSK-A63-A=200	63165302005	63165302006	40	149	168	43	35	M18x1,5

For other DPC chucks with HSK-A63, see following page.

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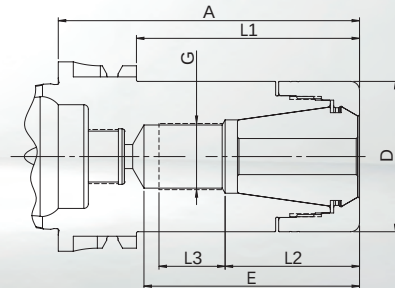
HSK-A63 DPC

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-HSK-A63-A=70	63166300705	63166300706	50	45	44	---	---	---
DPC32-HSK-A63-A=100	63166301005	63166301006	50	72	73	45	22	M22x1,5
DPC32-HSK-A63-A=130	63166301305	63166301306	50	102	103	45	35	M22x1,5
DPC32-HSK-A63-A=160	63166301605	63166301606	50	130	133	48	40	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-HSK-A63-A=80	63167300805	---	63	56	54	---	---	---
DPC40-HSK-A63-A=120	63167301205	---	63	90	94	56	30	M28x1,5
DPC40-HSK-A63-A=160	63167301605	---	63	90	134	56	30	M28x1,5

Suitable Accessories

Collets



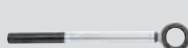
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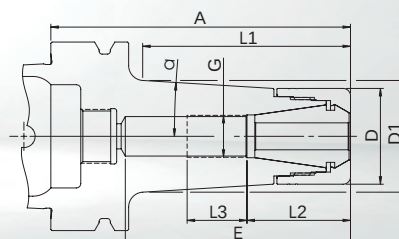
DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

HSK-A63 DPC

Stable precision chuck for demanding tasks, especially in HDC milling
Tapered design for better damping and higher stability



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm

- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16										
DPC16C-HSK-A63-A=75	63163310755	63163310756	30	51	33	4,5°	42	32	15	M11x1
DPC16C-HSK-A63-A=100	63163311005	63163311006	30	75	35,5	3,5°	68	32	20	M11x1
DPC16C-HSK-A63-A=130	63163311305	63163311306	30	105	36,5	2,5°	97	32	20	M11x1
Clamping range Ø 1-13 mm - Collets GERC20										
DPC20C-HSK-A63-A=75	63164310755	63164310756	32	50	35	4,5°	45	34	10	M14x1
DPC20C-HSK-A63-A=100	63164311005	63164311006	32	75	37	3,5°	69	34	20	M14x1
DPC20C-HSK-A63-A=130	63164311305	63164311306	32	105	39	2,5°	99	34	20	M14x1
Clamping range Ø 1-16 mm - Collets GERC25										
DPC25C-HSK-A63-A=75	63165310755	63165310756	40	50	44	4,5°	45	---	---	---
DPC25C-HSK-A63-A=100	63165311005	63165311006	40	74	46	3,5°	71	43	25	M18x1,5
DPC25C-HSK-A63-A=130	63165311305	63165311306	40	104	47	2,5°	101	43	25	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32										
DPC32C-HSK-A63-A=75	63166310755	63166310756	50	71	51,5	4°	49	---	---	---

Suitable Accessories

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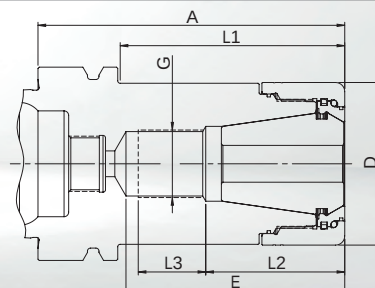
HSK-A63 UPC

UPC ULTRA POWER CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Cylindrical design with a multi-part clamping nut for optimised damping and maximum stability



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
UPC32-HSK-A63-A=70	67166300705	53	45	43	---	---	---
UPC32-HSK-A63-A=100	67166301005	53	72	74	45	22	M22x1,5

Suitable Accessories

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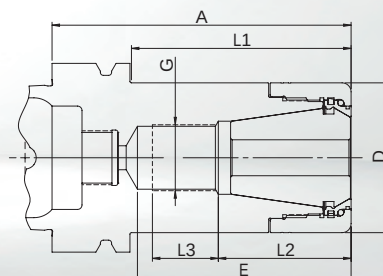
FPC FULL PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

HSK-A63 FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-HSK-A63-A=70	63166300709	50	45	44	---	---	---
FPC32-HSK-A63-A=100	63166301009	50	72	73	45	22	M22x1,5
FPC32-HSK-A63-A=130	63166301309	50	102	103	45	35	M22x1,5
FPC32-HSK-A63-A=160	63166301609	50	130	133	48	40	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-HSK-A63-A=80	63167300809	63	56	54	---	---	---
FPC40-HSK-A63-A=120	63167301209	63	90	94	56	30	M28x1,5
FPC40-HSK-A63-A=160	63167301609	63	90	134	56	30	M28x1,5

Suitable Accessories

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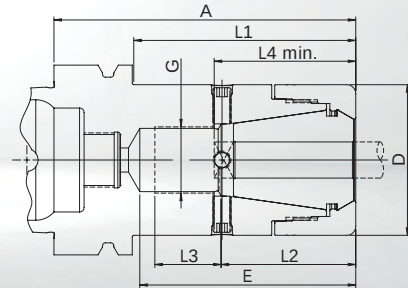
HSK-A63 AFC

AFC ADJUSTABLE FINISHING CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-HSK-A63-A=100	63165305235	40	71	68	43	23	M18x1,5
11-13	10,1-13,5	43	AFC25-HSK-A63-A=100	63165305245	40	71	68	43	23	M18x1,5
14-16	13,51-16	43	AFC25-HSK-A63-A=100	63165305265	40	71	68	43	23	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-HSK-A63-A=100	63166305245	50	72	73	45	22	M22x1,5
14-20	13,51-20	47	AFC32-HSK-A63-A=100	63166305265	50	72	73	45	22	M22x1,5
Collets GERC40										
10-16	9,51-16,5	55	AFC40-HSK-A63-A=120	63167305365	63	90	94	56	30	M28x1,5
17-22	16,51-22,5	55	AFC40-HSK-A63-A=120	63167305385	63	90	94	56	30	M28x1,5
23-26	22,51-26	55	AFC40-HSK-A63-A=120	63167305395	63	90	94	56	30	M28x1,5

Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø.
Other versions and clamping Ø can be offered after technical examination.

Suitable Accessories

Collets



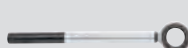
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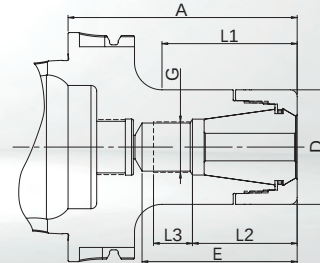
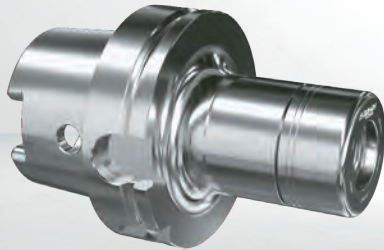
DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

HSK-A100 DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-HSK-A100-A=100	63183301005	63183301006	30	71	58	32	25	M11x1
DPC16-HSK-A100-A=130	63183301305	63183301306	30	101	89	32	25	M11x1
DPC16-HSK-A100-A=160	63183301605	63183301606	30	130	118	32	25	M11x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-A100-A=100	63185301005	63185301006	40	68	59	42	20	M18x1,5
DPC25-HSK-A100-A=130	63185301305	63185301306	40	98	89	42	35	M18x1,5
DPC25-HSK-A100-A=160	63185301605	63185301606	40	128	119	42	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-HSK-A100-A=100	63186301005	63186301006	50	67	59	45	17	M22x1,5
DPC32-HSK-A100-A=130	63186301305	63186301306	50	97	89	47	35	M22x1,5
DPC32-HSK-A100-A=160	63186301605	63186301606	50	99	119	47	35	M22x1,5
DPC32-HSK-A100-A=200	63186302005	63186302006	50	149	159	47	35	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-HSK-A100-A=100	63187301005	---	63	65	65	---	---	---
DPC40-HSK-A100-A=130	63187301305	---	63	90	95	56	30	M28x1,5
DPC40-HSK-A100-A=160	63187301605	---	63	90	125	56	35	M28x1,5

Suitable Accessories

Collets



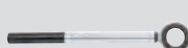
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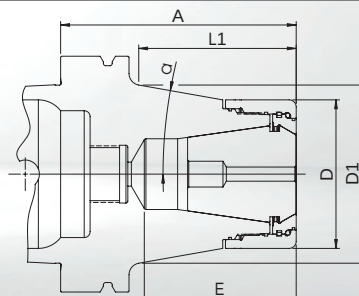
HSK-A100 UPC

UPC ULTRA POWER CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Tapered design with a multi-part clamping nut for optimised damping and maximum stability



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32									
UPC32C-HSK-A100-A=100	67186311005	53	68	66,5	10°	66	45	19	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40									
UPC40C-HSK-A100-A=100	67187311005	63	65	75,5	10°	66,5	---	---	---

Note about UPC40: For longer A dimensions in cylindrical form A=130 and A=160, see FPC page 57.

Suitable Accessories

Collets



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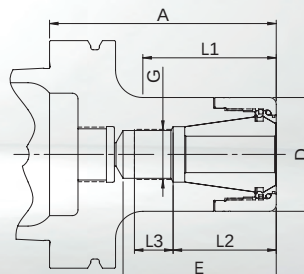
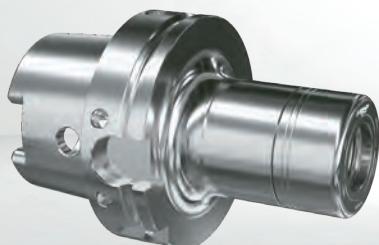
FPC FULL PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

HSK-A100 FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-HSK-A100-A=100	63186301009	50	67	59	45	17	M22x1,5
FPC32-HSK-A100-A=130	63186301309	50	97	89	47	35	M22x1,5
FPC32-HSK-A100-A=160	63186301609	50	99	119	47	35	M22x1,5
FPC32-HSK-A100-A=200	63186302009	50	149	159	47	35	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-HSK-A100-A=100	63187301009	63	65	65	---	---	---
FPC40-HSK-A100-A=130	63187301309	63	90	95	56	30	M28x1,5
FPC40-HSK-A100-A=160	63187301609	63	90	125	56	35	M28x1,5

Suitable Accessories

Collets



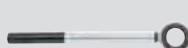
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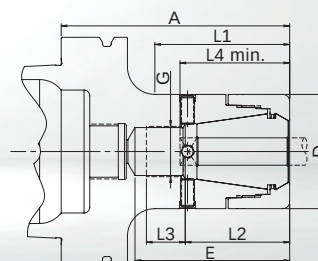
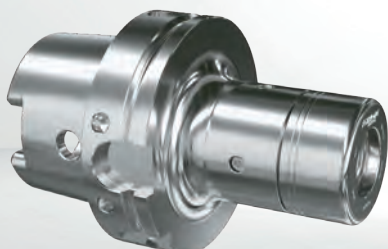
HSK-A100 AFC

AFC ADJUSTABLE FINISHING CHUCKS

DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-HSK-A100-A=100	63185305235	40	68	59	43	20	M18x1,5
11-13	10,1-13,5	43	AFC25-HSK-A100-A=100	63185305245	40	68	59	43	20	M18x1,5
14-16	13,51-16	43	AFC25-HSK-A100-A=100	63185305265	40	68	59	43	20	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-HSK-A100-A=100	63186305245	50	68	59	45	17	M22x1,5
14-20	13,51-20	47	AFC32-HSK-A100-A=100	63186305265	50	68	59	45	17	M22x1,5
Collets GERC40										
7-15	7-15,5	55	AFC40-HSK-A100-A=100	63187305245	63	65	65	---	---	---
16-26	15,51-26	55	AFC40-HSK-A100-A=100	63187305265	63	65	65	---	---	---

Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø. Other versions and clamping Ø can be offered after technical examination.

Suitable Accessories

Collets



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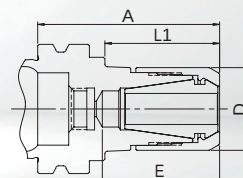
MPC MINI PRECISION CHUCKS

DIN 69893-5

FORM AD - CENTRAL COOLANT SUPPLY

HSK-E25
MPC

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm

- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-5 mm - Collets GERC8									
MPC8-HSK-E25-A=35	61320340355	---	10	60.000	21	21	---	---	---
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-HSK-E25-A=35	61321340355	---	16	60.000	22,5	22	---	---	---
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-HSK-E25-A=45	61323340455	61323340456	22	60.000	30	34	---	---	---

Suitable Accessories

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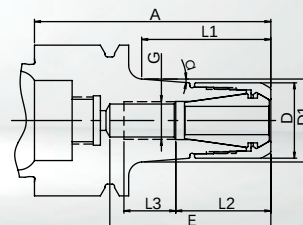
HSK-E32 MPC

MPC MINI PRECISION CHUCKS

DIN 69893-5

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-5 mm - Collets GERC8											
MPC8C-HSK-E32-A=50	61330330505	---	10	50.000	33	12,5	4,5°	27,5	17	10	M5x0,8
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-HSK-E32-A=50	61331330505	---	16	50.000	34	17,5	4,5°	27	20	11	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-HSK-E32-A=55	61333330555	61333330556	22	50.000	32	23,2	2,5°	34	34	7	M6x1

Suitable Accessories

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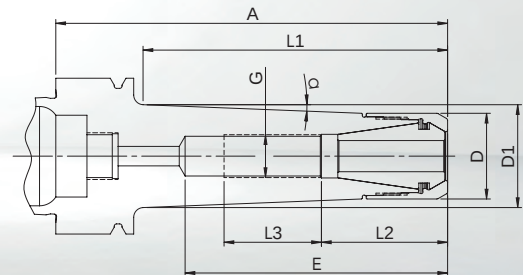
MPC MINI PRECISION CHUCKS

DIN 69893-5

FORM AD - CENTRAL COOLANT SUPPLY

HSK-E40
MPC

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm

- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-HSK-E40-A=50	61341330505	---	16	42.000	31	17	4,5°	22,5	19	10	M8x1
MPC11C-HSK-E40-A=100	61341331005	---	16	40.000	65	25,5	4,5°	75,5	19	25	M8x1
MPC11C-HSK-E40-A=130	61341331305	---	16	35.000	65	30,5	4,5°	108	19	25	M8x1
MPC11C-HSK-E40-A=160	61341331605	---	16	27.000	65	32	4,5°	139	19	25	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-HSK-E40-A=55	61343330555	61343330556	22	42.000	32	23,5	4,5°	31,5	---	---	---
MPC16C-HSK-E40-A=100	61343331005	61343331006	22	40.000	67	26	2,5°	78	32	25	M11x1

Suitable Accessories

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HSK-E40

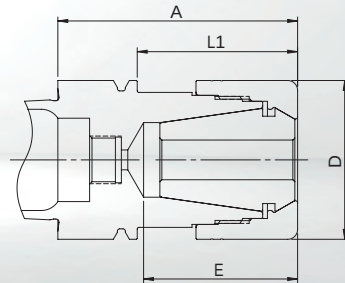
DPC

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-5

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-E40-A=60	63345300605	63345300606	40	38,5	40	---	---	---

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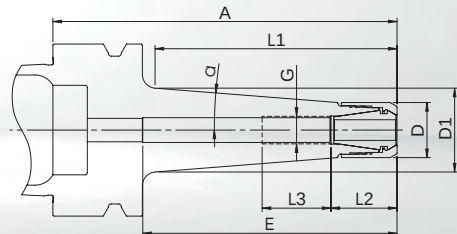
MPC MINI PRECISION CHUCKS

DIN 69893-5

FORM AD - CENTRAL COOLANT SUPPLY

HSK-E50
MPC

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 μm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 μm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-HSK-E50-A=60	61351330605	---	16	30.000	37	18	4,5°	30	18,5	12	M8x1
MPC11C-HSK-E50-A=100	61351331005	---	16	30.000	73	24,5	4,5°	70	19	20	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-HSK-E50-A=60	61353330605	61353330606	22	30.000	32	23,5	4,5°	30	---	---	---
MPC16C-HSK-E50-A=100	61353331005	61353331006	22	30.000	73	26	2,5°	68,5	32	25	M11x1

Suitable Accessories

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HSK-E50

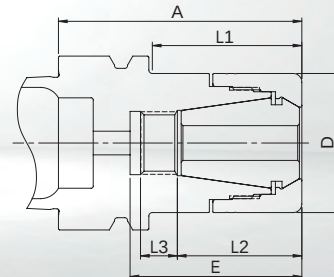
DPC

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-5

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or $U \leq 1$ gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of $\leq 10 \mu\text{m}$ with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-E50-A=70	63355300705	63355300706	40	49	43	35	10	M11x1

Suitable Accessories

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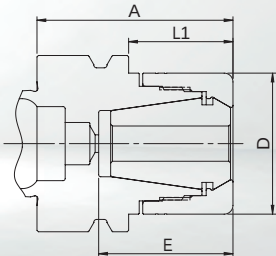
DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-6

FORM AD - CENTRAL COOLANT SUPPLY

HSK-F50
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or $U \leq 1 \text{ gmm}$
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \text{ }\mu\text{m}$ with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of $\leq 10 \text{ }\mu\text{m}$ with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench $\varnothing$	E	L1	L2	L3	G
Clamping range $\varnothing$ 1-16 mm - Collets GERC25								
DPC25-HSK-F50-A=55	63455300555	63455300556	40	38	29	---	---	---

Suitable Accessories

Collets



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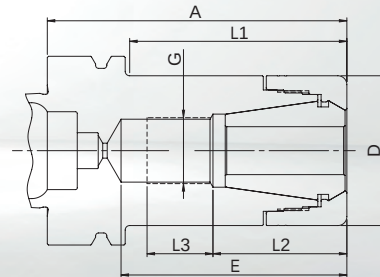
HSK-F63 DPC

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-6

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-HSK-F63-A=100	63463301005	63463301006	30	77	64	32	25	M11x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-F63-A=100	63465301005	63465301006	40	73	68	42	23	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-HSK-F63-A=65	63466300655	63466300656	50	45	38	---	---	---
DPC32-HSK-F63-A=100	63466301005	63466301006	50	75	72	44	22	M22x1,5

Suitable Accessories

Collets



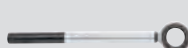
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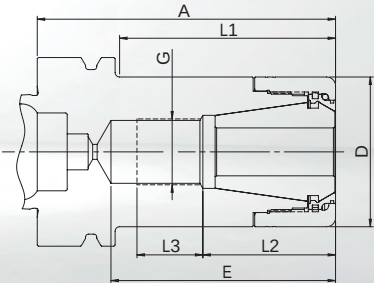
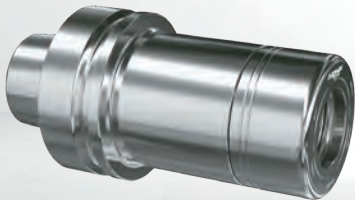
FPC FULL PERFORMANCE CHUCKS

DIN 69893-6

FORM AD - CENTRAL COOLANT SUPPLY

HSK-F63
FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-HSK-F63-A=65	63466300659	50	45	38	---	---	---
FPC32-HSK-F63-A=100	63466301009	50	75	72	44	22	M22x1,5

Suitable Accessories

Collets



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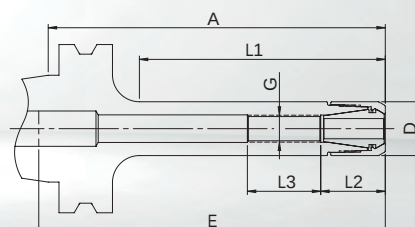
SK30 MPC

MPC MINI PRECISION CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or $U \leq 1 \text{ gmm}$
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \text{ }\mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench $\varnothing$	max. 1/min	E	L1	L2	L3	G
Clamping range $\varnothing$ 1-7 mm - Collets GERC11								
MPC11-AD30-A=50	60121340505	16	25.000	60	23	19	17	M8x1
MPC11-AD30-A=100	60121341005	16	25.000	100	73	19	22	M8x1

Suitable Accessories

Collets



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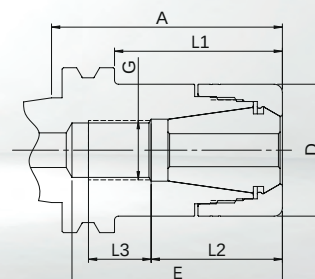
DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

SK30
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-AD30-A=50	62123300505	62123300506	30	65	29	32	25	M11x1
DPC16-AD30-A=100	62123301005	62123301006	30	100	78	32	25	M11x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-AD30-A=70	62125300705	62125300706	40	64	50,5	40	19	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-AD30-A=70	62126300705	62126300706	50	76	51	45	23	M22x1,5

Suitable Accessories

Collets



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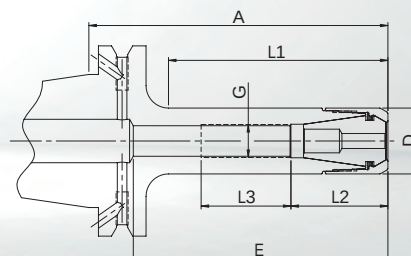
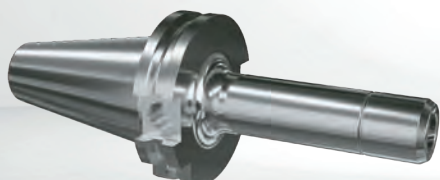
SK40 MPC

MPC MINI PRECISION CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm

- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-B40-A=70	60241340705	---	16	25.000	60	41	19	20	M8x1
MPC11-B40-A=100	60241341005	---	16	25.000	80	71	19	20	M8x1
MPC11-B40-A=130	60241341305	---	16	25.000	110	101	19	25	M8x1
MPC11-B40-A=160	60241341605	---	16	25.000	140	131	19	30	M8x1
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-B40-A=70	60243340705	60243340706	22	25.000	100	45	32	20	M11x1
MPC16-B40-A=100	60243341005	60243341006	22	25.000	100	73	32	30	M11x1
MPC16-B40-A=130	60243341305	60243341306	22	25.000	130	100	32	25	M11x1
MPC16-B40-A=160	60243341605	60243341606	22	25.000	140	130	32	30	M11x1

Suitable Accessories

Collets



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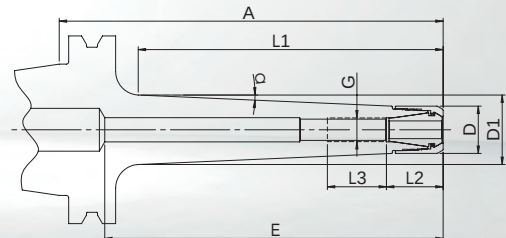
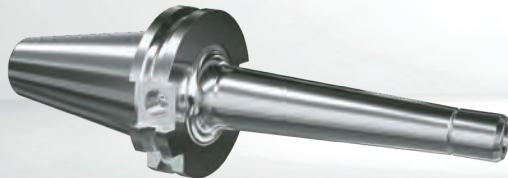
MPC MINI PRECISION CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

SK40
MPC

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-AD40-A=100	60141331005	---	16	25.000	100	21	2,5°	73	19	35	M8x1
MPC11C-AD40-A=130	60141331305	---	16	25.000	100	23,5	2,5°	103	19	35	M8x1
MPC11C-AD40-A=160	60141331605	---	16	25.000	130	26	2,5°	133	19	35	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-AD40-A=100	60143331005	60143331006	22	25.000	80	27	2,5°	76	32	35	M11x1
MPC16C-AD40-A=130	60143331305	60143331306	22	25.000	110	29	2,5°	106	32	35	M11x1
MPC16C-AD40-A=160	60143331605	60143331606	22	25.000	130	32	2,5°	136	32	35	M11x1

Suitable Accessories

Collets



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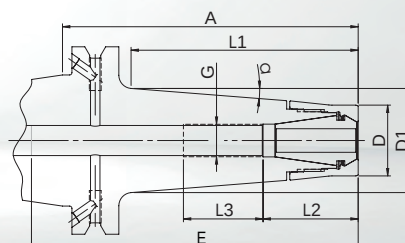
SK40 MPC

MPC MINI PRECISION CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

Slim precision chuck for difficult cutting tasks and milling operations
Tapered design with tapered clamping nut for more stability and clamping force



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm

- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16T-B40-A=100	60243321005	60243321006	24	25.000	100	35	4,5°	77	32	25	M11x1
MPC16T-B40-A=130	60243321305	60243321306	24	25.000	130	40	4,5°	106	32	25	M11x1
MPC16T-B40-A=160	60243321605	60243321606	24	25.000	140	37	2,5°	137	32	25	M11x1

Suitable Accessories

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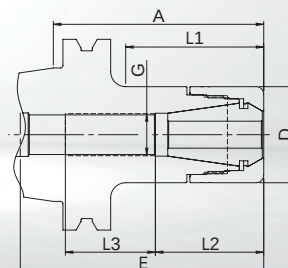
DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

SK40
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-AD40-A=70	62143300705	62143300706	30	100	43,5	32	25	M11x1
DPC16-AD40-A=100	62143301005	62143301006	30	130	73,5	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-AD40-A=70	62144300705	62144300706	32	85	46	36	46	M14x1
DPC20-AD40-A=100	62144301005	62144301006	32	85	75	36	46	M14x1
DPC20-AD40-A=130	62144301305	62144301306	32	150	105	36	25	M14x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-AD40-A=70	62145300705	62145300706	40	110	48,5	45	30	M18x1,5
DPC25-AD40-A=100	62145301005	62145301006	40	130	79	45	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-AD40-A=50	62146300505	62146300506	50	84	31	48	29	M22x1,5
DPC32-AD40-A=70	62146300705	62146300706	50	99	51	48	40	M22x1,5
DPC32-AD40-A=100	62146301005	62146301006	50	114	81	45	50	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-AD40-A=70*	62147300705	---	63	83	50	56	22	M28x1,5
DPC40-AD40-A=100*	62147301005	---	63	83	81	56	20	M28x1,5

* Without clearance to DIN 69871 in front of the tool change flange.
For other DPC chucks with SK40 in AD/B, see following page.

Suitable Accessories

Collets



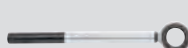
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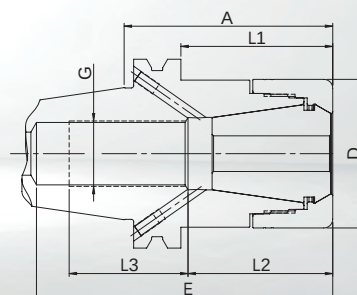
SK40 DPC

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-B40-A=70	62243300705	62243300706	30	100	43,5	32	25	M11x1
DPC16-B40-A=100	62243301005	62243301006	30	130	73,5	32	25	M11x1
DPC16-B40-A=130	62243301305	62243301306	30	160	103,5	32	25	M11x1
DPC16-B40-A=160	62243301605	62243301606	30	180	133,5	32	25	M11x1
DPC16-B40-A=200	62243302005	62243302006	30	220	173	32	25	M11x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-B40-A=45	62245300455	62245300456	40	80	26	43	25	M18x1,5
DPC25-B40-A=70	62245300705	62245300706	40	110	48,5	45	30	M18x1,5
DPC25-B40-A=100	62245301005	62245301006	40	130	79	45	35	M18x1,5
DPC25-B40-A=130	62245301305	62245301306	40	135	109	43	35	M18x1,5
DPC25-B40-A=160	62245301605	62245301606	40	118	139	43	35	M18x1,5
DPC25-B40-A=200	62245302005	62245302006	40	164	178	43	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-B40-A=50	62246300505	62246300506	50	84	31	48	29	M22x1,5
DPC32-B40-A=70	62246300705	62246300706	50	99	51	48	40	M22x1,5
DPC32-B40-A=100	62246301005	62246301006	50	114	81	45	50	M22x1,5
DPC32-B40-A=130	62246301305	62246301306	50	114	111	45	39	M22x1,5
DPC32-B40-A=160	62246301605	62246301606	50	149	141	45	47	M22x1,5

Suitable Accessories

Collets



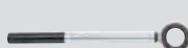
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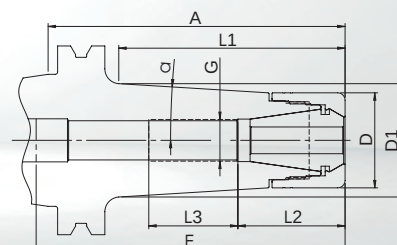
DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

SK40
DPC

Stable precision chuck for demanding tasks, especially in HDC milling
Tapered design for better damping and higher stability



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16										
DPC16C-AD40-A=70	62143310705	62143310706	30	80	34	4,5°	48	32	25	M11x1
DPC16C-AD40-A=100	62143311005	62143311006	30	110	37	3,5°	78	32	25	M11x1
DPC16C-AD40-A=130	62143311305	62143311306	30	130	37	2,5°	108	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20										
DPC20C-AD40-A=70	62144310705	62144310706	32	100	35,5	4,5°	46	32	25	M14x1
DPC20C-AD40-A=100	62144311005	62144311006	32	120	38	3,5°	76	32	25	M14x1
DPC20C-AD40-A=130	62144311305	62144311306	32	140	39	2,5°	106	32	25	M14x1
Clamping range Ø 1-16 mm - Collets GERC25										
DPC25C-AD40-A=70	62145310705	62145310706	40	103	43	4,5°	48	44	30	M18x1,5
DPC25C-AD40-A=100	62145311005	62145311006	40	109	46	3,5°	80	43	35	M18x1,5
DPC25C-AD40-A=130	62145311305	62145311306	40	128	47	2,5°	109	43	35	M18x1,5

Suitable Accessories

Collets



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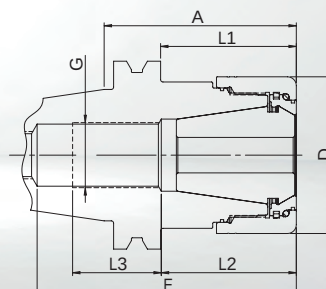
SK40 UPC

UPC ULTRA POWER CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Cylindrical design with a multi-part clamping nut for optimised damping and maximum stability



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
UPC32-AD40-A=65	66146300655	53	87	45	45	30	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
UPC40-AD40-A=70	66147300705	63	83	50	56	27	M28x1,5

Note about UPC40: For longer A dimensions A=100, see FPC page 77.

Suitable Accessories

Collets



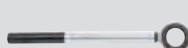
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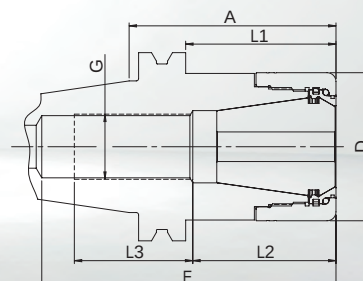
FPC FULL PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

SK40
FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-AD40-A=50	62146300509	50	84	31	48	29	M22x1,5
FPC32-AD40-A=70	62146300709	50	99	51	48	40	M22x1,5
FPC32-AD40-A=100	62146301009	50	114	81	45	50	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-AD40-A=100*	62147301009	63	83	81	56	20	M28x1,5

* Without clearance to DIN 69871 in front of the tool change flange.
For other FPC chucks with SK40 in AD/B, see following page.

Suitable Accessories

Collets



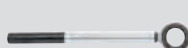
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Clamping Nuts



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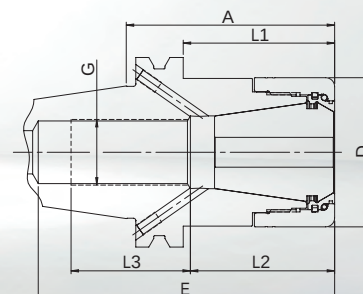
SK40 FPC

FPC FULL PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-B40-A=50	62246300509	50	84	31	48	29	M22x1,5
FPC32-B40-A=70	62246300709	50	99	51	48	40	M22x1,5
FPC32-B40-A=100	62246301009	50	114	81	45	50	M22x1,5
FPC32-B40-A=130	62246301309	50	114	111	45	39	M22x1,5
FPC32-B40-A=160	62246301609	50	149	141	45	47	M22x1,5

Suitable Accessories

Collets



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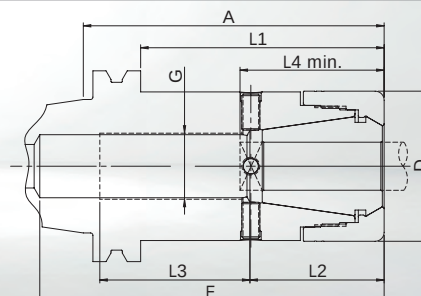
AFC ADJUSTABLE FINISHING CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

SK40
AFC

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-AD40-A=100	62145305235	40	130	79	45	35	M18x1,5
11-13	10,1-13,5	43	AFC25-AD40-A=100	62145305245	40	130	79	45	35	M18x1,5
14-16	13,51-16	43	AFC25-AD40-A=100	62145305265	40	130	79	45	35	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-AD40-A=100	62146305245	50	114	81	45	50	M22x1,5
14-20	13,51-20	47	AFC32-AD40-A=100	62146305265	50	114	81	45	50	M22x1,5
Collets GERC40										
7-15	7-15,5	55	AFC40-AD40-A=100*	62147305245	63	83	81	56	20	M28x1,5
16-26	15,51-26	55	AFC40-AD40-A=100*	62147305265	63	83	81	56	20	M28x1,5

* Without clearance to DIN 69871 in front of the tool change flange.

Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø.
Other versions and clamping Ø can be offered after technical examination.

Suitable Accessories

Collets



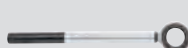
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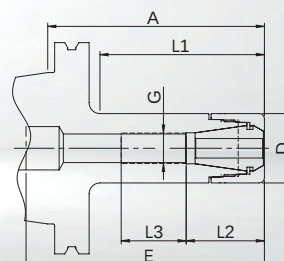
SK50 DPC

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-AD50-A=70	62163300705	62163300706	30	110	39	32	23	M11x1
DPC16-AD50-A=100	62163301005	62163301006	30	140	69	32	30	M11x1
DPC16-AD50-A=160	62163301605	62163301606	30	200	129	32	30	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-AD50-A=100	62164301005	62164301006	32	130	76	36	46	M14x1
DPC20-AD50-A=160	62164301605	62164301606	32	160	106	36	46	M14x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-AD50-A=70	62165300705	62165300706	40	120	38	40	50	M18x1,5
DPC25-AD50-A=100	62165301005	62165301006	40	140	68	43	40	M18x1,5
DPC25-AD50-A=160	62165301605	62165301606	40	200	128	40	40	M18x1,5

For other DPC chucks with SK50 in AD/B, see following page.

Suitable Accessories

Collets



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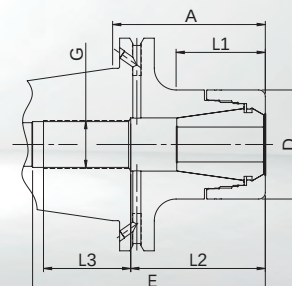
DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

SK50
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm

- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-B50-A=70	62266300705	62266300706	50	108	40	62	34	M22x1,5
DPC32-B50-A=100	62266301005	62266301006	50	120	70	45	40	M22x1,5
DPC32-B50-A=130	62266301305	62266301306	50	150	101	45	40	M22x1,5
DPC32-B50-A=160	62266301605	62266301606	50	150	130	47	40	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-B50-A=70	62267300705	---	63	90	46	56	30	M28x1,5
DPC40-B50-A=100	62267301005	---	63	90	76	56	30	M28x1,5
DPC40-B50-A=130	62267301305	---	63	90	106	56	30	M28x1,5
DPC40-B50-A=160	62267301605	---	63	90	136	56	40	M28x1,5

Suitable Accessories

Collets



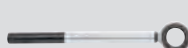
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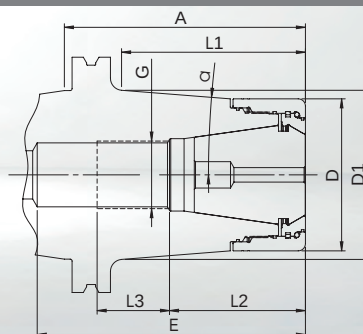
SK50 UPC

UPC ULTRA POWER CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Tapered design with a multi-part clamping nut for optimised damping and maximum stability



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32									
UPC32C-AD50-A=70	66166310705	53	91	59,5	10°	46,5	45,5	35	M22x1,5
UPC32C-AD50-A=100	66166311005	53	121	70,5	10°	77	45,5	38	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40									
UPC40C-AD50-A=70	66167310705	63	93	68	10°	46,5	56	30	M28x1,5
UPC40C-AD50-A=100	66167311005	63	140	70	4,5°	76,5	56	30	M28x1,5

Note about UPC40: For longer A dimensions in cylindrical form A=130 and A=160, see FPC page 83.

Suitable Accessories

Collets



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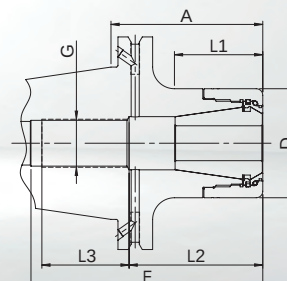
FPC FULL PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

SK50
FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-B50-A=70	62266300709	50	108	40	62	34	M22x1,5
FPC32-B50-A=100	62266301009	50	120	70	45	40	M22x1,5
FPC32-B50-A=130	62266301309	50	150	101	45	40	M22x1,5
FPC32-B50-A=160	62266301609	50	150	130	47	40	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-B50-A=70	62267300709	63	90	46	56	30	M28x1,5
FPC40-B50-A=100	62267301009	63	90	76	56	30	M28x1,5
FPC40-B50-A=130	62267301309	63	90	106	56	30	M28x1,5
FPC40-B50-A=160	62267301609	63	90	136	56	40	M28x1,5

Suitable Accessories

Collets



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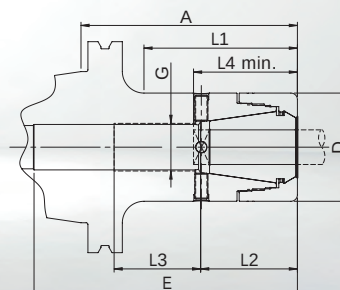
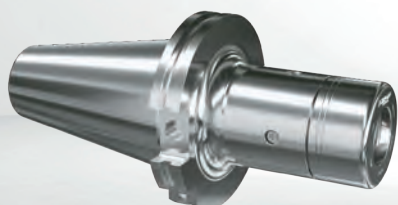
SK50 AFC

AFC ADJUSTABLE FINISHING CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-AD50-A=100	62165305235	40	130	68	43	40	M18x1,5
11-13	10,1-13,5	43	AFC25-AD50-A=100	62165305245	40	130	68	43	40	M18x1,5
14-16	13,51-16	43	AFC25-AD50-A=100	62165305265	40	130	68	43	40	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-AD50-A=100	62166305245	50	114	70	45	40	M22x1,5
14-20	13,51-20	47	AFC32-AD50-A=100	62166305265	50	114	70	45	40	M22x1,5
Collets GERC40										
7-15	7-15,5	55	AFC40-AD50-A=100	62167305245	63	90	76	56	30	M28x1,5
16-26	15,51-26	55	AFC40-AD50-A=100	62167305265	63	90	76	56	30	M28x1,5

Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø.
Other versions and clamping Ø can be offered after technical examination.

Suitable Accessories

Collets



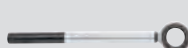
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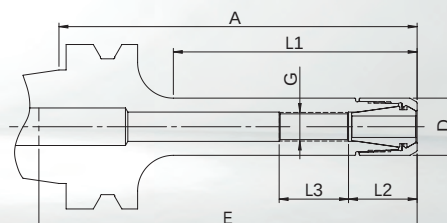
MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

BT30
MPC

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-5 mm - Collets GERC8								
MPC8-BT30-A=75	60420340755	10	25.000	80	43	17	15	M5x0,8
Clamping range Ø 1-7 mm - Collets GERC11								
MPC11-BT30-A=50	60421340505	16	25.000	70	18	19	20	M8x1
MPC11-BT30-A=100	60421341005	16	25.000	120	68	19	20	M8x1

Suitable Accessories

Collets



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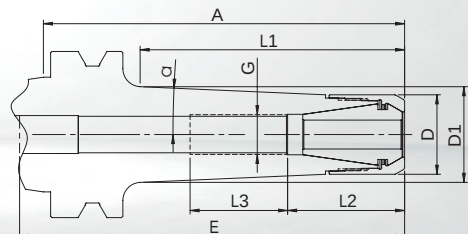
BT30 MPC

MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-BT30-A=100	60421331005	---	16	25.000	110	32	2,5°	73	19	40	M8x1
MPC11C-BT30-A=130	60421331305	---	16	25.000	140	32,5	5,5°	102,5	19	20	M8x1
MPC11C-BT30-A=160	60421331605	---	16	25.000	170	34,5	4,5°	133,5	19	20	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-BT30-A=100	60423331005	60423331006	22	25.000	100	30	2,5°	73	32	40	M11x1

Suitable Accessories

Collets



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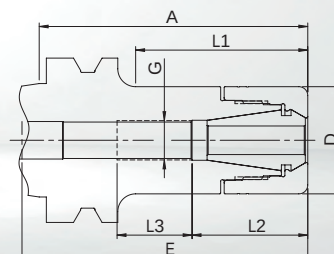
DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

BT30
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-BT30-A=50	62423300505	62423300506	30	70	24	32	25	M11x1
DPC16-BT30-A=60	62423300605	62423300606	30	80	33	32	21	M11x1
DPC16-BT30-A=75	62423300755	62423300756	30	95	48	32	21	M11x1
DPC16-BT30-A=90	62423300905	62423300906	30	110	63	32	21	M11x1
DPC16-BT30-A=105	62423301055	62423301056	30	120	77	32	25	M11x1
DPC16-BT30-A=120	62423301205	62423301206	30	95	93	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-BT30-A=60	62424300605	62424300606	32	65	35	36	22	M14x1
DPC20-BT30-A=75	62424300755	62424300756	32	65	50	36	22	M14x1
DPC20-BT30-A=90	62424300905	62424300906	32	80	65	36	22	M14x1
DPC20-BT30-A=105	62424301055	62424301056	32	95	80	36	22	M14x1
DPC20-BT30-A=120	62424301205	62424301206	32	96	95	36	22	M14x1

For other DPC chucks with BT30, see following page.

Suitable Accessories

Collets



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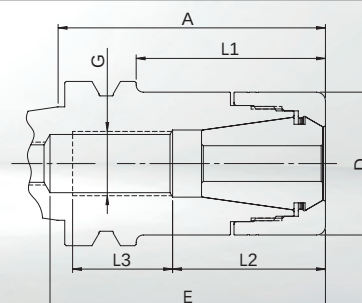
BT30 DPC

DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm

- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-BT30-A=60	62425300605	62425300606	40	77	36	42	24	M18x1,5
DPC25-BT30-A=75	62425300755	62425300756	40	77	51	42	28	M18x1,5
DPC25-BT30-A=90	62425300905	62425300906	40	87	66	42	35	M18x1,5
DPC25-BT30-A=105	62425301055	62425301056	40	92	81	42	44	M18x1,5
DPC25-BT30-A=120	62425301205	62425301206	40	112	96	42	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-BT30-A=60	62426300605	62426300606	50	63	38	46	20	M22x1,5
DPC32-BT30-A=75	62426300755	62426300756	50	80	53	46	23	M22x1,5
DPC32-BT30-A=90	62426300905	62426300906	50	90	68	46	30	M22x1,5
DPC32-BT30-A=105	62426301055	62426301056	50	90	78	46	28	M22x1,5

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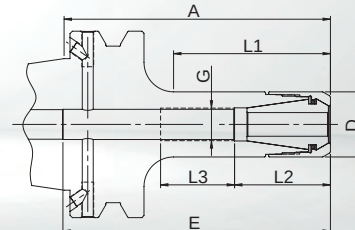
MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

BT40
MPC

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-BTB40-A=75	60541340755	---	16	25.000	105	38	19	20	M8x1
MPC11-BTB40-A=100	60541341005	---	16	25.000	130	63	19	30	M8x1
MPC11-BTB40-A=120	60541341205	---	16	25.000	150	83	19	20	M8x1
MPC11-BTB40-A=160	60541341605	---	16	25.000	180	123	19	28	M8x1
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-BTB40-A=75	60543340755	60543340756	22	25.000	110	38	32	25	M11x1
MPC16-BTB40-A=90	60543340905	60543340906	22	25.000	120	53	32	25	M11x1
MPC16-BTB40-A=120	60543341205	60543341206	22	25.000	105	83	32	25	M11x1
MPC16-BTB40-A=150	60543341505	60543341506	22	25.000	170	113	32	25	M11x1

Suitable Accessories

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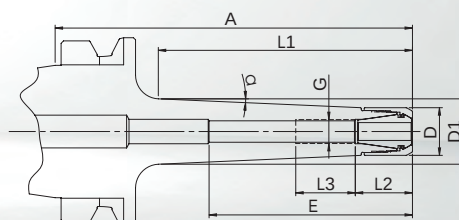
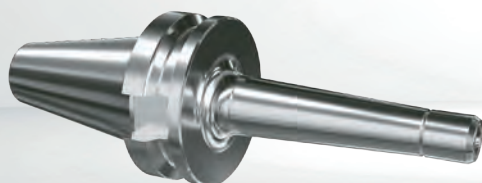
BT40 MPC

MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm

- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-BT40-A=100	60441331005	---	16	25.000	130	20	2,5°	63	19	30	M8x1
MPC11C-BT40-A=120	60441331205	---	16	25.000	150	22	2,5°	85	19	30	M8x1
MPC11C-BT40-A=160	60441331605	---	16	25.000	170	26	2,5°	125	19	30	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-BT40-A=100	60443331005	60443331006	22	25.000	130	26	2,5°	68	32	35	M11x1
MPC16C-BT40-A=120	60443331205	60443331206	22	25.000	150	28	2,5°	88	32	35	M11x1
MPC16C-BT40-A=160	60443331605	60443331606	22	25.000	180	31,5	2,5°	128	32	35	M11x1

Suitable Accessories

Collets



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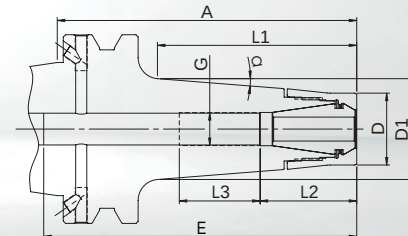
MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

BT40
MPC

Slim precision chuck for difficult cutting tasks and milling operations
Tapered design with tapered clamping nut for more stability and clamping force



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16T-BTB40-A=100	60543321005	60543321006	24	25.000	130	34	4,5°	68	32	27	M11x1
MPC16T-BTB40-A=135	60543321355	60543321356	24	25.000	165	39	4,5°	103	32	27	M11x1
MPC16T-BTB40-A=160	60543321605	60543321606	24	25.000	180	44	4,5°	128	32	27	M11x1

Suitable Accessories

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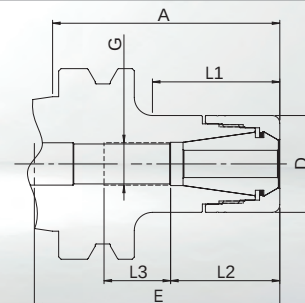
BT40 DPC

DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-BT40-A=75	62443300755	62443300756	30	100	38	32	25	M11x1
DPC16-BT40-A=90	62443300905	62443300906	30	120	53	32	25	M11x1
DPC16-BT40-A=105	62443301055	62443301056	30	130	68	32	30	M11x1
DPC16-BT40-A=120	62443301205	62443301206	30	150	83	32	30	M11x1
DPC16-BT40-A=150	62443301505	62443301506	30	180	113	32	30	M11x1
DPC16-BT40-A=165	62443301655	62443301656	30	190	127	32	30	M11x1
DPC16-BT40-A=200	62443302005	62443302006	30	220	162	32	30	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-BT40-A=75	62444300755	62444300756	32	95	42	36	20	M14x1
DPC20-BT40-A=90	62444300905	62444300906	32	110	57	36	22	M14x1
DPC20-BT40-A=105	62444301055	62444301056	32	125	72	36	22	M14x1
DPC20-BT40-A=120	62444301205	62444301206	32	135	87	36	22	M14x1
DPC20-BT40-A=150	62444301505	62444301506	32	165	117	36	46	M14x1
DPC20-BT40-A=165	62444301655	62444301656	32	180	132	36	22	M14x1

For other DPC chucks with BT40, see following page.

Suitable Accessories

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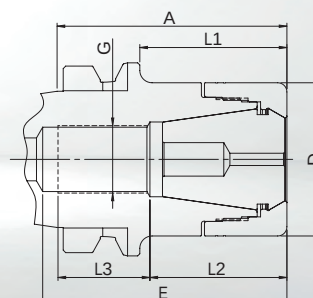
DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

BT40
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm

- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-BT40-A=60	62445300605	62445300606	40	82	28	42	35	M18x1,5
DPC25-BT40-A=75	62445300755	62445300756	40	90	43	42	35	M18x1,5
DPC25-BT40-A=90	62445300905	62445300906	40	95	58	42	35	M18x1,5
DPC25-BT40-A=105	62445301055	62445301056	40	95	73	42	35	M18x1,5
DPC25-BT40-A=120	62445301205	62445301206	40	100	88	42	35	M18x1,5
DPC25-BT40-A=150	62445301505	62445301506	40	125	118	42	35	M18x1,5
DPC25-BT40-A=165	62445301655	62445301656	40	190	133	42	35	M18x1,5
DPC25-BT40-A=200	62445302005	62445302006	40	220	168	42	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-BT40-A=60	62446300605	62446300606	50	80	29	45	30	M22x1,5
DPC32-BT40-A=75	62446300755	62446300756	50	98	44	45	45	M22x1,5
DPC32-BT40-A=90	62446300905	62446300906	50	98	59	45	45	M22x1,5
DPC32-BT40-A=105	62446301055	62446301056	50	125	74	45	45	M22x1,5
DPC32-BT40-A=120	62446301205	62446301206	50	110	89	45	45	M22x1,5
DPC32-BT40-A=150	62446301505	62446301506	50	140	119	45	45	M22x1,5
DPC32-BT40-A=165	62446301655	62446301656	50	150	134	45	45	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-BT40-A=75	62447300755	---	63	85	48	56	21	M28x1,5
DPC40-BT40-A=105	62447301055	---	63	90	78	56	30	M28x1,5

Suitable Accessories

Collets



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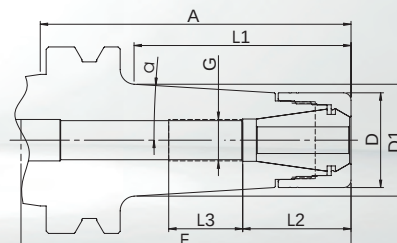
BT40 DPC

DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Stable precision chuck for demanding tasks, especially in HDC milling
Tapered design for better damping and higher stability



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 μm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 μm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16										
DPC16C-BT40-A=75	62443310755	62443310756	30	80	31,5	4,5°	33,5	32	25	M11x1
DPC16C-BT40-A=105	62443311055	62443311056	30	110	34,5	3,5°	63,5	32	25	M11x1
DPC16C-BT40-A=135	62443311355	62443311356	30	130	36	2,5°	93	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20										
DPC20C-BT40-A=75	62444310755	62444310756	32	80	34	4,5°	38	36	25	M14x1
DPC20C-BT40-A=105	62444311055	62444311056	32	110	37	3,5°	68	36	25	M14x1
DPC20C-BT40-A=135	62444311355	62444311356	32	140	38,5	2,5°	98	36	25	M14x1
Clamping range Ø 1-16 mm - Collets GERC25										
DPC25C-BT40-A=75	62445310755	62445310756	40	90	41,5	4,5°	38	43	35	M18x1,5
DPC25C-BT40-A=105	62445311055	62445311056	40	100	45	3,5°	68	43	35	M18x1,5
DPC25C-BT40-A=135	62445311355	62445311356	40	124	46	2,5°	98	43	35	M18x1,5

Suitable Accessories

Collets



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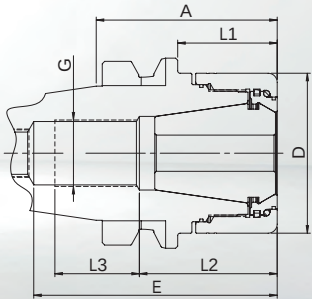
UPC ULTRA POWER CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

BT40
UPC

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Cylindrical design with a multi-part clamping nut for optimised damping and maximum stability



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
UPC32-BT40-A=60	66446300605	53	80	32	45	28	M22x1,5
UPC32-BT40-A=90	66446300905	53	85	63	45	28	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
UPC40-BT40-A=60	66447300605	63	84	47	56	21	M28x1,5
UPC40-BT40-A=90	66447300905	63	87	62	56	23	M28x1,5

Note about UPC40: For longer A dimensions A=75 and A=105, see FPC page 96.

Suitable Accessories

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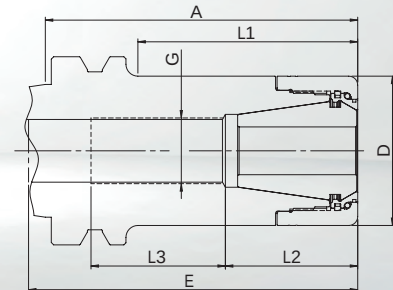
BT40 FPC

FPC FULL PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-BT40-A=60	62446300609	50	80	29	45	30	M22x1,5
FPC32-BT40-A=75	62446300759	50	98	44	45	45	M22x1,5
FPC32-BT40-A=90	62446300909	50	98	59	45	45	M22x1,5
FPC32-BT40-A=105	62446301059	50	125	74	45	45	M22x1,5
FPC32-BT40-A=120	62446301209	50	110	89	45	45	M22x1,5
FPC32-BT40-A=150	62446301509	50	140	119	45	45	M22x1,5
FPC32-BT40-A=165	62446301659	50	150	134	45	45	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-BT40-A=75	62447300759	63	85	48	56	21	M28x1,5
FPC40-BT40-A=105	62447301059	63	90	78	56	30	M28x1,5

Suitable Accessories

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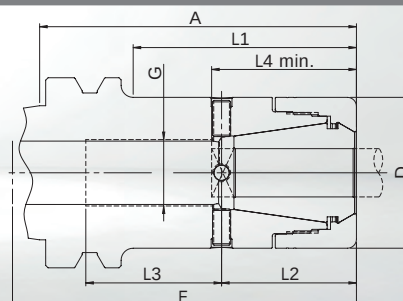
AFC ADJUSTABLE FINISHING CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

BT40
AFC

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-BT40-A=105	62445305235	40	95	73	42	35	M18x1,5
11-13	10,1-13,5	43	AFC25-BT40-A=105	62445305245	40	95	73	42	35	M18x1,5
14-16	13,51-16	43	AFC25-BT40-A=105	62445305265	40	95	73	42	35	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-BT40-A=105	62446305245	50	91	78	56	30	M22x1,5
14-20	13,51-20	47	AFC32-BT40-A=105	62446305265	50	91	78	56	30	M22x1,5
Collets GERC40										
7-15	7-15,5	55	AFC40-BT40-A=105	62447305245	63	90	78	56	30	M28x1,5
16-26	15,51-26	55	AFC40-BT40-A=105	62447305265	63	90	78	56	30	M28x1,5

Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø.
Other versions and clamping Ø can be offered after technical examination.

Suitable Accessories

Collets



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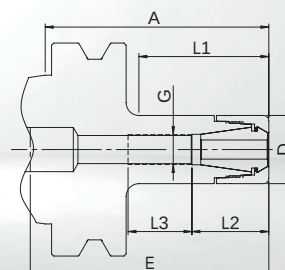
BT50 DPC

DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min

- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of $\leq 10 \mu\text{m}$ with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-BT50-A=105	62463301055	62463301056	30	150	55	31	24	M11x1
DPC16-BT50-A=135	62463301355	62463301356	30	180	85	31	24	M11x1
DPC16-BT50-A=165	62463301655	62463301656	30	200	115	31	41	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-BT50-A=105	62464301055	62464301056	32	140	61	36	46	M14x1
DPC20-BT50-A=135	62464301355	62464301356	32	170	91	36	46	M14x1
DPC20-BT50-A=165	62464301655	62464301656	32	200	121	36	46	M14x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-BT50-A=105	62465301055	62465301056	40	150	59	42	36	M18x1,5
DPC25-BT50-A=135	62465301355	62465301356	40	180	89	42	36	M18x1,5
DPC25-BT50-A=165	62465301655	62465301656	40	210	122	42	36	M18x1,5

For other DPC chucks with BT50, see following page.

Suitable Accessories

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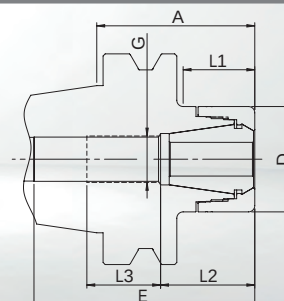
DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

BT50
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min

- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of $\leq 10 \mu\text{m}$ with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-BT50-A=75	62466300755	62466300756	50	120	34	45	35	M22x1,5
DPC32-BT50-A=105	62466301055	62466301056	50	150	64	45	35	M22x1,5
DPC32-BT50-A=135	62466301355	62466301356	50	180	94	45	35	M22x1,5
DPC32-BT50-A=165	62466301655	62466301656	50	210	124	45	40	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-BT50-A=75	62467300755	---	63	90	32	56	30	M28x1,5
DPC40-BT50-A=105	62467301055	---	63	90	62	56	30	M28x1,5
DPC40-BT50-A=135	62467301355	---	63	90	93	56	35	M28x1,5
DPC40-BT50-A=165	62467301655	---	63	90	123	56	35	M28x1,5

Suitable Accessories

Collets



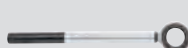
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Clamping Nuts



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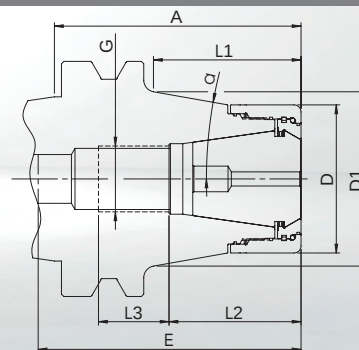
BT50 UPC

UPC ULTRA POWER CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Tapered design with a multi-part clamping nut for optimised damping and maximum stability



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32									
UPC32C-BT50-A=75	66466310755	53	114	55	10°	33	45	45	M22x1,5
UPC32C-BT50-A=105	66466311055	53	140	65	10°	62	45	45	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40									
UPC40C-BT50-A=75	66467310755	63	95	64	10°	32,5	56	30	M28x1,5
UPC40C-BT50-A=105	66467311055	63	95	74,5	10°	62	56	30	M28x1,5

Note about UPC40: For longer A dimensions in cylindrical form A=130 and A=160, see FPC page 101.

Suitable Accessories

Collets



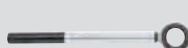
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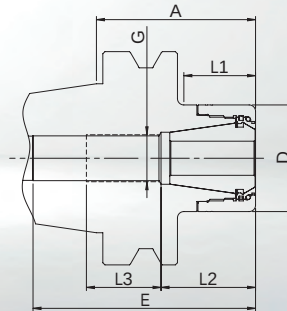
FPC FULL PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

BT50
FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-BT50-A=75	62466300759	50	120	34	45	35	M22x1,5
FPC32-BT50-A=105	62466301059	50	150	64	45	35	M22x1,5
FPC32-BT50-A=135	62466301359	50	180	94	45	35	M22x1,5
FPC32-BT50-A=165	62466301659	50	210	124	45	40	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-BT50-A=75	62467300759	63	90	32	56	30	M28x1,5
FPC40-BT50-A=105	62467301059	63	90	62	56	30	M28x1,5
FPC40-BT50-A=135	62467301359	63	90	93	56	35	M28x1,5
FPC40-BT50-A=165	62467301659	63	90	123	56	35	M28x1,5

Suitable Accessories

Collets



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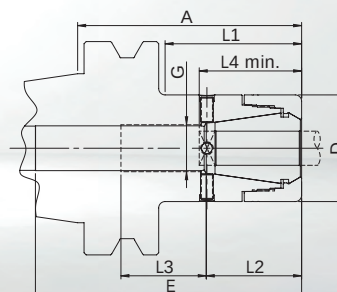
BT50 AFC

AFC ADJUSTABLE FINISHING CHUCKS

JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-BT50-A=105	62465305235	40	150	59	42	36	M18x1,5
11-13	10,1-13,5	43	AFC25-BT50-A=105	62465305245	40	150	59	42	36	M18x1,5
14-16	13,51-16	43	AFC25-BT50-A=105	62465305265	40	150	59	42	36	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-BT50-A=105	62466305245	50	150	64	45	35	M22x1,5
14-20	13,51-20	47	AFC32-BT50-A=105	62466305265	50	150	64	45	35	M22x1,5
Collets GERC40										
7-15	7-15,5	55	AFC40-BT50-A=105	62467305245	63	90	62	56	30	M28x1,5
16-26	15,51-26	55	AFC40-BT50-A=105	62467305265	63	90	62	56	30	M28x1,5

Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø.
Other versions and clamping Ø can be offered after technical examination.

Suitable Accessories

Collets



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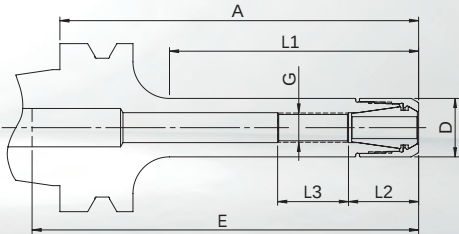
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MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT
FORM AD - CENTRAL COOLANT SUPPLY

BTP30
MPC

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11								
MPC11-BTP30-A=60	60431340605	16	25.000	70	29	19	20	M8x1
MPC11-BTP30-A=90	60431340905	16	25.000	100	59	19	20	M8x1
MPC11-BTP30-A=105	60431341055	16	25.000	115	74	19	20	M8x1

Suitable Accessories

Collets



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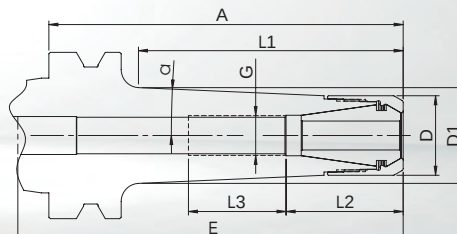
BTP30 MPC

MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm

- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-BTP30-A=100	60431331005	---	16	25.000	100	32,5	2,5°	73	19	40	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-BTP30-A=100	60433331005	60433331006	22	25.000	110	30	2,5°	73	32	40	M11x1

Suitable Accessories

Collets



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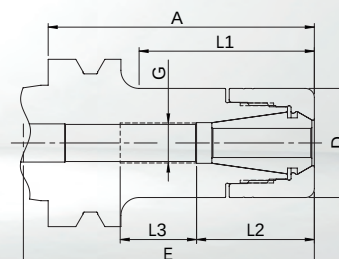
DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

BTP30
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of $\leq 10 \mu\text{m}$ with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-BTP30-A=60	62433300605	62433300606	30	75	34	32	21	M11x1
DPC16-BTP30-A=75	62433300755	62433300756	30	90	49	32	21	M11x1
DPC16-BTP30-A=90	62433300905	62433300906	30	105	64	32	21	M11x1
DPC16-BTP30-A=105	62433301055	62433301056	30	120	79	32	21	M11x1
DPC16-BTP30-A=120	62433301205	62433301206	30	130	94	32	21	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-BTP30-A=60	62434300605	62434300606	32	65	36,5	36	22	M14x1
DPC20-BTP30-A=75	62434300755	62434300756	32	65	51,5	36	22	M14x1
DPC20-BTP30-A=90	62434300905	62434300906	32	81	66,5	36	22	M14x1
DPC20-BTP30-A=105	62434301055	62434301056	32	96	81,5	36	22	M14x1
DPC20-BTP30-A=120	62434301205	62434301206	32	111	96,5	36	22	M14x1

For other DPC chucks with BTP30, see following page.

Suitable Accessories

Collets



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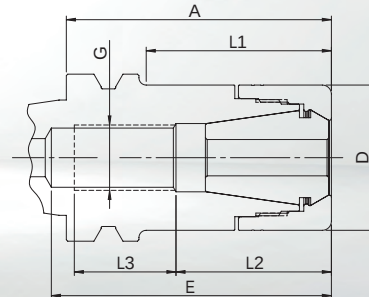
BTP30 DPC

DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-BTP30-A=60	62435300605	62435300606	40	76	37	42	28	M18x1,5
DPC25-BTP30-A=75	62435300755	62435300756	40	77	52	42	28	M18x1,5
DPC25-BTP30-A=90	62435300905	62435300906	40	88	67	42	28	M18x1,5
DPC25-BTP30-A=105	62435301055	62435301056	40	98	81	42	28	M18x1,5
DPC25-BTP30-A=120	62435301205	62435301206	40	110	97	42	28	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-BTP30-A=60	62436300605	62436300606	50	70	39	46	20	M22x1,5
DPC32-BTP30-A=75	62436300755	62436300756	50	78	54	46	25	M22x1,5
DPC32-BTP30-A=90	62436300905	62436300906	50	90	69	46	32	M22x1,5
DPC32-BTP30-A=105	62436301055	62436301056	50	95	84	46	32	M22x1,5

Suitable Accessories

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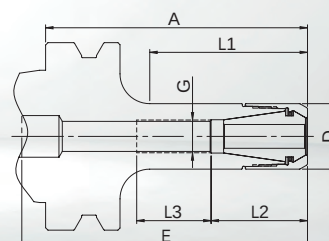
MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

BTP40
MPC

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm

- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-BTP40-A=90	60451340905	---	16	25.000	100	54	19	20	M8x1
MPC11-BTP40-A=120	60451341205	---	16	25.000	140	84	19	20	M8x1
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-BTP40-A=90	60453340905	60453340906	22	25.000	110	54	32	25	M11x1
MPC16-BTP40-A=120	60453341205	60453341206	22	25.000	140	84	32	25	M11x1

Suitable Accessories

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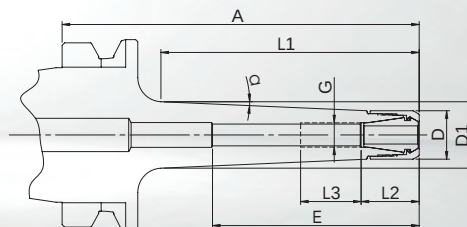
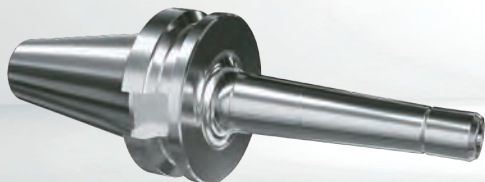
BTP40 MPC

MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-BTP40-A=100	60451331005	---	16	25.000	110	20	2,5°	65	19	20	M8x1
MPC11C-BTP40-A=120	60451331205	---	16	25.000	140	21,5	2,5°	85	19	20	M8x1
MPC11C-BTP40-A=160	60451331605	---	16	25.000	170	25,5	2,5°	125	19	20	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-BTP40-A=100	60453331005	60453331006	22	25.000	125	30,5	2,5°	67	32	27	M11x1
MPC16C-BTP40-A=120	60453331205	60453331206	22	25.000	140	32,5	2,5°	87	32	27	M11x1
MPC16C-BTP40-A=160	60453331605	60453331606	22	25.000	170	36	2,5°	127	32	27	M11x1

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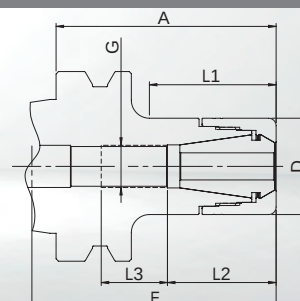
DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

BTP40
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm

- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-BTP40-A=75	62453300755	62453300756	30	100	39	32	20	M11x1
DPC16-BTP40-A=90	62453300905	62453300906	30	115	54	32	25	M11x1
DPC16-BTP40-A=105	62453301055	62453301056	30	130	69	32	25	M11x1
DPC16-BTP40-A=120	62453301205	62453301206	30	145	84	32	25	M11x1
DPC16-BTP40-A=150	62453301505	62453301506	30	175	114	32	25	M11x1
DPC16-BTP40-A=165	62453301655	62453301656	30	190	129	32	25	M11x1
DPC16-BTP40-A=200	62453302005	62453302006	30	225	164	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-BTP40-A=75	62454300755	62454300756	32	95	46,5	46	25	M14x1
DPC20-BTP40-A=90	62454300905	62454300906	32	110	61,5	43	25	M14x1
DPC20-BTP40-A=105	62454301055	62454301056	32	125	76,5	43	25	M14x1
DPC20-BTP40-A=120	62454301205	62454301206	32	135	91,5	43	25	M14x1
DPC20-BTP40-A=150	62454301505	62454301506	32	165	121,5	43	25	M14x1
DPC20-BTP40-A=165	62454301655	62454301656	32	180	136,5	43	25	M14x1

For other DPC chucks with BTP40, see following page.

Suitable Accessories

Collets



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Clamping Nuts



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Wrenches



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Mounting Devices



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Adjustable
Stop Screws



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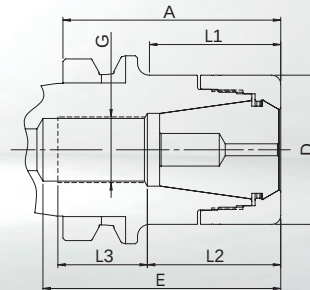
BTP40 DPC

DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-BTP40-A=60	62455300605	62455300606	40	83	29	43	35	M18x1,5
DPC25-BTP40-A=75	62455300755	62455300756	40	84	44	43	35	M18x1,5
DPC25-BTP40-A=90	62455300905	62455300906	40	84	59	43	35	M18x1,5
DPC25-BTP40-A=105	62455301055	62455301056	40	98	74	43	35	M18x1,5
DPC25-BTP40-A=120	62455301205	62455301206	40	113	89	43	35	M18x1,5
DPC25-BTP40-A=150	62455301505	62455301506	40	144	119	43	35	M18x1,5
DPC25-BTP40-A=165	62455301655	62455301656	40	158	134	43	35	M18x1,5
DPC25-BTP40-A=200	62455302005	62455302006	40	190	159	43	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-BTP40-A=60	62456300605	62456300606	50	80	30	45	30	M22x1,5
DPC32-BTP40-A=75	62456300755	62456300756	50	80	45	45	30	M22x1,5
DPC32-BTP40-A=90	62456300905	62456300906	50	95	60	45	40	M22x1,5
DPC32-BTP40-A=105	62456301055	62456301056	50	100	75	45	40	M22x1,5
DPC32-BTP40-A=120	62456301205	62456301206	50	110	89,5	45	40	M22x1,5
DPC32-BTP40-A=150	62456301505	62456301506	50	140	119,5	45	40	M22x1,5
DPC32-BTP40-A=165	62456301655	62456301656	50	140	134,5	45	40	M22x1,5

Suitable Accessories

Collets



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Clamping Nuts



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Wrenches



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Mounting Devices



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Adjustable
Stop Screws



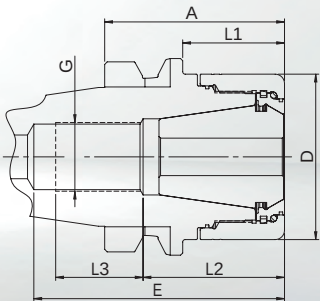
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UPC ULTRA POWER CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT
 FORM AD - CENTRAL COOLANT SUPPLY

BTP40
 UPC

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
 Cylindrical design with a multi-part clamping nut for optimised damping and maximum stability



- **Chuck body and clamping nut separately balanced**
 G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3\text{ }\mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
UPC32-BTP40-A=60	66456300605	53	80	33	45	28	M22x1,5
UPC32-BTP40-A=90	64456300905	53	95	63	45	30	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
UPC40-BTP40-A=60	66457300605	63	81	31	---	---	---
UPC40-BTP40-A=90	66457300905	63	86	61	56	25	M28x1,5

Suitable Accessories

Collets



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Clamping Nuts



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Wrenches



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Mounting Devices



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Adjustable
 Stop Screws



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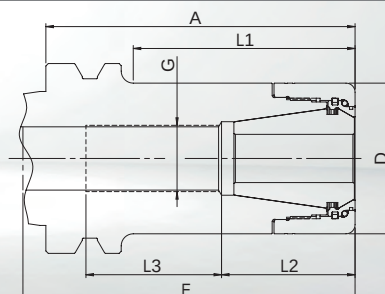
BTP40 FPC

FPC FULL PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-BTP40-A=60	62456300609	50	80	30	45	30	M22x1,5
FPC32-BTP40-A=75	62456300759	50	80	45	45	30	M22x1,5
FPC32-BTP40-A=90	62456300909	50	95	60	45	40	M22x1,5
FPC32-BTP40-A=105	62456301059	50	100	75	45	40	M22x1,5
FPC32-BTP40-A=120	62456301209	50	110	89,5	45	40	M22x1,5
FPC32-BTP40-A=150	62456301509	50	140	119,5	45	40	M22x1,5
FPC32-BTP40-A=165	62456301659	50	140	134,5	45	40	M22x1,5

Suitable Accessories

Collets



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Adjustable Stop Screws



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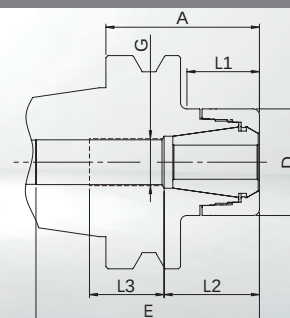
DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

BTP50
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min

- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of $\leq 10 \mu\text{m}$ with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-BTP50-A=105	62473301055	62473301056	30	150	56,5	31	22	M11x1
DPC16-BTP50-A=135	62473301355	62473301356	30	180	86,5	31	22	M11x1
DPC16-BTP50-A=165	62473301655	62473301656	30	210	116,5	31	41	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-BTP50-A=105	62474301055	62474301056	32	150	61	36	46	M14x1
DPC20-BTP50-A=135	62474301355	62474301356	32	180	91	36	46	M14x1
DPC20-BTP50-A=165	62474301655	62474301656	32	210	121	36	46	M14x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-BTP50-A=105	62475301055	62475301056	40	150	60,5	43	36	M18x1,5
DPC25-BTP50-A=135	62475301355	62475301356	40	180	90,5	43	36	M18x1,5
DPC25-BTP50-A=165	62475301655	62475301656	40	200	120,5	43	36	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-BTP50-A=75	62476300755	62476300756	50	120	34	45	35	M22x1,5
DPC32-BTP50-A=105	62476301055	62476301056	50	135	65,5	45	35	M22x1,5
DPC32-BTP50-A=135	62476301355	62476301356	50	165	95,5	45	35	M22x1,5
DPC32-BTP50-A=165	62476301655	62476301656	50	195	125,5	45	35	M22x1,5

Suitable Accessories

Collets



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Clamping Nuts



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Wrenches



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Adjustable
Stop Screws



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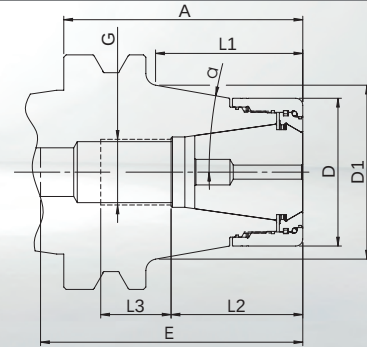
BTP50 UPC

UPC ULTRA POWER CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Tapered design with a multi-part clamping nut for optimised damping and maximum stability



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32									
UPC32C-BTP50-A=75	66476310755	53	114	55,2	10°	34	46	45	M22x1,5
UPC32C-BTP50-A=105	66476311055	53	144	65,5	10°	64	46	45	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40									
UPC40C-BTP50-A=75	66477310755	63	91	64,2	10°	34	55	30	M28x1,5
UPC40C-BTP50-A=105	66477311055	63	101	74,5	10°	64	55	30	M28x1,5

Note about UPC32: For longer A dimensions in cylindrical form A=135 and A=165, see FPC page 115.

Suitable Accessories

Collets



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Clamping Nuts



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Mounting Devices



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Adjustable Stop Screws



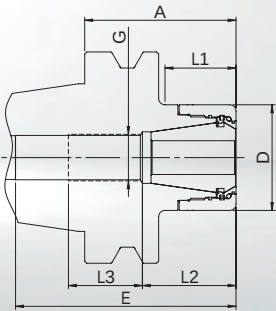
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FPC FULL PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT
FORM AD - CENTRAL COOLANT SUPPLY

BTP50
FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3\text{ }\mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-BTP50-A=75	62476300759	50	120	34	45	35	M22x1,5
FPC32-BTP50-A=105	62476301059	50	135	65,5	45	35	M22x1,5
FPC32-BTP50-A=135	62476301359	50	165	95,5	45	35	M22x1,5
FPC32-BTP50-A=165	62476301659	50	195	125,5	45	35	M22x1,5

Suitable Accessories

Collets



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Clamping Nuts



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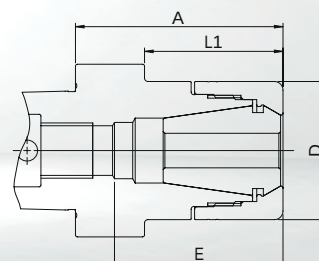
PSC50 DPC

DPC DYNAMIC PERFORMANCE CHUCKS

ISO 26623-1

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-C5-A=60	62853300605	62853300606	30	46	39	32	13	M11x1
DPC16-C5-A=100	62853301005	62853301006	30	86	79	32	30	M11x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-C5-A=60	62855300605	62855300606	40	49	39	---	---	---
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-C5-A=60	62856300605	62856300606	50	50	27,5	---	---	---

PSC

Suitable Accessories

Collets



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Clamping Nuts



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Adjustable
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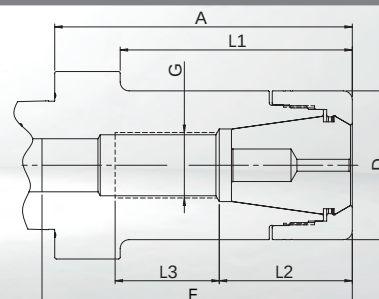
DPC DYNAMIC PERFORMANCE CHUCKS

ISO 26623-1

FORM AD - CENTRAL COOLANT SUPPLY

PSC63
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G_{2,5} at 25.000 1/min or U ≤ 1 gmm

- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clam- ping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-C6-A=60	62863300605	62863300606	30	56	33	---	---	---
DPC16-C6-A=100	62863301005	62863301006	30	90	73	32	30	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-C6-A=60	62864300605	62864300606	32	56	37	---	---	---
DPC20-C6-A=100	62864301005	62864301006	32	80	77	36	35	M14x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-C6-A=60	62865300605	62865300606	40	56	35	---	---	---
DPC25-C6-A=100	62865301005	62865301006	40	83	75	43	35	M18x1,5
DPC25-C6-A=130	62865301305	62865301306	40	125	105	43	35	M18x1,5
DPC25-C6-A=160	62865301605	62865301606	40	140	135	43	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-C6-A=60	62866300605	62866300606	50	56	35	---	---	---
DPC32-C6-A=100	62866301005	62866301006	50	84	75	44	35	M22x1,5
DPC32-C6-A=130	62866301305	62866301306	50	98	104	44	30	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-C6-A=65	62867300655	---	63	57	42	---	---	---
DPC40-C6-A=100	62867301005	---	63	87	77	54	25	M28x1,5

Suitable Accessories

Collets



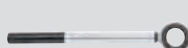
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Clamping Nuts



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Wrenches



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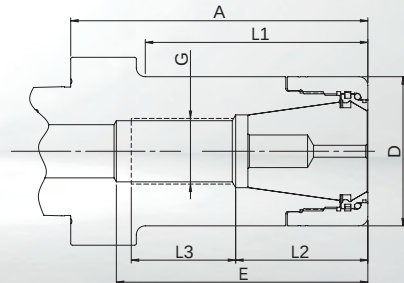
PSC63 FPC

FPC FULL PERFORMANCE CHUCKS

ISO 26623-1

FORM AD - CENTRAL COOLANT SUPPLY

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-C6-A=60	62866300609	50	56	35	---	---	---
FPC32-C6-A=100	62866301009	50	84	75	44	35	M22x1,5
FPC32-C6-A=130	62866301309	50	98	104	44	30	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-C6-A=65	62867300659	63	57	42	---	---	---
FPC40-C6-A=100	62867301009	63	87	77	54	25	M28x1,5

PSC

Suitable Accessories

Collets



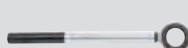
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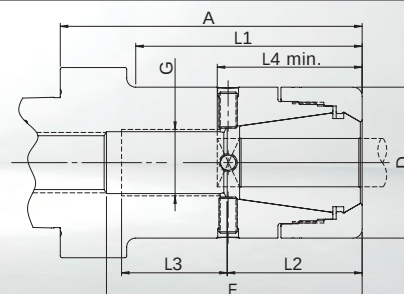
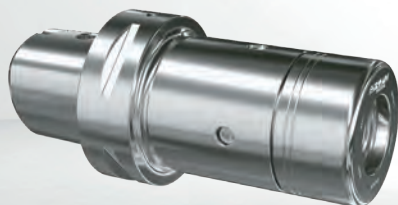
AFC ADJUSTABLE FINISHING CHUCKS

ISO 26623-1

FORM AD - CENTRAL COOLANT SUPPLY

PSC63
AFC

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-C6-A=100	62865305235	40	83	75	43	35	M18x1,5
10,5-13,5	10,1-13,5	43	AFC25-C6-A=100	62865305245	40	83	75	43	35	M18x1,5
14-16	13,51-16	43	AFC25-C6-A=100	62865305265	40	83	75	43	35	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-C6-A=100	62866305245	50	84	75	44	35	M22x1,5
14-20	13,51-20	47	AFC32-C6-A=100	62866305265	50	84	75	44	35	M22x1,5
Collets GERC40										
7-15	7-15,5	55	AFC40-C6-A=100	62867305245	63	87	77	54	25	M28x1,5
16-26	15,51-26	55	AFC40-C6-A=100	62867305265	63	87	77	54	25	M28x1,5

Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø. Other versions and clamping Ø can be offered after technical examination.

Suitable Accessories

Collets



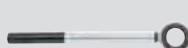
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Clamping Nuts



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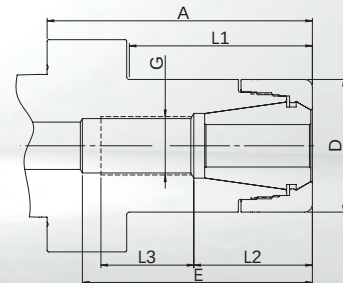
PSC80 DPC

DPC DYNAMIC PERFORMANCE CHUCKS

ISO 26623-1

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours



- **Chuck body and clamping nut separately balanced**
G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of ≤ 3 µm with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-C8-A=100	62885301005	62885301006	40	90	67	43	30	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-C8-A=100	62886301005	62886301006	50	87	69	45	35	M22x1,5

PSC

Suitable Accessories

Collets



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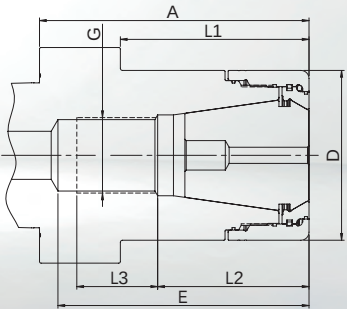
UPC ULTRA POWER CHUCKS

ISO 26623-1

FORM AD - CENTRAL COOLANT SUPPLY

PSC80
UPC

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Cylindrical design with a multi-part clamping nut for optimised damping and maximum stability



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
UPC32-C8-A=100	66886301005	53	85	70	45	35	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
UPC40-C8-A=100	66887301005	63	93	70	56	30	M28x1,5

PSC

Suitable Accessories

Collets



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Clamping Nuts



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Wrenches



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Mounting Devices



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Adjustable
Stop Screws



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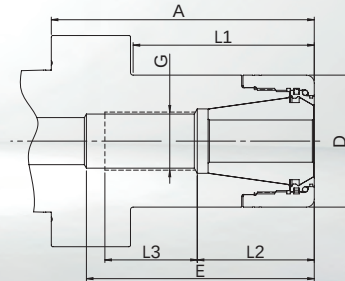
PSC80 FPC

FPC FULL PERFORMANCE CHUCKS

ISO 26623-1

FORM AD - CENTRAL COOLANT SUPPLY

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load



- **Chuck body and clamping nut separately balanced**
G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-C8-A=100	62886301009	50	87	69	45	35	M22x1,5

PSC

Suitable Accessories

Collets



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Clamping Nuts



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Wrenches



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Mounting Devices



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Adjustable
Stop Screws



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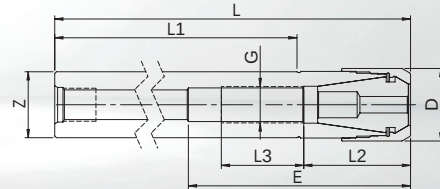
MPC MINI PRECISION TOOL EXTENSIONS

CYLINDRICAL SHANK

FORM AD - CENTRAL COOLANT SUPPLY

CYL
MPC

Slim extensions with optimum interference contour for deep immersion in tight spaces
Variable lengths possible due to different insertion depths in DPC or UPC chucks

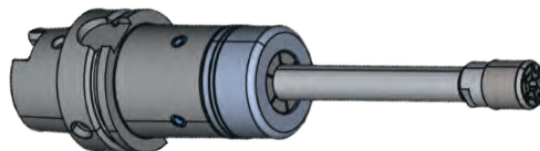


• **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

• **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of $\leq 10 \mu\text{m}$ with GERC-B collets. Not suitable for sealed collets.

Description + L	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	Z	E	L1	L2	L3	G
Clamping range Ø 1-5 mm - Collets GERC8									
MPC8-Z10-L=80	60010340805	---	10	10	16	48	---	---	---
MPC8-Z10-L=150	60010341505	---	10	10	16	138	17	15	M5x0,8
MPC8-Z10-L=200	60010342005	---	10	10	16	188	17	15	M5x0,8
MPC8-Z12-L=120	60020341205	---	10	12	16	88	---	---	---
MPC8-Z12-L=160	60020341605	---	10	12	16	148	---	---	---
MPC8-Z12-L=200	60020342005	---	10	12	16	188	---	---	---
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-Z16-L=150	60031341505	---	16	16	68	133	20	25	M8x1
MPC11-Z16-L=200	60031342005	---	16	16	68	183	20	25	M8x1
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-Z16-L=150	60033341505	60033341506	22	16	68	117	32	25	M11x1
MPC16-Z16-L=200	60033342005	60033342006	22	16	68	167	32	25	M11x1
MPC16-Z20-L=150	60043341505	60043341506	22	20	68	117	32	25	M11x1
MPC16-Z20-L=200	60043342005	60043342006	22	20	68	167	32	25	M11x1

Optimal run-out for MPC Tool Extensions
can be achieved when combined with
the AFC Adjustable Chucks



Suitable Accessories

Collets



Page 134ff

Clamping Nuts



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Wrenches



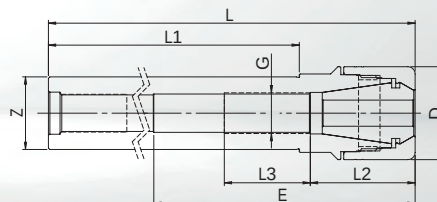
Page 160

Adjustable
Stop Screws



Page 165

Slim extensions with optimum interference contour for deep immersion in tight spaces
Variable lengths possible due to different insertion depths in DPC or UPC chucks

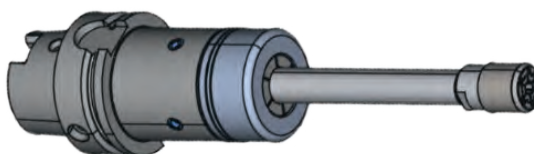


- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of $\leq 10 \mu\text{m}$ with GERC-B collets. Not suitable for sealed collets.

Description + L	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	Z	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16									
DPC16-Z20-L=150	62043301505	62043301506	30	20	70	113	32	25	M11x1
DPC16-Z20-L=250	62043302505	62043302506	30	20	70	213	32	25	M11x1
DPC16-Z20-L=350	62043303505	62043303506	30	20	70	313	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20									
DPC20-Z25-L=150	62054301505	62054301506	32	25	70	110	36	30	M14x1
DPC20-Z25-L=250	62054302505	62054302506	32	25	70	210	36	30	M14x1
DPC20-Z25-L=350	62054303505	62054303506	32	25	70	310	36	30	M14x1

Optimal run-out for DPC Tool Extensions
can be achieved when combined with
the AFC Adjustable Chucks



Suitable Accessories

Collets



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Clamping Nuts



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Wrenches



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Adjustable Stop Screws



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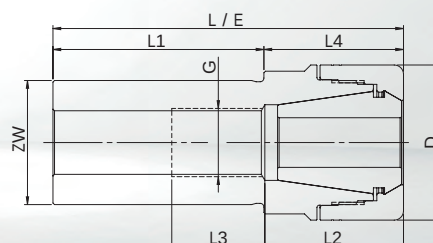
DPC DYNAMIC PERFORMANCE HOLDERS NC

CYLINDRICAL SHANK WITH FLAT

FORM AD - CENTRAL COOLANT SUPPLY

CYL
DPC

Variable collet chuck with high clamping force for drilling, threading and reaming
Version with stop flange for quick pre-setting for CNC lathe



• **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

• **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of $\leq 10 \mu\text{m}$ with GERC-B collets. Not suitable for sealed collets.

Description + L1	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	ZW	E	L	L2	L3	L4	G
Clamping range Ø 1-16 mm - Collets GERC25										
DPC25-ZW25-L1=54	62955300545	62955300546	40	25	99	99	42,8	30	45	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32										
DPC32-ZW32-L1=58	62966300585	62966300586	50	32	103	103	45	30	45	M22x1,5
DPC32-ZW40-L1=68	62976300685	62976300686	50	40	113	113	45	30	45	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40										
DPC40-ZW40-L1=68	62977300685	---	63	40	123	123	55	35	55	M28x1,5

The advantages of CENTRO|P on the lathe machine:

- Precision guaranteed when drilling and reaming.
- Never again risk of injury due to slipping during tool assembly in the machine.
- High straightness for deep bores (e.g. deep hole drilling).
- High clamping force secures the tool in the axial direction, preventing it from being pushed towards you.

CYL

Suitable Accessories

Collets



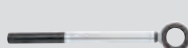
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Clamping Nuts



Page 162ff

Wrenches



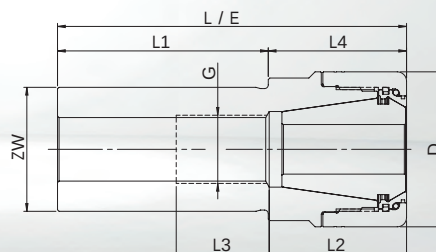
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Adjustable
Stop Screws



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Variable collet chuck with even higher clamping force for drilling, threading and reaming
Version with a multi-part clamping nut and stop flange for quick pre-setting for CNC lathe



- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of $\leq 3 \mu\text{m}$ with GERC-HP collets.

Description + L1	Order-No. incl. FPC clamping nut	D = Wrench Ø	ZW	E	L	L2	L3	L4	G
Clamping range Ø 2-20 mm - Collets GERC32									
FPC32-ZW32-L1=58	62966300589	50	32	103	103	45	30	45	M22x1,5
FPC32-ZW40-L1=68	62976300689	50	40	113	113	45	30	45	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40									
FPC40-ZW40-L1=68	62977300689	63	40	123	123	55	35	55	M28x1,5

The advantages of CENTRO|P on the lathe machine:

- $3 \mu\text{m}$ precision guaranteed when drilling and reaming.
- Never again risk of injury due to slipping during tool assembly in the machine.
- High straightness for deep bores (e.g. deep hole drilling).
- Increased holding force due to multi-part clamping nut.

Suitable Accessories

Collets



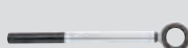
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Clamping Nuts



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Wrenches



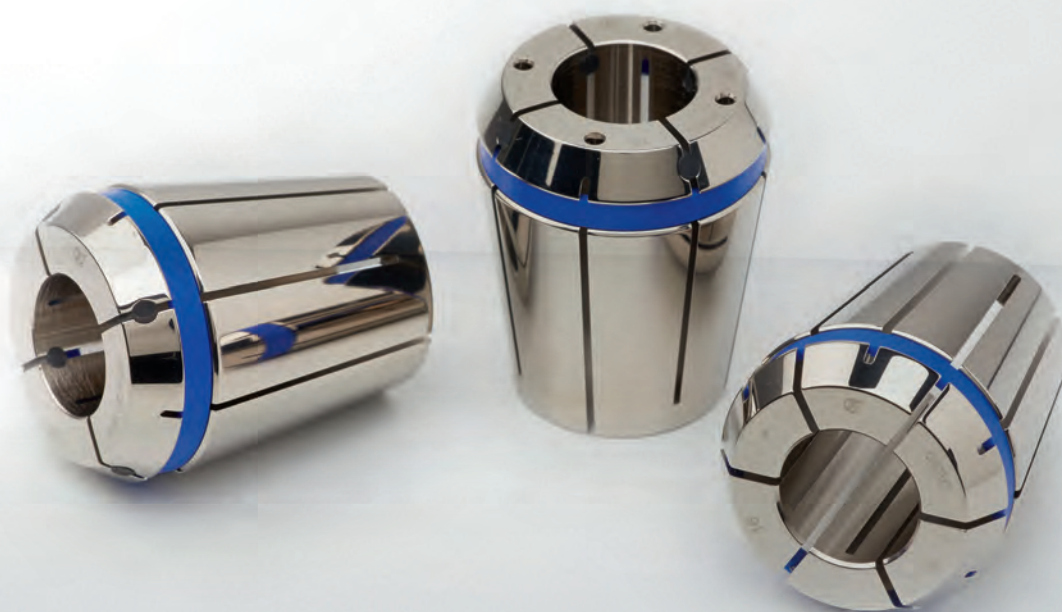
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Adjustable Stop Screws



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COLLETS



GERC – A CLASS OF ITS OWN



Rust on collets reduces the life of your tools and leads to significant losses in precision. That's why we have developed FAHRION|Protect. A ground-breaking technology that provides long term protection against corrosion.

- The nominal geometry between the collet and the taper seat in the chuck is maintained for long lasting and precision surface contact without corrosion-related irregularities
- Hold component tolerances even longer during manufacturing: the number of quality parts increases.
- You can keep production processes on a high level for longer, you save time which leads to reduced delivery time.
- A higher concentricity extends the service life of your tools. Thus, you save time and money by reducing set-up time.
- Collets have to be replaced less frequently or can be used longer for precision applications.



With and without FAHRION|Protect – after four months of normal use



This shows you the Performance and Characteristic of the FAHRION Collets



Advantages of FAHRION Collets DIN ISO 15488 - GERC-B and GERC-HP (ER/ESX)

Precise

FAHRION Collets DIN ISO 15488-B (ER/ESX) set the standard of concentricity and repeatability, which is $5\mu\text{m}$ for the types GERC11-B up to GERC40-B and $2\mu\text{m}$ for the types GERC11-HP up to GERC40-HP.

Rigid

12 slots are sufficient to reach the required collapse to DIN ISO 15488. This is possible because of special steel produced for us and a particular harmonised heat treatment. Compared to 16 slot collets, our collets have fewer tendencies to distort.

Saving

All edges are not only deburred, but additionally rounded, which is a prerequisite to protect the inner cone of the collet chuck from marks. This process is important to guarantee a consistent repeatable high level of accuracy.

Due to its super-finished design, FAHRION | Protect achieves increased holding power and rigidity, higher load-bearing capacity, higher system accuracy and higher corrosion resistance in GERC-B and GERC-HP

Powerful

The defined increased surface roughness of the clamping bore, combined with the optimised grinding pattern, ensure significantly higher retaining forces compared to standard collets.



Not only are the slots deburred on all sides, but the collets also have an average roughness depth of the R_z surface area = $1.6\mu\text{m}$

THE WEDGE COLLET GERC-W

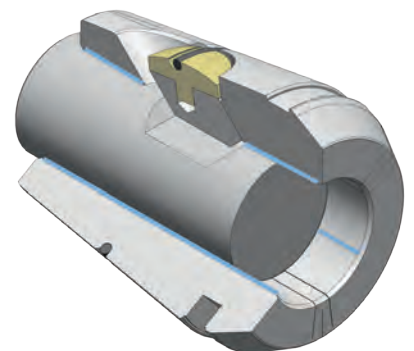
Uncompromising Safety During Milling



No more tool pull out or micro creeping - 100% guaranteed. The solution is as simple as it is ingenious. It is an integrated wedge that rests on the Weldon surface. The user can be certain that no costly damage from tool pull out will occur, even if the tool system is overloaded.

Higher Clamping Forces

When clamping, the wedge always lies against the slope of the Weldon surface and thus creates a positive lock without radially displacing the tool. The tool shank is clamped extensively on three lines, making it perfectly centered and allowing for larger clamping forces (with shank tolerances up to h9).

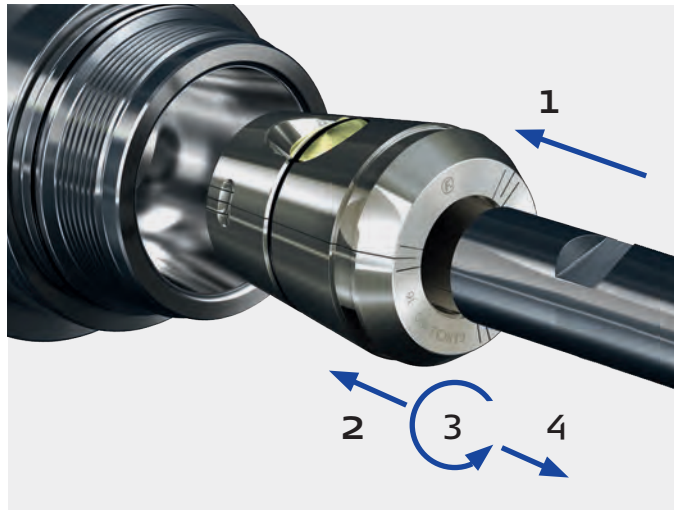


The three clamping lines on the tool (blue) centre the tool shank and generate impressive clamping forces as well as optimum concentricity.

Easy Handling

For assembly, you only have to insert the tool (1) until the wedge locks into place.

For disassembly, the tool is briefly inserted further (2), turned (3) and pulled out (4).



The pin pressure spring is locked in the receptor. The spring applies axial pressure on the tool to preload surface contact between the Weldon and locking wedge.



Optimal Damping

When using the **Wedge Collet GERC-W** together with the **UPC Ultra Power Chuck**, very good damping properties are achieved. The additional damping reduces vibrations which protects the spindle bearings.

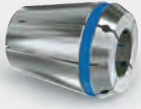
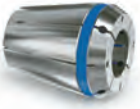
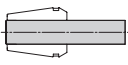
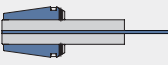
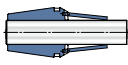
Higher Service Life

Better tool concentricity increases the service life of your tools. Your tool budget will thank you.

ABSOLUTELY TOP OF THE RANGE

The Features of Collets DIN ISO 15488 GERC-HP, GERC-HPD, GERC-HPDD, GERC-W



Shape/Use	GERC-HP	GERC-HPD	GERC-HPDD	GERC-W	GERC-WD
					
	Standard	Sealed	Sealed with Jet Holes	Pull-Out Protection	Sealed with Pull-Out Protection
					
Standard Collet Chuck	■	■	■	□	□
Precision Collet Chuck CENTRO P	■	■	■	■	■
Mini Precision Chuck MPC	■	■	■	□	□
Dynamic Power Chuck DPC	■	■	■	■	■
Ultra Power Chuck UPC	■	■	■	■	■
Full Performance Chucks FPC	■	■	■	■	■
Adjustable Finishing Chucks AFC	■	■	■	□	□
Concentricity, e.g. Ø 12.0 mm	2 µm	2 µm	2 µm	3 µm	3 µm
Repeatability	2 µm	2 µm	2 µm	3 µm	3 µm
Tool Shank Tolerance	h10	h8	h8	h8	h8
Through Tool Coolant	□	■	□	□	■

Use: ■ preferred ■ limited □ unusable

FLEXIBLE AND PRECISE

The Features of Collets DIN ISO 15488 GERC-B, GERC-BD, GERC-GBD, GERC-GBDD



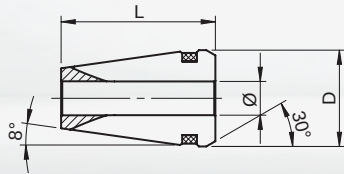
Shape/Use	GERC-B	GERC-BD	GERC-GBD	GERC-GBDD
	Standard	Sealed	Sealed for Taps	Sealed with Jet Holes for Taps
Standard Collet Chuck	■	■	■	■
Precision Collet Chuck CENTRO P	▣	▣	■	■
Mini Precision Chuck MPC	▣	▣	▣	▣
Dynamic Power Chuck DPC	▣	▣	■	■
Ultra Power Chuck UPC	▣	▣	■	■
Full Performance Chucks FPC	▣	▣	■	■
Adjustable Finishing Chucks AFC	□	□	□	□
Concentricity, e.g. Ø 12.0 mm	5 µm	5 µm	10 µm	10 µm
Repeatability	3 µm	3 µm	5 µm	5 µm
Tool Shank Tolerance	h10	h8	h8	h8
Through Tool Coolant	□	■	■	□

Use: ■ preferred ▣ limited □ unusable

GERC8 1-5 mm

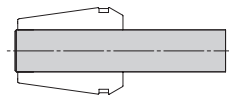
ACCESSORIES FOR CHUCKS MPC8

High Precision Collets 5 µm

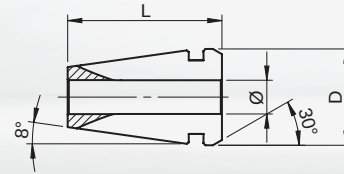


GERC8-HP Ø 1-5 mm

Standard

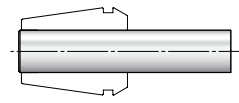


Precision Collets 10 µm



GERC8-B Ø 1-5 mm

Standard



☐ = 5 µm
D = 8,5
L = 13,6

☐ = 10 µm
D = 8,5
L = 13,6

Ø mm	Order-No.	Ø inch	Order-No.
1,0	13610010100	1/16"	13610040159
1,5	13610010150	1/8"	13610040318
2,0	13610010200	3/16"	13610040476
2,5	13610010250		
2,8	13610010280		
3,0	13610010300		
3,5	13610010350		
4,0	13610010400		
4,5	13610010450		
5,0	13610010500		

Ø mm	Order-No.	Ø inch	Order-No.
1,0	13710010100	1/16"	13710040159
1,5	13710010150	1/8"	13710040318
2,0	13710010200	3/16"	13710040476
2,5	13710010250		
3,0	13710010300		
3,5	13710010350		
4,0	13710010400		
4,5	13710010450		
5,0	13710010500		

GERC8-B Set

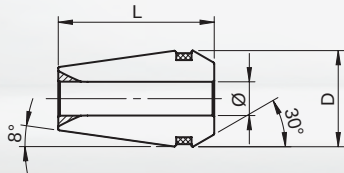
Content of set (Ø mm)	Order-No.	Set
1,0-5,0/ 0,5 Increments	1371016	9pieces

ACCESSORIES FOR CHUCKS

MPC11

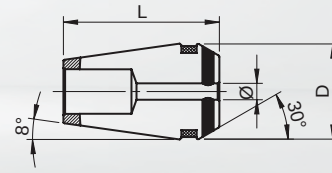
GERC11
1-7 mm

High Precision Collets 2 µm



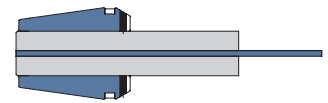
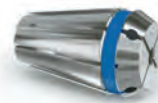
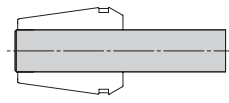
GERC11-**HP** Ø 1-7 mm

Standard



GERC11-**HPD** Ø 3-6 mm

Sealed for Inner Coolant Supply



□ =
D =
L =

2 µm
11,3
18

□ =
D =
L =

2 µm
11,3
18

Ø mm	Order-No.	Ø inch	Order-No.	Ø mm	Order-No.	Ø inch	Order-No.
1,0	13611010100	1/16"	13611040159	3,0	13621010300	1/8"	13621040318
1,5	13611010150	3/32"	13611040238	4,0	13621010400	3/16"	13621040476
2,0	13611010200	1/8"	13611040318	5,0	13621010500	1/4"	13621040635
2,5	13611010250	5/32"	13611040397	6,0	13621010600		
2,8	13611010280	3/16"	13611040476				
3,0	13611010300	7/32"	13611040556				
3,5	13611010350	1/4"	13611040635				
4,0	13611010400						
4,5	13611010450						
5,0	13611010500						
5,5	13611010550						
6,0	13611010600						
6,5	13611010650						
7,0	13611010700						

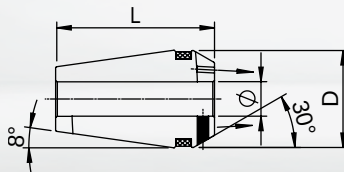
GERC11

1-7 mm

ACCESSORIES FOR CHUCKS

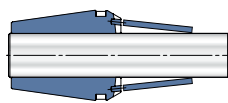
MPC11

High Precision Collets 2 µm



GERC11-HPDD Ø 3-6 mm

Sealed for Inner Coolant Supply and Jet Holes



□ =	2 µm
D =	11,3
L =	18

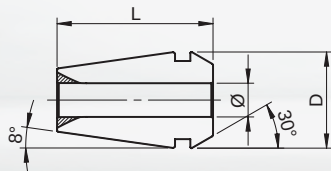
Ø mm	Order-No.	Ø inch	Order-No.
3,0	13631010300	1/8"	13631040318
4,0	13631010400	3/16"	13631040476
6,0	13631010600	1/4"	13631040635

ACCESSORIES FOR CHUCKS

MPC11

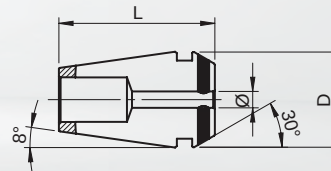
GERC11
1-7 mm

Precision Collets 5 µm



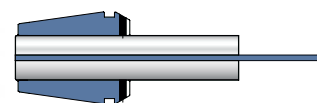
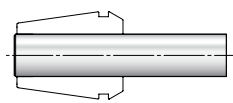
GERC11-B Ø 1-7 mm

Standard



GERC11-BD Ø 3-6 mm

Sealed for Inner Coolant Supply



□ =
D =
L =

5 µm
11,3
18

□ =
D =
L =

5 µm
11,3
18

Ø mm	Order-No.	Ø inch	Order-No.	Ø mm	Order-No.	Ø inch	Order-No.
1,0	13711010100	1/16"	13711040159	3,0	13721010300	1/8"	13721040318
1,5	13711010150	3/32"	13711040238	4,0	13721010400	3/16"	13721040476
2,0	13711010200	1/8"	13711040318	5,0	13721010500	1/4"	13721040635
2,5	13711010250	5/32"	13711040397	6,0	13721010600		
3,0	13711010300	3/16"	13711040476				
3,5	13711010350	7/32"	13711040556				
4,0	13711010400	1/4"	13711040635				
4,5	13711010450						
5,0	13711010500						
5,5	13711010550						
6,0	13711010600						
6,5	13711010650						
7,0	13711010700						

GERC11-B Set

Content of set (Ø mm)	Order-No.	Set
1,0-7,0/ 0,5 Increments	1371116	13pieces

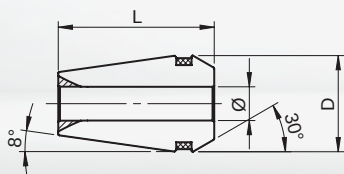
GERC16

1-10 mm

ACCESSORIES FOR CHUCKS

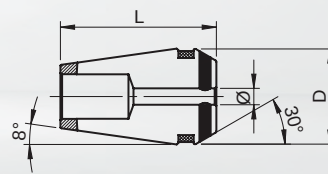
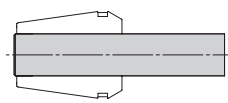
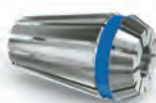
MPC16 | DPC16

High Precision Collets 2 µm



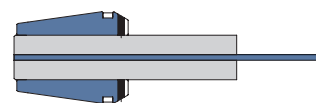
GERC16-HP Ø 1-10 mm

Standard



GERC16-HPD Ø 3-10 mm

Sealed for Inner Coolant Supply



□ =
D =
L =

2 µm
17
27,5

□ =
D =
L =

2 µm
17
27,5

Ø mm	Order-No.	Ø mm	Order-No.	Ø mm	Order-No.	Ø inch	Order-No.
1,0	13613010100	4,5	13613010450	3,0	13623010300	1/8"	13623040318
1,1	13613010110	5,0	13613010500	4,0	13623010400	5/32"	13623040397
1,2	13613010120	5,5	13613010550	5,0	13623010500	3/16"	13623040476
1,3	13613010130	5,6	13613010560	6,0	13623010600	7/32"	13623040556
1,4	13613010140	6,0	13613010600	7,0	13623010700	1/4"	13623040635
1,5	13613010150	6,3	13613010630	8,0	13623010800	9/32"	13623040714
1,6	13613010160	6,5	13613010650	9,0	13623010900	5/16"	13623040794
1,7	13613010170	7,0	13613010700	10,0	13623011000	11/32"	13623040873
1,8	13613010180	7,1	13613010710			3/8"	13623040953
1,9	13613010190	7,5	13613010750			13/32"	13623041032
2,0	13613010200	8,0	13613010800				
2,1	13613010210	8,5	13613010850				
2,2	13613010220	9,0	13613010900				
2,3	13613010230	9,5	13613010950				
2,4	13613010240	10,0	13613011000				
2,5	13613010250						
2,6	13613010260						
2,7	13613010270	Ø inch	Order-No.				
2,8	13613010280	1/16"	13613040159				
2,9	13613010290	3/32"	13613040238				
3,0	13613010300	1/8"	13613040318				
3,1	13613010310	5/32"	13613040397				
3,2	13613010320	3/16"	13613040476				
3,3	13613010330	7/32"	13613040556				
3,4	13613010340	1/4"	13613040635				
3,5	13613010350	9/32"	13613040714				
3,6	13613010360	5/16"	13613040794				
3,7	13613010370	11/32"	13613040873				
3,8	13613010380	3/8"	13613040953				
4,0	13613010400						

GERC16-HP Set

Content of set (Ø mm)	Order-No.	Set
3,0•4,0•5,0•6,0•8,0•10,0	13613160060	6pieces

GERC16-HPD Set

Content of set (Ø mm)	Order-No.	Set
3,0•4,0•5,0•6,0•8,0•10,0	13623160060	6pieces

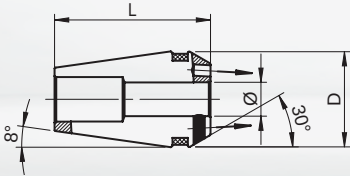
ACCESSORIES FOR CHUCKS

MPC16 | DPC16

GERC16

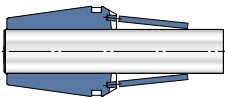
1-10 mm

High Precison Collets 2 µm



GERC16-HPDD Ø 3-10 mm

Sealed for Inner Coolant Supply and Jet Holes



 =	2 µm		
D =	17		
L =	27,5		
Ø mm	Order-No.	Ø inch	Order-No.
3,0	13633010300	1/8"	13633040318
4,0	13633010400	3/16"	13633040476
6,0	13633010600	1/4"	13633040635
8,0	13633010800	5/16"	13633040794
10,0	13633011000	3/8"	13633040953

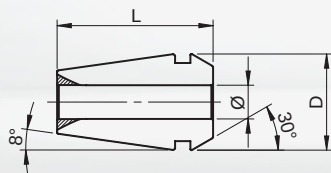
GERC16

1-10 mm

ACCESSORIES FOR CHUCKS

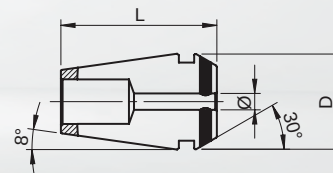
MPC16 | DPC16

Precision Collets 5 µm



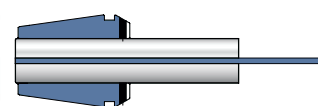
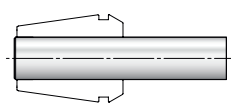
GERC16-B Ø 1-10 mm

Standard



GERC16-BD Ø 3-10 mm

Sealed for Inner Coolant Supply



□ =
D =
L =

5 µm
17
27,5

□ =
D =
L =

5 µm
17
27,5

Ø mm	Order-No.	Ø inch	Order-No.	Ø mm	Order-No.	Ø inch	Order-No.
1,0	13713010100	1/16"	13713040159	3,0	13723010300	1/8"	13723040318
1,5	13713010150	3/32"	13713040238	4,0	13723010400	3/16"	13723040476
2,0	13713010200	1/8"	13713040318	5,0	13723010500	1/4"	13723040635
2,5	13713010250	5/32"	13713040397	6,0	13723010600	5/16"	13723040794
3,0	13713010300	3/16"	13713040476	7,0	13723010700	3/8"	13723040953
3,5	13713010350	7/32"	13713040556	8,0	13723010800		
4,0	13713010400	1/4"	13713040635	9,0	13723010900		
4,5	13713010450	9/32"	13713040714	10,0	13723011000		
5,0	13713010500	5/16"	13713040794				
5,5	13713010550	11/32"	13713040873				
6,0	13713010600	3/8"	13713040953				
6,5	13713010650	13/32"	13713041032				
7,0	13713010700						
7,5	13713010750						
8,0	13713010800						
8,5	13713010850						
9,0	13713010900						
9,5	13713010950						
10,0	13713011000						

GERC16-B Set

Content of set (Ø mm)	Order-No.	Set
1,0-10,0/ 1,0 Increments	1371316	10pieces

GERC16-BD Set

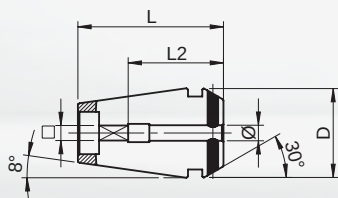
Content of set (Ø mm)	Order-No.	Set
3,0•4,0•5,0•6,0•8,0•10,0	13723160060	6pieces

ACCESSORIES FOR CHUCKS

MPC16 | DPC16

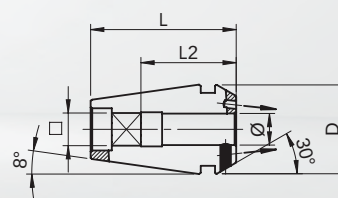
GERC16
1-10 mm

Tap Collets 10 µm



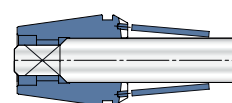
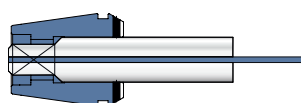
GERC16-GBD Ø 2,8-9 mm

Sealed for Inner Coolant Supply



GERC16-GBDD Ø 3,5-9 mm

Sealed for Inner Coolant Supply and Jet Holes



☐ =		10 µm	☐ =		10 µm
D =		17	D =		17
L =		27,5	L =		27,5
Ø/□ mm	L2	Order-No.	Ø/□ mm	L2	Order-No.
2,8/2,1	18	13823010280	3,5/2,7	18	13833010350
3,5/2,7	18	13823010350	4,5/3,55	18	13833010450
4,0/3,2	18	13823010400	6,0/5,0	18	13833010600
4,5/3,55	18	13823010450	7,0/5,6	18	13833010700
5,0/4,0	18	13823010500	8,0/6,3	22	13833010800
5,5/4,5	18	13823010550	9,0/7,1	22	13833010900
6,0/5,0	18	13823010600			
6,3/5,0	18	13823010630			
7,0/5,6	18	13823010700			
7,1/5,6	18	13823010710			
8,0/6,3	22	13823010800			
9,0/7,1	22	13823010900			

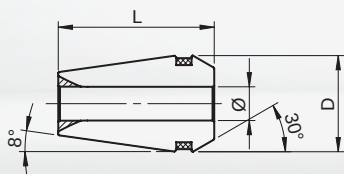
GERC20

1-13 mm

ACCESSORIES FOR CHUCKS

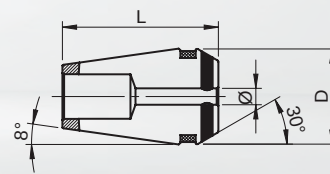
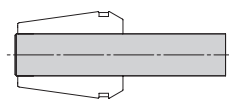
DPC20

High Precision Collets 2 µm



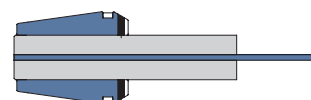
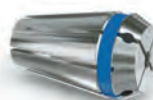
GERC20-HP Ø 1-13 mm

Standard



GERC20-HPD Ø 3-12 mm

Sealed for Inner Coolant Supply



□ =
D =
L =

2 µm
21
31,5

□ =
D =
L =

2 µm
21
31,5

Ø mm	Order-No.	Ø mm	Order-No.	Ø mm	Order-No.	Ø inch	Order-No.
1,0	13614010100	10,0	13614011000	3,0	13624010300	1/8"	13624040318
1,5	13614010150	10,5	13614011050	4,0	13624010400	3/16"	13624040476
2,0	13614010200	11,0	13614011100	5,0	13624010500	1/4"	13624040635
2,5	13614010250	11,5	13614011150	6,0	13624010600	5/16"	13624040794
3,0	13614010300	12,0	13614011200	7,0	13624010700	3/8"	13624040953
3,5	13614010350	12,5	13614011250	8,0	13624010800	7/16"	13624041111
4,0	13614010400	13,0	13614011300	9,0	13624010900	1/2"	13624041270
4,5	13614010450			10,0	13624011000		
5,0	13614010500			11,0	13624011100		
5,5	13614010550	Ø inch	Order-No.	12,0	13624011200		
6,0	13614010600	1/8"	13614040318				
6,5	13614010650	3/16"	13614040476				
7,0	13614010700	1/4"	13614040635				
7,5	13614010750	5/16"	13614040794				
8,0	13614010800	3/8"	13614040953				
8,5	13614010850	7/16"	13614041111				
9,0	13614010900	1/2"	13614041270				
9,5	13614010950						

GERC20-HP Set

Content of set (Ø mm)	Order-No.	Set
3,0•4,0•5,0•6,0•8,0•10,0•12,0	13614160070	7pieces

GERC20-HPD Set

Content of set (Ø mm)	Order-No.	Set
3,0•4,0•5,0•6,0•8,0•10,0•12,0	13624160070	7pieces

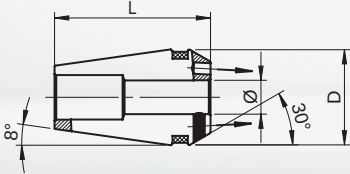
ACCESSORIES FOR CHUCKS

DPC20

GERC20
1-13 mm

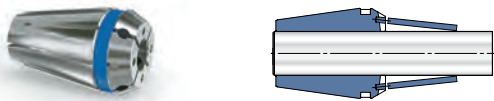
High Precision Collets 2 µm





GERC20-HPDD Ø 4-12 mm

Sealed for Inner Coolant Supply and Jet Holes

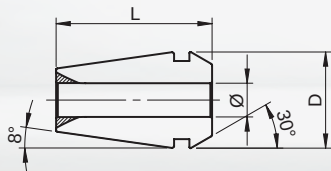


 =	2 µm		
D =	21		
L =	31,5		
Ø mm	Order-No.	Ø inch	Order-No.
4,0	13634010400	1/8"	13634040318
6,0	13634010600	3/16"	13634040476
8,0	13634010800	1/4"	13634040635
10,0	13634011000	5/16"	13634040794
12,0	13634011200	3/8"	13634040953
		7/16"	13634041111
		1/2"	13634041270

GERC20 1-13 mm

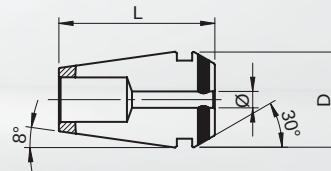
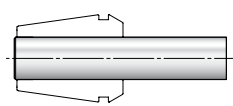
ACCESSORIES FOR CHUCKS DPC20

Precision Collets 5 µm



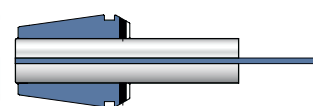
GERC20-B Ø 1-13 mm

Standard



GERC20-BD Ø 3-12 mm

Sealed for Inner Coolant Supply



☐ =
D =
L =

5 µm
21
31,5

☐ =
D =
L =

5 µm
21
31,5

Ø mm	Order-No.	Ø mm	Order-No.	Ø mm	Order-No.	Ø inch	Order-No.
1,0	13714010100	10,0	13714011000	3,0	13724010300	1/8"	13724040318
1,5	13714010150	10,5	13714011050	4,0	13724010400	3/16"	13724040476
2,0	13714010200	11,0	13714011100	5,0	13724010500	1/4"	13724040635
2,5	13714010250	11,5	13714011150	6,0	13724010600	5/16"	13724040794
3,0	13714010300	12,0	13714011200	7,0	13724010700	3/8"	13724040953
3,5	13714010350	12,5	13714011250	8,0	13724010800	7/16"	13724041111
4,0	13714010400	13,0	13714011300	9,0	13724010900	1/2"	13724041270
4,5	13714010450			10,0	13724011000		
5,0	13714010500			11,0	13724011100		
5,5	13714010550	Ø inch	Order-No.	12,0	13724011200		
6,0	13714010600	1/8"	13714040318				
6,5	13714010650	3/16"	13714040476				
7,0	13714010700	1/4"	13714040635				
7,5	13714010750	5/16"	13714040794				
8,0	13714010800	3/8"	13714040953				
8,5	13714010850	7/16"	13714041111				
9,0	13714010900	1/2"	13714041270				
9,5	13714010950						

GERC20-B Set

Content of set (Ø mm)	Order-No.	Set
2,0-13,0/ 1,0 Increments	1371416	12pieces

GERC20-BD Set

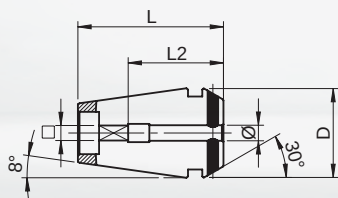
Content of set (Ø mm)	Order-No.	Set
3,0•4,0•5,0•6,0•8,0•10,0•12,0	13724160070	7pieces

ACCESSORIES FOR CHUCKS

DPC20

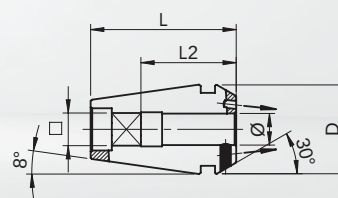
GERC20
1-13 mm

Tap Collets 10 µm



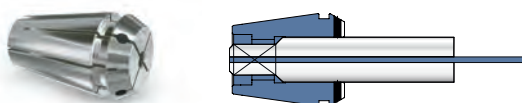
GERC20-GBD Ø 3,5-12 mm

Sealed for Inner Coolant Supply



GERC20-GBDD Ø 4,5-12 mm

Sealed for Inner Coolant Supply and Jet Holes



☐ =		10 µm	☐ =		10 µm
D =		21	D =		21
L =		31,5	L =		31,5
Ø/□ mm	L2	Order-No.	Ø/□ mm	L2	Order-No.
3,5/2,7	18	13824010350	4,5/3,55	18	13834010450
4,0/3,2	18	13824010400	6,0/5,0	18	13834010600
4,5/3,55	18	13824010450	7,0/5,6	18	13834010700
5,0/4,0	18	13824010500	8,0/6,3	22	13834010800
5,5/4,5	18	13824010550	9,0/7,1	22	13834010900
6,0/5,0	18	13824010600	10,0/8,0	25	13834011000
6,3/5,0	18	13824010630	11,0/9,0	25	13834011100
7,0/5,6	18	13824010700	12,0/9,0	25	13834011200
7,1/5,6	18	13824010710			
8,0/6,3	22	13824010800			
9,0/7,1	22	13824010900			
10,0/8,0	25	13824011000			
11,0/9,0	25	13824011100			
11,2/9,0	25	13824011120			
12,0/9,0	25	13824011200			

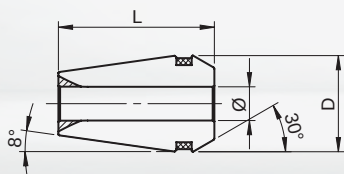
GERC25

1-16 mm

ACCESSORIES FOR CHUCKS

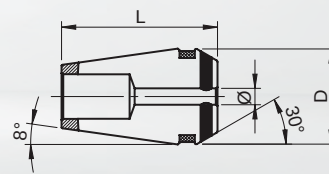
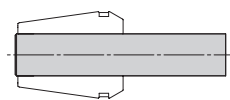
DPC25 | AFC25

High Precision Collets 2 µm



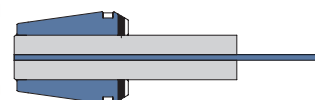
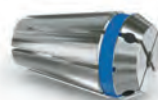
GERC25-HP Ø 1-16 mm

Standard



GERC25-HPD Ø 3-16 mm

Sealed for Inner Coolant Supply



□ =
D =
L =

2 µm
26
34

□ =
D =
L =

2 µm
26
34

Ø mm	Order-No.	Ø mm	Order-No.	Ø mm	Order-No.	Ø inch	Order-No.
1,0	13615010100	12,0	13615011200	3,0	13625010300	1/8"	13625040318
1,5	13615010150	12,5	13615011250	4,0	13625010400	3/16"	13625040476
2,0	13615010200	13,0	13615011300	5,0	13625010500	1/4"	13625040635
2,5	13615010250	13,5	13615011350	6,0	13625010600	5/16"	13625040794
3,0	13615010300	14,0	13615011400	7,0	13625010700	3/8"	13625040953
3,5	13615010350	14,5	13615011450	8,0	13625010800	7/16"	13625041111
4,0	13615010400	15,0	13615011500	9,0	13625010900	1/2"	13625041270
4,5	13615010450	15,5	13615011550	10,0	13625011000	9/16"	13625041429
5,0	13615010500	16,0	13615011600	11,0	13625011100	5/8"	13625041588
5,5	13615010550			12,0	13625011200		
6,0	13615010600			13,0	13625011300		
6,5	13615010650	Ø inch	Order-No.	14,0	13625011400		
7,0	13615010700	1/8"	13615040318	15,0	13625011500		
7,5	13615010750	3/16"	13615040476	16,0	13625011600		
8,0	13615010800	1/4"	13615040635				
8,5	13615010850	5/16"	13615040794				
9,0	13615010900	3/8"	13615040953				
9,5	13615010950	7/16"	13615041111				
10,0	13615011000	1/2"	13615041270				
10,5	13615011050	9/16"	13615041429				
11,0	13615011100	5/8"	13615041588				
11,5	13615011150						

GERC25-HP Set

Content of set (Ø mm)	Order-No.	Set
4,0•6,0•8,0•10,0•12,0•14,0•16,0	13615160070	7pieces

GERC25-HPD Set

Content of set (Ø mm)	Order-No.	Set
4,0•6,0•8,0•10,0•12,0•14,0•16,0	13625160070	7pieces

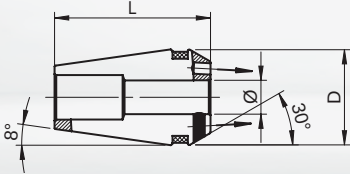
ACCESSORIES FOR CHUCKS

DPC25 | AFC25

GERC25

1-16 mm

High Precision Collets 2 µm



GERC25-HPDD Ø 4-16 mm

Sealed for Inner Coolant Supply and Jet Holes



 =	2 µm		
D =	26		
L =	34		
Ø mm	Order-No.	Ø inch	Order-No.
4,0	13635010400	1/8"	13635040318
6,0	13635010600	3/16"	13635040476
8,0	13635010800	1/4"	13635040635
10,0	13635011000	5/16"	13635040794
12,0	13635011200	3/8"	13635040953
14,0	13635011400	7/16"	13635041111
16,0	13635011600	1/2"	13635041270
		9/16"	13635041429
		5/8"	13635041588

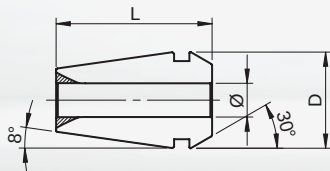
GERC25

1-16 mm

ACCESSORIES FOR CHUCKS

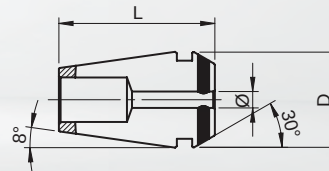
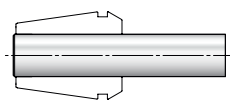
DPC25

Precision Collets 5 µm



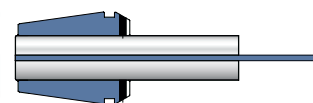
GERC25-B Ø 1-16 mm

Standard



GERC25-BD Ø 3-16 mm

Sealed for Inner Coolant Supply



□ =
D =
L =

5 µm
26
34

□ =
D =
L =

5 µm
26
34

Ø mm	Order-No.	Ø mm	Order-No.	Ø mm	Order-No.	Ø inch	Order-No.
1,0	13715010100	12,0	13715011200	3,0	13725010300	1/8"	13725040318
1,5	13715010150	12,5	13715011250	4,0	13725010400	3/16"	13725040476
2,0	13715010200	13,0	13715011300	5,0	13725010500	1/4"	13725040635
2,5	13715010250	13,5	13715011350	6,0	13725010600	5/16"	13725040794
3,0	13715010300	14,0	13715011400	7,0	13725010700	3/8"	13725040953
3,5	13715010350	14,5	13715011450	8,0	13725010800	7/16"	13725041111
4,0	13715010400	15,0	13715011500	9,0	13725010900	1/2"	13725041270
4,5	13715010450	15,5	13715011550	10,0	13725011000	9/16"	13725041429
5,0	13715010500	16,0	13715011600	11,0	13725011100	5/8"	13725041588
5,5	13715010550			12,0	13725011200		
6,0	13715010600			13,0	13725011300		
6,5	13715010650	Ø inch	Order-No.	14,0	13725011400		
7,0	13715010700	1/8"	13715040318	15,0	13725011500		
7,5	13715010750	3/16"	13715040476	16,0	13725011600		
8,0	13715010800	1/4"	13715040635				
8,5	13715010850	5/16"	13715040794				
9,0	13715010900	3/8"	13715040953				
9,5	13715010950	7/16"	13715041111				
10,0	13715011000	1/2"	13715041270				
10,5	13715011050	9/16"	13715041429				
11,0	13715011100	5/8"	13715041588				
11,5	13715011150						

GERC25-B Set

Content of set (Ø mm)	Order-No.	Set
2,0-16,0/ 1,0 Increments	1371516	15pieces

GERC25-BD Set

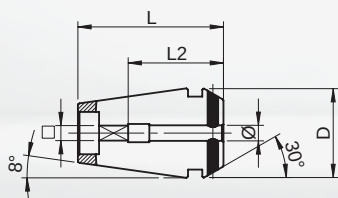
Content of set (Ø mm)	Order-No.	Set
4,0•6,0•8,0•10,0•12,0•14,0•16,0	13725160070	7pieces

ACCESSORIES FOR CHUCKS

DPC25

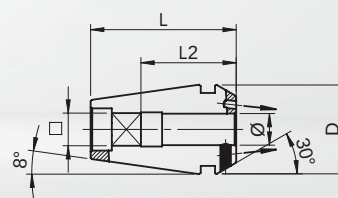
GERC25
1-16 mm

Tap Collets 10 µm



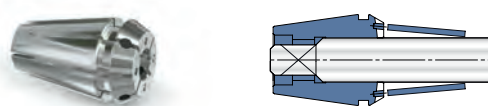
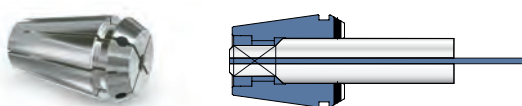
GERC25-GBD Ø 3,5-16 mm

Sealed for Inner Coolant Supply



GERC25-GBDD Ø 4,5-16 mm

Sealed for Inner Coolant Supply and Jet Holes



☐ =		10 µm	☐ =		10 µm
D =		26	D =		26
L =		34	L =		34
Ø/□ mm	L2	Order-No.	Ø/□ mm	L2	Order-No.
3,5/2,7	18	13825010350	4,5/3,55	18	13835010450
4,0/3,2	18	13825010400	6,0/5,0	18	13835010600
4,5/3,55	18	13825010450	7,0/5,6	18	13835010700
5,0/4,0	18	13825010500	8,0/6,3	22	13835010800
5,5/4,5	18	13825010550	9,0/7,1	22	13835010900
6,0/5,0	18	13825010600	10,0/8,0	25	13835011000
6,3/5,0	18	13825010630	11,0/9,0	25	13835011100
7,0/5,6	18	13825010700	12,0/9,0	25	13835011200
7,1/5,6	18	13825010710	14,0/11,2	25	13835011400
8,0/6,3	22	13825010800	16,0/12,5	25	13835011600
9,0/7,1	22	13825010900			
10,0/8,0	25	13825011000			
11,0/9,0	25	13825011100			
11,2/9,0	25	13825011120			
12,0/9,0	25	13825011200			
12,5/10,0	25	13825011250			
14,0/11,2	25	13825011400			
16,0/12,5	25	13825011600			

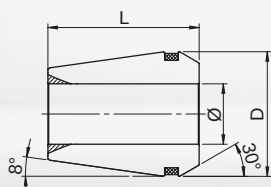
GERC32

2-20 mm

ACCESSORIES FOR CHUCKS

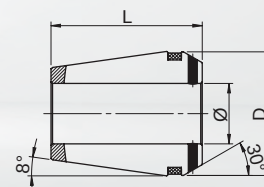
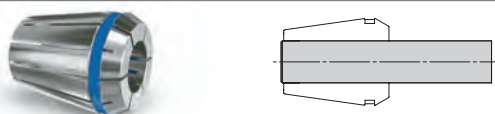
DPC32 | UPC32 | FPC32 | AFC32

High Precision Collets 2 µm



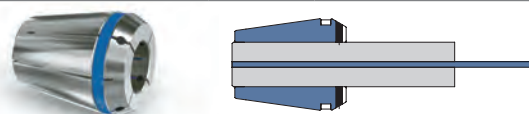
GERC32-HP Ø 2-20 mm

Standard



GERC32-HPD Ø 3-20 mm

Sealed for Inner Coolant Supply



☐ =
D =
L =

2 µm
33
40

☐ =
D =
L =

2 µm
33
40

Ø mm	Order-No.	Ø mm	Order-No.	Ø mm	Order-No.	Ø inch	Order-No.
2,0	13616010200	15,0	13616011500	3,0	13626010300	1/8"	13626040318
2,5	13616010250	15,5	13616011550	4,0	13626010400	3/16"	13626040476
3,0	13616010300	16,0	13616011600	5,0	13626010500	1/4"	13626040635
3,5	13616010350	16,5	13616011650	6,0	13626010600	5/16"	13626040794
4,0	13616010400	17,0	13616011700	7,0	13626010700	3/8"	13626040953
4,5	13616010450	17,5	13616011750	8,0	13626010800	7/16"	13626041111
5,0	13616010500	18,0	13616011800	9,0	13626010900	1/2"	13626041270
5,5	13616010550	18,5	13616011850	10,0	13626011000	9/16"	13626041429
6,0	13616010600	19,0	13616011900	11,0	13626011100	5/8"	13626041588
6,5	13616010650	19,5	13616011950	12,0	13626011200	11/16"	13626041746
7,0	13616010700	20,0	13616012000	13,0	13626011300	3/4"	13626041905
7,5	13616010750			14,0	13626011400		
8,0	13616010800			15,0	13626011500		
8,5	13616010850	Ø inch	Order-No.	16,0	13626011600		
9,0	13616010900	1/8"	13616040318	17,0	13626011700		
9,5	13616010950	3/16"	13616040476	18,0	13626011800		
10,0	13616011000	1/4"	13616040635	19,0	13626011900		
10,5	13616011050	5/16"	13616040794	20,0	13626012000		
11,0	13616011100	3/8"	13616040953				
11,5	13616011150	7/16"	13616041111				
12,0	13616011200	1/2"	13616041270				
12,5	13616011250	9/16"	13616041429				
13,0	13616011300	5/8"	13616041588				
13,5	13616011350	11/16"	13616041746				
14,0	13616011400	3/4"	13616041905				
14,5	13616011450						

GERC32-HP Set

Content of set (Ø mm)	Order-No.	Set
4,0•6,0•8,0•10,0•12,0•14,0•16,0•20,0	13616160080	8pieces

GERC32-HPD Set

Content of set (Ø mm)	Order-No.	Set
4,0•6,0•8,0•10,0•12,0•14,0•16,0•20,0	13626160080	8pieces

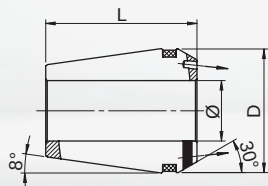
ACCESSORIES FOR CHUCKS

DPC32 | UPC32 | FPC32 | AFC32(HPDD ONLY)

GERC32

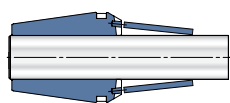
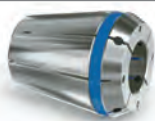
2-20 mm

High Precision Collets 2 µm



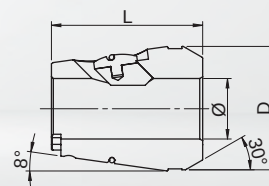
GERC32-HPDD Ø 4-20 mm

Sealed for Inner Coolant Supply and Jet Holes



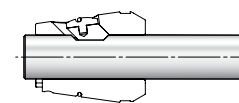
□ = 2 µm
D = 33
L = 40

Wedge Collets 3 µm



GERC32-W Ø 12-20 mm

Pull-Out Protection



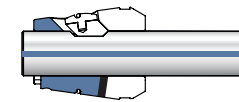
□ = 3 µm
D = 33
L = 40

Ø mm	Order-No.	Ø inch	Order-No.
4,0	13636010400	1/8"	13636040318
6,0	13636010600	3/16"	13636040476
8,0	13636010800	1/4"	13636040635
10,0	13636011000	5/16"	13636040794
12,0	13636011200	3/8"	13636040953
14,0	13636011400	7/16"	13636041111
16,0	13636011600	1/2"	13636041270
18,0	13636011800	9/16"	13636041429
20,0	13636012000	5/8"	13636041588
		11/16"	13636041746
		3/4"	13636041905

* Version differs from the picture!

GERC32-WD Ø 12-16 mm

Sealed with Pull-Out Protection



□ = 3 µm
D = 33
L = 40

Ø mm	Order-No.	Ø inch	Order-No.
12,0	13926011200	1/2"	13926041270
16,0	13926011600	5/8"	13926041588

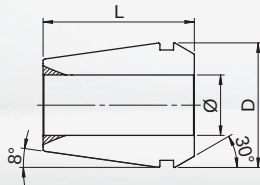
GERC32

2-20 mm

ACCESSORIES FOR CHUCKS

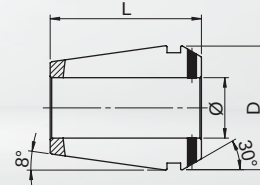
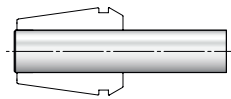
DPC32 | UPC32 | FPC32

Precision Collets 5 µm



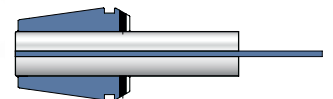
GERC32-B Ø 2-20 mm

Standard



GERC32-BD Ø 3-20 mm

Sealed for Inner Coolant Supply



☐ =
D =
L =

5 µm
33
40

☐ =
D =
L =

5 µm
33
40

Ø mm	Order-No.	Ø mm	Order-No.	Ø mm	Order-No.	Ø inch	Order-No.
2,0	13716010200	15,0	13716011500	3,0	13726010300	1/8"	13726040318
2,5	13716010250	15,5	13716011550	4,0	13726010400	3/16"	13726040476
3,0	13716010300	16,0	13716011600	5,0	13726010500	1/4"	13726040635
3,5	13716010350	16,5	13716011650	6,0	13726010600	5/16"	13726040794
4,0	13716010400	17,0	13716011700	7,0	13726010700	3/8"	13726040953
4,5	13716010450	17,5	13716011750	8,0	13726010800	7/16"	13726041111
5,0	13716010500	18,0	13716011800	9,0	13726010900	1/2"	13726041270
5,5	13716010550	18,5	13716011850	10,0	13726011000	9/16"	13726041429
6,0	13716010600	19,0	13716011900	11,0	13726011100	5/8"	13726041588
6,5	13716010650	19,5	13716011950	12,0	13726011200	3/4"	13726041905
7,0	13716010700	20,0	13716012000	13,0	13726011300		
7,5	13716010750			14,0	13726011400		
8,0	13716010800			15,0	13726011500		
8,5	13716010850	Ø inch	Order-No.	16,0	13726011600		
9,0	13716010900	1/8"	13716040318	17,0	13726011700		
9,5	13716010950	3/16"	13716040476	18,0	13726011800		
10,0	13716011000	1/4"	13716040635	19,0	13726011900		
10,5	13716011050	5/16"	13716040794	20,0	13726012000		
11,0	13716011100	3/8"	13716040953				
11,5	13716011150	7/16"	13716041111				
12,0	13716011200	1/2"	13716041270				
12,5	13716011250	9/16"	13716041429				
13,0	13716011300	5/8"	13716041588				
13,5	13716011350	11/16"	13716041746				
14,0	13716011400	3/4"	13716041905				
14,5	13716011450	13/16"	13716042064				

GERC32-B Set

Content of set (Ø mm)	Order-No.	Set
3,0-20,0/ 1,0 Increments	1371616	18pieces

GERC32-BD Set

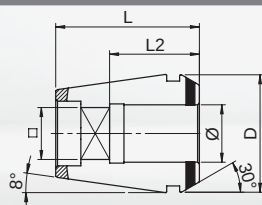
Content of set (Ø mm)	Order-No.	Set
4,0•6,0•8,0•10,0•12,0•14,0•16,0•20,0	13726160080	8pieces

ACCESSORIES FOR CHUCKS

DPC32 | UPC32 | FPC32

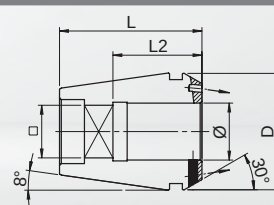
GERC32
2-20 mm

Tap Collets 10 µm



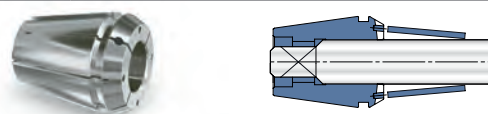
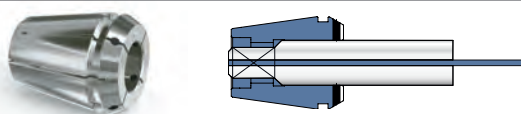
GERC32-GBD Ø 4-20 mm

Sealed for Inner Coolant Supply



GERC32-GBDD Ø 4,5-20 mm

Sealed for Inner Coolant Supply and Jet Holes



☐ =		10 µm	☐ =		10 µm
D =		33	D =		33
L =		40	L =		40
Ø/☐ mm	L2	Order-No.	Ø/☐ mm	L2	Order-No.
4,0/3,2	18	13826010400	4,5/3,55	18	13836010450
4,5/3,55	18	13826010450	6,0/5,0	18	13836010600
5,0/4,0	18	13826010500	7,0/5,6	18	13836010700
5,5/4,5	18	13826010550	8,0/6,3	22	13836010800
6,0/5,0	18	13826010600	9,0/7,1	22	13836010900
6,3/5,0	18	13826010630	10,0/8,0	25	13836011000
7,0/5,6	18	13826010700	11,0/9,0	25	13836011100
7,1/5,6	18	13826010710	12,0/9,0	25	13836011200
8,0/6,3	22	13826010800	14,0/11,2	25	13836011400
9,0/7,1	22	13826010900	16,0/12,5	25	13836011600
10,0/8,0	25	13826011000	18,0/14,5	30	13836011800
11,0/9,0	25	13826011100	20,0/16,0	30	13836012000
11,2/9,0	25	13826011120			
12,0/9,0	25	13826011200			
12,5/10,0	25	13826011250			
14,0/11,2	25	13826011400			
16,0/12,5	25	13826011600			
18,0/14,5	30	13826011800			
20,0/16,0	30	13826012000			

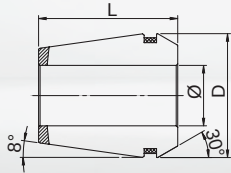
GERC40

3-26 mm

ACCESSORIES FOR CHUCKS

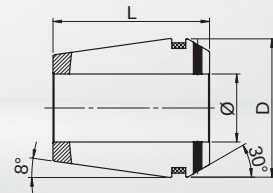
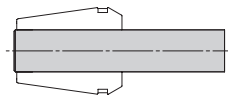
DPC40 | UPC40 | FPC40

High Precision Collets 2 µm



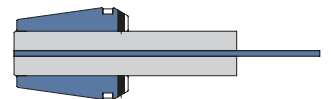
GERC40-HP Ø 3-26 mm

Standard



GERC40-HPD Ø 6-25 mm

Sealed for Inner Coolant Supply



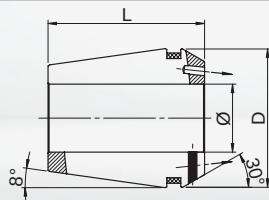
☐ = D = L =		2 μm		☐ = D = L =		2 μm	
		41				41	
		46				46	
Ø mm	Order-No.	Ø mm	Order-No.	Ø mm	Order-No.	Ø inch	Order-No.
3,0	13617010300	19,0	13617011900	6,0	13627010600	1/4"	13627040635
3,5	13617010350	19,5	13617011950	8,0	13627010800	3/8"	13627040953
4,0	13617010400	20,0	13617012000	10,0	13627011000	1/2"	13627041270
4,5	13617010450	20,5	13617012050	12,0	13627011200	5/8"	13627041588
5,0	13617010500	21,0	13617012100	14,0	13627011400	3/4"	13627041905
5,5	13617010550	21,5	13617012150	16,0	13627011600	1"	13627042540
6,0	13617010600	22,0	13617012200	18,0	13627011800		
6,5	13617010650	22,5	13617012250	20,0	13627012000		
7,0	13617010700	23,0	13617012300	22,0	13627012200		
7,5	13617010750	23,5	13617012350	25,0	13627012500		
8,0	13617010800	24,0	13617012400				
8,5	13617010850	24,5	13617012450				
9,0	13617010900	25,0	13617012500				
9,5	13617010950	25,5	13617012550				
10,0	13617011000	26,0	13617012600				
10,5	13617011050						
11,0	13617011100						
11,5	13617011150	Ø inch	Order-No.				
12,0	13617011200	1/8"	13617040318				
12,5	13617011250	3/16"	13617040476				
13,0	13617011300	1/4"	13617040635				
13,5	13617011350	5/16"	13617040794				
14,0	13617011400	3/8"	13617040953				
14,5	13617011450	7/16"	13617041111				
15,0	13617011500	1/2"	13617041270				
15,5	13617011550	9/16"	13617041429				
16,0	13617011600	5/8"	13617041588				
16,5	13617011650	11/16"	13617041746				
17,0	13617011700	3/4"	13617041905				
17,5	13617011750	13/16"	13617042064				
18,0	13617011800	7/8"	13617042223				
18,5	13617011850	1"	13617042540				

ACCESSORIES FOR CHUCKS

DPC40 | UPC40 | FPC40

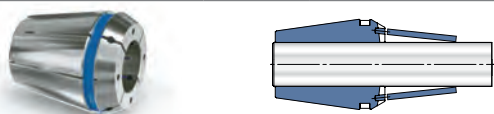
GERC40
3-26 mm

High Precision Collets 2 µm



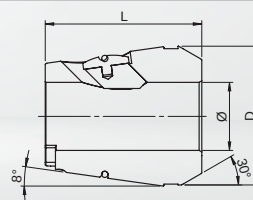
GERC40-HPDD Ø 6-25 mm

Sealed for Inner Coolant Supply and Jet Holes



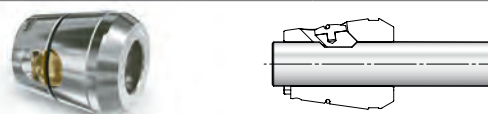
☐ =	2 µm
D =	41
L =	46

Wedge Collets 3 µm



GERC40-W Ø 16-25 mm

Pull-Out Protection

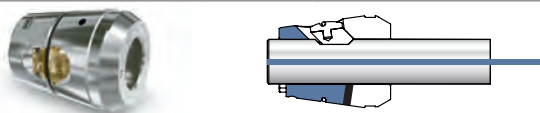


☐ =	3 µm
D =	41
L =	46

Ø mm	Order-No.	Ø inch	Order-No.
6,0	13637010600	1/4"	13637040635
8,0	13637010800	3/8"	13637040953
10,0	13637011000	1/2"	13637041270
12,0	13637011200	5/8"	13637041588
14,0	13637011400	3/4"	13637041905
16,0	13637011600	1"	13637042540
18,0	13637011800		
20,0	13637012000		
25,0	13637012500		

GERC40-WD Ø 16-20 mm

Sealed with Pull-Out Protection



☐ =	3 µm
D =	41
L =	46

Ø mm	Order-No.	Ø inch	Order-No.
16,0	13927011600	5/8"	13927041588
20,0	13927012000	3/4"	13927041905

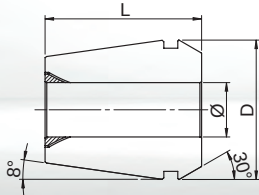
GERC40

3-26 mm

ACCESSORIES FOR CHUCKS

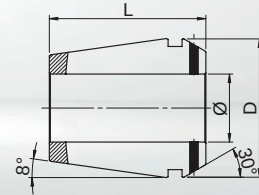
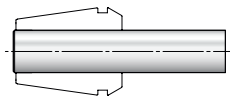
DPC40 | UPC40 | FPC40

Precision Collets 5 µm



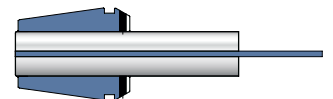
GERC40-B Ø 3-26 mm

Standard



GERC40-BD Ø 6-25 mm

Sealed for Inner Coolant Supply



□ =
D =
L =

5 µm
41
46

□ =
D =
L =

5 µm
41
46

Ø mm	Order-No.	Ø mm	Order-No.	Ø mm	Order-No.
3,0	13717010300	19,0	13717011900	6,0	13727010600
3,5	13717010350	19,5	13717011950	8,0	13727010800
4,0	13717010400	20,0	13717012000	10,0	13727011000
4,5	13717010450	20,5	13717012050	12,0	13727011200
5,0	13717010500	21,0	13717012100	14,0	13727011400
5,5	13717010550	21,5	13717012150	16,0	13727011600
6,0	13717010600	22,0	13717012200	18,0	13727011800
6,5	13717010650	22,5	13717012250	20,0	13727012000
7,0	13717010700	23,0	13717012300	22,0	13727012200
7,5	13717010750	23,5	13717012350	25,0	13727012500
8,0	13717010800	24,0	13717012400		
8,5	13717010850	24,5	13717012450		
9,0	13717010900	25,0	13717012500		
9,5	13717010950	25,5	13717012550		
10,0	13717011000	26,0	13717012600		
10,5	13717011050				
11,0	13717011100				
11,5	13717011150	Ø inch	Order-No.		
12,0	13717011200	1/8"	13717040318		
12,5	13717011250	3/16"	13717040476		
13,0	13717011300	1/4"	13717040635		
13,5	13717011350	5/16"	13717040794		
14,0	13717011400	3/8"	13717040953		
14,5	13717011450	7/16"	13717041111		
15,0	13717011500	1/2"	13717041270		
15,5	13717011550	9/16"	13717041429		
16,0	13717011600	5/8"	13717041588		
16,5	13717011650	11/16"	13717041746		
17,0	13717011700	3/4"	13717041905		
17,5	13717011750	13/16"	13717042064		
18,0	13717011800	7/8"	13717042223		
18,5	13717011850	1"	13717042540		

GERC40-B Set

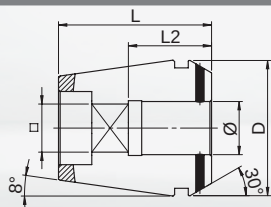
Content of set (Ø mm)	Order-No.	Set
4,0-26,0/ 1,0 Increments	1371716	23pieces

ACCESSORIES FOR CHUCKS

DPC40 | UPC40 | FPC40

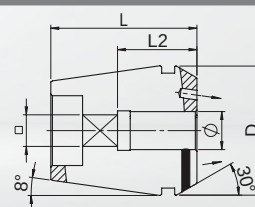
GERC40
3-26 mm

Tap Collets 10 µm



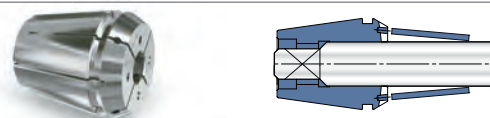
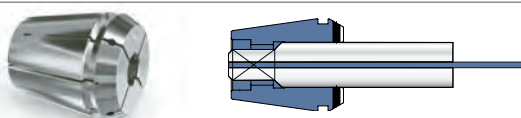
GERC40-GBD Ø 6-25 mm

Sealed for Inner Coolant Supply



GERC40-GBDD Ø 6-25 mm

Sealed for Inner Coolant Supply and Jet Holes



☐ =		10 µm	☐ =		10 µm
D =		41	D =		41
L =		46	L =		46
Ø/☐ mm	L2	Order-No.	Ø/☐ mm	L2	Order-No.
6,0/5,0	18	13827010600	6,0/5,0	18	13837010600
6,3/5,0	18	13827010630	7,0/5,6	18	13837010700
7,0/5,6	18	13827010700	8,0/6,3	22	13837010800
7,1/5,6	18	13827010710	9,0/7,1	22	13837010900
8,0/6,3	22	13827010800	10,0/8,0	25	13837011000
9,0/7,1	22	13827010900	11,0/9,0	25	13837011100
10,0/8,0	25	13827011000	12,0/9,0	25	13837011200
11,0/9,0	25	13827011100	14,0/11,2	25	13837011400
11,2/9,0	25	13827011120	16,0/12,5	25	13837011600
12,0/9,0	25	13827011200	18,0/14,5	33	13837011800
12,5/10,0	25	13827011250	20,0/16,0	33	13837012000
14,0/11,2	25	13827011400	22,0/18,0	33	13837012200
16,0/12,5	25	13827011600	25,0/20,0	33	13837012500
18,0/14,5	33	13827011800			
20,0/16,0	33	13827012000			
22,0/18,0	33	13827012200			
25,0/20,0	33	13827012500			

ACCESSORIES



ACCESSORIES FOR CHUCKS

MPC | DPC | UPC | FPC | AFC

Roller Bearing Wrenches with Handle



D = Wrench Ø	Description	Order-No.	for Chucks
10	ROD10	4996300	MPC8
16	RH16	49904000500	MPC11/MPC11C
22	RO22	4990500	MPC16/MPC16C
24	RO24	4990600	MPC16T
30	RO30	4990900	DPC16
32	RO32	4991100	DPC20
40	RO40	4991400	DPC25/AFC25
50	RO50	4991800	DPC32/FPC32/AFC32
53	RO53	4991900	UPC32
63	RO63	4992000	DPC40/FPC40/UPC40

Roller Bearing Heads for Torque Setting Wrenches



D = Wrench Ø	Description	Order-No.	Square	for Chucks
16	DRH16	49934000500	9x12	MPC11 / MPC11C
22	DRO22	4993500	9x12	MPC16 / MPC16C
24	DRO24	4993600	9x12	MPC16T
30	DRO30	4993900	14x18	DPC16
32	DRO32	4994100	14x18	DPC20
40	DRO40	4994400	14x18	DPC25/AFC25
50	DRO50	4994800	14x18	DPC32/FPC32/AFC32
53	DRO53	4994900	14x18	UPC32
63	DRO63	4995000	14x18	DPC40/FPC40/UPC40

Torque Setting Wrenches



Description	Order-No.	Square	Torque Range
DRTW-5-30 (9x12)	4901200	9x12	5 - 30 Nm
DRTW-10-80 (9x12)	4901400	9x12	10 - 80 Nm
DRTW-10-80 (9x12)	4901400	9x12	10 - 80 Nm
DRTW-10-80 (14x18)	4901500	14x18	10 - 80 Nm
DRTW-10-80 (14x18)	4901500	14x18	10 - 80 Nm
DRTW-20-200 (14x18)	4901600	14x18	20 - 200 Nm
DRTW-20-200 (14x18)	4901600	14x18	20 - 200 Nm
DRTW-20-200 (14x18)	4901600	14x18	20 - 200 Nm
DRTW-20-200 (14x18)	4901600	14x18	20 - 200 Nm

ACCESSORIES FOR CHUCKS

MPC | DPC | UPC | FPC | AFC

Mounting Devices



Description	Order-No.	D	for Interfaces
TBR525	4980200	25	HSK25
TBR532	4980400	32	HSK32
TBR540	4980600	40	HSK40
TBR546	4980800	46	BT30, BTP30
TBR550	4981000	50	HSK50, SK30, PSC50
TBR563	4981200	63	HSK63, SK40, BT40, BTP40, PSC63
TBR580	4981600	80	PSC80
TBR597	4981800	97,5	SK50
TBR5100	4982000	100	HSK100, BT50, BTP50



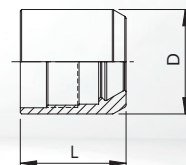
- for easy and safe clamping of the flange interface using rollers for mounting and removing cutting tools, therefore self clamping and ideal for HSK forms E and F as well polygonal shanks
- for all common interfaces such as SK (DIN 69871-1), HSK (DIN 69893 / ISO 12164 - forms A, B, C, D, E, F), polygonal shanks (ISO 26623-1) and BT (JIS B 6339)

ACCESSORIES FOR CHUCKS

MPC | DPC | UPC | FPC | AFC

Mini Clamping Nuts

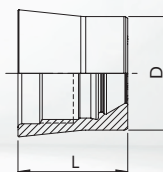
Protect



Description	Order-No.	D	L	for Collets	Clamping range
MPC8	6184000	10	11,1	GERC8-B/HP	1,0-5,0
MPC11	6184100	16	16,2	GERC11-B/HP	1,0-7,0
MPC16	6184300	22	20,9	GERC16-B/HP/GBD	1,0-10,0

Mini Clamping Nuts, tapered

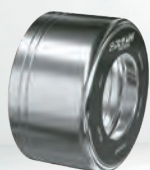
Protect



Description	Order-No.	D	L	for Collets	Clamping range
MPC16T	6182300	24	23,2	GERC16-B/HP/GBD	1,0-10,0

Clamping Nuts

Protect

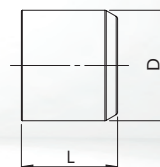


Description	Order-No.	D	L	for Collets	Clamping range
DPC16	6380300	30	23,4	GERC16-B/HP/GBD	1,0-10,0
DPC20	6380400	32	24,6	GERC20-B/HP/GBD	1,0-13,0
DPC25	6380500	40	25,6	GERC25-B/HP/GBD	1,0-16,0
DPC32	6380600	50	26,9	GERC32-B/HP/GBD	2,0-20,0
DPC40	6380700	63	31,5	GERC40-B/HP/GBD	3,0-26,0

ACCESSORIES FOR CHUCKS

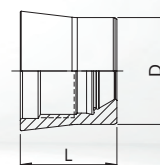
MPC | DPC | UPC | FPC | AFC

Mini Clamping Nuts with collapse -0,4 mm



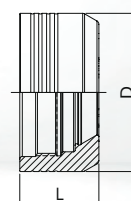
Description	Order-No.	D	L	for Collets	Clamping range
CP16M-HSS-Ø-0,4	4183200	22	20,9	GERC16-B/HP	1,0-10,0

Mini Clamping Nuts, tapered with collapse -0,4 mm



Description	Order-No.	D	L	for Collets	Clamping range
CPC16-HSS-Ø-0,4	4184200	24	23,2	GERC16-B/HP	1,0-10,0

Clamping Nuts with collapse -0,4 mm



Description	Order-No.	D	L	for Collets	Clamping range
CP16-HSS-Ø-0,4	4185200	30	21,3	GERC16-B/HP	1,0-10,0
CP20-HSS-Ø-0,4	4185300	32	22,8	GERC20-B/HP	1,0-13,0
CP25-HSS-Ø-0,4	4185400	40	23,8	GERC25-B/HP	1,0-16,0
CP32-HSS-Ø-0,4	4185500	50	24,9	GERC32-B/HP	2,0-20,0

ACCESSORIES FOR CHUCKS

MPC | DPC | UPC | FPC | AFC

Clamping Nuts, multi-part

Protect



Description	Order-No.	D	L	for Collets	Clamping range
UPC32	6790600	53	27	GERC32-B/HP/GBD	2,0-20,0
UPC40	6790700	63	31,5	GERC40-B/HP/GBD	3,0-26,0

Clamping Nuts, multi-part

Protect

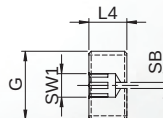


Description	Order-No.	D	L	for Collets	Clamping range
FPC32	6390600	50	26,9	GERC32-B/HP/GBD	2,0-20,0
FPC40	6390700	63	31,5	GERC40-B/HP/GBD	3,0-26,0

ACCESSORIES FOR CHUCKS

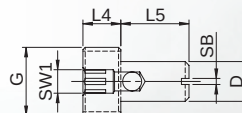
MPC | DPC | UPC | FPC | AFC

Adjustable Stop Screws, short



Description	Order-No.	G	SW1	SB	L4	for Chucks
AS-CP8M-U	44980000100	M5x0,8	2,5	1,2	5	MPC8
AS-CP11-U	44981000100	M8x1	4	1,6	8	MPC11
AS-CP16-U	44982000100	M11x1	6	1,6	8	MPC16, MPC16T, DPC16
AS-CP20-U	44983000100	M14x1	5	1,5	10	DPC20
AS-CP25-U	44984000102	M18x1,5	6	1,6	10	DPC25
AS-CP32-U	44984000103	M22x1,5	6	1,6	12	DPC32, UPC32
AS-CP40-U	44985000100	M28x1,5	6	1,8	25	DPC40, UPC40

Adjustable Stop Screws, long



Description	Order-No.	G	SW1	SB	L4	L5	D	for Chucks
AS-CP11-W	44981000200	M8x1	4	1,2	8	10	4,5	MPC11
AS-CP16-W	44982000200	M11x1	6	1,2	8	14	7	MPC16, MPC16T, DPC16
AS-CP20-W	44983000200	M14x1	5	1,6	10	14	8	DPC20
AS-CP25-W	44984000202	M18x1,5	6	1,6	10	18	10,5	DPC25
AS-CP32-W	44984000203	M22x1,5	6	1,6	10	18	10,5	DPC32, UPC32
AS-CP40-W	44985000200	M28x1,5	6	1,8	22	18	10,5	DPC40, UPC40

Coolant Supply Tubes



Description	Order-No.	for HSK	Form	G
IKR-HSK25	2490200	25	A and E	M8x1
IKR-HSK32	2490300	32	A and E	M10x1
IKR-HSK40	2490400	40	A and E	M12x1
IKR-HSK50	2490500	50	A and E	M16x1
IKR-HSK63	2490600	63	A and E	M18x1
IKR-HSK100	2490800	100	A and E	M24x1,5

Wrenches for Coolant Supply Tubes

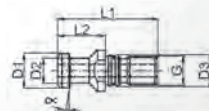


Description	Order-No.	for HSK
SCHL-IKR-HSK25	2492200	25
SCHL-IKR-HSK32	2492300	32
SCHL-IKR-HSK40	2492400	40
SCHL-IKR-HSK50	2492500	50
SCHL-IKR-HSK63	2492600	63
SCHL-IKR-HSK100	2492800	100

ACCESSORIES FOR CHUCKS

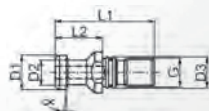
MPC | DPC | UPC | FPC | AFC

Pull Studs DIN 69872-A with Bore



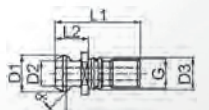
Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-DIN-A	2910500	54	26	19	14	17	15 °	M16	50	40
AZB50-DIN-A	2910700	74	34	28	21	25	15 °	M24	150	50

Pull Studs DIN 69872-B without Bore



Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-DIN-B	2911500	54	26	19	14	17	15 °	M16	50	40
AZB50-DIN-B	2911700	74	34	28	21	25	15 °	M24	150	50

Pull Studs ISO 7388/II-B with Bore



Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-ISO-A	2920500	44,5	16,4	18,95	12,95	17	45 °	M16	50	40
AZB50-ISO-A	2920700	65	25,5	29	19,6	25	45 °	M24	150	50

Pull Studs ISO 7388-B without Bore

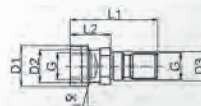


Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-ISO-B	2921500	44,5	16,4	18,95	12,95	17	45 °	M16	50	40
AZB50-ISO-B	2921700	65	25,5	29	19,6	25	45 °	M24	150	50

ACCESSORIES FOR CHUCKS

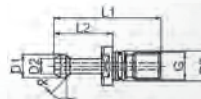
MPC | DPC | UPC | FPC | AFC

Pull Studs DIN 2080 with Inner Thread



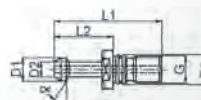
Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-DIN2080-G	2943500	54	25	25	21,6	17	15 °	M16	50	40
AZB50-DIN2080-G	2943700	65	25,1	39,3	32	25	15 °	M24	150	50

Pull Studs BT 45° (JIS B 6339) with Bore



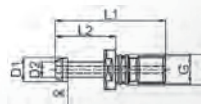
Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB30-BT-45°-A	2930300	43	23	11	7	12,5	45 °	M12	20	30
AZB40-BT-45°-A	2930500	60	35	15	10	17	45 °	M16	50	40
AZB50-BT-45°-A	2930700	85	45	23	17	25	45 °	M24	150	50

Pull Studs BT 30° (JIS B 6339) with Bore



Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB30-BT-30°-A	2931300	43	23	11	7	12,5	30 °	M12	20	30
AZB40-BT-30°-A	2931500	60	35	15	10	17	30 °	M16	50	40
AZB50-BT-30°-A	2931700	85	45	23	17	25	30 °	M24	150	50

Pull Studs BT 90° (JIS B 6339) with Bore

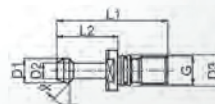


Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-BT-90°-A	2932500	60	35	15	10	17	90 °	M16	50	40
AZB50-BT-90°-A	2932700	85	45	23	17	25	90 °	M24	150	50

ACCESSORIES FOR CHUCKS

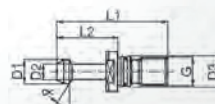
MPC | DPC | UPC | FPC | AFC

Pull Studs BT 45° (JIS B 6339) without Bore



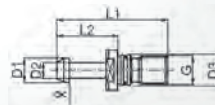
Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB30-BT-45°-B	2933300	43	23	11	7	12,5	45 °	M12	20	30
AZB40-BT-45°-B	2933500	60	35	15	10	17	45 °	M16	50	40
AZB50-BT-45°-B	2933700	85	45	23	17	25	45 °	M24	150	50

Pull Studs BT 30° (JIS B 6339) without Bore



Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB30-BT-30°-B	2934300	43	23	11	7	12,5	30 °	M12	20	30
AZB40-BT-30°-B	2934500	60	35	15	10	17	30 °	M16	50	40
AZB50-BT-30°-B	2934700	85	45	23	17	23	30 °	M24	150	50

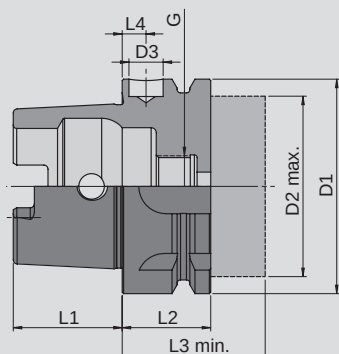
Pull Studs BT 90° (JIS B 6339) without Bore



Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-BT-90°-B	2935500	60	35	15	10	17	90 °	M16	50	40
AZB50-BT-90°-B	2935700	85	45	23	17	25	90 °	M24	150	50

TECHNICAL SECTION

TAPER OVERVIEW



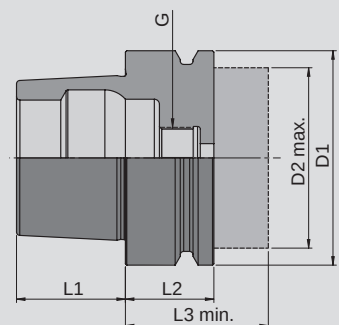
Case-hardened material, hardened and ground
Surface hardness: 58-2 HRC
Minimum core tensile strength: 1,000 N/mm²

Hollow Tapers DIN 69893-1/ISO 12164-1 – HSK-A

HSK-	D1	D2 max.	D3	L1	L2	L3 min.	L4	G
A32	32	26	10	16	20	35	7	M10x1
A40	40	34	-	20	20	35	-	M12x1
A50	50	42	-	25	26	42	-	M16x1
A63	63	53	10	32	26	42	7	M18x1
A80	80	68	10	40	26	42	7	M20x1,5
A100	100	88	10	50	29	45	7	M24x1,5
A125	125	111	10	63	29	45	7	M30x1,5
A160	160	144	10	80	31	47	7	M35x1,5

HSK-A32 to HSK-A63 and A100 in this catalogue – others on request

For **automatic** tool change with gripping and indexing groove.
Manual operation possible through an access hole in the taper, e.g. HSK-A is compatible with interface HSK-C (**manual tool change**).
Torque is transferred by drive slots and the taper.
RFID Chip Holes – standard from range HSK-A63 onwards.



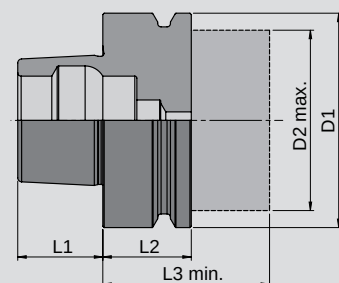
Case-hardened material, hardened and ground
Surface hardness: 58-2 HRC
Minimum core tensile strength: 1,000 N/mm²

Hollow Tapers DIN 69893-5 – HSK-E

HSK-	D1	D2 max.	L1	L2	L3 min.	G
E25	25	20	13	10	20	M8x1
E32	32	26	16	20	35	M10x1
E40	40	34	20	20	35	M12x1
E50	50	42	25	26	42	M16x1
E63	63	53	32	26	42	M18x1

HSK-E25 to E50 in this catalogue – others on request

For **automatic** tool change.
Manual confirmation is **not** possible because no access hole exists in the cone.
Torque is transferred by the taper



Case-hardened material, hardened and ground
Surface hardness: 58-2 HRC
Minimum core tensile strength: 1,000 N/mm²

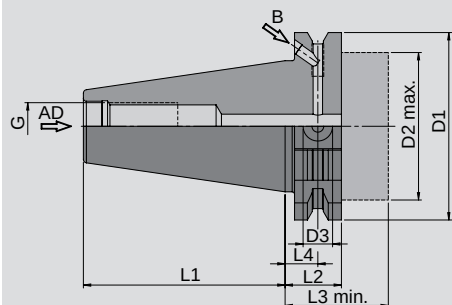
Hollow Tapers DIN 69893-6 – HSK-F

HSK-	D1	D2 max.	L1	L2	L3 min.
F50	50	42	25	26	42
F63	63	53	32	26	42

HSK-F50 to F63 in this catalogue

For **automatic** tool change.
Manual confirmation is **not** possible because no access hole exists in the cone.
Torque is transferred by the taper

HSK Form B, C and D are not common, but available on request.



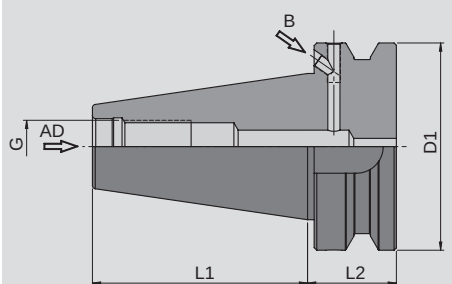
Case-hardened material, hardened and ground
 Surface hardness: 60-2 HRC
 Minimum core tensile strength: 950 N/mm²
 Taper angle tolerance AT₃

Taper Shanks DIN 69871-1 (DIN ISO 7388-1) – SK

SK	D1	D2 max.	D3	L1	L2	L3 min.	L4	G
30	50	45	10	47,8	19,1	35	11,1	M12
40	63,55	50	10	68,4	19,1	35	11,1	M16
50	97,5	80	10	101,75	19,1	35	11,1	M24

SK30 to SK50 in this catalogue

For **automatic** tool change.
 Coolant supply AD (AD) and / or AD/B (B).
 RFID Chip Holes – standard with SK40 and SK50.



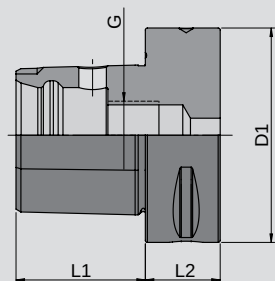
Case-hardened material, hardened and ground
 Surface hardness: 60-2 HRC
 Minimum core tensile strength: 950 N/mm²
 Taper angle tolerance AT₃

Taper Shanks JIS B 6339 (DIN ISO 7388-2) – BT/BTP

BT/BTP	D1	L1	L2	G
30	46	48,4	22	M12
40	63	65,4	27	M16
50	100	101,8	38	M24

BT/BTP30 to BT/BTP50 in this catalogue

For **automatic** tool change.
 Coolant supply AD (BT) and / or AD/B (BTB).
 RFID Chip Holes – on request!



Case-hardened material, hardened and ground
 Surface hardness: 60-2 HRC
 Minimum core tensile strength: 950 N/mm²

Polygonal Shank ISO 26623-1 – PSC

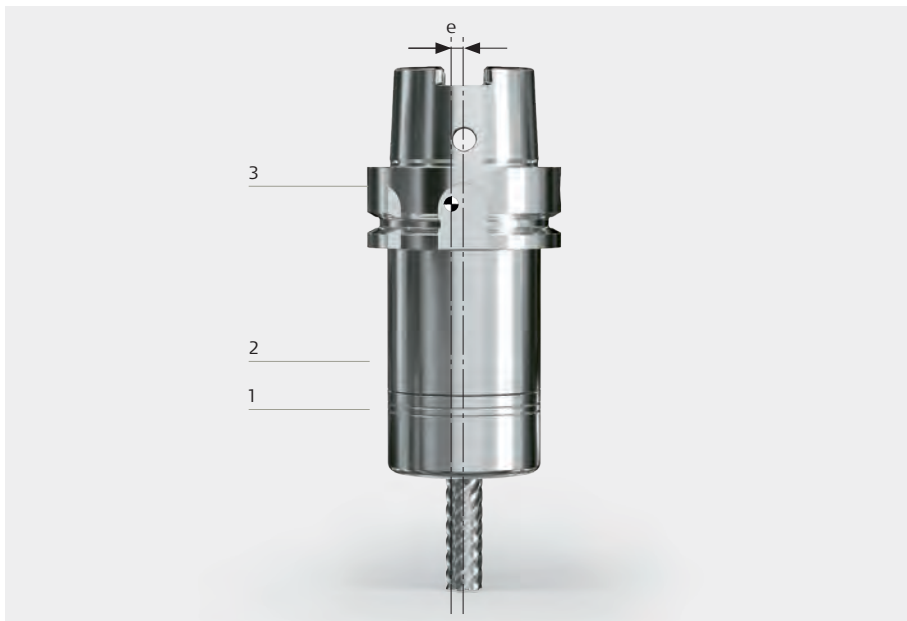
PSC	D1	L1	L2	G
32 (C3)	32	19	15	M12x1,5
40 (C4)	40	24	20	M14x1,5
50 (C5)	50	30	20	M16x1,5
63 (C6)	63	38	22	M20x2
80 (C8)	80	48	30	M20x2

PSC50 to PSC80 in this catalogue – others on request

For **automatic** tool change.
 RFID Chip Holes – on request!

BALANCING

Explanations to our Balancing Information



Imbalance

- Rotor centre of gravity **2** is outside its rotational axis **1** (=offset **e 3**)

Causes

- Unsymmetrical bores and milling at the tool holder (e.g. bei taper shanks DIN ISO 7388-1 (so far DIN 69871) and DIN 69893/ISO 12164 HSK form A and B)
- Unsymmetrical shape of the tool (e.g. clamping surface at the milling cutter)
- Production tolerances (runout)
- Spindle runout

Consequences

Centrifugal forces cause vibrations. These cause:

- Damage to the spindle bearings
- Mediocre surface quality
- Insufficient repeatability of accuracy
- Reduction in tool life
- Noise

Requirements

Balancing is necessary whenever optimum working conditions have to be achieved e.g.:

- Surface quality
- Production accuracies
- Tool operational life
- or if prescribed by the machine tool manufacturer (warranty claims!)

However, it is only economically sensible to balance at speeds of 8,000 rpm or higher. At speeds lower than this the cutting forces are as a rule greater than the imbalance forces.

Balancing means – determining the centre of gravity axis and moving it back to the axis of rotation.

What Balance Grade

Our CENTRO|P precision collet chucks are fine balanced as standard.

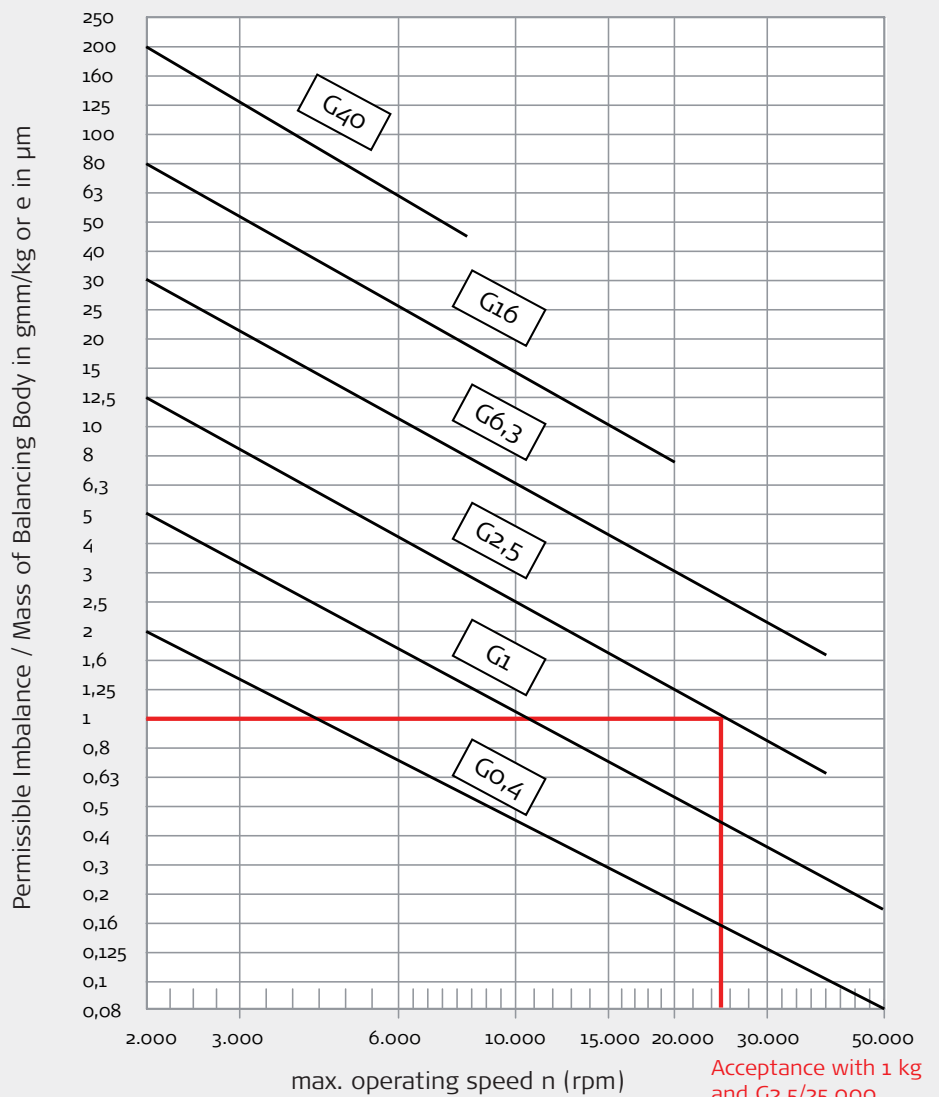
Limits to Balancing Grade

According to ISO standard 1940, the balancing standard is described using G. The balancing standard G corresponds to g/mmkg or μm and is in relation to the speed.

As an explanation: At a speed of 9,500 rpm and a weight of 1 kg G2,5 means a permissible offset between the rotational axis and the centre of gravity axis of the spindle of 2.5 μm . At a speed of 19,000 rpm it would be 1.25 μm and at 38,000 rpm 0.625 μm . If the tool holder together with the tool weighs half the amount, i.e. 0.5 kg, the balance will also be halved.

Until now, so as to minimise guarantee claims the machine or spindle manufacturers demanded such excessively fine balancing that their demands could only be met by balancing the chuck and the cutter on the machine spindle.

In order to avoid the high economic costs this caused, draft standard DIN 69888 covering balancing requirements on rotating tool systems was agreed jointly by the machine, spindle, balancing machine and tool manufacturers. The standard is a sensible solution in both technical and economic terms, since in that norm all residual imbalances are indicated in „gmm“ and **not** assigned to a balance grade. Moreover, possible tool change faults are considered.



Grade steps to DIN ISO 1940-1

Permissible residual imbalances in relation to the balancing body weight for different grade steps G depending on the highest operating speed

General Formula

$$G = e \times \omega = \frac{U}{m_R} \times \frac{2 \times \pi \times n}{60} = \frac{U \times \pi \times n}{m_R \times 30}$$

$$\text{then } U = \frac{G \times m_R \times 30}{\pi \times n}$$

G = Balancing grade step

e = Centre of gravity concentricity, related imbalance

n = Speed

U = Imbalance

ω = Angular velocity

m_R = Weight of the tool or the rotor

[mm/s]

[gmm/kg or μm]

[rpm]

[gmm]

[1/sec]

[g]

BALANCING

Explanations to our Balancing Information

Calculation of the Total Balancing Grade
of the assembled system (spindle • tool holder • tool)

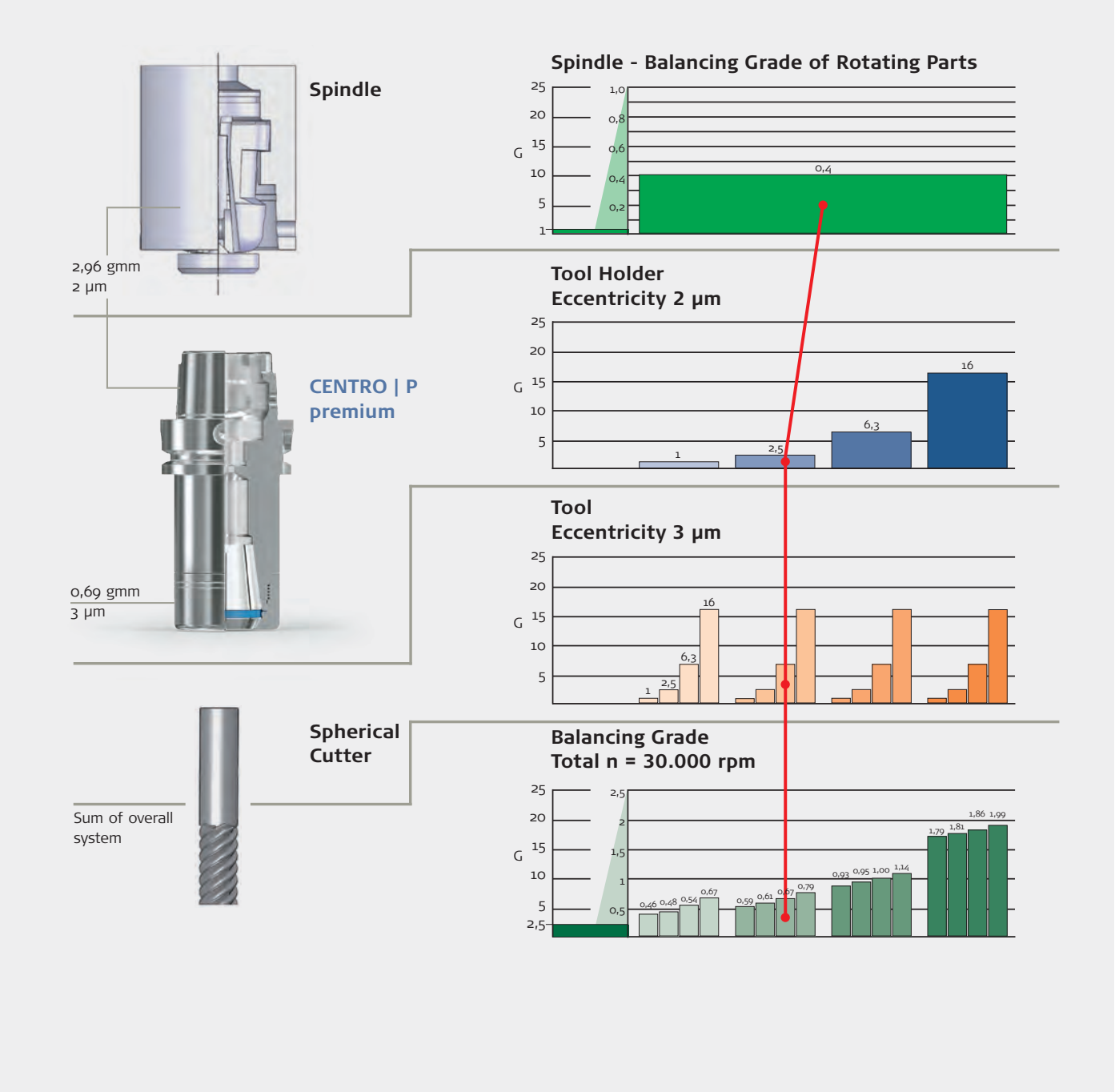


Illustration of Balancing Grade Total

$$U_{\text{total}} = U_{\text{Spindle}} + U_{\text{Tool holder}} + U_{\text{Tool}}$$

Example

$$U_{\text{total}} = U_{\text{Spindle (G 0,4)}} + U_{\text{Tool holder (G2,5)}} + U_{\text{Tool (G6,3)}}$$

Calculation of Eccentricity

$$U = \frac{G \times 60}{2 \times \pi \times n} \times m$$

		m in g	U in gmm
U_{Spindle}	$= \frac{0,4 \times 60}{2 \times \pi \times 30.000} \times$	15.000	$= 1,910$
$U_{\text{Tool holder}}$	$= \frac{2,5 \times 60}{2 \times \pi \times 30.000} \times$	1.487	$= 1,176$
U_{Tool}	$= \frac{6,3 \times 60}{2 \times \pi \times 30.000} \times$	230	$= 0,461$
		16.708	3,547
		$m_{\text{total in g}}$	$U_{\text{total in gmm}}$

Balancing grade conversion of the total system

$$G = U_{\text{total}} \times 2 \times \pi \times \frac{n}{60 \times m_{\text{total}}}$$

Example

$$G = 3,547_{\text{gmm}} \times 2 \times \pi \times \frac{30.000 \times \text{rpm}}{60 \times 16.708\text{g}} = 0,67$$

Calculation scheme with kind permission of Gühring oHG, Albstadt

EXPLANATIONS

All items with a bold item number are in stock.
All other items are available either from stock
or at short notice.



All products with this symbol are protected
with FAHRION | Protect



Concentricity
Measured at 3 x D overhang

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