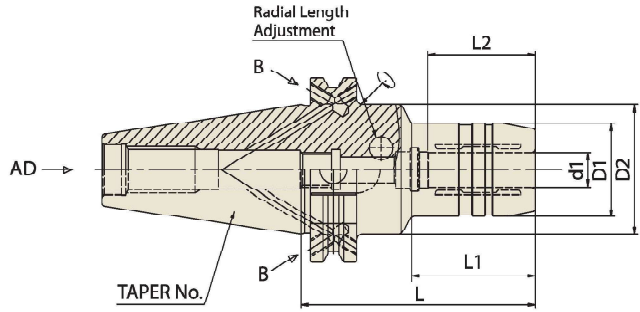


HYDRAULIC CHUCK (RADIAL TOOL LENGTH PRE-SETTING TYPE)

CAT



ASME B5.50 - CAT	Taper Accuracy AT3	G Value 2.5	RPM 25,000	Run-Out (at 3D) ≤0.00012"	Coolant System AD/B
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ASME B5.50-2009-CAT

Unit : mm

EDP No.	TAPER No.	MODEL No.	d1	D1	D2	L	L1	L2
WK100HCR	40	CAT40AD/B-HCR12-80.5	12	32	49.5	80.5	31.5	37
WK102HCR		CAT40AD/B-HCR20-80.5	20	42	49.5	80.5	34	42
WK104HCR		CAT40AD/B-HCR32-110	32	64	80	110	50	55
WL100HCR	50	CAT50AD/B-HCR12-80.5	12	32	49.5	80.5	31.5	37
WL102HCR		CAT50AD/B-HCR20-80.5	20	42	49.5	80.5	34	42
WL104HCR		CAT50AD/B-HCR32-100	32	60	60	100	-	55

* Applicable Hydraulic Chuck collets(reduction sleeves) on page 29~36.

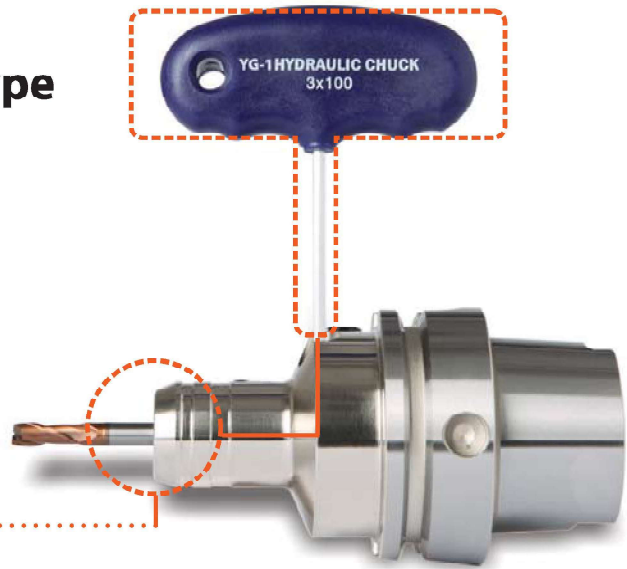
TECHNICAL INFORMATION

HYDRAULIC CHUCK



Radial Tool Length Pre-setting Type

- Easy to adjust pre-setting length of cutting tool (Saving time to pre-set cutting tool to one fifth compared with conventional Hydraulic Chuck)
- Precise adjustment of cutting tool length
- Designed to separate tool length adjustment screw from clamping screw



Adjustable range of cutting tool length : 0~0.394"

APPLICATION

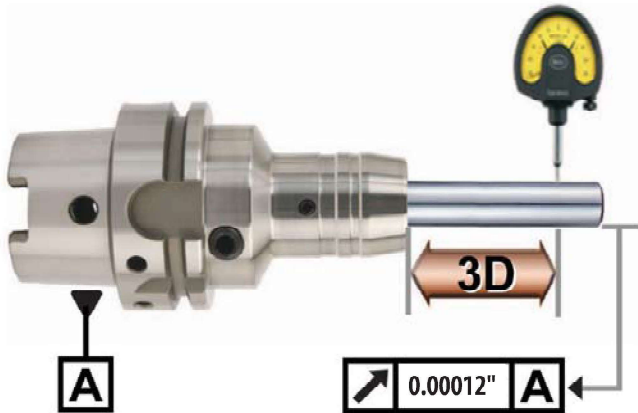
Milling	High Speed Cutting	Fine Drilling
Reaming	Tapping & Thread Milling	Chamfering

TECHNICAL INFORMATION

HYDRAULIC CHUCK

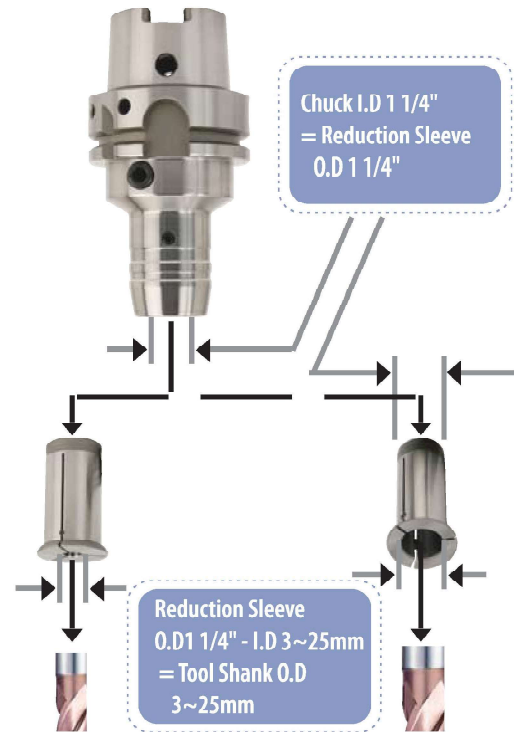


- **High precision T.I.R :**
 $\leq 0.00012''$ (Without Reduction Sleeve)

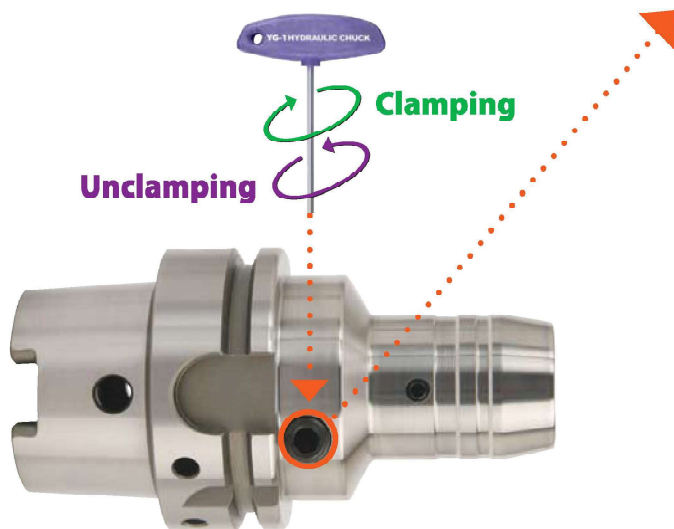


- Less than 0.00012" T.I.R
 => Suitable for high-speed precision machining

- **Flexible use of cutting tools by using reduction sleeves**

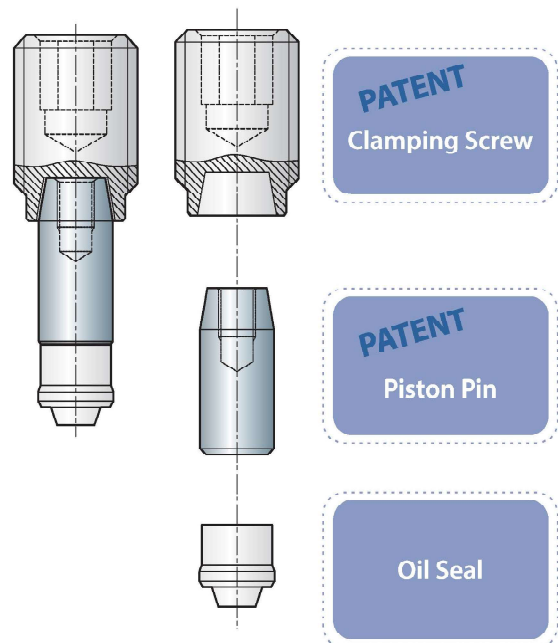


- **Easy Tool Change**



- Easy clamping and unclamping by use of T wrench
 => Reducing tool change time

CLAMPING SCREW



TECHNICAL INFORMATION

HYDRAULIC CHUCK



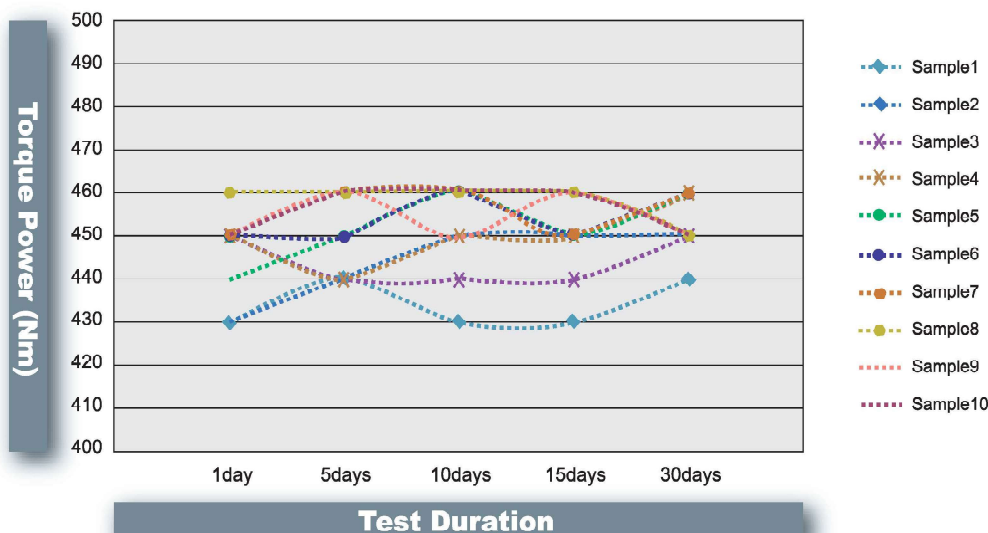
● Strong Torque Power

Hydraulic Chuck I.D(mm)	Tool Shank O.D(mm)	Applicable RPM	Minimum Clamping Depth (mm)		Min. Torque Power (Nm)	
			Slim	Power E Hydro	Slim	Power E Hydro
6	6	40,000	27		16	
8	8	40,000	27		23	
10	10	40,000	32		45	
12	12	40,000	27	41	90	110
14	14	40,000	37		110	
16	16	40,000	42		185	
18	18	40,000	42		240	
20	20	40,000	42	48	330	520
25	25	25,000	48		400	
32	32	25,000	55	57	650	900

- Tool Holder I.D Tolerance : H6
- Operating Temperature : 20~25 °C
- Maximum pressure of coolant oil : 80bar



● Test of Torque Power and Hydraulic Oil Leakage



- Test Model : BT40AD/B-HC20-90
- No oil leakage for long period ⇒ Maintaining stable torque power

TECHNICAL INFORMATION

T.I.R and TOLERANCE

● T.I.R (Total Indicated Run-out)

HYDRAULIC CHUCK

Concentric to 0.00012" T.I.R (at 3D)

SHRINK FIT HOLDER

Concentric to 0.00012" T.I.R (at I.D)

ER COLLET CHUCK

Concentric to 0.0002" T.I.R (at I.D)

END MILL HOLDER

Concentric to 0.0002" T.I.R (at I.D)

SLITTING SAW ARBOR

Face perpendicular to taper within 0.0002" T.I.R (at I.D)

STUB ARBOR

Face perpendicular to taper within 0.0002" T.I.R (at I.D)

SHELL MILL ARBOR

Face perpendicular to taper within 0.0001" T.I.R

Out diameter to taper within 0.0002" T.I.R

MORSE & JACOBS TAPER ARBOR

Concentric to 0.0003" T.I.R

* To put tool precisely on spindle center line for getting correct T.I.R.

● AT3 or better accuracy on all shank tapers

● Accurate and rigid tool holder mounting to spindle

● The bore diameter of all tool holders is controlled by H5 grade tolerance limit.

TAPER	AT3
#30	0.000078"
#40	0.00012"
#50	0.00016"