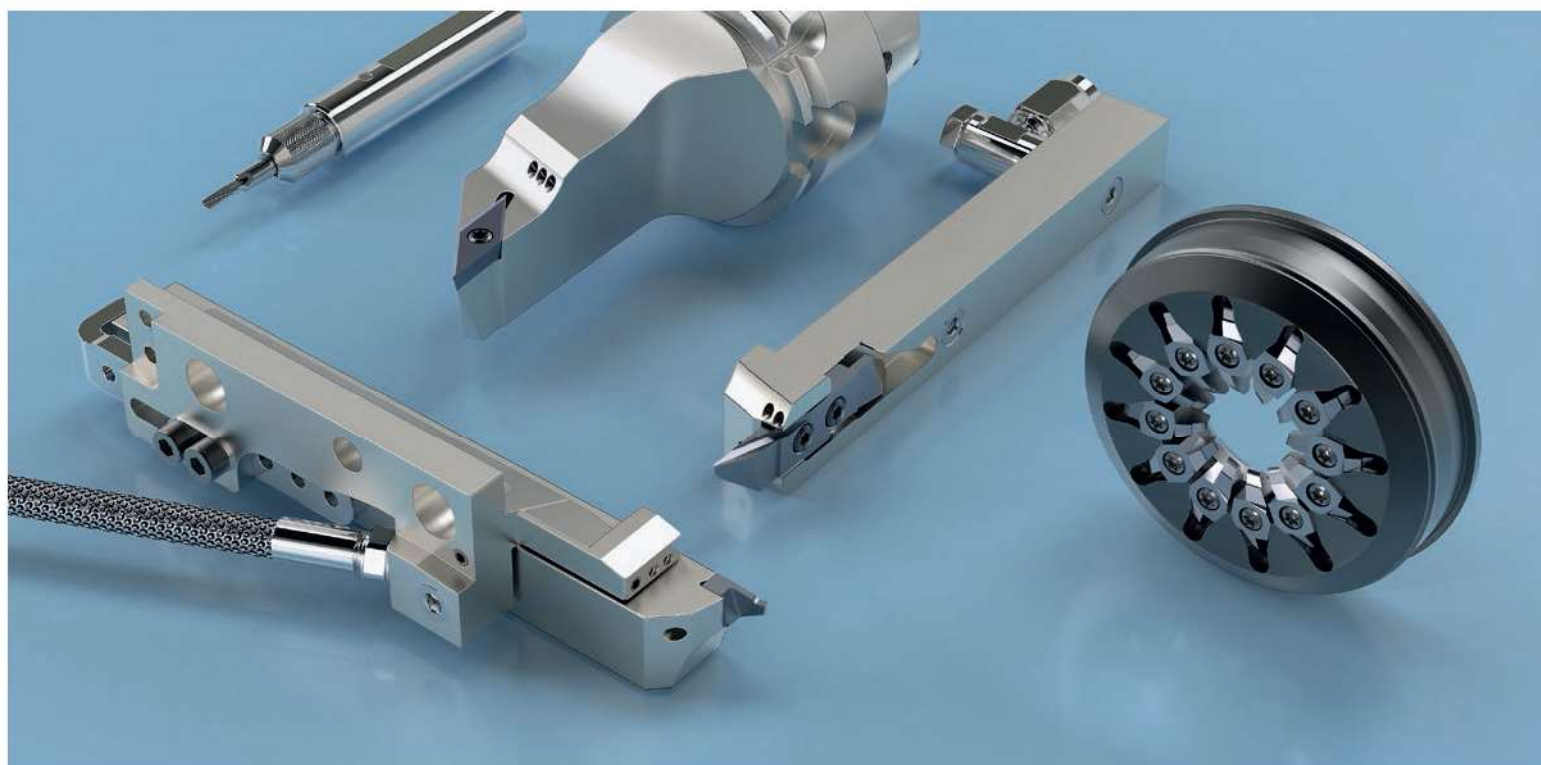


GENERAL CATALOG 2020/21



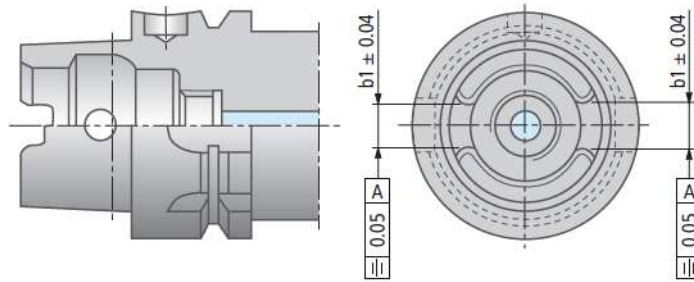
**PRECISION TOOLS
FOR SMALL PART MANUFACTURING AND MICRO-CUTTING**

Use of the multidec®-HSK-system with ISO 12164/DIN 69893 standardized attachment has become increasingly widespread in recent years. This system makes the customer independent from specific tool system, which is a great advantage. Simplicity, precision and reliability: these are the criteria that customers place on modern tool systems. HSK tools largely satisfy these demands and help to maximize productivity. The program comprises a wide selection of tool holders for both OD and ID turning on lathes. The standard range has been developed in size 32 and form "C" for manual tool changing. Now we propose a new size 40 in form HSK-T for the automatic- and manual tool change. Other HSK shapes and sizes are available on request.

**Advantages:**

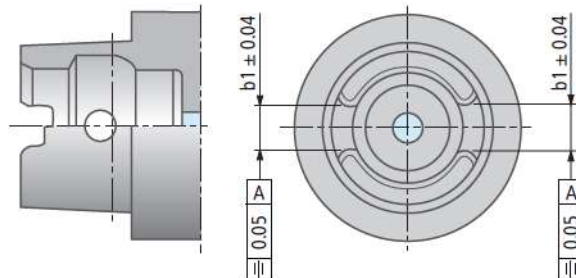
- Large program of toolholders in heat-treatable steel, with internal cooling, available from stock
- Holder with high rigidity and repeat accuracy
- High precision in positioning of cutting edge, cause of the axial positioning and the close tolerance of the holder keyway HSK-T standard ISO 12164
- Utilisation of high quality UTILIS multidec®-inserts

HSK – Form A



- Used on machining centers, milling machines, turning machines, special machines with automatic tool change
- Central, axial coolant supply through coolant tube
- Torque transmission via two key slots at end of taper
- Two slots on collar for tool magazine, location edge hole for data carrier in collar

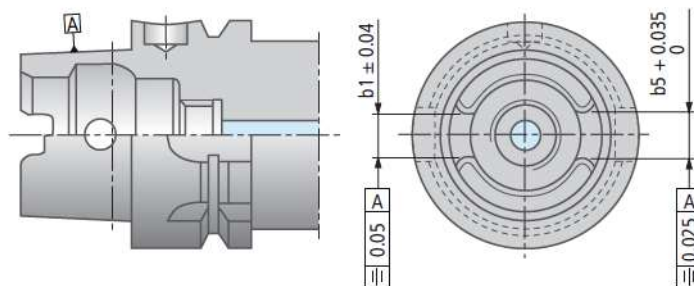
HSK – Form C



- Preferably used for spindles on transfer lines and special machines without automatic tool change or for short bore spindles and tool extensions and reductions
- Central, axial coolant supply
- Torque transmission via two key slots at end of taper

538

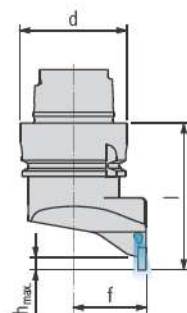
HSK – Form T



Tighter tolerance for perfect change precision

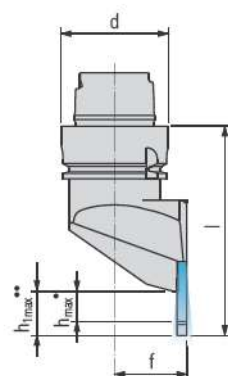
The "T" stands for "Turning". HSK-T combines the basic shape of the HSK taper in form A/C and differs by closer tolerances of the cam grooves on the cone of the tools.

This important feature for turning assures accurate radial positioning (center height).



HSK... CUT 1600 .

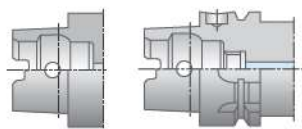
Order designation				Form / Size	Dimensions					Inserts
L		R		HSK	d	f	l		h _{max}	□49...
HSK-C32 CUT 1600 L	■	HSK-C32 CUT 1600 R	■	C32	32	22	40		5	16...
HSK-T40 CUT 1600 L	■	HSK-T40 CUT 1600 R	■	A40 / C40	40	27	55		5	16...



HSK... CUT 3000 .

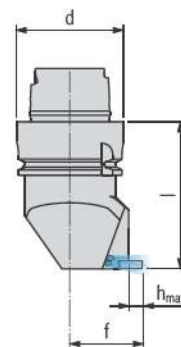
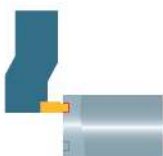
Order designation				Form / Size	Dimensions							Inserts
L		R		HSK	d	f	l			h _{max}	h _{1max}	□ 111...
HSK-C32 CUT 3000 L	■	HSK-C32 CUT 3000 R	■	C32	32	22	50			10	16	30...
HSK-T40 CUT 3000 L	■	HSK-T40 CUT 3000 R	■	A40 / C40	40	27	73			10	16	30...

• Short insert; •• Long insert



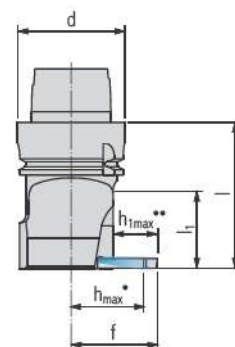
HSK-C... HSK-T (A/C)... Versions □538

Legend □8...



HSK... CUT 1600-90 .

Order designation				Form / Size	Dimensions						Inserts*
				HSK	d	f	l			h _{max}	□49...
L		R									
HSK-C32 CUT 1600-90 L	■	HSK-C32 CUT 1600-90 R	■	C32	32	22	40			5	16...
HSK-T40 CUT 1600-90 L	■	HSK-T40 CUT 1600-90 R	■	A40 / C40	40	27	55			5	16...

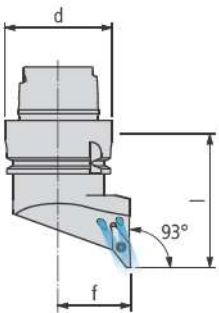
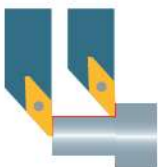


HSK... CUT 3000-90 .

Order designation				Form / Size	Dimensions							Inserts*
<div>L</div>		<div>R</div>		HSK	d	f	l	l ₁		h _{max}	h _{1max}	<div>□ 111...</div>
HSK-C32 CUT 3000-90 L	■	HSK-C32 CUT 3000-90 R	■	C32	32	22	40	24		10	—	30...
HSK-T40 CUT 3000-90 L	■	HSK-T40 CUT 3000-90 R	■	A40 / C40	40	27	55	30		10	16	30...

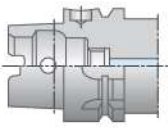
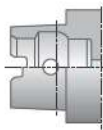
• Short insert; •• Long insert

*** Attention**
Right hand holder needs left hand insert!

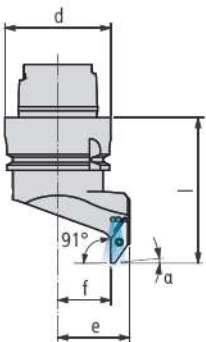


HSK... SVJP... (93°)

Order designation				Form / Size	Dimensions								Inserts
L		R		HSK	d	f	l						305...
HSK-C32 SVJPL 10	■	HSK-C32 SVJPR 10	■	C32	32	22	40						VP...1003...
HSK-T40 SVJPL 10	■	HSK-T40 SVJPR 10	■	A40 / C40	40	27	55						VP...1003...



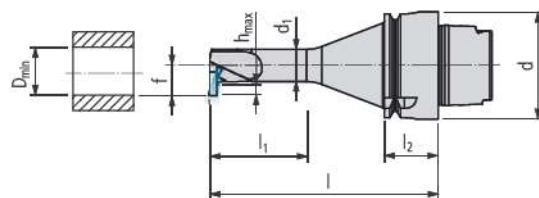
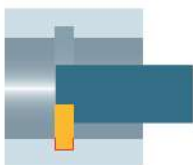
HSK-C... HSK-T (A/C)... Versions 538



HSK... SVXP... (91°)

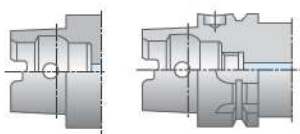
Order designation				Form / Size	Dimensions							Inserts*
				HSK	d	f	l	e			a	□305...
<div> <div>L</div> <div></div> </div>		<div> <div>R</div> <div></div> </div>		C32	32	15	40	22			3°	VP...1003...
<div> <div>L</div> <div></div> </div>		<div> <div>R</div> <div></div> </div>		A40 / C40	40	20	55	27			3°	VP...1003...

* Attention
 Right hand holder needs left hand insert!



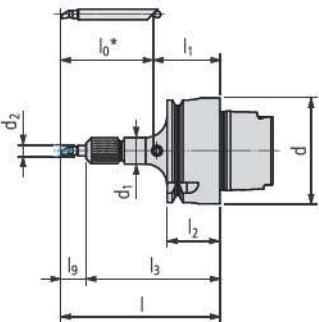
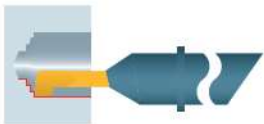
HSK... CUT 1600... RD

Order designation				Form / Size	Dimensions								Inserts* □ 49...
L		R			HSK	d	f	l	D _{min}	l ₁	l ₂	d ₁	
HSK-C32 CUT 1600-12 RD L	■	HSK-C32 CUT 1600-12 RD R	■	C32	32	11	75	17.5	36	10	12	3	16...
HSK-C32 CUT 1600-16 RD L	■	HSK-C32 CUT 1600-16 RD R	■	C32	32	13	75	21	48	10	16	4	16...
HSK-C32 CUT 1600-20 RD L	■	HSK-C32 CUT 1600-20 RD R	■	C32	32	15	75	25	60	10	20	4	16...
HSK-T40 CUT 1600-12 RD L	■	HSK-T40 CUT 1600-12 RD R	■	A40 / C40	40	11	85	17.5	36	20	12	3	16...
HSK-T40 CUT 1600-16 RD L	■	HSK-T40 CUT 1600-16 RD R	■	A40 / C40	40	13	85	21	48	20	16	4	16...
HSK-T40 CUT 1600-20 RD L	■	HSK-T40 CUT 1600-20 RD R	■	A40 / C40	40	15	85	25	60	20	20	4	16...



HSK-C... HSK-T (A/C)... Versions □ 538

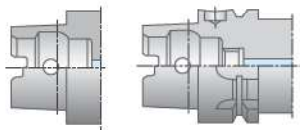
*** Attention**
Right hand holder needs left hand insert!



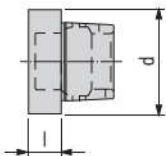
HSK... SDA...

Order designation		Form / Size	Dimensions								Inserts
N		HSK	d	l	l ₀	l ₁	l ₂	l ₃	d ₁	d ₂	□ 335...
HSK-C32 SDA-4	■	C32	32	l ₀ +l ₁	l-l ₃	15	10	40.5	10	4	SD.4.../SX.4...
HSK-C32 SDA-6	■	C32	32	l ₀ +l ₁	l-l ₃	15	10	44.5	15	6	SD.6.../SX.6...
HSK-C32 SDA-8	■	C32	32	l ₀ +l ₁	l-l ₃	15	10	46.5	18	8	SD.8.../SX.8...
HSK-T40 SDA-4	■	A40 / C40	40	l ₀ +l ₁	l-l ₃	25	20	50.5	10	4	SD.4.../SX.4...
HSK-T40 SDA-6	■	A40 / C40	40	l ₀ +l ₁	l-l ₃	25	20	54.5	15	6	SD.6.../SX.6...
HSK-T40 SDA-8	■	A40 / C40	40	l ₀ +l ₁	l-l ₃	25	20	56.5	18	8	SD.8.../SX.8...

* The length of the insert is variable



HSK-C... HSK-T (A/C)... Versions □ 538



HSK... VS

Order designation		Form / Size	Dimensions								
		HSK	d	l							
HSK-C32 VS	■	C32	32	10							
HSK-C40 VS	■	C40	40	15							

For holders (CUT/SC/SD/SV...) OD turning

Illustration	Description	Dimensions	Order designation		Holder
	TORX screw	M2.5 × 6 T08	MSP 25060 T08	■	HSK ... CUT 1600 ... HSK ... SV.P ...
		M3 × 9 T08	MSP 30090 T08	■	HSK ... CUT 3000 ...

For holders (CUT/SC/SD/SV...) ID turning

Illustration	Description	Dimensions	Order designation		Holder	Inserts
	TORX screw	M2.5 × 6 T08	MSP 25060 T08	■	HSK ... CUT 1600 ... RD	
	Nut	M8 × 0.5	MSP SDA 4M	■	HSK...SDA-4.	
		M12 × 0.6	MSP SDA 6M	■	HSK...SDA-6.	
		M14 × 0.75	MSP SDA 8M	■	HSK...SDA-8.	
	Aligning device		SDA 4X	■	HSK...SDA-4.	
			SDA 6X	■	HSK...SDA-6.	
			SDA 8X	■	HSK...SDA-8.	
	Retaining ring		MSP SDA 4S	■		SD. 4... SX. 4...
			MSP SDA 6S	■		SD. 6... SX. 6...
			MSP SDA 8S	■		SD. 8... SX. 8...

TORX screwdriver  651...