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HAIMER®

HAIMER.

Tool
Holders

TOOL HOLDERS



DIN ISO 7388-1 SK30/SK40/SK50

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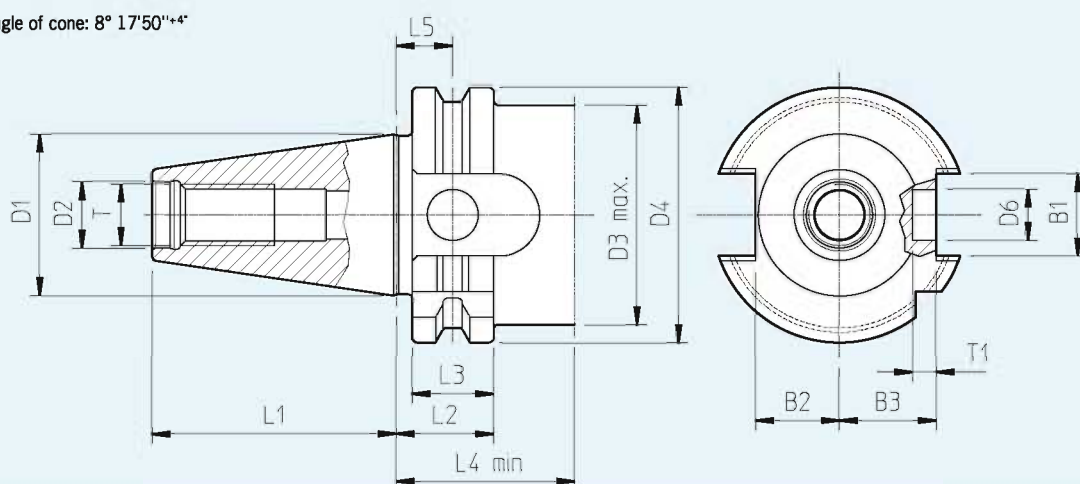
STEEP TAPER DIN ISO 7388-1 · SK30/SK40 (FORMERLY DIN 69871)

Design:

- Tool holders case-hardened 60–2 HRC
- Tensile strength in the core at least 950 N/mm²
- Taper in tolerance quality AT3
- Form AD/AF: interior coolant supply through center (form AD) and through the collar, (form AF)
- Incl. bore for data chip Ø 10 mm

SK30

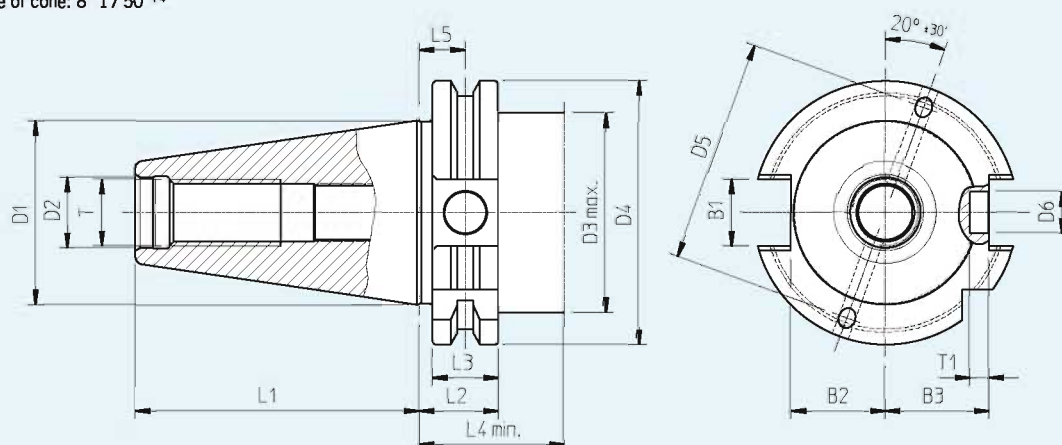
– Angle of cone: $8^{\circ} 17'50''^{+4^{\circ}}$



SK30	D1	D2	D3 max.	D4	D5	D6	L1	L2	L3	L4 min.	L5	T	T1	B1	B2	B3
[mm]	31.75	13	43	50	—	10	47.	19.1	15.9	35	11.1	M12	4.65	16.1	16.4	19

SK40

– Angle of cone: $8^{\circ} 17'50''^{+4^{\circ}}$



SK40	D1	D2	D3 max.	D4	D5	D6	L1	L2	L3	L4 min.	L5	T	T1	B1	B2	B3
[mm]	44.45	17	48	63.55	54	10	68.4	19.1	15.9	35	11.1	M16	4.65	16.1	22.8	25

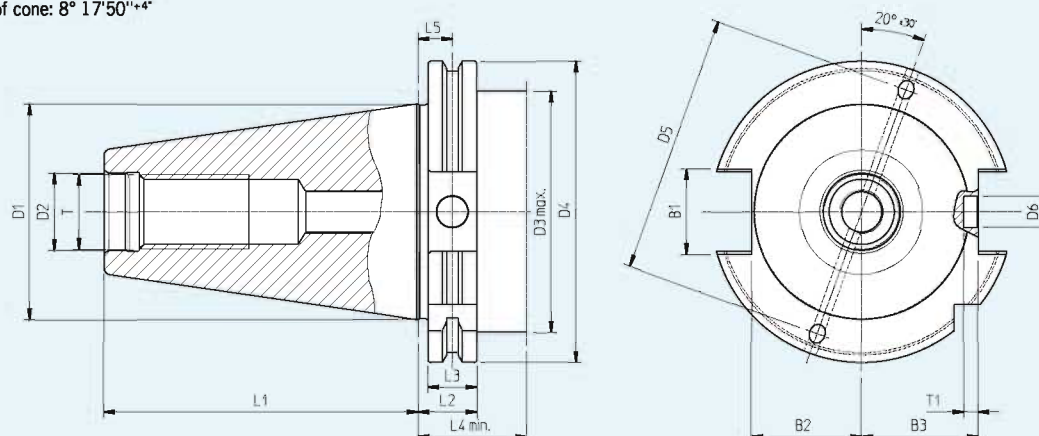
STEEP TAPER DIN ISO 7388-1 · SK50 (FORMERLY DIN 69871)

Design:

- Tool holders case-hardened 60–2 HRC
- Tensile strength in the core at least 950 N/mm²
- Taper in tolerance quality AT3
- Form AD/AF: interior coolant supply through center (form AD) and through the collar, (form AF)
- Incl. bore for data chip Ø 10 mm

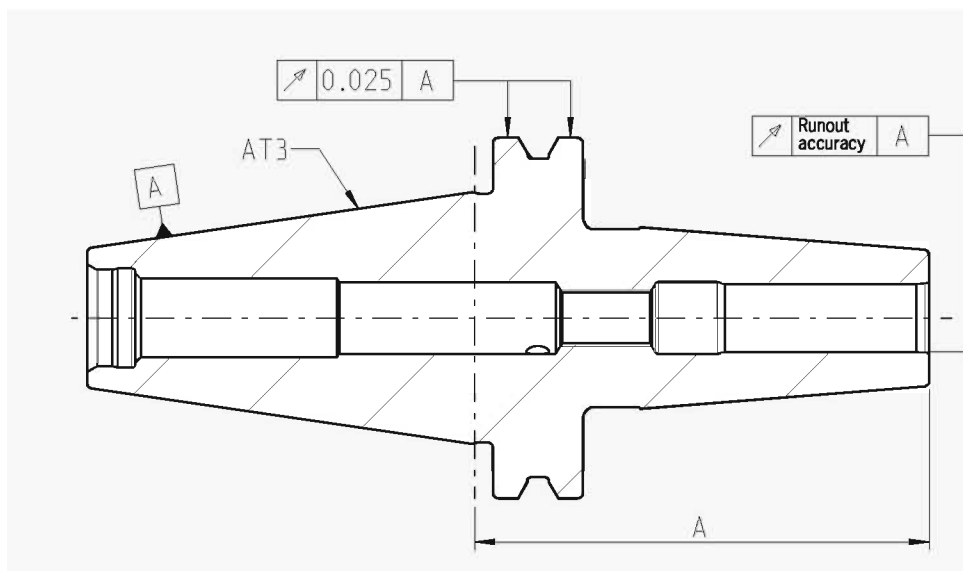
SK50

- Angle of cone: $8^{\circ} 17' 50'' \pm 4''$



SK50	D1	D2	D3 max.	D4	D5	D6	L1	L2	L3	L4 min.	L5	T	T1	B1	B2	B3
[mm]	69.85	25	78	97.5	84	10	101.75	19.1	15.9	35	11.1	M24	4.65	25.7	35.5	37.7

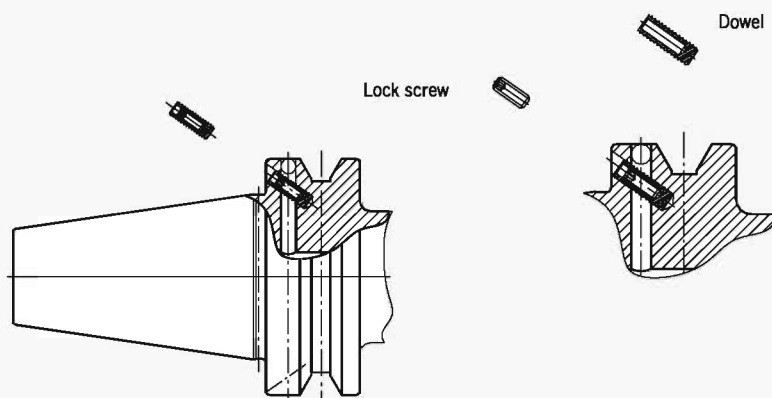
RUNOUT ACCURACY **DIN ISO 7388-1** **(FORMERLY DIN 69871)**



Gage length	A < 160	A ≥ 160
max. runout tolerance in mm		
Shrink Fit Chuck	0.003	0.004
Collet Chuck ER	0.003	0.004
Power Collet Chuck	0.003	0.004
High Precision Collet Chuck	0.003	0.004
High Precision Chuck	0.003	0.003
Weldon Tool Holder	0.003	0.004
Face Mill Arbor	0.006	0.006
Adapter for Morse Taper	0.008	—
Adapter SK40/SK50	0.005	—
Drill Chuck Adapter	0.005	—

COOLANT DIN ISO 7388-1 (FORMERLY DIN 69871)

Attention: each dowel for single use only!



According to DIN ISO 7388-1, 3 possibilities of inner coolant supply are available:

- **Form A:** no inner coolant supply
- **Form AD:** central coolant supply through retention knob.
A retention knob with centralized bore is required.
- **Form AF:** lateral coolant supply via the collar.
A sealed retention knob is required.

HAIMER tool holders with taper according to DIN ISO 7388-1 are produced in form AD/AF unless otherwise noted.

Form AD/AF means the tool holders are equipped with bores for form AD as well as for form AF. Unless otherwise requested, the tool holders are delivered in form AD. The bores on the flange, for form AF are then sealed with plastic-dowels and secured with lock screws.

For changing to form AF, the bores at the collar, must be opened by unscrewing the lock screw halfway. Removal of screws together with the dowels are done by using pliers.

The bores also can be sealed again. A conversion kit consisting of dowels and lock screws is available (please refer to accessories).

– Spare part

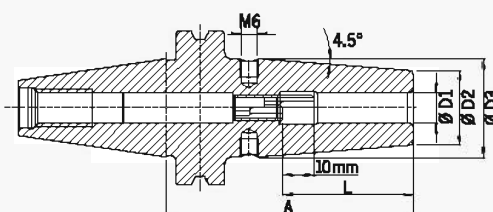
Dowel

Order No. 85.600.40 (SK40)

Order No. 85.600.50 (SK50)

(incl. 50 pcs)

SHRINK FIT CHUCK DIN ISO 7388-1 · SK30 (FORMERLY DIN 69871)



CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced
G2.5 25,000 rpm or U<1 gmm
- ☒ All functional surfaces fine machined
- ☒ Taper tolerance AT3

Use:

Suitable for all shrinking units.

With taper **DIN ISO 7388-1 SK30 form AD**.

- Heat resistant hot-working steel
- Hardened 54–2 HRC
- For HSS and solid carbide tools
- Shank tolerance h6
- With threaded holes in order to balance with balancing screws
- Included in delivery: Shrink fit chuck with back-up screw
- Cooling with Cool Jet for an extra charge (see page 501)
- Cooling with Cool Flash for an extra charge (See pages 502–503)

Standard version, similar to DIN 69882-8

Clamping	Ø D1 [mm]	03	04	05	06	08	10	12	16
	Ø D2 [mm]	10	10	10	21	21	24	24	27
	Ø D3 [mm]	—	—	—	27	27	32	32	34
	L [mm]	09	12	15	36	36	42	47	50
Length A [mm]	short	80 ¹⁾	80 ¹⁾	80 ¹⁾	80	80	80	80	80
Order No.	30.440...	.03	.04	.05	.06	.08	.10	.12	.16

Ultra short version

Clamping	Ø D1 [mm]	03	04	06	08	10	12	16	20
	Ø D2 [mm]	10	10	23	23	27	27	30	35.5
	Ø D3 [mm]	—	—	—	—	—	—	—	40.5
	L [mm]	09	12	36	36	42	47	50	52
Length A [mm]	ultra short	60 ¹⁾	60 ¹⁾	60 ²⁾	60 ²⁾	60 ²⁾	60 ²⁾	65 ²⁾	70 ²⁾
Order No.	30.445...	.03	.04	.06	.08	.10	.12	.16	.20

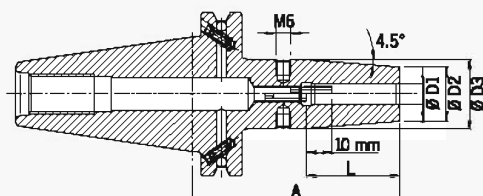
Accessories

Shrink fit extensions		See pages 751–753
Balancing screws		See page 784
Pull studs		See pages 789–791
Reduction sleeves		See page 794
Back-up screws		See pages 796–799
Cool Jet bores		See page 501
Cool Flash		Order No. 91.100.40 See pages 502–503
Cool Flash Upgrade Incl. Cool Jet		Order No. 91.100.41 See pages 502–503

SHRINK FIT CHUCK DIN ISO 7388-1 · SK40 (FORMERLY DIN 69871)

CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced
G2.5 25,000 rpm or U<1 grmm
- ✓ All functional surfaces fine machined
- ✓ Taper tolerance AT3
- ✓ Coolant supply form AD/AF



Use:

Suitable for all shrinking units.

With taper **DIN ISO 7388-1 SK40 form AD/AF**.

Form AD/AF means central coolant supply and coolant channels through the flange which can be sealed again.

- Heat resistant hot-working steel
- Hardened 54–2 HRC
- For HSS and solid carbide tools
- Shank tolerance h6
- With threaded holes in order to balance with balancing screws
- Included in delivery: Shrink fit chuck with back-up screw

- Cooling with Cool Jet for an extra charge (see page 501)
- Cooling with Cool Flash for an extra charge (See pages 502–503)

Standard version, similar to DIN 69882-8

Clamping	Ø D1 [mm]	03	04	05	06	08	10	12	14	16	18	20	25	32
Ø D2 [mm]		10	10	10	21	21	24	24	27	27	33	33	44	44
Ø D3 [mm]		—	—	—	27	27	32	32	34	34	42	42	53	53
L [mm]		09	12	15	36	36	42	47	47	50	50	52	58	58
Length A [mm]	short	80 ¹⁾	80 ¹⁾	80 ¹⁾	80	80	80	80	80	80	80	80	100	100
Order No.	40.440...	.03.1	.04.1	.05.1	.06	.08	.10	.12	.14	.16	.18	.20	.25	.32
Length A [mm]	ZG120	120 ²⁾	120 ²⁾	120 ²⁾	120	120	120	120	120	120	120	120	120	120
Order No.	40.447...	.03.1	.04.1	.05.1	.06	.08	.10	.12	.14	.16	.18	.20	.25	.32
Length A [mm]	ZG130	130 ²⁾	130 ²⁾	130 ²⁾	130	130	130	130	130	130	130	130	130	130
Order No.	40.444...	.03.1	.04.1	.05.1	.06	.08	.10	.12	.14	.16	.18	.20	.25	.32
Length A [mm]	oversize	—	—	—	160	160	160	160	160	160	160	160	160	—
Order No.	40.442...	—	—	—	.06	.08	.10	.12	.14	.16	.18	.20	.25	—
Length A [mm]	ZG200	—	—	—	200	200	200	200	200	200	200	200	200	—
Order No.	40.446...	—	—	—	.06	.08	.10	.12	.14	.16	.18	.20	.25	—

Standard version, with Cool Jet (Ø 3–5 mm cooling with slits)

Clamping	Ø D1 [mm]	03	04	05	06	08	10	12	14	16	18	20	25	32
Ø D2 [mm]		10	10	10	21	21	24	24	27	27	33	33	44	44
Ø D3 [mm]		—	—	—	27	27	32	32	34	34	42	42	53	53
L [mm]		09	12	15	36	36	42	47	47	50	50	52	58	58
Length A [mm]	short	80 ³⁾	80 ³⁾	80 ³⁾	80	80	80	80	80	80	80	80	100	100
Order No.	40.440...	.03	.04	.05	.06.2	.08.2	.10.2	.12.2	.14.2	.16.2	.18.2	.20.2	.25.2	.32.2

Standard version, with Safe-Lock pull out protection

Clamping	Ø D1 [mm]	06	08	10	12	14	16	18	20	25	32
Ø D2 [mm]		21	21	24	24	27	27	33	33	44	44
Ø D3 [mm]		27	27	32	32	34	34	42	42	53	53
L [mm]		36	36	42	47	47	50	50	52	58	58
Length A [mm]	short	80 ³⁾	80 ³⁾	80 ³⁾	80 ³⁾	80 ³⁾	80 ³⁾	80 ³⁾	80 ³⁾	100 ³⁾	100 ³⁾
Order No.	40.440...	.06.7	.08.7	.10.7	.12.7	.14.7	.16.7	.18.7	.20.7	.25.7	.32.7

1) Without back-up screw, without thread for balancing screws, without slits along the clamping bore for cooling from outside

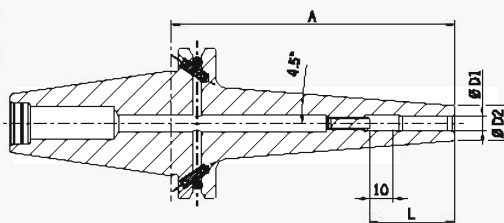
2) Without back-up screw, without thread for balancing screws, with slits along the clamping bore for cooling from outside

3) With tension spring

SHRINK FIT CHUCK EXTRA SLIM

DIN ISO 7388-1 · SK40

(FORMERLY DIN 69871)



CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced
G2.5 25,000 rpm or U<1 gmm
- ☒ All functional surfaces fine machined
- ☒ Taper tolerance AT3
- ☒ Coolant supply form AD/AF

Use:

Suitable for all shrinking units.

Extra slim version with smaller diameter D2, 4.5°.

With taper **DIN ISO 7388-1 SK40 form AD/AF**.

Form AD/AF means central coolant supply and coolant channels through the flange which can be sealed again.

- Heat resistant hot-working steel
- Hardened 54–2 HRC
- For solid carbide tools with shank tolerance h6
- Shank tolerance h6
- Included in delivery: Shrink fit chuck with back-up screw (Ø 6–12 mm)
- Cooling with slits for an extra charge

Standard version, similar to DIN 69882-8

METRIC	Clamping Ø D1 [mm]		03	04	05	06	08	10	12
	Ø D2 [mm]		09	09	09	15	15	18	18
	L [mm]		—	—	—	36	36	42	47
Length A [mm]	ZG120		120 ¹⁾	120 ¹⁾	120 ¹⁾	120	120	120	120
Order No.	40.447...		.03.10	.04.10	.05.10	.06.10	.08.10	.10.10	.12.10

Accessories

Shrink fit extensions See pages 751–753

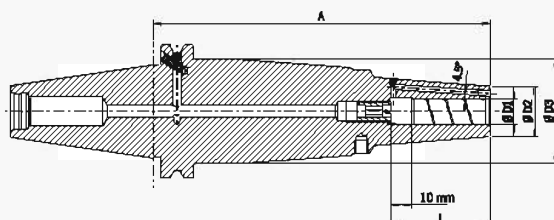
Reduction sleeves See page 794

Back-up screws See pages 796–799

Cooling adapter **Ø 3 – 5 mm** **Ø 6 – 12 mm** See page 592
Order No. **80.105.14.1.3** **80.105.14.1.2**

POWER SHRINK CHUCK DIN ISO 7388-1 · SK40 (FORMERLY DIN 69871)

CERTIFICATE OF QUALITY	
☑	Chuck body fine balanced G2.5 25,000 rpm or U<1 gmm
☑	All functional surfaces fine machined
☑	Taper tolerance AT3
☑	Coolant supply form AD/AF
☑	Cool Jet, can be sealed



The Power Shrink Chuck is the shrink fit chuck for highest cutting performance in High Speed machining. The optimized design combines high rigidity with dampening vibrations, therefore giving more protection to machines, spindles and tools.

- Increased machining capacity due to higher spindle speed, higher feed and larger cutting depth
- Shorter processing times, higher machining accuracy
- Quieter running, therefore better surface quality and protection of tools, spindles and machines
- With threaded holes in order to balance with balancing screws
- Cool Jet bores that can be sealed included
- Cooling with Cool Flash for an extra charge (See pages 502–503)

The long versions (A=130 and 160) with slim tips are especially versatile to use.

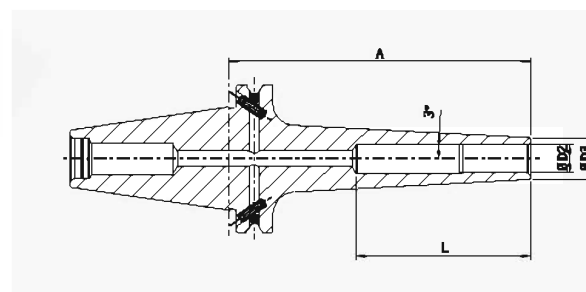
- High rigidity, slim at the tip, dampen vibrations
- High clamping force
- Equally suited to High Speed and Heavy Duty machining
- Universal usage, saves space in tool magazine

Clamping	Ø D1 [mm]	06	08	10	12	14	16	18	20	25	32
	Ø D2 [mm] ultra short	22	22	26.5	26.5	29.5	29.5	35.5	35.5	45.5	45.5
	L [mm] ultra short	36	36	42	47	47	50	50	52	58	58
Length A [mm] Order No.	ultra short 40.445...	65 .06.3	65 .08.3	65 .10.3	65 .12.3	65 .14.3	65 .16.3	65 .18.3	65 .20.3	75 .25.3	80 .32.3
	Ø D2 [mm]	21	21	24	24	27	27	33	33	44	44
	Ø D3 [mm]	50	50	50	50	50	50	50	50	53	53
	L [mm]	36	36	42	47	47	50	50	52	58	58
Length A [mm] Order No.	ZG130 40.444...	130 .06.3	130 .08.3	130 .10.3	130 .12.3	130 .14.3	130 .16.3	130 .18.3	130 .20.3	130 .25.3	130 .32.3
Length A [mm] Order No.	oversize 40.442...	160 .06.3	160 .08.3	160 .10.3	160 .12.3	160 .14.3	160 .16.3	160 .18.3	160 .20.3	160 .25.3	160 .32.3

Power Shrink Chuck with Safe-Lock

Clamping	Ø D1 [mm]	06	08	10	12	14	16	18	20	25	32
	Ø D2 [mm] ultra short	22	22	26.5	26.5	29.5	29.5	35.5	35.5	45.5	45.5
	L [mm] ultra short	36	36	42	47	47	50	50	52	58	58
Length A [mm] Order No.	ultra short 40.445...	65 .06.37	65 .08.37	65 .10.37	65 .12.37	65 .14.37	65 .16.37	65 .18.37	65 .20.37	75 .25.37	80 .32.37
	Ø D2 [mm]	21	21	24	24	27	27	33	33	44	44
	Ø D3 [mm]	50	50	50	50	50	50	50	50	53	53
	L [mm]	36	36	42	47	47	50	50	52	58	58
Length A [mm] Order No.	ZG130 40.444...	130 .06.37	130 .08.37	130 .10.37	130 .12.37	130 .14.37	130 .16.37	130 .18.37	130 .20.37	130 .25.37	130 .32.37
Length A [mm] Order No.	oversize 40.442...	160 .06.37	160 .08.37	160 .10.37	160 .12.37	160 .14.37	160 .16.37	160 .18.37	160 .20.37	160 .25.37	160 .32.37

MINI SHRINK DIN ISO 7388-1 · SK40 (FORMERLY DIN 69871)



CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced
G2.5 25,000 rpm or U<1 gmm
- ✓ All functional surfaces fine machined
- ✓ Taper tolerance AT3
- ✓ Coolant supply form AD/AF

SK40

- No disturbing edges
- Highest runout accuracy: 3 µm
- Also jobs difficult to access can be reached
- Optimum rigidity
- Ideal to shrink with the HAIMER Power Clamp
- For all solid carbide tools with shank tolerance h6
- Heat resistant hot-working steel
- Hardened 54 – 2 HRC
- With 3° angle for die and mold

- Tool holders fine balanced
- Delivery without coolant tube
- **Extra slim version:** extremely slim for fine machining and for jobs very difficult to reach
- **Standard version:** with high clamping force

Heating and cooling sleeves are needed when shrinking on most shrink fit machines (see accessories). However, when using the Power Clamp i4.0 Sprint/Air or Nano machines with the motorized coil and scanner, sleeves are not necessary.

METRIC	Clamping Ø D1 [mm]		03	04	05	06	08	10	12	16
	Ø D2 extra slim [mm]		06	07	08	09	11	13	15	—
	Ø D2 standard [mm]		09	10	11	12	14	16	18	22
Gage Length A [mm]	ZG120		120	120	120	120	120	120	120	—
Order No.	extra slim 40.477...		.03	.04	.05	.06	.08	.10	.12	—
Gage Length A [mm]	ZG120		120	120	120	120	120	120	120	120
Order No.	standard 40.487...		.03	.04	.05	.06	.08	.10	.12	.16



Mini Shrink shrink and cooling sleeve

- Protect Mini Shrink chucks from overheating
- Extend lifetime of shrink fit chucks
- Secure and user friendly handling
- Cooling with standard cooling body

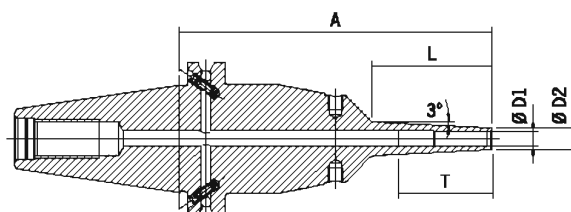
Shrinking and cooling sleeves for Mini Shrink chucks								Order No.
Extra slim								
Size [mm]	Ø 03	Ø 04	Ø 05	Ø 06	Ø 08	Ø 10	Ø 12	
Size [inch]	Ø 1/8	—	Ø 3/16	Ø 1/4	Ø 5/16	Ø 3/8	Ø 1/2	
Order No. 80.105.14...	.2.01	.2.02	.2.03	.2.04	.2.05	.2.06	.2.07	
Standard								
Size [mm]	Ø 03	Ø 04	Ø 05	Ø 06	Ø 08	Ø 10	Ø 12	Ø 16
Size [inch]	Ø 1/8	—	Ø 3/16	Ø 1/4	Ø 5/16	Ø 3/8	Ø 1/2	Ø 5/8
Order No. 80.105.14...	.2.04	.2.08	.2.05	.2.09	.2.10	.2.11	.2.12	.2.16
Base								80.105.14.2.99
Set with base (12 pcs., diameter 3 – 12 mm)								80.105.14.2.00

POWER MINI SHRINK CHUCK

DIN ISO 7388-1 · SK40

(FORMERLY DIN 69871)

CERTIFICATE OF QUALITY	
✓ Chuck body fine balanced	G2.5 25,000 rpm or U<1 gmm
✓ All functional surfaces fine machined	
✓ Taper tolerance AT3	
✓ Coolant supply form AD/AF	

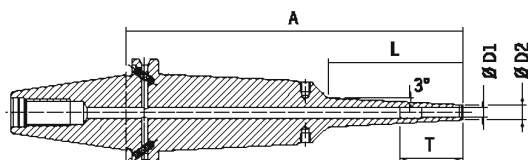


Power Mini Shrink Chuck is perfect for 5-axis-machining in the die & mold and in the medical industry. Very slim at the top like the HAIMER Mini Shrink Chuck, the Power Mini Shrink is reinforced at the base. Therefore, efficient milling is possible with an angled tool even at long protruding lengths.

- 2 types: Standard (3 mm wall thickness) and extra slim (1.5 mm wall thickness)
- 3° angle at the top
- With threaded holes in order to balance with balancing screws
- For solid carbide tools with shank tolerance h6

Attention: Heating and cooling sleeves are needed when shrinking on most shrink fit machines (see accessories). However, when using the Power Clamp i4.0 Sprint/Air or Nano machines with the motorized coil and scanner, sleeves are not necessary.

CERTIFICATE OF QUALITY	
✓ Chuck body fine balanced	G2.5 25,000 rpm or U<1 gmm
✓ All functional surfaces fine machined	
✓ Taper tolerance AT3	
✓ Coolant supply form AD/AF	



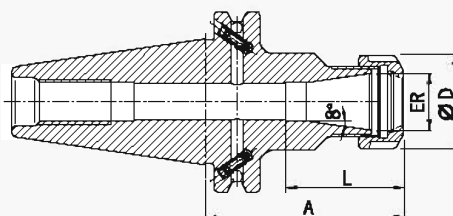
Clamping	Ø D1 [mm]		03	04	05	06	08	10	12	16
	Ø D2 [mm] standard		09	10	11	12	14	16	18	24
	Ø D2 [mm] extra slim		06	07	08	09	11	13	15	—
	T [mm]		—	—	—	—	—	68	75	75
	L [mm] ZG130		50	50	50	50	50	50	50	50
Length A [mm]	ZG130		130	130	130	130	130	130	130	130
Order No.	standard	40.484...	.03.8	.04.8	.05.8	.06.8	.08.8	.10.8	.12.8	.16.8
Order No.	extra slim	40.474...	.03.8	.04.8	.05.8	.06.8	.08.8	.10.8	.12.8	—
	L [mm]		80	80	80	80	80	80	80	80
Length A [mm]	oversize		160	160	160	160	160	160	160	160
Order No.	standard	40.482...	.03.8	.04.8	.05.8	.06.8	.08.8	.10.8	.12.8	.16.8
Order No.	extra slim	40.472...	.03.8	.04.8	.05.8	.06.8	.08.8	.10.8	.12.8	—
Length A [mm]	ZG200		200	200	200	200	200	200	200	200
Order No.	standard	40.486...	.03.8	.04.8	.05.8	.06.8	.08.8	.10.8	.12.8	.16.8
Order No.	extra slim	40.476...	.03.8	.04.8	.05.8	.06.8	.08.8	.10.8	.12.8	—

Accessories

Shrink and cooling adapter for Mini Shrink

See page 593

COLLET CHUCK ER DIN ISO 7388-1 · SK40 (FORMERLY DIN 69871)



CERTIFICATE OF QUALITY

<input checked="" type="checkbox"/>	Chuck body fine balanced G2.5 22,000 rpm
<input checked="" type="checkbox"/>	All functional surfaces fine machined
<input checked="" type="checkbox"/>	Taper tolerance AT3
<input checked="" type="checkbox"/>	Coolant supply form AD/AF
<input checked="" type="checkbox"/>	Cool Jet, can be sealed

Use:

For clamping tools with cylindrical shank in collets according to ISO 15488 (formerly DIN 6499).

With taper **DIN ISO 7388-1 SK40 form AD/AF**.

Form AD/AF means central coolant supply and coolant channels on the collar, which can be sealed again.

- Included in delivery: locknut (balanced, with slide coating for higher clamping forces)
- Locknut type HS (High-Speed, fine balanced, with slide coating for higher clamping forces) for an extra charge
- Enlarging of size L upon request

ER	16	20	25	32	40
Ø D [mm]	28	34	42	50	63
Clamping range [mm]	0.5–10.0	1.5–13.0	1.0–18.0	1.5–20.0	2.5–26.0
Clamping range [inch]	0.02–0.39	0.06–0.51	0.04–0.63	0.06–0.79	0.1–1.02
L [mm]	4	41.5	62	64	73
Length A [mm]	short	70 ¹⁾	70 ¹⁾	70 ¹⁾	70
Order No.	40.320...	.16	.20	.25	.32
L [mm]	4	41.5	57	64	73
Length A [mm]	long	100 ¹⁾	100 ¹⁾	100 ¹⁾	100
Order No.	40.321...	.16	.20	.25	.32
Length A [mm]	oversize	160 ¹⁾	—	160 ¹⁾	160
Order No.	40.322...	.16	—	.25	.32
Length A [mm]	ZG200	200 ¹⁾	—	200 ¹⁾	200
Order No.	40.326...	.16	—	.25	.32

Accessories

Collets ER



See pages 768–773

Shrink Fit Collets



See pages 760–767

Locknut (pre-balanced)

Size

Order No.

83.912..



ER 16

ER 20

ER 25

ER 32

ER 40

Locknut HS (fine-balanced)

Size

Order No.

83.912..



ER 16

ER 20

ER 25

ER 32

ER 40

Fork wrench

Size

Order No.

84.200...



ER 16

ER 20

—

—

—

Clamping wrench

Size

Order No.

84.200...



—

—

ER 25

ER 32

ER 40

Balancing index rings

Size

Order No.

79.350...



ER 16

ER 20

—

—

—

Size

Order No.

79.350...



ER 16

ER 20

ER 25

ER 32

ER 40

Pull studs



See pages 789–791

Shrink fit extensions

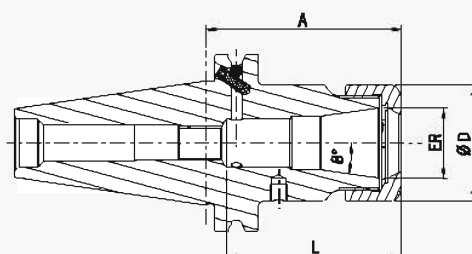


See pages 751–753

POWER COLLET CHUCK DIN ISO 7388-1 · SK40 (FORMERLY DIN 69871)

CERTIFICATE OF QUALITY

- Chuck body fine balanced
G2.5 25,000 rpm
- All functional surfaces fine machined
- Taper tolerance AT3
- Coolant supply form AD/AF



The Power Collet Chuck is the collet chuck for the highest machining capacity in High Speed machining. The optimized design with better construction combines high rigidity with vibration dampening features, giving more protection to machines, spindles and tools. The universal Power Collet Chuck is a unique high performance chuck that can also be used with standard collets.

- High runout accuracy: 0.003 mm at 3 × D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488 (Attention: By using standard collet ER, length A will get longer)
- High rigidity

- Runs smoother thanks to vibration absorbing geometry, yielding better surface finish and increased tool, spindle and machine protection
- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle times, higher machining accuracy, higher clamping forces
- Equally suited to High Speed and dynamic machining
- With threaded holes in order to balance with balancing screws
- Optional: Cool Jet bores on Power Collets
- Product range of Power Collets on pages 774 – 776

	ER	16	25	32
Ø D [mm]		28	42	50
Clamping range [mm]		2.0–10.0	2.0–16.0	2.0–20.0
Clamping range [Inch]		1/8–3/8	1/8–5/8	1/8–3/4
L [mm]		43	61.5	62
Length A [mm]	short	70	70	70
Order No.	40.320...	.16.3	.25.3	.32.3
L [mm]		43	51	53
Length A [mm]	long	100	100	100
Order No.	40.321...	.16.3	.25.3	.32.3
Length A [mm]	oversize	160	160	160
Order No.	40.322...	.16.3	.25.3	.32.3

Accessories

Locknut (fine-balanced)

Size ER 16 ER 25 ER 32 See page 779

Order No. 83.914...

Power Collet clamping wrench



Torque Master torque wrench

Order No. 84.600.00

Power Collets



Power Collets with Safe-Lock



Cool Jet bores for Power Collets

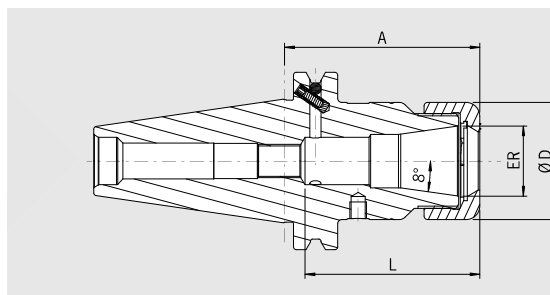
Order No. 91.100.27

Shrink Fit Collets



See pages 760–767

HIGH PRECISION COLLET CHUCK DIN ISO 7388-1 · SK40 (FORMERLY DIN 69871)



CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced
G2.5 30,000 rpm
- ☒ All functional surfaces fine machined
- ☒ Taper tolerance AT3
- ☒ Coolant supply form AD/AF

The High Precision Collet Chuck is the collet chuck for highest metal removal rates in High Speed machining. The optimized design with better construction and a special coated smooth locknut combines high rigidity with vibration dampening and noise-reducing features, giving more protection to machines, spindles and tools.

- With a specially coated smooth locknut, balanced at < 1 gmm
- High runout accuracy: 0.003 mm at 3×D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488 (Attention: By using standard collet ER, length A will get longer)
- High rigidity

- Runs smoother thanks to vibration absorbing geometry, yielding better surface finish and increased tool, spindle and machine protection
- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle times, higher machining accuracy, higher clamping forces
- Equally suited to High Speed and dynamic machining
- With threaded holes in order to balance with balancing screws
- Optional: Cool Jet bores on Power Collets
- Product range of Power Collets on pages 774 – 776

ER	16	25	32
Ø D [mm]	28	42	50
Clamping range [mm]	2.0–10.0	2.0–16.0	2.0–20.0
Clamping range [inch]	1/8–3/8	1/8–5/8	1/8–3/4
L [mm]	43	61.5	62
Length A [mm]	short	70	70
Order No.	40.320...	.16.3.HP	.25.3.HP
L [mm]	43	51	53
Length A [mm]	long	100	100
Order No.	40.321...	.16.3.HP	.25.3.HP
Length A [mm]	oversize	160	160
Order No.	40.322...	.16.3.HP	.25.3.HP

Accessories

High Precision Smooth Locknut (fine-balanced)

See page 779

Size

ER 16

ER 25

ER 32

Order No. 83.914...



.16.1

.25.1

.32.1

Roller bearing wrench

See page 782

Order No. 84.650...



.16.1

.25.1

.32.1

Collets ER



See pages 768–773

Shrink Fit Collets



See pages 760–767

Power Collets



See page 775

Power Collets with Safe-Lock



See page 776

Cool Jet bores for Power Collets



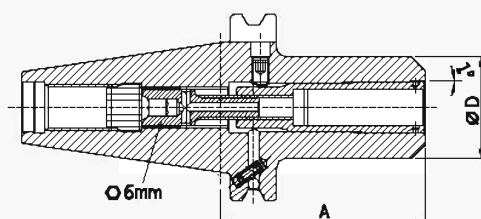
See page 777

Order No. 91.100.27

HIGH-PRECISION CHUCK DIN ISO 7388-1 · SK40 (FORMERLY DIN 69871)

CERTIFICATE OF QUALITY

- Chuck body fine balanced
G2.5 25,000 rpm
- All functional surfaces fine machined
- Taper tolerance AT3
- Coolant supply form AD/AF



Use:

For highly precise clamping of tools with cylindrical shank with special collets and also for shanks with clamping flats. Very useful for high-speed machining.

With taper **DIN ISO 7388-1 SK40 form AD/AF**.

Form AD/AF means central coolant supply and coolant channels on the collar, which can be sealed again.

- Included in delivery: High-Precision Chuck with clamping screw and pull-out hook without collet
- Shank tolerance h6

	HG		01		02		03
	Ø D [mm]		30		35		48
	Clamping diameter		2 3 4 5 6 8		10 12 14		16 18 20
Length A [mm]	short		65 ¹⁾		70 ¹⁾		75
Order No.	40.420...		.01		.02		.03
Length A [mm]	long		100 ¹⁾		100 ¹⁾		100
Order No.	40.421...		.01		.02		.03
Length A [mm]	oversize		160 ¹⁾		160 ¹⁾		160
Order No.	40.422...		.01		.02		.03

Accessories

Clamping screw



Collets HG INCH

HG 01 Ø D [inch]

Order No.

82.510...



Ø 1/8 Ø 3/16 Ø 1/4 Ø 5/16

.1/8Z .3/16Z .1/4Z .5/16Z

See page 783

HG 02 Ø D [inch]

Order No.

82.520...



Ø 3/8 Ø 7/16 Ø 1/2 Ø 9/16

.3/8Z .7/16Z .1/2Z .9/16Z

HG 03 Ø D [inch]

Order No.

82.530...



Ø 5/8 Ø 3/4

.5/8Z .3/4Z

See page 783

Collets HG METRIC

HG 01

Order No.

82.510...



Ø 02 Ø 03 Ø 04 Ø 05 Ø 06 Ø 08

.02 .03 .04 .05 .06 .08

HG 02

Order No.

82.520...



Ø 10 Ø 12 Ø 14

.10 .12 .14

HG 03

Order No.

82.530...



Ø 16 Ø 18 Ø 20

.16 .18 .20

Pull-out hook

HG

Order No.

82.570...



HG 01

.00

HG 02

.00

HG 03

.00

Balancing index rings

HG

Order No.

79.350...



HG 01

.30

HG 02

.35

HG 03

.48

Pull studs



See pages 789–791

Shrink fit extensions



See pages 751–753

Cool Jet bores

Order No.

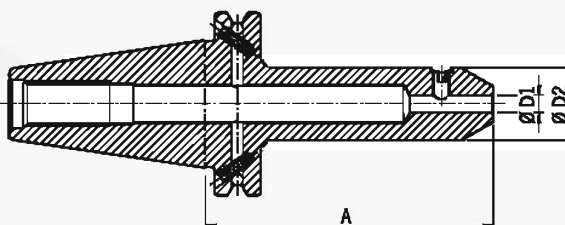
91.100.24



See page 501

1) Also suitable for ANSHCAT

WELDON TOOL HOLDER DIN ISO 7388-1 · SK40 (FORMERLY DIN 69871)



CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced
G2.5 22,000 rpm
- ☒ All functional surfaces fine machined
- ☒ Taper tolerance AT3
- ☒ Coolant supply form AD/AF

Use:

For clamping cutters with cylindrical shank and Weldon flat similar to DIN 1835-B and DIN 6535-HB.

Similar to DIN 6359-2 with taper **DIN ISO 7388-1 SK40 form AD/AF**.
Form AD/AF means central coolant supply and coolant channels on the collar, which can be sealed again.

- Delivery: with clamping screw
- Extra short design only available in form AD
- Cooling with Cool Jet for an extra charge (See page 501)

Clamping	Ø D1 [mm]		06	08	10	12	14	16	18	20	25	32
	Ø D2 [mm]		25	28	35	42	42	48	48	52	65	72
Length A [mm]	ultra short		—	—	—	—	—	35	35	40	60	70
Order No.	40.305...							.16	.18	.20	.25	.32
Length A [mm]	short		50 ¹⁾	50 ¹⁾	50 ¹⁾	50 ¹⁾	50 ¹⁾	63	63	63	100	100
Order No.	40.300...		.06	.08	.10	.12	.14	.16	.18	.20	.25	.32
Length A [mm]	long		100 ¹⁾	100 ¹⁾	100 ¹⁾	100 ¹⁾	100 ¹⁾	100	100	100	—	—
Order No.	40.301...		.06	.08	.10	.12	.14	.16	.18	.20		
Length A [mm]	oversize		160 ¹⁾	160 ¹⁾	160 ¹⁾	160 ¹⁾	160 ¹⁾	160	160	160	160	—
Order No.	40.302...		.06	.08	.10	.12	.14	.16	.18	.20	.25	

Standard version, with Cool Jet

Clamping	Ø D1 [mm]		06	08	10	12	14	16	20	25
	Ø D2 [mm]		25	28	35	42	42	48	52	65
Length A [mm]	short		50 ¹⁾	50 ¹⁾	50 ¹⁾	50 ¹⁾	50 ¹⁾	63	63	100
Order No.	40.300...		.06.2	.08.2	.10.2	.12.2	.14.2	.16.2	.20.2	.25.2

Accessories

Clamping screw

Clamping Ø			06	08	10	12	14	16	18	20	25	32
Order No.	85.100...		.06	.08	.10	.12	.12	.14	.14	.16	.18	.20

Balancing index rings

Clamping Ø	long/ZG130/oversize/ZG200		06	08	10	12	14	16	18	20	25	32
Order No.	79.350...		.25	.28	.35	.42	.42	.48	.48	.52	.65	.72

Pull studs



See pages 789–791

Cool Jet bores from Ø 6 mm – Ø 20 mm

Order No. 91.100.24



See page 501

Cool Jet bores from Ø 25 mm – Ø 32 mm

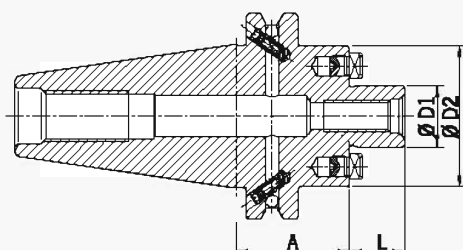
Order No. 91.100.28



See page 501

FACE MILL ARBOR DIN ISO 7388-1 · SK40 (FORMERLY DIN 69871)

CERTIFICATE OF QUALITY	
<input checked="" type="checkbox"/>	Chuck body fine balanced G2.5 22,000 rpm
<input checked="" type="checkbox"/>	All functional surfaces fine machined
<input checked="" type="checkbox"/>	Taper tolerance AT3
<input checked="" type="checkbox"/>	Coolant supply form AD/AF



Use:

For holding face mill cutters and cutters with radial driving slot DIN 1880 and exceeding clamping diameter 40 clamping according to DIN 2079 is possible, too (4 additional tapping holes).

According to DIN 6357 with taper **DIN ISO 7388-1 SK40 form AD/AF**.

Form AD/AF means central coolant supply and coolant channels on the collar, which can be sealed again.

- Included in delivery: tightening bolt, size 16.1 with reduced contact diameter
- With coolant exit bores on the end face for milling cutters with central cooling

Clamping	Ø D1 [mm]	16	22	27	32	40
	Ø D2 [mm] short	32	48	48	78	87
	L [mm]	17	19	21	24	27
Length A [mm]	short	35	35	35	50	50
Order No.	40.350...	.16.KKB	.22.KKB	.27.KKB	.32.KKB	.40.KKB
	Ø D2 [mm]	36	48	60	78	
Length A [mm]	long	100	100	100	100	
Order No.	40.351...	.16.KKB	.22.KKB	.27.KKB	.32.KKB	
Length A [mm]	oversize	—	160	160	160	
Order No.	40.352...		.22.KKB	.27.KKB	.32.KKB	

Accessories

Tightening bolt

Size D1			—	22	27	32	40
Order No.	85.300...			.22	.27	.32	.40

Wrench

Size D1			—	22	27	32	40
Order No.	84.400...			.22	.27	.32	.40

Balancing index rings

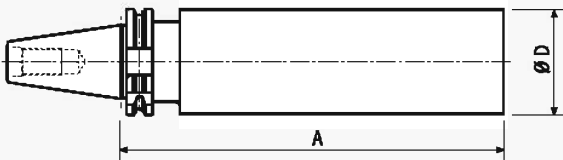
Size D1	short		—	22	27	—	—
Order No.	79.350...				.48		.48

Pull studs



See pages 789–791

BLANK ADAPTER
DIN ISO 7388-1 · SK40
(FORMERLY DIN 69871)



CERTIFICATE OF QUALITY

☒ All functional surfaces fine machined

☒ Taper tolerance AT3

☒ Coolant supply form AD/AF

Use:
For manufacturing special tools in your factory.
Also suitable for ANSHCAT.

Design:
Taper and groove are hardened and ground, the cylindrical part is soft.

With taper **SK40 form AD/AF** DIN ISO 7388-1.
Form AD/AF means central coolant supply and coolant channels on the collar, which can be sealed again.

	Ø D [mm]		63
Length A [mm]	ZG100		100
Order No.	40.395...		.63
Length A [mm]	ZG230		230
Order No.	40.390...		.63

Accessories
Pull studs

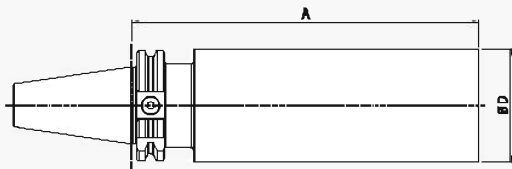


See pages 789–791

BLANK ADAPTER – HARDENED
DIN ISO 7388-1 · SK40
(FORMERLY DIN 69871)

CERTIFICATE OF QUALITY

- ✓ All functional surfaces fine machined
- ✓ Taper tolerance AT3



Use:

For manufacturing special tools in your factory.

Version:

- Taper and groove hardened and ground
- Cylindrical part hardened to 52+2 HRC

Taper **DIN ISO 7388-1 SK40** prepared for Form AD.
Form AD means central coolant supply

	Ø D [mm]		65
Gage Length A [mm]	ZG100		100
Order No.	R40.396.0650...		.0100
Gage Length A [mm]	ZG200		200
Order No.	R40.396.0650...		.0200
Gage Length A [mm]	ZG300		300
Order No.	R40.396.0650...		.0300

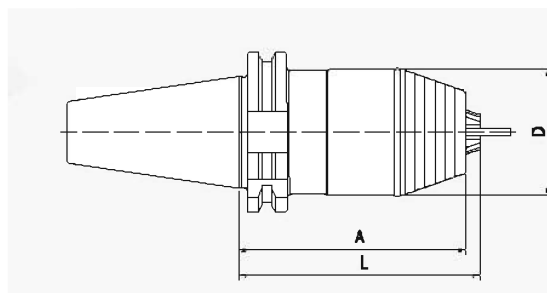
Accessories
Pull studs



See pages 789–791

HAIMER

SHORT DRILL CHUCK DIN ISO 7388-1 · SK40 (FORMERLY DIN 69871)



CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced
G2.5 22,000 rpm
- ☒ All functional surfaces fine machined
- ☒ Taper tolerance AT3
- ☒ Coolant supply form AD/AF

Use:

For clamping tools with cylindrical shank, for left and right hand turn, clamping and loosening with a hexagon socket wrench.

With DIN ISO 7388-1 SK40 Form AD/AF.

Form AD/AF means central coolant supply and coolant channels on the collar which can be sealed again

Clamping range [mm]		0.5–13
Ø D [mm]		50
L [mm]		96
Length A [mm]		90
Order No.	40.411...	.13



Accessories
Pull studs



See pages 789–791

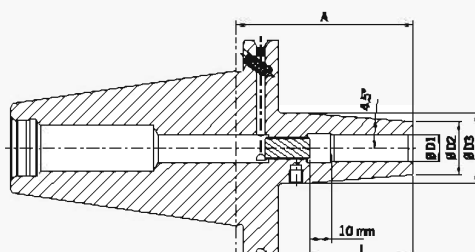
SHRINK FIT CHUCK

DIN ISO 7388-1 · SK50

(FORMERLY DIN 69871)

CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced
G2.5 25,000 rpm
- ☑ All functional surfaces fine machined
- ☑ Taper tolerance AT3
- ☑ Coolant supply form AD/AF



Use:

Suitable for all shrinking units.

With taper **DIN ISO 7388-1 SK40 form AD/AF**.

Form AD/AF means central coolant supply and coolant channels through the flange which can be sealed again.

- Heat resistant hot-working steel
- Hardened 54–2 HRC
- For HSS and solid carbide tools
- Shank tolerance h6
- With threaded holes in order to balance with balancing screws
- Included in delivery: Shrink fit chuck with back-up screw
- Cooling with Cool Jet for an extra charge (See page 501)
- Cooling with Cool Flash for an extra charge (See pages 502–503)

Standard version, similar to DIN 69882-8

Clamping	Ø D1 [mm]		06	08	10	12	14	16	18	20	25	32
	Ø D2 [mm]		21	21	24	24	27	27	33	33	44	44
	Ø D3 [mm]		27	27	32	32	34	34	42	42	53	53
	L [mm]		36	36	42	47	47	50	50	52	58	58
Length A [mm]	short		80	80	80	80	80	80	80	80	100	100
Order No.	50.440...		.06	.08	.10	.12	.14	.16	.18	.20	.25	.32
Length A [mm]	ZG120		120	120	120	120	120	120	120	120	120	120
Order No.	50.447...		.06	.08	.10	.12	.14	.16	.18	.20	.25	.32
Length A [mm]	ZG130		130	130	130	130	130	130	130	130	130	130
Order No.	50.444...		.06	.08	.10	.12	.14	.16	.18	.20	.25	.32
Length A [mm]	oversize		160	160	160	160	160	160	160	160	160	160
Order No.	50.442...		.06	.08	.10	.12	.14	.16	.18	.20	.25	.32
Length A [mm]	ZG200		200	200	200	200	200	200	200	200	200	200
Order No.	50.446...		.06	.08	.10	.12	.14	.16	.18	.20	.25	.32

Standard version, with Cool Jet

Clamping	Ø D1 [mm]		06	08	10	12	14	16	18	20	25	32
	Ø D2 [mm]		21	21	24	24	27	27	33	33	44	44
	Ø D3 [mm]		27	27	32	32	34	34	42	42	53	53
	L [mm]		36	36	42	47	47	50	50	52	58	58
Length A [mm]	short		80	80	80	80	80	80	80	80	100	100
Order No.	50.440...		.06.2	.08.2	.10.2	.12.2	.14.2	.16.2	.18.2	.20.2	.25.2	.32.2

Accessories

Cool Flash
Cool Flash Upgrade Incl. Cool Jet



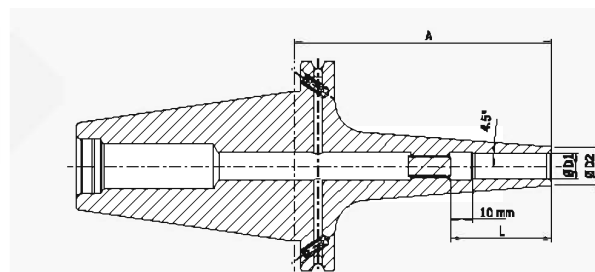
Order No. 91.100.40
Order No. 91.100.41

See pages 502–503
See pages 502–503

SHRINK FIT CHUCK EXTRA SLIM

DIN ISO 7388-1 · SK50

(FORMERLY DIN 69871)



CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced
G2.5 25,000 rpm or U<1 gmm
- ☒ All functional surfaces fine machined
- ☒ Taper tolerance AT3
- ☒ Coolant supply form AD/AF

Use:

Suitable for all shrinking units.

Extra slim version with smaller diameter D2, 4.5°.

With taper DIN ISO 7388-1 SK40 form AD/AF.

Form AD/AF means central coolant supply and coolant channels through the flange which can be sealed again.

- Heat resistant hot-working steel
- Hardened 54–2 HRC
- For solid carbide tools with shank tolerance h6
- Shank tolerance h6
- Included in delivery: Shrink fit chuck with back-up screw
- Cooling with slits for an extra charge

Standard version, similar to DIN 69882-8

METRIC	Clamping Ø D1 [mm]	03	04	05	06	08	10	12
	Ø D2 [mm]	09	09	09	15	15	18	18
	L [mm]	—	—	—	36	36	42	47
Length A [mm]	ZG120	120 ¹⁾	120 ¹⁾	120 ¹⁾	120	120	120	120
Order No.	50.447...	.03.10	.04.10	.05.10	.06.10	.08.10	.10.10	.12.10

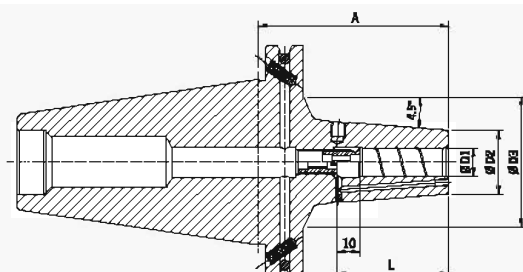
Accessories

Shrink fit extensions		See pages 751–753						
Pull studs		See pages 789–791						
Reduction sleeves		See page 794						
Back-up screws		See pages 796–799						
Cooling adapter		See page 592						
Order No.		Ø 3 – 5 mm 80.105.14.1.3			Ø 6 – 12 mm 80.105.14.1.2			

1) Without back-up screw

POWER SHRINK CHUCK DIN ISO 7388-1 · SK50 (FORMERLY DIN 69871)

CERTIFICATE OF QUALITY	
<input checked="" type="checkbox"/>	Chuck body fine balanced G2.5 25,000 rpm
<input checked="" type="checkbox"/>	All functional surfaces fine machined
<input checked="" type="checkbox"/>	Taper tolerance AT3
<input checked="" type="checkbox"/>	Coolant supply form AD/AF
<input checked="" type="checkbox"/>	Cool Jet, can be sealed



The Power Shrink Chuck is the shrink fit chuck for highest cutting performance in High Speed machining. The optimized design combines high rigidity with dampening vibrations, therefore giving more protection to machines, spindles and tools.

- Increased machining capacity due to higher spindle speed, higher feed and larger cutting depth
- Shorter processing times, higher machining accuracy
- Quieter running, therefore better surface quality and protection of tools, spindles and machines
- With threaded holes in order to balance with balancing screws
- Cool Jet bores that can be sealed included
- Cooling with Cool Flash for an extra charge (See pages 502–503)

The long versions (A=160 and 200 mm) with slim tips are especially versatile to use.

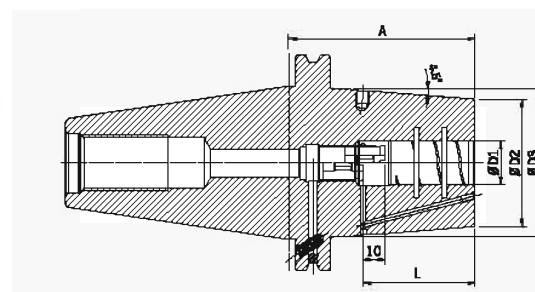
- High rigidity, slim at the tip, dampen vibrations
- High clamping force
- Equally suited to High Speed and Heavy Duty machining
- Universal usage, saves space in tool magazine

Clamping	Ø D1 [mm]		06	08	10	12	14	16	18	20	25
	Ø D2 [mm] short		21	21	27	27	33.3	33.3	44.7	44.7	44
	Ø D3 [mm] short		70	70	55	55	—	—	—	—	78
	L [mm]		36	36	42	47	47	50	50	52	58
Length A [mm] Order No.	short 50.440...		80 .06.3	80 .06.3	80 .10.3	80 .12.3	80 .14.3	80 .16.3	80 .18.3	80 .20.3	100 .25.3
	Ø D2 [mm]		21	21	27	27	33	33	44	44	44
	Ø D3 [mm]		78	78	78	78	78	78	78	78	78
Length A [mm] Order No.	oversize 50.442...		160 .06.3	160 .08.3	160 .10.3	160 .12.3	160 .14.3	160 .16.3	160 .18.3	160 .20.3	160 .25.3
Length A [mm] Order No.	ZG200 50.446...		200 .06.3	200 .06.3	200 .10.3	200 .12.3	200 .14.3	200 .16.3	200 .18.3	200 .20.3	200 .25.3

Power Shrink Chuck with Safe-Lock

Clamping	Ø D1 [mm]		06	08	10	12	14	16	18	20	25
	Ø D2 [mm] short		21	21	27	27	33.3	33.3	44.7	44.7	44
	Ø D3 [mm] short		70	70	55	55	—	—	—	—	78
	L [mm]		36	36	42	47	47	50	50	52	58
Length A [mm] Order No.	short 50.440...		80 .06.37	80 .08.37	80 .10.37	80 .12.37	80 .14.37	80 .16.37	80 .18.37	80 .20.37	100 .25.37
	Ø D2 [mm]		21	21	27	27	33	33	44	44	44
	Ø D3 [mm]		78	78	78	78	78	78	78	78	78
Length A [mm] Order No.	oversize 50.442...		160 .06.37	160 .08.37	160 .10.37	160 .12.37	160 .14.37	160 .16.37	160 .18.37	160 .20.37	160 .25.37
Length A [mm] Order No.	ZG200 50.446...		200 .06.37	200 .06.37	200 .10.37	200 .12.37	200 .14.37	200 .16.37	200 .18.37	200 .20.37	200 .25.37

HEAVY DUTY CHUCK DIN ISO 7388-1 · SK50 (FORMERLY DIN 69871)



CERTIFICATE OF QUALITY

- Chuck body fine balanced G2.5 25,000 rpm
- All functional surfaces fine machined
- Taper tolerance AT3
- Coolant supply form AD/AF
- Cool Jet, can be sealed

For heavy machining applications it is now possible to replace the Weldon tool holders finally. Heavy Duty Chuck is the shrink fit chuck for extreme cases. The contour is optimized for highest rigidity and clamping force.

- Smooth clamping of the tool shank
- No deformation at the tool shank after shrink process
- High runout accuracy: 3 µm
- Reinforced outer contour
- To shrink with 13 kW HD coil (see page 600) or with high performance shrink fit unit HAIMER Power Clamp Profi Plus (20 kW)
- With internal groove in the clamping bore
- With threaded holes in order to balance with balancing screws
- Cool Jet bores that can be sealed included
- Cooling with Cool Flash for an extra charge (See pages 502–503)

Clamping	Ø D1 [mm]	16	20	25	32	40	50
	Ø D2 [mm]	51	58	63	70	82	82
	Ø D3 [mm] short	—	67	72	78	90	94
	Ø D3 [mm]	78	78	78	85	94	94
	L [mm]	50	52	58	61	88	88
Length A [mm]	short	80	85	90	90	100	140
Order No.	50.450...	.16.6	.20.6	.25.6	.32.6	.40.6	.50.6
Length A [mm]	oversize	160	160	160	160	160	160
Order No.	50.452...	.16.6	.20.6	.25.6	.32.6	.40.6	.50.6
Length A [mm]	ZG200	200	200	200	200	200	200
Order No.	50.456...	.16.6	.20.6	.25.6	.32.6	.40.6	.50.6

Heavy Duty Chuck with Safe-Lock

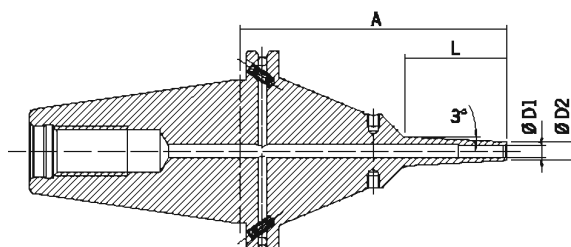
Clamping	Ø D1 [mm]	16	20	25	32	40	50
	Ø D2 [mm]	51	58	63	70	82	82
	Ø D3 [mm] short	—	67	72	78	90	94
	Ø D3 [mm]	78	78	78	85	94	94
	L [mm]	50	52	58	61	88	88
Length A [mm]	short	80	85	90	90	100	140
Order No.	50.450...	.16.67	.20.67	.25.67	.32.67	.40.67	.50.67
Length A [mm]	oversize	160	160	160	160	160	160
Order No.	50.452...	.16.67	.20.67	.25.67	.32.67	.40.67	.50.67
Length A [mm]	ZG200	200	200	200	200	200	200
Order No.	50.456...	.16.67	.20.67	.25.67	.32.67	.40.67	.50.67

For 13 kW shrink fit machine

Clamping	Ø D1 [mm]	16
	Ø D2 [mm]	46
	L [mm]	50
Length A [mm]	short	80
Order No.	Standard 50.440...	.16.6
Order No.	Safe-Lock 50.440...	.16.67

POWER MINI SHRINK CHUCK DIN ISO 7388-1 · SK50 (FORMERLY DIN 69871)

CERTIFICATE OF QUALITY	
<input checked="" type="checkbox"/>	Chuck body fine balanced G2.5 25,000 rpm
<input checked="" type="checkbox"/>	All functional surfaces fine machined
<input checked="" type="checkbox"/>	Taper tolerance AT3
<input checked="" type="checkbox"/>	Coolant supply form AD/AF

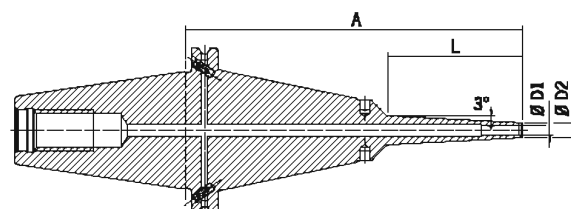


Power Mini Shrink Chuck is perfect for 5-axis-machining in the die & mold and in the medical industry. Very slim at the top like the HAIMER Mini Shrink Chuck, the Power Mini Shrink is reinforced at the base. Therefore, efficient milling is possible with an angled tool even at long protruding lengths.

- 2 types: Standard (3 mm wall thickness) and extra slim (1.5 mm wall thickness)
- 3° angle at the top
- With threaded holes in order to balance with balancing screws
- For solid carbide tools with shank tolerance h6

Attention: Heating and cooling sleeves are needed when shrinking on most shrink fit machines (see accessories). However, when using the Power Clamp i4.0 Sprint or Air machines with the motorized coil and scanner, sleeves are not necessary.

CERTIFICATE OF QUALITY	
<input checked="" type="checkbox"/>	Chuck body fine balanced G2.5 25,000 rpm
<input checked="" type="checkbox"/>	All functional surfaces fine machined
<input checked="" type="checkbox"/>	Taper tolerance AT3
<input checked="" type="checkbox"/>	Coolant supply form AD/AF



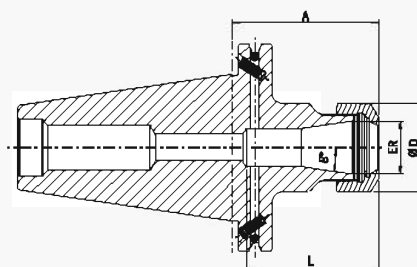
Clamping	Ø D1 [mm]		06	08
	Ø D2 [mm] standard		12	14
	Ø D2 [mm] extra slim		09	11
	L [mm] ZG130		50	50
Length A [mm]	ZG130		130	130
Order No.	standard	50.484...	.06.8	.08.8
Order No.	extra slim	50.474...	.06.8	.08.8
	L [mm]		80	80
Length A [mm]	oversize		160	160
Order No.	standard	50.482...	.06.8	.08.8
Order No.	extra slim	50.472...	.06.8	.08.8
Length A [mm]	ZG200		200	200
Order No.	standard	50.486...	.06.8	.08.8
Order No.	extra slim	50.476...	.06.8	.08.8

Accessories

Shrink and cooling adapter for Mini Shrink

See page 593

COLLET CHUCK ER DIN ISO 7388-1 · SK50 (FORMERLY DIN 69871)



CERTIFICATE OF QUALITY

- Chuck body fine balanced
G2.5 22,000 rpm
- All functional surfaces fine machined
- Taper tolerance AT3
- Coolant supply form AD/AF

Use:

For clamping tools with cylindrical shank in collets according to ISO 15488 (formerly DIN 6499).

With taper SK50 form AD/AF DIN ISO 7388-1.

Form AD/AF means central coolant supply and coolant channels on the collar, which can be sealed again.

- Included in delivery: locknut (balanced, with slide coating for higher clamping forces)
- Locknut type HS (High-Speed, fine balanced, with slide coating for higher clamping forces) for an extra charge
- Enlarging of size L upon request

ER	16	20	25	32	40
Ø D [mm]	28	34	42	50	63
Clamping range [mm]	0.5–10.0	1.5–13.0	1.0–16.0	1.5–20.0	2.5–26.0
Clamping range [inch]	0.02–0.39	0.06–0.51	0.04–0.63	0.06–0.79	0.10–1.02
L [mm]	70 ¹⁾	70 ¹⁾	70 ¹⁾	70 ¹⁾	70 ¹⁾
Length A [mm]	short	long	oversize	ZG200	
Order No.	50.320...	50.321...	50.322...	50.326...	
L [mm]	41.5	57	64	73	
Length A [mm]	100 ¹⁾	100 ¹⁾	100 ¹⁾	100 ¹⁾	100 ¹⁾
Order No.	50.321...	50.322...	50.323...	50.324...	50.325...
Length A [mm]	oversize				
Order No.	50.322...				
Length A [mm]	ZG200				
Order No.	50.326...				

Accessories

Collets ER



See pages 768–773

Shrink Fit Collets



See pages 760–767

Locknut (pre-balanced)

Size

Order No. 83.912...



ER 16

ER 20

ER 25

ER 32

ER 40

Locknut HS (fine-balanced)

Size

Order No. 83.912...



ER 16

ER 20

ER 25

ER 32

ER 40

Fork wrench

Size

Order No. 84.200...



ER 16

ER 20

—

—

—

Clamping wrench

Size

Order No. 84.200...



—

—

ER 25

ER 32

ER 40

Balancing index rings

Size

Order No. 79.350...



ER 16

ER 20

—

—

—

Size long/oversize/ZG200

Order No. 79.350...

ER 16

ER 20

ER 25

ER 32

ER 40

Pull studs



See pages 789–791

Shrink fit extensions

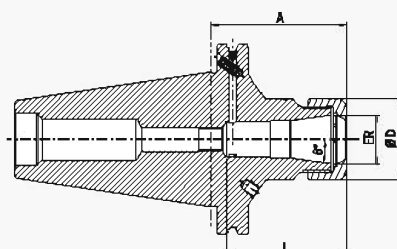


See pages 751–753

POWER COLLET CHUCK DIN ISO 7388-1 · SK50 (FORMERLY DIN 69871)

CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced
G2.5 25,000 rpm
- ✓ All functional surfaces fine machined
- ✓ Taper tolerance AT3
- ✓ Coolant supply form AD/AF



The Power Collet Chuck is the collet chuck for the highest machining capacity in High Speed machining. The optimized design with better construction combines high rigidity with vibration dampening features, giving more protection to machines, spindles and tools. The universal Power Collet Chuck is a unique high performance chuck that can also be used with standard collets.

- High runout accuracy: 0.003 mm at 3×D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488 (Attention: By using standard collet ER, length A will get longer)
- High rigidity

- Runs smoother thanks to vibration absorbing geometry, yielding better surface finish and increased tool, spindle and machine protection
- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle times, higher machining accuracy, higher clamping forces
- Equally suited to High Speed and dynamic machining
- With threaded holes in order to balance with balancing screws
- Optional: Cool Jet bores on Power Collets
- Product range of Power Collets on pages 774 – 776

ER	16	25	32
Ø D [mm]	28	42	50
Clamping range [mm]	2.0–10.0	2.0–16.0	2.0–20.0
Clamping range [inch]	1/8–3/8	1/8–5/8	1/8–3/4
L [mm]	43	62	62.5
Length A [mm]	short	70	70
Order No.	50.320...	.16.3	.25.3
L [mm]	43	51	53
Length A [mm]	long	100	100
Order No.	50.321...	.16.3	.25.3
Length A [mm]	ZG130	130	130
Order No.	50.324...	.16.3	.25.3
Length A [mm]	oversize	160	160
Order No.	50.322...	.16.3	.25.3

Accessories

Locknut (fine-balanced)

Size ER 16 ER 25 ER 32 See page 779

Order No. 83.914...



Power Collet clamping wrench



See page 781

Torque Master torque wrench

Order No. 84.600.00



See page 780

Power Collets



See page 775

Power Collets with Safe-Lock



See page 776

Cool Jet bores for Power Collets

Order No. 91.100.27



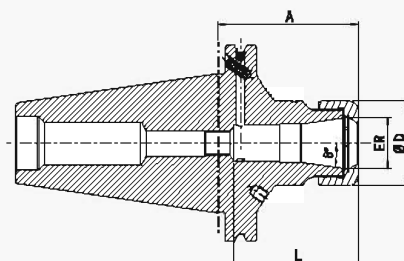
See page 777

Shrink Fit Collets



See pages 760–767

HIGH PRECISION COLLET CHUCK DIN ISO 7388-1 · SK50 (FORMERLY DIN 69871)



CERTIFICATE OF QUALITY

✓	Chuck body fine balanced G2.5 25,000 rpm
✓	All functional surfaces fine machined
✓	Taper tolerance AT3
✓	Coolant supply form AD/AF

The High Precision Collet Chuck is the collet chuck for highest metal removal rates in High Speed machining. The optimized design with better construction and a special coated smooth locknut combines high rigidity with vibration dampening and noise-reducing features, giving more protection to machines, spindles and tools.

- With a specially coated smooth locknut, balanced at < 1 gmm
- High runout accuracy: 0.003 mm at 3 × D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488 (Attention: By using standard collet ER, length A will get longer)
- High rigidity

- Runs smoother thanks to vibration absorbing geometry, yielding better surface finish and increased tool, spindle and machine protection
- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle times, higher machining accuracy, higher clamping forces
- Equally suited to High Speed and dynamic machining
- With threaded holes in order to balance with balancing screws
- Optional: Cool Jet bores on Power Collets
- Product range of Power Collets see page 668

ER	16	25	32
Ø D [mm]	28	42	50
Clamping range [mm]	2.0–10.0	2.0–16.0	2.0–20.0
Clamping range [inch]	1/8–3/8	1/8–5/8	1/8–3/4
L [mm]	43	62	62.5
Length A [mm]	short	70	70
Order No.	50.320...	.16.3.HP	.25.3.HP
L [mm]	43	51	53
Length A [mm]	long	100	100
Order No.	50.321...	.16.3.HP	.25.3.HP
Length A [mm]	ZG130	130	130
Order No.	50.324...	.16.3.HP	.25.3.HP
Length A [mm]	oversize	160	160
Order No.	50.322...	.16.3.HP	.25.3.HP

Accessories

High Precision Smooth Locknut (fine-balanced)

Size ER 16 ER 25 ER 32 See page 779

Order No. 83.914...



.16.1

.25.1

.32.1

Roller bearing wrench

Order No. 84.650...



.16.1

.25.1

.32.1

Collets ER



See pages 768–773

Shrink Fit Collets



See pages 760–767

Power Collets



See page 775

Power Collets with Safe-Lock



See page 776

Cool Jet bores for Power Collets

Order No. 91.100.27

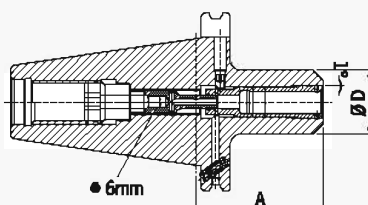


See page 777

HIGH-PRECISION CHUCK DIN ISO 7388-1 · SK50 (FORMERLY DIN 69871)

CERTIFICATE OF QUALITY

<input checked="" type="checkbox"/> Chuck body fine balanced G2.5 25,000 rpm
<input checked="" type="checkbox"/> All functional surfaces fine machined
<input checked="" type="checkbox"/> Taper tolerance AT3
<input checked="" type="checkbox"/> Coolant supply form AD/AF



Use:

For highly precise clamping of tools with cylindrical shank with special collets.
Very useful for high-speed machining.
Also suitable for ANSI-CAT.

With taper **SK50 form AD/AF** DIN ISO 7388-1.

Form AD/AF means central coolant supply and coolant channels on the collar, which can be sealed again.

- Included in delivery: High-Precision Chuck with clamping screw and pull-out hook without collet
- Shank tolerance h6

HG	Ø D [mm]	Clamping diameter	01						02				03	
			2	3	4	5	6	8	10	12	14	16	18	20
Length A [mm]	short		65						70			75		
Order No.	50.420...		.01						.02			.03		
Length A [mm]	long		100						100			100		
Order No.	50.421...		.01						.02			.03		
Length A [mm]	oversize		160						160			160		
Order No.	50.422...		.01						.02			.03		

Accessories

Clamping screw



Collets HG INCH

See page 783

HG 01 Ø D [inch]		Ø 1/8	Ø 3/16	Ø 1/4	Ø 5/16									
Order No.	82.510...	.1/8Z	.3/16Z	.1/4Z	.5/16Z									

HG 02 Ø D [inch]		Ø 3/8	Ø 7/16	Ø 1/2	Ø 9/16									
Order No.	82.520...	.3/8Z	.7/16Z	.1/2Z	.9/16Z									

HG 03 Ø D [inch]		Ø 5/8	Ø 3/4											
Order No.	82.530...	.5/8Z	.3/4Z											

Collets HG METRIC

See page 783

HG 01		Ø 02	Ø 03	Ø 04	Ø 05	Ø 06	Ø 08	—	—	—	—	—	—	—
Order No.	82.510...	.02	.03	.04	.05	.06	.08							

HG 02		—	—	—	—	—	—	Ø 10	Ø 12	Ø 14	—	—	—	—
Order No.	82.520...							.10	.12	.14				

HG 03		—	—	—	—	—	—	—	—	—	Ø 16	Ø 18	Ø 20	—
Order No.	82.530...										.16	.18	.20	

Pull-out hook														
HG		HG 01						HG 02			HG 03			
Order No.	82.570...	.00						.00			.00			

Balancing index rings														
HG		HG 01						HG 02			HG 03			
Order No.	79.350...	.30						.35			.48			

Pull studs														

See pages 789–791

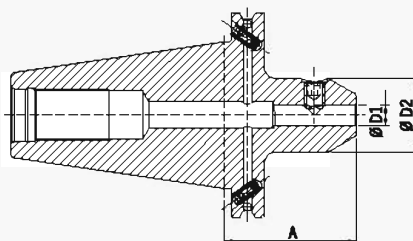
Shrink fit extensions														

See pages 751–753

Cool Jet bores														
Order No.	91.100.24													

See page 501

WELDON TOOL HOLDER DIN ISO 7388-1 · SK50 (FORMERLY DIN 69871)



CERTIFICATE OF QUALITY

- Chuck body fine balanced
G2.5 22,000 rpm
- All functional surfaces fine machined
- Taper tolerance AT3
- Coolant supply form AD/AF

Use:

For clamping cutters with cylindrical shank and Weldon flat similar to DIN 1835-B and DIN 6535-HB.

Similar to DIN 6359-2 with taper SK50 form AD/AF DIN ISO 7388-1. Form AD/AF means central coolant supply and coolant channels on the collar, which can be sealed again.

Included in delivery: with clamping screw

– Cooling with Cool Jet for an extra charge (See page 501)

Clamping	Ø D1 [mm]		06	08	10	12	14	16	18	20	25	32	40
	Ø D2 [mm]		25	28	35	42	42	48	48	52	65	72	78
Length A [mm]	short		63 ¹⁾	63 ¹⁾	63 ¹⁾	63 ¹⁾	63 ¹⁾	63 ¹⁾	63 ¹⁾	63 ¹⁾	80 ¹⁾	100	100
Order No.	50.300...		.06	.08	.10	.12	.14	.16	.18	.20	.25	.32	.40
Length A [mm]	long		100 ¹⁾	100 ¹⁾	100 ¹⁾	100 ¹⁾	100 ¹⁾	100 ¹⁾	100 ¹⁾	100 ¹⁾	100 ¹⁾	—	—
Order No.	50.301...		.06	.08	.10	.12	.14	.16	.18	.20	.25	—	—
Length A [mm]	ZG130		130 ¹⁾	130 ¹⁾	130 ¹⁾	130 ¹⁾	130 ¹⁾	130 ¹⁾	130 ¹⁾	130 ¹⁾	130 ¹⁾	130	130
Order No.	50.304...		.06	.08	.10	.12	.14	.16	.18	.20	.25	.32	.40
Length A [mm]	oversize		160 ¹⁾	160 ¹⁾	160 ¹⁾	160 ¹⁾	160 ¹⁾	160 ¹⁾	160 ¹⁾	160 ¹⁾	160	160	160
Order No.	50.302...		.06	.08	.10	.12	.14	.16	.18	.20	.25	.32	.40
Length A [mm]	ZG200		200 ¹⁾	200 ¹⁾	200 ¹⁾	200 ¹⁾	200 ¹⁾	200 ¹⁾	200 ¹⁾	200 ¹⁾	—	—	—
Order No.	50.306...		.06	.08	.10	.12	.14	.16	.18	.20	—	—	—

Standard version, with Cool Jet

Clamping	Ø D1 [mm]		10	12	16	20
	Ø D2 [mm]		35	42	48	52
Length A [mm]	short		63 ¹⁾	63 ¹⁾	63 ¹⁾	63 ¹⁾
Order No.	50.300...		.10.2	.12.2	.16.2	.20.2

Accessories

Clamping screw

Clamping Ø			06	08	10	12	14	16	18	20	25	32
Order No.	85.100...		.06	.08	.10	.12	.12	.14	.14	.16	.18	.20

Balancing index rings

Clamping Ø	long/ZG130/oversize/ZG200		06	08	10	12	14	16	18	20	25	32
Order No.	79.350...		.25	.28	.35	.42	.42	.48	.48	.52	.65	.72

Pull studs



See pages 789–791

Cool Jet bores from Ø 6 mm – Ø 20 mm



Order No. 91.100.24

See page 501

Cool Jet bores from Ø 25 mm – Ø 32 mm



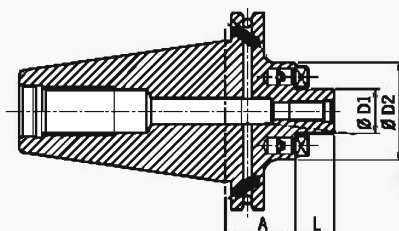
Order No. 91.100.28

See page 501

1) Also suitable for ANSI-CAT

FACE MILL ARBOR DIN ISO 7388-1 · SK50 (FORMERLY DIN 69871)

CERTIFICATE OF QUALITY	
<input checked="" type="checkbox"/>	Chuck body fine balanced G2.5 22,000 rpm
<input checked="" type="checkbox"/>	All functional surfaces fine machined
<input checked="" type="checkbox"/>	Taper tolerance AT3
<input checked="" type="checkbox"/>	Coolant supply form AD/AF



Use:

For holding face mill cutters and cutters with radial driving slot DIN 1880 and exceeding clamping diameter 40 clamping according to DIN 2079 is possible, too (4 additional tapping holes).

According to DIN 6357 with taper **SK50 form AD/AF** DIN ISO 7388-1.

Form AD/AF means central coolant supply and coolant channels on the collar, which can be sealed again.

- Included in delivery: tightening bolt
- With coolant exit bores on the end face for milling cutters with central cooling

Clamping	Ø D1 [mm]		22	27	32	40	50	60
	Ø D2 [mm]		48	60	78	88	120	127
	L [mm]		19	21	24	27	30	40
Length A [mm]	short		35 ¹⁾	35 ¹⁾	35	50	70	70
Order No.	50.350...		.22.KKB	.27.KKB	.32.KKB	.40.KKB	.50.KKB	.60.KKB
Length A [mm]	long		100 ¹⁾	100 ¹⁾	100	100	—	—
Order No.	50.351...		.22.KKB	.27.KKB	.32.KKB	.40.KKB	—	—
Length A [mm]	oversize		160 ¹⁾	160 ¹⁾	160	160	—	—
Order No.	50.352...		.22.KKB	.27.KKB	.32.KKB	.40.KKB	—	—

Accessories

Tightening bolt

Size D1

Order No.

85.300...



22

27

32

40

50

60

Wrench

Size D1

Order No.

84.400...



22

27

32

40

50

60

Balancing index rings

Size D1

Order No.

79.350...



22

27

—

—

—

—

Size D1

Order No.

79.350...

22

27

32

40

—

—

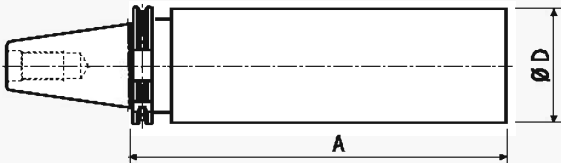
Pull studs



See pages 789–791

1) Also suitable for ANSI-CAT

BLANK ADAPTER
DIN ISO 7388-1 · SK50
(FORMERLY DIN 69871)



CERTIFICATE OF QUALITY	
<input checked="" type="checkbox"/>	All functional surfaces fine machined
<input checked="" type="checkbox"/>	Taper tolerance AT3
<input checked="" type="checkbox"/>	Coolant supply form AD/AF

Use:
For manufacturing special tools in your factory.

Design:
Taper and groove are hardened and ground, the cylindrical part is soft.

With taper **SK50 form AD/AF** DIN ISO 7388-1.
Form AD/AF means central coolant supply and coolant channels on the collar, which can be sealed again.

	Ø D [mm]		95
Length A [mm]	ZG315		315 ¹⁾
Order No.	50.390...		.95

Accessories
Pull studs



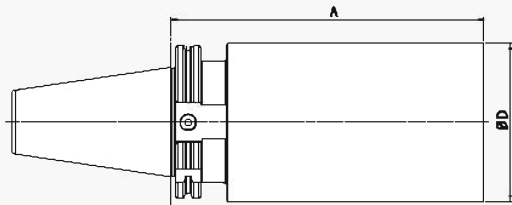
See pages 789–791

1) Also suitable for ANSI-CAT

BLANK ADAPTER – HARDENED
DIN ISO 7388-1 · SK50
(FORMERLY DIN 69871)

CERTIFICATE OF QUALITY

- ✓ All functional surfaces fine machined
- ✓ Taper tolerance AT3



Use:

For manufacturing special tools in your factory.

Version:

- Taper and groove hardened and ground
- Cylindrical part hardened to 52+2 HRC

Taper **DIN ISO 7388-1 SK50** prepared for Form AD.
Form AD means central coolant supply

	Ø D [mm]		101
Gage Length A [mm]	ZG100		100
Order No.	R50.396.1010...		.0100
Gage Length A [mm]	ZG200		200
Order No.	R50.396.1010...		.0200
Gage Length A [mm]	ZG300		300
Order No.	R50.396.1010...		.0300

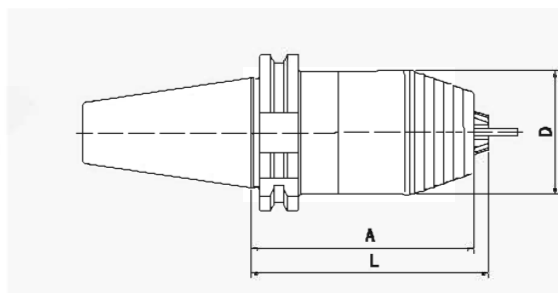
Accessories
Pull studs



See pages 789–791

HAIMER

SHORT DRILL CHUCK **DIN ISO 7388-1 · SK50** **(FORMERLY DIN 69871)**



CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced
G6.3 22,000 rpm
- ☒ All functional surfaces fine machined
- ☒ Taper tolerance AT3
- ☒ Coolant supply form AD/AF

Use:

For clamping tools with cylindrical shank, for left and right hand turn, clamping and loosening with a hexagon socket wrench.

With DIN ISO 7388-1 SK50 Form AD/AF.

Form AD/AF means central coolant supply and coolant channels on the collar which can be sealed again

	Clamping range [mm]		0.5–13
	Ø D [mm]		50
	L [mm]		106
Length A [mm]			112
Order No.	50.411...		.13

Accessories

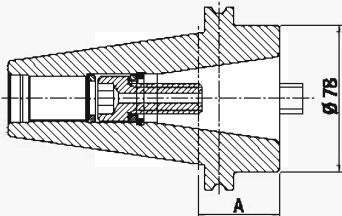
Pull studs



See pages 789–791

ADAPTER
DIN ISO 7388-1 · SK50
(FORMERLY DIN 69871)


CERTIFICATE OF QUALITY	
<input checked="" type="checkbox"/>	Chuck body fine balanced G6.3 8,000 rpm
<input checked="" type="checkbox"/>	All functional surfaces fine machined
<input checked="" type="checkbox"/>	Taper tolerance AT3



Use:
For holding tapers according to DIN ISO 7388-1 AD SK40
and JIS B 6339 BT40.

With taper **SK50 form AD** DIN ISO 7388-1.

- Included in delivery: mounted tightening bolt
- Fine-balancing for an extra charge

Holding Taper	SK		40
Length A [mm]	short		43
Order No.	50.360...		.40

Accessories
Pull studs



See pages 789–791



Tooling
Technology

Shrinking
Technology

Balancing
Technology

Measuring and
Presetting Technology

HAIMER SAFE-LOCK®

For reliable roughing and trochoidal milling processes, combined with the highest precision and without any risk of tool pull out