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# HAIMER®

HAIMER.

Tool  
Holders

# TOOL HOLDERS



# DIN 69893 HSK-A / HSK-E / HSK-F

## Article

## Page

### DIN 69893 HSK-A32

Shrink Fit Chuck	392
Collet Chuck ER	393
Power Collet Chuck	394
High Precision Collet Chuck	395
Blank Adapter – Hardened	396

### DIN 69893 HSK-A40

Shrink Fit Chuck	397
Collet Chuck ER	398
Power Collet Chuck	399
High Precision Collet Chuck	400
Face Mill Arbor	401
Blank Adapter – Hardened	402

### DIN 69893 HSK-A50

Shrink Fit Chuck	403
Collet Chuck ER	404
Power Collet Chuck	405
High Precision Collet Chuck	406
Face Mill Arbor	407
Blank Adapter – Hardened	408

### DIN 69893 HSK-A63

Shrink Fit Chuck	409
Collet Chuck ER	416
Power Collet Chuck	417
High Precision Collet Chuck	418
High-Precision Chuck	419
Face Mill Arbor	420
Adapter for Morse Taper	421
Blank Adapter / Blank Adapter – Hardened	423

### DIN 69893 HSK-A63/80

Shrink Fit Chuck	424
Power Collet Chuck	430
Face Mill Arbor	431
Blank Adapter – Hardened	432

### DIN 69893 HSK-A80

Shrink Fit Chuck	433
Collet Chuck ER	435
Power Collet Chuck	436
Blank Adapter – Hardened	437

### DIN 69893 HSK-A100

Shrink Fit Chuck	438
Power Shrink Chuck	439
Heavy Duty Chuck	440
Collet Chuck ER	441
Power Collet Chuck	442
High Precision Collet Chuck	443
High-Precision Chuck	444
Face Mill Arbor	445
Adapter for Morse Taper	446
Blank Adapter / Blank Adapter – Hardened	448

### DIN 69893 HSK-A125

Power Shrink Chuck	449
Heavy Duty Chuck	450
Power Collet Chuck	451
Face Mill Arbor	452

### DIN 69893 HSK-E25

Mini Shrink Chuck	453
Collet Chuck Mini ER	454
Power Collet Chuck	455
Blank Adapter – Hardened	456

### DIN 69893 HSK-E32

Shrink Fit Chuck	457
Collet Chuck ER	459
Power Collet Chuck	460
High Precision Collet Chuck	461
Blank Adapter – Hardened	462

### DIN 69893 HSK-E40

Shrink Fit Chuck	463
Collet Chuck ER	465
Power Collet Chuck	466
High Precision Collet Chuck	467
Blank Adapter – Hardened	468

### DIN 69893 HSK-E50

Shrink Fit Chuck	469
Collet Chuck ER	471
Power Collet Chuck	472
High Precision Collet Chuck	473
Face Mill Arbor	474

### DIN 69893 HSK-F63

Shrink Fit Chuck	475
Collet Chuck ER	476
Face Mill Arbor	477
Blank Adapter – Hardened	478

### DIN 69893-6 HSK-F80M

Shrink Fit Chuck	479
Collet Chuck ER	481
Face Mill Arbor	482
Blank Adapter – Hardened	483

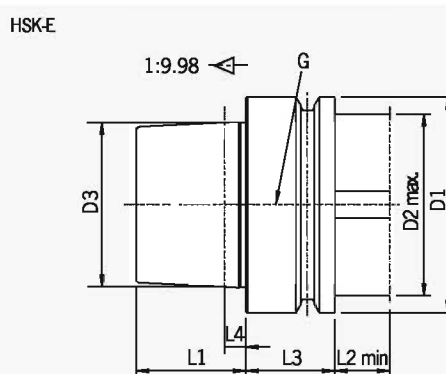
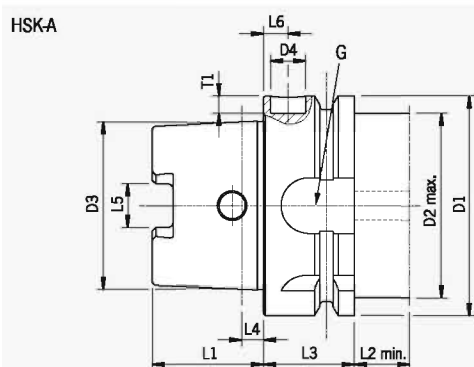
# HSK-A/HSK-E/HSK-F DIN 69893

**Compared to the steep taper the HSK has the following advantages:**

- Highly repeatable accuracy when clamping tools into spindle
- Fixed axial positioning with flat contact surface
- Suitable for high speed cutting
- No pull stud necessary
- Incl. bore for data chip (only HSK-A)

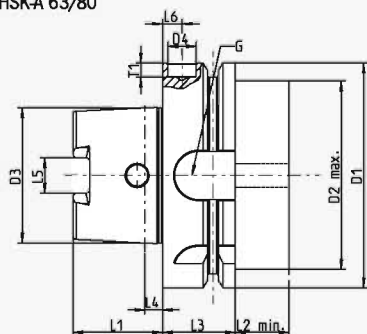
**Material:**

- Special case-hardening steel for highly stressed parts
- Surface hardness: 58–2 HRC
- **Tensile strength in core min. 1000 N/mm<sup>2</sup>**

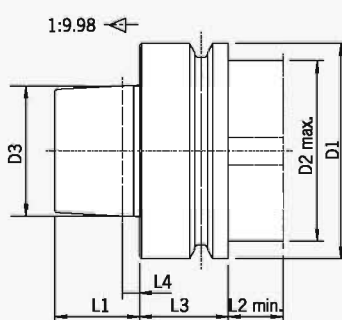


Length [mm]	D1	D2 max.	D3	D4	L1	L2 min.	L3	L4	L5	L6	G	T1
HSK-E 25	25	20	19.006	—	13	10	10	2.5	—	—	M8x1	—
HSK-A/E 32	32	26	24.007	10/—	16	15	20	3.2	7.05	7	M10x1	5.4/—
HSK-A/E 40	40	34	30.007	10/—	20	15	20	4	8.05	7	M12x1	5.3/—
HSK-A/E 50	50	42	38.009	10/—	25	16	26	5	10.54	7	M16x1	5.2/—
HSK-A 63	63	53	48.010	10/—	32	16	26	6.3	12.54	7	M18x1	5/—
HSK-A 80	80	67	60.012	10/—	40	16	26	8	16.04	7	M20x1.5	5/—
HSK-A 100	100	85	75.013	10/—	50	16	29	10	20.02	7	M24x1.5	4.9/—
HSK-A 125	125	111	95.016	10/—	63	16	29	12.5	25.02	7	M30x1.5	4.8/—

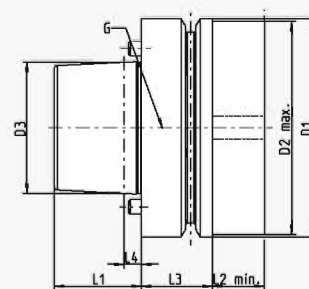
HSK-A 63/80



HSK-F

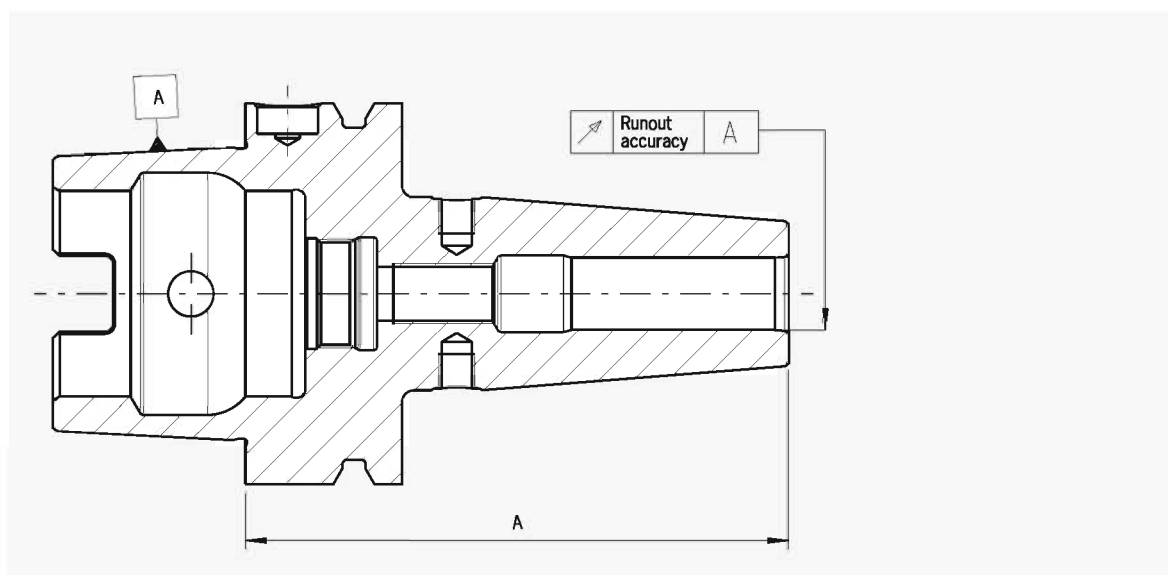


HSK-F 80M



Length [mm]	D1	D2 max.	D3	D4	L1	L2 min.	L3	L4	L5	L6	G	T1
HSK-A 63/80	80	67	48.010	10/—	32	16	26	6.3	12.54	7	M18x1	5/—
HSK-F 63	63	53	38.009	—	25	16	26	5	—	—	—	—
HSK-F 80M	80	78	48.010	—	32	16	26	6.3	—	—	M18x1	—

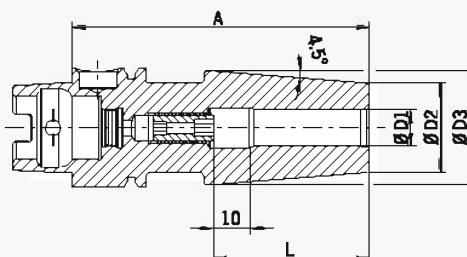
# RUNOUT ACCURACY DIN 69893



Gage length A [mm]	A < 160	A ≥ 160
max. runout tolerance in mm		
Shrink Fit Chuck	0.003	0.004
Mini Shrink	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
Face Mill Arbor	0.006	0.006
Whistle Notch Tool Holder	0.003	0.004
Adapter for Morse Taper	0.008	—



# SHRINK FIT CHUCK DIN 69893-1 · HSK-A32



## CERTIFICATE OF QUALITY

- Chuck body fine balanced  
U < 1 gmm
- All functional surfaces fine machined
- More accurate than DIN

### Use:

Shrink fit chuck suitable for use with all available shrink fit units.

### DIN 69893-1

- Included in delivery: Shrink fit chuck with back-up screw, without coolant tube
- Heat resistant hot-working steel
- Hardened 54-2 HRC
- For HSS and solid carbide tools
- Shank tolerance h6

### Optional:

- Cooling with Cool Jet for an extra charge (See page 501)
- Cooling with Cool Flash from diam. 6 mm for an extra charge (See pages 502–503)

### Standard version, similar to DIN 69882-8

METRIC	Clamping Ø D1 [mm]	03	04	05	06	08	10
	Ø D2 [mm]	10	10	10	21	21	24
	Ø D3 [mm]	—	—	—	27	27	32
	L [mm]	09	12	15	36	36	42
Length A [mm]	short	60 <sup>1)</sup>	60 <sup>1)</sup>	60 <sup>1)</sup>	70 <sup>2)</sup>	70 <sup>2)</sup>	80 <sup>2)</sup>
Order No.	A32.140...	.03	.04	.05	.06	.08	.10

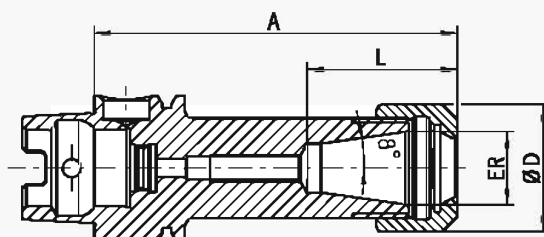
### Accessories

Shrink fit extensions		See pages 751–753
Balancing screws		See page 784
Coolant tube		Order No. 85.700.32 See page 793
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

## ER COLLET CHUCK DIN 69893-1 · HSK-A32

### CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced  
U < 1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



### Use:

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

### DIN 69882-6

– Hardened 54–2 HRC

Included in delivery:

- Locknut type HS (High-Speed, fine balanced, with slide coating for higher clamping forces)
- Enlarging of size L upon request

INCH	ER		16	25
	Ø D [inch]		1.1	1.65
	Clamping range [inch]		0.02–0.39	0.04–0.51
	Clamping range [mm]		0.5–10.0	1.0–16.0
	L [inch] ultra short		1.28	1.61
Gage length A [inch]	ultra short		2.17 <sup>1)</sup>	—
Order No.	A32.025...		.16	—
Gage length A [inch]	short		3.15	3.15
Order No.	A32.020...		.16	.25

### Accessories

#### Collets ER



See pages 768–773

#### Shrink Fit Collets



See pages 759–763

#### Locknut (pre-balanced)

Size

Order No.

83.912...



ER 16

ER 25

Order No.

83.912...

.16

.25

#### Chuck nut HS (fine-balanced)

Size

Order No.

83.912...



ER 16

ER 25

Order No.

83.912...

.16.HS

.25.HS

#### Fork wrench

Size

Order No.

84.200...



ER 16

—

#### Clamping wrench

Size

Order No.

84.200...



—

ER 25

#### Balancing index rings

Size

Order No.

long/oversize  
79.350...



ER 16

ER 25

Order No.

79.350...

.22

.32

#### Adjusting screw

Size

Order No.

85.800...



ER 16

ER 25

#### Coolant tube

Order No.

85.700.32



.34

.34

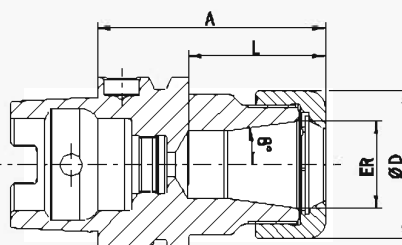
#### Shrink fit extensions



See pages 751–753

1) Without thread for back-up screw

# POWER COLLET CHUCK DIN 69893-1 · HSK-A32



## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
U < 1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN








The Power Collet Chuck is designed for the highest cutting performance in High Speed machining. The optimized design with improved construction combines high rigidity with vibration dampening features, giving more protection to the machine, spindle and tool. The universal Power Collet Chuck is a unique high performance chuck that can also be used with standard collets.

- High runout accuracy: < 0.00012" (3 µm) 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 increase)
- High rigidity

- Hardened 54-2 HRC
- 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
- Program of Power Collets on pages 774 – 776

INCH	ER	16	25
	Ø D [inch]	1.1	1.65
	Clamping range [inch]	1/8–3/8	1/8–5/8
	Clamping range [mm]	2.0–10.0	2.0–16.0
	L [inch]	1.26	1.53
Gage length A [inch]	ultra short	1.97	2.36
Order No.	A32.025...	.16.3	.25.3

## Accessories

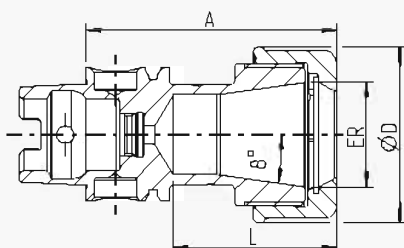
Locknut (fine-balanced)				See page 779
Size		ER 16	ER 25	
Order No. 83.914...		.16	.25	
Power Collet clamping wrench				See page 781
Torque Master torque wrench				See page 780
Power Collets				See page 775
Power Collets with Safe-Lock				See page 776
Cool Jet bores for Power Collets				See page 777
Shrink FR Collets				See pages 759–763



## HIGH PRECISION COLLET CHUCK DIN 69893-1 · HSK-A32

### CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
U < 1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



The High Precision Collet Chuck is designed for the highest cutting performance 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. The chuck is especially suitable for micro and fine machining (e.g. in the medical or watchmaking industry).

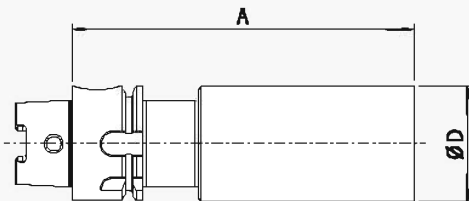
- With a specially coated smooth locknut, balanced at < 1 gmm
- High runout accuracy: < 0.00012" (3 µm) at 3 × D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488  
(Attention: By using standard collet, ER length A will increase)
- High rigidity
- Runs smoother thanks to 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
- Program of Power Collets on pages 774 – 776

INCH	ER	16	25
	Ø D [inch]	1.1	1.65
	Clamping range [inch]	1/8–3/8	1/8–5/8
	Clamping range [mm]	2.0–10.0	2.0–16.0
	L [inch]	1.26	1.53
Gage length A [inch]	ultra short	1.97	2.36
Order No.	A32.025...	.16.3.HP	.25.3.HP

### Accessories

High Precision Smooth Locknut (fine-balanced)			See page 779
Size		ER 16	ER 25
Order No. 83.914...		.16.1	.25.1
Roller bearing wrench			See page 782
Order No. 84.650...		.16.1	.25.1
Collets ER			See pages 768–773
Shrink Fit Collets			See pages 759–763
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			

BLANK ADAPTER – HARDENED  
DIN 69893-1 · HSK-A32



CERTIFICATE OF QUALITY

☒ All functional surfaces fine machined
   
☒ More accurate than DIN

**Use:**  
For manufacturing special tools in your own factory.

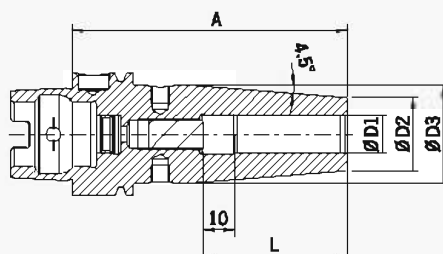
- Version:**
- HSK hardened and ground
  - Cylindrical part hardened to 52+2 HRC

METRIC	Ø D [mm]		32.3
Gage Length A [mm]	ZG96		96
Order No.	RA32.096.0323...		.0096

# SHRINK FIT CHUCK DIN 69893-1 · HSK-A40

## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
G2.5 25,000 rpm or U<1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



## Use:

Shrink fit chuck suitable for use with all available shrink fit units.

## Optional:

- Cooling with Cool Jet for an extra charge (See page 501)
- Cooling with Cool Flash from 1/4" for an extra charge (See pages 502–503)

## DIN 69893-1

- Included in delivery: Shrink fit chuck with back-up screw, without coolant tube
- 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

INCH	Clamping Ø D1 [inch]	1/8	3/16	1/4	3/8	7/16	1/2	5/8
	Ø D2 [inch]	0.39	0.39	0.83	0.94	0.94	0.94	1.06
	Ø D3 [inch]	—	—	1.06	1.26	1.26	1.26	1.30
	L [inch]	0.35	0.59	1.42	1.65	1.65	1.85	1.97
Gage length A [inch]	short	2.36 <sup>1)</sup>	2.36 <sup>1)</sup>	3.15	3.15	3.15	3.54	3.54
Order No.	A40.140...	.1/8Z	.3/16Z	.1/4Z	.3/8Z	.7/16Z	.1/2Z	.5/8Z

## Standard version, similar to DIN 69882-8

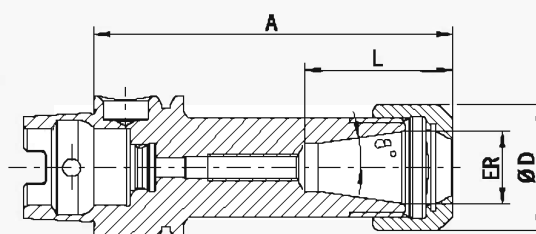
METRIC	Clamping Ø D1 [mm]	03	04	05	06	08	10	12	14	16
	Ø D2 [mm]	10	10	10	21	21	24	24	27	27
	Ø D3 [mm]	—	—	—	27	27	32	32	34	34
	L [mm]	09	12	15	36	36	42	47	47	50
Length A [mm]	short	60 <sup>1)</sup>	60 <sup>1)</sup>	60 <sup>1)</sup>	80	80	80	90	90	90
Order No.	A40.140...	.03	.04	.05	.06	.08	.10	.12	.14	.16
Length A [mm]	ZG120	120 <sup>2)</sup>	120 <sup>2)</sup>	120 <sup>2)</sup>	120	120	120	120	—	—
Order No.	A40.147...	.03.1	.04.1	.05.1	.06	.08	.10	.12	—	—
Length A [mm]	ZG130	130 <sup>2)</sup>	130 <sup>2)</sup>	130 <sup>2)</sup>	130	130	130	130	—	—
Order No.	A40.144...	.03.1	.04.1	.05.1	.06	.08	.10	.12	—	—

## Accessories

Shrink fit extensions		See pages 750–753
Balancing screws		See page 784
Coolant tube		Order No. 85.700.40 See page 793
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

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

# ER COLLET CHUCK DIN 69893-1 · HSK-A40



## CERTIFICATE OF QUALITY

- Chuck body fine balanced  
U<1 gmm
- All functional surfaces fine machined
- More accurate than DIN

### Use:

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

### DIN 69892-6

– Hardened 54–2 HRC

Included in delivery:

- Locknut type HS (High Speed, fine balanced, with slide coating for higher clamping forces)
- Enlarging of size L upon request

INCH	ER	11	16	25	32
Ø D [inch]		0.75	1.10	1.65	1.97
Clamping range [inch]		0.02–0.28	0.02–0.39	0.04–0.63	0.04–0.79
Clamping range [mm]		0.5–7.0	0.5–10.0	1.0–16.0	1.5–20.0
L [inch]		0.93	1.28	1.61	1.85
Gage length A [inch]	ultra short	2.36 <sup>1)</sup>	2.36 <sup>1)</sup>	2.76 <sup>1)</sup>	2.76 <sup>1)</sup>
Order No.	A40.023...	.11	.16	.25	.32
Gage length A [inch]	short	—	3.15	3.15	—
Order No.	A40.020...	—	.16	.25	—

### Accessories

#### Collets ER



See pages 768–773

#### Shrink Fit Collets



See pages 758–767

#### Locknut (pre-balanced)

Size  
Order No. 83.912...



ER 11	ER 16	ER 25	ER 32
.11	.16	.25	.32

#### Chuck nut HS (fine-balanced)

Size  
Order No. 83.912...



—	ER 16	ER 25	ER 32
—	.16.HS	.25.HS	.32.HS

#### Fork wrench

Size  
Order No. 84.200...



ER 11	ER 16	—	—
.11	.16	—	—

#### Clamping wrench

Size  
Order No. 84.200...



—	—	ER 25	ER 32
—	—	.25	.32

#### Balancing Index rings

Size  
Order No. long/oversize 79.350...



—	ER 16	ER 25	ER 32
—	.19	.28	.32

#### Adjusting screw

Size  
Order No. 85.800...



—	ER 16	ER 25	ER 32
—	.34	.34	.35

#### Coolant tube

Order No. 85.700.40



#### Shrink fit extensions



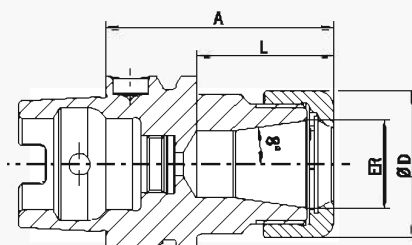
See pages 751–753

1) Drilled through

# POWER COLLET CHUCK DIN 69893-1 · HSK-A40

## CERTIFICATE OF QUALITY

- Chuck body fine balanced  
U < 1 g/mm
- All functional surfaces fine machined
- More accurate than DIN



The Power Collet Chuck is designed for the highest cutting performance in High Speed machining. The optimized design with improved construction combines high rigidity with vibration dampening features, giving more protection to the machine, spindle and tool. The universal Power Collet Chuck is a unique high performance chuck that can also be used with standard collets.

- High runout accuracy: < 0.00012" (3 µm) at 3 x D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488  
(Attention: By using standard collet, ER length A will increase)
- High rigidity

- Hardened 54–2 HRC
- 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
- Program of Power Collets on pages 774 – 776

INCH	ER	16	25	32
	Ø D [inch]	1.1	1.65	1.97
	Clamping range [inch]	1/8–3/8	1/8–5/8	1/8–3/4
	Clamping range [mm]	2.0–10.0	2.0–16.0	2.0–20.0
	L [inch] ultra short	1.22	1.51	1.85
Gage length A [inch]	ultra short	1.97	2.36	2.76
Order No.	A40.025...	.16.3	.25.3	.32.3
	L [inch] short	1.69	2.01	2.09
Gage length A [inch]	short	3.15	3.15	3.15
Order No.	A40.020...	.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



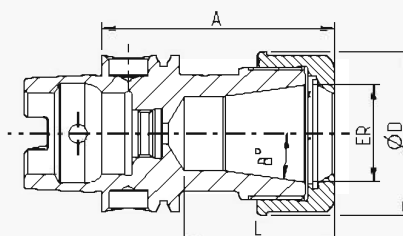
Coolant tube

Order No. 85.700.40





# HIGH PRECISION COLLET CHUCK DIN 69893-1 · HSK-A40



## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
U<1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN

The High Precision Collet Chuck is designed for the highest cutting performance 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. The chuck is especially suitable for micro and fine machining (e.g. in the medical or watchmaking industry).

- With a specially coated smooth locknut, balanced at < 1 gmm
- High runout accuracy: < 0.00012" (3 µm) at 3 x D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488  
(Attention: By using standard collet, ER length A will increase)
- 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
- Program of Power Collets on pages 774 – 776

INCH	ER	16	25	32
	Ø D [inch]	1.1	1.65	1.97
	Clamping range [inch]	1/8–3/8	1/8–5/8	1/8–3/4
	Clamping range [mm]	2.0–10.0	2.0–16.0	2.0–20.0
	L [inch] ultra short	1.22	1.51	1.85
Gage length A [inch]	ultra short	1.97	2.36	2.76
Order No.	A40.025...	.16.3.HP	.25.3.HP	.32.3.HP
	L [inch] short	1.69	2.01	2.09
Gage length A [inch]	short	3.15	3.15	3.15
Order No.	A40.020...	.16.3.HP	.25.3.HP	.32.3.HP

## Accessories

### High Precision Smooth Locknut (fine-balanced)

Size ER 16 ER 25 ER 32 See page 779

Order No. 83.914...

### Roller bearing wrench

Order No. 84.650...

### Collets ER

### Shrink Fit Collets

### Power Collets

### Power Collets with Safe-Lock

### Cool Jet bores for Power Collets

Order No. 91.100.27

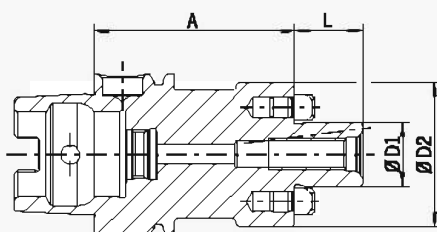
### Coolant tube

Order No. 85.700.40

## FACE MILL ARBOR DIN 69893-1 · HSK-A40

### CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced  
U<1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



### Use:

For holding face mill cutters and cutters with radial driving slot DIN 1880.

### DIN 69892-3

- Hardened 54–2 HRC
- Included in delivery: tightening bolt, without coolant tube
- With coolant exit bores on the end face for milling cutters with central cooling

METRIC	Clamping Ø D1 [mm]	16	22
	Ø D2 [mm]	36	48
	L [mm]	17	19
Length A [mm]	short	50	60
Order No.	A40.050...	.16.KKB	.22.KKB

### Accessories

#### Tightening bolt

Size D1		16	22
Order No.	85.300...	.16	.22

#### Wrench

Size D1		16	22
Order No.	84.400...	.16	.22

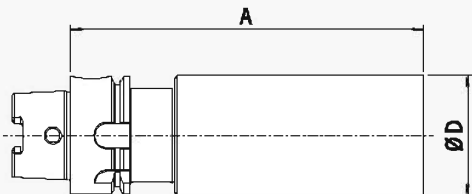
#### Balancing index rings

Size D1		16	22
Order No.	79.350...	.36	.48

#### Coolant tube

Order No.	85.700.40		
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BLANK ADAPTER – HARDENED  
DIN 69893-1 · HSK-A40



CERTIFICATE OF QUALITY

☒ All functional surfaces fine machined
   
☒ More accurate than DIN

**Use:**  
For manufacturing special tools in your own factory.

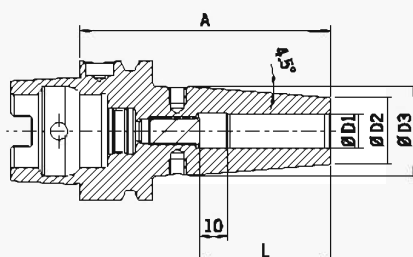
**Version:**  
 – HSK hardened and ground  
 – Cylindrical part hardened to 52+2 HRC

METRIC	Ø D [mm]	40.7
Gage Length A [mm]	ZG120	120
Order No.	RA40.096.0407... 	.0120

## SHRINK FIT CHUCK DIN 69893-1 · HSK-A50

### CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced  
G2.5 25,000 rpm or U<1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



### Use:

Shrink fit chuck suitable for use with all available shrink fit units.

### DIN 69893-1

- Included in delivery: Shrink fit chuck with backup screw, without coolant tube
- 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

### Optional:

- Cooling with Cool Jet for an extra charge (See page 501)
- Cooling with Cool Flash from diam. 6 mm for an extra charge (See pages 502–503)

### Standard version, similar to DIN 69882-8

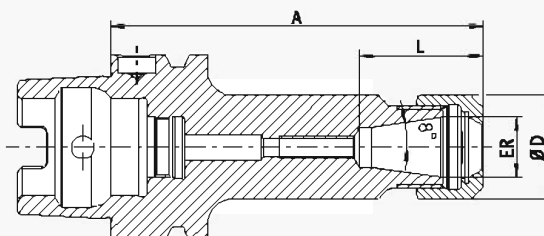
METRIC	Clamping Ø D1 [mm]		03	04	05	06	08	10	12	14	16
	Ø D2 [mm]		10	10	10	21	21	24	24	27	27
	Ø D3 [mm]		—	—	—	27	27	32	32	34	34
	L [mm]		09	12	15	38	38	42	47	47	50
Length A [mm]	short		60 <sup>1)</sup>	60 <sup>1)</sup>	60 <sup>1)</sup>	80	80	85	90	90	95
Order No.	A50.140...		.03	.04	.05	.06	.08	.10	.12	.14	.16
Length A [mm]	ZG120		120 <sup>2)</sup>	120 <sup>2)</sup>	120 <sup>2)</sup>	120	120	120	120	—	120
Order No.	A50.147...		.03.1	.04.1	.05.1	.06	.08	.10	.12		.16
Length A [mm]	ZG130		130 <sup>2)</sup>	130 <sup>2)</sup>	130 <sup>2)</sup>	130	130	130	130	—	130
Order No.	A50.144...		.03.1	.04.1	.05.1	.06	.08	.10	.12		.16

### Accessories

Shrink fit extensions			See pages 751–753
Balancing screws			See page 784
Coolant tube		Order No. 85.700.50	See page 793
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

1) Without backup screw, without threads for balancing screws, with slots along the clamping bore for cooling from outside  
2) Without backup screw, without threads for balancing screws, without slots along the clamping bore for cooling from outside

# ER COLLET CHUCK DIN 69893-1 · HSK-A50



## CERTIFICATE OF QUALITY

- Chuck body fine balanced  
G2.5 25,000 rpm or U<1 gmm
- All functional surfaces fine machined
- More accurate than DIN

### Use:

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

### DIN 69892-6

– Hardened 54–2 HRC

Included in delivery:

- Locknut type HS (High-Speed, fine balanced, with slide coating for higher clamping forces)
- Enlarging of size L upon request

INCH	ER		11	16	25	32	40
	Ø D [inch]		0.75	1.10	1.85	1.97	2.48
	Clamping range [inch]		0.02–0.28	0.02–0.39	0.04–0.63	0.06–0.79	0.10–1.02
	Clamping range [mm]		0.5–7.0	0.5–10.0	1.0–16.0	1.5–20.0	2.5–26.0
	L [inch]		1.04	1.28	1.81	1.85	2.09
Gage length A [inch]	ultra short		2.36 <sup>1)</sup>	2.36 <sup>1)</sup>	2.76 <sup>1)</sup>	3.15 <sup>1)</sup>	3.15 <sup>1)</sup>
Order No.	A50.025...		.11	.16	.25	.32	.40
Gage length A [inch]	short		—	3.94	3.94	3.94	4.72
Order No.	A50.020...		—	.16	.25	.32	.40

### Accessories

#### Collets ER



See pages 768–773

#### Shrink Fit Collets



See pages 758–767

#### Locknut (pre-balanced)

Size

Order No.

83.912...



ER 16

.16

ER 25

.25

ER 32

.32

#### Chuck nut HS (fine-balanced)

Size

Order No.

83.912...



ER 16

.16.HS

ER 25

.25.HS

ER 32

.32.HS

#### Fork wrench

Size

Order No.

84.200...



ER 16

.16

—

—

#### Clamping wrench

Size

Order No.

84.200...



—

ER 25

.25

ER 32

.32

#### Balancing index rings

Size

Order No.

long/oversize  
79.350...<sup>2)</sup>



ER11

.19

ER 16

.22

ER 25

.32

ER 32

.40

ER 40

.50

#### Adjusting screw

Size

Order No.

85.800...



ER 16

.34

ER 25

.34

ER 32

.35

#### Coolant tube

Order No.

85.700.50



#### Shrink fit extensions



See pages 751–753

<sup>1)</sup> Drilled through

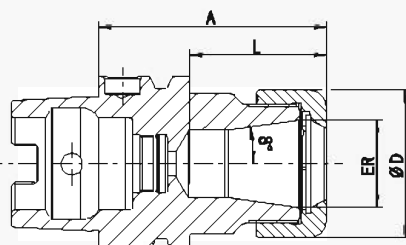
<sup>2)</sup> Suitable balancing index rings Order No. 79.350.28



# POWER COLLET CHUCK DIN 69893-1 · HSK-A50

## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
U < 1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



The Power Collet Chuck is designed for the highest cutting performance in High Speed machining. The optimized design with improved construction combines high rigidity with vibration dampening features, giving more protection to the machine, spindle and tool. The universal Power Collet Chuck is a unique high performance chuck that can also be used with standard collets.

- High runout accuracy: < 0.00012" (3 µm) at 3 x D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488 (formerly DIN 6499)  
(Attention: By using standard collet, ER length A will increase)
- High rigidity
- Hardened 54-2 HRC

- 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
- Program of Power Collets on pages 774 - 776

INCH	ER	16	25	32
	Ø D [inch]	1.1	1.65	1.97
	Clamping range [inch]	1/8-3/8	1/8-5/8	1/8-3/4
	Clamping range [mm]	2.0-10.0	2.0-16.0	2.0-20.0
	L [inch]	1.26	1.53	1.89
Gage length A [inch]	ultra short	2.36	2.56	2.95
Order No.	A50.025...	.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

Order No. 91.100.27

Shrink Fit Collets

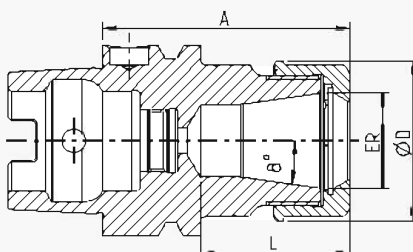


Coolant tube

Order No. 85.700.50



## HIGH PRECISION COLLET CHUCK DIN 69893-1 · HSK-A50



### CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
U < 1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN

The High Precision Collet Chuck is designed for the highest cutting performance 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. The chuck is especially suitable for micro and fine machining (e.g. in the medical or watchmaking Industry).

- With a specially coated smooth locknut, balanced at < 1 gmm
- High runout accuracy: < 0.00012" (3 µm) at 3 x D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488 (Attention: By using standard collet, ER length A will increase)

- 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
- Program of Power Collets on pages 774 – 776

INCH	ER	16	25	32
	Ø D [Inch]	1.1	1.65	1.97
	Clamping range [Inch]	1/8–3/8	1/8–5/8	1/8–3/4
	Clamping range [mm]	2.0–10.0	2.0–16.0	2.0–20.0
	L [Inch]	1.26	1.53	1.89
Gage length A [Inch]	ultra short	2.36	2.56	2.95
Order No.	A50.025...	.16.3.HP	.25.3.HP	.32.3.HP

### Accessories

#### High Precision Smooth Locknut (fine-balanced)

Size ER 16 ER 25 ER 32 See page 779

Order No. 83.914...

#### Roller bearing wrench

Order No. 84.650...

#### Collets ER

#### Shrink Fit Collets

#### Power Collets

#### Power Collets with Safe-Lock

#### Cool Jet bores for Power Collets

Order No. 91.100.27

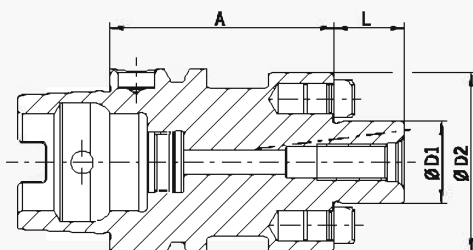
Coolant tube

Order No. 85.700.50

## FACE MILL ARBOR DIN 69893-1 · HSK-A50

### CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
G2.5 25,000 rpm or U<1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN





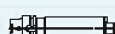
### Uses:

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 tapped holes).

With coolant exit bores on the end face for milling cutters with central cooling.

### DIN 69892-3

– Included in delivery: tightening bolt, without coolant tube

METRIC	Clamping Ø D1 [mm]		16	22	27	32
	Ø D2 [mm]		36	48	60	78
	L [mm]		17	19	21	24
Length A [mm]	short		50	60	60	—
Order No.	A50.050...		.16.KKB	.22.KKB	.27.KKB	—
Length A [mm]	long		100	100	100	100
Order No.	A50.051...		.16.KKB	.22.KKB	.27.KKB	.32.KKB
Length A [mm]	oversize		160	—	—	—
Order No.	A50.052...		.16.KKB	—	—	—

### Accessories

#### Tightening bolt

Size D1

Order No. 85.300...



16

22

27

.16

.22

.27

#### Wrench

Size D1

Order No. 84.400...



16

22

27

.16

.22

.27

#### Balancing index rings

Size D1

Order No. 79.350...



16

22

27

.36

.48

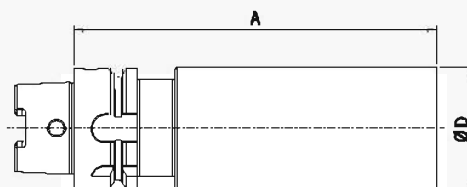
.60

#### Coolant tube

Order No. 85.700.50



## BLANK ADAPTER – HARDENED DIN 69893-1 · HSK-A50



### CERTIFICATE OF QUALITY

- ☒ All functional surfaces fine machined
- ☒ More accurate than DIN

#### Use:

For manufacturing special tools in your own factory.

#### Version:

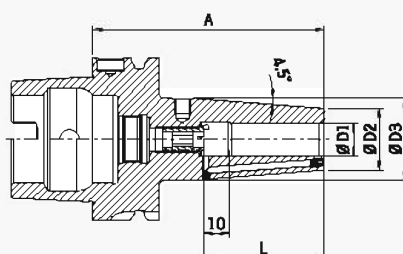
- HSK hardened and ground
- Cylindrical part hardened to 52+2 HRC

METRIC	Ø D [mm]	50.7
Gage Length A [mm]	ZG150	150
Order No.	RA50.096.0507... 	.0150

# SHRINK FIT CHUCK DIN 69893-1 · HSK-A63 INCH

## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
G2.5 25,000 rpm  
or U<1 gmm
- ✓ All functional surfaces machined
- ✓ More accurate than DIN
- ✓ Cool Jet, can be sealed



## Use:

Shrink fit chuck suitable for use with all available shrink fit units.

- 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
- Cool Jet coolant bores that can be sealed included

## DIN 69893-1

Optional:

- Cooling with Cool Flash from ¼"–1" for an extra charge (See pages 502–503)

## Standard version

INCH	Clamping Ø D1 [Inch]		1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	1 1/4
	Ø D2 [Inch]		0.39	0.39	0.83	0.83	0.94	0.94	0.94	1.06	1.30	1.73	1.73
	Ø D3 [Inch]		–	–	1.06	1.06	1.26	1.26	1.26	1.34	1.65	2.09	2.09
	L [Inch]		0.35	0.47	1.42	1.42	1.65	1.65	1.85	1.97	2.05	2.28	2.28
Gage length A [Inch]	short		3.15 <sup>1)</sup>	3.15 <sup>1)</sup>	3.15	3.15	3.35	3.35	3.54	3.74	3.94	4.53	4.72
Order No.	A63.140...		.1/82	.3/162	.1/42.4	.5/162.4	.3/82.4	.7/162.4	.1/22.4	.5/82.4	.3/42.4	.12.4	.1 1/42.4
Gage length A [Inch]	ZG130		–	–	5.12	5.12	5.12	5.12	5.12	5.12	5.12	5.12	5.12
Order No.	A63.144...		–	–	.1/42.4	.5/162.4	.3/82.4	.7/162.4	.1/22.4	.5/82.4	.3/42.4	.12.4	.1 1/42.4
Gage length A [Inch]	oversize		–	–	6.30	6.30	6.30	6.30	6.30	6.30	6.30	6.30	–
Order No.	A63.142...		–	–	.1/42.4	.5/162.4	.3/82.4	.7/162.4	.1/22.4	.5/82.4	.3/42.4	.12.4	–

## Standard version with Safe-Lock and M3 seal screw installed

INCH	Clamping Ø D1 [Inch]		1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4
	Ø D2 [Inch]		0.83	0.83	0.94	0.94	1.06	1.30	1.73	1.73
	Ø D3 [Inch]		1.06	1.06	1.26	1.26	1.34	1.65	2.09	2.09
	L [Inch]		1.42	1.42	1.65	1.85	1.97	2.05	2.28	2.28
Gage length A [Inch]	short		3.15 <sup>2)</sup>	3.15 <sup>2)</sup>	3.35 <sup>2)</sup>	3.54 <sup>2)</sup>	3.74 <sup>2)</sup>	3.94 <sup>2)</sup>	4.53 <sup>2)</sup>	4.72 <sup>2)</sup>
Order No.	A63.140...		.1/42.47	.5/162.47	.3/82.47	.1/22.47	.5/82.47	.3/42.47	.12.47	.1 1/42.47

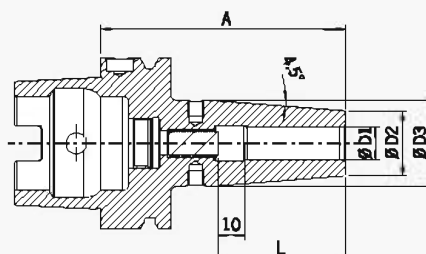
## Accessories

Coolant tube		Order No. 85.700.63	See page 793
Set of Balancing Screws		Order No. 80.203.00	See pages 784
Back-up screws			See pages 796–799
Cool Flash		Order No. 91.100.40	See pages 502–503

1) Without back-up screw, without threads for balancing screws, with slots along the clamping bore for coolant around the tool  
2) With tension spring



# SHRINK FIT CHUCK DIN 69893-1 · HSK-A63 METRIC



## CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced  
G2.5 25,000 rpm or U<1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN

### Use:

Shrink fit chuck suitable for use with all available shrink fit units.

- 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, without coolant tube

### DIN 69893-1

#### Optional:

- 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

METRIC	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 <sup>1)</sup>	80 <sup>1)</sup>	80 <sup>1)</sup>	80	80	85	90	90	95	95	100	115	120
Order No.	A63.140...	.03.1	.04.1	.05.1	.06	.08	.10	.12	.14	.16	.18	.20	.25	.32
Length A [mm]	ZG120	120 <sup>2)</sup>	120 <sup>2)</sup>	120 <sup>2)</sup>	120	120	120	120	120	120	120	120	—	—
Order No.	A63.147...	.03.1	.04.1	.05.1	.06	.08	.10	.12	.14	.16	.18	.20	—	—
Length A [mm]	ZG130	130 <sup>2)</sup>	130 <sup>2)</sup>	130 <sup>2)</sup>	130	130	130	130	130	130	130	130	130	—
Order No.	A63.144...	.03.1	.04.1	.05.1	.06	.08	.10	.12	.14	.16	.18	.20	.25	—
Length A [mm]	oversize	—	—	—	160	160	160	160	160	160	160	160	160	160
Order No.	A63.142...	—	—	—	.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.	A63.146...	—	—	—	.06	.08	.10	.12	.14	.16	.18	.20	.25	.32

### Standard version, with Cool Jet (Ø 3–5 mm Cooling with slots)

METRIC	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 <sup>3)</sup>	80 <sup>3)</sup>	80 <sup>3)</sup>	80	80	85	90	90	95	95	100	115	120
Order No.	A63.140...	.03	.04	.05	.06.2	.08.2	.10.2	.12.2	.14.2	.16.2	.18.2	.20.2	.25.2	.32.2
Length A [mm]	ZG130	—	—	—	130	130	130	130	130	130	130	130	130	—
Order No.	A63.144...	—	—	—	.06.2	.08.2	.10.2	.12.2	.14.2	.16.2	.18.2	.20.2	.25.2	—

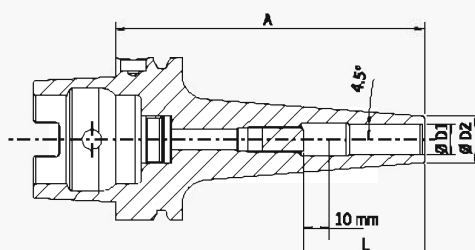
### Standard version, with Safe-Lock pull out protection

METRIC	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 <sup>3)</sup>	80 <sup>3)</sup>	85 <sup>3)</sup>	90 <sup>3)</sup>	90 <sup>3)</sup>	95 <sup>3)</sup>	95 <sup>3)</sup>	100 <sup>3)</sup>	115 <sup>3)</sup>	120 <sup>3)</sup>
Order No.	A63.140...	.06.7	.08.7	.10.7	.12.7	.14.7	.16.7	.18.7	.20.7	.25.7	.32.7

## SHRINK FIT CHUCK – EXTRA SLIM DIN 69893-1 · HSK-A63 METRIC

### CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
G2.5 25,000 rpm or U < 1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



### Use:

Shrink fit chuck suitable for use with all available shrink fit units.  
Extra slim version with smaller diameter D2, 4.5°.






- 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, without coolant tube
- Cooling with slits for an extra charge

### Standard version, similar to DIN 69882-8

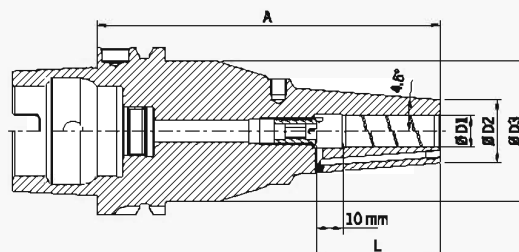
METRIC	Clamping Ø D1 [mm]	06	08	10	12
	Ø D2 [mm]	15	15	18	18
	L [mm]	36	36	42	47
Length A [mm]	ZG120	120	120	120	120
Order No.	A53.147...	.06.10	.08.10	.10.10	.12.10



### Accessories

Shrink fit extensions			See pages 751–753
Coolant tube		Order No. 85.700.63	See page 793
Reduction sleeves			See page 794
Back-up screws			See pages 796–799
Cooling adapter		Ø 6 – 12 mm	See page 592
Order No.		80.105.14.1.2	

# POWER SHRINK CHUCK DIN 69893-1 · HSK-A63



## CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced  
G2.5 25,000 rpm  
or U<1 gmm
- ☒ All functional surfaces fine machined
- ☒ More accurate than DIN
- ☒ Cool Jet, can be sealed

The Power Shrink Chuck is designed for the highest cutting performance in High Speed machining. The optimized design combines high rigidity with vibration dampening, which protects the machine, spindle and tool.

- Heat resistant hot-working steel
- Hardened 54-2 HRC
- 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

The long versions (A=120, 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
- Cool Jet coolant bores that can be sealed included

### Optional:

- Cooling with Cool Flash for an extra charge (See pages 502-503)
- Safe-Lock pull out protection (See pages 496-500)

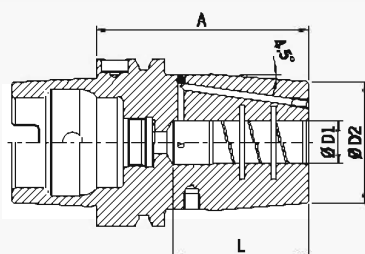
INCH	Clamping Ø D1 [inch]	1/4	5/16	3/8	1/2	5/8	3/4	1	1 1/4
	Ø D2 [inch] ultra short	0.87	0.87	1.04	1.04	1.16	1.40	1.77	1.77
	Ø D3 [inch] ultra short	—	—	—	—	—	—	2.01	2.01
	L [inch] ultra short	1.49	1.49	1.70	1.81	1.93	1.93	2.24	2.32
Gage length A [inch]	ultra short	2.76 <sup>1)</sup>	2.76 <sup>1)</sup>	2.76 <sup>1)</sup>	2.76 <sup>1)</sup>	2.95 <sup>1)</sup>	2.95 <sup>1)</sup>	3.35 <sup>1)</sup>	3.35 <sup>1)</sup>
Order No.	A63.145...	.1/4x.3	.5/16x.3	.3/8x.3	.1/2x.3	.5/8x.3	.3/4x.3	.1x.3	.1 1/4x.3
Safe-Lock Order No.	A63.145...	.1/4x.37	.5/16x.37	.3/8x.37	.1/2x.37	.5/8x.37	.3/4x.37	.1x.37	.1 1/4x.37
	Ø D2 [inch]	0.83	0.83	0.94	0.94	1.06	1.30	1.73	1.73
	Ø D3 [inch]	2.09	2.09	2.09	2.09	2.09	2.09	2.09	2.09
	L [inch]	1.42	1.42	1.65	1.85	1.97	2.05	2.28	2.28
Gage length A [inch]	ZG130	5.12	5.12	5.12	5.12	5.12	5.12	5.12	5.12
Order No.	A63.144...	.1/4x.3	.5/16x.3	.3/8x.3	.1/2x.3	.5/8x.3	.3/4x.3	.1x.3	.1 1/4x.3
Safe-Lock Order No.	A63.144...	.1/4x.37	.5/16x.37	.3/8x.37	.1/2x.37	.5/8x.37	.3/4x.37	.1x.37	.1 1/4x.37
Gage length A [inch]	oversize	6.30	6.30	6.30	6.30	6.30	6.30	6.30	6.30
Order No.	A63.142...	.1/4x.3	.5/16x.3	.3/8x.3	.1/2x.3	.5/8x.3	.3/4x.3	.1x.3	.1 1/4x.3
Safe-Lock Order No.	A63.142...	.1/4x.37	.5/16x.37	.3/8x.37	.1/2x.37	.5/8x.37	.3/4x.37	.1x.37	.1 1/4x.37

METRIC	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	45
	Ø D3 [mm] ultra short	—	—	—	—	—	—	—	—	51	51
	L [mm] ultra short	38	38	43	46	48	48	49	49	57	58
Gage length A [mm]	ultra short	70 <sup>1)</sup>	70 <sup>1)</sup>	70 <sup>1)</sup>	70 <sup>1)</sup>	75 <sup>1)</sup>	75 <sup>1)</sup>	75 <sup>1)</sup>	75 <sup>1)</sup>	85 <sup>1)</sup>	85 <sup>1)</sup>
Order No.	A63.145...	.06.3	.08.3	.10.3	.12.3	.14.3	.16.3	.18.3	.20.3	.25.3	.32.3
Safe-Lock Order No.	A63.145...	.06.37	.08.37	.10.37	.12.37	.14.37	.16.37	.18.37	.20.37	.25.37	.32.37
	Ø D2 [mm]	21	21	24	24	27	27	33	33	44	44
	Ø D3 [mm]	53	53	53	53	53	53	53	53	53	53
	L [mm]	36	36	42	47	47	50	50	52	58	58
Gage length A [mm]	ZG120	120	120	120	120	120	120	120	120	120	120
Order No.	A63.147...	.06.3	.08.3	.10.3	.12.3	.14.3	.16.3	.18.3	.20.3	.25.3	.32.3
Safe-Lock Order No.	A63.147...	.06.37	.08.37	.10.37	.12.37	.14.37	.16.37	.18.37	.20.37	.25.37	—
Gage length A [mm]	ZG130	130	130	130	130	130	130	130	130	130	130
Order No.	A63.144...	.06.3	.08.3	.10.3	.12.3	.14.3	.16.3	.18.3	.20.3	.25.3	.32.3
Safe-Lock Order No.	A63.144...	.06.37	.08.37	.10.37	.12.37	.14.37	.16.37	.18.37	.20.37	.25.37	.32.37
Gage length A [mm]	oversize	160	160	160	160	160	160	160	160	160	160
Order No.	A63.142...	.06.3	.08.3	.10.3	.12.3	.14.3	.16.3	.18.3	.20.3	.25.3	.32.3
Safe-Lock Order No.	A63.142...	.06.37	.08.37	.10.37	.12.37	.14.37	.16.37	.18.37	.20.37	.25.37	.32.37

1) Without backup screw

# HEAVY DUTY CHUCK DIN 69893-1 · HSK-A63

CERTIFICATE OF QUALITY	
✓ Chuck body fine balanced	G2.5 25,000 rpm or U<1 gmm
✓ All functional surfaces fine machined	
✓ More accurate than DIN	
✓ Cool Jet, can be sealed	



The Heavy Duty Chuck is a shrink fit chuck designed for extreme cases and Heavy Duty machining. The contour is optimized for highest rigidity and clamping force.



- Heat resistant hotworking steel
- Hardened 54-2 HRC
- Smooth clamping of the tool shank
- No deformation at the tool shank after shrink process
- TIR less than 0.00012" (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 coolant bores that can be sealed included
- Without back-up screws

Optional:

- Cooling with Cool Flash for an extra charge (See pages 502-503)
- Safe-Lock pull out protection (See pages 496-500)

INCH	Clamping Ø D1 [inch]	5/8	3/4
	Ø D2 [inch]	1.81	1.81
	L [inch]	2.01	2.08
Gage length A [inch]	ultra short	3.15	3.15
Order No.	A63.145...	.5/8z.6	.3/4z.6
Safe-Lock Order No.	A63.145...	.5/8z.67	.3/4z.67
Gage length A [inch]	short	3.35	3.35
Order No.	A63.140...	.5/8z.6	.3/4z.6
Safe-Lock Order No.	A63.140...	.5/8z.67	.3/4z.67

METRIC	Clamping Ø D1 [mm]	16	20
	Ø D2 [mm]	46	46
	L [mm]	51	53
Gage length A [mm]	ultra short	80	80
Order No.	A63.145...	.16.6	.20.6
Safe-Lock Order No	A63.145... 	.16.67	.20.67
Gage length A [mm]	short	85	85
Order No.	A63.140...	.16.6	.20.6
Safe-Lock Order No	A63.140... 	.16.67	.20.67

## Accessories

Cool Flash

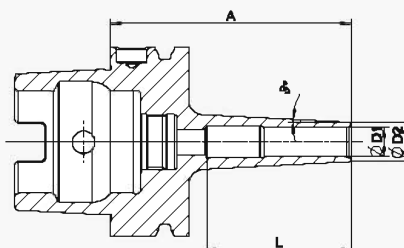


Order No. 91.100.40

See pages 502-503



# MINI SHRINK DIN 69893-1 · HSK-A63



## CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced  
G2.5 25,000 rpm  
or U<1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN

- Extremely slim design
- 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 [mm] extra slim	06	07	08	09	11	13	15	—
	Ø L [mm] extra slim	—	—	—	—	—	48	48	—
Gage length A [mm]	ZG80	—	—	—	80	80	80	80	—
Order No.	extra slim A63.173...	—	—	—	.06	.08	.10	.12	—
Gage length A [mm]	ZG120	120	120	120	120	120	120	120	—
Order No.	extra slim A63.177...	.03	.04	.05	.06	.08	.10	.12	—
	Ø D2 [mm] standard	09	10	11	12	14	16	18	24
	Ø L [mm] standard	—	—	—	—	—	68	75	75
Length A [mm]	standard	120	120	120	120	120	120	120	120
Order No.	extra slim A63.187...	.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

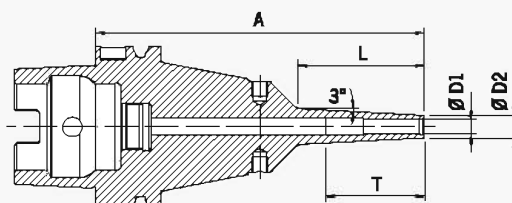
Shrinking and cooling sleeves for Mini Shrink chucks								Order No.
<b>Extra slim</b>								
Size [mm]	Ø 03	Ø 04	Ø 05	Ø 06	Ø 08	Ø 10	Ø 12	
Order No. 80.105.14...	.2.01	.2.02	.2.03	.2.04	.2.05	.2.06	.2.07	
<b>Standard</b>								
Size [mm]	Ø 03	Ø 04	Ø 05	Ø 06	Ø 08	Ø 10	Ø 12	Ø 16
Order No. 80.105.14...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



# POWER MINI SHRINK CHUCK DIN 69893-1 · HSK-A63

## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
G2.5 25,000 rpm  
or U < 1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



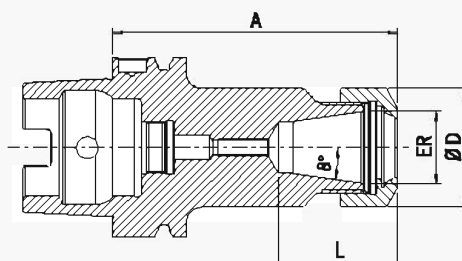
The Power Mini Shrink Chuck is perfect for 5-axis machining in the die & mold and in the medical industry. Very slim at the top like the HAIMER Mini Shrink Chucks, the Power Mini Shrink is reinforced at the base. This allows for efficient milling with an angled tool, even at long protruding lengths.

- 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
- Heat resistant hot-working steel
- Hardened 54–2 HRC

**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.




INCH	Clamping Ø D1 [inch]	1/8	3/16	1/4	5/16	3/8	1/2	5/8
	Ø D2 [inch] standard	0.35	0.43	0.47	0.55	0.63	0.71	0.94
	Ø D2 [inch] extra slim	0.24	0.32	0.35	0.43	0.51	0.59	—
	T [inch]	—	—	—	—	2.68	2.95	2.95
	L [inch] ZG130	1.97	1.97	1.97	1.97	1.97	1.97	1.97
Gage length A [inch]	ZG130	5.12	5.12	5.12	5.12	5.12	5.12	5.12
Order No.	standard	A63.184...	.1/8z.8	.3/16z.8	.1/4z.8	.5/16z.8	.3/8z.8	.1/2z.8
Order No.	extra slim	A63.174...	.1/8z.8	.3/16z.8	.1/4z.8	.5/16z.8	.3/8z.8	.1/2z.8
	L [inch] oversize/ZG200	3.15	3.15	3.15	3.15	3.15	3.15	3.15
Gage length A [inch]	oversize	160	160	160	160	160	160	160
Order No.	standard	A63.182...	.1/8z.8	.3/16z.8	.1/4z.8	.5/16z.8	.3/8z.8	.1/2z.8
Order No.	extra slim	A63.172...	.1/8z.8	.3/16z.8	.1/4z.8	.5/16z.8	.3/8z.8	.1/2z.8
Gage length A [inch]	ZG200	200	200	200	200	200	200	200
Order No.	standard	A63.186...	.1/8z.8	.3/16z.8	.1/4z.8	.5/16z.8	.3/8z.8	.1/2z.8
Order No.	extra slim	A63.176...	.1/8z.8	.3/16z.8	.1/4z.8	.5/16z.8	.3/8z.8	.1/2z.8

METRIC	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
Gage length A [mm]	ZG130	130	130	130	130	130	130	130	130
Order No.	standard	A63.184...	.03.8	.04.8	.05.8	.06.8	.08.8	.10.8	.12.8
Order No.	extra slim	A63.174...	.03.8	.04.8	.05.8	.06.8	.08.8	.10.8	.12.8
	L [mm] oversize/ZG200	80	80	80	80	80	80	80	80
Gage length A [mm]	oversize	160	160	160	160	160	160	160	160
Order No.	standard	A63.182...	.03.8	.04.8	.05.8	.06.8	.08.8	.10.8	.12.8
Order No.	extra slim	A63.172...	.03.8	.04.8	.05.8	.06.8	.08.8	.10.8	.12.8
Gage length A [mm]	ZG200	200	200	200	200	200	200	200	200
Order No.	standard	A63.186...	.03.8	.04.8	.05.8	.06.8	.08.8	.10.8	.12.8
Order No.	extra slim	A63.176...	.03.8	.04.8	.05.8	.06.8	.08.8	.10.8	.12.8



- ☒ Chuck fine balanced  
G2.5 25,000 rpm
- ☒ All functional surfaces fine machined
- ☒ More accurate than DIN

- Increasing size L possible upon request

- | INCH                 |             | ER  | 11               | 16               | 25               | 32               | 40               |
|----------------------|-------------|---|------------------|------------------|------------------|------------------|------------------|
|                      |             | Ø D [Inch]  | 0.75             | 1.1              | 1.65             | 1.97             | 2.48             |
|                      |             | Clamping range [Inch]   | 0.02-0.28        | 0.02-0.39        | 0.04-0.63        | 0.06-0.79        | 0.09-1.02        |
|                      |             | Clamping range [mm]   | 0.5-7.0          | 0.5-10.0         | 1.0-16.0         | 1.5-20.0         | 2.5-26.0         |
| L [Inch]             |             |   | 1.03             | 1.81             | 1.83             | 1.85             | 2.09             |
| Gage length A [Inch] | ultra short |  | 2.95             | 2.95             | 2.95             | 2.95             | 3.35             |
| Order No.            | A63.025...  |   | .11 <sup>D</sup> | .16 <sup>H</sup> | .25 <sup>H</sup> | .32 <sup>H</sup> | .40 <sup>H</sup> |
| L [Inch]             |             |   | <sup>a</sup>     | 1.28             | 1.61             | 1.85             | 2.09             |
| Gage length A [Inch] | short       |  | 3.94             | 3.94             | 3.94             | 3.94             | 4.72             |
| Order No.            | A63.020...  |   | .11              | .16              | .25              | .32              | .40              |
| L [Inch]             |             |   |                  | 1.28             | 1.61             | 1.85             | 2.09             |
| Gage length A [Inch] | oversize    |  |                  | 6.30             | 6.30             | 6.30             | 6.30             |
| Order No.            | A63.022...  |   | —                | .16              | .25              | .32              | .40              |

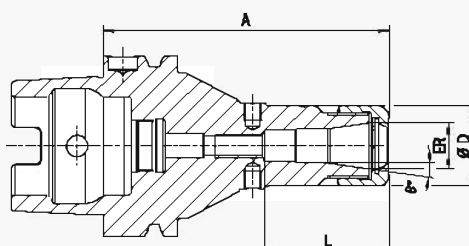
See pages 768–773

**See pages 758–767**

## POWER COLLET CHUCK DIN 69893-1 · HSK-A63

### CERTIFICATE OF QUALITY

- ☑ Chuck fine balanced  
G2.5 25,000 rpm or U<1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



The Power Collet Chuck is designed for the highest cutting performance in High Speed machining. The optimized design with improved construction combines high rigidity with vibration dampening features, giving more protection to the machine, spindle and tool. The universal Power Collet Chuck is a unique high performance chuck that can also be used with standard collets.

- High runout accuracy: < 0.00012" (3 µm) 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 increase)
- 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
- Program of Power Collets on pages 774 – 776

INCH	ER	16	25	32
	Ø D [inch]	1.1	1.65	1.97
	Clamping range [inch]	1/8–3/8	1/8–5/8	1/8–3/4
	Clamping range [mm]	2.0–10.0	2.0–16.0	2.0–20.0
	L [inch] ultra short	1.12	1.41	1.65
Gage length A [inch]	ultra short	2.95	2.95	2.95
Order No.	A63.025...	.16.3 <sup>1)</sup>	.25.3 <sup>1)</sup>	.32.3 <sup>1)</sup>
	L [inch]	1.69	2.01	2.09
Gage length A [inch]	short	3.94	3.94	3.94
Order No.	A63.020...	.16.3	.25.3	.32.3
Gage length A [inch]	oversize	6.30	6.30	6.30
Order No.	A63.022...	.16.3	.25.3	.32.3

### Accessories

#### Locknut (fine-balanced)

Size ER 16 ER 25 ER 32 See page 779

Order No. 83.914...



.16

.25

.32

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

Coolant tube

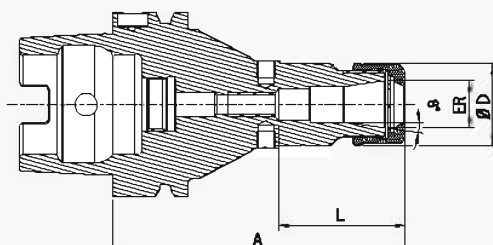
Order No. 85.700.63



See page 793

1) Without thread for back-up screw

## HIGH PRECISION COLLET CHUCK DIN 69893-1 · HSK-A63



### CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced  
G2.5 30,000 rpm or U < 1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN

The High Precision Collet Chuck is designed for the highest cutting performance 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: < 0.00012" (3 µm) at 3 x D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488 (Attention: By using standard collet, ER length A will increase)
- 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
- Program of Power Collets on pages 774 – 776

INCH	ER	16	25	32
	Ø D [inch]	1.1	1.65	1.97
	Clamping range [inch]	1/8–3/8	1/8–5/8	1/8–3/4
	Clamping range [mm]	2.0–10.0	2.0–16.0	2.0–20.0
	L [inch] ultra short	1.12	1.41	1.65
Gage length A [inch]	ultra short	2.95	2.95	2.95
Order No.	A63.025...	.16.3.HP <sup>1)</sup>	.25.3.HP <sup>1)</sup>	.32.3.HP <sup>1)</sup>
	L [inch]	1.69	2.01	2.08
Gage length A [inch]	short	3.94	3.94	3.94
Order No.	A63.020...	.16.3.HP	.25.3.HP	.32.3.HP
Gage length A [inch]	oversize	6.30	6.30	6.30
Order No.	A63.022...	.16.3.HP	.25.3.HP	.32.3.HP

### Accessories

#### High Precision Smooth Locknut (fine-balanced)

Size ER 16 ER 25 ER 32 See page 779

Order No. 83.914...

#### Roller bearing wrench

Order No. 84.650...

#### Collets ER

See pages 768–773

#### Shrink Fit Collets

See pages 759–767

#### Power Collets

See page 775

#### Power Collets with Safe-Lock

See page 776

#### Cool Jet bores for Power Collets

Order No. 91.100.27

#### Coolant tube

Order No. 85.700.63

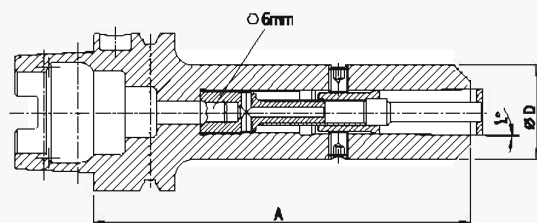
See page 793

1) With back-up screw

## HIGH-PRECISION CHUCK DIN 69893-1 · HSK-A63

### CERTIFICATE OF QUALITY

- ☑ Chuck fine balanced  
G2.5 25,000 rpm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



### Use:

For high-precision clamping of tools with cylindrical shank, also with clamping flats. Very useful for High Speed machining.

- Included in delivery: High-Precision Chuck with clamping screw and pull-out hook, without collet, without coolant tube
- Shank tolerance h6
- Optional: Cool Jet bores on HG Collets from diam. 1/4" (6 mm)
- Extensions for High-Precision Chuck available

METRIC	HG		01						02			03		
	Ø D [mm]		30						35			48		
	Clamping diameter		2	3	4	5	6	8	10	12	14	18	18	20
Length A [mm]	short		120						120			120		
Order No.	A63.120...		.01						.02			.03		
Length A [mm]	oversize		160						160			160		
Order No.	A63.122...		.01						.02			.03		

### Accessories

#### Clamping screw



#### Collets HG INCH

See page 783

##### HG 01 Ø D [inch]

Order No. 82.510... 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]

Order No. 82.520... 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]

Order No. 82.530... Ø 5/8 Ø 3/4

Order No. 82.530... .5/8Z .3/4Z

See page 783

#### Collets HG METRIC

##### HG 01 Ø D [mm]

Order No. 82.510... 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 D [mm]

Order No. 82.520... Ø 10 Ø 12 Ø 14

Order No. 82.520... .10 .12 .14

##### HG 03 Ø D [mm]

Order No. 82.530... Ø 16 Ø 18 Ø 20

Order No. 82.530... .16 .18 .20

#### Pull-out hook

##### HG

Order No. 82.570...

##### HG

Order No. 79.350...

##### HG

Order No. 79.350...

##### HG

Order No. 79.350...

##### HG

Order No. 79.350...

##### HG

Order No. 79.350...

##### HG

Order No. 79.350...

##### HG

Order No. 79.350...

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Order No. 79.350...

##### HG

Order No. 79.350...

##### HG

Order No. 79.350...

##### HG

Order No. 79.350...

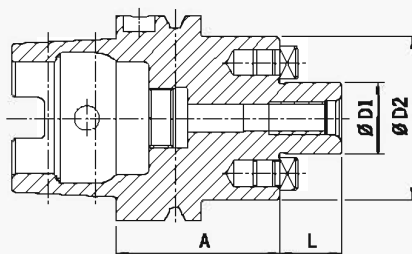
##### HG

Order No. 79.350...

##### HG



# FACE MILL ARBOR DIN 69893-1 · HSK-A63



## CERTIFICATE OF QUALITY

- Chuck fine balanced  
G2.5 25,000 rpm or U<1 gmm
- All functional surfaces fine machined
- More accurate than DIN

### Use:

For clamping face mill cutters.

Metric version: With coolant exit bores on the end face for milling cutters with central cooling

— Included in delivery: tightening bolt, without coolant tube

— Inch sizes: Coolant bores on front side for an extra charge

INCH	Clamping Ø D1 [inch]		3/4	1	1 1/4	1 1/2
	L [inch]		0.70	0.70	0.70	0.94
	Ø D2 [inch]		1.67	1.67	1.67	3.78
Gage length A [inch]	short		1.97	2.36	2.36	2.36
Order No.	A63.050...		.3/4Z	.1Z	.1 1/4Z	.1 1/2Z
Gage length A [inch]	long		3.94	3.94	3.94	3.94
Order No.	A63.051...		.3/4Z	.1Z	.1 1/4Z	.1 1/2Z
Gage length A [inch]	oversize		6.30	6.30	—	—
Order No.	A63.052...		.3/4Z	.1Z		

METRIC	Clamping Ø D1 [mm]		16	22	27	32	40
	Ø D2 [mm]		36	48	60	78	87
	L [mm]		17	19	21	24	27
Length A [mm]	short		50	50	60	60	60
Order No.	A63.050...		.16.KKB	.22.KKB	.27.KKB	.32.KKB	.40.KKB
Length A [mm]	long		—	100	100	100	100
Order No.	A63.051...			.22.KKB	.27.KKB	.32.KKB	.40.KKB
Length A [mm]	oversize		—	160	160	160	—
Order No.	A63.052...			.22.KKB	.27.KKB	.32.KKB	

### Accessories

#### Clamping Screw

Ø D1 [inch]			3/4	1	1 1/4	1 1/2
Order No.	85.300...		.3/4Z	.1Z	.11/4Z	.11/2Z

#### Wrench

Ø D1 [inch]			3/4	1	1 1/4	1 1/2
Order No.	84.400...		.3/4Z	.1Z	.11/4Z	.11/2Z

#### Balancing Index ring

Ø D1 [inch]			3/4	1	—	—
Order No.	79.350...		.1.71Z	.55		

#### Coolant tube

Ø D1 [inch]			3/4	1	1 1/4	1 1/2
Order No.	85.700...		.63	.63	.63	.63

#### Coolant bores

Order No.	91.100.03	
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### Accessories

#### Tightening bolt

Size D1			16	22	27	32	40
Order No.	85.300...		.16	.22	.27	.32	.40

#### Wrench

Size D1			16	22	27	32	40
Order No.	84.400...		.16	.22	.27	.32	.40

#### Balancing Index rings

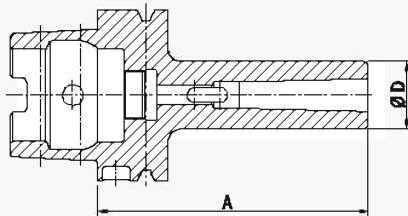
Size D1			16	22	27	32	40
Order No.	79.350...		.36	.48	.60	.78	.87



ADAPTER FOR MORSE TAPER WITH TANG  
DIN 69893-1 · HSK-A63

CERTIFICATE OF QUALITY

- ✓ Chuck balanced  
G6.3 8,000 rpm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



Use:

For holding tools with morse taper and tang  
according to DIN 228-1 form AF.

– Fine-balancing for an extra charge

METRIC	MK		01	02	03	04
	Ø D [mm]		25	32	40	48
Gage Length A [mm]	short		100	120	140	160
Order No.	A63.080...		.01	.02	.03	.04

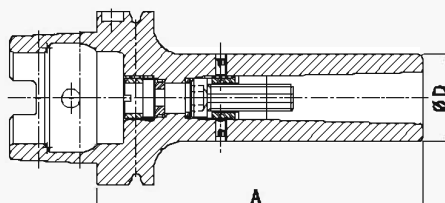
Accessories

Balancing index rings

MK			01	02	03	04
Order No.	79.350...		.25	.32	.40	.48
Coolant tube						
Order No.	85.700.63					

See page 793

## ADAPTER FOR MORSE TAPER WITH THREAD DIN 69893-1 · HSK-A63



### CERTIFICATE OF QUALITY

- ☒ Chuck balanced  
G6.3 8,000 rpm
- ☒ All functional surfaces fine machined
- ☒ More accurate than DIN

#### Use:

For holding tools with morse taper with thread  
according to DIN 228-1 form A.

- Fine-balancing for an extra charge
- Delivery with tightening bolt without coolant tube

METRIC	MK	02	03	04
	Ø D [mm]	32	40	48
Gage Length A [mm]	short	120	140	160
Order No.	A63.130...	.02	.03	.04

#### Accessories

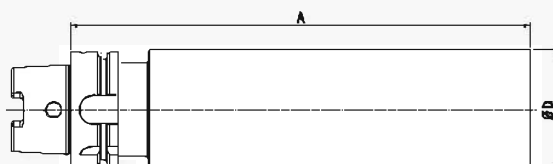
##### Balancing index rings

MK		02	03	04
Order No.	79.350...	.32	.40	.48
Coolant tube				
Order No.	85.700.63			

## BLANK ADAPTER DIN 69893-1 · HSK-A63

### CERTIFICATE OF QUALITY

- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



### Use:

For manufacturing special tools in your own factory.

### Design:

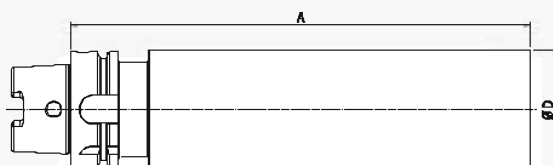
HSK is hardened and ground, the cylindrical part is soft.

METRIC	Ø D [mm]		64
Gage Length A [mm]	ZG250		250
Order No.	A63.090...		.64

## BLANK ADAPTER – HARDENED DIN 69893-1 · HSK-A63

### CERTIFICATE OF QUALITY

- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



### Use:

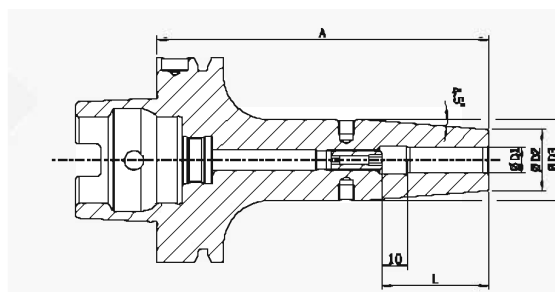
For manufacturing special tools in your own factory.

### Version:

- HSK hardened and ground
- Cylindrical part hardened to 52+2 HRC

METRIC	Ø D [mm]		65
Gage Length A [mm]	ZG100		100
Order No.	RA63.096.0650...		.0100
Gage Length A [mm]	ZG250		250
Order No.	RA63.096.0650...		.0250

# STANDARD SHRINK FIT CHUCK SIMILAR DIN 69893-1 · HSK-A63/80 (TAPER A63/FLANGE 80MM)



## CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced  
G2.5 33,000 rpm or U < 1 gmm
- ☒ All functional surfaces fine machined
- ☒ More accurate than DIN

### Use:

Suitable for all shrinking units.

### DIN 69893-1

- With threaded holes in order to balance with balancing screws
- Included in delivery: Shrink fit chuck with back-up screw, without coolant tube
- Heat resistant hot-working steel
- Hardened 54–2 HRC
- For HSS and solid carbide tools
- Shank tolerance h6
- Incl. pocket for data chip
- Cooling systems Cool Jet and Cool Flash available on request

### Standard version, similar to DIN 69892-8

INCH	Clamping Ø D1 [inch]	1/4	5/16	3/8	1/2	5/8
	Ø D2 [inch]	0.83	0.83	0.94	0.94	1.06
	Ø D3 [inch]	1.06	1.06	1.26	1.26	1.34
	L [inch]	1.42	1.42	1.65	1.85	1.97
Length A [inch]	ZG130	5	5	5	5	5
Order No.	A63/80.144...	.1/4xL	.5/16xL	.3/8xL	.1/2xL	5/8xL

METRIC	Clamping Ø D1 [mm]	06	08	10	12	14	16	18
	Ø D2 [mm]	21	21	24	24	27	27	33
	Ø D3 [mm]	27	27	32	32	34	34	42
	L [mm]	36	36	42	47	47	50	50
Length A [mm]	ZG130	130	130	130	130	130	130	130
Order No.	A63/80.144...	.06	.08	.10	.12	.14	.16	.18

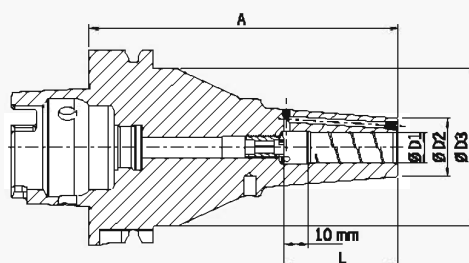
### Accessories

Shrink fit extensions			See pages 750–753
Balancing screws		Order No. 80.203.00	See page 784
Cool Jet bores		Order No. 91.100.24	See page 501
Cool Flash Upgrade Incl. Cool Jet		Order No. 91.100.41	See pages 502–503
Balluff-Chip BIS-C-122-04/L		Order No. 909009-0002	
Data-Lock mechanical data carrier locking system		Order No. 91.100.06	See page 504
Coolant tube		Order No. 85.700.63	See page 793
Reduction sleeves			See page 794
Back-up screws			See pages 796–799
Cooling grooves on request			

# POWER SHRINK CHUCK SIMILAR DIN 69893-1 · HSK-A63/80 (TAPER A63/FLANGE 80MM) INCH

## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
G2.5 33,000 rpm or U<1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



The Power Shrink Chuck is designed for the highest cutting performance in High Speed machining. The optimized design combines high rigidity with vibration dampening, which protects the machine, spindle and tool.

- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle times, higher machining accuracy
- Heat resistant hot-working steel
- Hardened 54–2 HRC

## Delivery Includes:

- Cool Jet bores (sealed)
- With threaded holes in order to balance with balancing screws
- Incl. pocket for data chip
- With thread for coolant tube

INCH	Clamping Ø D1 [inch]	1/4	5/16	3/8	1/2	5/8	3/4	1
	Ø D2 [inch]	0.87	0.87	1.04	1.04	1.16	1.40	1.81
	L [inch] extra ultra short	—	—	—	—	—	1.71	1.85
Length A [inch] Order No.	extra ultra short A63/80.145...						2.75 .3/4z.5i	2.75 .1z.5.i
	Ø D2 [inch]	0.87	0.87	1.04	1.04	1.16	1.40	1.77
	L [inch] ultra short	1.50	1.50	1.69	1.81	1.93	1.93	2.24
Length A [inch] Order No.	ultra short A63/80.145...	3 .1/4z.3i	3 .5/16z.3i	3 .3/8z.3i	3 .1/2z.3i	3 .5/8z.3i	3 .3/4z.3i	3 .1z.3i
Length A [inch] Order No.	short A63/80.140...							3.5 .1z.3.i

## Length A = ZG130

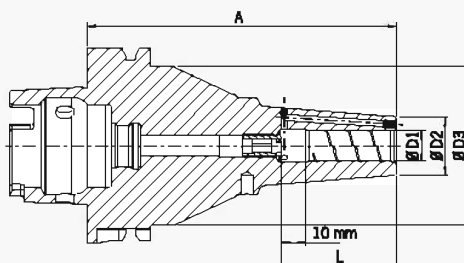
INCH	Clamping Ø D1 [inch]	1/4	5/16	3/8	1/2	5/8
	Ø D2 [inch]	0.83	0.83	0.94	0.94	1.06
	Ø D2 [inch]	2.56	2.56	2.56	2.56	2.56
	L [inch]	1.42	1.42	1.65	1.85	1.97
Length A [inch] Order No.	ZG130 A63/80.144...	5 <sup>1)</sup> .1/4z.3i	5 <sup>1)</sup> .5/16z.3i	5 <sup>1)</sup> .3/8z.3i	5 <sup>1)</sup> .1/2z.3i	5 <sup>1)</sup> .5/8z.3i

## Accessories

Shrink fit extensions			See page 750
Balancing screws		Order No. 80.203.00	See page 784
Cool Flash		Order No. 91.100.40	See pages 502–503
Balluff-Chip BIS-C-122-04/L		Order No. 909009-0002	
Data-Lock mechanical data carrier locking system		Order No. 91.100.06	See page 504
Coolant tube		Order No. 85.700.63	See page 793
Cooling adapters for extra ultra short holders			
Size		Ø 20	Ø 25
Order No.	80.105...	.16.0045	.18.0011
Cooling grooves on request			

1) With back-up screw

# POWER SHRINK CHUCK WITH SAFE-LOCK® SIMILAR DIN 69893-1 · HSK-A63/80 (TAPER A63/FLANGE 80MM) INCH



## CERTIFICATE OF QUALITY

- Chuck body fine balanced  
G2.5 33,000 rpm or U<1 gmm
- All functional surfaces fine machined
- More accurate than DIN

The Power Shrink Chuck is designed for the highest cutting performance in High Speed machining. The optimized design combines high rigidity with vibration dampening, which protects the machine, spindle and tool.

- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle times, higher machining accuracy
- Heat resistant hot-working steel
- Hardened 54–2 HRC

## Delivery Includes:

- Safe-Lock pull-out protection
- Cool Jet bores (sealed)
- With threaded holes in order to balance with balancing screws
- Incl. pocket for data chip
- With thread for coolant tube

INCH	Clamping Ø D1 [inch]	1/2	5/8	3/4	1
	Ø D2 [inch] extra ultra short	—	—	1.40	1.77
	L [inch] extra ultra short	—	—	1.93	2.24
Length A [inch]	extra ultra short	—	—	2.75	2.75
Order No.	A63/80.145...			.3/4x.571	.1x.571
	Ø D2 [inch]	1.04	1.16	1.40	1.77
	L [inch]	1.81	1.93	1.93	2.24
Length A [inch]	ultra short	3	3	3	3
Order No.	A63/80.145...	.1/2x.37.1	.5/8x.37.1	.3/4x.37.1	.1x.37.1
Length A [inch]	short	—	—	—	3.5
Order No.	A63/80.140...				.1x.37.1

## Length A = ZG130

INCH	Clamping Ø D1 [inch]	1/2	5/8
	Ø D2 [inch]	0.94	1.06
	Ø D3 [inch]	2.56	2.56
	L [inch]	1.85	1.97
Length A [inch]	ZG130	5 <sup>11</sup>	5 <sup>11</sup>
Order No.	A63/80.144...	.1/2x.37.1	.5/8x.37.1

## Accessories

Shrink fit extensions		See page 750
Balancing screws		Order No. 80.203.00 See page 784
Cool Flash		Order No. 91.100.40 See pages 502–503
Balluff-Chip BIS-C-122-04/L		Order No. 909009-0002
Data-Lock mechanical data carrier locking system		Order No. 91.100.06 See page 504
Coolant tube		Order No. 85.700.63 See page 793
Cooling adapters for extra ultra short holders		
Size		Ø 20 Ø 25
Order No.	80.105...	.16.0045 .18.0011
Cooling grooves on request		

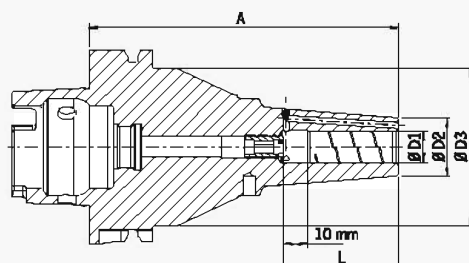
1) With back-up screw



# POWER SHRINK CHUCK SIMILAR DIN 69893-1 · HSK-A63/80 (TAPER A63/FLANGE 80MM) METRIC

## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
G2.5 33,000 rpm or U<1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



The Power Shrink Chuck is designed for the highest cutting performance in High Speed machining. The optimized design combines high rigidity with vibration dampening, which protects the machine, spindle and tool.

- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle times, higher machining accuracy
- Heat resistant hot-working steel
- Hardened 54–2 HRC

## Delivery Includes:

- Cool Jet bores (sealed)
- With threaded holes in order to balance with balancing screws
- Incl. pocket for data chip
- With thread for coolant tube

METRIC	Clamping Ø D1 [mm]	06	08	10	12	16	20	25	32
	Ø D2 [mm] extra ultra short	22	22	27	26.5	29.5	35.5	46	—
	L [mm] extra ultra short	—	—	41	—	—	43.5	47	—
Length A [mm]	extra ultra short			65			70 <sup>a</sup>	70 <sup>a</sup>	
Order No.	A63/80.145...			.10.5			.20.5	.25.5	
	Ø D2 [mm]	22	22	26.5	26.5	29.5	35.5	45	45
	L [mm]	38	38	43	46	49	49	57	59
Length A [mm]	ultra short	70	70	70	70	75	75	80 <sup>a</sup>	—
Order No.	A63/80.145...	.06.3	.08.3	.10.3	.12.3	.16.3	.20.3	.25.3	
Length A [mm]	short							90	90
Order No.	A63/80.140...							.25.3	.32.3

## Length A = ZG130

METRIC	Clamping Ø D1 [mm]	06	08	10	12	16
	Ø D2 [mm]	21	21	24	24	27
	Ø D3 [mm]	65	65	65	65	65
	L [mm]	36	36	42	47	50
Length A [mm]	ZG130	130	130	130	130	130
Order No.	A63/80.144...	.06.3 <sup>1)</sup>	.08.3 <sup>1)</sup>	.10.3 <sup>2)</sup>	.12.3 <sup>2)</sup>	.16.3 <sup>1)</sup>

## Accessories

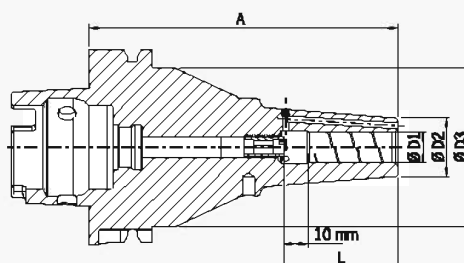
Shrink fit extensions		See pages 751–753
Balancing screws		Order No. 80.203.00 See page 784
Cool Flash		Order No. 91.100.40 See pages 502–503
Balluff-Chip BIS-C-122-04/L		Order No. 909009-0002
Data-Lock mechanical data carrier locking system		Order No. 91.100.06 See page 504
Coolant tube		Order No. 85.700.63 See page 793
Cooling adapters for extra ultra short holders		
Size		Ø 20 Ø 25
Order No.	80.105...	.16.0045 .16.0011
Cooling grooves on request		

1) With back-up screw

2) Cooling adapter for Ø 20 mm

3) Cooling adapter for Ø 25 mm

# POWER SHRINK CHUCK WITH SAFE-LOCK® SIMILAR DIN 69893-1 · HSK-A63/80 (TAPER A63/FLANGE 80MM) METRIC



## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
G2.5 33,000 rpm or U<1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN

The Power Shrink Chuck is designed for the highest cutting performance in High Speed machining. The optimized design combines high rigidity with vibration dampening, which protects the machine, spindle and tool.

- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle times, higher machining accuracy
- Heat resistant hot-working steel
- Hardened 54–2 HRC

## Delivery includes:


- Safe-Lock pull-out protection
- Cool Jet bores (sealed)
- With threaded holes in order to balance with balancing screws
- Incl. pocket for data chip
- With thread for coolant tube

METRIC	Clamping Ø D1 [mm]	08	10	12	16	20	25
	Ø D2 [mm] extra ultra short	—	—	—	—	35.5	46
	L [mm] extra ultra short	—	—	—	—	43.5	47
Length A [mm]	extra ultra short					70 <sup>a</sup>	70 <sup>a</sup>
Order No.	A63/80.145...					.20.57	.25.57
	Ø D2 [mm]	22	26.5	26.5	29.5	35.5	45
	L [mm]	38	43	46	49	49	57
Length A [mm]	ultra short	70	70	70	75	75	80 <sup>a</sup>
Order No.	A63/80.145...	.08.37	.10.37	.12.37	.16.37	.20.37	.25.37
Length A [mm]	short						90
Order No.	A63/80.140...						.25.37

## Length A = ZG130

METRIC	Clamping Ø D1 [mm]	12	16
	Ø D2 [mm]	24	27
	Ø D3 [mm]	65	65
	L [mm]	47	50
Length A [mm]	ZG130	130 <sup>b</sup>	130 <sup>b</sup>
Order No.	A63/80.144...	.12.37	.16.37

## Accessories

Shrink fit extensions  See pages 751–753

Balancing screws  See page 784

Cool Flash  Order No. 91.100.40

Balluff-Chip BIS-C-122-04/L  Order No. 909009-0002

Data-Lock mechanical data carrier locking system Order No. 91.100.06 See page 504

Coolant tube  Order No. 85.700.63 See page 793

## Cooling adapters for extra ultra short holders

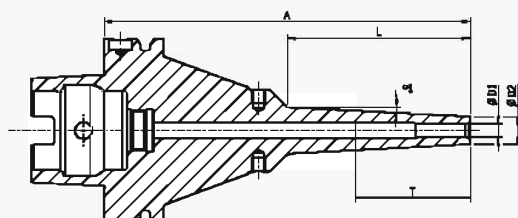
Size  <sup>a</sup>Ø 20 <sup>a</sup>Ø 25  
Order No. 80.105... .16.0045 .18.0011

- 1) With back-up screw
- 2) Cooling adapter for Ø 20 mm
- 3) Cooling adapter for Ø 25 mm

# POWER MINI SHRINK SIMILAR DIN 69893-1 · HSK-A63/80 (TAPER A63/FLANGE 80MM)

## CERTIFICATE OF QUALITY

- Chuck body fine balanced  
G2.5 33,000 rpm or U < 1 gmm
- All functional surfaces fine machined
- More accurate than DIN



Power Mini Shrink Chuck is perfect for 5-axis machining of parts that are difficult to access. Very slim at the top like the HAIMER Mini Shrink Chucks, the Power Mini Shrink is reinforced at the base. This allows for efficient milling with an angled tool, even at long protruding lengths.

- 3 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
- Incl. pocket for data chip
- Heat resistant hot-working steel
- Hardened 54–2 HRC

**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.

INCH	Clamping Ø D1 [inch]	1/8	1/4	5/16	3/8	1/2
	Ø D2 [inch]	0.35	0.47	0.55	0.63	0.71
	T [inch]	—	—	—	2.68	2.95
	L [inch]	3.15	3.15	3.15	3.15	3.15
Length A [inch]	oversize	6.5	6.5	6.5	6.5	6.5
Order No.	A63/80.182...	.1/8z.8.i	.1/4z.8.i	.5/16z.8.i	.3/8z.8.i	.1/2z.8.i

METRIC	Clamping Ø D1 [mm]	03	04	05	06	08	10	12
	Ø D2 [mm]	09	10	11	12	14	16	18
	T [mm]	—	—	—	—	—	68	75
	L [mm]	80	80	80	80	80	80	80
Length A [mm]	oversize	160	160	160	160	160	160	160
Order No.	A63/80.182...	.03.8	.04.8	.05.8	.06.8	.08.8	.10.8	.12.8

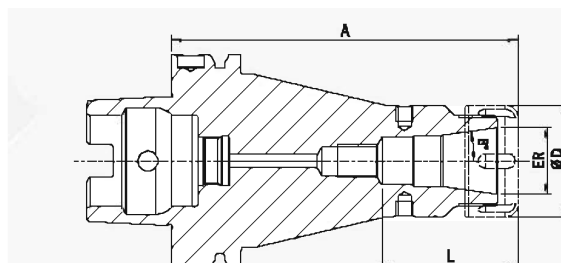
## Mini Shrink shrink and cooling sleeve

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



Fitting sleeves for Mini Shrink chucks						Order No.
Size [mm]	Ø 03	Ø 06	Ø 08	Ø 10	Ø 12	
Size [inch]	Ø 1/8	Ø 1/4	Ø 5/16	Ø 3/8	Ø 1/2	
Order No.	80.105.14.2...	.04	.09	.10	.11	.12
Base						80.105.14.2.99
Set with base (12 pcs., diameter 3 – 12 mm)						80.105.14.2.00

# POWER COLLET CHUCK SIMILAR DIN 69893-1 · HSK-A63/80 (TAPER A63/FLANGE 80MM)



## CERTIFICATE OF QUALITY

- Chuck body fine balanced  
G2.5 33,000 rpm or U<1 gmm
- All functional surfaces fine machined
- More accurate than DIN

The Power Collet Chuck is designed for the highest cutting performance in High Speed machining. The optimized design with improved construction combines high rigidity with vibration dampening features, giving more protection to the machine, spindle and tool. The universal Power Collet Chuck is a unique high performance chuck that can also be used with standard collets.

- High runout accuracy: < 0.00012" (3 µm) 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 increase)
- 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, high clamping force
- Equally suited to High Speed and dynamic machining
- With threaded holes in order to balance with balancing screws
- Incl. pocket for data chip
- Optional: Cool Jet bores on Power Collets from ER 25, Ø 6 mm
- Program of Power Collets on pages 774 – 777

INCH	ER		16	25	32
	Ø D [inch]		1.10	1.63	1.97
	Clamping range [inch]		1/8–3/8	1/8–5/8	1/8–3/4
	Clamping range [mm]		2.0–10.0	2.0–16.0	2.0–20.0
	L [inch]		1.69	1.97	1.87
Length A [inch]	ultra short		2.95	2.95	2.95
Order No.	A63/80.023...		.16.3	.25.3	.32.3
Length A [inch]	ZG130		5.12	5.12	5.12
Order No.	A63/80.024...		.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

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 759–767

### Coolant tube

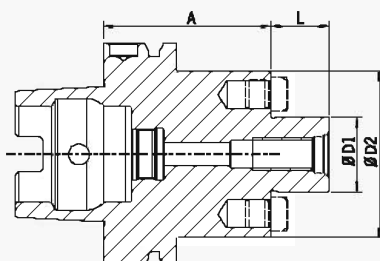
Order No. 85.700.63

See page 793

## FACE MILL ARBOR SIMILAR DIN 69893-1 · HSK-A63/80 (TAPER A63/FLANGE 80MM)

### CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
G2.5 33,000 rpm or U < 1 µm/m
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



### 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 tapped holes).

### DIN 69882-3

- Included in delivery: tightening bolt, without coolant tube
- INCH Version: With coolant exit bores on the end face for milling cutters with central cooling
- METRIC Version: Coolant exit bores optional

INCH	Clamping Ø D1 [inch]	3/4	1
	Ø D2 [inch]	1.71	2.17
	L [inch]	0.67	0.67
Length A [inch]	short	1.97	2.36
Order No.	A63/80.050...	.3/4z.1	.1z.1

METRIC	Clamping Ø D1 [mm]	22	27
	Ø D2 [mm]	48	60
	L [mm]	19	21
Length A [mm]	short	50	60
Order No.	A63/80.050...	.22	.27

### Accessories


#### Tightening bolt

Size D1			22	27
Order No.	85.300...		.22	.27

#### Wrench

Size D1			22	27
Order No.	84.400...		.22	.27

#### Balancing index rings

Size D1			22	27
Order No.	79.350...		.50	.60

### Accessories

#### Cool Jet bores

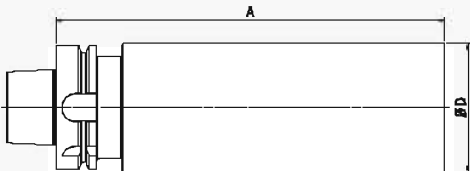


Order No. 91.100.24

See page 501



BLANK ADAPTER – HARDENED  
SIMILAR DIN 69893-1 · HSK-A63/80 (TAPER A63/FLANGE 80MM)



CERTIFICATE OF QUALITY

☒ All functional surfaces fine machined  
☒ More accurate than DIN

**Use:**  
For manufacturing special tools in your own factory.

**Version:**  
 – HSK hardened and ground  
 – Cylindrical part hardened to 52+2 HRC

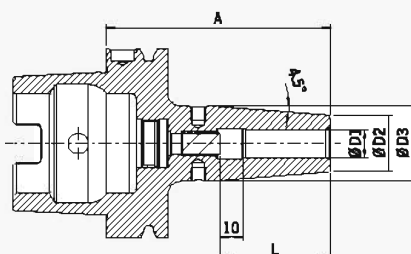
METRIC	Ø D [mm]	82
Gage Length A [mm]	ZG250	250
Order No.	RA63/80.096.0820... 	.0250



## SHRINK FIT CHUCK DIN 69893-1 · HSK-A80

### CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced  
G2.5 25,000 rpm or U<1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



### Use:

Shrink fit chuck suitable for use with all available shrink fit units.

- 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 backup screw, without coolant tube

### Optional:

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

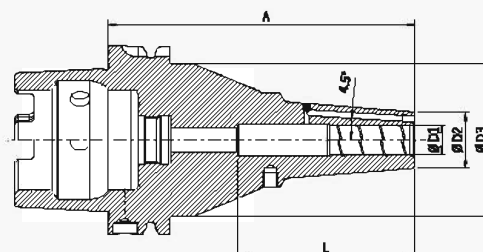
### Standard version, similar to DIN 69882-8

METRIC	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	85	85	90	95	95	100	100	105	115	120
Order No.	A80.140...	.06	.08	.10	.12	.14	.16	.18	.20	.25	.32

### Accessories

Shrink fit extensions		See pages 751-753
Balancing screws		See page 784
Coolant tube	 Order No. 85.700.80	See page 793
Reduction sleeves		See page 794
Back-up screws		See pages 796-799
Cool Jet bores	 Order No. 91.100.24	See page 501
Cool Flash	 Order No. 91.100.40	See pages 502-503

# POWER SHRINK CHUCK DIN 69893-1 · HSK-A80



## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
G2.5 25,000 rpm or U<1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN

The Power Shrink Chuck is designed for the highest cutting performance in High Speed machining. The optimized design combines high rigidity with vibration dampening, which protects the machine, spindle and tool.


- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle times
- Quieter running, therefore better surface quality and protection of tools, spindles and machines
- Higher machining accuracy
- With threaded holes in order to balance with balancing screws
- Cool Jet coolant bores that can be sealed included




The long versions with slim tips are especially versatile to use.

- High rigidity
- Slim at the tip
- Dampen vibrations
- Higher clamping forces
- Equally suited to High Speed and Heavy Duty machining
- Universal usage, saves space in tool magazine

Optional:

- Cooling with Cool Flash from for an extra charge (See pages 502–503)
- Safe-Lock pull out protection

INCH	Clamping Ø D1 [inch]		½	¾
	Ø D2 [inch]		0.944	1.299
	Ø D3 [inch] short		2.598	2.598
	Ø D3 [inch] ZG130/oversize		2.559	2.559
	L [inch] short		2.795	2.716
	L [inch] ZG130		2.952	3.779
	L [inch] oversize		2.952	3.976
Gage length A [inch]	short		3.94	3.94
Order No.	A80.149...		.1/2x.3.2140	.3/4x.3.2140
Gage length A [inch]	ZG130		5.12	5.12
Order No.	A80.149...		.1/2x.3.2144	.3/4x.3.2144
Gage length A [inch]	oversize		6.3	6.3
Order No.	A80.149...		.1/2x.3.2142	.3/4x.3.2142

METRIC	Clamping Ø D1 [mm]		08	10	12	16	20
	Ø D2 [mm]		21	24	24	27	33
	Ø D3 [mm] short		66	66	66	66	66
	Ø D3 [mm] ZG130/oversize		65	65	65	65	65
	L [mm] short		—	68	71	70	69
	L [mm] ZG130		—	70	75	75	96
	L [mm] oversize		—	70	75	75	101
Gage length A [mm]	short		100	100	100	100	100
Order No.	A80.149...		.08.3.2140	.10.3.2140	.12.3.2140	.16.3.2140	.20.3.2140
Gage length A [mm]	ZG130		130	130	130	130	130
Order No.	A80.149...		.08.3.2144	.10.3.2144	.12.3.2144	.16.3.2144	.20.3.2144
Gage length A [mm]	oversize		160	160	160	160	160
Order No.	A80.149...		.08.3.2142	.10.3.2142	.12.3.2142	.16.3.2142	.20.3.2142

## Accessories Cool Flash



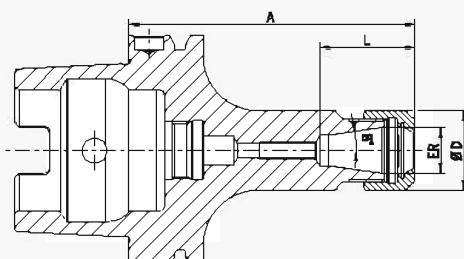
Order No. 91.100.40

See pages 502–503

## ER COLLET CHUCK DIN 69893-1 · HSK-A80

### CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
G2.5 25,000 rpm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



### Use:

For clamping tools with cylindrical shank in ER collets according to ISO 15488.

- Included in delivery: locknut (balanced, with slide coating for higher clamping forces); without coolant tube
- Locknut type HS (High Speed, fine balanced, with slide coating for higher clamping forces) for an extra charge
- Increasing size L possible upon request

INCH	Ø ER	16	25	32
	Ø D [inch]	1.1	1.65	1.97
	Clamping range [inch]	0.02–0.39	0.04–0.63	0.59–0.79
	Clamping range [mm]	0.5–10.0	1.0–16.0	1.5–20.0
	L [inch]	1.26	1.62	1.85
Gage length A [inch]	short	3.94	3.94	3.94
Order No.	A80.020...	.16	.25	.32



### Accessories

Collets ER  See pages 768–773

Shrink Fit Collets  See pages 759–767

### Locknut (pre-balanced)

Size  ER 16 ER 25 ER 32


Order No. 83.912... .16 .25 .32

### Chuck nut HS (fine-balanced)

Size  ER 16 ER 25 ER 32

Order No. 83.912... .16.HS .25.HS .32.HS

### Fork wrench

Size  ER 16 — —


Order No. 84.200... .16

### Clamping wrench

Size  — ER 25 ER 32

Order No. 84.200... .25 .32

### Balancing index rings

Size  long/oversize ER 16 ER 25 ER 32

Order No. 79.350... .28 .42 .48


### Adjusting screw

Size  ER 16 ER 25 ER 32

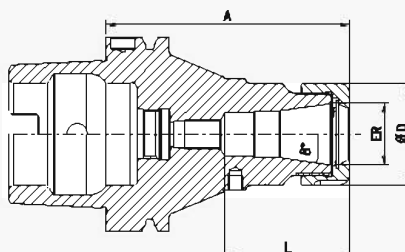
Order No. 85.800... .34 .34 .35

### Coolant tube

Order No. 85.700.80 

Shrink fit extensions  See pages 751–753

# POWER COLLET CHUCK DIN 69893-1 · HSK-A80






## CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced  
G2.5 25,000 rpm or U<1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN

The Power Collet Chuck is designed for the highest cutting performance in High Speed machining. The optimized design with improved construction combines high rigidity with vibration dampening features, giving more protection to the machine, spindle and tool. The universal Power Collet Chuck is a unique high performance chuck that can also be used with standard collets.


- High runout accuracy: < 0.00012" (3 µm) 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 increase)
- 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
- Program of Power Collets on pages 774 – 776

INCH	ER		25	32
	Ø D1 [inch]		1.653	1.968
	Clamping range [inch]		1/8–5/8	1/8–3/4
	Clamping range [mm]		2.0–16.0	2.0–20.0
	L [inch] short		2.755	2.716
	L [inch] ZG130		3.248	3.543
	L [inch] oversize		3.248	3.858
Gage length A [inch]	short		3.94	3.94
Order No.	A90.029...		.25.3.2021	.32.3.2021
Gage length A [inch]	ZG130		5.12	5.12
Order No.	A90.029...		.25.3.2024	.32.3.2024
Gage length A [inch]	oversize		6.3	6.3
Order No.	A90.029...		.25.3.2022	.32.3.2022

## Accessories

### Locknut (fine-balanced)

Size  ER 25 ER 32 See page 779

Order No. 83.914...

Power Collet clamping wrench



ER 25

.25

ER 32

.32

See page 781

### Torque Master torque wrench

Order No. 84.600.00



See page 780

### Power Collets



See page 774

### 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 763–766

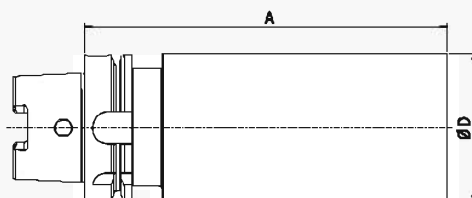
### Coolant tube

Order No. 85.700.80



See page 793

## BLANK ADAPTER – HARDENED DIN 69893-1 · HSK-A80



### Use:

For manufacturing special tools in your own factory.

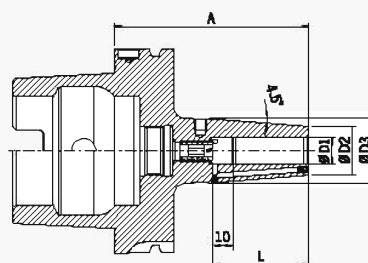
### Version:

- HSK hardened and ground
- Cylindrical part hardened to 52+2 HRC

METRIC	Ø D [mm]		82
Gage Length A [mm] Order No.	ZG100 RA80.096.0820...		100 .0100
Gage Length A [mm] Order No.	ZG200 RA80.096.0820...		200 .0200
Gage Length A [mm] Order No.	ZG300 RA80.096.0820...		300 .0300



# SHRINK FIT CHUCK DIN 69893-1 · HSK-A100



## CERTIFICATE OF QUALITY

- Chuck body fine balanced G2.5 25,000 rpm
- All functional surfaces fine machined
- More accurate than DIN

### Use:

Shrink fit chuck suitable for use with all available shrink fit units.

- Heat resistant hotworking steel
- Hardened 54-2 HRC
- For HSS and solid carbide tools
- Shank tolerance h6

- With threaded holes in order to balance with balancing screws
- Inch sizes with Cool Jet, metric sizes with Cool Jet optional
- Included in delivery: Back-up screw, without coolant tube

### Optional:


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


INCH	Clamping Ø D1 [Inch]	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	1 1/4
	Ø D2 [Inch]	0.83	0.83	0.94	0.94	0.94	1.06	1.30	1.73	1.73
	Ø D3 [Inch]	1.06	1.06	1.26	1.26	1.26	1.34	1.65	2.09	2.09
	L [Inch]	1.42	1.42	1.65	1.65	1.85	1.97	2.05	2.28	2.28
Gage length A [Inch]	short	3.35	3.35	3.54	3.54	3.74	3.94	4.13	4.53	4.72
Order No.	A10.140...	.1/4Z.4	.5/16Z.4	.3/8Z.4	.7/16Z.4	.1/2Z.4	.5/8Z.4	.3/4Z.4	.1Z.4	.1 1/4Z.4
Gage length A [Inch]	ZG130	5.12	5.12	5.12	5.12	5.12	5.12	5.12	5.12	5.12
Order No.	A10.144...	.1/4Z.4	.5/16Z.4	.3/8Z.4	.7/16Z.4	.1/2Z.4	.5/8Z.4	.3/4Z.4	.1Z.4	.1 1/4Z.4
Gage length A [Inch]	oversize	6.30	6.30	6.30	6.30	6.30	6.30	6.30	6.30	6.30
Order No.	A10.142...	.1/4Z.4	.5/16Z.4	.3/8Z.4	.7/16Z.4	.1/2Z.4	.5/8Z.4	.3/4Z.4	.1Z.4	.1 1/4Z.4
Gage length A [Inch]	ZG200	7.87	7.87	7.87	7.87	7.87	7.87	7.87	7.87	7.87
Order No.	A10.146...	.1/4Z.4	—	.3/8Z.4	—	.1/2Z.4	.5/8Z.4	.3/4Z.4	.1Z.4	.1 1/4Z.4

### Standard version, similar to DIN 69892-9


METRIC	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
Gage length A [mm]	short	85	85	90	95	95	100	100	105	115	120
Order No.	A10.140...	.06	.08	.10	.12	.14	.16	.18	.20	.25	.32
Gage length A [mm]	ZG120	120	120	120	120	120	120	120	120	120	—
Order No.	A10.147...	.06	.08	.10	.12	.14	.16	.18	.20	.25	—
Gage length A [mm]	ZG130	130	130	130	130	130	130	130	130	130	130
Order No.	A10.144...	.06	.08	.10	.12	.14	.16	.18	.20	.25	.32
Gage length A [mm]	oversize	160	160	160	160	160	160	160	160	160	160
Order No.	A10.142...	.06	.08	.10	.12	.14	.16	.18	.20	.25	.32
Gage length A [mm]	ZG200	200	200	200	200	200	200	200	200	200	200
Order No.	A10.146...	.06	.08	.10	.12	.14	.16	.18	.20	.25	.32

### Accessories


Shrink fit extensions  See pages 750–753

Balancing screws  See page 784

Coolant tube  Order No. 85.700.10 See page 793

Reduction sleeves  See page 794

Back-up screws  See pages 796–799

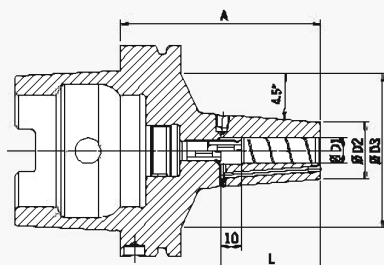
Cool Flash  Order No. 91.100.40 See pages 502–503  
Cool Flash Upgrade Incl. Cool Jet Order No. 91.100.41 See pages 502–503



# POWER SHRINK CHUCK DIN 69893-1 · HSK-A100

## CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced  
G2.5 25,000 rpm
- ☑ All functional surfaces machined
- ☑ More accurate than DIN
- ☑ Cool Jet, can be sealed



The Power Shrink Chuck is designed for the highest cutting performance in High Speed machining. The optimized design combines high rigidity with vibration dampening, which protects the machine, spindle and tool.

- Heat resistant hot-working steel
- Hardened 54-2 HRC
- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle 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 coolant bores that can be sealed included

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

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

Optional:

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

INCH	Clamping Ø D1 [inch]	1/4	5/16	3/8	1/2	5/8	3/4	1
	Ø D2 [inch]	0.83	0.83	1.06	1.06	1.3	1.73	1.73
	Ø D3 [inch] ultra short	2.36	2.36	2.09	2.87	3.07	3.35	3.35
	Ø D3 [inch]	3.27	3.27	3.27	3.27	3.27	3.27	3.27
	L [inch]	1.42	1.42	1.85	1.85	1.97	2.05	2.28
Gage length A [inch]	short	3.35	3.35	3.54	3.74	3.94	4.13	4.53
Standard Order No.	A10.140...	.1/4z.3	.5/16z.3	.3/8z.3	.1/2z.3	.5/8z.3	.3/4z.3	.1z.3
Safe-Lock Order No.	A10.140...	.1/4z.37	.5/16z.37	.3/8z.37	.1/2z.37	.5/8z.37	.3/4z.37	.1z.37
Gage length A [inch]	oversize	6.30	6.30	6.30	6.30	6.30	6.30	6.30
Standard Order No.	A10.142...	.1/4z.3	.5/16z.3	.3/8z.3	.1/2z.3	.5/8z.3	.3/4z.3	.1z.3
Safe-Lock Order No.	A10.142...	.1/4z.37	.5/16z.37	.3/8z.37	.1/2z.37	.5/8z.37	.3/4z.37	.1z.37
Gage length A [inch]	ZG200	7.87	7.87	7.87	7.87	7.87	7.87	7.87
Standard Order No.	A10.146...	.1/4z.3	.5/16z.3	.3/8z.3	.1/2z.3	.5/8z.3	.3/4z.3	.1z.3
Safe-Lock Order No.	A10.146...	.1/4z.37	.5/16z.37	.3/8z.37	.1/2z.37	.5/8z.37	.3/4z.37	.1z.37

METRIC	Clamping Ø D1 [mm]	06	08	10	12	14	16	18	20	25
	Ø D2 [mm]	21	21	27	27	33	33	44	44	44
	Ø D3 [mm] ultra short	60	60	53	73	60	78	76	85	85
	Ø D3 [mm]	83	83	83	83	83	83	83	83	83
	L [mm]	36	36	42	47	47	50	50	52	58
Gage length A [mm]	short	85	85	90	95	95	100	100	105	115
Standard Order No.	A10.140...	.06.3	.08.3	.10.3	.12.3	.14.3	.16.3	.18.3	.20.3	.25.3
Safe-Lock Order No.	A10.140...	.06.37	.08.37	.10.37	.12.37	.14.37	.16.37	.18.37	.20.37	.25.37
Gage length A [mm]	oversize	160	160	160	160	160	160	160	160	160
Standard Order No.	A10.142...	.06.3	.08.3	.10.3	.12.3	.14.3	.16.3	.18.3	.20.3	.25.3
Safe-Lock Order No.	A10.142...	.06.37	.08.37	.10.37	.12.37	.14.37	.16.37	.18.37	.20.37	.25.37
Gage length A [mm]	ZG200	200	200	200	200	200	200	200	200	200
Standard Order No.	A10.146...	.06.3	.08.3	.10.3	.12.3	.14.3	.16.3	.18.3	.20.3	.25.3
Safe-Lock Order No.	A10.146...	.06.37	.08.37	.10.37	.12.37	.14.37	.16.37	.18.37	.20.37	.25.37

## Accessories

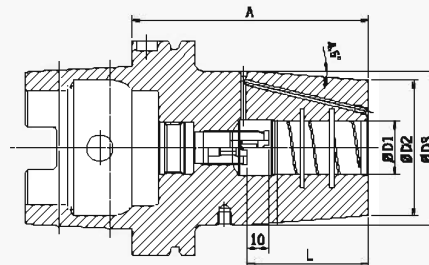
Cool Flash



Order No. 91.100.40

See pages 502–503

# HEAVY DUTY CHUCK DIN 69893-1 · HSK-A100



## CERTIFICATE OF QUALITY

- Chuck body fine balanced G2.5 25,000 rpm
- All functional surfaces fine machined
- More accurate than DIN
- Cool Jet, can be sealed

The Heavy Duty Chuck is a shrink fit chuck designed for extreme cases and Heavy Duty machining. The contour is optimized for highest rigidity and clamping force.

- Heat resistant hot-working steel
- Hardened 54-2 HRC
- Smooth clamping of the tool shank
- TIR less than 0.00012" (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 coolant bores that can be sealed included

Optional:

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

INCH	Clamping Ø D1 [inch]	5/8	3/4	1	1 1/4	1 1/2	2
	Ø D2 [inch]	2.01	2.28	2.48	2.76	3.22	3.22
	Ø D3 [inch]	—	2.64	2.83	3.07	3.70	3.70
	L [inch]	1.97	2.05	2.28	2.4	3.46	3.46
Gage length A [inch]	short	3.94	3.94	4.33	4.33	5.51	5.51
Order No.	A10.150...	.5/8z.6	.3/4z.6	.1z.6	.11/4z.6	.11/2z.6	.2z.6
Safe-Lock Order No.	A10.150...	.5/8z.67	.3/4z.67	.1z.67	.11/4z.67	.11/2z.67	.2z.67

METRIC	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	94	94
	Ø D3 [mm]	85	85	85	85	94	94
	L [mm]	50	52	58	61	88	88
Gage length A [mm]	short	100	100	110	110	140	140
Order No.	A10.150...	.16.6	.20.6	.25.6	.32.6	.40.6	.50.6
Safe-Lock Order No.	A10.150...	.16.67	.20.67	.25.67	.32.67	.40.67	.50.67
Gage length A [mm]	oversize	160	160	160	160	160	160
Order No.	A10.152...	.16.6	.20.6	.25.6	.32.6	.40.6	.50.6
Safe-Lock Order No.	A10.152...	.16.67	.20.67	.25.67	.32.67	.40.67	.50.67
Gage length A [mm]	ZG200	200	200	200	200	200	200
Order No.	A10.156...	.16.6	.20.6	.25.6	.32.6	.40.6	.50.6
Safe-Lock Order No.	A10.156...	.16.67	.20.67	.25.67	.32.67	.40.67	.50.67

Heavy Duty Chuck – For 13 kW shrink fit machine

METRIC	Clamping Ø D1 [mm]	16	20
	Ø D2 [mm]	46	46
	L [mm]	51	53
Gage length A [mm]	short	100	100
Order No.	A10.140...	.16.6	.20.6 <sup>1)</sup>
Safe-Lock Order No.	A10.140...	.16.67	.20.67 <sup>1)</sup>

## Accessories

Cool Flash



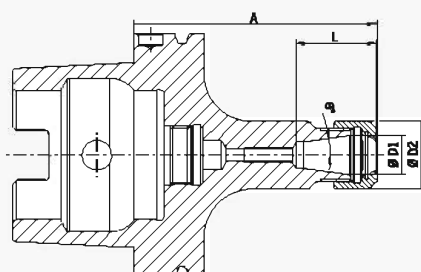
Order No. 91.100.40

See pages 502–503

# ER COLLET CHUCK DIN 69893-1 · HSK-A100

## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced G2.5 25,000 rpm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



## Use:

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

## DIN 69892-6

Included in delivery:

- Locknut (balanced, with slide coating for higher clamping forces); without coolant tube
- Locknut Type HS (High-Speed, fine balanced, with slide coating for higher clamping forces) for an extra charge
- Enlarging of size L upon request

INCH	ER		16	25	32	40
	Ø D [inch]		1.1	1.65	1.97	2.48
	Clamping range [inch]		0.02–0.39	0.04–0.63	0.06–0.79	0.10–1.02
	Clamping range [mm]		0.5–10.0	1.0–16.0	1.5–16.0	2.5–26.0
	L [inch]		1.28	1.62	1.85	2.09
Gage length A [inch]	short		3.94	3.94	3.94	4.72
Order No.	A10.020...		.16	.25	.32	.40
Gage length A [inch]	oversize		6.30	6.30	6.30	6.30
Order No.	A10.022...		.16	.25	.32	.40

## Accessories

### Collets ER



See pages 768–773

### Shrink Fit Collets



See pages 759–767

### Locknut (pre-balanced)

Size		ER 16	ER 25	ER 32	ER 40
Order No.	83.912...	.16	.25	.32	.40

### Chuck nut HS (fine-balanced)

Size		ER 16	ER 25	ER 32	ER 40
Order No.	83.912...	.16.HS	.25.HS	.32.HS	.40.HS

### Fork wrench

Size		ER 16	—	—	—
Order No.	84.200...	.16			

### Clamping wrench

Size		—	ER 25	ER 32	ER 40
Order No.	84.200...		.25	.32	.40

### Balancing index rings

Size	long/oversize	ER 16	ER 25	ER 32	ER 40
Order No.	79.350...	.28	.42	.48	.50

### Adjusting screw

Size		ER 16	ER 25	ER 32	ER 40
Order No.	85.800...	.34	.34	.35	.35

### Coolant tube

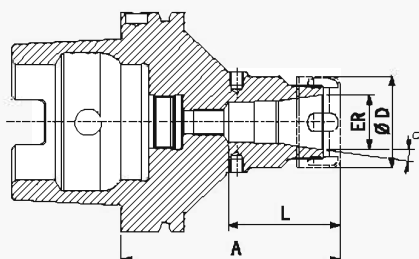
Order No.	85.700.10
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### Shrink fit extensions



See pages 751–753

# POWER COLLET CHUCK DIN 69893-1 · HSK-A100



## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
G2.5 25,000 rpm  
or U<1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN

The Power Collet Chuck is designed for the highest cutting performance in High Speed machining. The optimized design with improved construction combines high rigidity with vibration dampening features, giving more protection to the machine, spindle and tool. The universal Power Collet Chuck is a unique high performance chuck that can also be used with standard collets.

- High runout accuracy: < 0.00012" (3 µm) at 3 x D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488 (formerly DIN 6499) (Attention: By using standard collet, ER length A will increase)
- 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
- Program of Power Collets on pages 774 – 776

INCH	ER		16	25	32
	Ø D [inch]		1.1	1.65	1.97
	Clamping range [inch]		1/8–3/8	1/8–5/8	1/8–3/4
	Clamping range [mm]		2.0–10.0	2.0–16.0	2.0–20.0
	L [inch]		1.69	2.01	2.09
Gage length A [inch]	ultra short		3.35	3.35	3.35
Order No.	A10.025...		.16.3	.25.3	.32.3
Gage length A [inch]	short		3.93	3.93	3.93
Order No.	A10.020...		.16.3	.25.3	.32.3
Gage length A [inch]	ZG130		5.12	5.12	5.12
Order No.	A10.024...		.16.3	.25.3	.32.3
Gage length A [inch]	oversize		6.30	6.30	6.30
Order No.	A10.022...		.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 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 759–767

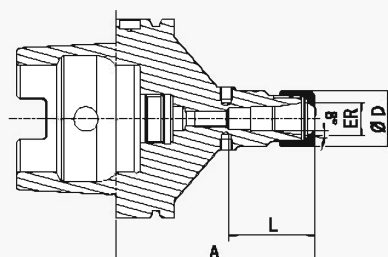
### Coolant tube

Order No. 85.700.10 See page 793

# HIGH PRECISION COLLET CHUCK DIN 69893-1 · HSK-A100

## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced G2.5 25,000 rpm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



The High Precision Collet Chuck is designed for the highest cutting performance 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: < 0.00012" (3 µm) 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 increase)
- 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
- Program of Power Collets on pages 774 – 776

INCH	ER		16	25	32
	Ø D [inch]		1.1	1.85	1.97
	Clamping range [inch]		1/8–3/8	1/8–5/8	1/8–3/4
	Clamping range [mm]		2.0–10.0	2.0–16.0	2.0–20.0
	L [inch]		1.89	2.01	2.09
Gage length A [inch]	ultra short		3.35	3.35	3.35
Order No.	A10.025...		.16.3.HP	.25.3.HP	.32.3.HP
Gage length A [inch]	short		3.93	3.93	3.93
Order No.	A10.020...		.16.3.HP	.25.3.HP	.32.3.HP
Gage length A [inch]	ZG130		5.12	5.12	5.12
Order No.	A10.024...		.16.3.HP	.25.3.HP	.32.3.HP
Gage length A [inch]	oversize		6.30	6.30	6.30
Order No.	A10.022...		.16.3.HP	.25.3.HP	.32.3.HP

## Accessories

### High Precision Smooth Locknut (fine-balanced)

Size ER 16 ER 25 ER 32 See page 779

Order No. 83.914...



ER 16

ER 25

ER 32

Roller bearing wrench

Order No. 84.650...



.16.1

.25.1

.32.1

See page 782

Collets ER



See pages 768–773

Shrink Fit Collets



See pages 759–767

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

Coolant tube

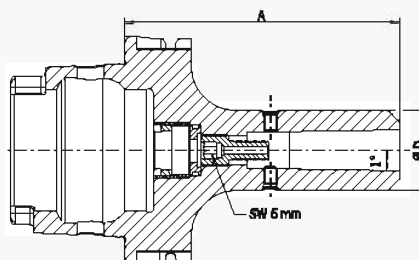
Order No. 85.700.10



See page 793



# HIGH-PRECISION CHUCK DIN 69893-1 · HSK-A100



## CERTIFICATE OF QUALITY

- Chuck fine balanced  
G2.5 25,000 rpm
- All functional surfaces fine machined
- More accurate than DIN

### Use:

For high-precision clamping of tools with cylindrical shank, also with clamping flats. Very useful for High Speed machining.

- Included in delivery: High-Precision Chuck with clamping screw and pull-out hook, without collet, without coolant tube
- Shank tolerance h6
- Optional: Cool Jet bores on HG Collets from diam. 0.25" – 0.78"
- Extensions for High-Precision Chuck available

INCH	HG	01	02	03
ØD [inch]		1.18	1.38	1.89
Clamping Ø [inch]		0.08–0.35	0.39–0.57	0.63–0.79
Clamping Ø [mm]		2   3   4   5   6   8	10   12   14	16   18   20
Gage length A [inch]	short	4.72	4.72	5.12
Order No.	A10.120...	.01	.02	.03
Gage length A [inch]	oversize	6.30	6.30	6.30
Order No.	A10.122...	.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 D [mm]		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 D [mm]								Ø 10	Ø 12	Ø 14	—	—	—
Order No.	82.520...							.10	.12	.14			
HG 03 Ø D [mm]											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

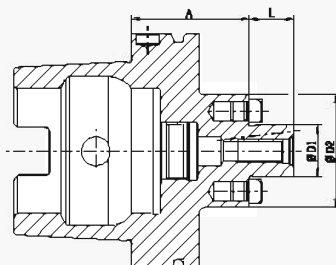


# FACE MILL ARBOR

## DIN 69893-1 · HSK-A100

### CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
G2.5 25,000 rpm  
or U<1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



### Use:

For clamping face mill cutters.

Metric version: With coolant exit bores on the end face for milling cutters with central cooling.

- Included in delivery: Face Mill Arbor with clamping screw
- Inch sizes: Coolant bores on front side for an extra charge

INCH	Ø D1 [inch]		3/4	1	1 1/4	1 1/2
	L [inch]		0.67	0.67	0.67	0.94
	Ø D2 [inch]		1.71	2.17	2.75	3.78
Gage length A [inch]	long		3.94	3.94	3.94	3.94
Order No.	A10.051...		.3/4Z	.1Z	.1 1/4Z	.1 1/2Z
Gage length A [inch]	oversize		6.30	6.30	6.30	6.30
Order No.	A10.052...		.3/4Z	.1Z	.1 1/4Z	.1 1/2Z

METRIC	Ø D1 [mm]		16	22	27	32	40
	L [mm]		17	19	21	24	27
	Ø D2 [mm]		38	48	60	78	87
Gage length A [mm]	short		50	50	50	50	60
Order No.	A10.050...		.16.KKB	.22.KKB	.27.KKB	.32.KKB	.40.KKB
Gage length A [mm]	long		100	100	100	100	100
Order No.	A10.051...		.16.KKB	.22.KKB	.27.KKB	.32.KKB	.40.KKB
Gage length A [mm]	oversize		160	160	160	160	160
Order No.	A10.052...		.16.KKB	.22.KKB	.27.KKB	.32.KKB	.40.KKB

### Accessories

#### Clamping Screw

Ø D1 [inch]			3/4	1	1 1/4	1 1/2
Order No.	85.300...		.3/4Z	.1Z	.11/4Z	.11/2Z

#### Wrench

Ø D1 [inch]			3/4	1	1 1/4	1 1/2
Order No.	84.400...		.3/4Z	.1Z	.11/4Z	.11/2Z

#### Balancing index ring

Ø D1 [inch]			3/4	1	—	—
Order No.	79.350...		.1.71Z	.55		

#### Coolant tube

Ø D1 [inch]			3/4	1	1 1/4	1 1/2
Order No.	85.700...		.10	.10	.10	.10

#### Coolant bores

Order No.	91.100.03	
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### Accessories

#### Clamping Screw

Ø D1 [mm]			16	22	27	32	40
Order No.	85.300...		.16	.22	.27	.32	.40

#### Wrench

Ø D1 [mm]			16	22	27	32	40
Order No.	84.400...		.16	.22	.27	.32	.40

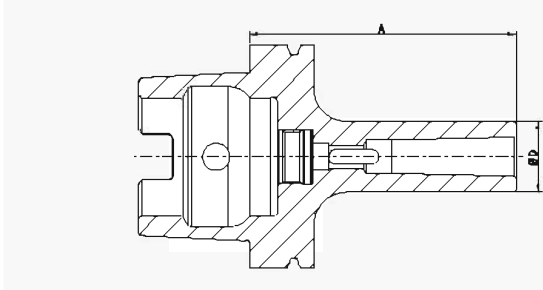
#### Balancing index ring

Ø D1 [mm]			16	22	27	32	40
Order No.	79.350...		.36	.48	.60	.78	.87

#### Coolant tube

Ø D1 [mm]			16	22	27	32	40
Order No.	85.700...		.10	.10	.10	.10	.10

ADAPTER FOR MORSE TAPER WITH TANG  
DIN 69893-1 · HSK-A100



CERTIFICATE OF QUALITY	
<input checked="" type="checkbox"/>	Chuck balanced
	G6.3 8,000 rpm
<input checked="" type="checkbox"/>	All functional surfaces fine machined
<input checked="" type="checkbox"/>	More accurate than DIN

**Use:**  
For holding tools with morse taper and tang according to DIN 228-1 form AF.

– Fine-balancing for an extra charge

MK			01	02	03	04
	Ø D [mm]		25	32	40	48
Gage Length A [mm]	short		110	120	150	170
Order No.	A10.080...		.01	.02	.03	.04

Accessories

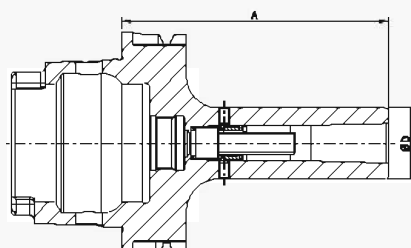
Balancing index rings

MK			01	02	03	04
Order No.	79.350...		.25	.32	.40	.48
Coolant tube						
Order No.	85.700.10					

## ADAPTER FOR MORSE TAPER WITH THREAD DIN 69893-1 · HSK-A100

### CERTIFICATE OF QUALITY

- ☒ Chuck balanced  
G6.3 8,000 rpm
- ☒ All functional surfaces fine machined
- ☒ More accurate than DIN



### Use:

For holding tools with morse taper with thread according to DIN 228-1 form A.

- Fine-balancing for an extra charge
- Delivery with tightening bolt without coolant tube

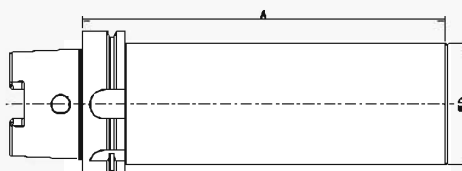
MK			01	02	03	04
Ø D [mm]			25	32	40	48
Gage Length A [mm]	short		110	120	150	170
Order No.	A10.130...		.01	.02	.03	.04

### Accessories

#### Balancing index rings

MK			01	02	03	04
Order No.	79.350...		.25	.32	.40	.48
Coolant tube						
Order No.	85.700.10					

## BLANK ADAPTER DIN 69893-1 · HSK-A100



### CERTIFICATE OF QUALITY

- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN

#### Use:

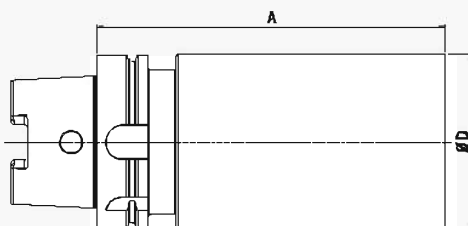
For manufacturing special tools in your own factory.

#### Design:

HSK is hardened and ground, the cylindrical part is soft.

	Ø D [mm]		83
Gage Length A [mm]	ZG250		250
Order No.	A10.090...		.83

## BLANK ADAPTER – HARDENED DIN 69893-1 · HSK-A100



### CERTIFICATE OF QUALITY

- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN

#### Use:

For manufacturing special tools in your own factory.

#### Version:

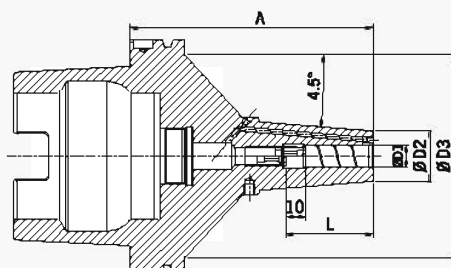
- HSK hardened and ground
- Cylindrical part hardened to 52+2 HRC

METRIC	Ø D [mm]		101
Gage Length A [mm]	ZG100		100
Order No.	RA100.096.1010....		.0100
Gage Length A [mm]	ZG200		200
Order No.	RA100.096.1010....		.0200

# POWER SHRINK CHUCK DIN 69893-1 · HSK-A125

## CERTIFICATE OF QUALITY

- Chuck body fine balanced  
G2.5 25,000 rpm or U<1 gmm
- All functional surfaces fine machined
- More accurate than DIN
- Cool Jet, can be sealed



The Power Shrink Chuck is designed for the highest cutting performance in High Speed machining. The optimized design combines high rigidity with vibration dampening, which protects the machine, spindle and tool.

- Heat resistant hot-working steel
- Hardened 54-2 HRC
- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle times, higher machining accuracy
- Quieter running, therefore better surface quality and protection of tools, spindles and machines
- With Cool Jet bores that can be sealed (Thread M4) and 6 bores

- With internal groove in the clamping bore
- Higher coolant flow rate due to optimized coolant bores
- With threaded holes in order to balance with balancing screws

The long versions (A=oversize and ZG9 Inch) with slim tips are especially versatile to use.

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

Optional:

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

INCH	Clamping Ø D1 [inch]		3/8	1/2	5/8	3/4	1
	Ø D2 [inch]		1.06	1.06	1.30	1.73	1.73
	Ø D3 [inch]		4.29	4.29	4.29	4.29	4.29
	L [inch]		1.65	1.85	1.97	2.05	2.28
Gage length A [inch]	ZG5 inch		5 <sup>1)</sup>	5 <sup>1)</sup>	5 <sup>1)</sup>	5	5
Order No.	A125.140...		.3/8Z.3.I	.1/2Z.3.I	.5/8Z.3.I	.3/4Z.3.I	.1Z.3.I
Safe-Lock Order No.	A125.140...		.3/8Z.37.I	.1/2Z.37.I	.5/8Z.37.I	.3/4Z.37.I	.1Z.37.I
Gage length A [inch]	oversize		7 <sup>1)</sup>	7 <sup>1)</sup>	7 <sup>1)</sup>	7	7
Order No.	A125.142...		.3/8Z.3.I	.1/2Z.3.I	.5/8Z.3.I	.3/4Z.3.I	.1Z.3.I
Safe-Lock Order No.	A125.142...		.3/8Z.37.I	.1/2Z.37.I	.5/8Z.37.I	.3/4Z.37.I	.1Z.37.I
Gage length A [inch]	ZG9 inch		9 <sup>1)</sup>	9 <sup>1)</sup>	9 <sup>1)</sup>	9	9
Order No.	A125.146...		.3/8Z.3.I	.1/2Z.3.I	.5/8Z.3.I	.3/4Z.3.I	.1Z.3.I
Safe-Lock Order No.	A125.146...		.3/8Z.37.I	.1/2Z.37.I	.5/8Z.37.I	.3/4Z.37.I	.1Z.37.I

METRIC	Clamping Ø D1 [mm]		10	12	16	20	25
	Ø D2 [mm]		27	27	33	44	44
	Ø D3 [mm]		109	109	109	109	109
	L [mm]		42	47	50	52	58
Gage length A [mm]	ZG130		130 <sup>1)</sup>	130 <sup>1)</sup>	130	130	130
Order No.	A125.140...		.10.3	.12.3	.16.3	.20.3	.25.3
Safe-Lock Order No.	A125.140...		.10.37	.12.37	.16.37	.20.37	.25.37
Gage length A [mm]	oversize		160 <sup>1)</sup>	160 <sup>1)</sup>	160	160	160
Order No.	A125.142...		.10.3	.12.3	.16.3	.20.3	.25.3
Safe-Lock Order No.	A125.142...		.10.37	.12.37	.16.37	.20.37	.25.37
Gage length A [mm]	ZG200		200 <sup>1)</sup>	200 <sup>1)</sup>	200	200	200
Order No.	A125.146...		.10.3	.12.3	.16.3	.20.3	.25.3
Safe-Lock Order No.	A125.146...		.10.37	.12.37	.16.37	.20.37	.25.37

## Accessories

### Cool Flash



Order No. 91.100.40

See pages 502–503

### Coolant tube

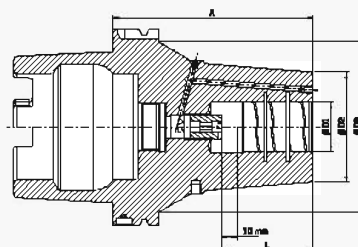


Order No. 85.700.125

See page 793

1) Thread M3, 2 bores

# HEAVY DUTY SHRINK CHUCK DIN 69893-1 · HSK-A125



## CERTIFICATE OF QUALITY

- Chuck body fine balanced G2.5 25,000 rpm
- All functional surfaces fine machined
- More accurate than DIN
- Cool Jet, can be sealed

The Heavy Duty Chuck is a shrink fit chuck designed for extreme cases and Heavy Duty machining. The contour is optimized for highest rigidity and clamping force.

- Heat resistant hot-working steel
- Hardened 54-2 HRC
- No deformation at the tool shank after shrink process
- TIR less than 0.00012" (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 Cool Jet bores that can be sealed (Thread M4) and 6 bores
- Higher coolant flow rate due to optimized coolant bores
- With threaded holes in order to balance with balancing screws

### Optional:

- Cooling with Cool Flash from 5/8"-1" for an extra charge (See pages 502-503)

INCH	Clamping Ø D1 [inch]		5/8	3/4	1	1 1/4	1 1/2	2
	Ø D2 [inch]		2.01	2.28	2.48	2.76	3.23	3.23
	Ø D3 [inch]		4.29	4.29	4.29	4.29	4.29	4.28
	L [inch]		1.97	2.05	2.28	2.28	3.46	3.46
Gage length A [inch]	ZG5 inch		5	5	5	5	5 <sup>12)</sup>	5 <sup>12)</sup>
Order No.	A125.150...		.5/8Z.6J	.3/4Z.6J	.12.6J	.11/4Z.6J	.11/2Z.6J	.22.6J
Safe-Lock Order No.	A125.150...		.5/8Z.67J	.3/4Z.67J	.12.67J	.11/4Z.67J	.11/2Z.67J	.22.67J
Gage length A [inch]	oversize		7	7	7	7	7	7
Order No.	A125.152...		.5/8Z.6J	.3/4Z.6J	.12.6J	.11/4Z.6J	.11/2Z.6J	.22.6J
Safe-Lock Order No.	A125.152...		.5/8Z.67J	.3/4Z.67J	.12.67J	.11/4Z.67J	.11/2Z.67J	.22.67J
Gage length A [inch]	ZG9 inch		9	9	9	9	9	9
Order No.	A125.156...		.5/8Z.6J	.3/4Z.6J	.12.6J	.11/4Z.6J	.11/2Z.6J	.22.6J
Safe-Lock Order No.	A125.156...		.5/8Z.67J	.3/4Z.67J	.12.67J	.11/4Z.67J	.11/2Z.67J	.22.67J

METRIC	Clamping Ø D1 [mm]		16	20	25	32	40	50
	Ø D2 [mm]		51	58	63	70	82	82
	Ø D3 [mm]		109	109	109	109	109	109
	L [mm]		50	52	58	61	88	88
Gage length A [mm]	ZG130		130	130	130	130	130 <sup>12)</sup>	130 <sup>12)</sup>
Order No.	A125.150...		.16.6	.20.6	.25.6	.32.6	.40.6	.50.6
Safe-Lock Order No.	A125.150...		.16.67	.20.67	.25.67	.32.67	.40.67	.50.67
Gage length A [mm]	oversize		160	160	160	160	160	160
Order No.	A125.152...		.16.6	.20.6	.25.6	.32.6	.40.6	.50.6
Safe-Lock Order No.	A125.152...		.16.67	.20.67	.25.67	.32.67	.40.67	.50.67
Gage length A [mm]	ZG200		200	200	200	200	200	200
Order No.	A125.156...		.16.6	.20.6	.25.6	.32.6	.40.6	.50.6
Safe-Lock Order No.	A125.156...		.16.67	.20.67	.25.67	.32.67	.40.67	.50.67

### Accessories

Coolant tube



Order No. 85.700.125

See page 793

Back-up screws



See pages 796-798

Cool Flash



Order No. 91.100.40

See pages 502-503

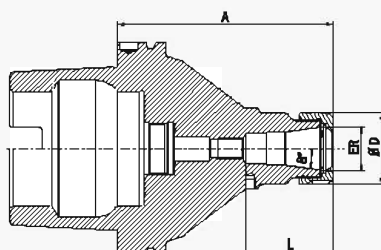


# POWER COLLET CHUCK

## DIN 69893-1 · HSK-A125

### CERTIFICATE OF QUALITY

- ☑ Chuck fine balanced  
G2.5 25,000 rpm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



The Power Collet Chuck is designed for the highest cutting performance in High Speed machining. The optimized design with improved construction combines high rigidity with vibration dampening features, giving more protection to the machine, spindle and tool. The universal Power Collet Chuck is a unique high performance chuck that can also be used with standard collets.

- High runout accuracy: < 0.00012" (3 µm) at 3 × D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488 (formerly DIN 6499)  
(Attention: By using standard collet, ER length A will increase)
- 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
- Program of Power Collets on pages 774 – 776

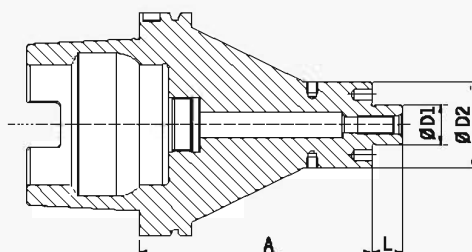
INCH	ER		25	32
	Ø D [inch]		1.65	1.97
	Clamping range [inch]		1/8–5/8	1/8–3/4
	Clamping range [mm]		2.0–16.0	2.0–20.0
	L [inch]		2.01	2.09
Gage length A [inch]	short		4	4
Order No.	A125.020...		.25.3.1	.32.3.1
Gage length A [inch]	ZG5 inch		5	5
Order No.	A125.024...		.25.3.1	.32.3.1
Gage length A [inch]	oversize		7	7
Order No.	A125.022...		.25.3.1	.32.3.1
Gage length A [inch]	ZG9 inch		9	9
Order No.	A125.026...		.25.3.1	.32.3.1

METRIC	ER		25	32
	Ø D [mm]		42	50
	Clamping range [mm]		2.0–16.0	2.0–20.0
	L [mm]		51	53
Gage length A [mm]	short		100	100
Order No.	A125.020...		.25.3	.32.3
Gage length A [mm]	ZG130		130	130
Order No.	A125.024...		.25.3	.32.3
Gage length A [mm]	oversize		160	160
Order No.	A125.022...		.25.3	.32.3
Gage length A [mm]	ZG200		200	200
Order No.	A125.026...		.25.3	.32.3

### Accessories

Power Collets		See pages 774–775
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 763–767

# FACE MILL ARBOR DIN 69893-1 · HSK-A125



## CERTIFICATE OF QUALITY

✓ Chuck body fine balanced  
G2.5 25,000 rpm  
or U<1 gmm

✓ All functional surfaces machined

✓ More accurate than DIN

### Use:

For holding face mill cutters and cutters with radial driving slot DIN 1880.

### DIN 69892-3

- Reinforced outer contour
- Included in delivery: tightening bolt, with threaded holes in order to balance with balancing screws, without coolant tube
- Metric sizes: With coolant exit bores on the end face for milling cutters with central cooling

INCH	Clamping Ø D1 [inch]		3/4	1
	Ø D2 [inch]		1.71	2.17
	L [inch]		0.67	0.67
Gage length A [inch]	short		4	4
Order No.	A125.050...		.3/4Z.3.I	.1Z.3.I
Gage length A [inch]	ZG5 inch		5	5
Order No.	A125.054...		.3/4Z.3.I	.1Z.3.I
Gage length A [inch]	oversize		7	7
Order No.	A125.052...		.3/4Z.3.I	.1Z.3.I
Gage length A [inch]	ZG9 inch		9	9
Order No.	A125.056...		.3/4Z.3.I	.1Z.3.I

METRIC	Clamping Ø D1 [mm]		22	27
	Ø D2 [mm]		48	60
	L [mm]		19	21
Gage length A [mm]	short		100	100
Order No.	A125.050...		.22.3.KKB	.27.3.KKB
Gage length A [mm]	ZG130		130	130
Order No.	A125.054...		.22.3.KKB	.27.3.KKB
Gage length A [mm]	oversize		160	160
Order No.	A125.052...		.22.3.KKB	.27.3.KKB
Gage length A [mm]	ZG200		200	200
Order No.	A125.056...		.22.3.KKB	.27.3.KKB

### Accessories

#### Tightening bolt

Size D1

Order No.

85.300...



22

.22

27

.27

#### Wrench

Size D1

Order No.

84.400...



22

.22

27

.27

#### Balancing Index rings

Size D1

Order No.

79.350...



22

.48

27

.60

#### Coolant bores

Order No.

91.100.03



#### Coolant tube

Order No.

85.700.125

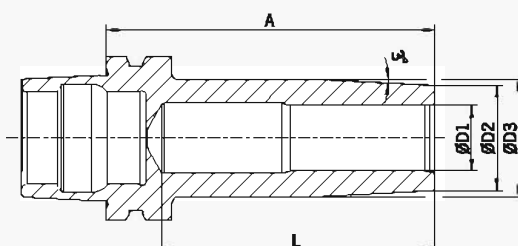


See page 793

## MINI SHRINK DIN 69893-5 · HSK-E25

### CERTIFICATE OF QUALITY



- ☑ Chuck body fine balanced  
U<1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



Low cutting forces at high rpm are typical in micro machining (die & mold, medical engineering, micro mechanical engineering). The slim and short design of the all new HSK-E25 series from HAIMER – which is well known from the HAIMER Mini Shrink tool holders – is perfectly suitable for the requirements of micro machining.

- No disturbing edges, also jobs difficult to access can be reached
- Highest runout accuracy: < 0.00012" (3 µm)
- Ideal to shrink with the HAIMER Power Clamp Nano
- Heat resistant hot-working steel
- Hardened 54–2 HRC

**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.

METRIC	Clamping Ø D1 [mm]		03	04	05	06	06	06	08	10	10	10	12
	Ø D2 [mm]		09	10	11	12	12	12	14	16	16	16	18
	Ø D3 [mm]		—	—	—	—	—	—	—	18	18	18	20
	L [mm] ultra short		15	18	23	27.5	—	—	27	26.5	—	—	26
	L [mm] standard		15	18	28	37.5	32.5	37.5	27	41.5	36.5	41.5	35.5
Gage length A [mm]	ultra short		35 <sup>1)</sup>	35 <sup>1)</sup>	35 <sup>1)</sup>	40 <sup>1)</sup>	—	—	40 <sup>1)</sup>	40 <sup>1)</sup>	—	—	40 <sup>1)</sup>
Order No.	E25.185...		.03	.04	.05	.06			.08	.10			.12
Gage length A [mm]	standard		45	45	45	45 <sup>2)</sup>	45	50	50	50 <sup>2)</sup>	50	55	50
Order No.	E25.180...		.03	.04	.05	.06	.06.V2	.06.V3	.08	.10	.10.V2	.10.V3	.12

1) Only shrinkable with Power Clamp Nano

2) Without thread for coolant tube

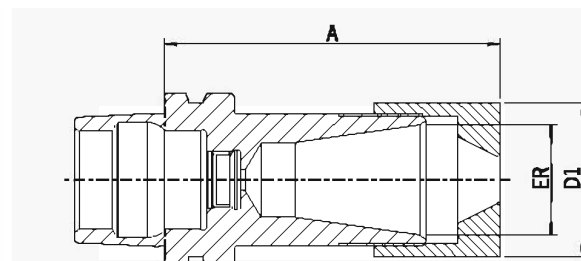
### Mini Shrink shrink and cooling sleeves

- 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.
<b>Extra slim</b>								
Size [mm]	Ø 03	Ø 04	Ø 05	Ø 06	Ø 08	Ø 10	Ø 12	
Order No. 80.105.14...	.2.01	.2.02	.2.03	.2.04	.2.05	.2.06	.2.07	
<b>Standard</b>								
Size [mm]	Ø 03	Ø 04	Ø 05	Ø 06	Ø 08	Ø 10	Ø 12	
Order No. 80.105.14...	.2.04	.2.08	.2.05	.2.09	.2.10	.2.11	.2.12	
<b>Base</b>								80.105.14.2.99
Set with base (12 pcs., diameter 3 – 12 mm)								80.105.14.2.00

# COLLET CHUCK MINI ER DIN 69893-5 · HSK-E25



## CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced  
U < 1 gmm
- ☒ All functional surfaces fine machined
- ☒ More accurate than DIN

Low cutting forces at high RPMs are typical in micro machining (die & mold, medical engineering, micro mechanical engineering). The slim and short design of the all new HSK-E25 series from HAIMER is perfectly suitable for the requirements of micro machining.

– Included in delivery: Locknut

Available as:

– Mini-ER collet chuck (Mini-ER 16) in two different lengths

Standard version, similar to DIN 69882-8

INCH	Mini-ER	16
	Ø D [inch]	0.87
	Clamping range [inch]	0.02–0.39
	Clamping range [mm]	0.50–10.0
Gage length A [inch]	ultra short	1.69
Order No.	E25.025...	.16.7 <sup>1)</sup>
Gage length A [inch]	short	1.89
Order No.	E25.020...	.16.7

## Accessories

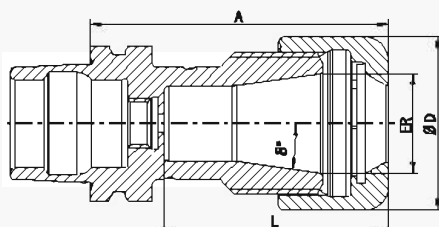
### Clamping nut

Size		Mini ER 16
Order No.	915010-	.0002
Torque Master torque wrench		
Order No.	84.600.00	
Insert torque wrench		Mini ER 16
Order No.	84.620...	.16.1

# HIGH PRECISION COLLET CHUCK DIN 69893-5 · HSK-E25

## CERTIFICATE OF QUALITY

- Chuck body fine balanced  
U < 1 gmm
- All functional surfaces fine machined
- More accurate than DIN



The High Precision Collet Chuck is designed for the highest cutting performance 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. The chuck is especially suitable for micro and fine machining (e.g. in the medical or watchmaking industry).

- With a specially coated smooth locknut, balanced at < 1 gmm
- High runout accuracy: 0.00012" (3 µm) 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 increase)
- High rigidity

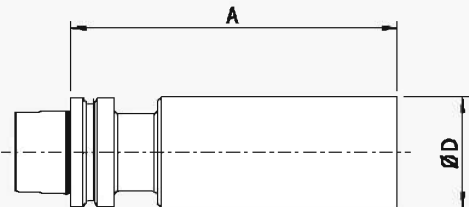
- Runs smoother thanks to vibration absorbing geometry, yielding better surface finish and increased tool, spindle and machine protection
- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle times, higher machining accuracy, higher clamping 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
- Program of Power Collets on pages 774 – 776

INCH	ER	16
Ø D [inch]		1.1
Clamping range [inch]		1/8–3/8
Clamping range [mm]		2.0–10.0
L [inch]		1.22
Gage length A [inch]	ultra short	1.77
Order No.	E25.025...	.16.3.HP

## Accessories

High Precision Smooth Locknut (fine-balanced)			See page 779
Size		ER 16	
Order No.	83.914...	.16.1	
Roller bearing wrench			See page 782
Order No.	84.650...	.16.1	
Collets ER			See pages 768–773
Shrink Fit Collets			See pages 759–765
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		

BLANK ADAPTER – HARDENED  
DIN 69893-5 · HSK-E25



CERTIFICATE OF QUALITY

All functional surfaces fine machined

More accurate than DIN

**Use:**  
For manufacturing special tools in your own factory.

**Version:**  
– HSK hardened and ground  
– Cylindrical part hardened to 52+2 HRC

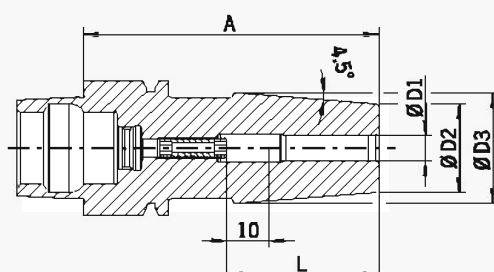
METRIC	Ø D [mm]	25.3
Gage Length A [mm]	ZG75	75
Order No.	RE25.096.0253... 	.0075



# SHRINK FIT CHUCK DIN 69893-5 · HSK-E32

## CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced  
U<1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



## Use:

Shrink fit chuck suitable for use with all available shrink fit units.

## Optional:


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

## DIN 69893-5

- With threaded holes in order to balance with balancing screws
- Included in delivery: Shrink fit chuck with backup screw, without coolant tube
- Heat resistant hot-working steel
- Hardened 54–2 HRC
- For HSS and solid carbide tools
- Shank tolerance h6


## Standard version, similar to DIN 69882-8

INCH	Clamping Ø D1 [inch]		1/8	3/16	1/4	3/8
	Ø D2 [inch]		0.39	0.39	0.83	0.94
	L [inch]		0.35	0.59	1.42	1.65
Gage length A [inch]	short		2.36 <sup>1)</sup>	2.36 <sup>1)</sup>	2.76	3.15
Order No.	E32.140...		.1/8Z	.3/16Z	.1/4Z	.3/8Z


METRIC	Clamping Ø D1 [mm]		03	04	05	06	08	10
	Ø D2 [mm]		10	10	10	21	21	24
	Ø D3 [mm]		—	—	—	27	27	32
	L [mm]		09	12	15	36	36	42
Length A [mm]	short		60 <sup>1)</sup>	60 <sup>1)</sup>	60 <sup>1)</sup>	70 <sup>2)</sup>	70 <sup>2)</sup>	80 <sup>2)</sup>
Order No.	E32.140...		.03	.04	.05	.06	.08	.10

## Accessories

Balancing screws  See page 784

Back-up screws  See pages 796–799

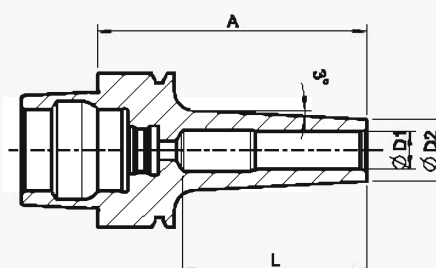
Cool Jet bores  See page 501

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

1) Without back-up screw, without threads for balancing screws, with slits along the clamping bore for coolant around the tool  
2) Without threads for balancing screws

# MINI SHRINK DIN 69893-5 · HSK-E32



## CERTIFICATE OF QUALITY



- Chuck body fine balanced  
 $U < 1 \text{ gmm}$
- All functional surfaces fine machined
- More accurate than DIN

- Extremely slim design
- No disturbing edges
- Highest runout accuracy:  $3 \mu\text{m}$
- Also jobs difficult to access can be reached
- Optimum rigidity
- Heat resistant hot-working steel
- Hardened 54–2 HRC
- Ideal to shrink with the HAIMER Power Clamp
- For all solid carbide tools with shank tolerance h6
- With  $3^\circ$  angle for die and mold

- Standard version: with high clamping force
- Tool holders fine balanced
- Delivery without coolant tube

**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.

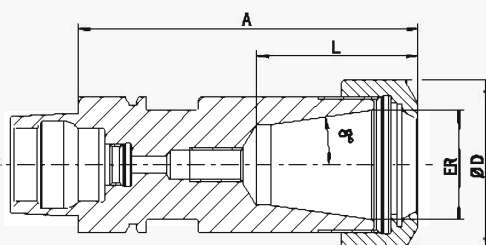
INCH	Clamping Ø D1 [inch]		1/8	3/16	1/4	3/8	1/2
	Ø D2 [inch]		0.35	0.43	0.47	0.63	0.71
Gage length A [inch]	ultra short		2.37	2.37	2.37	2.37	2.37
Length L [inch]			1.81	1.69	1.69	1.65	1.63
Order No.	E32.185...		.1/8Z	.3/16Z	.1/4Z	.3/8Z	.1/2Z
Gage length A [inch]	short		2.76	2.76	2.76	2.76	2.76
Length L [inch]			2.6	2.48	2.48	1.89	1.89
Order No.	E32.183...		.1/8Z	.3/16Z	.1/4Z	.3/8Z	.1/2Z

METRIC	Clamping Ø D1 [mm]		03	04	05	06	08	10	12
	Ø D2 Standard [mm]		09	10	11	12	14	16	18
Gage length A [mm]	ultra short		60	60	60	60	60	60	60
Length L [mm]			46	43	43	43	38	42	41.5
Order No.	E32.185...		.03	.04	.05	.06	.08	.10	.12
Gage length A [mm]	ZG80		80	80	80	80	80	80	80
Length L [mm]			66	63	63	63	38	48	48
Order No.	E32.183...		.03	.04	.05	.06	.08	.10	.12

Shrinking and cooling sleeves for Mini Shrink chucks								Order No.
<b>Extra slim</b>								
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	
<b>Standard</b>								
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...	.2.04	.2.08	.2.05	.2.09	.2.10	.2.11	.2.12	
<b>Base</b>								80.105.14.2.99
<b>Set with base (12 pcs., diameter 3 – 12 mm)</b>								80.105.14.2.00

# ER COLLET CHUCK DIN 69893-5 · HSK-E32

CERTIFICATE OF QUALITY	
<input checked="" type="checkbox"/>	Chuck body fine balanced U<1 gmm
<input checked="" type="checkbox"/>	All functional surfaces machined
<input checked="" type="checkbox"/>	More accurate than DIN



## Use:

For clamping tools with cylindrical shank in ER collets.

- Locknut type HS (High Speed, fine balanced, with slide coating for higher clamping forces)
- Balanced collet nuts with special slide coating for low friction and higher clamping forces

INCH	ER	16	25
	ØD [inch]	1.1	1.65
	Clamping range [inch]	0.02–0.39	0.04–0.63
	Clamping range [mm]	0.5–10.0	1.0–16.0
L [inch]		1.28	1.61
Gage length A [inch]	short	3.15	3.15
Order No.	E32.020...	.16	.25
L [inch]		1.28	
Gage length A [inch]	long	3.94	—
Order No.	E32.021...	.16	

## Accessories

### Collet nut HS (Highspeed), fine-balanced

ØER		ER16	ER25
Order No.	83.912...	.16.HS	.25.HS

### Wrench

ØER		ER16	
Order No.	84.200...	.16	

### Wrench

ØER			ER25
Order No.	84.200...		.25

### Balancing Index rings

ØER		ER16	ER25
Order No.	79.350...	.22	.32

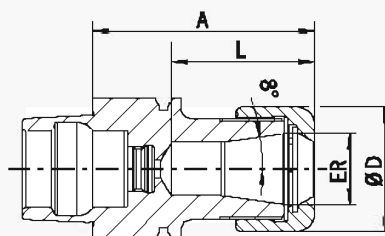
### Back-up screw

ØER		ER16	ER25
Order No.	85.800...	.34	.34

### Coolant tube

ØER		ER16	ER25
Order No.	85.700...	.32	.32

# POWER COLLET CHUCK DIN 69893-5 · HSK-E32



## CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced or U<1 gmm
- ☒ All functional surfaces machined
- ☒ More accurate than DIN

The Power Collet Chuck is designed for the highest cutting performance in High Speed machining. The optimized design with improved construction combines high rigidity with vibration dampening features, giving more protection to the machine, spindle and tool. The universal Power Collet Chuck is a unique high performance chuck that can also be used with standard collets.


- High runout accuracy: < 0.00012" (3 µm) at 3×D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488 (formerly DIN 6499) (Attention: By using standard collet, ER length A will increase)
- 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
- Without thread for set screw
- Optional: Cool Jet bores on Power Collets
- Program of Power Collets on pages 774 – 776

INCH	ER	16	25
	Ø D [Inch]	1.1	1.65
	Clamping range [Inch]	1/8–3/8	1/8–5/8
	Clamping range [mm]	2.0–10.0	2.0–16.0
	L [Inch]	1.26	1.53
Gage length A [Inch]	ultra short	1.97	2.36
Order No.	E32.025...	.16.3	.25.3

## Accessories


### Locknut (fine-balanced)

Size  ER 16 ER 25 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 759–765

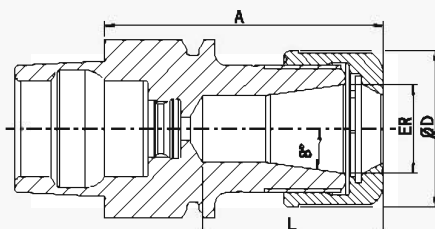
### Coolant tube

Order No. 85.700.32  See page 793

# HIGH PRECISION COLLET CHUCK DIN 69893-5 · HSK-E32

## CERTIFICATE OF QUALITY

- Chuck body fine balanced  
U < 1 gmm
- All functional surfaces fine machined
- More accurate than DIN



The High Precision Collet Chuck is designed for the highest cutting performance 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. The chuck is especially suitable for micro and fine machining (e.g. in the medical or watchmaking industry).

- With a specially coated smooth locknut, balanced at < 1 gmm
- High runout accuracy: 0.00012" (3 µm) 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 increase)
- 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
- Program of Power Collets on pages 774 – 776

INCH	ER	16	25
	Ø D [inch]	1.1	1.65
	Clamping range [inch]	1/8–3/8	1/8–5/8
	Clamping range [mm]	2.0–10.0	2.0–16.0
	L [inch]	1.26	1.53
Gage length A [inch]	ultra short	1.97	2.36
Order No.	E32.025...	.16.3.HP	.25.3.HP

## Accessories

### High Precision Smooth Locknut (fine-balanced)

Size		ER 16	ER 25	See page 779
Order No.	83.914...	.16.1	.25.1	

### Roller bearing wrench

Order No.	84.650...	.16.1	.25.1	See page 782
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### Collets ER

				See pages 768–773
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### Shrink Fit Collets

				See pages 759–765
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### Power Collets

				See page 775
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### Power Collets with Safe-Lock

				See page 776
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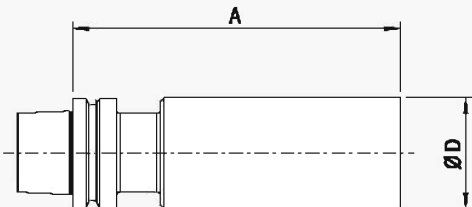
### Cool Jet bores for Power Collets

Order No.	91.100.27			See page 777
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### Coolant tube

Order No.	85.700.32			See page 793
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BLANK ADAPTER – HARDENED  
DIN 69893-5 · HSK-E32



CERTIFICATE OF QUALITY

☒ All functional surfaces fine machined
   
☒ More accurate than DIN

**Use:**  
For manufacturing special tools in your own factory.

**Version:**  
 – HSK hardened and ground  
 – Cylindrical part hardened to 52+2 HRC

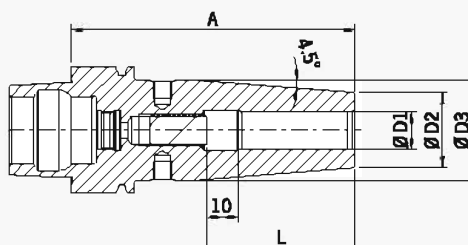
METRIC	Ø D [mm]		32.3
Gage Length A [mm]	ZG96		96
Order No.	RE32.096.0323...		.0096



## SHRINK FIT CHUCK DIN 69893-5 · HSK-E40

### CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
U < 1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



### Use:

Shrink fit chuck suitable for use with all available shrink fit units.

- With threaded holes in order to balance with balancing screws
- Included in delivery: Shrink fit chuck with backup screw, without coolant tube
- Heat resistant hot-working steel
- Hardened 54–2 HRC
- For HSS and solid carbide tools
- Shank tolerance h6

### Optional:

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

INCH	Clamping Ø D1 [inch]	1/8	3/16	1/4	5/16	3/8	1/2	5/8
	Ø D2 [inch]	0.39	0.39	0.83	0.83	0.94	0.94	1.06
	Ø D3 [inch]	–	–	1.08	1.08	1.26	1.26	1.34
	L [inch]	0.35	0.59	1.42	1.42	1.65	1.85	1.97
Gage length A [inch]	short	2.36 <sup>1)</sup>	2.36 <sup>1)</sup>	3.15	3.15	3.15	3.54	3.54
Order No.	E40.140...	.1/8Z	.3/16Z	.1/4Z	.5/16Z	.3/8Z	.1/2Z	.5/8Z

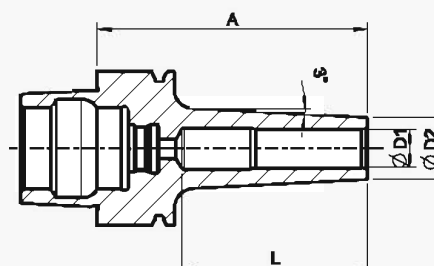
METRIC	Clamping Ø D1 [mm]	03	04	05	06	08	10	12	14	16
	Ø D2 [mm]	10	10	10	21	21	24	24	27	27
	Ø D3 [mm]	–	–	–	27	27	32	32	34	34
	Ø D2 [mm] E40.145...	–	–	–	22.5	22.5	26.5	26.5	30	30
	Ø D3 [mm] E40.145...	–	–	–	28.7	28.7	32	32	33	33
	L [mm]	09	12	15	36	36	42	47	47	50
Length A [mm]	ultra short	–	–	–	60 <sup>2)</sup>	60 <sup>2)</sup>	60 <sup>3)</sup>	60 <sup>3)</sup>	60 <sup>3)</sup>	60 <sup>3)</sup>
Order No.	E40.145...	–	–	–	.08	.08	.10	.12	.14	.16
Length A [mm]	short	60 <sup>1)</sup>	60 <sup>1)</sup>	60 <sup>1)</sup>	80	80	80	90	90	90
Order No.	E40.140...	.03	.04	.05	.08	.08	.10	.12	.14	.16

### Accessories

Balancing screws		See page 784
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

1) Without backup screw, without threads for balancing screws, with slots along the clamping bore for coolant around the tool  
 2) Without backup screw, without threads for balancing screws  
 3) Without backup screw, without threads for balancing screws, without thread for coolant tube

# MINI SHRINK DIN 69893-5 · HSK-E40



## CERTIFICATE OF QUALITY

- Chuck fine balanced U<1 gmm
- All functional surfaces fine machined
- More accurate than DIN

- Extremely slim design
- No disturbing edges
- TIR less than 0.00012" (3 µm)
- Also jobs difficult to access can be reached
- Optimum rigidity
- Heat resistant hot-working steel
- Hardened 54–2 HRC
- Ideal for the HAIMER Power Clamp
- For all solid carbide tools with shank tolerance h6
- With 3° angle for die and mold

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

**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.

INCH	Clamping Ø D1 [inch]		1/8	3/16	1/4	3/8	1/2
	Ø D2 [inch]		0.35	0.43	0.47	0.63	0.71
Gage length A [inch]	ultra short		2.36	2.36	2.36	2.36	2.36
Length L [inch]			—	1.61	1.61	1.65	1.61
Order No.	Standard E40.185...		.1/8Z	.3/16Z	.1/4Z	.3/8Z	.1/2Z
Gage length A [inch]	short		2.76	2.76	2.76	2.76	2.76
Length L [inch]			—	—	2.01	1.89	1.89
Order No.	Standard E40.180...		.1/8Z	.3/16Z	.1/4Z	.3/8Z	.1/2Z

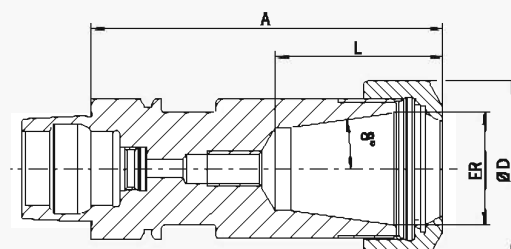
METRIC	Clamping Ø D1 [mm]		03	04	05	06	08	10	12
	Ø D2 Standard [mm]		09	10	11	12	14	16	18
	Ø D2 Extra slim [mm]		06	07	08	09	11	13	15
Length A [mm]	ultra short		60	60	60	60	60	60	60
Length L [mm]			—	—	—	41	41	42	41.5
Order No.	Standard E40.185...		.03	.04	.05	.06	.08	.10	.12
Order No.	Extra slim E40.175...		.03	.04	.05	.06	.08	.10	.12
Length A [mm]	short		70	70	70	70	70	70	70
Length L [mm]			—	—	—	51	51	48	48
Order No.	Standard E40.180...		.03	.04	.05	.06	.08	.10	.12
Order No.	Extra slim E40.170...		.03	.04	.05	.06	.08	.10	.12
Length A [mm]	ZG80		80	80	80	80	80	80	80
Length L [mm]			—	—	—	61	61	48	48
Order No.	Standard E40.183...		.03	.04	.05	.06	.08	.10	.12
Order No.	Extra slim E40.173...		.03	.04	.05	.06	.08	.10	.12

Shrinking and cooling sleeves for Mini Shrink chucks								Order No.
<b>Extra slim</b>								
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	
<b>Standard</b>								
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
<b>Base</b>								80.105.14.2.99
<b>Set with base (12 pcs., diameter 3 – 12 mm)</b>								80.105.14.2.00

# ER COLLET CHUCK DIN 69893-5 · HSK-E40

## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
U < 1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



## Uses:

For clamping tools with cylindrical shank in ER collets.

- Locknut type HS (High Speed, fine balanced, with slide coating for higher clamping forces)
- Balanced collet nuts with special slide coating for low friction and higher clamping forces

INCH	ER	11	16	25	32
	Ø D [inch]	0.75	1.1	1.65	1.97
	Clamping range [inch]	0.02–0.28	0.02–0.39	0.04–0.63	0.04–0.79
	Clamping range [mm]	0.5–7.0	0.5–10.0	1.0–16.0	1.5–20.0
L [inch]		1.05	1.28	1.61	1.85
Gage length A [inch]	ultra short	2.36	2.36	2.76	2.76
Order No.	E40.025...	.11 <sup>1)</sup>	.16 <sup>1)</sup>	.25 <sup>1)</sup>	.32 <sup>1)</sup>
L [inch]			1.30	1.61	
Gage length A [inch]	short		3.15	3.15	
Order No.	E40.020...	—	.16	.25	—

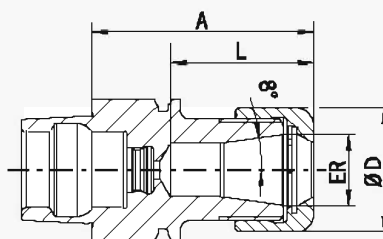
## Accessories

### Collet nut HS (Highspeed), fine-balanced

Ø ER		—	ER16	ER25	ER32
Order No.	83.912...		.16.H8	.25.H8	.32.H8
Wrench					
Ø ER		ER11	ER16	—	—
Order No.	84.200...	.11	.16		
Wrench					
Ø ER		—	—	ER25	ER32
Order No.	84.200...			.25	.32
Balancing index rings					
Ø ER		ER11	ER16	ER25	ER32
Order No.	79.350...	.19	.28	.32	.40
Back-up screw					
Ø ER		—	ER16	ER25	ER32
Order No.	85.800...		.34	.34	.35
Coolant tube					
Ø ER		ER11	ER16	ER25	ER32
Order No.	85.700...	.40	.40	.40	.40

1) Without thread for back-up screw

# POWER COLLET CHUCK DIN 69893-5 · HSK-E40



## CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced  
U < 1 gmm
- ☒ All functional surfaces fine machined
- ☒ More accurate than DIN

The Power Collet Chuck is designed for the highest cutting performance in High Speed machining. The optimized design with improved construction combines high rigidity with vibration dampening features, giving more protection to the machine, spindle and tool. The universal Power Collet Chuck is a unique high performance chuck that can also be used with standard collets.

- High runout accuracy: < 0.00012" (3 µm) at 3 × D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488 (formerly DIN 6499) (Attention: By using standard collet, ER length A will increase)
- 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
- Without thread for set screw
- Optional: Cool Jet bores on Power Collets
- Program of Power Collets on pages 774 – 776

INCH	ER		16	25	32
	Ø D [inch]		1.1	1.65	1.97
	Clamping range [inch]		1/8–3/8	1/8–5/8	1/8–3/4
	Clamping range [mm]		2.0–10.0	2.0–16.0	2.0–20.0
	L [inch]		1.22	1.51	1.85
Gage length A [inch]	ultra short		1.97	2.36	2.76
Order No.	E40.025...		.16.3	.25.3	.32.3
	L [inch]		1.69	2.01	2.09
Gage length A [inch]	short		3.15	3.15	3.15
Order No.	E40.020...		.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



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 759–767

### Coolant tube

Order No. 85.700.40

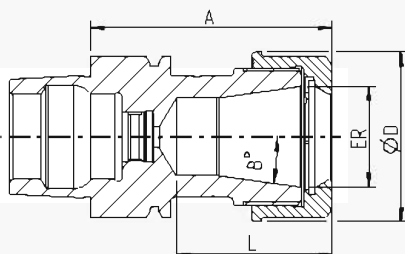


See page 793

## HIGH PRECISION COLLET CHUCK DIN 69893-5 · HSK-E40

### CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
U < 1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



The High Precision Collet Chuck is designed for the highest cutting performance 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. The chuck is especially suitable for micro and fine machining (e.g. in the medical or watchmaking industry).

- With a specially coated smooth locknut, balanced at < 1 gmm
- High runout accuracy: < 0.00012" (3 µm) 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 increase)
- 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
- Program of Power Collets on pages 774 – 776

INCH	ER		16	25	32
	Ø D [inch]		1.1	1.65	1.97
	Clamping range [inch]		1/8–3/8	1/8–5/8	1/8–3/4
	Clamping range [mm]		2.0–10.0	2.0–16.0	2.0–20.0
	L [inch]		1.22	1.51	1.85
Gage length A [inch]	ultra short		1.97	2.36	2.76
Order No.	E40.025...		.16.3.HP	.25.3.HP	.32.3.HP
	L [inch]		1.69	2.01	2.09
Gage length A [inch]	short		3.15	3.15	3.15
Order No.	E40.020...		.16.3.HP	.25.3.HP	.32.3.HP

### Accessories

#### High Precision Smooth Locknut (fine-balanced)

Size ER 16 ER 25 ER 32 See page 779

Order No. 83.914...



Roller bearing wrench

Order No. 84.650...



Collets ER



See pages 768–773

Shrink Fit Collets



See pages 759–767

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

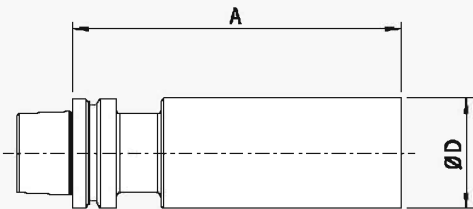
Coolant tube

Order No. 85.700.40



See page 793

BLANK ADAPTER – HARDENED  
DIN 69893-5 · HSK-E40



CERTIFICATE OF QUALITY

All functional surfaces fine machined

More accurate than DIN

**Use:**  
For manufacturing special tools in your own factory.

- Version:**
- HSK hardened and ground
  - Cylindrical part hardened to 52+2 HRC

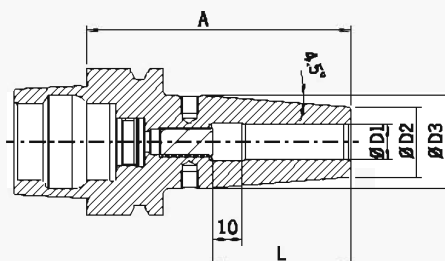
METRIC	Ø D [mm]	40.7
Gage Length A [mm]	ZG120	120
Order No.	RE40.096.0407... 	.0120



## SHRINK FIT CHUCK DIN 69893-5 · HSK-E50

### CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced  
U < 1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



### Use:

Shrink fit chuck suitable for use with all available shrink fit units.

### Optional:


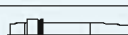
- Cooling with Cool Jet for an extra charge (See page 501)
- Cooling with Cool Flash for an extra charge (See pages 502–503)

### DIN 69893-5

- Included in delivery: Shrink fit chuck with back-up screw, without coolant tube
- Heat resistant hot-working steel
- Hardened 54-2 HRC
- For HSS and solid carbide tools
- Shank tolerance h6

INCH	Clamping Ø D1 [inch]		1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4
	Ø D2 [inch]		0.39	0.39	0.83	0.83	0.94	0.94	0.94	1.06	1.30
	Ø D3 [inch]		—	—	1.06	1.06	1.26	1.26	1.26	1.34	1.65
	L [inch]		0.35	0.59	1.42	1.42	1.65	1.65	1.85	1.97	2.05
Gage length A [inch]	short		2.36 <sup>1)</sup>	2.36 <sup>1)</sup>	3.15	3.15	3.35	3.35	3.54	3.74	3.94
Order No.	E50.140...		.1/8Z	.3/16Z	.1/4Z	.5/16Z	.3/8Z	.7/16Z	.1/2Z	.5/8Z	.3/4Z
Gage length A [inch]	ZG130		—	—	5.12	5.12	5.12	5.12	5.12	5.12	5.12
Order No.	E50.144...		—	—	.1/4Z	.5/16Z	.3/8Z	.7/16Z	.1/2Z	.5/8Z	.3/4Z

### Standard version, similar to DIN 69882-8

METRIC	Clamping Ø D1 [mm]		03	04	05	06	08	10	12	14	16
	Ø D2 [mm]		10	10	10	21	21	24	24	27	27
	Ø D3 [mm]		—	—	—	27	27	32	32	34	34
	L [mm]		09	12	15	38	38	42	47	47	50
Length A [mm]	short		60 <sup>1)</sup>	60 <sup>1)</sup>	60 <sup>1)</sup>	80	80	85	90	90	95
Order No.	E50.140...		.03	.04	.05	.08	.08	.10	.12	.14	.16
Length A [mm]	ZG130		—	—	—	130	130	130	130	130	130
Order No.	E50.144...		—	—	—	.06	.08	.10	.12	.14	.16

### Accessories

#### Shrink fit extensions



See pages 750–753

#### Set of Balancing Screws



Order No. 80.203.00

See page 784

#### Coolant tube



Order No. 85.700.50

See page 793

#### Reduction sleeves



See page 794

#### Back-up Screws



See pages 796–799

#### Cool Jet bores



Order No. 91.100.24

See page 501

#### Cool Flash Upgrade

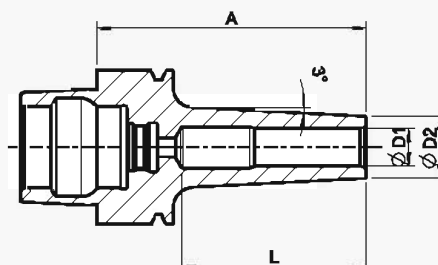


Order No. 91.100.41

See pages 502–503

1) Without back-up screw, without threads for balancing screws, with slots along the clamping bore for coolant around the tool

# MINI SHRINK DIN 69893-5 · HSK-E50



## CERTIFICATE OF QUALITY

- Chuck fine balanced  $U < 1 \text{ gmm}$
- All functional surfaces fine machined
- More accurate than DIN

- Extremely slim design
- No disturbing edges
- TIR less than  $0.00012''$  ( $3 \mu\text{m}$ )
- Also jobs difficult to access can be reached
- Ideal for the HAIMER Power Clamp
- For all solid carbide tools with shank tolerance h6
- With  $3^\circ$  angle for die and mold

- With high clamping force
- Tool holders fine balanced
- Delivery without coolant tube

**Attention:** Heating and cooling sleeves are needed when shrinking on most shrink fit machines (see accessories). However, when using the Power Clamp 14.0 Sprint/Air or Nano machines with the motorized coil and scanner, sleeves are not necessary.

INCH	Clamping $\varnothing D1$ [inch]		1/8	3/16	1/4	3/8	1/2
	$\varnothing D2$ standard [inch]		0.35	0.43	0.47	0.63	0.71
	$\varnothing D2$ extra slim [inch]		0.24	0.31	0.35	0.51	0.59
	L [inch]		1)	1)	1)	1.89	1.89
Gage length A [inch]	short		2.76	2.76	2.76	2.76	2.76
Order No.	Standard E50.180...		.1/8Z	.3/16Z	.1/4Z	.3/8Z	.1/2Z
Order No.	extra slim E50.170...		.1/8Z	.3/16Z	.1/4Z	.3/8Z	.1/2Z
Gage length A [inch]	ZG100		3.94	3.94	3.94	3.94	3.94
Order No.	Standard E50.181...		—	.3/16Z	.1/4Z	.3/8Z	.1/2Z
Order No.	extra slim E50.171...		.1/8Z	.3/16Z	.1/4Z	.3/8Z	.1/2Z

METRIC	Clamping $\varnothing D1$ [mm]		03	04	05	06	08	10	12
	$\varnothing D2$ Standard [mm]		09	10	11	12	14	16	18
	$\varnothing D2$ extra slim [mm]		06	07	08	09	11	13	15
Gage length A [mm]	short		70	70	70	70	70	70	70
Gage length L [mm]			—	—	—	—	—	48	48
Order No.	Standard E50.180...		.03	.04	.05	.06	.08	.10	.12
Order No.	extra slim E50.170...		.03	.04	.05	.06	.08	.10	.12
Gage length A [mm]	ZG80		80	80	80	80	80	80	80
Gage length L [mm]			—	—	—	—	—	48	48
Order No.	Standard E50.183...		.03	.04	.05	.06	.08	.10	.12
Order No.	extra slim E50.173...		.03	.04	.05	.06	.08	.10	.12
Gage length A [mm]	ZG100		—	—	100	100	100	100	100
Gage length L [mm]			—	—	—	—	—	48	48
Order No.	Standard E50.181...		—	—	.05	.06	.08	.10	.12
Order No.	extra slim E50.171...		—	—	.05	.08	.08	.10	.12

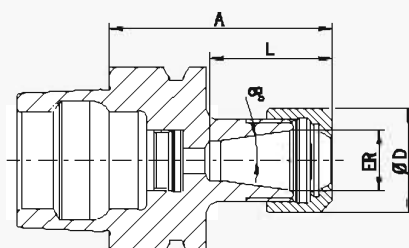
Shrinking and cooling sleeves for Mini Shrink chucks							Order No.
<b>Extra slim</b>							
Size [mm]		$\varnothing 03$	$\varnothing 04$	$\varnothing 05$	$\varnothing 06$	$\varnothing 08$	$\varnothing 10$
Size [inch]		$\varnothing 1/8$	—	$\varnothing 3/16$	$\varnothing 1/4$	$\varnothing 5/16$	$\varnothing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

1) Drilled through

# ER COLLET CHUCK DIN 69893-5 · HSK-E50

## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
U < 1 gmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN




## Use:


For clamping tools with cylindrical shank in ER collets.

- Locknut type HS (High Speed, fine balanced, with slide coating for higher clamping forces)
- Balanced collet nuts with special slide coating for low friction and higher clamping forces


INCH	ER	11	16	20	25	32
	Ø D [inch]	0.75	1.1	1.34	1.65	1.97
	Clamping range [inch]	0.02–0.28	0.02–0.39	0.04–0.51	0.04–0.63	0.04–0.79
	Clamping range [mm]	0.5–7.0	0.5–10.0	1.5–13.0	1.0–16.0	1.5–20.0
L [inch]		1.05	1.28	1.73	1.61	1.85
Gage length A [inch]	ultra short	2.36	2.36	2.76	2.76	3.15
Order No.	E50.025...	.11 <sup>1)</sup>	.16 <sup>1)</sup>	.20 <sup>1)</sup>	.25 <sup>1)</sup>	.32 <sup>1)</sup>
L [inch]		1.28	1.28	1.61	1.61	1.85
Gage length A [inch]	short	—	3.94	—	3.94	3.94
Order No.	E50.020...	—	.16	—	.25	.32


## Accessories


Collets ER  See pages 768–773


Shrink Fit Collets  See pages 758–767


## Chuck nut HS (fine-balanced)


Size  ER 16 ER 20 ER 25 ER 32  
Order No. 83.912... .16.HS .20.HS .25.HS .32.HS

Fork wrench  ER 11 ER 16 ER 20 — —

Size  ER 11 ER 16 ER 20 — —  
Order No. 84.200... .11 .16 .20


Clamping wrench  — — ER 25 ER 32

Size  — — ER 25 ER 32  
Order No. 84.200... .25 .32

Balancing index rings  ER 11 ER 16 ER 20 ER 25 ER 32


Size  ER 11 ER 16 ER 20 ER 25 ER 32  
Order No. 79.350... .19 .22 .34 .32 .40

Adjusting screw  ER 16 — ER 25 ER 32

Size  ER 16 — ER 25 ER 32  
Order No. 85.800... .34 .34 .35

Coolant tube  See page 793

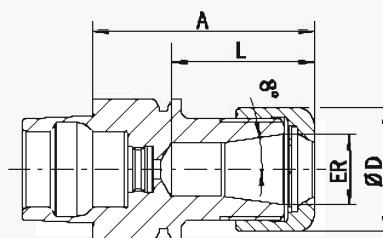
Order No. 85.700.50

Shrink fit extensions  See pages 751–753

1) Without thread for back-up screw

2) Suitable balancing index rings Order No. 79.350.28

# POWER COLLET CHUCK DIN 69893-5 · HSK-E50



## CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced  
U < 1 gmm
- ☒ All functional surfaces fine machined
- ☒ More accurate than DIN

The Power Collet Chuck is designed for the highest cutting performance in High Speed machining. The optimized design with improved construction combines high rigidity with vibration dampening features, giving more protection to the machine, spindle and tool. The universal Power Collet Chuck is a unique high performance chuck that can also be used with standard collets.

- High runout accuracy: < 0.00012" (3 µm) at 3 × D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488 (formerly DIN 6499) (Attention: By using standard collet, ER length A will increase)
- 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
- Without thread for set screw
- Optional: Cool Jet bores on Power Collets
- Program of Power Collets on pages 774 – 776

INCH	ER	16	25	32
	Ø D [Inch]	1.1	1.65	1.97
	Clamping range [Inch]	1/8–3/8	1/8–5/8	1/8–3/4
	Clamping range [mm]	2.0–10.0	2.0–16.0	2.0–20.0
	L [Inch]	1.26	1.53	1.89
Gage length A [Inch]	ultra short	2.36	2.56	2.95
Order No.	E50.025...	.16.3	.25.3	.32.3

## Accessories

### Locknut (fine-balanced)

Size		ER 16	ER 25	ER 32	See page 779
Order No.	83.914...	.16	.25	.32	

### Power Collet clamping wrench

					See page 781
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### Torque Master torque wrench

Order No.	84.600.00				See page 780
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### Power Collets

					See page 775
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### Power Collets with Safe-Lock

					See page 776
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### Cool Jet bores for Power Collets

Order No.	91.100.27				See page 777
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### Shrink Fit Collets

					See pages 759–767
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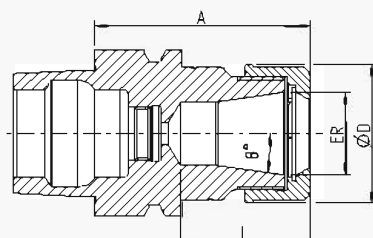
### Coolant tube

Order No.	85.700.50				See page 793
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# HIGH PRECISION COLLET CHUCK DIN 69893-5 · HSK-E50

## CERTIFICATE OF QUALITY

- ✓ Chuck body fine balanced  
U < 1 grmm
- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



The High Precision Collet Chuck is designed for the highest cutting performance 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. The chuck is especially suitable for micro and fine machining (e.g. in the medical or watchmaking industry).

- With a specially coated smooth locknut, balanced at < 1 grmm
- High runout accuracy: < 0.00012" (3 µm) at 3 × D with HAIMER Power Collets
- Also for standard collets ER according to ISO 15488 (formerly DIN 6499)  
(Attention: By using standard collet, ER length A will increase)
- 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
- Program of Power Collets on pages 774 – 776

INCH	ER	16	25	32
	Ø D [inch]	1.1	1.65	1.97
	Clamping range [inch]	1/8–3/8	1/8–5/8	1/8–3/4
	Clamping range [mm]	2.0–10.0	2.0–16.0	2.0–20.0
	L [inch]	1.26	1.53	1.89
Gage length A [inch]	ultra short	2.36	2.56	2.95
Order No.	E50.025...	.16.3.HP	.25.3.HP	.32.3.HP

## Accessories

### High Precision Smooth Locknut (fine-balanced)

Size ER 16 ER 25 ER 32 See page 779

Order No. 83.914...



ER 16

ER 25

ER 32

Roller bearing wrench

Order No. 84.650...



.16.1

.25.1

.32.1

See page 782

Collets ER



See pages 768–773

Shrink Fit Collets



See pages 759–767

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

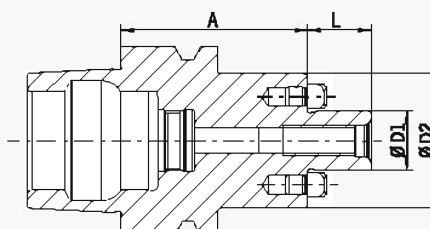
Coolant tube

Order No. 85.700.50



See page 793

# FACE MILL ARBOR DIN 69893-5 · HSK-E50



## CERTIFICATE OF QUALITY

- ☒ Chuck body fine balanced  
G2.5 25,000 1/min  
or U < 1 gmm
- ☒ All functional surfaces fine machined
- ☒ More accurate than DIN

### 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).

### DIN 69882-3

- Included in delivery: tightening bolt, without coolant tube
- With coolant exit bores on the end face for milling cutters with central cooling

METRIC	Clamping Ø D1 [mm]		16	22	27	32
	Ø D2 [mm]		36	48	60	78
	L [mm]		17	19	21	24
Length A [mm]	short		50	60	60	60
Order No.	E50.050...		.16.KKB	.22.KKB	.27.KKB	.32.KKB
Length A [mm]	long		100	100	100	100
Order No.	E50.051...		.16.KKB	.22.KKB	.27.KKB	.32.KKB
Length A [mm]	oversize		—	160	—	—
Order No.	E50.052...		—	.22.KKB	—	—

### Accessories

#### Tightening bolt

Size D1

Order No.

85.300...



16

.16

22

.22

27

.27

32

.32

#### Wrench

Size D1

Order No.

84.400...



16

.16

22

.22

27

.27

32

.32

#### Balancing index rings

Size D1

Order No.

79.350...



16

.36

22

.48

27

.80

32

.78

#### Coolant tube

Order No.

85.700.50



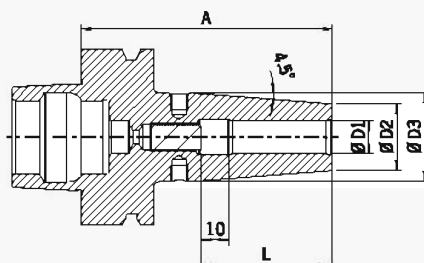
See page 793



## SHRINK FIT CHUCK DIN 69893-6 · HSK-F63

### CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced  
G2.5 25,000 rpm  
or U<1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



### Use:

Shrink fit chuck suitable for use with all available shrink fit units.

- 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
- Cool Jet option available upon request (See page 501)

INCH	Clamping Ø D1 [inch]		1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
	Ø D2 [inch]		0.39	0.39	0.83	0.83	0.94	0.94	1.06	1.3	1.73
	Ø D3 [inch]		–	–	1.06	1.06	1.26	1.26	1.34	1.65	2.09
	L [inch]		0.35	0.59	1.42	1.42	1.65	1.85	1.97	2.05	2.28
Gage length A [inch]	short		3.15 <sup>1)</sup>	3.15 <sup>1)</sup>	3.15	3.15	3.35	3.54	3.74	3.94	4.53
Order No.	F63.140...		.1/8Z	.3/16Z	.1/4Z	.5/16Z	.3/8Z	.1/2Z	.5/8Z	.3/4Z	.12
Gage length A [inch]	ZG130		–	–	5.12	5.12	5.12	5.12	–	5.12	–
Order No.	F63.144...		–	–	.1/4Z	.5/16Z	.3/8Z	.1/2Z	–	.3/4Z	–

### Standard version, similar to DIN 69882-8

METRIC	Clamping Ø D1 [mm]		03	04	05	06	08	10	12	16	20	25
	Ø D2 [mm]		10	10	10	21	21	24	24	27	33	44
	Ø D3 [mm]		–	–	–	27	27	32	32	34	42	53
	L [mm]		09	12	15	36	36	42	47	50	52	58
Length A [mm]	short		80 <sup>1)</sup>	80 <sup>1)</sup>	80 <sup>1)</sup>	80	80	85	90	95	100	115
Order No.	F63.140...		.03	.04	.05	.06	.08	.10	.12	.16	.20	.25
Length A [mm]	ZG120		120 <sup>2)</sup>	120 <sup>2)</sup>	120 <sup>2)</sup>	120	120	120	120	120	120	120
Order No.	F63.147...		.03.1	.04.1	.05.1	.06	.08	.10	.12	.16	.20	.25
Length A [mm]	ZG130		–	–	–	130	130	130	130	130	130	130
Order No.	F63.144...		–	–	–	.06	.08	.10	.12	.16	.20	.25

### Accessories

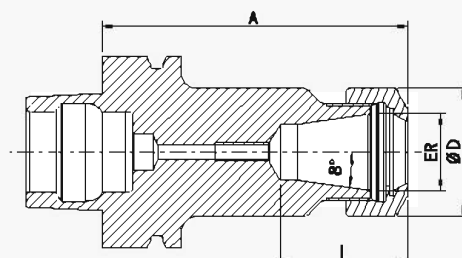
Shrink fit extensions See pages 750–753

Balancing screws See page 784

Back-up screws See pages 796–799

1) Without back-up screw, without threads for balancing screws, with slots along the clamping bore for coolant around the tool  
2) Without slots along the clamping bore

# ER COLLET CHUCK DIN 69893-6 · HSK-F63



## CERTIFICATE OF QUALITY

- Chuck body fine balanced G2.5 25,000 rpm
- All functional surfaces fine machined
- More accurate than DIN

### Use:

For clamping tools with cylindrical shank in ER collets according to ISO 15488.

### DIN 69882-6

- 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

INCH	ER		11	16	20	25	32	40
	ØD [inch]		0.75	1.1	1.34	1.65	1.97	2.48
	Clamping range [inch]		0.02-0.28	0.02-0.39	0.06-0.51	0.04-0.63	0.06-0.79	0.10-1.02
	Clamping range [mm]		0.5-7.0	0.5-10.0	1.5-13.0	1.0-16.0	1.5-20.0	2.5-26.0
L [inch]			1.93	1.93	1.93	1.89	1.98	2.09
Gage length A [inch]	ultra short		2.95	2.95	2.95	2.95	2.95	2.95
Order No.	F63.025...		.11	.16	.20	.25	.32	.40
L [inch]			0.91	1.28	1.51	1.61	1.85	.09
Gage length A [inch]	short		3.94	3.94	3.94	3.94	3.94	4.72
Order No.	F63.020...		.11	.16	.20	.25	.32	.40

### Accessories

#### Collets ER



See pages 768–773

#### Shrink Fit Collets



See pages 758–767

#### Locknut (pre-balanced)

Size		ER 11	ER 16	ER 20	ER 25	ER 32	ER 40
Order No.	83.912...	.11	.16	.20	.25	.32	.40

#### Chuck nut HS (fine-balanced)

Size		—	ER 16	ER 20	ER 25	ER 32	ER 40
Order No.	83.912...	—	.16.HS	.20.HS	.25.HS	.32.HS	.40.HS

#### Balancing Index rings

Size	short/oversize	ER 11	ER 16	ER 20	ER 25	ER 32	ER 40
Order No.	79.350...	.19	.28	.34	.42	.48	.50

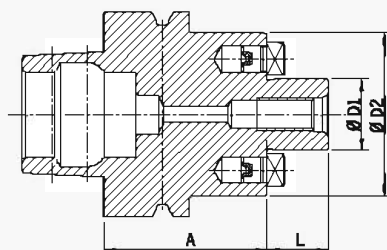
#### Adjusting screw

Size		—	ER 16	ER 20	ER 25	ER 32	ER 40
Order No.	85.800...	—	.34	.34	.34	.35	.35

## FACE MILL ARBOR DIN 69893 · HSK-F63

### CERTIFICATE OF QUALITY

- ☑ Chuck body fine balanced  
G2.5 25,000 rpm  
or U<1 gmm
- ☑ All functional surfaces fine machined
- ☑ More accurate than DIN



### Use:

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

With coolant exit bores on the end face for milling cutters with central cooling. Special modification available: Mounting thread for coolant tube for an extra charge.

### DIN 69892

– Included in delivery: tightening bolt, without coolant tube

METRIC	Clamping Ø D1 [mm]	22	27
	Ø D2 [mm]	48	60
	L [mm]	19	21
Gage length A [mm]	short	50	60
Order No.	F63.050...	22.KKB	27.KKB



### Accessories

#### Tightening bolt

Size D1			22	27
Order No.	85.300...		22	27

Wrench See page 781

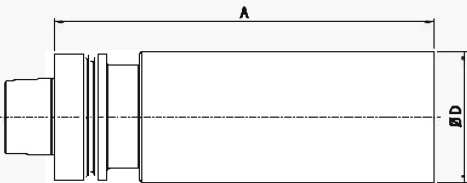
Size D1			22	27
Order No.	84.400...		22	27

Balancing index rings See page 785

Size D1			22	27
Order No.	79.350...		48	60

Thread for coolant tube 91.100.18

BLANK ADAPTER – HARDENED  
DIN 69893-6 · HSK-F63



CERTIFICATE OF QUALITY

☒ All functional surfaces fine machined

☒ More accurate than DIN

**Use:**  
For manufacturing special tools in your own factory.

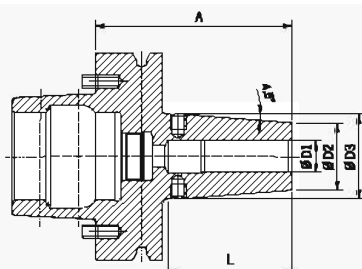
**Version:**  
 – HSK hardened and ground  
 – Cylindrical part hardened to 52+2 HRC

METRIC	Ø D [mm]	65
Gage Length A [mm]	ZG250	189
Order No.	RF63.096.0650... 	.0189

## SHRINK FIT CHUCK SIMILAR DIN 69893-6 - HSK-F80 MAKINO INCH

### CERTIFICATE OF QUALITY

- ☑ Chuck fine balanced  
G2.5 33,000 rpm or U < 1 gmm
- ☑ Balanceable via screws M6
- ☑ All functional surfaces fine machined
- ☑ With thread for coolant tube



The HAIMER HSK-F80 Makino shrink fit chucks provide the highest machining capacity in High Speed machining. The optimized design combines high rigidity with vibration dampening, which protects machine, spindle and tool.

- All pre-balanced to G2.5 @ 33,000 rpm or U < 1 gmm
- All standard balanceable via set screws
- Short gage length per machine builders recommendation
- Dampen vibrations, high clamping force
- Equally suited to High Speed machining and heavy milling
- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle times
- Quieter running, therefore better surface quality and protection of cutting tools, machine spindles and machines
- Higher machining accuracy
- Heat resistant hot-working steel
- Hardened 54-2 HRC
- For HSS and solid carbide tools
- Shank tolerance h6
- With thread for coolant tube
- 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

INCH	Clamping Ø D1 [inch]	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	1 1/4
	Ø D2 [inch]	0.826	0.826	1.003	1.023	1.023	1.141	1.397	1.83	1.772
	Ø D3 [inch]	1.063	1.063	1.220	1.260	1.300	1.417	1.614	2.047	2.087
	L [inch]	1.417	1.417	1.693	1.693	1.890	2.008	2.008	1.930	2.560
Gage length A [inch]	ultra short	3	3	3	3	3	3	3	3	3.5
Order No.	F80ML145...	.1/4z <sup>1)</sup>	.5/16z <sup>1)</sup>	.3/8z	.7/16z	.1/2z	.5/8z	.3/4z	.1z	.11/4z

### Extra ultra short version

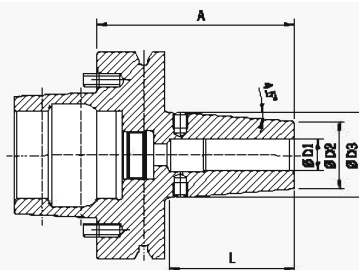
INCH	Clamping Ø D1 [inch]	3/4	1
	Ø D2 [inch]	1.398	1.811
	Ø D3 [inch]	—	—
	L [inch]	1.713	1.850
Gage length A [inch]	extra ultra short	2.75	2.75
Order No.	F80ML145...	.3/4z 5.1	.1z 5.1
Suitable Cooling adapter	80.105...	.16.0045	.18.0011

### Accessories

Shrink fit extensions		See page 750
Coolant tube	Order No. 85.700.63	See page 793
Reduction sleeves		See page 794
Back-up screws		See pages 796-799
Set of balancing screws	Order No. 80.203.00	See page 784
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

1) With back-up screw

# SHRINK FIT CHUCK SIMILAR DIN 69893-6 - HSK-F80 MAKINO METRIC



## CERTIFICATE OF QUALITY

- ☒ Chuck fine balanced  
G2.5 33,000 rpm or U< 1gmm
- ☒ Balanceable via screws M6
- ☒ All functional surfaces fine machined
- ☒ With thread for coolant tube

The HAIMER HSK-F80 Makino shrink fit chucks provide the highest machining capacity in High Speed machining. The optimized design combines high rigidity with vibration dampening, which protects machine, spindle and tool.

- All pre-balanced to G2.5@33,000 RPM or U < 1gmm
- All standard balanceable via set screws
- Short gage length per machine builders recommendation
- Dampen vibrations, high clamping force
- Equally suited to High Speed machining and heavy milling
- Highest cutting performance with higher spindle speeds, higher feeds and larger cutting depths
- Shorter cycle times
- Quieter running, therefore better surface quality and protection of cutting tools, machine spindles and machines
- Higher machining accuracy

## Use:

Shrink fit chuck suitable for use with all available shrink fit units.

- Heat resistant hot-working steel
- Hardened 54-2 HRC
- For HSS and solid carbide tools
- Shank tolerance h6
- With thread for coolant tube
- Safe-Lock pull-out protection for an extra charge
- 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

METRIC	Clamping Ø D1 [mm]	6	8	10	12	14	16	20	25
	Ø D2 [mm]	21	21	26	26	29	29	35.5	46.5
	Ø D3 [mm]	27	27	32	33	36	36	41	52
	L [mm]	36	36	43	48	48	51	50.5	49
Length A [mm]	ultra short	76.2	76.2	76.2	76.2	76.2	76.2	76.2	76.2
Order No.	F80M.145...	.06 <sup>1)</sup>	.08 <sup>1)</sup>	.10	.12	.14	.16	.20	.25

## Extra ultra short version

METRIC	Clamping Ø D1 [mm]	6	8	10	12	16	20	25
	Ø D2 [mm]	22	22	26.5	26.5	29.5	35.5	46
	Ø D3 [mm]	—	—	—	—	—	—	—
	L [mm]	38	38	43	38	44.5	43.5	47
Length A [mm]	extra ultra short	70	70	70	70	70	70	70
Order No.	F80M.145...	06.5	08.5	10.5	12.5	16.5	20.5	25.5
Suitable Cooling adapter	80.105...	—	—	—	—	—	.18.0045	.18.0011

## Accessories

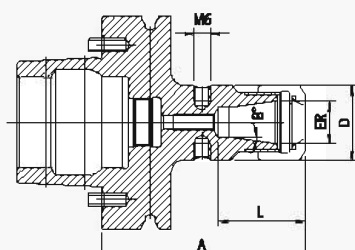
Shrink fit extensions		See pages 751-753
Coolant tube	Order No. 85.700.63	See page 793
Reduction sleeves		See page 794
Back-up screws		See pages 796-799
Set of balancing screws	Order No. 80.203.00	See page 784
Cool Flash		Order No. 91.100.40
Cool Flash Upgrade Incl. Cool Jet		Order No. 91.100.41



## ER COLLET CHUCK SIMILAR DIN 69893-6 - HSK-F80 MAKINO

### CERTIFICATE OF QUALITY

- ☑ Chuck fine balanced  
G2.5 33,000 rpm or U < 1gmm
- ☑ Balanceable via screws M6
- ☑ All functional surfaces fine machined
- ☑ With thread for coolant tube



The HAIMER HSK-F80 Makino ER collet chucks provide a universal clamping solution for High Speed machining. The optimized design combines a highly accurate universal clamping system for cutting tools.

- All pre-balanced to G2.5 @ 33,000 RPM or U < 1 gmm
- All standard balanceable via screws
- Short gage length per machine builders recommendation
- Balanced nuts with special slide coating for low friction and high clamping forces
- Great for drilling
- Good clamping force
- Higher machining accuracy

### Use:

For clamping tools with cylindrical shank in collets according to ISO 15488.

- 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) available for an extra charge
- With threaded holes in order to balance with balancing screws

INCH	ER	11	16	20	25	32	40
Ø D [inch]		1.062	1.102	1.574	1.653	1.968	2.483
Clamping range [inch]		0.02–0.276	0.02–0.394	0.059–0.512	0.039–0.63	0.02–0.787	0.098–1.024
Clamping range [mm]		0.5–7.0	0.5–10.0	1.5–13.0	1.0–16.0	1.5–20.0	2.5–26.0
L [inch]		1.043	1.279	1.515	1.889	1.850	2.086
Gage length A [inch]	ultra short	3	3	3	3	3	3
Order No.	F80M.025...	.11	.16	.20	.25	.32	.40

### Accessories

#### Collets ER



See pages 768–773

#### Shrink Fit Collets



See pages 758–767

#### Locknut (pre-balanced)

##### Size

Order No. 83.912...



ER11

ER16

ER20

ER25

ER32

ER40

#### Chuck nut HS (fine-balanced)

##### Size

Order No. 83.912...



ER11

ER16

ER20

ER25

ER32

ER40

#### Set of balancing screws



Order No. 80.203.00

See page 784

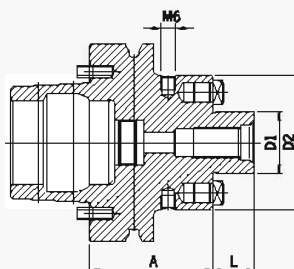
#### Coolant tube



Order No. 85.700.63

See page 793

# FACE MILL ARBOR SIMILAR DIN 69893-6 - HSK-F80 MAKINO



## CERTIFICATE OF QUALITY

- ☒ Chuck fine balanced G2.5 33,000 rpm
- ☒ Balanceable via screws M6
- ☒ Integrated thread for coolant tube

The HAIMER HSK-F80 Makino Face mill arbors provide a solid base for face mill cutters for High Speed machining. The optimized design combines a highly accurate universal clamping system for cutting tools.

## Use:

For holding face mill cutters and milling cutters with radial driving slot DIN 1880.

- All pre-balanced to G2.5@33,000 RPM
- All standard as a balanceable for fine tune balancing capability
- Short gage length per machine builders recommendation
- Higher machining accuracy due to proper construction

- Included in delivery: Tightening bolt, without coolant tube
- Coolant bores on front side available for an extra charge
- With threaded holes in order to balance with balancing screws

INCH	Clamping Ø D1 [inch]		3/4	1
	Ø D2 [inch]		1.710	2.165
	L [inch]		0.689	0.689
Gage length A [inch]	ultra short		1.968	1.968
Order No.	F80ML050...		.3/4z	.1z
Gage length A [inch]	short		3.937	3.937
Order No.	F80ML051...		.3/4z	.1z

## Accessories

### Tightening bolt

Ø D1 [inch]

Order No.

85.300...



3/4

.3/4z

1

.1z

### Coolant bores



Order No. 91.100.03

### Set of Balancing Screws



Order No. 80.203.00

See page 784

### Coolant tube



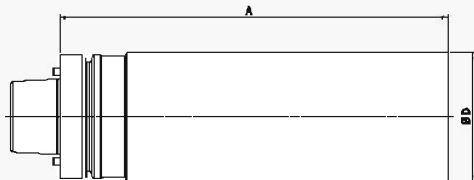
Order No. 85.700.83

See page 793

BLANK ADAPTER – HARDENED  
SIMILAR DIN 69893-6 - HSK-F80 MAKINO

CERTIFICATE OF QUALITY

- ✓ All functional surfaces fine machined
- ✓ More accurate than DIN



Use:

For manufacturing special tools in your own factory.

Version:

- HSK hardened and ground
- Cylindrical part hardened to 52+2 HRC

METRIC	Ø D [mm]	82
Gage Length A [mm]	ZG250	250
Order No.	RF80M.096.0820...	.0250

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FOR YOUR NOTES