



# Hydrochucks



## HYDROCHUCKS

### Information

#### Quick facts about SPV Spintec's hydrochucks

- High clamping force, 320 Nm at a Ø20 mm shank in a standard hydrochuck.
- Runout accuracy better than 0,003 mm (see below).
- Quick assembly method of the tool. No special equipment is needed.
- Standard balanced for 10 000 RPM (G6,3). Can be supplied fine balanced to 30 000 RPM (G2,5)
- The widest range of hydrochucks on the market. Available for all applications.
- If our standard assortment doesn't cover your needs, we can design custom chucks just for you.

#### Benefits of using SPV Spintec's hydrochucks

- Up to 50% longer tool lifetime compared to conventional tool holder systems.
- Increased surface finish, thanks to the solid fastening of the tool shaft.
- Permits machining with much closer tolerances.
- Quicker and simpler tool changes.

#### Runout accuracy

All of our different models of hydrochucks are made with a runout accuracy better than 0,003 mm. This allows for precision machining with closer tolerances. It also extends the tool lifetime



#### Our different types of hydrochucks



**HCF / HCF+**  
Short standard chuck



**HCFL / HCFL+**  
Standard chuck with extended length



**HCP+**  
Pen-chuck in two different lengths



**HCPK+**  
Long tapered chuck



**HCK+**  
Extra short and powerful chuck

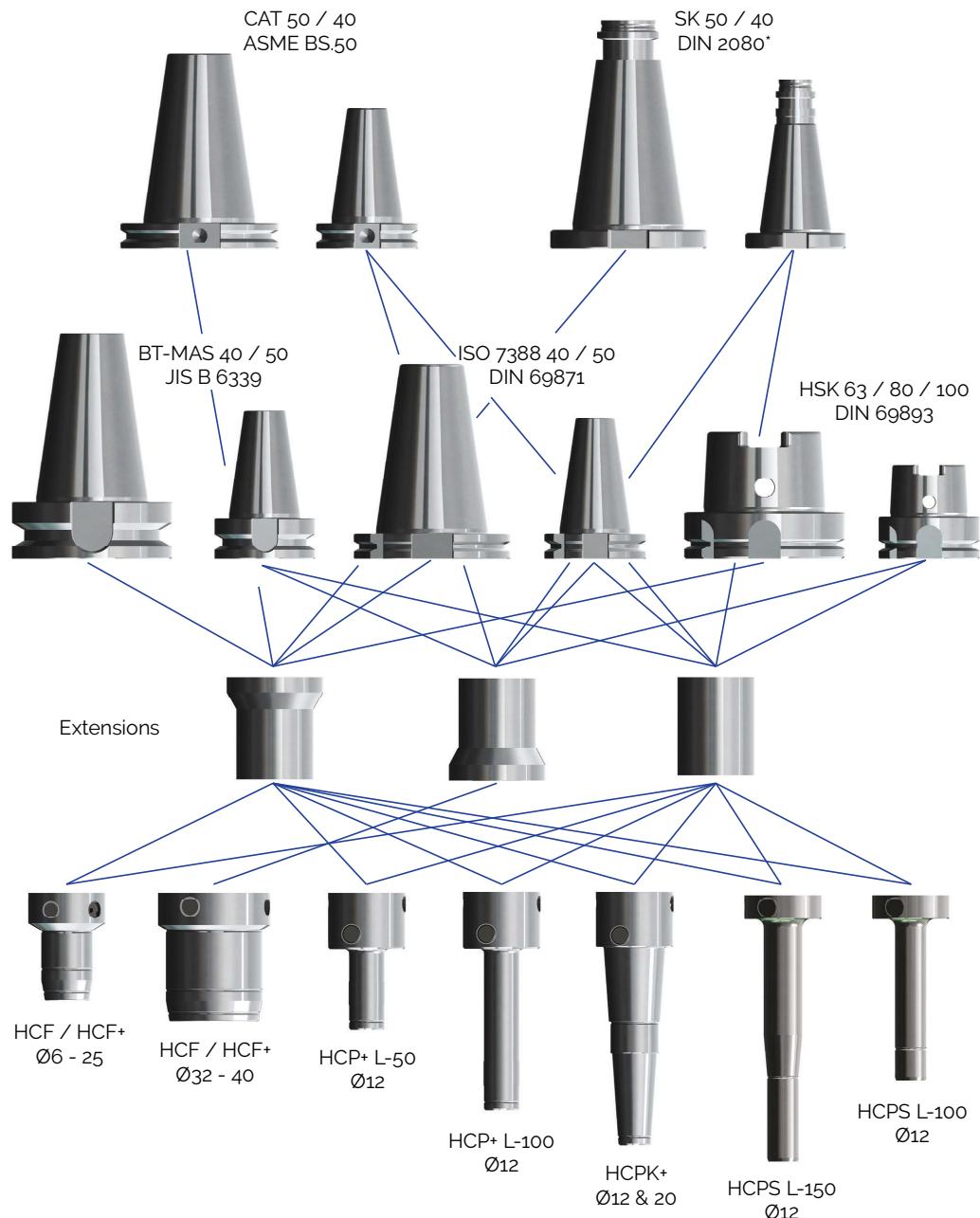


**HCPS**  
Extra long and narrow pen-chuck

## HYDROCHUCKS

System overview

### Optional combinations for SPV Spintec hydrochucks



\* Hydrochucks with DIN 2080 available on request.  
Please contact us for more information.

## HYDROCHUCKS

The Plus-membrane

### Facts about SPV Spintec's developed milling-membrane - The Plus-membrane [+]

SPV Spintec's hexagonal milling membrane (+membrane) permits though, vibration free milling. A highly stable tool anchorage makes it possible to machine at greater feed rates and with greater axial and radial depths of cut than normally recommended.

#### Limitations of conventional hydrochucks

The limitation in machining with hydraulic chucks has frequently been the use of recommended cutting data for heavy duty milling.

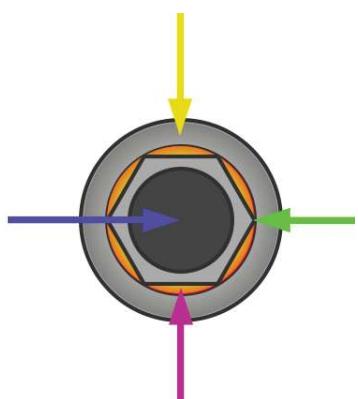
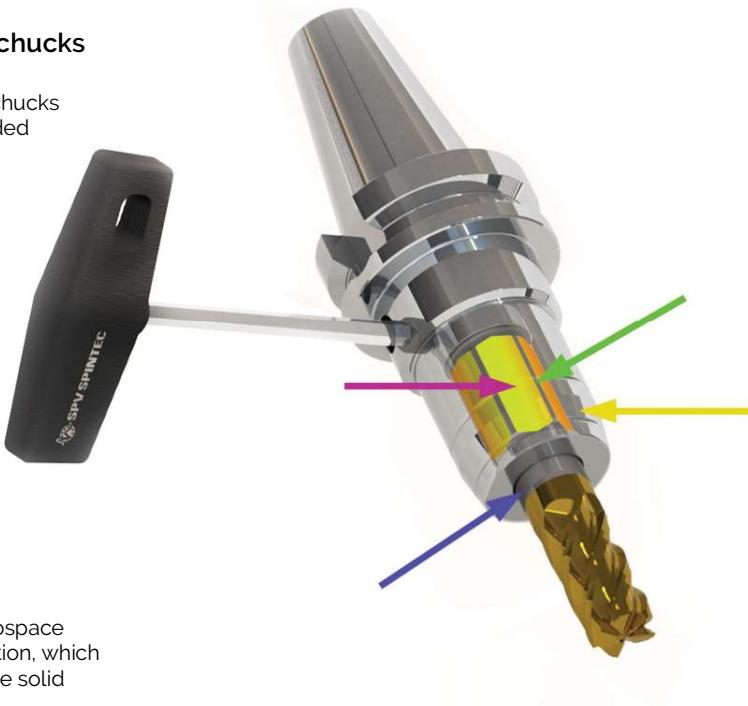
Customers have often been obliged to purchase specially shortened hydraulic milling-chucks with increased torque when they have needed to remove a large amount of material in the shortest possible time.

We have eliminated this limitation and offer our customers the opportunity of using our developed hydraulic milling-membrane for both milling and other operations, resulting in a better overall economy.

#### History of development

The development started when British Aerospace in England had problems with milling vibration, which lead to very short lifetime for their expensive solid carbide cutting tools.

British Aerospace tried several commercially available retention systems but didn't find a satisfactory solution. At that time SPV developed the hydrochucks with the hexagonal membrane which was found in tests at BA to multiply the period of contact several times over. In some cases it even enabled them to double both radial and axial cutting depths.



#### Yellow arrow

Outer body of the hydrochuck.

#### Blue arrow

The cutting tool shaft (drill, cutter etc.)

#### Purple arrow

The hydraulic chamber which combined with high hydraulic pressure provides a stable anchorage. The long, linear, thin wall gripping-surfaces protects the tool from flexing.

#### Green arrow

The remaining material between the hydraulic chambers creates reinforcement ribs, which minimize vibrations and stabilizes the membrane.

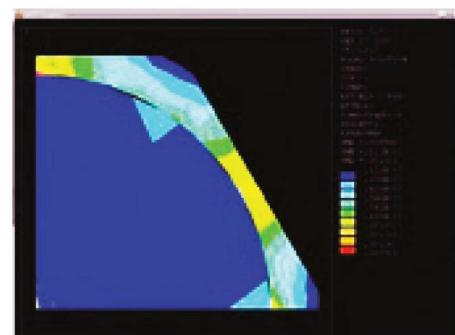
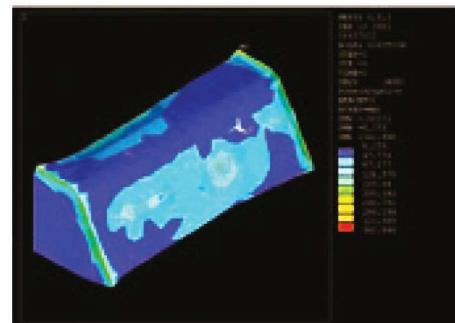
### Analysis

A calculation and simulation of loading cases using the Finite Element Method (FEM) from 3D-models was done in collaboration with the Mälardalen University College in Eskilstuna. This was to verify the results offered by the new design and to make a comparison with the traditional cylindrical membrande design in hydrochucks.

### Testing

A trial was done in the spring of 2003 at SECO tools in Fagersta, Sweden to attempt to verify any limits there might be on cutting data. An extract from the test report (P-1006, 2003-04-29 at SECO, Fagersta) shows the following.

- **Test sample:**  
Hydrochucks HCF+ with hexagonal membrane
- **Machining tools:**  
Solid 3-blade carbide metal cutters made by Jabro, with Tribon coating.  
Dimensions: Ø10 mm, Ø12 mm and Ø20 mm.
- **Work piece material:**  
Square bar, 75 x 75 mm made from heat threetable steel SS 2244-05, hardness 270 - 315 HB.



### Test summary

The results show that the hydrochucks equipped with a hexagonal membrane (The Plus-membrane) can manage up to twice the recommended cutting depth (both radial and axial) without tool chipping or vibrations that affects the surface finish. In practice, this means that the possible swarf yield has been multiplied by four.

#### HCF+ chucks

- Hydrochucks HCF+ with tools Ø10, Ø12 and Ø20 can manage the cutting data in Jabro's recommendation for coarse slab milling.
- 2 x the recommended axial cutting depth is quite OK, without any vibrations arising that could damage the cutting tool.
- 2 x the recommended radial cutting depth is quite OK.

### Specifications

**Coarse slab milling with rotational speed and feed rate to Jabro's recommendations:**

Recommended depth of cut:  
axial: 1 x tool diameter  
radial: 0,4 x tool diameter

Results in a chip area of:  
 $1 \times D \text{ mm} \times 0,4 \times D \text{ mm} = 0,4 \times D \text{ mm}^2$



**Coarse slab milling with rotational speed and feed rate to Jabro's recommendations:**

HCF+ tests with twice the recommended depth of cut,  
axial and radially.

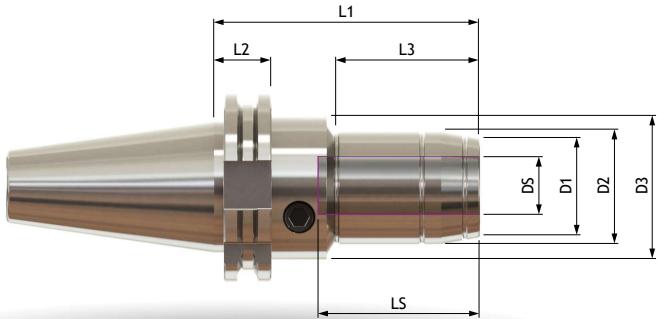
Results in a chip area of:  
 $1 \times D \text{ mm} \times 0,4 \times D \text{ mm} = 0,4 \times D \text{ mm}^2$



## HYDROCHUCKS

ISO 7388 / DIN 69871

HCF / HCF+



For chuck with Plus-membrane, specify + after art.no

D5 Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>6</b>	ISO 40	21,5	26	49,5	80,5	19,1	29,5	37,5	<b>54800</b>
	ISO 50	21,5	26	48	87	19,1	43,5	37,5	<b>56630</b>
<b>8</b>	ISO 40	23,5	28	49,5	80,5	19,1	30	37,5	<b>54801</b>
	ISO 50	23,5	28	48	87	19,1	43,5	37,5	<b>56631</b>
<b>10</b>	ISO 40	25,5	30	49,5	80,5	19,1	31	42,5	<b>54802</b>
	ISO 50	25,5	30	48	87	19,1	43,5	42,5	<b>56632</b>
<b>12</b> ▲	ISO 40	27,5	32	49,5	80,5	19,1	31,5	47,5	<b>54803</b>
	ISO 45	27,5	32	48	87	19,1	44,5	47,5	<b>56803</b>
	ISO 50	27,5	32	48	87	19,1	44,5	47,5	<b>56633</b>
<b>14</b>	ISO 40	27,5	32	49,5	80,5	19,1	31,5	47,5	<b>54804</b>
	ISO 50	29,5	32	48	87	19,1	44,5	47,5	<b>56634</b>
<b>16</b>	ISO 40	34,5	38	49,5	80,5	19,1	33	51	<b>54805</b>
	ISO 50	33,5	38	48	87	19,1	47,5	52,5	<b>56635</b>
<b>18</b>	ISO 40	38	42	49,5	80,5	19,1	34	51	<b>54806</b>
	ISO 50	35,5	40	48	87	19,1	47,5	52,5	<b>56636</b>
<b>20</b> ▲	ISO 40	38	42	49,5	80,5	19,1	34	51	<b>54807</b>
	ISO 45	37,5	42	48	87	19,1	47,5	52,5	<b>56807</b>
	ISO 50	37,5	42	48	87	19,1	47,5	52,5	<b>56637</b>
<b>25</b>	ISO 40	43,5	48	48	91	19,1	71	55	<b>56628</b>
	ISO 50	43,5	48	48	91	19,1	71	55	<b>56638</b>
<b>32</b> ▲	ISO 40	55,5	60	70	120	19,1	57	65	<b>56629</b>
	ISO 50	55,5	60	70	100	19,1	57	65	<b>56639</b>
<b>40*</b>	ISO 50	65	70	70	105	19,1	86	70	<b>56113+</b>

▲ = dimension compatible with reduction sleeve.

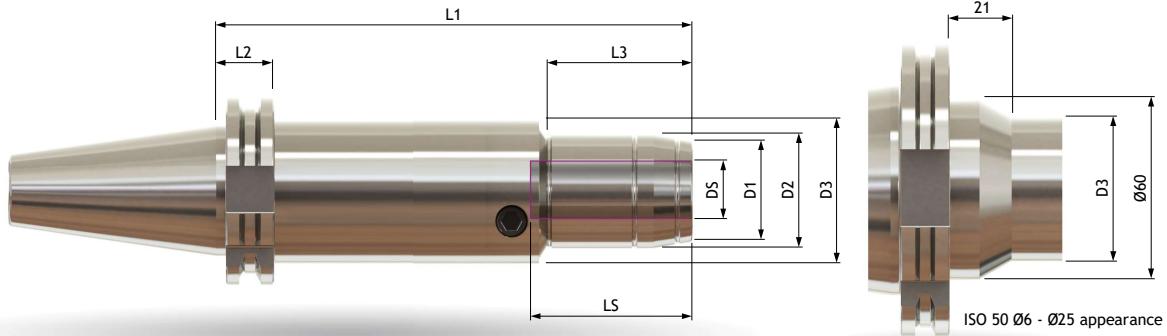
\* = Ø40 is only available with ISO-50 and Plus-membrane.

Other dimensions with ISO-45 on request.

## HYDROCHUCKS

ISO 7388 / DIN 69871

HCFL / HCFL+



For chuck with Plus-membrane, specify + after art.no

DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>6</b>	ISO 40	21,5	26	48	130	19,1	43,5	37,5	<b>56700</b>
	ISO 40	21,5	26	48	130 - 480	19,1	43,5	37,5	▲
	ISO 50	21,5	26	48	160	19,1	43,5	37,5	<b>56710</b>
	ISO 50	21,5	26	48	160 - 445	19,1	43,5	37,5	▲
<b>8</b>	ISO 40	23,5	28	48	130	19,1	43,5	37,5	<b>56701</b>
	ISO 40	23,5	28	48	130 - 480	19,1	43,5	37,5	▲
	ISO 50	23,5	28	48	160	19,1	43,5	37,5	<b>56711</b>
	ISO 50	23,5	28	48	160 - 445	19,1	43,5	37,5	▲
<b>10</b>	ISO 40	25,5	30	48	130	19,1	43,5	42,5	<b>56702</b>
	ISO 40	25,5	30	48	130 - 480	19,1	43,5	42,5	▲
	ISO 50	25,5	30	48	160	19,1	43,5	42,5	<b>56712</b>
	ISO 50	25,5	30	48	160 - 445	19,1	43,5	42,5	▲
<b>12</b> ▲	ISO 40	27,5	32	48	130	19,1	44,5	47,5	<b>56703</b>
	ISO 40	27,5	32	48	130 - 480	19,1	44,5	47,5	▲
	ISO 45	27,5	32	48	160	19,1	44,5	47,5	<b>56753</b>
	ISO 45	27,5	32	48	160 - 445	19,1	44,5	47,5	▲
	ISO 50	27,5	32	48	160	19,1	44,5	47,5	<b>56713</b>
	ISO 50	27,5	32	48	160 - 445	19,1	44,5	47,5	▲
<b>14</b>	ISO 40	29,5	34	48	130	19,1	44,5	47,5	<b>56704</b>
	ISO 40	29,5	34	48	130 - 480	19,1	44,5	47,5	▲
	ISO 50	29,5	34	48	160	19,1	44,5	47,5	<b>56714</b>
	ISO 50	29,5	34	48	160 - 445	19,1	44,5	47,5	▲
<b>16</b>	ISO 40	33,5	38	48	130	19,1	47,5	52,5	<b>56705</b>
	ISO 40	33,5	38	48	130 - 480	19,1	47,5	52,5	▲
	ISO 50	33,5	38	48	160	19,1	47,5	52,5	<b>56715</b>
	ISO 50	33,5	38	48	160 - 445	19,1	47,5	52,5	▲

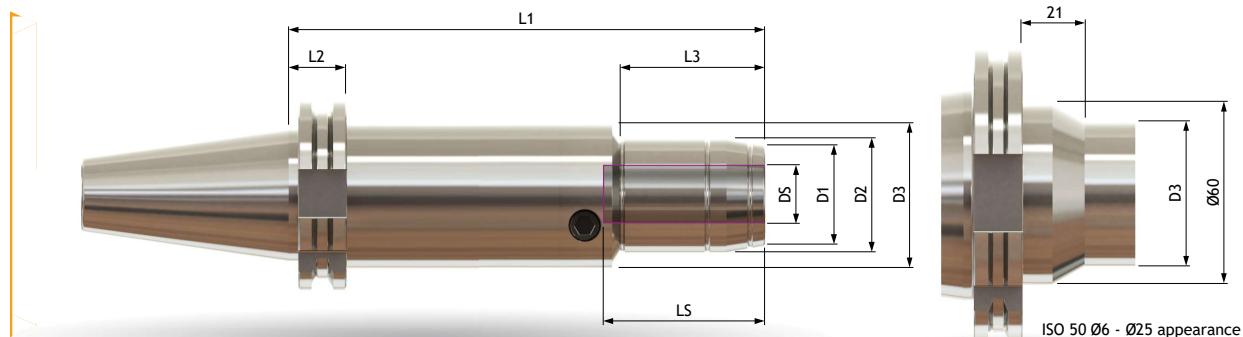
▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

## HYDROCHUCKS

ISO 7388 / DIN 69871

HCFL / HCFL+



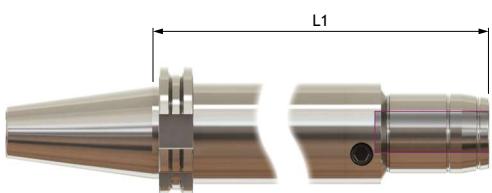
For chuck with Plus-membrane, specify + after art.no

DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>18</b>	ISO 40	35,5	40	48	130	19,1	47,5	52,5	<b>56706</b>
	ISO 40	35,5	40	48	130 - 480	19,1	47,5	52,5	▲
	ISO 50	35,5	40	48	160	19,1	47,5	52,5	<b>56716</b>
	ISO 50	35,5	40	48	160 - 445	19,1	47,5	52,5	▲
<b>20</b> ▲	ISO 40	37,5	42	48	130	19,1	47,5	52,5	<b>56707</b>
	ISO 40	37,5	42	48	130 - 480	19,1	47,5	52,5	▲
	ISO 45	37,5	42	48	160	19,1	47,5	52,5	<b>56757</b>
	ISO 45	37,5	42	48	160 - 445	19,1	47,5	52,5	▲
	ISO 50	37,5	42	48	160	19,1	47,5	52,5	<b>56717</b>
	ISO 50	37,5	42	48	160 - 445	19,1	47,5	52,5	▲
<b>25</b>	ISO 40	43,5	48	48	134	19,1	114	55	<b>56708</b>
	ISO 40	43,5	48	48	130 - 480	19,1	-----	55	▲
	ISO 50	43,5	48	48	160	19,1	123	55	<b>56718</b>
	ISO 50	43,5	48	48	160 - 445	19,1	-----	55	▲
<b>32</b> ▲	ISO 40	55,5	60	70	140	19,1	57	65	<b>56709</b>
	ISO 40	55,5	60	70	140 - 480	19,1	57	65	▲
	ISO 50	55,5	60	70	140	19,1	57	65	<b>56719</b>
	ISO 50	55,5	60	70	140 - 445	19,1	57	65	▲

▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

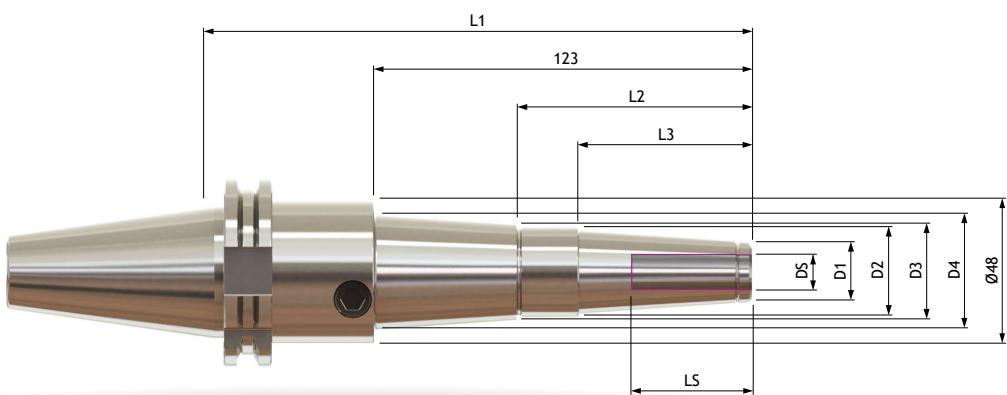
Choose your own length (L1) of HCFL / HCFL+. Specify Art.no / L1 on order.



## HYDROCHUCKS

ISO 7388 / DIN 69871

HCPK+

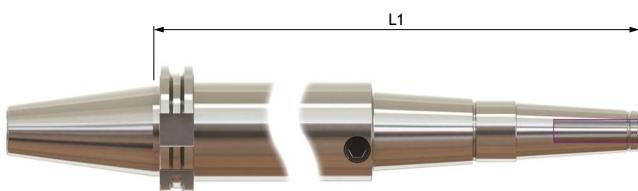


DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	D4 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
12 ▲	ISO 40	20	30	32	40,5	177	76,8	57	44	59183+
	ISO 40	20	30	32	40,5	217 - 480	76,8	57	44	▲
	ISO 50	20	30	32	40,5	177	76,8	57	44	59193+
	ISO 50	20	30	32	40,5	217 - 445	76,8	57	44	▲
20 ▲	ISO 40	32	39	42	50,5	177	74,8	55	52	59187+
	ISO 40	32	39	42	50,5	217 - 480	74,8	55	52	▲
	ISO 50	32	39	42	50,5	177	74,8	55	52	59197+
	ISO 50	32	39	42	50,5	214 - 445	74,8	55	52	▲

▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

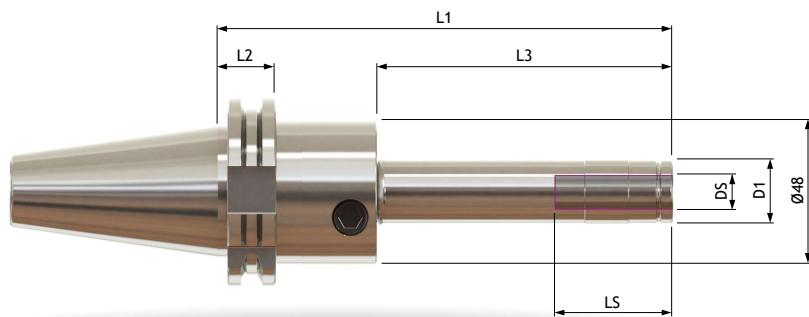
Choose your own length (L1) of HCPK+. Specify Art.no / L1 on order.



## HYDROCHUCKS

ISO 7388 / DIN 69871

HCP+



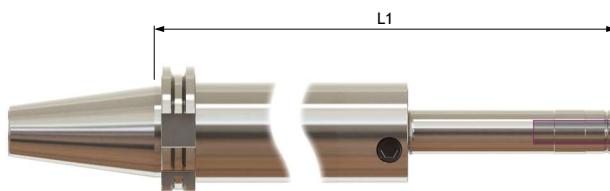
Short model



DS Ømm	Mount type.	D1 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>12</b> ▲	ISO 40	22,5	105	19,1	50	44	<b>59003+</b>
	ISO 40	22,5	155	19,1	100	44	<b>59013+</b>
	ISO 50	22,5	105	19,1	50	44	<b>59053+</b>
	ISO 50	22,5	155	19,1	100	44	<b>59063+</b>

▲ = dimension compatible with reduction sleeve.

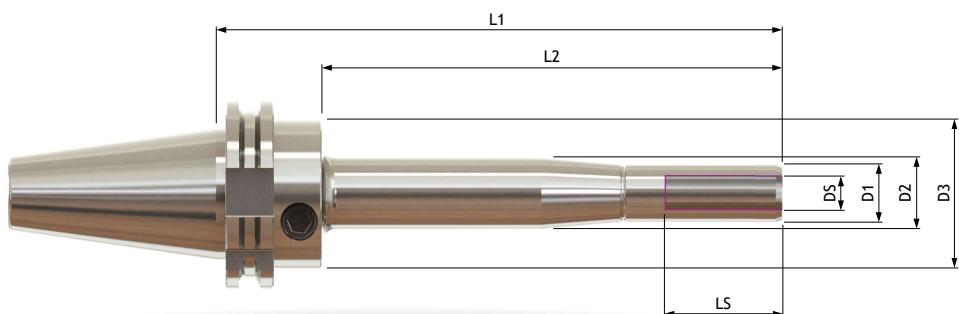
Choose your own length (L1) of HCP+. Specify Art.no / L1 on order.



## HYDROCHUCKS

ISO 7388 / DIN 69871

### HCPS



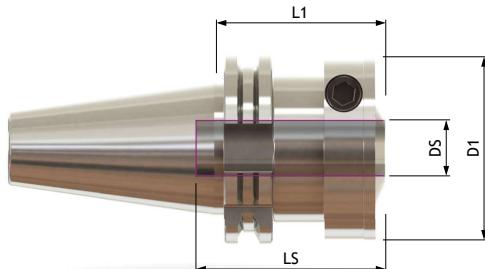
Short model



DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>12</b> ▲	ISO 40	19,5	----	48	135	100	----	42	<b>59623</b>
	ISO 50	19,5	----	48	135	100	----	42	<b>59633</b>
	ISO 40	19,5	24	48	185	150	52	42	<b>59723</b>
	ISO 50	19,5	24	48	185	150	52	42	<b>59733</b>

▲ = dimension compatible with reduction sleeve.

### HCK+



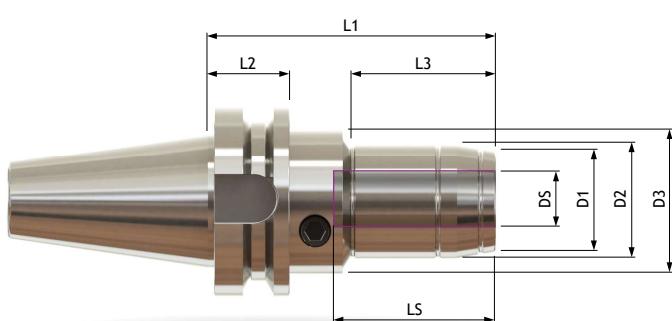
HCK+ has an extended membrane which provides 600 Nm compared to 320 Nm on a standard Ø20 mm chuck.

DS Ømm	Mount type.	D1 Ømm	L1 mm	LS mm	Art.no
<b>20</b>	ISO 40	61	56	70	<b>66122+</b>

## HYDROCHUCKS

BT-MAS

HCF / HCF+



For chuck with Plus-membrane, specify + after art.no

DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>6</b>	BT 40	21,5	26	48	95	27	43,5	37,5	<b>56640</b>
	BT 50	21,5	26	48	106	38	43,5	37,5	<b>56650</b>
<b>8</b>	BT 40	23,5	28	48	95	27	43,5	37,5	<b>56641</b>
	BT 50	23,5	28	48	106	38	43,5	37,5	<b>56651</b>
<b>10</b>	BT 40	25,5	30	48	95	27	43,5	42,5	<b>56642</b>
	BT 50	25,5	30	48	106	38	43,5	42,5	<b>56652</b>
<b>12</b> ▲	BT 40	27,5	32	48	95	27	44,5	47,5	<b>56643</b>
	BT 50	27,5	32	48	106	38	44,5	47,5	<b>56653</b>
<b>14</b>	BT 40	29,5	34	48	95	27	44,5	47,5	<b>56644</b>
	BT 50	29,5	34	48	106	38	44,5	47,5	<b>56654</b>
<b>16</b>	BT 40	33,5	38	48	95	27	47,5	52,5	<b>56645</b>
	BT 50	33,5	38	48	106	38	47,5	52,5	<b>56655</b>
<b>18</b>	BT 40	35,5	40	48	95	27	47,5	52,5	<b>56646</b>
	BT 50	35,5	40	48	106	38	47,5	52,5	<b>56656</b>
<b>20</b> ▲	BT 40	37,5	42	48	95	27	47,5	52,5	<b>56647</b>
	BT 50	37,5	42	48	106	38	47,5	52,5	<b>56657</b>
<b>25</b>	BT 40	43,5	48	48	99	27	72	55	<b>56648</b>
	BT 50	43,5	48	48	110	38	72	55	<b>56658</b>
<b>32</b> ▲	BT 40	55,5	60	70	108	27	57	65	<b>56649</b>
	BT 50	55,5	60	70	119	38	57	65	<b>56659</b>
<b>40</b> *	BT 50	65	70	70	124	38	85	70	<b>56114+</b>

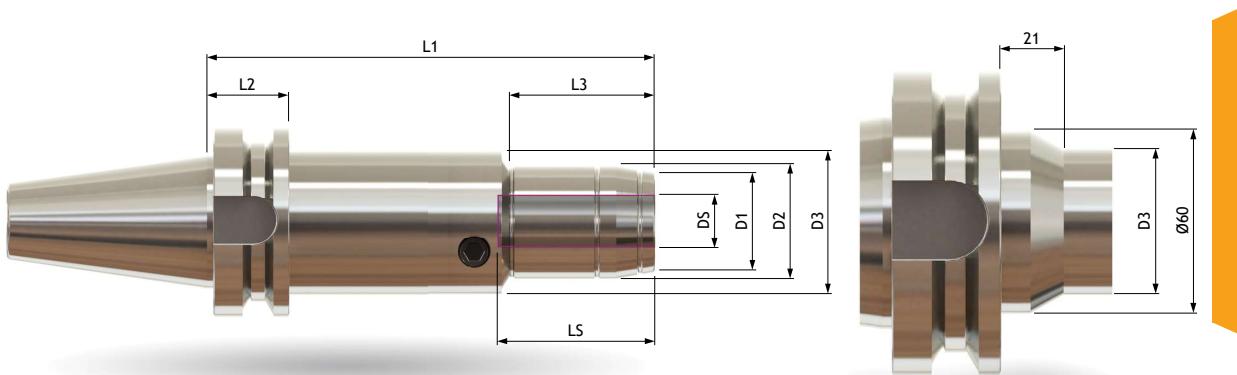
▲ = dimension compatible with reduction sleeve.

\* = Ø40 is only available with BT-50 and Plus-membrane.

## HYDROCHUCKS

BT-MAS

HCFL / HCFL+



BT 50 Ø6 - Ø25 appearance

For chuck with Plus-membrane, specify + after art.no

D5 Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>6</b>	BT 40	21,5	26	48	135	27	43,5	37,5	<b>56720</b>
	BT 40	21,5	26	48	135 - 485	27	43,5	37,5	▲
	BT 50	21,5	26	48	160	38	43,5	37,5	<b>56730</b>
	BT 50	21,5	26	48	160 - 445	38	43,5	37,5	▲
<b>8</b>	BT 40	23,5	28	48	135	27	43,5	37,5	<b>56721</b>
	BT 40	23,5	28	48	135 - 485	27	43,5	37,5	▲
	BT 50	23,5	28	48	160	38	43,5	37,5	<b>56731</b>
	BT 50	23,5	28	48	160 - 445	38	43,5	37,5	▲
<b>10</b>	BT 40	25,5	30	48	135	27	43,5	42,5	<b>56722</b>
	BT 40	25,5	30	48	135 - 485	27	43,5	42,5	▲
	BT 50	25,5	30	48	160	38	43,5	42,5	<b>56732</b>
	BT 50	25,5	30	48	160 - 445	38	43,5	42,5	▲
<b>12</b> ▲	BT 40	27,5	32	48	135	27	44,5	47,5	<b>56723</b>
	BT 40	27,5	32	48	135 - 485	27	44,5	47,5	▲
	BT 50	27,5	32	48	160	38	44,5	47,5	<b>56733</b>
	BT 50	27,5	32	48	160 - 445	38	44,5	47,5	▲
<b>14</b>	BT 40	29,5	34	48	135	27	44,5	47,5	<b>56724</b>
	BT 40	29,5	34	48	135 - 485	27	44,5	47,5	▲
	BT 50	29,5	34	48	160	38	44,5	47,5	<b>56734</b>
	BT 50	29,5	34	48	160 - 445	38	44,5	47,5	▲
<b>16</b>	BT 40	33,5	38	48	135	27	47,5	52,5	<b>56725</b>
	BT 40	33,5	38	48	135 - 485	27	47,5	52,5	▲
	BT 50	33,5	38	48	160	38	47,5	52,5	<b>56735</b>
	BT 50	33,5	38	48	160 - 445	38	47,5	52,5	▲

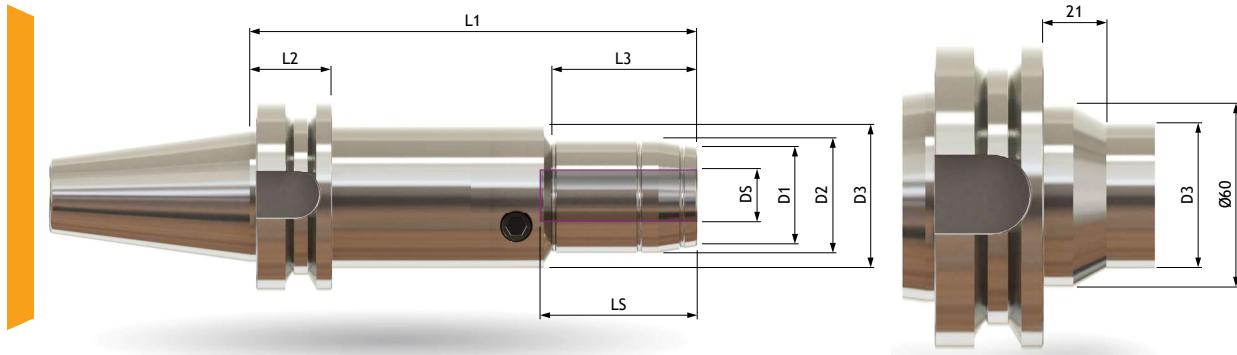
▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

## HYDROCHUCKS

BT-MAS

HCFL / HCFL+



For chuck with Plus-membrane, specify + after art.no

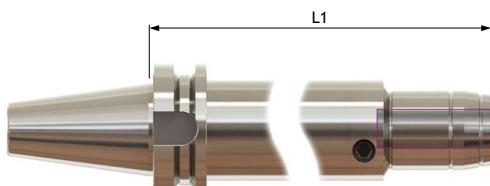
BT 50 Ø6 - Ø25 appearance

D5 Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>18</b>	BT 40	35,5	40	48	135	27	47,5	52,5	<b>56726</b>
	BT 40	35,5	40	48	135 - 485	27	47,5	52,5	▲
	BT 50	35,5	40	48	160	38	47,5	52,5	<b>56736</b>
	BT 50	35,5	40	48	160 - 445	38	47,5	52,5	▲
<b>20</b> ▲	BT 40	37,5	42	48	135	27	47,5	52,5	<b>56727</b>
	BT 40	37,5	42	48	135 - 485	27	47,5	52,5	▲
	BT 50	37,5	42	48	160	38	47,5	52,5	<b>56737</b>
	BT 50	37,5	42	48	160 - 445	38	47,5	52,5	▲
<b>25</b>	BT 40	43,5	48	48	139	27	111	55	<b>56728</b>
	BT 40	43,5	48	48	139 - 485	27	-----	55	▲
	BT 50	43,5	48	48	164	38	105	55	<b>56738</b>
	BT 50	43,5	48	48	164 - 445	38	-----	55	▲
<b>32</b> ▲	BT 40	55,5	60	70	148	27	57	65	<b>56729</b>
	BT 40	55,5	60	70	148 - 485	27	57	65	▲
	BT 50	55,5	60	70	159	38	57	65	<b>56739</b>
	BT 50	55,5	60	70	159 - 445	38	57	65	▲

▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

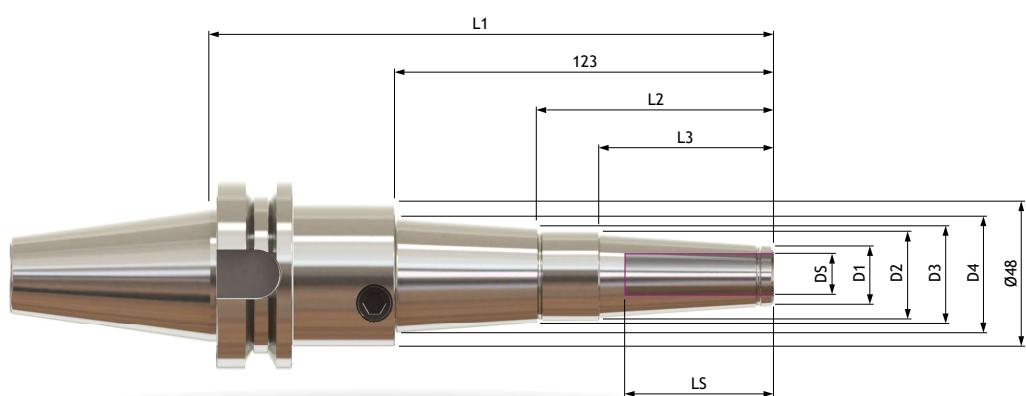
Choose your own length (L1) of HCFL / HCFL+. Specify Art.no / L1 on order.



## HYDROCHUCKS

BT-MAS

HCPK+

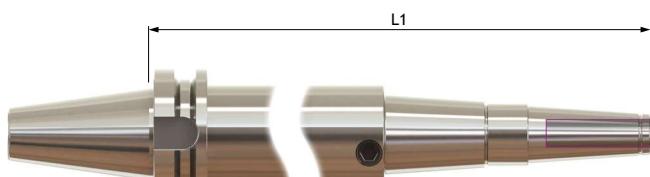


DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	D4 Ømm	L1 mm	L2 mm	L3 mm	L5 mm	Art.no
<b>12</b> ▲	BT 40	20	30	32	40,5	185	76,8	57	44	<b>59143+</b>
	BT 40	20	30	32	40,5	225 - 485	76,8	57	44	▲
	BT 50	20	30	32	40,5	196	76,8	57	44	<b>59173+</b>
	BT 50	20	30	32	40,5	236 - 445	76,8	57	44	▲
<b>20</b> ▲	BT 40	32	39	42	50,5	185	74,8	55	52	<b>59147+</b>
	BT 40	32	39	42	50,5	225 - 485	74,8	55	52	▲
	BT 50	32	39	42	50,5	196	74,8	55	52	<b>59177+</b>
	BT 50	32	39	42	50,5	236 - 445	74,8	55	52	▲

▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

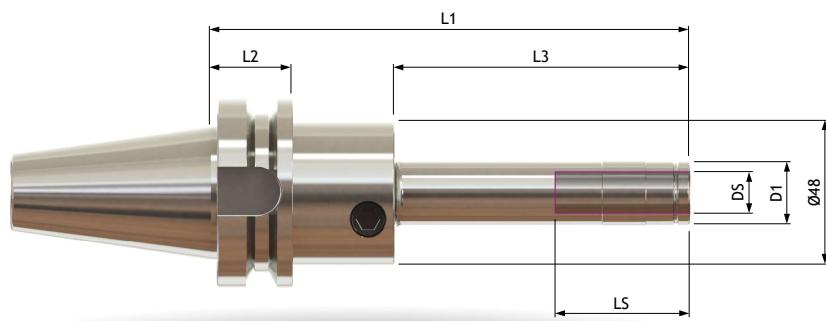
Choose your own length (L1) of HCPK+. Specify Art.no / L1 on order.



## HYDROCHUCKS

BT-MAS

HCP+



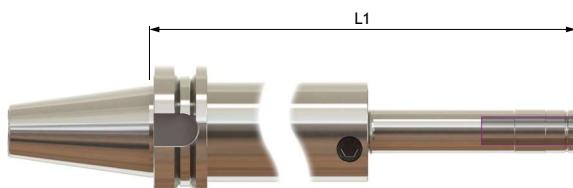
Short model



DS Ømm	Mount type.	D1 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>12</b> ▲	BT 40	22,5	113	27	50	44	<b>59103+</b>
	BT 40	22,5	163	27	100	44	<b>59113+</b>
	BT 50	22,5	124	38	50	44	<b>59153+</b>
	BT 50	22,5	174	38	100	44	<b>59163+</b>

▲ = dimension compatible with reduction sleeve.

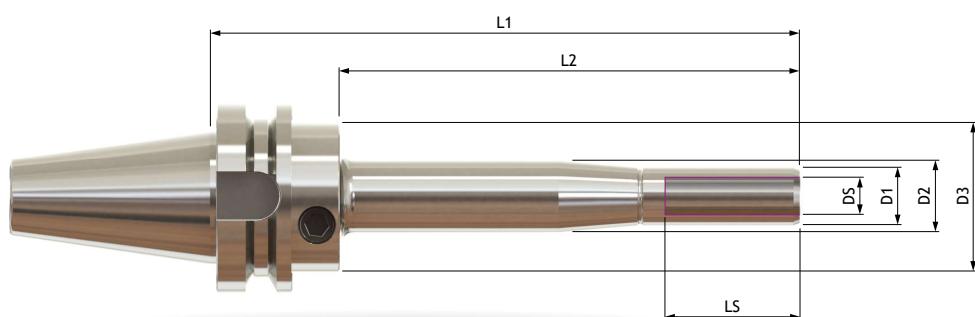
Choose your own length (L1) of HCP+. Specify Art.no / L1 on order.



## HYDROCHUCKS

BT-MAS

HCPS



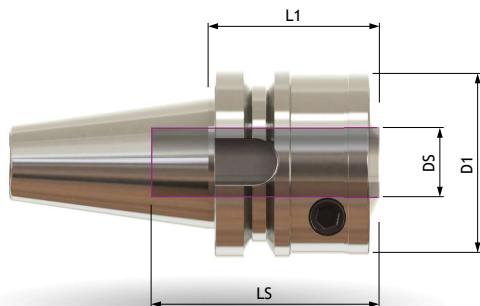
Short model



DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>12</b> ▲	BT 40	19,5	----	48	143	100	----	42	<b>59603</b>
	BT 50	19,5	----	48	154	100	----	42	<b>59613</b>
	BT 40	19,5	24	48	193	150	52	42	<b>59703</b>
	BT 50	19,5	24	48	204	150	52	42	<b>59713</b>

▲ = dimension compatible with reduction sleeve.

HCK+



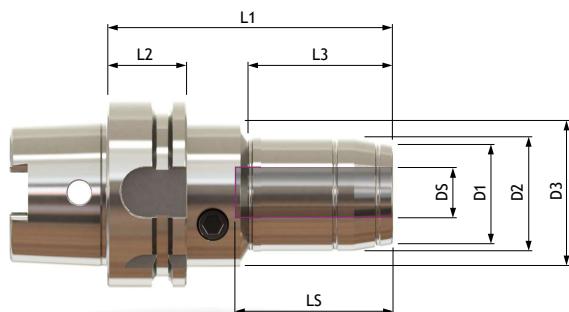
HCK+ has an extended membrane which provides 600 Nm compared to 320 Nm on a standard Ø20 mm chuck.

DS Ømm	Mount type.	D1 Ømm	L1 mm	LS mm	Art.no
<b>20</b>	BT 40	61	56	52,5	<b>66125+</b>

## HYDROCHUCKS

HSK-A

HCF / HCF+



For chuck with Plus-membrane, specify + after art.no

DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>6</b>	HSK-A63	21,5	26	50	71,5	26	24,5	37,5	<b>54870</b>
	HSK-A80	21,5	26	48	127	26	43,5	37,5	<b>56670</b>
	HSK-A100	21,5	26	48	140	29	43,5	37,5	<b>56680</b>
<b>8</b>	HSK-A63	24	28	50	71,5	26	25,5	37,5	<b>54871</b>
	HSK-A80	23,5	28	48	127	26	43,5	37,5	<b>56671</b>
	HSK-A100	23,5	28	48	140	29	43,5	37,5	<b>56681</b>
<b>10</b>	HSK-A63	26	30	50	81,5	26	35,5	42,5	<b>54872</b>
	HSK-A80	25,5	30	48	127	26	43,5	42,5	<b>56672</b>
	HSK-A100	25,5	30	48	140	29	43,5	42,5	<b>56682</b>
<b>12</b>	HSK-A40	28	32	42	94,5	20	41,5	47,5	<b>54853</b>
	HSK-A50	28	32	42	86,5	26	43,5	47,5	<b>54863</b>
	HSK-A63	28	32	50	86,5	26	41,5	47,5	<b>54873</b>
	HSK-A80	27,5	32	48	127	26	44,5	47,5	<b>56673</b>
	HSK-A100	27,5	32	48	140	29	44,5	47,5	<b>56683</b>
<b>14</b>	HSK-A63	30	34	50	86,5	26	41,5	47,5	<b>54874</b>
	HSK-A80	29,5	34	48	127	26	44,5	47,5	<b>56674</b>
	HSK-A100	29,5	34	48	140	29	44,5	47,5	<b>56684</b>
<b>16</b>	HSK-A63	34	38	50	91,5	26	48	52,5	<b>54875</b>
	HSK-A80	33,5	38	48	127	26	47,5	52,5	<b>56675</b>
	HSK-A100	33,5	38	48	140	29	47,5	52,5	<b>56685</b>
<b>18</b>	HSK-A63	35,5	40	50	91,5	26	48,5	52,5	<b>54876</b>
	HSK-A80	35,5	40	48	127	26	47,5	52,5	<b>56676</b>
	HSK-A100	35,5	40	48	140	29	47,5	52,5	<b>56686</b>

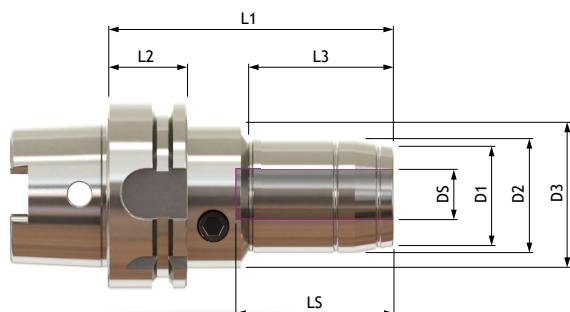
= dimension compatible with reduction sleeve.

Other dimensions (DS) with HSK-40 and HSK-50 on request.

## HYDROCHUCKS

HSK-A

HCF / HCF+



For chuck with Plus-membrane, specify + after art.no

DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>20</b> ▲	HSK-A50	38	42	42	91,5	20	65,5	51	<b>54867</b>
	HSK-A63	38	42	50	91,5	26	49,5	52,5	<b>54877</b>
	HSK-A80	37,5	42	48	127	26	47,5	52,5	<b>56677</b>
	HSK-A100	37,5	42	48	140	29	47,5	52,5	<b>56687</b>
<b>25</b>	HSK-A63	53	57	63	121	26	52	61	<b>54878</b>
	HSK-A80	43,5	48	48	131	26	105	55	<b>56678</b>
	HSK-A100	43,5	48	48	144	29	115	55	<b>56688</b>
<b>32</b> ▲	HSK-A63	60	64	75	126	26	62	65	<b>54879</b>
	HSK-A80	55,5	60	70	140	26	57	65	<b>56679</b>
	HSK-A100	55,5	60	70	153	29	57	65	<b>56689</b>

▲ = dimension compatible with reduction sleeve.

Other dimensions (DS) with HSK-40 and HSK-50 on request..

We also manufacture other types of HSK-mounts. Contact us for more info.



HSK-C



HSK-E

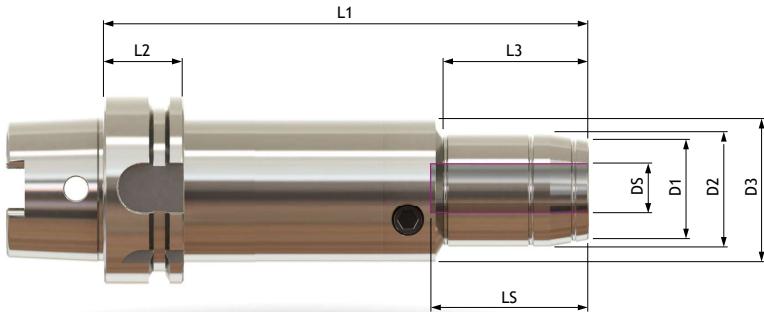


HSK-F

## HYDROCHUCKS

HSK-A

HCFL / HCFL+



For chuck with Plus-membrane, specify + after art.no

DS 0mm	Mount type.	D1 0mm	D2 0mm	D3 0mm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>6</b>	HSK-A63	21,5	26	48	140	26	43,5	37,5	<b>56660</b>
	HSK-A63	21,5	26	48	140 - 515	26	43,5	37,5	▲
	HSK-A80	21,5	26	48	167	26	43,5	37,5	<b>56690</b>
	HSK-A80	21,5	26	48	167 - 510	26	43,5	37,5	▲
	HSK-A100	21,5	26	48	180	29	43,5	37,5	<b>56760</b>
	HSK-A100	21,5	26	48	180 - 500	29	43,5	37,5	▲
<b>8</b>	HSK-A63	23,5	28	48	140	26	43,5	37,5	<b>56661</b>
	HSK-A63	23,5	28	48	140 - 515	26	43,5	37,5	▲
	HSK-A80	23,5	28	48	167	26	43,5	37,5	<b>56691</b>
	HSK-A80	23,5	28	48	167 - 510	26	43,5	37,5	▲
	HSK-A100	23,5	28	48	180	29	43,5	37,5	<b>56761</b>
	HSK-A100	23,5	28	48	180 - 500	29	43,5	37,5	▲
<b>10</b>	HSK-A63	25,5	30	48	140	26	43,5	42,5	<b>56662</b>
	HSK-A63	25,5	30	48	140 - 515	26	43,5	42,5	▲
	HSK-A80	25,5	30	48	167	26	43,5	42,5	<b>56692</b>
	HSK-A80	25,5	30	48	167 - 510	26	43,5	42,5	▲
	HSK-A100	25,5	30	48	180	29	43,5	42,5	<b>56762</b>
	HSK-A100	25,5	30	48	180 - 500	29	43,5	42,5	▲
<b>12</b> ▲	HSK-A63	27,5	32	48	140	26	44,5	47,5	<b>56663</b>
	HSK-A63	27,5	32	48	140 - 515	26	44,5	47,5	▲
	HSK-A80	27,5	32	48	167	26	44,5	47,5	<b>56693</b>
	HSK-A80	27,5	32	48	167 - 510	26	44,5	47,5	▲
	HSK-A100	27,5	32	48	180	29	44,5	47,5	<b>56763</b>
	HSK-A100	27,5	32	48	180 - 500	29	44,5	47,5	▲

▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

## HYDROCHUCKS

HSK-A

### HCFL / HCFL+

DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>14</b>	HSK-A63	29,5	34	48	140	26	44,5	52,5	<b>56664</b>
	HSK-A63	29,5	34	48	140 - 515	26	44,5	52,5	▲
	HSK-A80	29,5	34	48	167	26	44,5	52,5	<b>56694</b>
	HSK-A80	29,5	34	48	167 - 510	26	44,5	52,5	▲
	HSK-A100	29,5	34	48	180	29	44,5	52,5	<b>56764</b>
	HSK-A100	29,5	34	48	180 - 500	29	44,5	52,5	▲
<b>16</b>	HSK-A63	33,5	38	48	140	26	47,5	52,5	<b>56665</b>
	HSK-A63	33,5	38	48	140 - 515	26	47,5	52,5	▲
	HSK-A80	33,5	38	48	167	26	47,5	52,5	<b>56695</b>
	HSK-A80	33,5	38	48	167 - 510	26	47,5	52,5	▲
	HSK-A100	33,5	38	48	180	29	47,5	52,5	<b>56765</b>
	HSK-A100	33,5	38	48	180 - 500	29	47,5	52,5	▲
<b>18</b>	HSK-A63	35,5	40	48	140	26	47,5	52,5	<b>56666</b>
	HSK-A63	35,5	40	48	140 - 515	26	47,5	52,5	▲
	HSK-A80	35,5	40	48	167	26	47,5	52,5	<b>56696</b>
	HSK-A80	35,5	40	48	167 - 510	26	47,5	52,5	▲
	HSK-A100	35,5	40	48	180	29	47,5	52,5	<b>56766</b>
	HSK-A100	35,5	40	48	180 - 500	29	47,5	52,5	▲
<b>20</b> ▲	HSK-A63	37,5	42	48	140	26	47,5	52,5	<b>56667</b>
	HSK-A63	37,5	42	48	140 - 515	26	47,5	52,5	▲
	HSK-A80	37,5	42	48	167	26	47,5	52,5	<b>56697</b>
	HSK-A80	37,5	42	48	167 - 510	26	47,5	52,5	▲
	HSK-A100	37,5	42	48	180	29	47,5	52,5	<b>56767</b>
	HSK-A100	37,5	42	48	180 - 500	29	47,5	52,5	▲
<b>25</b>	HSK-A63	43,5	48	48	144	26	118	55	<b>56668</b>
	HSK-A63	43,5	48	48	144 - 515	26	.....	55	▲
	HSK-A80	43,5	48	48	171	26	145	55	<b>56698</b>
	HSK-A80	43,5	48	48	171 - 510	26	.....	55	▲
	HSK-A100	43,5	48	48	184	29	155	55	<b>56768</b>
	HSK-A100	43,5	48	48	184 - 500	29	.....	55	▲
<b>32</b> ▲	HSK-A63	55,5	60	70	193	26	57	65	<b>56669</b>
	HSK-A63	55,5	60	70	153 - 515	26	57	65	▲
	HSK-A80	55,5	60	70	180	26	57	65	<b>56699</b>
	HSK-A80	55,5	60	70	180 - 510	26	57	65	▲
	HSK-A100	55,5	60	70	193	29	57	65	<b>56769</b>
	HSK-A100	55,5	60	70	193 - 500	29	57	65	▲

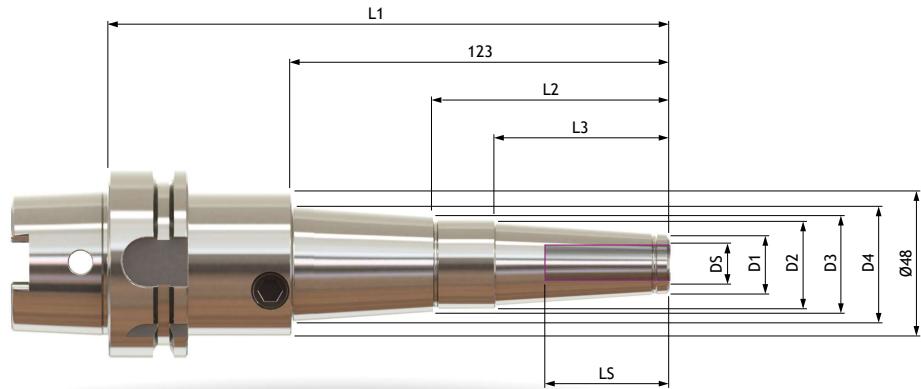
▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

## HYDROCHUCKS

HSK-A

HCPK+

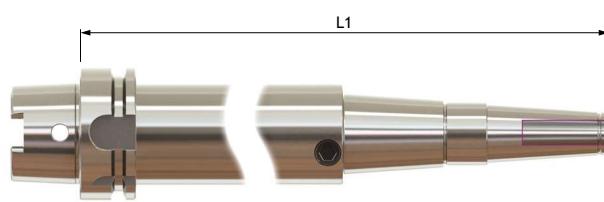


DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	D4 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
12 ▲	HSK-A63	20	30	32	40,5	197	76,8	57	44	54103+
	HSK-A63	20	30	32	40,5	237 - 515	76,8	57	44	▲
	HSK-A80	20	30	32	40,5	217	76,8	57	44	54113+
	HSK-A80	20	30	32	40,5	257 - 510	76,8	57	44	▲
	HSK-A100	20	30	32	40,5	230	76,8	57	44	54123+
	HSK-A100	20	30	32	40,5	270 - 500	76,8	57	44	▲
20 ▲	HSK-A63	32	39	42	50,5	197	74,8	55	52	54107+
	HSK-A63	32	39	42	50,5	237 - 515	74,8	55	52	▲
	HSK-A80	32	39	42	50,5	217	74,8	55	52	54117+
	HSK-A80	32	39	42	50,5	257 - 510	74,8	55	52	▲
	HSK-A100	32	39	42	50,5	230	74,8	55	52	54127+
	HSK-A100	32	39	42	50,5	270 - 500	74,8	55	52	▲

▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

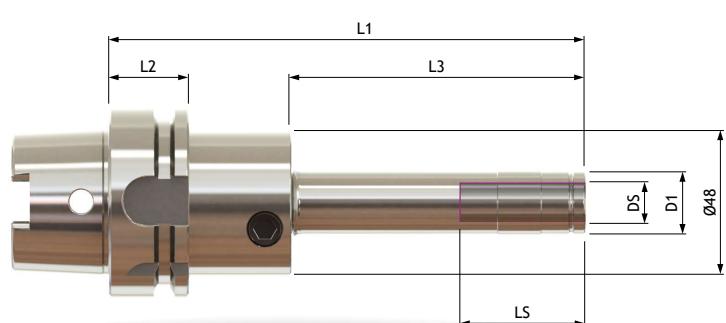
Choose your own length (L1) of HCPK+. Specify Art.no / L1 on order.



## HYDROCHUCKS

HSK-A

HCP+



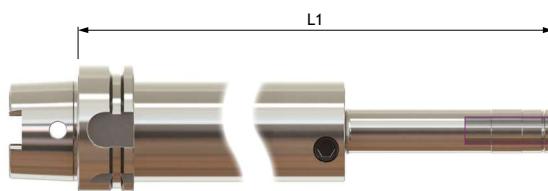
Short model



DS Ømm	Mount type.	D1 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>12</b> ▲	HSK-A63	22,5	125	26	50	44	<b>59303+</b>
	HSK-A63	22,5	175	26	100	44	<b>59313+</b>
	HSK-A80	22,5	145	26	50	44	<b>59238+</b>
	HSK-A80	22,5	195	26	100	44	<b>59243+</b>
	HSK-A100	22,5	158	29	50	44	<b>59353+</b>
	HSK-A100	22,5	208	29	100	44	<b>59363+</b>

▲ = dimension compatible with reduction sleeve.

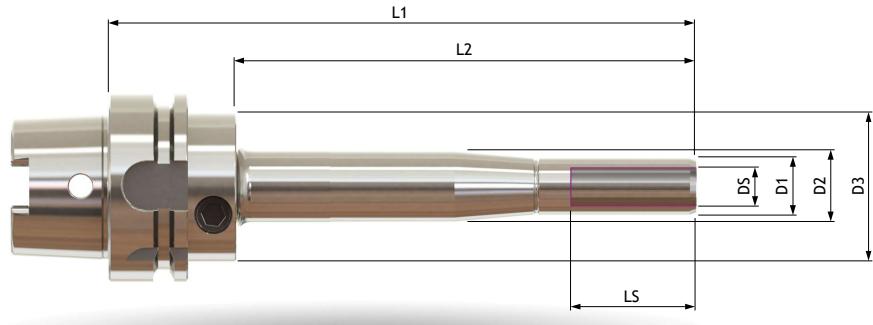
Choose your own length (L1) of HCP+. Specify Art.no / L1 on order.



## HYDROCHUCKS

HSK-A

HCPS



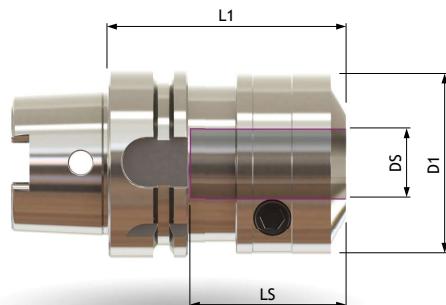
Short model



DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>12</b> ▲	HSK-A63	19,5	----	48	155	100	----	42	<b>59643</b>
	HSK-A80	19,5	----	48	175	100	----	42	<b>59653</b>
	HSK-A100	19,5	----	48	188	100	----	42	<b>59663</b>
	HSK-A63	19,5	24	48	205	150	52	42	<b>59743</b>
	HSK-A80	19,5	24	48	225	150	52	42	<b>59753</b>
	HSK-A100	19,5	24	48	238	150	52	42	<b>59763</b>

▲ = dimension compatible with reduction sleeve.

HCK+

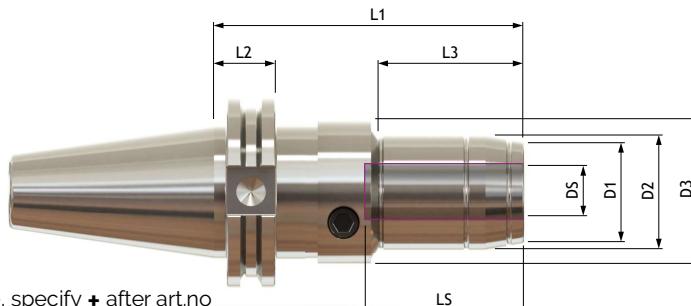


DS Ømm	Mount type.	D1 Ømm	L1 mm	LS mm	Art.no
<b>20</b>	HSK-A63	61	78	51,8	<b>66109+</b>
<b>32</b>	HSK-A63	82	88	61,8	<b>66111+</b>

## HYDROCHUCKS

CAT / ASME BS.50

**HCF / HCF+**



For chuck with Plus-membrane, specify + after art.no

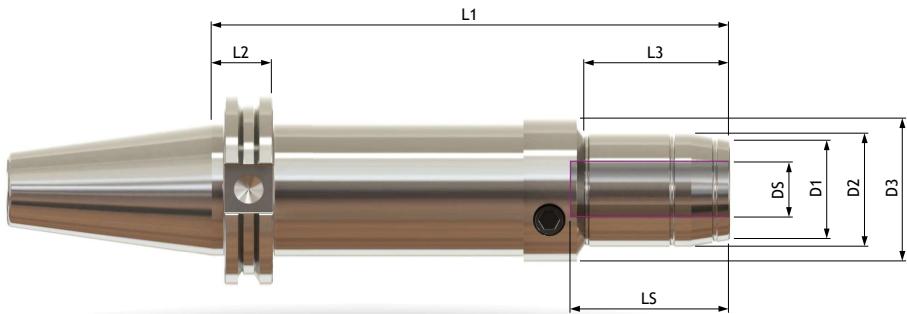
DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>6</b>	CAT 40	21,5	26	48	105	19,05	43,5	37,5	<b>56470</b>
	CAT 50	21,5	26	48	87	19,05	43,5	37,5	<b>56490</b>
	CAT 50	21,5	26	48	101,6	19,05	43,5	37,5	<b>56480</b>
<b>8</b>	CAT 40	23,5	28	48	105	19,05	43,5	37,5	<b>56471</b>
	CAT 50	23,5	28	48	84	19,05	43,5	37,5	<b>56491</b>
	CAT 50	23,5	28	48	101,6	19,05	43,5	37,5	<b>56481</b>
<b>10</b>	CAT 40	25,5	30	48	105	19,05	43,5	42,5	<b>56472</b>
	CAT 50	25,5	30	48	84	19,05	43,5	42,5	<b>56492</b>
	CAT 50	25,5	30	48	101,6	19,05	43,5	42,5	<b>56482</b>
<b>12</b> ▲	CAT 40	27,5	32	48	105	19,05	43,5	47,5	<b>56473</b>
	CAT 50	27,5	32	48	84	19,05	43,5	47,5	<b>56493</b>
	CAT 50	27,5	32	48	101,6	19,05	43,5	47,5	<b>56483</b>
<b>14</b>	CAT 40	29,5	34	48	105	19,05	44,5	47,5	<b>56474</b>
	CAT 50	29,5	34	48	84	19,05	44,5	47,5	<b>56494</b>
	CAT 50	29,5	34	48	101,6	19,05	44,5	47,5	<b>56484</b>
<b>16</b>	CAT 40	33,5	38	48	105	19,05	47,5	52,5	<b>56475</b>
	CAT 50	33,5	38	48	84	19,05	47,5	52,5	<b>56495</b>
	CAT 50	33,5	38	48	101,6	19,05	47,5	52,5	<b>56485</b>
<b>18</b>	CAT 40	35,5	40	48	105	19,05	47,5	52,5	<b>56476</b>
	CAT 50	35,5	40	48	84	19,05	47,5	52,5	<b>56496</b>
	CAT 50	35,5	40	48	101,6	19,05	47,5	52,5	<b>56486</b>
<b>20</b> ▲	CAT 40	37,5	42	48	105	19,05	47,5	52,5	<b>56477</b>
	CAT 50	37,5	42	48	84	19,05	47,5	52,5	<b>56497</b>
	CAT 50	37,5	42	48	101,6	19,05	47,5	52,5	<b>56487</b>
<b>25</b>	CAT 40	43,5	48	48	109	19,05	89,95	55	<b>56478</b>
	CAT 50	43,5	48	48	91	19,05	82,55	55	<b>56498</b>
	CAT 50	43,5	48	48	105,6	19,05	82,55	55	<b>56488</b>
<b>32</b> ▲	CAT 40	55,5	60	70	120	19,05	57	65	<b>56479</b>
	CAT 50	55,5	60	70	100	19,05	57	65	<b>56499</b>
	CAT 50	55,5	60	70	114,6	19,05	57	65	<b>56489</b>

▲ = dimension compatible with reduction sleeve.

## HYDROCHUCKS

CAT / ASME BS.50

HCFL / HCFL+



For chuck with Plus-membrane, specify + after art.no

DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>6</b>	CAT 40	21,5	26	48	127	19,05	43,5	37,5	<b>56600</b>
	CAT 40	21,5	26	48	127 - 480	19,05	43,5	37,5	▲
	CAT 50	21,5	26	48	152,4	19,05	43,5	37,5	<b>56610</b>
	CAT 50	21,5	26	48	127 - 445	19,05	43,5	37,5	▲
<b>8</b>	CAT 40	23,5	28	48	127	19,05	43,5	37,5	<b>56601</b>
	CAT 40	23,5	28	48	124 - 480	19,05	43,5	37,5	▲
	CAT 50	23,5	28	48	152,4	19,05	43,5	37,5	<b>56611</b>
	CAT 50	23,5	28	48	127 - 445	19,05	43,5	37,5	▲
<b>10</b>	CAT 40	25,5	30	48	127	19,05	43,5	42,5	<b>56602</b>
	CAT 40	25,5	30	48	127 - 480	19,05	43,5	42,5	▲
	CAT 50	25,5	30	48	152,4	19,05	43,5	42,5	<b>56612</b>
	CAT 50	25,5	30	48	127 - 445	19,05	43,5	42,5	▲
<b>12</b> ▲	CAT 40	27,5	32	48	127	19,05	43,5	47,5	<b>56603</b>
	CAT 40	27,5	32	48	127 - 480	19,05	43,5	47,5	▲
	CAT 50	27,5	32	48	152,4	19,05	43,5	47,5	<b>56613</b>
	CAT 50	27,5	32	48	127 - 445	19,05	43,5	47,5	▲
<b>14</b>	CAT 40	29,5	34	48	127	19,05	44,5	47,5	<b>56604</b>
	CAT 40	29,5	34	48	127 - 480	19,05	44,5	47,5	▲
	CAT 50	29,5	34	48	152,4	19,05	44,5	47,5	<b>56614</b>
	CAT 50	29,5	34	48	127 - 445	19,05	44,5	47,5	▲
<b>16</b>	CAT 40	33,5	38	48	127	19,05	47,5	52,5	<b>56605</b>
	CAT 40	33,5	38	48	127 - 480	19,05	47,5	52,5	▲
	CAT 50	33,5	38	48	152,4	19,05	47,5	52,5	<b>56615</b>
	CAT 50	33,5	38	48	127 - 445	19,05	47,5	52,5	▲

▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

## HYDROCHUCKS

CAT / ASME BS.50

### HCFL / HCFL+

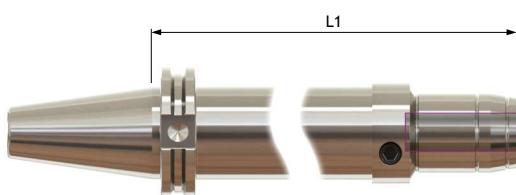
For chuck with Plus-membrane, specify + after art.no

Ds Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	Ls mm	Art.no
<b>18</b>	CAT 40	35,5	40	48	127	19,05	47,5	52,5	<b>56606</b>
	CAT 40	35,5	40	48	127 - 480	19,05	47,5	52,5	▲
	CAT 50	35,5	40	48	152,4	19,05	47,5	52,5	<b>56616</b>
	CAT 50	35,5	40	48	127 - 445	19,05	47,5	52,5	▲
<b>20</b> ▲	CAT 40	37,5	42	48	127	19,05	47,5	52,5	<b>56607</b>
	CAT 40	37,5	42	48	127 - 480	19,05	47,5	52,5	▲
	CAT 50	37,5	42	48	152,4	19,05	47,5	52,5	<b>56617</b>
	CAT 50	37,5	42	48	127 - 445	19,05	47,5	52,5	▲
<b>25</b>	CAT 40	43,5	48	48	131	19,05	111,95	55	<b>56608</b>
	CAT 40	43,5	48	48	131 - 480	19,05	.....	55	▲
	CAT 50	43,5	48	48	152,4	19,05	132,4	55	<b>56618</b>
	CAT 50	43,5	48	48	131 - 445	19,05	.....	55	▲
<b>32</b> ▲	CAT 40	55,5	60	70	158	19,05	57	65	<b>56609</b>
	CAT 40	55,5	60	70	158 - 480	19,05	.....	65	▲
	CAT 50	55,5	60	70	154,6	19,05	57	65	<b>56619</b>
	CAT 50	55,5	60	70	140 - 445	19,05	.....	65	▲

▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

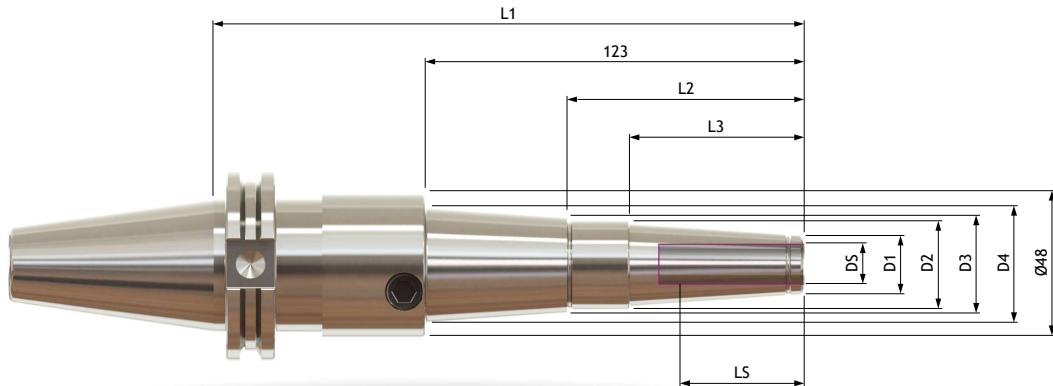
Choose your own length (L1) of HCFL / HCFL+. Specify Art.no / L1 on order.



## HYDROCHUCKS

CAT / ASME BS.50

HCPK+

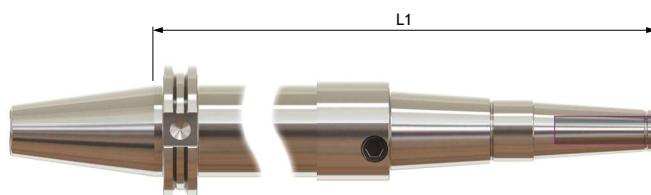


DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	D4 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>12</b> ▲	CAT 40	20	30	32	40,5	195	76,8	57	47,5	<b>59263+</b>
	CAT 40	20	30	32	40,5	235 - 480	76,8	57	47,5	▲
	CAT 50	20	30	32	40,5	177	76,8	57	47,5	<b>59273+</b>
	CAT 50	20	30	32	40,5	217 - 445	76,8	57	47,5	▲
<b>20</b> ▲	CAT 40	32	39	42	50,5	195	74,8	55	52,5	<b>59267+</b>
	CAT 40	32	39	42	50,5	235 - 480	74,8	55	52,5	▲
	CAT 50	32	39	42	50,5	177	74,8	55	52,5	<b>59277+</b>
	CAT 50	32	39	42	50,5	217 - 445	74,8	55	52,5	▲

▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

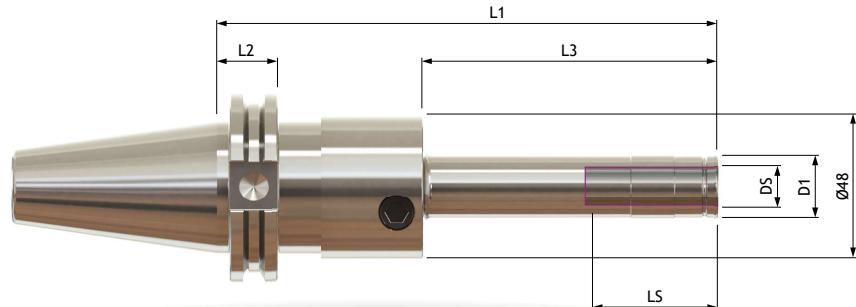
Choose your own length (L1) of HCPK+. Specify Art.no / L1 on order.



## HYDROCHUCKS

CAT / ASME BS.50

HCP+



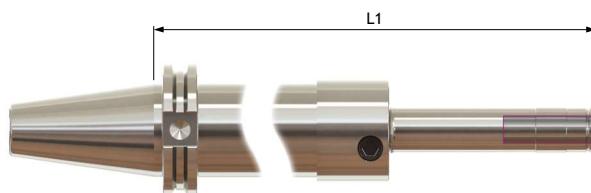
Short model



D2 Ømm	Mount type.	D1 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
12 ▲	CAT 40	22,5	123	19,05	50	47,5	59033+
	CAT 40	22,5	173	19,05	100	47,5	59043+
	CAT 50	22,5	105	19,05	50	47,5	59083+
	CAT 50	22,5	155	19,05	100	47,5	59093+

▲ = dimension compatible with reduction sleeve.

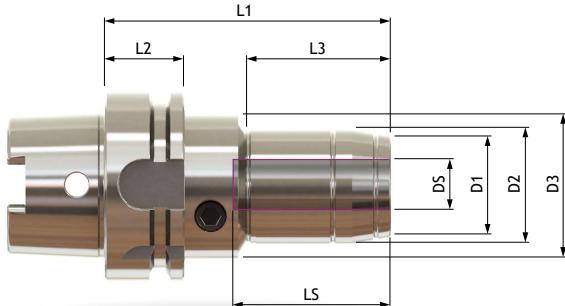
Choose your own length (L1) of HCP+. Specify Art.no / L1 on order.



## HYDROCHUCKS - INCH SIZES

HSK-A

HCF / HCF+



For chuck with Plus-membrane, specify + after art.no

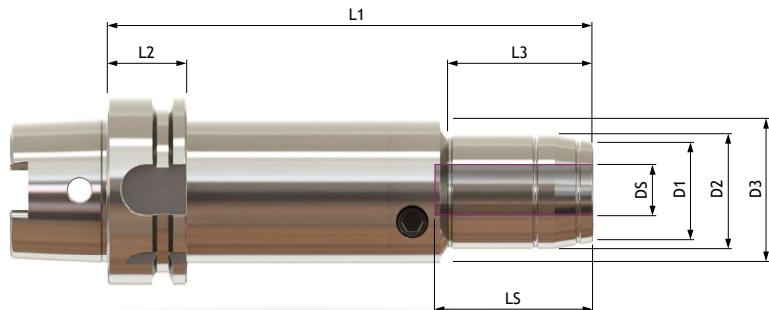
D <sub>S</sub> Ømm	Mount type.	D <sub>1</sub> Ømm	D <sub>2</sub> Ømm	D <sub>3</sub> Ømm	L <sub>1</sub> mm	L <sub>2</sub> mm	L <sub>3</sub> mm	L <sub>S</sub> mm	Art.no
<b>1/4"</b>	HSK-A63	22	26	50	71,5	26	24,5	37,5	<b>54470</b>
	HSK-A80	21,5	26	48	127	26	43,5	37,5	<b>56550</b>
	HSK-A100	21,5	26	48	140	29	43,5	37,5	<b>56530</b>
<b>5/16"</b>	HSK-A63	24	28	50	71,5	26	25,5	37,5	<b>54471</b>
	HSK-A80	23,5	28	48	127	26	43,5	37,5	<b>56551</b>
	HSK-A100	23,5	28	48	140	29	43,5	37,5	<b>56531</b>
<b>3/8"</b>	HSK-A63	26	30	50	81,5	26	35,5	42,5	<b>54472</b>
	HSK-A80	25,5	30	48	127	26	43,5	42,5	<b>56552</b>
	HSK-A100	25,5	30	48	140	29	43,5	42,5	<b>56532</b>
<b>1/2"</b>	HSK-A63	28	32	50	86,5	26	41,5	47,5	<b>54473</b>
	HSK-A80	27,5	32	48	127	26	44,5	47,5	<b>56553</b>
	HSK-A100	27,5	32	48	140	29	44,5	47,5	<b>56533</b>
<b>5/8"</b>	HSK-A63	34	38	50	91,5	26	48	52,5	<b>54474</b>
	HSK-A80	33,5	38	48	127	26	47,5	52,5	<b>56654</b>
	HSK-A100	33,5	38	48	140	29	47,5	52,5	<b>56534</b>
<b>3/4"</b> ►	HSK-A63	38	42	50	91,5	26	49,5	52,5	<b>54475</b>
	HSK-A80	37,5	42	48	127	26	47,5	52,5	<b>56555</b>
	HSK-A100	37,5	42	48	140	29	47,5	52,5	<b>56535</b>
<b>1"</b>	HSK-A63	53	57	63	121	26	52	61	<b>54476</b>
	HSK-A80	43,5	48	48	131	26	105	55	<b>56556</b>
	HSK-A100	43,5	48	48	144	29	115	55	<b>56536</b>
<b>1 1/4" ►</b>	HSK-A63	60	64	75	126	26	62	65	<b>54477</b>
	HSK-A80	55,5	60	70	140	26	57	65	<b>56557</b>
	HSK-A100	55,5	60	70	153	29	57	65	<b>56537</b>

► = dimension compatible with reduction sleeve.

## HYDROCHUCKS - INCH SIZES

HSK-A

HCFL / HCFL+



For chuck with Plus-membrane, specify + after art.no

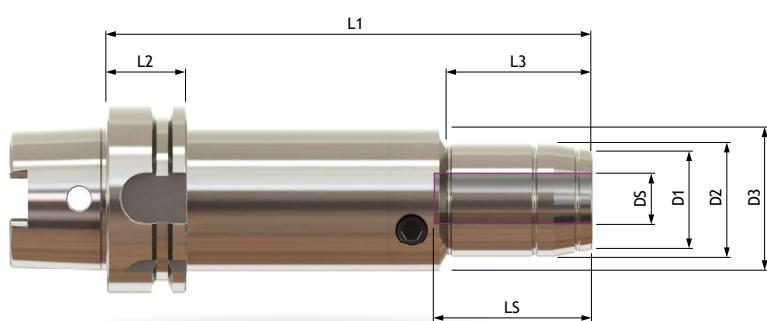
DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>1/4"</b>	HSK-A63	21,5	26	48	140	26	43,5	37,5	<b>56420</b>
	HSK-A63	21,5	26	48	140 - 515	26	43,5	37,5	▲
	HSK-A80	21,5	26	48	167	26	43,5	37,5	<b>56450</b>
	HSK-A80	21,5	26	48	167 - 510	26	43,5	37,5	▲
	HSK-A100	21,5	26	48	180	29	43,5	37,5	<b>56430</b>
	HSK-A100	21,5	26	48	180 - 500	29	43,5	37,5	▲
<b>5/16"</b>	HSK-A63	23,5	28	48	140	26	43,5	37,5	<b>56421</b>
	HSK-A63	23,5	28	48	140 - 515	26	43,5	37,5	▲
	HSK-A80	23,5	28	48	167	26	43,5	37,5	<b>56451</b>
	HSK-A80	23,5	28	48	167 - 510	26	43,5	37,5	▲
	HSK-A100	23,5	28	48	180	29	43,5	37,5	<b>56431</b>
	HSK-A100	23,5	28	48	180 - 500	29	43,5	37,5	▲
<b>3/8"</b>	HSK-A63	25,5	30	48	140	26	43,5	42,5	<b>56422</b>
	HSK-A63	25,5	30	48	140 - 515	26	43,5	42,5	▲
	HSK-A80	25,5	30	48	167	26	43,5	42,5	<b>56452</b>
	HSK-A80	25,5	30	48	167 - 510	26	43,5	42,5	▲
	HSK-A100	25,5	30	48	180	29	43,5	42,5	<b>56432</b>
	HSK-A100	25,5	30	48	180 - 500	29	43,5	42,5	▲
<b>1/2"</b>	HSK-A63	27,5	32	48	140	26	43,5	47,5	<b>56423</b>
	HSK-A63	27,5	32	48	144 - 515	26	43,5	47,5	▲
	HSK-A80	27,5	32	48	171	26	43,5	47,5	<b>56453</b>
	HSK-A80	27,5	32	48	171 - 510	26	43,5	47,5	▲
	HSK-A100	27,5	32	48	184	29	43,5	47,5	<b>56433</b>
	HSK-A100	27,5	32	48	184 - 500	29	43,5	47,5	▲

▲ = Specify art.no / L1 on order (L1 = length of your choice).

## HYDROCHUCKS - INCH SIZES

HSK-A

HCFL / HCFL+



For chuck with Plus-membrane, specify + after art.no

Ds Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>5/8"</b>	HSK-A63	33,5	38	48	140	26	47,5	52,5	<b>56424</b>
	HSK-A63	33,5	38	48	144 - 515	26	47,5	52,5	▲
	HSK-A80	33,5	38	48	171	26	47,5	52,5	<b>56454</b>
	HSK-A80	33,5	38	48	171 - 510	26	47,5	52,5	▲
	HSK-A100	33,5	38	48	184	29	47,5	52,5	<b>56434</b>
	HSK-A100	33,5	38	48	184 - 500	29	47,5	52,5	▲
<b>3/4" ▲</b>	HSK-A63	37,5	42	48	140	26	47,5	52,5	<b>56425</b>
	HSK-A63	37,5	42	48	144 - 515	26	47,5	52,5	▲
	HSK-A80	37,5	42	48	171	26	47,5	52,5	<b>56455</b>
	HSK-A80	37,5	42	48	171 - 510	26	47,5	52,5	▲
	HSK-A100	37,5	42	48	184	29	47,5	52,5	<b>56435</b>
	HSK-A100	37,5	42	48	184 - 500	29	47,5	52,5	▲
<b>1"</b>	HSK-A63	43,5	48	48	140	26	118	55	<b>56426</b>
	HSK-A63	43,5	48	48	144 - 515	26	-----	55	▲
	HSK-A80	43,5	48	48	167	26	145	55	<b>56456</b>
	HSK-A80	43,5	48	48	167 - 510	26	-----	55	▲
	HSK-A100	43,5	48	48	180	29	91	55	<b>56436</b>
	HSK-A100	43,5	48	48	180 - 500	29	-----	55	▲
<b>1 1/4" ▲</b>	HSK-A63	55,5	60	70	140	26	83	65	<b>56427</b>
	HSK-A63	55,5	60	70	140 - 515	26	83	65	▲
	HSK-A80	55,5	60	70	167	26	154	65	<b>56457</b>
	HSK-A80	55,5	60	70	167 - 515	26	154	65	▲
	HSK-A100	55,5	60	70	180	29	164	65	<b>56437</b>
	HSK-A100	55,5	60	70	180 - 500	29	164	65	▲

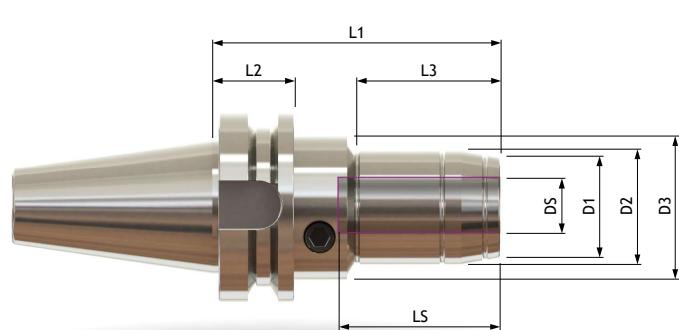
▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

## HYDROCHUCKS - INCH SIZES

BT-MAS

HCF / HCF+



For chuck with Plus-membrane, specify + after art.no

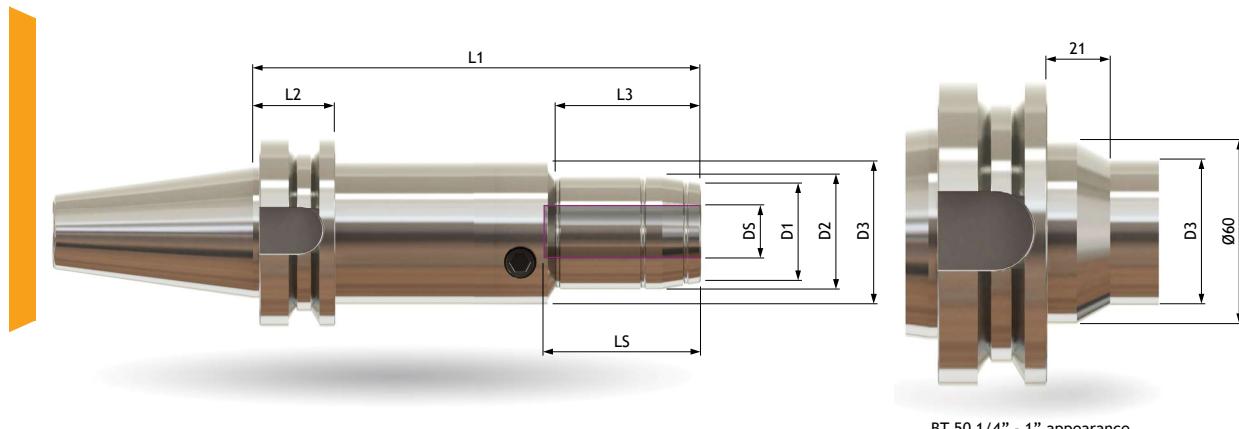
D5 Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>1/4"</b>	BT 40	21,5	26	48	95	27	43,5	37,5	<b>56500</b>
	BT 50	21,5	26	48	106	38	43,5	37,5	<b>56510</b>
<b>5/16"</b>	BT 40	23,5	28	48	95	27	43,5	37,5	<b>56501</b>
	BT 50	23,5	28	48	106	38	43,5	37,5	<b>56511</b>
<b>3/8"</b>	BT 40	25,5	30	48	95	27	43,5	42,5	<b>56502</b>
	BT 50	25,5	30	48	106	38	43,5	42,5	<b>56512</b>
<b>1/2"</b>	BT 40	27,5	32	48	95	27	43,5	47,5	<b>56503</b>
	BT 50	27,5	32	48	106	38	43,5	47,5	<b>56513</b>
<b>5/8"</b>	BT 40	33,5	38	48	95	27	47,5	52,5	<b>56504</b>
	BT 50	33,5	38	48	106	38	47,5	52,5	<b>56514</b>
<b>3/4" ▲</b>	BT 40	37,5	42	48	95	27	47,5	52,5	<b>56505</b>
	BT 50	37,5	42	48	106	38	47,5	52,5	<b>56515</b>
<b>1"</b>	BT 40	43,5	48	48	99	27	72	55	<b>56506</b>
	BT 50	43,5	48	48	110	38	72	55	<b>56516</b>
<b>1 1/4" ▲</b>	BT 40	55,5	60	70	108	27	57	65	<b>56507</b>
	BT 50	55,5	60	70	119	38	57	65	<b>56517</b>

▲ = dimension compatible with reduction sleeve.

## HYDROCHUCKS - INCH SIZES

BT-MAS

HCFL / HCFL+



For chuck with Plus-membrane, specify + after art.no

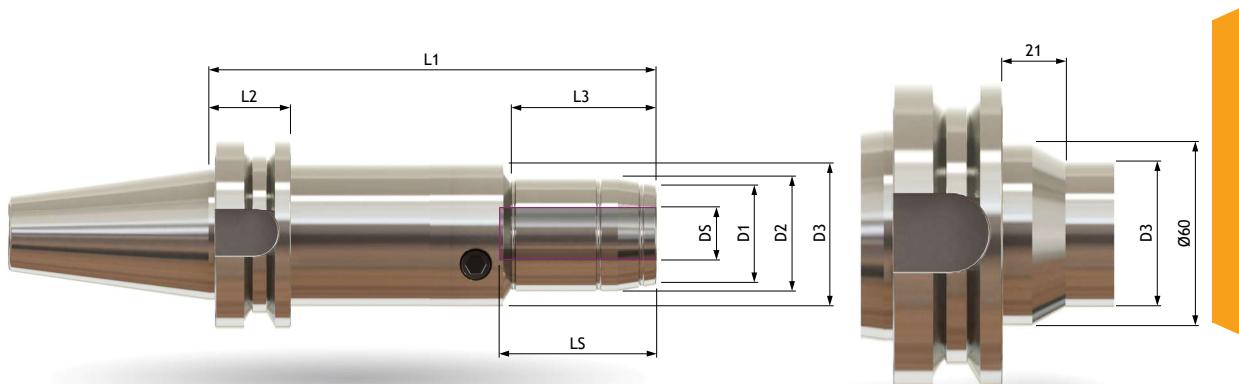
DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>1/4"</b>	BT 40	21,5	26	48	135	27	43,5	37,5	<b>56820</b>
	BT 40	21,5	26	48	135 - 485	27	43,5	37,5	▲
	BT 50	21,5	26	48	160	38	43,5	37,5	<b>56830</b>
	BT 50	21,5	26	48	146 - 445	38	43,5	37,5	▲
<b>5/16"</b>	BT 40	23,5	28	48	135	27	43,5	37,5	<b>56821</b>
	BT 40	23,5	28	48	135 - 485	27	43,5	37,5	▲
	BT 50	23,5	28	48	160	38	43,5	37,5	<b>56831</b>
	BT 50	23,5	28	48	146 - 445	38	43,5	37,5	▲
<b>3/8"</b>	BT 40	25,5	30	48	135	27	43,5	42,5	<b>56822</b>
	BT 40	25,5	30	48	135 - 485	27	43,5	42,5	▲
	BT 50	25,5	30	48	160	38	43,5	42,5	<b>56832</b>
	BT 50	25,5	30	48	146 - 445	38	43,5	42,5	▲
<b>1/2"</b>	BT 40	27,5	32	48	135	27	43,5	47,5	<b>56823</b>
	BT 40	27,5	32	48	135 - 485	27	43,5	47,5	▲
	BT 50	27,5	32	48	160	38	43,5	47,5	<b>56833</b>
	BT 50	27,5	32	48	146 - 445	38	43,5	47,5	▲
<b>5/8"</b>	BT 40	33,5	38	48	135	27	47,5	52,5	<b>56824</b>
	BT 40	33,5	38	48	135 - 485	27	47,5	52,5	▲
	BT 50	33,5	38	48	160	38	47,5	52,5	<b>56834</b>
	BT 50	33,5	38	48	146 - 445	38	47,5	52,5	▲

▲ = Specify art.no / L1 on order (L1 = length of your choice).

## HYDROCHUCKS - INCH SIZES

BT-MAS

**HCFL / HCFL+**



BT 50 1/4" - 1" appearance

For chuck with Plus-membrane, specify + after art.no

D5 Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>3/4"</b> ▲	BT 40	37,5	42	48	135	27	47,5	52,5	<b>56825</b>
	BT 40	37,5	42	48	135 - 485	27	47,5	52,5	▲
	BT 50	37,5	42	48	160	38	47,5	52,5	<b>56835</b>
	BT 50	37,5	42	48	146 - 445	38	47,5	52,5	▲
<b>5/16"</b>	BT 40	43,5	48	48	139	27	111	55	<b>56826</b>
	BT 40	43,5	48	48	139 - 485	27	-----	55	▲
	BT 50	43,5	48	48	160	38	101	55	<b>56836</b>
	BT 50	43,5	48	48	150 - 445	38	-----	55	▲
<b>1 1/4"</b> ▲	BT 40	55,5	60	70	148	27	57	65	<b>56827</b>
	BT 40	55,5	60	70	148 - 485	27	57	65	▲
	BT 50	55,5	60	70	160	38	57	65	<b>56837</b>
	BT 50	55,5	60	70	159 - 445	38	57	65	▲

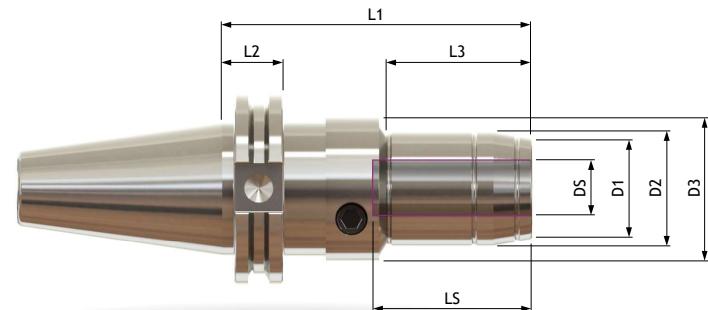
▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

## HYDROCHUCKS - INCH SIZES

CAT / ASME BS.50

HCF / HCF+



For chuck with Plus-membrane, specify + after art.no

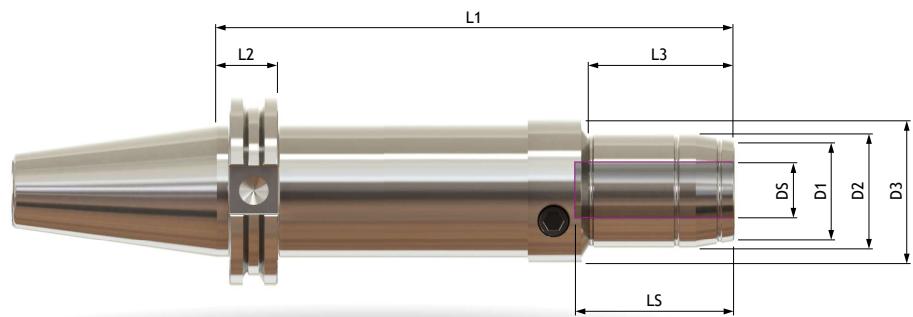
DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>1/4"</b>	CAT 40	21,5	26	48	105	19,05	43,5	37,5	<b>56580</b>
	CAT 50	21,5	26	48	87	19,05	43,5	37,5	<b>56790</b>
	CAT 50	21,5	26	48	101,6	19,05	43,5	37,5	<b>58600</b>
<b>5/16"</b>	CAT 40	23,5	28	48	105	19,05	43,5	37,5	<b>56581</b>
	CAT 50	23,5	28	48	87	19,05	43,5	37,5	<b>56791</b>
	CAT 50	23,5	28	48	101,6	19,05	43,5	37,5	<b>58601</b>
<b>3/8"</b>	CAT 40	25,5	30	48	105	19,05	43,5	42,5	<b>56582</b>
	CAT 50	25,5	30	48	87	19,05	43,5	42,5	<b>56792</b>
	CAT 50	25,5	30	48	101,6	19,05	43,5	42,5	<b>58602</b>
<b>1/2"</b>	CAT 40	27,5	32	48	105	19,05	43,5	47,5	<b>56583</b>
	CAT 50	27,5	32	48	87	19,05	43,5	47,5	<b>56793</b>
	CAT 50	27,5	32	48	101,6	19,05	43,5	47,5	<b>58603</b>
<b>5/8"</b>	CAT 40	33,5	38	48	105	19,05	47,5	52,5	<b>56584</b>
	CAT 50	33,5	38	48	87	19,05	47,5	52,5	<b>56794</b>
	CAT 50	33,5	38	48	101,6	19,05	47,5	52,5	<b>58604</b>
<b>3/4"</b>	CAT 40	37,5	42	48	105	19,05	47,5	52,5	<b>56585</b>
	CAT 50	37,5	42	48	87	19,05	47,5	52,5	<b>56795</b>
	CAT 50	37,5	42	48	101,6	19,05	47,5	52,5	<b>58605</b>
<b>1"</b>	CAT 40	43,5	48	48	109	19,05	89,95	55	<b>56586</b>
	CAT 50	43,5	48	48	91	19,05	82,95	55	<b>56796</b>
	CAT 50	43,5	48	48	105,6	19,05	82,95	55	<b>58606</b>
<b>1 1/4"</b>	CAT 40	55,5	60	70	118	19,05	57	65	<b>56587</b>
	CAT 50	55,5	60	70	100	19,05	57	65	<b>56797</b>
	CAT 50	55,5	60	70	114,6	19,05	57	65	<b>58607</b>

► = dimension compatible with reduction sleeve.

## HYDROCHUCKS - INCH SIZES

CAT / ASME BS.50

HCFL / HCFL+



For chuck with Plus-membrane, specify + after art.no

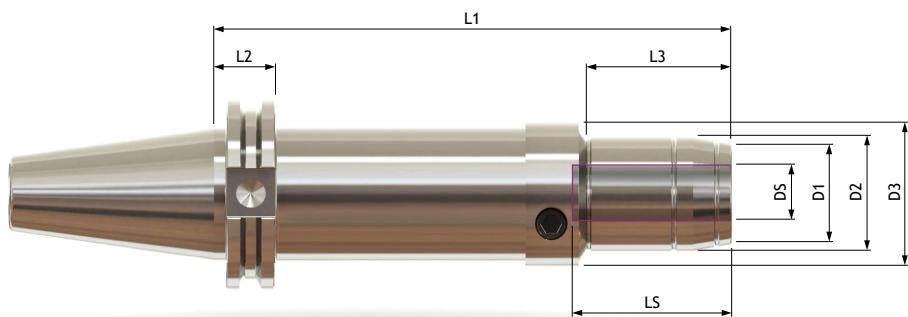
DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>1/4"</b>	CAT 40	21,5	26	48	127	19,05	43,5	37,5	<b>56780</b>
	CAT 40	21,5	26	48	127 - 480	19,05	43,5	37,5	▲
	CAT 50	21,5	26	48	152,4	19,05	43,5	37,5	<b>56740</b>
	CAT 50	21,5	26	48	127 - 445	19,05	43,5	37,5	▲
<b>5/16"</b>	CAT 40	23,5	28	48	127	19,05	43,5	37,5	<b>56781</b>
	CAT 40	23,5	28	48	127 - 480	19,05	43,5	37,5	▲
	CAT 50	23,5	28	48	152,4	19,05	43,5	37,5	<b>56741</b>
	CAT 50	23,5	28	48	127 - 445	19,05	43,5	37,5	▲
<b>3/8"</b>	CAT 40	25,5	30	48	127	19,05	43,5	42,5	<b>56782</b>
	CAT 40	25,5	30	48	127 - 480	19,05	43,5	42,5	▲
	CAT 50	25,5	30	48	152,4	19,05	43,5	42,5	<b>56742</b>
	CAT 50	25,5	30	48	127 - 445	19,05	43,5	42,5	▲
<b>1/2"</b>	CAT 40	27,5	32	48	127	19,05	43,5	47,5	<b>56783</b>
	CAT 40	27,5	32	48	127 - 480	19,05	43,5	47,5	▲
	CAT 50	27,5	32	48	152,4	19,05	43,5	47,5	<b>56743</b>
	CAT 50	27,5	32	48	127 - 445	19,05	43,5	47,5	▲
<b>5/8"</b>	CAT 40	33,5	38	48	127	19,05	47,5	52,5	<b>56784</b>
	CAT 40	33,5	38	48	127 - 480	19,05	47,5	52,5	▲
	CAT 50	33,5	38	48	152,4	19,05	47,5	52,5	<b>56744</b>
	CAT 50	33,5	38	48	127 - 445	19,05	47,5	52,5	▲

▲ = Specify art.no / L1 on order (L1 = length of your choice).

## HYDROCHUCKS - INCH SIZES

CAT / ASME BS.50

HCFL / HCFL+



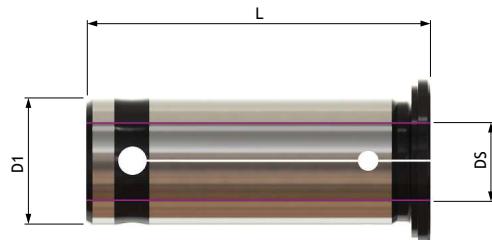
For chuck with Plus-membrane, specify + after art.no

DS Ømm	Mount type.	D1 Ømm	D2 Ømm	D3 Ømm	L1 mm	L2 mm	L3 mm	LS mm	Art.no
<b>3/4"</b> ▲	CAT 40	37,5	42	48	127	19,05	47,5	52,5	<b>56785</b>
	CAT 40	37,5	42	48	127 - 480	19,05	47,5	52,5	▲
	CAT 50	37,5	42	48	152,4	19,05	47,5	52,5	<b>56745</b>
	CAT 50	37,5	42	48	127 - 445	19,05	47,5	52,5	▲
<b>1"</b>	CAT 40	43,5	48	48	131	19,05	129,95	55	<b>56786</b>
	CAT 40	43,5	48	48	131 - 480	19,05	-----	55	▲
	CAT 50	43,5	48	48	152,4	19,05	142,4	55	<b>56746</b>
	CAT 50	43,5	48	48	131 - 445	19,05	-----	55	▲
<b>1 1/4"</b> ▲	CAT 40	55,5	60	70	160	19,05	57	65	<b>56787</b>
	CAT 40	55,5	60	70	160 - 480	19,05	-----	65	▲
	CAT 50	55,5	60	70	160	19,05	57	65	<b>56747</b>
	CAT 50	55,5	60	70	140 - 445	19,05	-----	65	▲

▲ = dimension compatible with reduction sleeve.

▲ = Specify art.no / L1 on order (L1 = length of your choice).

## Reduction Sleeves



Sealed sleeve with rubber stop.

Sleeves can be converted to unsealed by removing the rubber seal.

Other dimensions on request.

Reduction sleeves D = mm

D1 Ømm	DS Ømm	L mm	Art.no
<b>12</b>	3	44	<b>90003</b>
	4	44	<b>90004</b>
	5	44	<b>90005</b>
	6	44	<b>90006</b>
	8	44	<b>90008</b>
	10	44	<b>901010</b>
<b>20</b>	3	50	<b>90103</b>
	4	50	<b>90104</b>
	5	50	<b>90105</b>
	6	50	<b>90106</b>
	8	50	<b>90108</b>
	10	50	<b>90110</b>
	12	50	<b>90112</b>
	14	50	<b>90114</b>
	16	50	<b>90116</b>
<b>32</b>	6	63	<b>90206</b>
	8	63	<b>90208</b>
	10	63	<b>90210</b>
	12	63	<b>90212</b>
	14	63	<b>90214</b>
	16	63	<b>90216</b>
	18	63	<b>90218</b>
	20	63	<b>90220</b>
	25	63	<b>90225</b>

Reduction sleeves D = inch

D1 Ømm	DS Ømm	L mm	Art.no
<b>3/4"</b>	1/8"		<b>67960</b>
	5/32"		<b>67961</b>
	3/16"		<b>67962</b>
	1/4"		<b>67963</b>
	5/16"		<b>67964</b>
	3/8"		<b>67965</b>
	7/16"		<b>67966</b>
	1/2"		<b>67967</b>
	9/16"		<b>67968</b>
	5/8"		<b>67969</b>
<b>1 1/4"</b>	3/8"		<b>67980</b>
	1/2"		<b>67981</b>
	5/8"		<b>67982</b>
	3/4"		<b>67983</b>
	1"		<b>67984</b>

## Custom sleeves

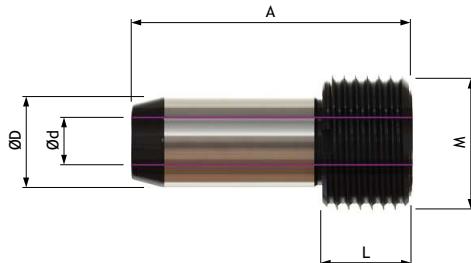
We also provide sleeves with custom clamping diameter (DS).

Please contact us for more info.

## HYDROCHUCKS

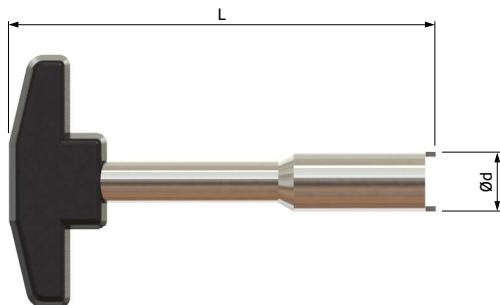
### Accessories

#### Coolant-adaptor for HSK



For HSK-size	ØD mm	A mm	Ød mm	L mm	M	Art.no
<b>HSK-A32 , HSK-E32 , HSK-F40</b>	6	25,7	3,5	5,5	M10 x 1	<b>HSKA.32.0100</b>
<b>HSK-A40 , HSK-E40 , HSK-F50</b>	8	29	5	7,5	M12 x 1	<b>HSKA.40.0120</b>
<b>HSK-A50 , HSK-E50 , HSK-F63</b>	10	33	6,4	10	M16 x 1	<b>HSKA.50.0160</b>
<b>HSK-A63 , HSK-E63 , HSK-F80</b>	12	36,2	8	11,5	M18 x 1	<b>HSKA.63.0180</b>
<b>HSK-A80 , HSK-E80 , HSK-F100</b>	14	39,6	10	13,5	M20 x 1,5	<b>HSKA.80.0200</b>
<b>HSK-A100 , HSK-E100 , HSK-F125</b>	16	43,6	12	15,5	M24 x 1,5	<b>HSKA.100.0240</b>

#### Key to coolant-adaptor for HSK



For HSK-size	ØD mm	L mm	Art.no
<b>HSK-A32 , HSK-E32 , HSK-F40</b>	9	110	<b>CH.HSK.0320</b>
<b>HSK-A40 , HSK-E40 , HSK-F50</b>	11	110	<b>CH.HSK.0400</b>
<b>HSK-A50 , HSK-E50 , HSK-F63</b>	15	120	<b>CH.HSK.0500</b>
<b>HSK-A63 , HSK-E63 , HSK-F80</b>	17	120	<b>CH.HSK.0630</b>
<b>HSK-A80 , HSK-E80 , HSK-F100</b>	18,5	130	<b>CH.HSK.0800</b>
<b>HSK-A100 , HSK-E100 , HSK-F125</b>	22	140	<b>CH.HSK.1000</b>

## HYDROCHUCKS

Customized hydrochuck solutions

Specially designed for you

SPV Spintec also manufactures hydraohucks in fully customized versions for e.g. odd machines that ar not equipped with a standard spindle mount. We meet the customers demands by designing and developing special chucks that fits the customers application. We manufacture special chucks for both internal and external clamping. The chucks can be designed for holding a tool or as a precision fixture for accurate clamping of a workpiece.



# HYDROCHUCKS

## Operating instructions

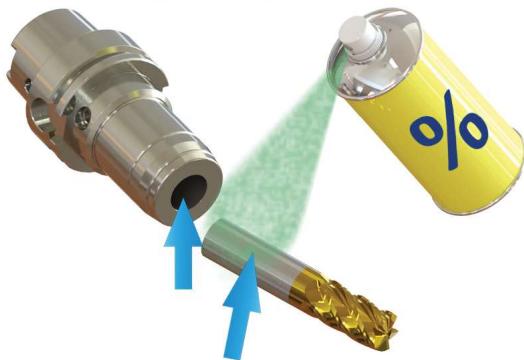
- **1. Working temperature**

Ideal and optimized working temperature is between 20° and 50°C. Do not store hydrochucks where the temperature could exceed 50°C.



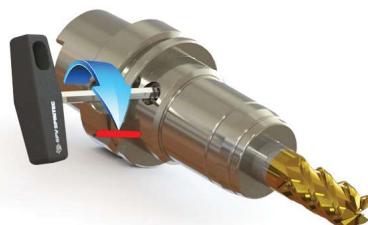
- **2. Cleaning**

It is very important that both the tool shaft and the inside of the hydrochuck are free from grease or other contamination. Use an alcohol based degreaser when cleaning the chuck and tool.



- **3. Tightening the membrane**

The screw must always be tightened to the fixed stop. No torque-key is needed. Never tighten the screw without a tool in the chuck, since there is a risk that the hydraulic chamber could be deformed.



- **4. Tool insertion length**

The tool must be inserted to a fixed stop, to prevent the hydraulic chamber from being deformed by the pressure. When reduction sleeves are used, at least 60% of the tool shaft length must be inserted and clamped.



- **5. Service and repair**

If you experience that your hydrochuck does not clamp properly, this can be due to several issues. A common explanation is that the hydraulic piston seal is worn out. We always recommend sending the chuck to us for service or repair. Contact us for more info.

## Important information about tool shafts.

- **Hydrochucks with standard membrane - HCF / HCFL / HCPS**

For standard chucks from Ø6 to Ø20 mm, Weldon-shafts can be used directly in the chuck.  
Shaft tolerance = h6

- **Hydrochucks with The Plus-membrane - HCF+ / HCFL+ / HCP+ / HCPK+ / HCK+**

For chucks with The Plus-membrane (+) only cylindrical shafts must be used directly in the chuck.  
Shaft tolerance = h6

- **Reduction sleeves - (Not suitable for HCK+)**

Other types of tool shafts such as Weldon, Whistlenotch etc can be used in combination with a reduction sleeve in the hydrochuck.

## Torque specifications

Chuck for tool Ø mm	HCF / HCF+	HCK+	HCP+	HCPK+	HCPS
<b>6</b>	15 Nm				
<b>8</b>	20 Nm				
<b>10</b>	40 Nm				
<b>12</b>	80 Nm		80 Nm	80 Nm	80 Nm
<b>14</b>	110 Nm				
<b>16</b>	130 Nm				
<b>18</b>	190 Nm				
<b>20</b>	320 Nm	600 Nm		320 Nm	
<b>25</b>	400 Nm				
<b>32</b>	650 Nm	1200 Nm			
<b>40</b>	1200 Nm				



### WARNING!

Disassembling and assembling a hydrochuck requires special tools and equipment.  
Always send the chuck to SPV Spintec representative if it needs to be repaired.

