

HSKA-SHRINK-FIT CHUCK

HSKA CHUCK FEATURES

Dynamic balancing grade: ≤G1.

High precision: Shank run-out accuracy: ≤0.002μm.

High axial and radial repeatability positioning precision.

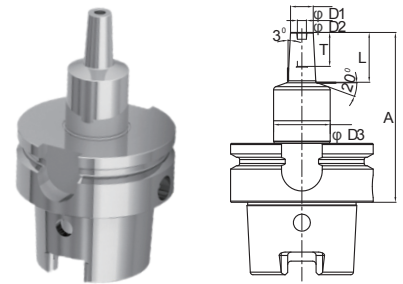
Repeatability positioning precision is ≤2μm.

Featuring high dynamic and static rigidity and stability, and high axial and radial accuracy, it ensures the accuracy of a product machined at high speed.

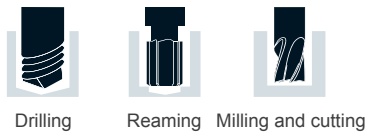
HSK shank is designed with a structure of hollow short taper shank. Compared with BT shank, HSK shank has a short length and light weight. With the power to change the cutter more quickly, it is especially suitable for high-speed machining.

Compared with the traditional carrier shank with the chuck, the shrink-fit shank has the following advantages:

1. Compact structure and high rigidity: The inner hole of the shank is directly connected with the cutter, without a middle carrier.
2. Large transmission torque: It can achieve a torque output 2 times or above that of an ordinary shank with ER chuck.
3. Wide adaptability and good machining surface quality: It is suitable for various kinds of rough and fine machining, with good machining surface quality.
4. High clamping accuracy: Generally, the clamping precision of the shank with the high-precision grade chuck is ≤0.005mm (at 4D position); but the run-out precision of the shrink-fit shank is ≤0.002mm (at 4D position)
5. Note: - The precision at the cutter shank is required to be H6.
 - The cutter is required to be made of tungsten steel, hard alloy, etc.
 - Adaptive induction heating type thermal shrinkage machine

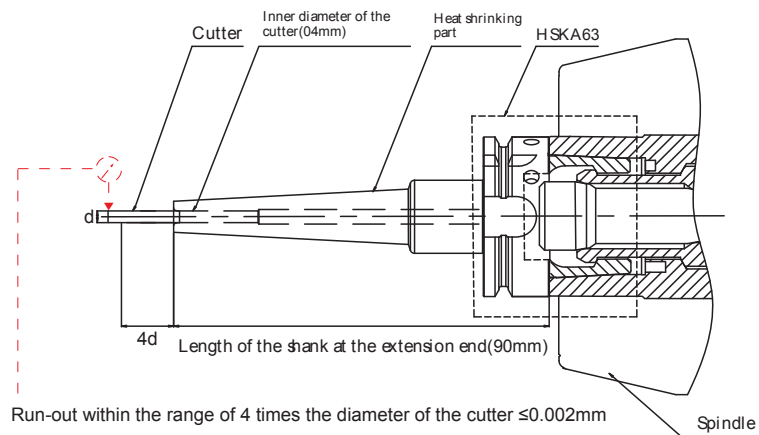


APPLICATION TYPE



SFHSKA63-04-090

Schematic Diagram



NAMING RULE:

SFHSKA63-04-090

Shrink-fit shank code

CHUCK TYPE
A | E

SHANK SPECIFICATION
25 | 32 | 40 | 50 | 63

LENGTH OF THE HOLDER AT THE EXTENSION END/mm (three-digit number)

04: INNER DIAMETER OF THE CUTTER/mm (two-digit number)

HSKA-SHRINK-FIT CHUCK

TECHNICAL PARAMETERS

Shank type	Order type	Dimensions						Diameter of the cutter to be used	Requirement for the precision of the cutter shank diameter	Applicable speed
		D	D1	D2	L	L1	clamping depth L2			
HSKA40	DSFHSKA40- 04- 090	4	10	10	90	20	12	φ4	H6	40000RPM
	DSFHSKA40- 06- 090	6	21	27	90		36	φ6		
	DSFHSKA40- 08- 090	8	21	27	90		36	φ8		
	DSFHSKA40- 10- 090	10	24	32	90		42	φ1 0		
	DSFHSKA40- 12- 090	12	24	32	90		47	φ1 2		
HSKA50	DSFHSKA50- 04- 090	4	10	10	90	26	12	φ4	H6	25000RPM
	DSFHSKA50- 06- 090	6	21	27	90		36	φ6		
	DSFHSKA50- 08- 090	8	21	27	90		36	φ8		
	DSFHSKA50- 10- 090	10	24	32	90		42	φ1 0		
	DSFHSKA50- 12- 090	12	24	32	90		47	φ1 2		
HSKA63	DSFHSKA63- 04- 090	4	10	10	90	26	12	φ4	H6	20000RPM
	130									
	DSFHSKA63- 06- 090	6	21	27	90		36	φ6		
	130									
	DSFHSKA63- 08- 090	8	21	27	90		36	φ8		
	130									
	DSFHSKA63- 10- 090	10	24	32	90		42	φ1 0		
	130									
	DSFHSKA63- 12- 090	12	24	32	90		47	φ1 2		
	130									
	DSFHSKA63- 14- 090	14	27	34	90		47	φ1 4		
	130									
	DSFHSKA63- 16- 090	16	24	34	90		50	φ1 6		
	130									
	DSFHSKA63- 18- 090	18	33	42	90		52	φ1 8		
	130									
	DSFHSKA63- 20- 090	20	33	42	90		52	φ2 0		
	130									
	DSFHSKA63- 25- 090	25	44	53	90		58	φ2 5		
	130									
DSFHSKA63- 32- 090	32	44	53	90	58	φ3 2				
130										