CLAMPING TECHNOLOGY

SHRINK CHUCKS
CLAMPING TECHNOLOGY

The optimal clamping tool for every application

On using tools, their connection to the machine spindle, and therefore the clamping technology, plays a central role that is often undervalued.

On fine machining parts, very good results can be achieved with the highest radial run-out accuracies. The effect is very significant even on drilling or milling, as lower radial variations have a positive effect on tool lives.

Manufactured with the latest technology, the clamping technology programme from WTE offers the perfect solution for every application and a connection that ensures the tool has the necessary performance, radial run-out and change-over accuracy in use. From the CNC precision drill chuck, through clamping tools with flange module, hydraulic and shrinking technology to adapters, the WTE standard programme covers a wide variety of systems and technologies. WTE offers a comprehensive standard programme also for machining with minimum quantity lubrication MQL.
STANDARD PROGRAMME

<table>
<thead>
<tr>
<th>Introduction</th>
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</table>

Milling | Turning | Reaming | Fine boring

Cutwel Ltd | Tel: 01924 869 610 | Email: sales@cutwel.net | Web: www.cutwel.co.uk
PRODUCT RANGE

1 Shrink Chucks
In long, short and heavy-duty design, however also with 3 degrees or KKB

2 HPH - High Performance Holder
In long, ultra-short and short heavy-duty design, however also with 3 degrees in additive design

3 Hydraulic Chuck
In long, ultra-short and short heavy-duty design as well as with compensation technology

4 NC Standard Drill Chucks

5 CNC Precision Drill Chucks
In all common shank forms

6 MICRO Universal Chucks
Also with cylindrical shank extension
# SELECTION OF A CHUCK

The optimal chuck for every application

<table>
<thead>
<tr>
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<th>Design</th>
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★ = 1st choice | ◆ = highly suitable | ■ = suitable in some situations | □ = not suitable

1) Short/heavy-duty design: Compact design for high rigidity.
2) With cooling channel bores: Chuck with additional decentral coolant outlets that, optionally, are resealable.
3) With compensation technology: Alignment function on the chuck for radial alignment feature for the compensation of radial run-out errors on the overall system.
4) Heavy-duty design: Reinforced contour for heavy-duty machining tasks, optionally with additional cooling channel bores.
Applications & features of WTE shrink technology

WTE shrink chucks are used on wood and metalworking machines with rotating tools. Shrink chucks make use of thermally-related expansion for tool clamping. The applications for these clamping tools range from a very wide range of milling tasks, through heavy machining, to woodworking or drilling applications.

WTE shrink chucks are in principle manufactured with internal coolant supply. Selected product groups are also available with collar cooling. Custom designs in relation to the usage of side cooling channel bores are possible at any time on request.

For automatic tool change, WTE shrink chucks are available in the designs ISO 7388-1 (DIN 69871), DIN 69893 HSK-A, DIN 69893 HSK-E, DIN 69893-F and ISO 7388-2 (JIS B6339).

For manual tool changing in the design DIN 69893 HSK-C.

Functional principle

1. Heating the chuck
   The chuck is heated specifically at the clamping point using the latest induction technology. For this purpose an induction coil generates quickly changing eddy currents that act directly on the shrink chuck and heats exactly in the place where the tool shank sits. The diameter of the bore expands.

2. Fitting the tool shank
   The cold tool shank is inserted in the heated shrink chuck.

3. Cooling
   The shrink chuck is cooled, the clamping diameter returns to its original size and clamps the tool shank. A powerful device with water-cooled cooling elements makes it possible to cool the chuck within 30 seconds. As a consequence there is no heating of the taper or the data chip. It is possible to cool extensions and non-standardised shrink chucks using adapters that can be fitted to the cooling element.

The result:
Tool changes can be realised in seconds due to the inductive heating. Shrink chuck and tool shank form a joint with force closure. It is possible to clamp carbide as well as HSS tools. The tool sits highly accurately with maximum clamping force in the tool adapter.
Description of length adjustment

1. Prior to the shrinking process, assemble tool (4), WTE length pre-adjuster (3) and WTE shrink chuck (1) with WTE stop screw (2).

2. Set length to the final dimension for the tool by turning the length pre-adjuster (this adjuster sets the stop screw to the required dimension). The required length (L) after shrinking is given by the pre-adjusted length (Lv) from \( L = Lv - 60 \) mm.

3. Remove length pre-adjuster and shrink tool. The tool must sit on the stop screw.

Additional information

Balancing value

All WTE shrink chucks are balanced as standard. For the balancing value, please refer to the individual article descriptions. Should you require other balancing values, the WTE shrink chucks can be balanced to meet your requirements.

Shrink chucks

Thanks to our many years of experience in the field of development, engineering and production of shrink chucks, we can develop shrink chucks according to your requirements and to manufacture them in a minimum of time. We look forward to receiving your enquiries.

Shrink chucks - heavy-duty design

For induction shrink units with 20 KVA on request.
Safe clamping & length adjustment

WTE shrink chucks are designed for the transmission of high transferable torques (holding forces). This characteristic is achieved by location bores and shrink fitting lengths optimally adapted to the material and the shrink units.

The length adjustment in the WTE shrink chuck is changed using an adjustment screw with an internal hexagon on both ends. There is a hole drilled through the middle of the screw for the internal coolant supply. The length adjustment can be made from both sides.
Technical data, WTE shrink chucks

- Workpiece material 1600-1800 N/mm²
- Hardness 52 ± 2HRc
- Tool holders balanced as standard
- Laser labelling
- Maximum spindle speed 40000 min⁻¹ (note spindle speed limit for connection, fine balancing recommended)
- Shrink temperature 100-420 °C
- Maximum shrink temperature 500 °C
- Coolant pressure maximum 80 bar
- Adjustment path 10 mm, from both sides
- Suitable for clamping: Cylindrical shanks, OD tolerance h6
- Shrinking and unshrinking carbide and HSS tools when using the corresponding shrink units

Permissible transferable torques, WTE shrink chucks

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## SHRINK CHUCKS

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Shrink Chuck DIN69871, Form AD

### STANDARD PROGRAMME

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#### Dimensions

![Shrink Chuck Diagram](image_url)

**ISO 7388-1 Form AD**

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**Dimensions in mm.**

Shrink extensions, spare parts and accessories at the end of this chapter.

Custom designs available on request.
Shrink Chuck DIN69871, Form AD/AF

### Standard Programme

Shrink Chucks

DIN69871, Form AD/AF

Dimensions in mm.

Basic form AD. Please indicate form AF (prev. B) in your order.

Shrink extensions, spare parts and accessories at the end of this chapter.

Custom designs available on request.

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(prev. DIN 69871-AD/B), long design

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Dimensions in mm.
Basic form AD. Please indicate form AF (prev. B) in your order.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN69871, Form AD/AF
(prev. DIN 69871-AD/B), long design

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Dimensions in mm.
Basic form AD. Please indicate form AF (prev. B) in your order.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.

Made in Germany

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## Shrink Chuck DIN69871, Form AD/AF
(prev. DIN 69871-AD/B), narrow design, 3°

![Image](image.png)

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Dimensions in mm.

Basic form AD. Please indicate form AF (prev. B) in your order.

Shrink extensions, spare parts and accessories at the end of this chapter.

Custom designs available on request.

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**STANDARD PROGRAMME**

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DIN69871, Form AD/AF (prev. DIN 69871-AD/B), narrow design, 3°

Dimensions G sw Weight [kg]

Order designation Order No.
### Shrink Chuck DIN69871, Form AD/AF

(prev. DIN 69871-AD/B), long narrow design, 3°

#### Dimensions

| d₁ | d₂ | d₃ | l₁ | l₂ | l₃ | l₄ | G | sw | Weight [kg] | Order designation | Order No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40 | 3 | 9 | 16 | 120 | - | - | 12 | - | - | 0.9 | 15.304.40.03.Z/120 | 30385322 |
| 40 | 3 | 9 | 19 | 160 | - | - | 12 | - | - | 1.1 | 15.304.40.03.Z/160 | 30385323 |
| 40 | 3 | 9 | 19 | 200 | - | - | 12 | - | - | 1.2 | 15.304.40.03.Z/200 | 30596516 |
| 40 | 4 | 10 | 17 | 120 | - | - | 16 | - | - | 0.9 | 15.304.40.04.Z/120 | 30385325 |
| 40 | 4 | 10 | 20 | 160 | - | - | 16 | - | - | 1.1 | 15.304.40.04.Z/160 | 30385326 |
| 40 | 4 | 10 | 20 | 200 | - | - | 16 | - | - | 1.2 | 15.304.40.04.Z/200 | 30596517 |
| 40 | 5 | 11 | 18 | 120 | - | - | 20 | - | - | 1 | 15.304.40.05.Z/120 | 30385328 |
| 40 | 5 | 11 | 21 | 160 | - | - | 20 | - | - | 1.1 | 15.304.40.05.Z/160 | 30385329 |
| 40 | 5 | 11 | 21 | 200 | - | - | 20 | - | - | 1.2 | 15.304.40.05.Z/200 | 30596518 |
| 40 | 6 | 12 | 22 | 120 | 36 | 10 | 26 | M5 | 2.5 | 1 | 15.304.40.06.Z/120 | 30385331 |
| 40 | 6 | 12 | 24 | 160 | 36 | 10 | 26 | M5 | 2.5 | 1.1 | 15.304.40.06.Z/160 | 30385332 |
| 40 | 6 | 12 | 24 | 200 | 36 | 10 | 26 | M5 | 2.5 | 1.4 | 15.304.40.06.Z/200 | 30596519 |
| 40 | 8 | 14 | 24 | 120 | 36 | 10 | 26 | M6 | 3 | 1 | 15.304.40.08.Z/120 | 30385334 |
| 40 | 8 | 14 | 26 | 160 | 36 | 10 | 26 | M6 | 3 | 1.2 | 15.304.40.08.Z/160 | 30385335 |
| 40 | 8 | 14 | 26 | 200 | 36 | 10 | 26 | M6 | 3 | 1.4 | 15.304.40.08.Z/200 | 30596520 |
| 40 | 10 | 16 | 26 | 120 | 41 | 10 | 31 | M6x1 | 3 | 1 | 15.304.40.10.Z/120 | 30385337 |
| 40 | 10 | 16 | 26 | 160 | 41 | 10 | 31 | M6x1 | 3 | 1.2 | 15.304.40.10.Z/160 | 30385338 |
| 40 | 10 | 16 | 26 | 200 | 41 | 10 | 31 | M6x1 | 3 | 1.6 | 15.304.40.10.Z/200 | 30596521 |
| 40 | 12 | 18 | 28 | 120 | 47 | 10 | 37 | M10x1 | 5 | 1 | 15.304.40.12.Z/120 | 30385340 |
| 40 | 12 | 18 | 30 | 160 | 47 | 10 | 37 | M10x1 | 5 | 1.3 | 15.304.40.12.Z/160 | 30385341 |
| 40 | 12 | 18 | 30 | 200 | 47 | 10 | 37 | M10x1 | 5 | 1.5 | 15.304.40.12.Z/200 | 30596522 |
| 40 | 14 | 20 | 32 | 120 | 47 | 10 | 37 | M10x1 | 5 | 1.1 | 15.304.40.14.Z/120 | 30385343 |
| 40 | 14 | 20 | 32 | 160 | 47 | 10 | 37 | M10x1 | 5 | 1.3 | 15.304.40.14.Z/160 | 30385344 |
| 40 | 14 | 20 | 32 | 200 | 47 | 10 | 37 | M10x1 | 5 | 1.6 | 15.304.40.14.Z/200 | 30596523 |
| 40 | 16 | 22 | 32 | 120 | 50 | 10 | 40 | M12x1 | 5 | 1 | 15.304.40.16.Z/120 | 30385346 |
| 40 | 16 | 22 | 32 | 160 | 50 | 10 | 40 | M12x1 | 5 | 1.2 | 15.304.40.16.Z/160 | 30385347 |
| 40 | 16 | 22 | 32 | 200 | 50 | 10 | 40 | M12x1 | 5 | 2.6 | 15.304.40.16.Z/200 | 30596525 |
| 40 | 18 | 24 | 34 | 120 | 50 | 10 | 40 | M12x1 | 5 | 1 | 15.304.40.18.Z/120 | 30385349 |
| 40 | 18 | 24 | 34 | 160 | 50 | 10 | 40 | M12x1 | 5 | 1.5 | 15.304.40.18.Z/160 | 30385350 |
| 40 | 18 | 24 | 34 | 200 | 50 | 10 | 40 | M12x1 | 5 | 2.8 | 15.304.40.18.Z/200 | 30596526 |
| 40 | 20 | 26 | 36 | 120 | 52 | 10 | 42 | M16x1 | 8 | 1.2 | 15.304.40.20.Z/120 | 30385352 |
| 40 | 20 | 26 | 36 | 160 | 52 | 10 | 42 | M16x1 | 8 | 1.6 | 15.304.40.20.Z/160 | 30385353 |
| 40 | 20 | 26 | 36 | 200 | 52 | 10 | 42 | M16x1 | 8 | 2.9 | 15.304.40.20.Z/200 | 30596528 |

Dimensions in mm.

Basic form AD. Please indicate form AF (prev. B) in your order.

Shrink extensions, spare parts and accessories at the end of this chapter.

Custom designs available on request.
# Shrink Chuck ISO DIN69871, Form AD/AF
(prev. DIN 69871-AD/B), with resealable coolant duct holes

---

**Nominal size** | **Dimensions** | **G** | **sw** | **Weight [kg]** | **Order designation** | **Order No.**
--- | --- | --- | --- | --- | --- | ---
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40 | 4 15 22 80 28 12 16 | M6 | 2 | 0.9 | 15.306.40.04.KKB | 30590787
40 | 5 15 22 80 30 10 20 | M6 | 2 | 0.9 | 15.306.40.05.KKB | 30590789
40 | 6 21 27 80 36 10 26 | M5 | 2.5 | 1 | 15.306.40.06.KKB | 30588645
40 | 8 21 27 80 36 10 26 | M6 | 3 | 1 | 15.306.40.08.KKB | 30589849
40 | 10 24 32 80 41 10 31 | M8x1 | 3 | 1 | 15.306.40.10.KKB | 30589850
40 | 12 24 32 80 47 10 37 | M10x1 | 5 | 1 | 15.306.40.12.KKB | 30589852
40 | 14 27 34 80 50 10 40 | M10x1 | 5 | 1 | 15.306.40.14.KKB | 30589853
40 | 16 27 34 80 50 10 40 | M12x1 | 5 | 1 | 15.306.40.16.KKB | 30589855
40 | 18 33 42 80 50 10 40 | M12x1_KKB | 5 | 1.1 | 15.306.40.18.KKB | 30589857
40 | 20 33 42 80 52 10 42 | M16x1_KKB | 5 | 1.1 | 15.306.40.20.KKB | 30589858
40 | 25 44 53 100 58 10 48 | M16x1 | 8 | 1.6 | 15.306.40.25.KKB | 30589870
40 | 32 44 53 100 62 10 52 | M16x1_KKB | 5 | 1.4 | 15.306.40.32.KKB | 30589872

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Dimensions in mm.
Basic form AD. Please indicate form AF (prev. B) in your order.
Standard design with two coolant duct holes.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.

---

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Shrink Chuck DIN69871, Form AD/AF
(prev. DIN 69871-AD/B), with resealable coolant duct holes

Nominal size | Dimensions | G | sw | Weight [kg] | Order designation | Order No.
--- | --- | --- | --- | --- | --- | ---
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40 | 4 | 10 | 17 | 120 | - | - | 16 | - | - | 1 | 15.306.40.04.120.KKB | 30590793
40 | 5 | 11 | 18 | 120 | - | - | 20 | - | - | 1 | 15.306.40.05.120.KKB | 30590794
40 | 6 | 12 | 22 | 120 | 36 | 10 | 26 | M5 | 2.5 | 1.1 | 15.306.40.06.120.KKB | 30588873
40 | 8 | 14 | 24 | 120 | 36 | 10 | 26 | M6 | 3 | 1.1 | 15.306.40.08.120.KKB | 30588874
40 | 10 | 16 | 26 | 120 | 41 | 10 | 31 | M8x1 | 3 | 1.2 | 15.306.40.10.120.KKB | 30588875
40 | 12 | 18 | 28 | 120 | 47 | 10 | 37 | M10x1 | 5 | 1.2 | 15.306.40.12.120.KKB | 30588876
40 | 14 | 20 | 30 | 120 | 47 | 10 | 37 | M10x1 | 5 | 1.3 | 15.306.40.14.120.KKB | 30588877
40 | 16 | 22 | 32 | 120 | 50 | 10 | 40 | M12x1_KKB | 5 | 1.3 | 15.306.40.16.120.KKB | 30588879
40 | 18 | 24 | 34 | 120 | 50 | 10 | 40 | M12x1_KKB | 5 | 1.5 | 15.306.40.18.120.KKB | 30588880
40 | 20 | 26 | 36 | 120 | 52 | 10 | 42 | M16x1_KKB | 5 | 1.5 | 15.306.40.20.120.KKB | 30588881
40 | 25 | 44 | 53 | 120 | 58 | 10 | 48 | M16x1 | 8 | 1.8 | 15.306.40.25.120.KKB | 30588882
40 | 32 | 44 | 53 | 120 | 62 | 10 | 52 | M16x1_KKB | 5 | 1.7 | 15.306.40.32.120.KKB | 30588883

Dimensions in mm.
Basic form AD. Please indicate form AF (prev. B) in your order.
Standard design with two coolant duct holes.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck ISO DIN 69871, Form AD/AF

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Dimensions in mm.
Basic form AD. Please indicate form AF (prev. B) in your order.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
### Shrink Chuck DIN69871, Form AD/AF

(prev. DIN 69871-AD/B), long design

![Diagram of Shrink Chuck DIN69871, Form AD/AF](image)

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Dimensions in mm.

Basic form AD. Please indicate form AF (prev. B) in your order.

Shrink extensions, spare parts and accessories at the end of this chapter.

Custom designs available on request.

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Made in Germany

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**STANDARD PROGRAMME**

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Cutwel Ltd | Tel: 01924 869 610 | Email: sales@cutwel.net | Web: www.cutwel.co.uk
Shrink Chuck

Volume Shrink, DIN69871, Form AD/AF
(prev. DIN 69871-AD/B), with resealable coolant duct holes

Dimensions in mm.
Basic form AD. Please indicate form AF (prev. B) in your order.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.

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Shrink Chuck
Volume Shrink, DIN69871, Form AD/AF
(prev. DIN 69871-AD/B), long design, with resealable coolant duct holes

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50 | 10 24 32.7 79.5 160 41 | 10 | 31 | 55 | M8x1_KKB | 3 | 5.1 | 15.307.50.10.160.KKB | 30655203
50 | 12 24 33.4 79.5 160 47 | 10 | 37 | 60 | M10x1_KKB | 5 | 5 | 15.307.50.12.160.KKB | 30655204
50 | 16 27 37.2 79.5 160 50 | 10 | 40 | 65 | M12x1_KKB | 5 | 5 | 15.307.50.16.160.KKB | 30655205
50 | 20 33 44 79.5 160 52 | 10 | 52 | 70 | M16x1_KKB | 5 | 5.1 | 15.307.50.20.160.KKB | 30655206
50 | 25 44 55.8 79.5 160 58 | 10 | 48 | 75 | M16x1_KKB | 5 | 5.6 | 15.307.50.25.160.KKB | 30655207
50 | 32 44 56.6 79.5 160 62 | 10 | 52 | 80 | M16x1_KKB | 5 | 5.4 | 15.307.50.32.160.KKB | 30655208

Dimensions in mm.
Basic form AD. Please indicate form AF (prev. B) in your order.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN 69893 HSK-A

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Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
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Dimensions in mm.
MQL-capable design possible on request.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
### Shrink Chuck DIN 69893 HSK-A

**Long design**

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**Dimensions in mm,**

- MQL-capable design possible on request.
- Shrink extensions, spare parts and accessories at the end of this chapter.
- Custom designs available on request.
## Shrink Chuck DIN 69893 HSK-A

![Shrink Chuck Diagram](image)

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Dimensions in mm.
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Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN 69893 HSK-A
Long design

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Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
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Dimensions in mm.
MQL-capable design possible on request.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN 69893 HSK-A
Long design

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Dimensions in mm.
MQL-capable design possible on request.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
# Shrink Chuck DIN 69893 HSK-A

## Long design

![Shrink Chuck Diagram](image)

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- **Nominal size**: HSK-A
- **Dimensions**: All dimensions are in mm.
- **G**: Shank type
- **sw**: Shank width
- **Weight**: Weight in kg
- **Order designation**: Order code
- **Order No.**: Order number

**Dimensions in mm.**

MQL-capable design possible on request.

Shrink extensions, spare parts and accessories at the end of this chapter.

Custom designs available on request.
Shrink Chuck DIN 69893 HSK-A
Narrow design, 3°

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Dimensions in mm.
MQL-capable design possible on request.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
### Shrink Chuck DIN 69893 HSK-A

**Long narrow design, 3°**

![Shrink Chuck Diagram]

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**Dimensions**

- d₁: Diameter 1
- d₂: Diameter 2
- d₃: Diameter 3
- l₁: Length 1
- l₂: Length 2
- l₃: Length 3
- l₄: Length 4

**Dimensions in mm.**

**G**: Shank diameter

**sw**: Shank width

**Weight**: [kg]

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**Custom designs available on request.**

**MQL-capable design possible on request.**

**Shrink extensions, spare parts and accessories at the end of this chapter.**

---

**STANDARD PROGRAMME**

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- DIN 69893
- HSK-A
- Dimensions G sw
- Weight [kg]
- Order designation
- Order No.

---

**Made in Germany**

**Shrink Chuck**

**Nominal size**

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- Long narrow design, 3°
- Custom designs available on request.
- MQL-capable design possible on request.
- Shrink extensions, spare parts and accessories at the end of this chapter.
## Shrink Chuck DIN 69893 HSK-A

With resealable coolant duct holes

![Diagram of the Shrink Chuck DIN 69893 HSK-A](image)

### Table: Shrink Chuck DIN 69893 HSK-A

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Dimensions in mm.
MQL-capable design possible on request.
Standard design with two coolant duct holes.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.

---

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## Shrink Chuck DIN 69893 HSK-A

Long design, with resealable coolant duct holes

![Image of Shrink Chuck]

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### Dimensions

- d₁, d₂, d₃: Dimensions in mm.
- l₁, l₂, l₃, l₄: Dimensions in mm.

### G, sw, Weight

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**Dimensions in mm.**
- **MQL-capable design possible on request.**
- **Standard design with two coolant duct holes.**
- **Shrink extensions, spare parts and accessories at the end of this chapter.**
- **Custom designs available on request.**

---

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Shrink Chuck Volume Shrink, DIN 69893 HSK-A
With resealable coolant duct holes

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Standard design with two coolant duct holes.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck Volume Shrink, DIN 69893 HSK-A
Long design, with resealable coolant duct holes

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Dimensions in mm.
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Standard design with two coolant duct holes.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN 69893 HSK-A

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Dimensions in mm.
MQL-capable design possible on request.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
### Shrink Chuck DIN 69893 HSK-A

**Long design**

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Dimensions in mm.
MQL-capable design possible on request.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN 69893 HSK-A

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Dimensions in mm.
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Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
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**Long design**

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Dimensions in mm.
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Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN 69893 HSK-A
Narrow design, 3°

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Dimensions in mm.
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Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
## Shrink Chuck DIN 69893 HSK-A

### Long narrow design, 3°

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**Dimensions in mm.**

MQL-capable design possible on request.

Shrink extensions, spare parts and accessories at the end of this chapter.

Custom designs available on request.
Shrink Chuck Volume Shrink DIN 69893 HSK-A

With resealable coolant duct holes

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Dimensions in mm.
MQL-capable design possible on request.
Standard design with two coolant duct holes.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck Volume Shrink DIN 69893 HSK-A
Long design, with resealable coolant duct holes

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HSK-A

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Dimensions in mm.
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Standard design with two coolant duct holes.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
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Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
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Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN 69893 HSK-C
Long design

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40 | 4 15 22 120 - - 16 | - | - | 0.4 | 23.306.40.04.Z/120 | 30385051
40 | 4 15 22 160 - - 16 | - | - | 0.5 | 23.306.40.04.Z/160 | 30385072
40 | 5 15 22 120 - - 20 | - | - | 0.4 | 23.306.40.05.Z/120 | 30385073
40 | 5 15 22 160 - - 20 | - | - | 0.5 | 23.306.40.05.Z/160 | 30385074
40 | 6 21 30 120 16 10 26 | M5 | 2.5 | 0.5 | 23.306.40.06.Z/120 | 30385055
40 | 6 21 30 160 16 10 26 | M5 | 2.5 | 0.6 | 23.306.40.06.Z/160 | 30385078
40 | 8 21 30 120 16 10 26 | M6 | 3 | 0.5 | 23.306.40.08.Z/120 | 30385056
40 | 8 21 30 160 16 10 26 | M6 | 3 | 0.6 | 23.306.40.08.Z/160 | 30385081
40 | 10 24 33.5 120 26 10 31 | M8x1 | 3 | 0.6 | 23.306.40.10.Z/120 | 30385057
40 | 10 24 33.5 160 26 10 31 | M8x1 | 3 | 0.7 | 23.306.40.10.Z/160 | 30385086
40 | 12 24 35 120 26 10 37 | M10x1 | 5 | 0.6 | 23.306.40.12.Z/120 | 30385058
40 | 12 24 35 160 26 10 37 | M10x1 | 5 | 0.7 | 23.306.40.12.Z/160 | 30385088
40 | 14 27 38 120 26 10 37 | M10x1 | 5 | 0.6 | 23.306.40.14.Z/120 | 30385059
40 | 14 27 38 160 26 10 37 | M10x1 | 5 | 0.7 | 23.306.40.14.Z/160 | 30385089
40 | 16 27 38 120 50 10 40 | M12x1 | 5 | 0.7 | 23.306.40.16.Z/120 | 30385061
40 | 16 27 38 160 50 10 40 | M12x1 | 5 | 0.8 | 23.306.40.16.Z/160 | 30385090

Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
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Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN 69893 HSK-C
Long design

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Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
## Shrink Chuck DIN 69893 HSK-C

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Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
# Shrink Chuck DIN 69893 HSK-C

## Long design

![Diagram of Shrink Chuck DIN 69893 HSK-C]

| Nominal size HSK-C | d₁ | d₂ | d₃ | l₁ | l₂ | l₃ | l₄ | G | sw | Weight [kg] | Order designation | Order No. |
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| 63                | 4  | 15 | 22 | 120| -  | -  | -  | -  | -  | -            | 23.306.63.04.Z/120| 30385262 |
| 63                | 4  | 15 | 22 | 200| -  | -  | -  | -  | -  | -            | 23.306.63.04.Z/200| 30386161 |
| 63                | 5  | 15 | 22 | 120| -  | -  | -  | -  | -  | -            | 23.306.63.05.Z/120| 30385263 |
| 63                | 5  | 15 | 22 | 200| -  | -  | -  | -  | -  | -            | 23.306.63.05.Z/200| 30386164 |
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| 63                | 6  | 21 | 30 | 200| 36 | 10 | 26 | -  | M5 | 2.5 | 0.9        | 23.306.63.06.Z/200| 30386168 |
| 63                | 8  | 21 | 30 | 120| 36 | 10 | 26 | -  | M6 | 3   | 0.8        | 23.306.63.08.Z/120| 30377877 |
| 63                | 8  | 21 | 27 | 160| 36 | 10 | 26 | -  | M6 | 3   | 0.9        | 23.306.63.08.Z/160| 30386168 |
| 63                | 10 | 24 | 34 | 120| 41 | 10 | 31 | -  | M8x1| 3   | 0.9        | 23.306.63.10.Z/120| 30377878 |
| 63                | 10 | 24 | 34 | 160| 41 | 10 | 31 | -  | M8x1| 3   | 1          | 23.306.63.10.Z/160| 30377879 |
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| 63                | 12 | 24 | 34 | 160| 47 | 10 | 37 | -  | M10x1| 5   | 1          | 23.306.63.12.Z/160| 30386169 |
| 63                | 14 | 27 | 36 | 120| 47 | 10 | 37 | -  | M10x1| 5   | 0.9        | 23.306.63.14.Z/120| 30385265 |
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| 63                | 16 | 27 | 36 | 120| 50 | 10 | 40 | -  | M12x1| 5   | 0.9        | 23.306.63.16.Z/120| 30377914 |
| 63                | 16 | 27 | 36 | 160| 50 | 10 | 40 | -  | M12x1| 5   | 1          | 23.306.63.16.Z/160| 30386173 |
| 63                | 18 | 33 | 44 | 120| 50 | 10 | 40 | -  | M12x1| 5   | 1.1        | 23.306.63.18.Z/120| 30377966 |
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| 63                | 20 | 33 | 45 | 120| 52 | 10 | 42 | -  | M16x1| 5   | 1.1        | 23.306.63.20.Z/120| 30385266 |
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Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN 69893 HSK-E

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Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN 69893 HSK-E

![Shrink Chuck Diagram]

**Nominal size HSK-E | d₁ | d₂ | d₃ | l₁ | l₂ | l₃ | l₄ | G | sw | Weight [kg] | Order designation | Order No.**

| 40  | 3  | 10 | 15 | 60 | 28 | 16 | 12 | M6 | 2  | 0.3 | 18.306.40.03.Z | 30337547 |
| 40  | 4  | 10 | 15 | 60 | 28 | 12 | 16 | M6 | 2  | 0.3 | 18.306.40.04.Z | 30337550 |
| 40  | 5  | 10 | 15 | 60 | 30 | 10 | 20 | M6 | 2  | 0.3 | 18.306.40.05.Z | 30337553 |
| 40  | 6  | 21 | 27 | 80 | 36 | 10 | 26 | M5 | 2.5 | 0.4 | 18.306.40.06.Z | 30337556 |
| 40  | 8  | 21 | 27 | 80 | 36 | 10 | 26 | M6 | 3  | 0.4 | 18.306.40.08.Z | 30337559 |
| 40  | 10 | 24 | 32 | 80 | 41 | 10 | 31 | M8x1 | 3 | 0.5 | 18.306.40.10.Z | 30337562 |
| 40  | 12 | 24 | 32 | 90 | 47 | 10 | 37 | M10x1 | 5 | 0.5 | 18.306.40.12.Z | 30337565 |
| 40  | 14 | 27 | 33.5| 90 | 47 | 10 | 37 | M10x1 | 5 | 0.6 | 18.306.40.14.Z | 30337568 |
| 40  | 16 | 27 | 33.5| 90 | 50 | 10 | 40 | M12x1 | 5 | 0.5 | 18.306.40.16.Z | 30337571 |

Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN 69893 HSK-E

Shrink Chuck DIN 69893 HSK-E
Long design

Nominal size HSK-E | Dimensions | G | sw | Weight [kg] | Order designation | Order No.
--- | --- | --- | --- | --- | --- | ---
40 | 3 10 20 120 - - 12 - - | 0.4 | 18.306.40.03.Z/120 | 30337548
40 | 3 10 20 160 - - 12 - - | 0.5 | 18.306.40.03.Z/160 | 30337549
40 | 4 15 22 120 - - 16 - - | 0.4 | 18.306.40.04.Z/120 | 30337551
40 | 4 15 22 160 - - 16 - - | 0.5 | 18.306.40.04.Z/160 | 30337552
40 | 5 15 22 120 - - 20 - - | 0.4 | 18.306.40.05.Z/120 | 30337554
40 | 5 15 22 160 - - 20 - - | 0.5 | 18.306.40.05.Z/160 | 30337555
40 | 6 21 27 120 36 10 26 | M5 | 2.5 | 18.306.40.06.Z/120 | 30337557
40 | 6 21 27 160 36 10 26 | M5 | 2.5 | 18.306.40.06.Z/160 | 30337558
40 | 8 21 27 120 36 10 26 | M6 | 3 | 18.306.40.08.Z/120 | 30337560
40 | 8 21 27 160 36 10 26 | M6 | 3 | 18.306.40.08.Z/160 | 30337561
40 | 10 24 32 120 41 10 31 | M8x1 | 3 | 18.306.40.10.Z/120 | 30337563
40 | 10 24 32 160 41 10 31 | M8x1 | 3 | 18.306.40.10.Z/160 | 30337564
40 | 12 24 32 120 47 10 37 | M10x1 | 5 | 18.306.40.12.Z/120 | 30337566
40 | 12 24 32 160 47 10 37 | M10x1 | 5 | 18.306.40.12.Z/160 | 30337567
40 | 14 27 33.5 120 47 10 37 | M10x1 | 5 | 18.306.40.14.Z/120 | 30337569
40 | 14 27 33.5 160 47 10 37 | M10x1 | 5 | 18.306.40.14.Z/160 | 30337570
40 | 16 27 33.5 120 50 10 40 | M12x1 | 5 | 18.306.40.16.Z/120 | 30337572
40 | 16 27 33.5 160 50 10 40 | M12x1 | 5 | 18.306.40.16.Z/160 | 30337573

Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
### Shrink Chuck DIN 69893 HSK-E

**Narrow design, 3°**

#### Dimensions in mm.

- Shrink extensions, spare parts and accessories at the end of this chapter.
- Custom designs available on request.

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Shrink Chuck DIN 69893 HSK-E

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Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
### Shrink Chuck DIN 69893 HSK-E

Long design

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Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
## Shrink Chuck DIN 69893 HSK-E

Narrow design, 3°

![Shrink Chuck Diagram](image)

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Dimensions in mm.

Shrink extensions, spare parts and accessories at the end of this chapter.

Custom designs available on request.
Shrink Chuck DIN 69893 HSK-E

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Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN 69893 HSK-E
Long design

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63 | 3 10 20 160 - - 12 | - | - | 0.9 | 18.306.63.03.Z/160 | 30337609  
63 | 4 15 22 120 - - 16 | - | - | 0.8 | 18.306.63.04.Z/120 | 30337611  
63 | 4 15 22 160 - - 16 | - | - | 0.9 | 18.306.63.04.Z/160 | 30337612  
63 | 5 15 22 120 - - 20 | - | - | 0.8 | 18.306.63.05.Z/120 | 30337614  
63 | 5 15 22 160 - - 20 | - | - | 0.9 | 18.306.63.05.Z/160 | 30337615  
63 | 6 21 27 120 36 10 26 | M5 | 2.5 | 1 | 18.306.63.06.Z/120 | 30337617  
63 | 6 21 27 160 36 10 26 | M5 | 2.5 | 1 | 18.306.63.06.Z/160 | 30337618  
63 | 6 21 27 160 36 10 26 | M6 | 3 | 0.9 | 18.306.63.08.Z/120 | 30337620  
63 | 8 21 27 160 36 10 26 | M6 | 3 | 18.306.63.08.Z/160 | 30337621  
63 | 10 24 32 120 41 10 31 | M8x1 | 3 | 1 | 18.306.63.10.Z/120 | 30337623  
63 | 10 24 32 160 41 10 31 | M8x1 | 3 | 1.1 | 18.306.63.10.Z/160 | 30337624  
63 | 12 24 32 120 47 10 37 | M10x1 | 5 | 1 | 18.306.63.12.Z/120 | 30337626  
63 | 12 24 32 160 47 10 37 | M10x1 | 5 | 1 | 18.306.63.12.Z/160 | 30337627  
63 | 12 24 32 160 47 10 37 | M10x1 | 5 | 1.1 | 18.306.63.14.Z/120 | 30337629  
63 | 14 27 34 120 47 10 37 | M10x1 | 5 | 1.2 | 18.306.63.14.Z/160 | 30337630  
63 | 14 27 34 160 47 10 37 | M10x1 | 5 | 1.2 | 18.306.63.16.Z/120 | 30337632  
63 | 16 27 34 120 50 10 40 | M12x1 | 5 | 1.4 | 18.306.63.16.Z/160 | 30337633  
63 | 16 27 34 160 50 10 40 | M12x1 | 5 | 1.5 | 18.306.63.18.Z/120 | 30337635  
63 | 16 27 34 160 50 10 40 | M12x1 | 5 | 1.3 | 18.306.63.18.Z/160 | 30337636  
63 | 20 33 42 120 52 10 42 | M16x1 | 5 | 1.3 | 18.306.63.20.Z/120 | 30337638  
63 | 20 33 42 160 52 10 42 | M16x1 | 5 | 1.5 | 18.306.63.20.Z/160 | 30337639  
63 | 25 44 53 120 58 10 48 | M16x1 | 5 | 1.6 | 18.306.63.25.Z/120 | 30337641  
63 | 25 44 53 160 58 10 48 | M16x1 | 5 | 1.8 | 18.306.63.25.Z/160 | 30337642  
63 | 32 44 53 160 62 10 52 | M16x1 | 5 | 1.7 | 18.306.63.32.Z/160 | 30337644  

Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
Shrink Chuck DIN 69893 HSK-E
Narrow design, 3°

![Diagram of shrink chuck dimensions]

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Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
### Shrink Chuck DIN 69893 HSK-E

**Long narrow design, 3°**

![Diagram of shrink chuck](image)

#### Dimensions in mm.

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Custom designs available on request.
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Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.
# Shrink Chuck DIN 69893 HSK-F

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Custom designs available on request.
Shrink Chuck DIN 69893 HSK-F
Long design

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**Dimensions in mm.**

Shrink extensions, spare parts and accessories at the end of this chapter.

Custom designs available on request.
Shrink Chuck DIN 69893 HSK-F
Narrow design, 3°

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Dimensions in mm.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs available on request.

STANDARD PROGRAMME | Shrink Chucks

Made in Germany

Cutwel Ltd    |     Tel: 01924 869 610     |     Email: sales@cutwel.net      |      Web: www.cutwel.co.uk
**Shrink Chuck DIN 69893 HSK-F**

Long narrow design, 3°

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### Dimensions in mm.

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Custom designs available on request.

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## Shrink Chuck BT MAS

Coolant supply as per ISO 7388-2, Form JD

![Shrink Chuck Diagram](image)

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Custom designs and version with face connection on request.
Shrink Chuck BT MAS
Coolant supply as per ISO 7388-2, Form JD/JF

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Dimensions in mm.
Basic form JD. Please indicate form JF (prev. B) in your order.
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Long design, coolant supply as per ISO 7388-2, Form JD/JF

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Dimensions in mm.
Basic form JD. Please indicate form JF (prev. B) in your order.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs and version with face connection on request.

Cutwel Ltd | Tel: 01924 869 610 | Email: sales@cutwel.net | Web: www.cutwel.co.uk
Shrink Chuck BT MAS

Coolant supply as per ISO 7388-2, Form JD/JF, with resealable coolant duct holes

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Dimensions in mm.
Basic form JD. Please indicate form JF (prev. B) in your order.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs and version with face connection on request.
Shrink Chuck BT MAS
Long design, coolant supply as per ISO 7388-2, Form JD/JF, with resealable coolant duct holes

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**Dimensions in mm.**

- d₁, d₂, d₃
- l₁, l₂, l₃, l₄

**G**

- M5
- M6
- M8x1
- M10x1_KKB
- M12x1_KKB
- M16x1_KKB

**sw**

- 3
- 5
- 2
- 4

**Weight [kg]**

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- 30591258

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Basic form JD. Please indicate form JF (prev. B) in your order.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs and version with face connection on request.
Shrink Chuck BT MAS
Narrow design, 3°, coolant supply as per ISO 7388-2, Form JD/JF

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Custom designs and version with face connection on request.
Shrink Chuck BT MAS

Long narrow design, 3°, coolant supply as per ISO 7388-2, Form JD/JF

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Basic form JD. Please indicate form JF (prev. B) in your order.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs and version with face connection on request.

Cutwel Ltd | Tel: 01924 869 610 | Email: sales@cutwel.net | Web: www.cutwel.co.uk
Shrink Chuck BT MAS
Narrow design, coolant supply as per ISO 7388-2, Form JD/JF

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Dimensions in mm.
Basic form JD. Please indicate form JF (prev. B) in your order.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs and version with face connection on request.
## Shrink Chuck BT MAS

Long design, coolant supply as per ISO 7388-2, Form JD/JF

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### BT MAS

Long design, coolant supply as per ISO 7388-2, Form JD/JF

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Dimensions in mm.
Basic form JD. Please indicate form JF (prev. B) in your order.
Shrink extensions, spare parts and accessories at the end of this chapter.
Custom designs and version with face connection on request.

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Made in Germany

**Cutwel Ltd**
Tel: 01924 869 610
Email: sales@cutwel.net
Web: www.cutwel.co.uk
Shrink Extension
As flexible adaptation, length adjustment screw (from ø 6mm)
Tool length as per customer request possible

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Dimensions in mm.
**Shrink Extension**

As flexible adaptation, length adjustment screw (from ø 6mm)

Tool length as per customer request possible

![Diagram of Shrink Extension with dimensions](image)

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Dimensions in mm.
Coolant Transfer Pipe
For DIN 69893 HSK-A/E

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Stop Screw direct clamping
For axial length adjustment

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Dimensions in mm.
### Hexagonal T-key

For axial length adjustment

![Hexagonal T-key](image)

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### ISO Protective Gloves

![ISO Protective Gloves](image)

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Dimensions in mm.
Length Presetter for Shrink Chucks

The WTE Length Presetter is used for easy length presetting of the tools before the shrink process. The stop screw must have a hexagon socket on two sides for length presetting with the appropriate careful and precise work method even with shrinkage accuracies of ± 0.02 mm are achieved.

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Dimensions in mm.