

**CNC 车床和车削中心固定刀座
德标 *DIN 69 880***

***Tool Holder to
DIN 69 880 For CNC Lathes***

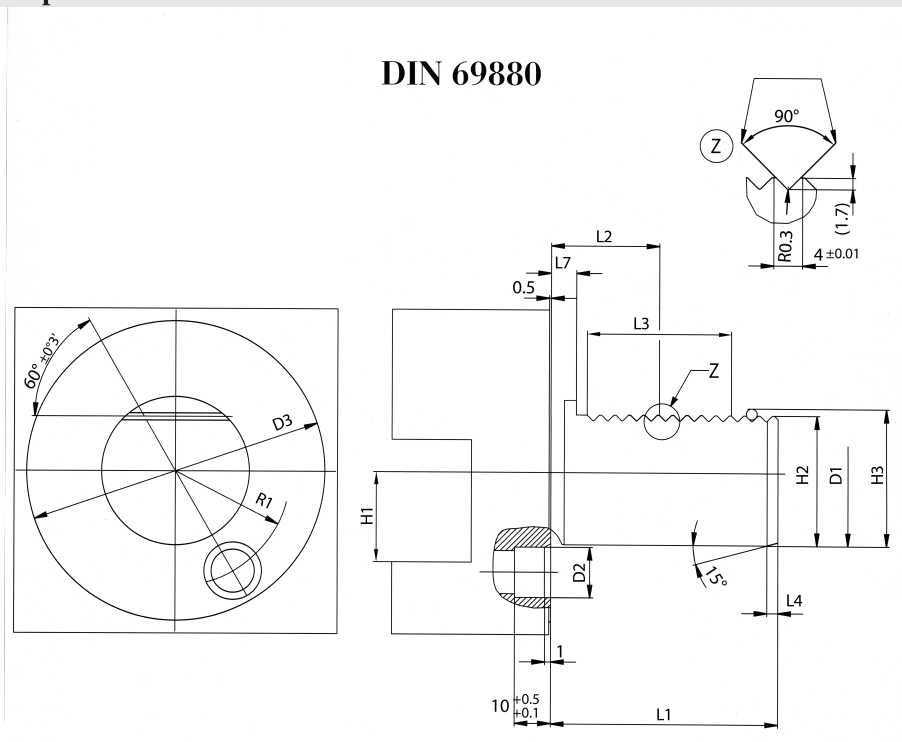
VDI刀座技术特点

VDI Technical Information

- 所有刀柄均是根据DIN69880标准制造的。
- 圆柱柄的误差-依据IT6 (H6) 等级。
- 每个刀座都进行表面硬化处理。
- 表面硬度达 58 ± 2 HRC。
- 核心强度超过 1000 N/mm^2
- 轴、锯齿面、座套面、定位孔、夹盘或定位器孔都经过磨光处理。
- 可以随时调整到下一个较低切削高度。
- 刀座中有两个定位螺丝可以调整刀具位置。
- 带弹簧压刀块可以精确夹持刀具。
- 通过可调式球形喷嘴提供内冷却液，使用新型的夹紧装置，具有快速精确的调节功能。
- 根据 *DIN 69880* 规定，刀座轴部和定位部有一个切口，可以装一个密封圈，以防冷却液渗漏。
- All toolholders are manufactured according to DIN 69880.
- Cylindrical shank's tolerance-according to the class IT6(h6)
- Each holder is fully case hardened.
- Surface hardness of 58 ± 2 HRC.
- Core strength in excess of 1000 N/mm^2
- Shaft, serration, seating face, locating bore, clamp plate or locator bore, are ground.
- Adjustable any time to the next lower cutter height.
- Position of cutter in tool holder adjustable using two stop screws.
- Spring-mounted pressure plates for clamping cutter in the exact position.
- Internal coolant supply through ball nozzles featuring quick and precise adjustment with new type of clamp fixture.
- As defined in DIN 69 880 the holders are equipped with an undercut at shaft/seating face to accomodate a sealing ring. The sealing ring is optional.

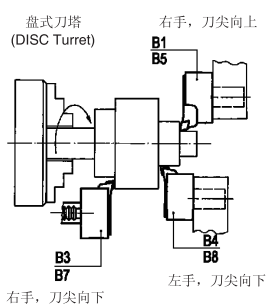
VDI刀座技术规格

The technical specifications of VDI toolholder

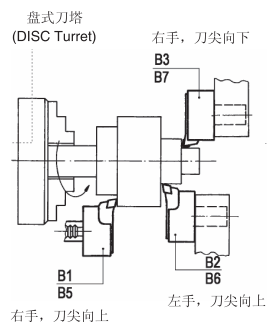


D1 _{h6}	L1±0.3	D2	D3	H1 _{max.}	H2±0.1	H3±0.1	L2±0.05	L3 _{min.}	L4 ₊₁	L7	R1±0.02
16	32	8 H6	40	12	15	16.92	12.7	16	2	3.5	14.5
20	40	10 H6	50	16	18	19.92	21.7	24	2	7	18
25	48	10 H6	58	16	23.5	25.42	21.7	24	2	7	21
30	55	14 H6	68	20	27	28.92	29.7	40	2	7	25
40	63	14 H6	83	25	36	37.92	29.7	40	3	7	32
50	78	16 H6	98	32	45	46.92	35.7	48	3	8	37
60	94	16 H6	123	32	55	56.92	43.7	56	4	10	48

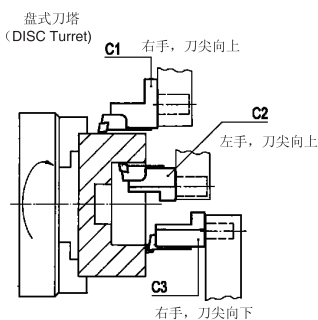
主轴逆时针旋转



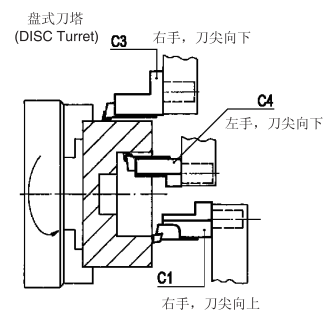
主轴顺时针旋转



主轴逆时针旋转



主轴顺时针旋转

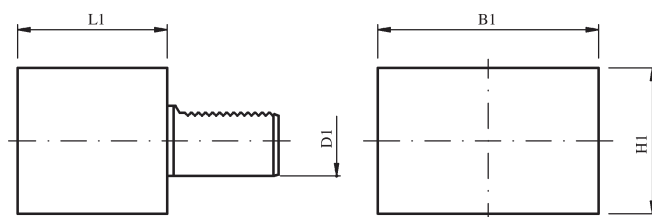


光刀座

Pre-machined blank (Tool holder for special design)

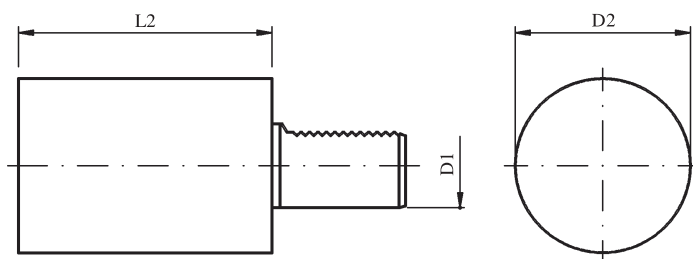
名称 DIN-Designation	D1	B1	H1	L1
A1-16x44	16	78	44	44
A1-20x65	20	100	60	65
A1-25x75	25	100	60	75
A1-30x85	30	130	75	85
A1-40x100	40	151	96	100
A1-50x125	50	160	120	125
A1-60x160	60	165	125	160

A1 型



名称 DIN-Designation	D1	D2	L2
A2-16x60	16	40	60
A2-20x70	20	50	70
A2-25x80	25	58	80
A2-25x200	25	58	200
A2-30x100	30	68	100
A2-30x240	30	68	240
A2-40x120	40	83	120
A2-40x320	40	83	320
A2-50x135	50	98	135
A2-50x400	50	98	400
A2-60x150	60	123	150
A2-60x480	60	123	480

A2 型

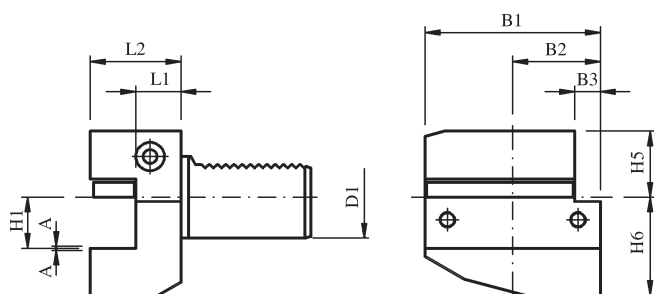


备注/Remarks:

特殊的尺寸可应客户要求定制

径向外径刀座

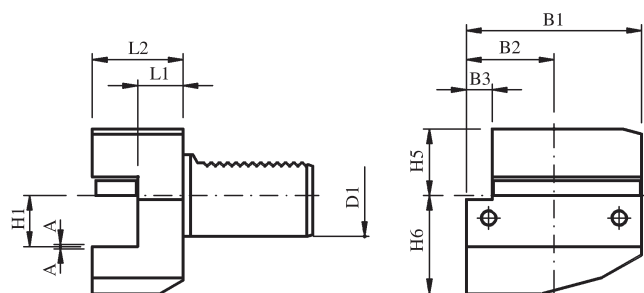
Rectangular transverse tool holder, right hand, short



B1 型

右手系，短，车刀刃向上

名称 DIN-Designation	D1	H1-0.1	B1	B2	B3	H5	H6	L1+0.5	L2
B1-16x12x24	16	12	42	23	5	20	22	13	24
B1-20x16x30	20	16	55	30	7	25	30	16	30
B1-25x16x30	25	16	55	30	7	25	30	16	30
B1-30x20x40	30	20	70	35	10	28	38	22	40
B1-40x25x44	40	25	85	42.5	12.5	32.5	48	22	44
B1-50x32x55	50	32	100	50	16	35	60	30	55
B1-60x32x60	60	32	125	62.5	16	42.5	62.5	30	60



B2 型

左手系，短，车刀刃向上

名称 DIN-Designation	D1	H1-0.1	B1	B2	B3	H5	H6	L1+0.5	L2
B2-16x12x24	16	12	42	23	5	20	22	13	24
B2-20x12x30	20	16	55	30	7	25	30	16	30
B2-25x16x30	25	16	55	30	7	25	30	16	30
B2-30x20x40	30	20	70	35	10	28	38	22	40
B2-40x25x44	40	25	85	42.5	12.5	32.2	48	22	44
B2-50x32x55	50	32	100	50	16	35	60	30	55
B2-60x32x60	60	32	125	62.5	16	42.5	62.5	30	60

备注/Remarks:

* 高度可调 A=1 / height adjustable / A=1

径向外径刀座

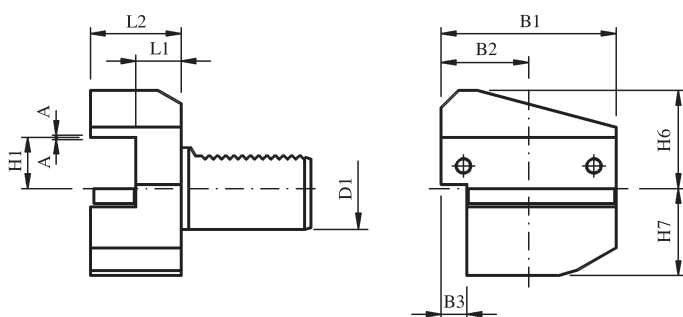
Rectangular transverse tool holder, overhead right hand, short



B3 型

右手系，短，车刀刃向下（反向）

名称 DIN-Designation	D1	H1-0.1	B1	B2	B3	H6	H7	L1+0.5	L2
B3-16x12x24	16	12	42	23	5	22	20	13	24
B3-20x16x30	20	16	55	30	7	30	25	16	30
B3-25x16x30	25	16	55	30	7	30	25	16	30
B3-30x20x40	30	20	70	35	10	38	35	22	40
B3-40x25x44	40	25	85	42.5	12.5	48	42.5	22	44
B3-50x32x55	50	32	100	50	16	60	50	30	55
B3-60x32x60	60	32	125	62.5	16	62.5	62.5	30	60



B4 型

左手系，短，车刀刃向下（反向）

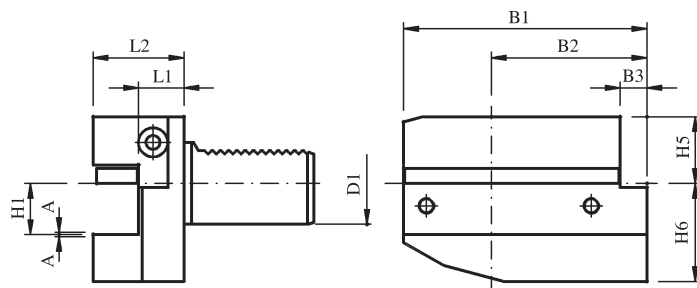
名称 DIN-Designation	D1	H1-0.1	B1	B2	B3	H6	H7	L1+0.5	L2
B4-20x16x30	20	16	55	30	7	30	25	16	30
B4-25x16x30	25	16	55	30	7	30	25	16	30
B4-30x20x40	30	20	70	35	10	38	35	22	40
B4-40x25x44	40	25	85	42.5	12.5	48	42.5	22	44
B4-50x32x55	50	32	100	50	16	60	50	30	55
B4-60x32x60	60	32	125	62.5	16	62.5	62.5	30	60

备注/Remarks:

* 高度可调 A=1 / height adjustable / A=1

径向外径刀座

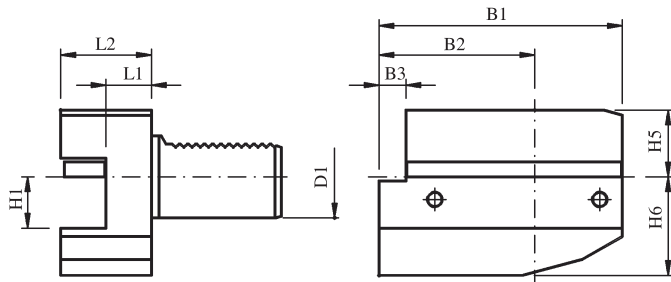
Rectangular transverse tool holder, right hand, long



B5 型

右手系，长，车刀刃向上

名称 DIN-Designation	D1	H1-0.1	B1	B2	B3	H5	H6	L1+0.5	L2
B5-20x16x30	20	16	75	50	7	25	30	16	30
B5-30x20x40	30	20	100	65	10	28	38	22	40
B5-40x25x44	40	25	118	75.5	12.5	32.5	48	22	44
B5-50x32x55	50	32	130	80	16	35	60	30	55
B5-60x32x60	60	32	145	82.5	16	42.5	62.5	30	60



B6 型

左手系，长，车刀刃向上

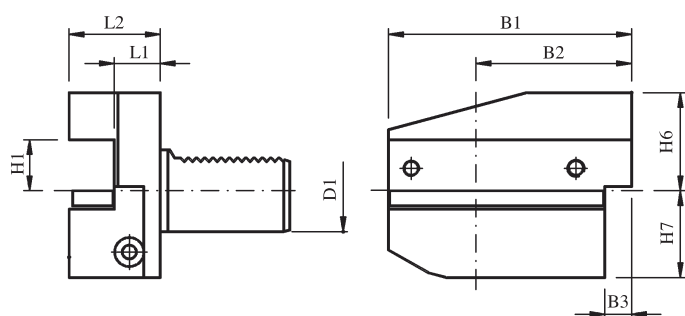
名称 DIN-Designation	D1	H1-0.1	B1	B2	B3	H5	H6	L1+0.5	L2
B6-20x16x30	20	16	75	50	7	25	30	16	30
B6-30x20x40	30	20	100	65	10	28	38	22	40
B6-40x25x44	40	25	118	75.5	12.5	32.5	48	22	44
B6-50x32x55	50	32	130	80	16	35	60	30	55
B6-60x32x60	60	32	145	82.5	16	42.5	62.5	30	60

备注/Remarks:

* 高度可调 A=1 / height adjustable / A=1

径向外径刀座

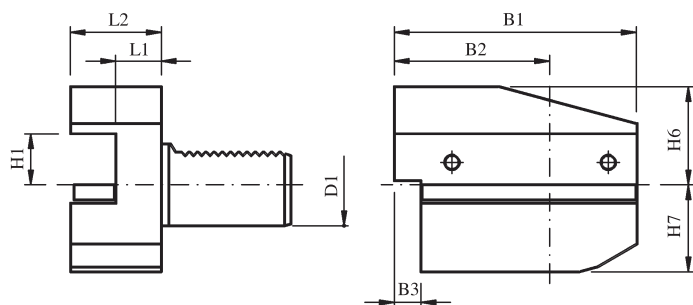
Rectangular transverse tool holder, overhead right hand, long



B7 型

右手系，长，车刀刃向下（反向）

名称 DIN-Designation	D1	H1-0.1	B1	B2	B3	H6	H7	L1+0.5	L2
B7-20x16x30	20	16	75	50	7	30	25	16	30
B7-30x20x40	30	20	100	65	10	38	35	22	40
B7-40x25x44	40	25	118	75.5	12.5	48	42.5	22	44
B7-50x32x55	50	32	130	80	16	60	50	30	55
B7-60x32x60	60	32	145	82.5	16	62.5	62.5	30	60



B8 型

左手系，长，车刀刃向下（反向）

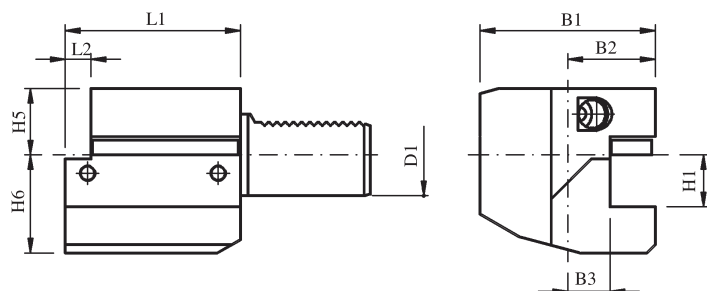
名称 DIN-Designation	D1	H1-0.1	B1	B2	B3	H6	H7	L1+0.5	L2
B8-20x16x30	20	16	75	50	7	30	25	16	30
B8-30x20x40	30	20	100	65	10	38	35	22	40
B8-40x25x44	40	25	118	75.5	12.5	48	42.5	22	44
B8-50x32x55	50	32	130	80	16	60	50	30	55
B8-60x32x60	60	32	145	82.5	16	62.5	62.5	30	60

备注/Remarks:

* 高度可调 A=1 / height adjustable / A=1

轴向外径刀座

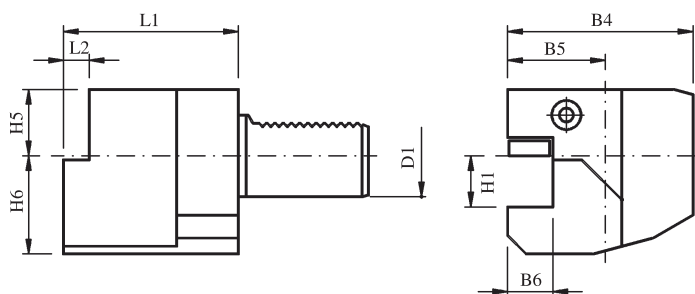
Rectangular lengthwise tool holder, right hand



C1 型

右手系, 车刀刃向上

名称 DIN-Designation	D1	H1-0.1	B1	B2	B3+0.5	H5	H6	L1	L2
C1-16x12	16	12	43	24	13	20	22	44	5
C1-20x16	20	16	52	27	13	25	30	55	7
C1-25x16	25	16	58	33	19	25	30	55	7
C1-30x20	30	20	70	35	17	28	38	70	10
C1-40x25	40	25	85	42.5	20.5	32.5	48	85	12.5
C1-50x32	50	32	100	50	25.5	35	60	100	16
C1-60x32	60	32	125	62.5	32.5	42.5	62.5	125	16



C2 型

左手系, 车刀刃向上

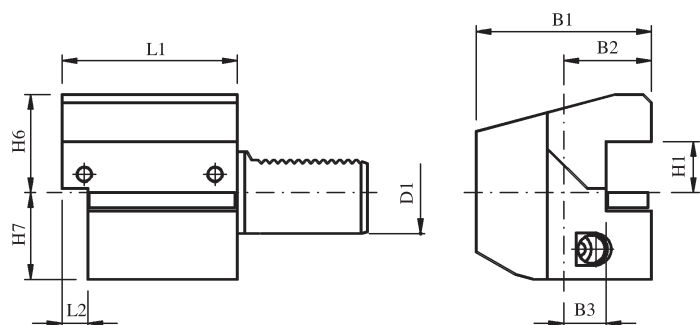
名称 DIN-Designation	D1	H1-0.1	B4	B5	B6+0.5	H5	H6	L1	L2
C2-20x16	20	16	65	40	26	25	30	50	-
C2-25x16	25	16	58	33	19	25	30	55	7
C2-30x20	30	20	76	41	23	28	38	70	10
C2-40x25	40	25	90	47.5	25.5	32.5	48	85	12.5
C2-50x32	50	32	105	55	30.5	35	60	100	16
C2-60x32	60	32	125	62.5	32.5	42.5	62.5	125	16

备注/Remarks:

* 高度可调 A=1 / height adjustable / A=1

轴向外径刀座

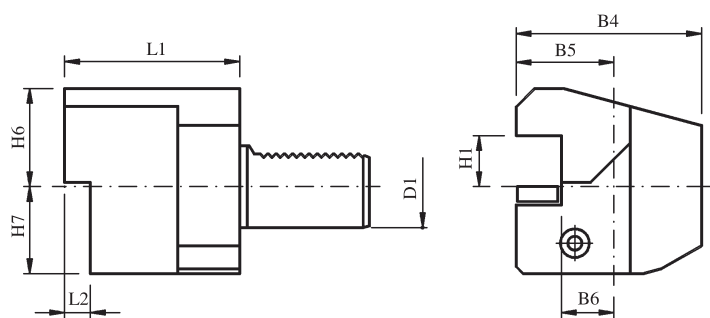
Rectangular lengthwise tool holder, overhead right hand



C3 型

右手系, 车刀刃向下 (反向)

名称 DIN-Designation	D1	H1-0.1	B1	B2	B3+0.5	H5	H6	L1	L2
C3-16x12	16	12	43	24	13	22	20	44	5
C3-20x16	20	16	52	27	13	30	25	55	7
C3-25x16	25	16	58	33	19	30	25	55	7
C3-30x20	30	20	70	35	17	38	35	70	10
C3-40x25	40	25	85	42.5	20.5	48	42.5	85	12.5
C3-50x32	50	32	100	50	25.5	60	50	100	16
C3-60x32	60	32	125	62.5	32.5	62.5	62.5	125	16



C4 型

左手系, 车刀刃向下 (反向)

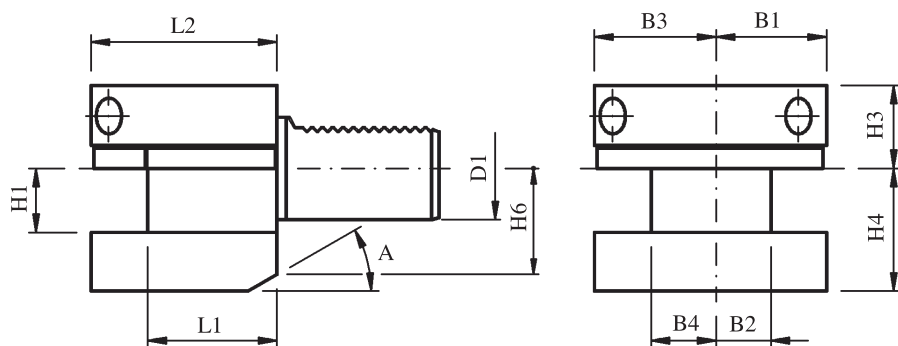
名称 DIN-Designation	D1	H1-0.1	B4	B5	B6+0.5	H6	H7	L1	L2
C4-20x16	20	16	65	40	26	30	25	50	-
C4-25x16	25	16	58	33	19	30	25	55	7
C4-30x20	30	20	76	41	23	38	35	70	10
C4-40x25	40	25	90	47.5	25.5	48	42.5	85	12.5
C4-50x32	50	32	105	55	30.5	60	50	100	16
C4-60x32	60	32	125	62.5	32.5	62.5	62.5	125	16

备注/Remarks:

* 高度可调 A=1 / height adjustable / A=1

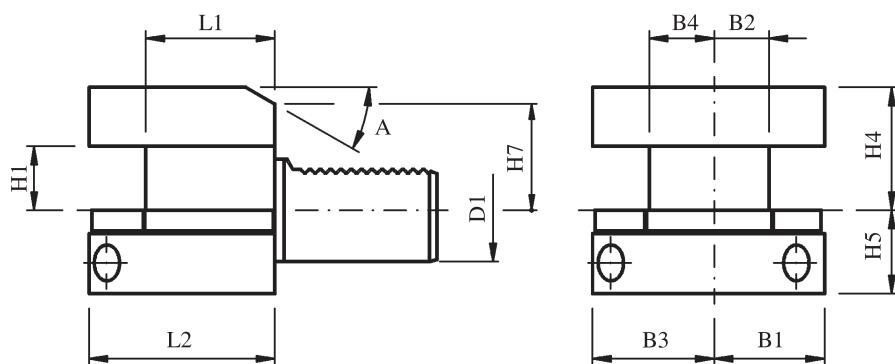
多装刀位外径刀座

Rectangular tool holder with multiple seats



D1 型
车刀刃向上

名称 DIN-Designation	D1	H1-0.1	B1	B2+0.3	B3	B4+0.3	H3	H4	H6	L1+0.5	L2	A
D1-25x16	25	16	33	19	33	19	22	30	25	34	48	30
D1-30x20	30	20	35	17	41	23	28	38	30	42	60	25
D1-40x25	40	25	42.5	20.5	47.5	25.5	32.5	48	-	50	72	-
D1-50x32	50	32	50	25.5	55	30.5	35	60	-	60	85	-
D1-60x32	60	32	57.5	32.5	57.5	32.5	42.5	62.5	-	85	110	-



D2 型
车刀刃向下 (反向)

名称 DIN-Designation	D1	H1-0.1	B1	B2+0.3	B3	B4+0.3	H4	H5	H7	L1+0.5	L2	A
D2-25x16	25	16	33	19	33	19	30	25	25	34	48	30
D2-30x20	30	20	35	17	41	23	38	35	28	42	60	25
D2-40x25	40	25	42.5	20.5	47.5	25.5	48	42.5	-	50	72	-
D2-50x32	50	32	50	25.5	55	30.5	60	50	-	60	85	-
D2-60x32	60	32	57.5	32.5	57.5	32.5	62.5	62.5	-	85	110	-

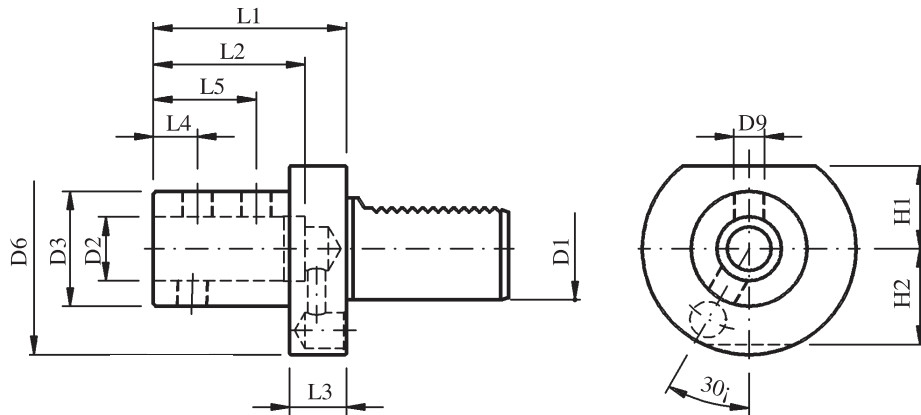
备注/Remarks:

* 高度可调 A=1 / height adjustable / A=1

内冷式硬质合金可转位钻削刀座

Tool holder for carbide indexable drill with internal coolant supply

E1 型

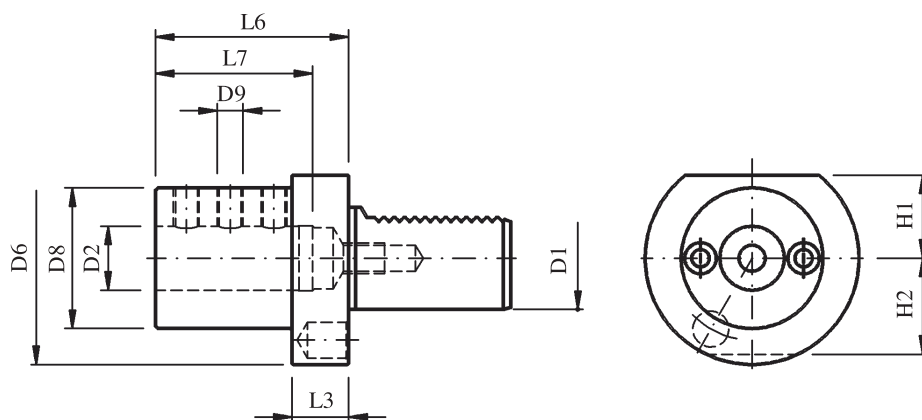


名称 DIN-Designation	D1	D2 _{H6}	D3	D6	H1	H2	L1	L2	L3	L4	L5	D9
E1-20x16	20	16	36	50	23	23	64	51	18	17	-	M10x1
E1-20x20	20	20	40	50	23	23	67	54	18	15	35	M10x1
E1-20x25	20	25	45	50	23	23	71	59	18	17	40	M12x1
E1-25x16	25	16	36	58	25	25	67	54	18	15	35	M10x1
E1-25x20	25	20	40	58	25	25	67	54	18	15	35	M10x1
E1-25x25	25	25	45	58	25	25	71	59	18	17	40	M12x1
E1-30x16	30	16	36	68	28	30	64	51	22	17	-	M10x1
E1-30x20	30	20	40	68	28	30	67	54	22	15	35	M10x1
E1-30x25	30	25	45	68	28	30	71	59	22	17	40	M12x1
E1-30x32	30	32	52	68	28	30	75	63	22	17	44	M12x1
E1-30x40	30	40	60	68	28	30	87	73	22	22	50	M16x1.5
E1-40x16	40	16	36	83	32.5	-	64	51	22	17	-	M10x1
E1-40x20	40	20	40	83	32.5	-	67	54	22	15	35	M10x1
E1-40x25	40	25	45	83	32.5	-	75	59	22	17	40	M12x1
E1-40x32	40	32	52	83	32.5	-	75	63	22	17	44	M12x1
E1-40x40	40	40	60	83	32.5	-	90	73	22	22	50	M10x1
E1-50x20	50	20	40	98	35	-	67	54	30	15	34	M10x1
E1-50x25	50	25	45	98	35	-	80	59	30	17	40	M12x1
E1-50x32	50	32	52	98	35	-	80	63	30	17	44	M12x1
E1-50x40	50	40	60	98	35	-	90	73	30	22	50	M16x1.5
E1-50x50	50	50	70	98	35	-	100	83	30	24	60	M16x1.5
E1-60x20	60	20	40	123	42.5	-	80	54	30	15	35	M10x1
E1-60x25	60	25	45	123	42.5	-	80	59	30	17	40	M12x1
E1-60x32	60	32	52	123	42.5	-	80	63	30	17	44	M12x1
E1-60x40	60	40	60	123	42.5	-	90	73	30	22	50	M16x1.5
E1-60x50	60	50	70	123	42.5	-	100	83	30	24	60	M16x1.5

内冷，外冷式镗刀刀座

Boring bar holder with external and internal coolant supply

E2 型

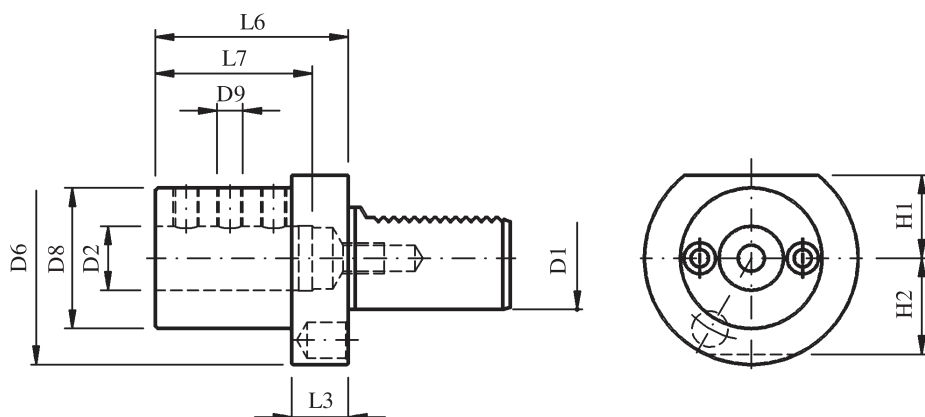


名称 DIN-Designation	D1	D2 _{H7}	D6	D8	H1	H2	L3	L6	L7	D9
E2-16x6	16	6	40	32	18	18	13	44	34	M6x12
E2-16x8	16	8	40	32	18	18	13	44	34	M6x12
E2-16x10	16	10	40	32	18	18	13	44	34	M6x12
E2-16x12	16	12	40	40	18	18	13	44	34	M8x12
E2-16x16	16	16	40	40	18	18	13	44	34	M8x12
E2-20x8	20	8	50	40	23	23	18	50	41	M6x16
E2-20x10	20	10	50	40	23	23	18	50	41	M8x16
E2-20x12	20	12	50	40	23	23	18	50	41	M8x16
E2-20x16	20	16	50	40	23	23	18	50	41	M8x12
E2-20x20	20	20	50	50	23	23	18	50	41	M8x12
E2-20x25	20	25	50	50	23	23	18	60	51	M8x10
E2-25x8	25	8	58	40	25	25	18	50	41	M6x25
E2-25x10	25	10	58	40	25	25	18	50	41	M6x25
E2-25x12	25	12	58	40	25	25	18	50	41	M8x16
E2-25x16	25	16	58	40	25	25	18	50	41	M8x16
E2-25x20	25	20	58	58	25	25	18	50	41	M8x16
E2-25x25	25	25	58	58	25	25	18	60	51	M8x16
E2-30x8	30	8	68	55	28	30	22	60	51	M8x25
E2-30x10	30	10	68	55	28	30	22	60	51	M8x25
E2-30x12	30	12	68	55	28	30	22	60	51	M8x20
E2-30x16	30	16	68	55	28	30	22	60	51	M8x20
E2-30x20	30	20	68	55	28	30	22	60	51	M8x20
E2-30x25	30	25	68	55	28	30	22	60	51	M8x16
E2-30x30	30	30	68	68	28	30	22	75	61	M8x16
E2-30x32	30	32	68	68	28	30	22	75	61	M8x16

内冷，外冷式镗刀刀座

Boring bar holder with external and internal coolant supply

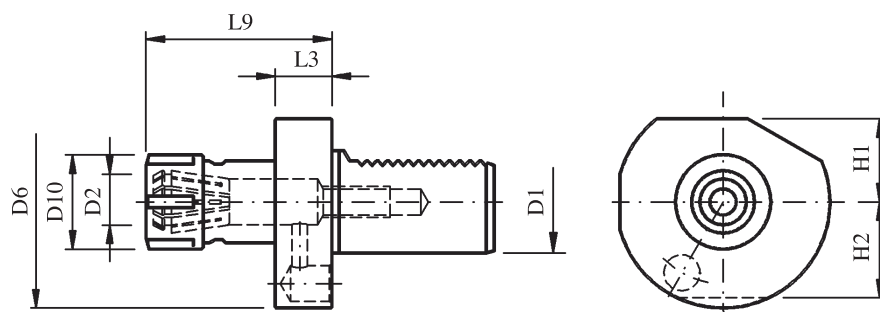
E2 型



名称 DIN-Designation	D1	D2 _{H7}	D6	D8	H1	H2	L3	L6	L7	D9
E2-40x8	40	8	83	55	32.5	-	22	75	61	M8x25
E2-40x10	40	10	83	55	32.5	-	22	75	61	M8x25
E2-40x12	40	12	83	55	32.5	-	22	75	61	M8x25
E2-40x16	40	16	83	55	32.5	-	22	75	61	M10x25
E2-40x20	40	20	83	55	32.5	-	22	75	61	M10x20
E2-40x25	40	25	83	55	32.5	-	22	75	61	M10x20
E2-40x30	40	30	83	83	32.5	-	22	75	61	M10x20
E2-40x32	40	32	83	83	32.5	-	22	75	61	M10x20
E2-40x40	40	40	83	83	32.5	-	20	90	76	M10x16
E2-50x12	50	12	98	68	35	-	30	90	76	M8x30
E2-50x16	50	16	98	68	35	-	30	90	76	M10x30
E2-50x20	50	20	98	68	35	-	30	90	76	M12x25
E2-50x25	50	25	98	68	35	-	30	90	76	M12x25
E2-50x30	50	30	98	68	35	-	30	90	76	M12x20
E2-50x32	50	32	98	68	35	-	30	90	76	M12x20
E2-50x40	50	40	98	98	35	-	30	90	76	M12x16
E2-50x50	50	50	98	98	35	-	30	100	76	M12x12
E2-60x16	60	16	123	68	42.5	-	30	90	76	M10x30
E2-60x20	60	20	123	68	42.5	-	30	90	76	M12x25
E2-60x25	60	25	123	68	42.5	-	30	90	76	M12x25
E2-60x30	60	30	123	68	42.5	-	30	90	76	M12x20
E2-60x32	60	32	123	68	42.5	-	30	90	76	M12x20
E2-60x40	60	40	123	98	42.5	-	30	90	76	M12x20
E2-60x50	60	50	123	98	42.5	-	30	100	86	M12x16

DIN 6388 弹簧夹头 Ortlieb

Collet chuck



E3 型

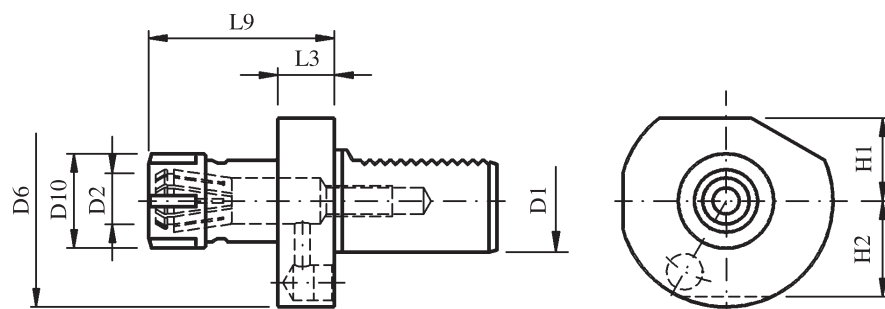
名称 DIN-Designation	D1	D2	D6	D10 max.	H1	H2	L3	L9 max.	弹簧夹 collets
E3-20x16	20	2-16	50	43	23	23	18	57	OZ 16
E3-20x20	20	2-20	50	50	23	23	18	62	OZ 20
E3-25x16	25	2-16	58	43	25	25	18	57	OZ 16
E3-30x16	30	2-16	68	43	28	30	22	57	OZ 16
E3-30x25	30	2-25	68	60	28	30	22	75	OZ 25
E3-40x25	40	2-25	83	60	32.5	-	22	75	OZ 25
E3-40x32	40	4-32	83	72	32.5	-	22	90	OZ 32
E3-50x25	50	2-25	98	60	35	-	30	75	OZ 25
E3-50x32	50	4-32	98	72	35	-	30	90	OZ 32
E3-60x32	60	4-32	123	72	42.5	-	30	90	OZ 32
E3-60x40	60	7.5-40	123	85	42.5	-	30	100	OZ 40

备注：
冷却液通过弹簧夹供应

Remarks:
Coolant supply through collet.

DIN 6499 弹簧夹头 Schaublin

Collet chuck



E4 型

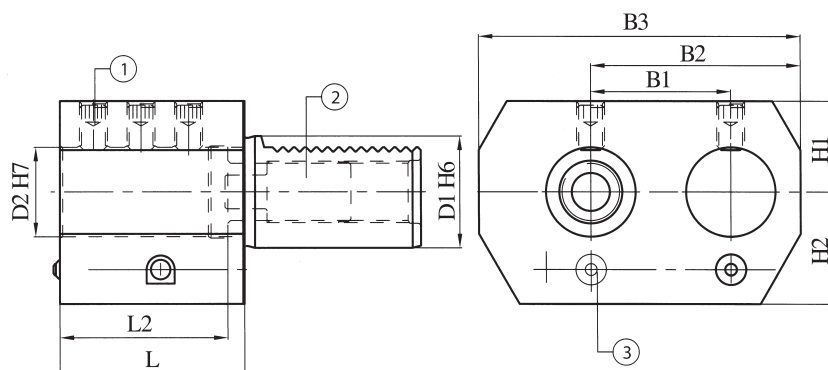
名称 DIN-Designation	D1	D2	D6	D10 max.	H1	H2	L3	L9 max.	弹簧夹 collets
E4-16x16	16	0.5-10	40	28	18	18	14	45.5	ER 16
E4-16x20	16	1-13	40	34	18	18	14	44	ER 20
E4-20x25	20	1-16	50	42	23	23	18	57	ER 25
E4-20x32	20	2-20	50	50	23	23	18	62	ER 32
E4-25x25	25	1-16	58	42	25	25	18	57	ER 25
E4-25x32	25	2-20	58	50	25	25	18	62	ER 32
E4-30x25	30	1-16	68	42	28	30	22	57	ER 25
E4-30x32	30	2-20	68	50	28	30	22	75	ER 32
E4-40x25	40	1-16	83	42	32.5	-	22	63	ER 25
E4-40x32	40	2-20	83	50	32.5	-	22	75	ER 32
E4-40x40	40	3-26	83	63	32.5	-	22	75	ER 40
E4-50x32	50	2-20	94	50	35	-	30	75	ER 32
E4-50x40	50	3-26	94	63	35	-	30	63	ER 40
E4-60x40	60	3-26	123	63	42.5	-	30	75	ER 40

备注：
冷却液通过弹簧夹供应

Remarks:
Coolant supply through collet.

右侧双搪孔刀柄

Double boring bar holder, right

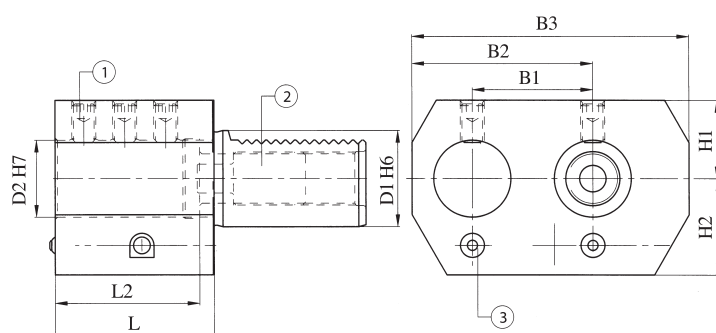


E7 型

Code N.	D1	D2	H1	H2	L1	L2	B1	B2	B3
E7-20x16	20	16	25	25	45	42	32	51	76
E7-20x20	20	20	25	25	45	42	32	51	76
E7-30x25	30	25	28	32	56	52	45	65	95
E7-40x32	40	32	32.5	40	66	60	50	75	115
E7-50x32	50	32	32.5	47.5	66	60	50	75	115
E7-50x50	50	50	35	49	90	80	68	103	152

左侧双搪孔刀柄

Double boring bar holder, left

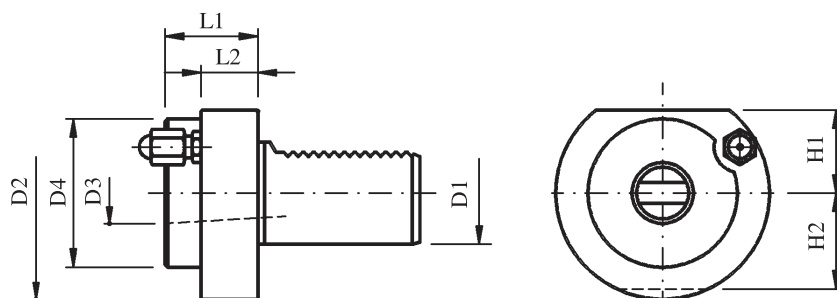


E8 型

Code N.	D1	D2	H1	H2	L1	L2	B1	B2	B3
E8-20x16	20	16	25	25	45	42	32	51	76
E8-20x20	20	20	25	25	45	42	32	51	76
E8-30x25	30	25	28	32	56	52	45	65	95
E8-40x32	40	32	32.5	40	66	60	50	75	115
E8-50x32	50	32	32.5	47.5	66	60	50	75	115
E8-50x50	50	50	35	49	90	80	68	103	152

莫氏锥度刀座

Morse taper holder



F 型

名称 DIN-Designation	D1	D2	D3	D4	H1	H2	L1	L2
F-20xM1	20	50	1	-	23	23	23	-
F-20xM2	20	50	2	-	23	23	87	-
F-25xM1	25	58	1	-	25	25	23	-
F-25xM2	25	58	2	-	25	25	27	-
F-30xM1	30	68	1	-	28	30	27	-
F-30xM2	30	68	2	-	28	30	27	-
F-30xM3	30	68	3	58	28	30	55	40
F-40xM2	40	83	2	55	32.5	-	36	22
F-40xM3	40	83	3	58	32.5	-	36	22
F-40xM4	40	83	4	68	32.5	-	80	22
F-50xM2	50	98	2	55	35	-	36	30
F-50xM3	50	98	3	58	35	-	36	30
F-50xM4	50	98	4	68	35	-	50	30
F-60xM2	60	123	2	55	42.5	-	36	30
F-60xM3	60	123	3	58	42.5	-	36	30
F-60xM4	60	123	4	68	42.5	-	50	30
F-60xM5	60	123	5	98	42.5	-	63	30

备注：
适用于采用 DIN228 BK型工具冷却的钻头

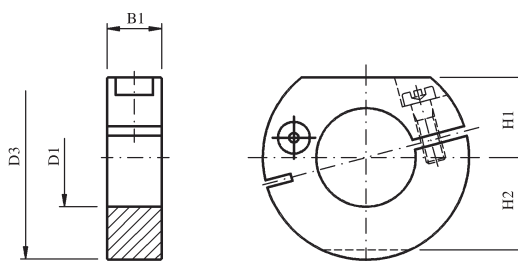
Remarks:
For drills with coolant through the tool to DIN 228 Form BK.

锁紧环

Clamping ring

Z1 型

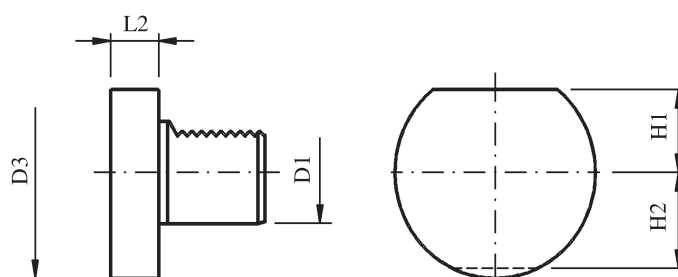
名称 DIN-Designation	D1	D3	H1	H2	B1
Z1-20	20	50	23	23	16
Z1-30	30	68	28	30	22
Z1-40	40	83	32.5	-	22
Z1-50	50	98	35	-	30
Z1-60	60	123	42.5	-	30



保护塞

Blanking plug

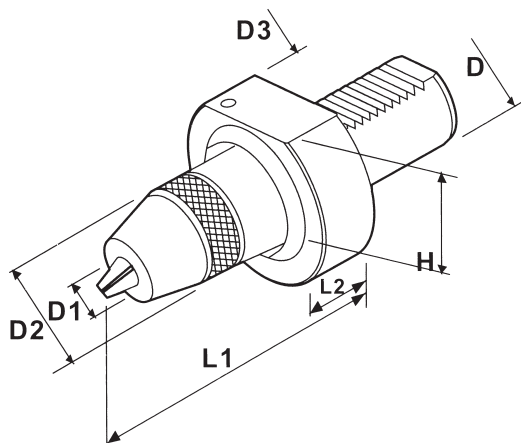
Z2 型



名称 DIN-Designation	D1	D3	H1	H2	L2	材料 material
Z2-16	16	40	18	-	13	钢 / steel
Z2-16	16	40	18	-	13	塑料 / plastic
Z2-20	20	50	23	23	16	钢 / steel
Z2-20	20	50	23	23	16	塑料 / plastic
Z2-25	25	58	25	25	16	钢 / steel
Z2-25	25	58	25	25	16	塑料 / plastic
Z2-30	30	68	28	30	16	钢 / steel
Z2-30	30	68	28	30	16	塑料 / plastic
Z2-40	40	83	32.5	-	20	钢 / steel
Z2-40	40	83	32.5	-	20	塑料 / plastic
Z2-50	50	98	35	-	20	钢 / steel
Z2-50	50	98	35	-	20	塑料 / plastic
Z2-60	60	123	42.5	-	20	钢 / steel
Z2-60	60	123	42.5	-	20	塑料 / plastic

钻夹头刀座

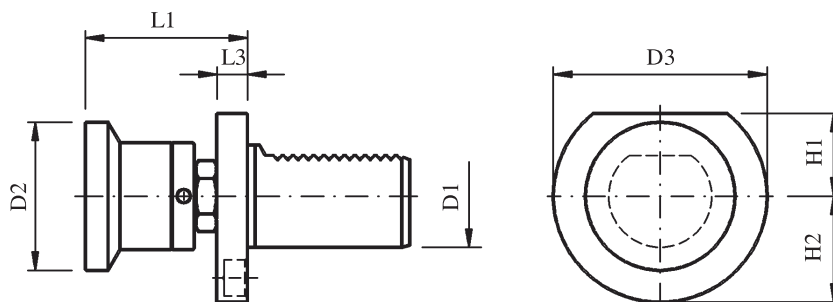
Keyless drill chuck



D	D1	D2	D3	H	L1	L2	Order No.
30	0.5-8	36	68	28	71	22	CHUCK-30-08
30	1-13	51	68	28	85	22	CHUCK-30-13
40	1-13	51	83	32.5	85	22	CHUCK-40-13
40	1-16	57	83	32.5	102	22	CHUCK-40-16
50	1-13	51	98	35	85	30	CHUCK-50-13
50	1-16	57	98	35	90	30	CHUCK-50-16
60	1-13	51	123	42.5	85	25	CHUCK-60-13
60	1-16	57	123	42.5	90	25	CHUCK-60-16

可旋转的棒料定位块

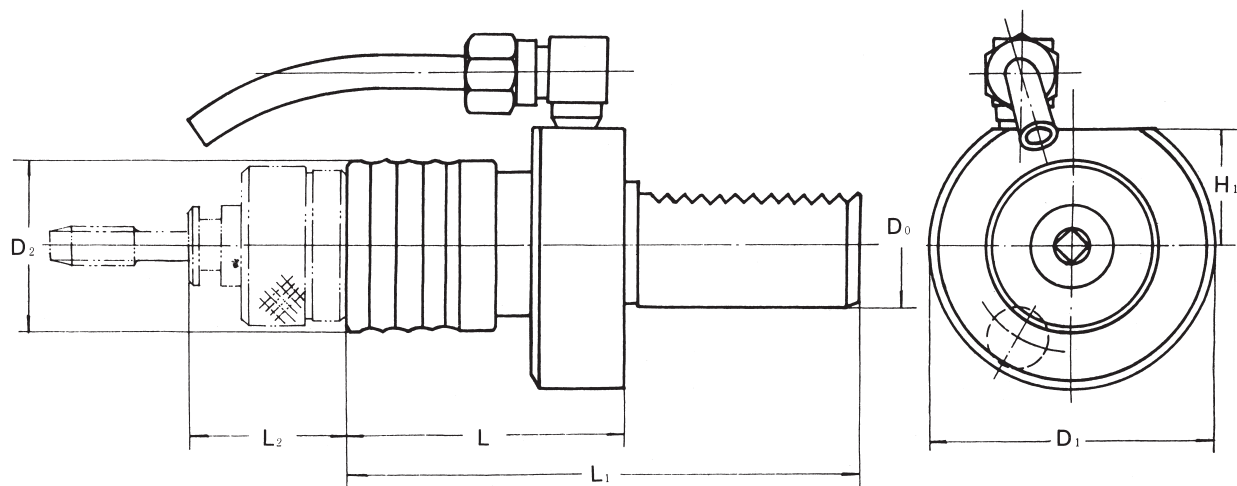
Revolving stock stop



D1	D2	D3	H1	H2	L1	L3
20	45	50	23	23	40 - 70	8
25	45	58	25	25	40 - 70	15
30	58	70	28	30	61 - 97	11
30	26	68	28	30	62 - 95	20
40	58	83	32.5	-	62 - 95	12

攻丝夹头刀座-带保护

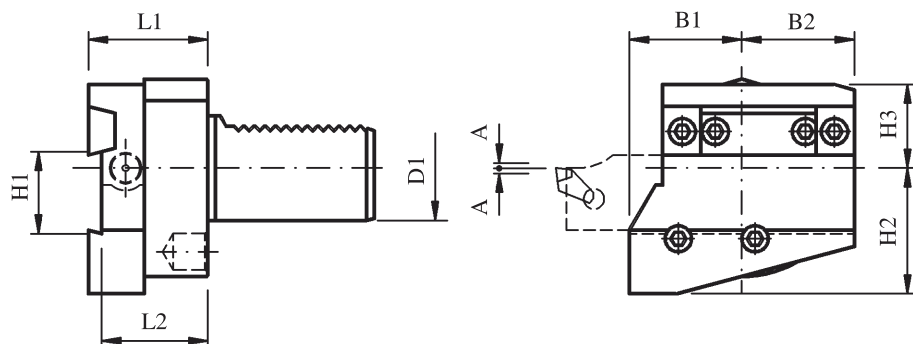
Tapping toolholders



型号 Model	攻丝范围 Tapping range	D ₀	D ₁	D ₂	H ₁	L	L ₁	L ₂	配套攻丝夹套 Tap Collets
VDI30-G3	M3~M12	30	68	40	28	65	120	37	G3-3,4,5,6,8,10,12
VDI40-G3	M3~M12	40	83	40	32.5	65	128	37	G3-3,4,5,6,8,10,12
VDI50-G3	M3~M12	50	98	40	35	65	143	37	G3-3,4,5,6,8,10,12
VDI30-G12	M12~M24	30	68	56	28	86	141	54	G12-12,14,16,18,20,22,24
VDI40-G12	M12~M24	40	83	56	32.5	86	149	54	G12-12,14,16,18,20,22,24
VDI50-G12	M12~M24	50	98	56	35	86	164	54	G12-12,14,16,18,20,22,24
VDI40-G24	M24~M48	40	83	82	32.5	130	193	46	G24-24,27,30,33,36,39,42,45,48
VDI50-G24	M24~M48	50	98	82	32	125	203	46	G24-24,27,30,33,36,39,42,45,48
VDI60-G24	M24~M48	60	123	82	-	-	-	-	G24-24,27,30,33,36,39,42,45,48

高度可调的切断（槽）刀座

Cut-off tool holder, height adjustable



规格 Execution	D1	B1	B2	H1	H2	H3	L1	L2	A	
Form A	20	28	25	26	30	25	40	35	1.5	
Form C	20	28	25	26	30	25	40	35	1.5	
Form A	25	28	25	26	30	25	40	35	2	*
Form C	25	28	25	26	30	25	40	35	2	*
Form A	30	35	35	26	38	28	49	44	2	*
Form B	30	35	35	26	38	28	49	44	2	*
Form C	30	35	35	26	38	34	49	44	2	*
Form D	30	35	35	26	38	34	49	44	2	*
Form A	40	42.5	42.5	32	48	32	49	44	2	*
Form B	40	42.5	42.5	32	48	32	49	44	2	*
Form C	40	42.5	42.5	32	48	32	49	44	2	*
Form D	40	42.5	42.5	32	48	32	49	44	2	*

备注 / Remarks:

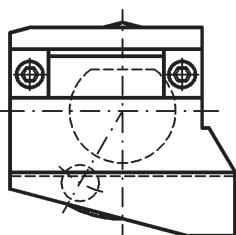
适用于Iscar和Coromant切断（槽）刀具

For Iscar and Coromant cut-off tool.

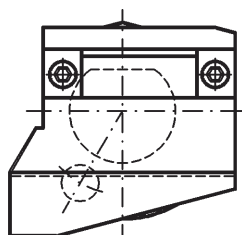
* 冷却液通过切断（槽）刀具供应

* For coolant supply through the cut-off tool.

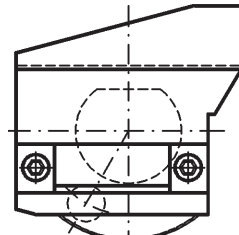
Form A



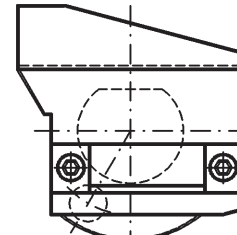
Form B



Form C

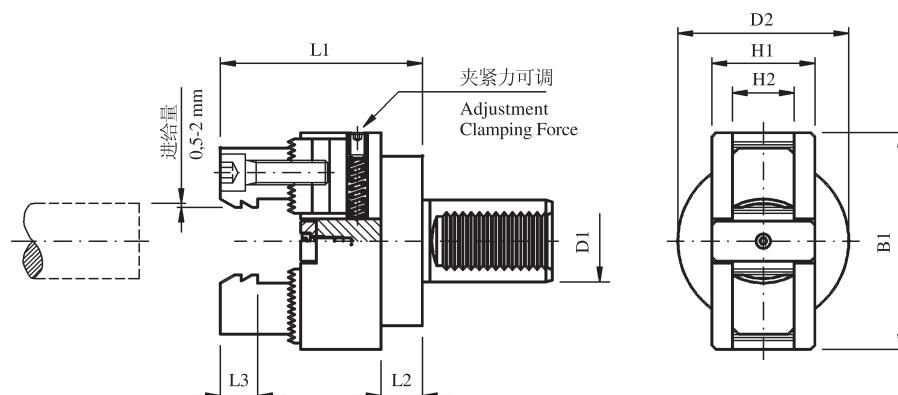


Form D



棒料牵引刀座

Bar puller



棒料外径 Raw material	夹紧力 范围	D1	L1	L2	L3	B1	D2	H1	H2
* 4-68	20-120	20	89.5	16	18	106	50	50	30
* 4-68	20-120	25	90	16.5	18	106	58	50	30
* 4-68	20-120	30	90	16.5	18	106	68	50	30
* 4-68	20-120	40	98	16.5	18	106	83	50	30
* 4-68	20-120	50	116	42.5	18	106	98	50	30

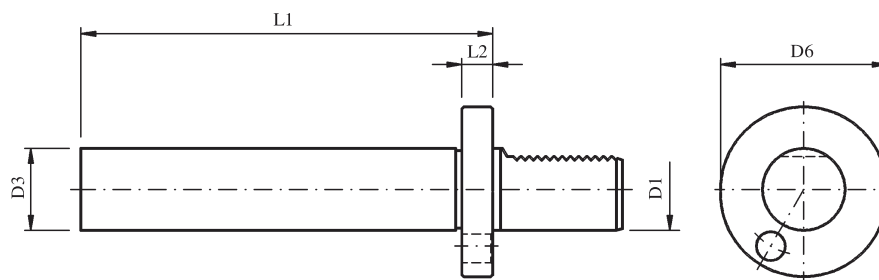
备注 / Remarks:

* 供货范围包括1套直径 $\text{Ø}15$ - $\text{Ø}68$ 棒料卡爪

* scope of delivery 1 set jaw for raw material $\text{Ø}15$ - $\text{Ø}68$

测试棒

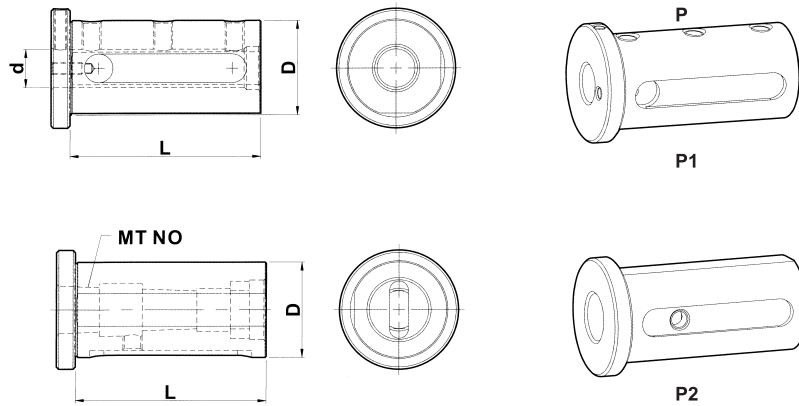
Test mandrel



D1	D3 _{h5}	D6	L1	L2
16	30	40	120	15
20	40	50	150	15
25	40	58	150	15
30	40	68	200	15
40	40	83	200	15
50	40	98	200	15
60	40	123	200	15

刀套

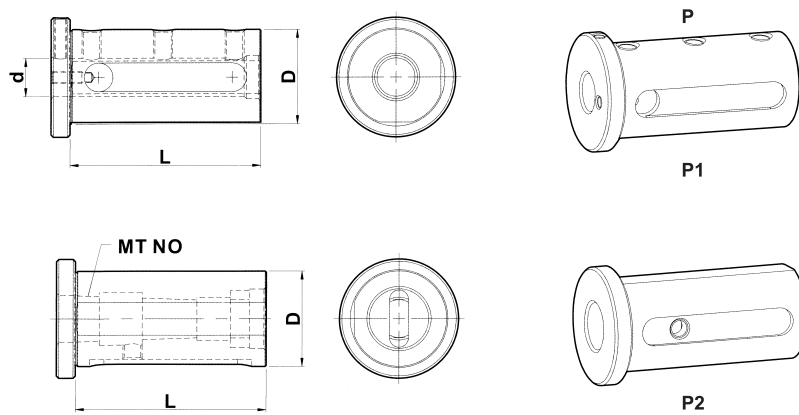
Reducing sleeves



Order No.	D	d	L	P	MT NO
D32-8	32	8	80	P1	
D32-10	32	10	80	P1	
D32-12	32	12	80	P1	
D32-16	32	16	80	P1	
D32-20	32	20	80	P1	
D32-25	32	25	80	P1	
D32-MT1	32		80	P2	1
D32-MT2	32		80	P2	2
D32-MT3	32		80	P2	3
D40-8	40	8	80	P1	
D40-10	40	10	80	P1	
D40-12	40	12	80	P1	
D40-16	40	16	80	P1	
D40-20	40	20	80	P1	
D40-25	40	25	80	P1	
D40-32	40	32	80	P1	
D40-MT1	40		80	P2	1
D40-MT2	40		80	P2	2
D40-MT3	40		80	P2	3
D40-MT4	40		80	P2	4
D50-8	50	8	80	P1	
D50-10	50	10	80	P1	
D50-12	50	12	80	P1	
D50-16	50	16	80	P1	
D50-20	50	20	80	P1	
D50-25	50	25	80	P1	
D50-32	50	32	80	P1	
D50-40	50	40	80	P1	
D50-MT1	50		80	P2	1
D50-MT2	50		80	P2	2
D50-MT3	50		80	P2	3
D50-MT4	50		80	P2	4

刀套

Reducing sleeves



Order No.	D	d	L	P	MT NO
D1-1/4" -5/16"	1-1/4"	5/16"	80	P1	
D1-1/4" -3/8"	1-1/4"	3/8"	80	P1	
D1-1/4" -1/2"	1-1/4"	1/2"	80	P1	
D1-1/4" -5/8"	1-1/4"	5/8"	80	P1	
D1-1/4" -3/4"	1-1/4"	3/4"	80	P1	
D1-1/4" -1"	1-1/4"	1"	80	P1	
D1-1/4" -MT1"	1-1/4"		80	P2	1
D1-1/4" -MT2"	1-1/4"		80	P2	2
D1-1/4" -MT3"	1-1/4"		80	P2	3
D1-1/2" -5/16"	1-1/2"	5/16"	80	P1	
D1-1/2" -3/8"	1-1/2"	3/8"	80	P1	
D1-1/2" -1/2"	1-1/2"	1/2"	80	P1	
D1-1/2" -5/8"	1-1/2"	5/8"	80	P1	
D1-1/2" -3/4"	1-1/2"	3/4"	80	P1	
D1-1/2" -1"	1-1/2"	1"	80	P1	
D1-1/2" -1-1/4"	1-1/2"	1-1/4"	80	P1	
D1-1/2" -MT1"	1-1/2"		80	P2	1
D1-1/2" -MT2"	1-1/2"		80	P2	2
D1-1/2" -MT3"	1-1/2"		80	P2	3
D1-1/2" -MT4"	1-1/2"		80	P2	4
D2" -5/16"	2"	5/16"	80	P1	
D2" -3/8"	2"	3/8"	80	P1	
D2" -1/2"	2"	1/2"	80	P1	
D2" -5/8"	2"	5/8"	80	P1	
D2" -3/4"	2"	3/4"	80	P1	
D2" -1"	2"	1"	80	P1	
D2" -1-1/4"	2"	1-1/4"	80	P1	
D2" -1-1/2"	2"	1-1/2"	80	P1	
D2" -MT1	2"		80	P2	1
D2" -MT2	2"		80	P2	2
D2" -MT3	2"		80	P2	3
D2" -MT4	2"		80	P2	4