

with positive taper lock mounting

clamping set with guided segment collet



Advantage: compact guide through segments, which means less imbalance of the clamping set



with retaining collet, for quick and easy tool change



with steep taper mounting



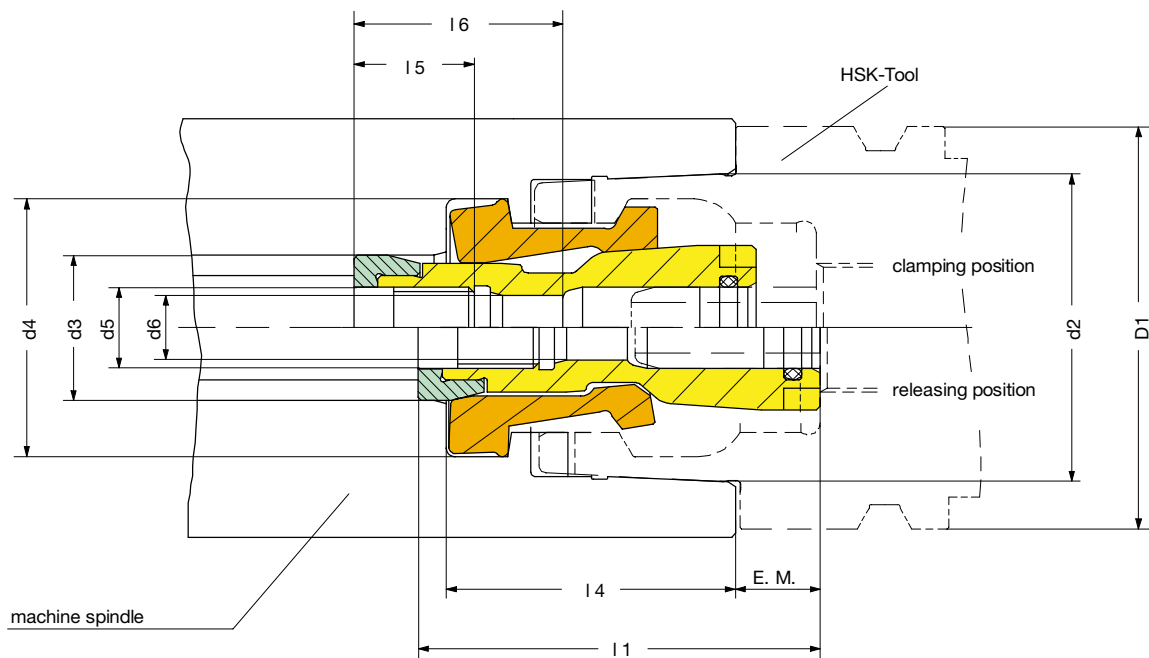
with standardised Röhms turning performance for speeds up to 36000 rpm

Positive taper lock system

Clamping sets: The main purpose of the automatic tool clamping of HSK-tools is the force amplification of the clamping set.

The clamping set **HSK-A** was developed to enforce positive driving grooves of the machining spindle designed for the shank types A or C. It is a short, solid built collet unit for very high clamping forces.

For the other HSK-types without positive drive, the clamping set **HSK-B** was designed. It is slightly longer and allows the clamping of all HSK-types.



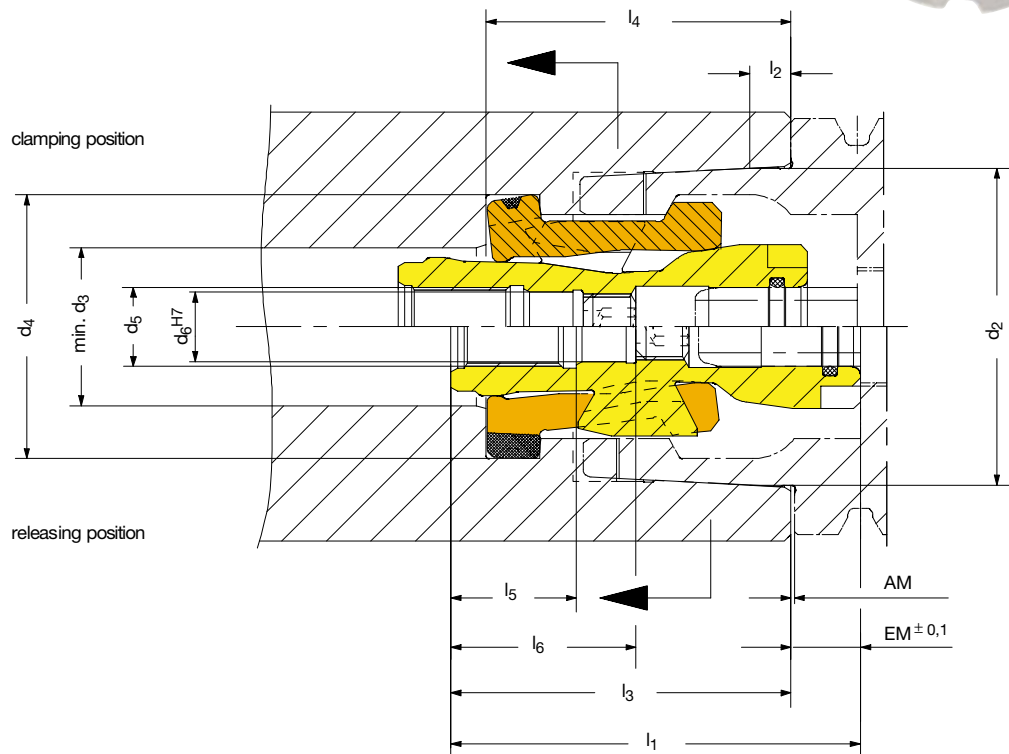
* with thread

HSK-A Initial size	D ₁	25	32	40	50	63	80	100	125	160
HSK-B Initial size	D ₁	32	40	50	63	80	100	125	-	-
Id.-No. HSK-A		795554	760431	760432	760433	760434	760435	760436	812522	800096
Id.-No. HSK-B		795554	760431	760432	795557	790581	800369	800370	-	-
Taper diameter	d ₂	19	24	30	38	48	60	75	95	125
	d ₃	10	12	15	18	24	32	40	48	60
	d ₄	17	21	25,5	32	40	50	63	80	101
	d ₅	M 4	M 6 x 0,75	M 8 x 1	M 10 x 1	M 12 x 1	M 16 X 1,5	M 20 x 1,5	M 24 x 1,5	M 30 x 2
	d ₆ ^{H7}	-*	-*	6,4	8	10,5	14,3	17,5	20,5	22
HSK-A / HSK-B	l ₁	28,8	35,1	42,5	50	59,5 / 62	76 / 80	92,5 / 98,5	114,2	154,5
HSK-A / HSK-B	l ₄	20,35	24,5	32	36 / 37,5	44 / 46,5	56 / 60	67,2 / 73,2	87,5	115
	l ₅	9,5	12,6	13	17	19	30	34,5	37	58
HSK-A / HSK-B	l ₆	-*	-*	20	26	25,5 / 28	38 / 42	46 / 52	56,5	75
Adjusting size	EM	6,2	8,4	8,5	10,5	10,5	13	13,3	16,8	17
Total stroke		7	9	13	15	16	18	20	21	36
Draw bar pull	F _{Z(kN)}	0,3	1	2	3	4,3	7,5	10	16	21
Pull-in force	F _{A(kN)}	1,5	5	10	15	21,5	37,5	50	70	90



Clamping Set with guided collet

Precise guiding of the clamping segments makes this clamping set especially suitable for higher speeds.

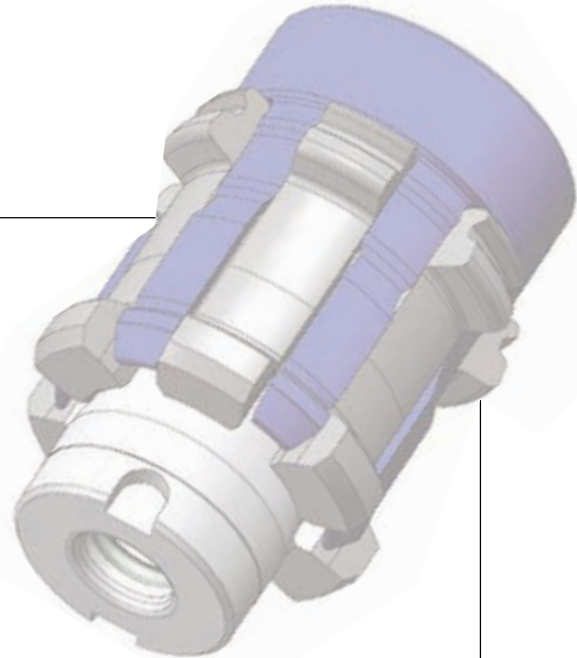


Type 288-64

Id.-No.		594332	466096	1011063	1011061	1015151	474917	462324
Clamping unit	HSK	E25/B32	A32/B40	A40/B50	A50/B63	A63/B80	A80/B100	A100/B125
Draw bar pull	kN	0,3	1	2	3	5	7,5	10
Pull-in force	kN	1,5	5	10	15	25	37,5	50
Total stroke		7	9	13	15	14	17	18
Pull-out stroke	AM	0,2	0,4	0,5	0,5	0,5	0,5	0,8
Adjusting size	EM	6,2	8,4	8,5	10,5	10,5	13	13,3
	d ₂	19	24	30	38	48	60	75
	d ₃	8,6	11,3	14	16,3	21	26,7	35
	d ₄	17	21	25,5	32	40	50	63
	d ₅	M4	M6x0,75	M8x1	M10x1	M12x1	M16x1,5	M20x1,5
	d ₆	4,2	6,5	6,4	8	10,5	14,3	17,5
	l ₁	28,8	35,1	42,5	50	62	80	98,5
	l ₂	2,5	3,2	4	5	6,3	8	10
	l ₃	22,6	26,7	34	39,5	51,5	67	85,2
	l ₄	20,3	24,5	31,9	37,2	46,2	59,7	73
	l ₅	9,5	12,5	13	17	19	30	34,5
	l ₆	2,5	3	20	26	28	42	51

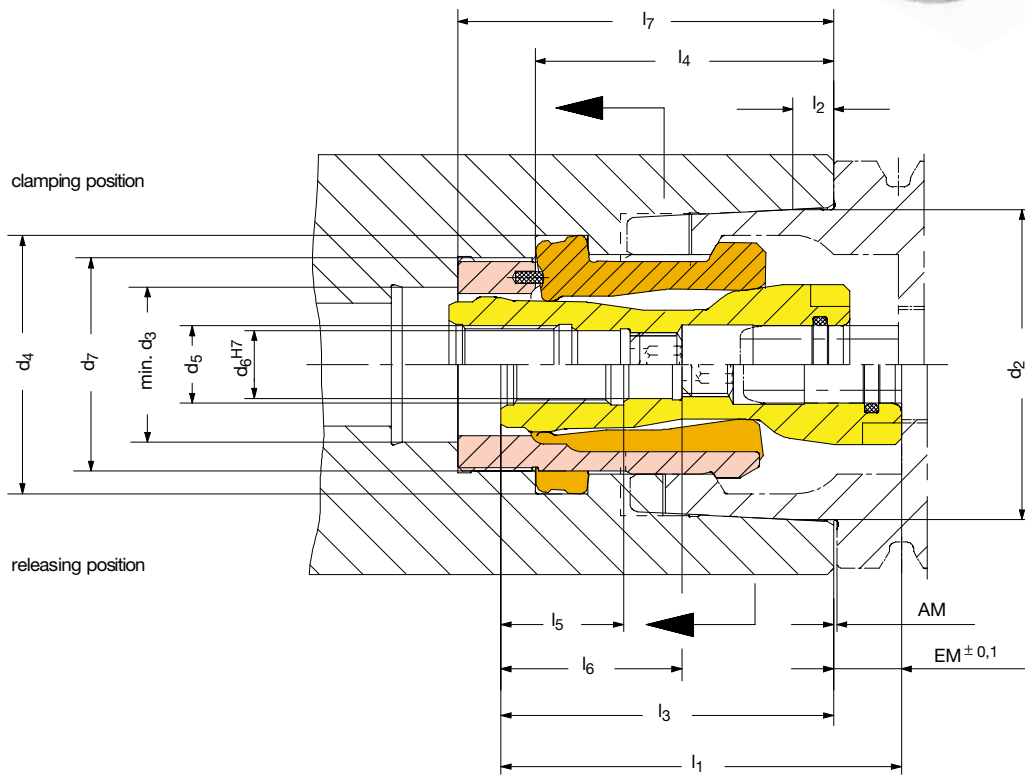
Positive taper lock system

Automatic HSK-Clamping Set with retaining collet



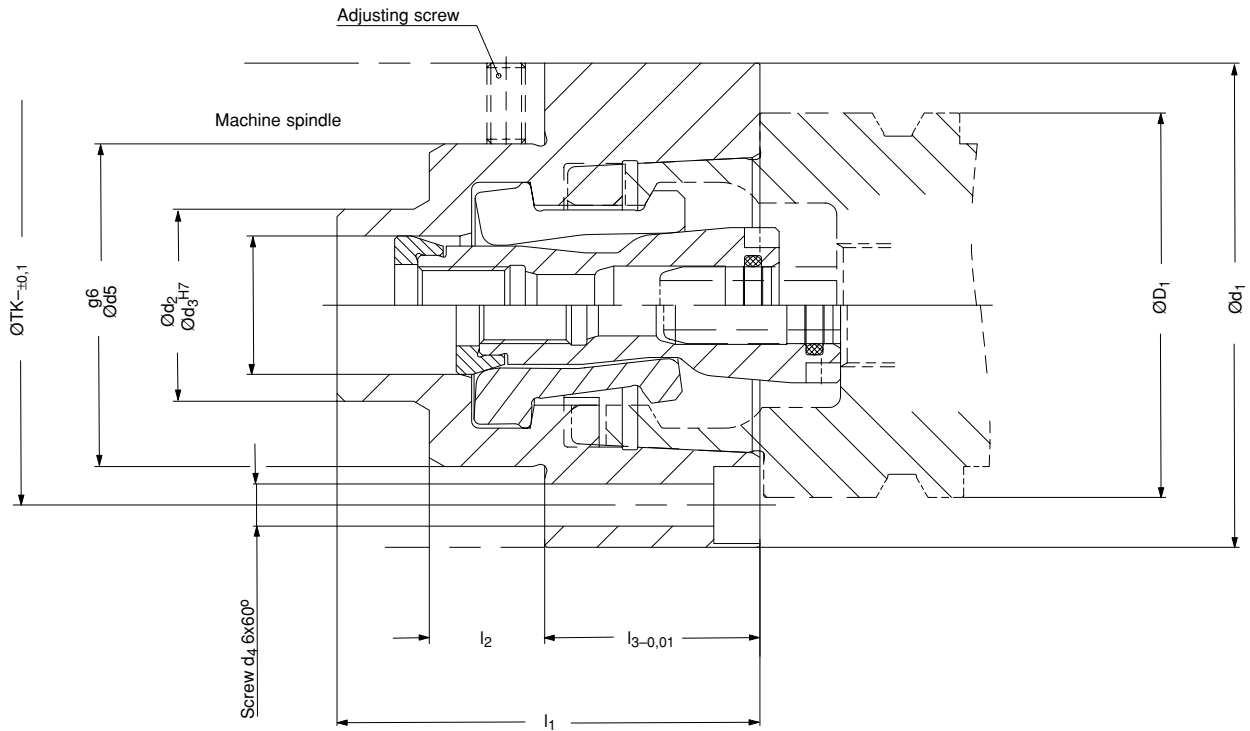
Clamping set with retaining collet

Saving time while changing tools, this clamping set with retaining collet will enable you to make multiple steps in the same time window. Clamping set with clip retaining collet available on request.



Type 288-64

Id.-No.		490980	1015265	1004827			
Clamping unit	HSK	A63/B80	A80/B100	A100/B125			
Draw bar pull	kN	4	6	10			
Pull-in force	kN	25	37,5	50			
Total stroke		16	17	18			
Pull-out stroke	AM	0,5	0,5	0,8			
Adjusting size	EM	10,5	13	13,3			
	d ₂	48	60	75			
	d ₃	21	27	36			
	d ₄	40	50	63			
	d ₅	M12x1	M16x1,5	M20x1,5			
	d ₆	10,5	14,3	17,5			
	d ₇	M33x1	M40x1	M53x1,5			
	l ₁	62	80	98,5			
	l ₂	6,3	8	10			
	l ₃	51,5	67	85,2			
	l ₄	46,2	59,7	73			
	l ₅	19	30	34,5			
	l ₆	28	42	51			
	l ₇	58,2	75	106			



Type 288-74

Initial size HSK-A/C	D ₁	25	32	40	50	63	80	100	125	160
Id.-No.		850282	850283	850284	850285	850286	850287	850288	850289	850290
d ₁		37	40	50	63	80	100	125	148	190
d ₅		24	27	33,5	42	56	68	84	100	125
d ₂		14	18	20	25	30	40	50	60	75
d ₃		10	12	15	18	24	32	40	48	60
d ₄		6xM3	6xM3	6xM4	6xM5	6xM6	6xM8	6xM10	6xM12	6xM16
Ø-TK		29	32	40,5	52	66	82	102	125	160
l ₁		31	36	48	55	68	86	106	120	160
l ₂		8	9	13	15	17	22	26	27	36
l ₃		15,5	19	23	28	35	44	54	70	90
Clamping set HSK-A/B		795554/0001	760431/0001	760432/0001	795557/0001	790581/0001	800369/0001	800370/0001	812522	800096

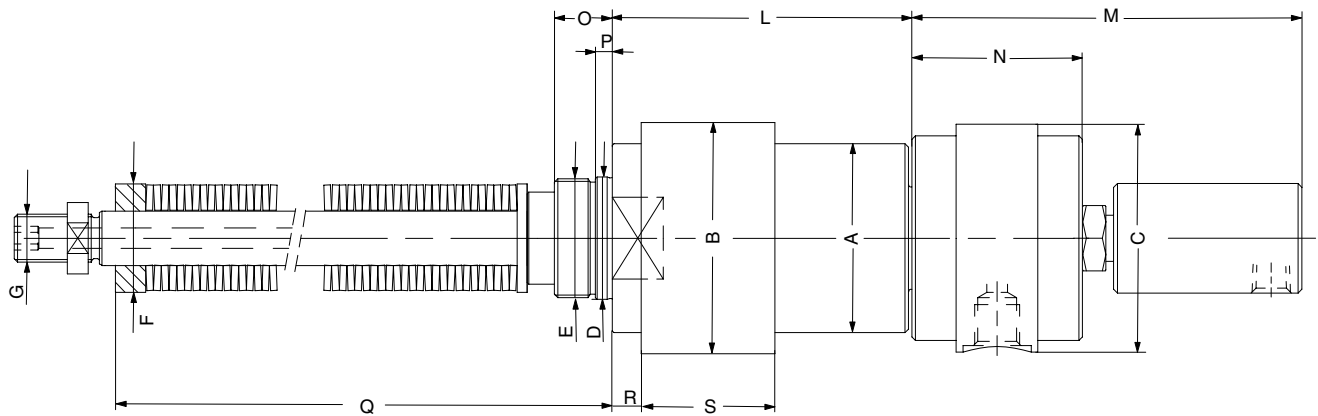
High precision design: l₃ – dyn. balanced: G 2,5 to DIN ISO 1940

Positive taper lock system

Röhm clamping and releasing unit SEH type 286 for automatic clamping system HSK.

The clamping unit is specially designed to meet the requirements of the automatic clamping system HSK:

- mechanical pulling force produced by a pile of springs
- released by a hydraulic system during spindle stop
- control-ring for stroke control – or disc for clamping control optional with or without variable coolant, coolant air or blast air connection
- suitable for high speeds due to rotational symmetry



Coolant supply will be designed while considering the environment.
Internal shape of spindle and drawbar enlargement available on request.

Type 286

Id.-No.		760437	760438	760439	760440	760441	760442
Clamping unit	SEH	32/100	40/200	50/300	63/500	80/750	100/100
	A	36	40	48	55,5	65	84
	B	44	48	60	68	77	97
	C	48	48	62	62	67	67
	D _{g6}	25	32	36	36	48	70
	E	M 24 x 1,5	M 30 x 1,5	M 35 x 1,5	M 35 x 1,5	M 45 x 1,5	M 68 x 1,5
	F _{f7}	21	26	32	32	41	62
	G	M 6	M 10	M 12 x 1,5	M 14 x 1,5	M 16 x 1,5	M 20 x 1,5
	L	68	75	83,5	87	96	125
	M	103	104	108	108	142	165
	N	46	47	51	51	51	51
	O	14	14	17	17	19	25
	P	4	4	5	5	5	8
	Q	104	167	193,4	261	264	279
Opening position		1,5	2	0,5	0,5	1,5	3
Clamping position	R	6,5	10	8,5	8,5	12,5	15
Total stroke		9	13	16	16	18	20
	S	30	34	38,5	39	45	60
Pull force	(kN)	1	2	3	5	7,5	10
Max. opening force	(bar)	80	80	80	80	80	80