



Precision ER collet chuck HDC, BT 40 A = 90, for ER collets: 32AD



Order data

Order number	302896 32AD
GTIN	2050002068759
Item class	33F

Description

Version:

- Taper ground internally and externally with RFID/Balluffchip bore.
- Concentricity and repetition accuracy 3 µm at 3×D, maximum 50 mm when using a HP precision collet.
- **HDC = Heavy Duty Chuck, a mount specially designed for rough machining. A reinforced chuck body ensures better stability and plenty of radial stiffness. Taper ground internally and externally. Ball-bearing clamping nut with trapezoidal-shaped fine thread for optimum tightening torques and clamping forces, reduces vibrations that occur.**
- **Very high clamping forces due to the collet fully seated in the chuck and coated clamping nut.**
- **Vibration damping due to the element collet and mass of the chuck.**
- **Alternatively for CENTRO P -> without seals, with ER clamping nut CP No. 309655 or sealed system with ER clamping nut CP for HP sealing rings No. 309665 in conjunction with HP sealing rings No. 309666 – 309668 (for internal coolant supply or as a dirt trap).**

Advantage:

Patented optimum seating of the collet, double guides, trapezoidal thread and low-friction coated clamping nut amalgamate when clamped into a sturdy unit, thus ensuring a very high degree of rigidity and precision.

Application:

For high precision clamping of tools with plain shank. HDC especially well-suited for roughing (including TPC milling) and finishing operations and machining of high-tensile or tough materials.

Supplied with:

Supplied with ball-bearing clamping nut.

Optional extras:

Pull studs (PS) No. 308600 – 308806, PS wrenches No. 308820 – 308835, precision ER collets for HP No. 309368 - 309381 and for taps No. 309402 – 309419 (not for Horex). ER clamping nuts CP No. 309655; 309665, ER clamping nut HDC No. 309657, HP sealing rings No. 309666 – 309668, CP roller bearing wrench No. 309754; 309756, HDC roller bearing wrench No. 309745; 309756.

Note:

- **Clamps only nominal \varnothing up to shank \varnothing tolerance h10.**
- **Use in combination with Fahrion collets.**
- **Not compatible with CP clamping nut.**

Machining strategy: HSC

Shape: AD

Concentricity ER collet with HDC collet chuck: $\leq 6 \mu\text{m}$

Concentricity HP collet with HDC collet chuck: $\leq 3 \mu\text{m}$

Clamping range: 2 - 20 mm

Overhang dimension A: 90 mm

External \varnothing D: 53 mm

Technical description

Clamping range	2 - 20 mm
External \varnothing D	53 mm
for ER collets	32AD
Shape	AD
Overhang dimension A	90 mm
Concentricity ER collet with HDC collet chuck	$\leq 6 \mu\text{m}$
Concentricity HP collet with HDC collet chuck	$\leq 3 \mu\text{m}$
Clamping \varnothing D ₁	2-20 mm
Adapter	BT 40 A = 90
Arbor standard	JIS B6339
Arbor standard	JIS B6339
Balance quality G at rotational speed	G 2.5 at 25,000 rpm
Concentricity ER collet with CP collet chuck	$\leq 6 \mu\text{m}$
Concentricity HP collet with CP collet chuck	$\leq 3 \mu\text{m}$
Machining strategy	HSC
Type of product	Collet chuck

Accessories

ER clamping nut CENTRO P HDC Type HDC for ER 32HDC

309657 32HDC