



Precision ER collet chuck HDC, HSK-A 100 A = 100, for ER collets: 32



Order data

Order number	305954 32
GTIN	2050002068780
Item class	33F

Description

Version:

- Ground externally and internally 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. Ball-bearing clamping nut with trapezoidal-shaped fine thread for optimum tightening torques and clamping forces reduces vibration.
- 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.

Advantage:

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

Application:

HDC especially well-suited for roughing (including TPC milling) and finishing operations and machining of high-tensile or tough materials.

For high precision clamping of tools with plain shank.

Supplied with:

Supplied with ball-bearing clamping nut.

Optional extras:

Coolant pipe No. 309880, socket wrench No. 309890, precision ER collets for HP No. 309368 – 309381, and for taps No. 309402 – 309419 (not for Horex), ER CP clamping nuts No. 309655;

309665, ER HDC clamping nuts No. 309657, HP sealing rings No. 309666 – 309668, CP roller bearing wrenches No. 309754; 309756, HDC roller bearing wrenches No. 309745/309756.

Note:

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

Machining strategy: HSC

Shape: A

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: 100 mm

External \varnothing D: 53 mm

Technical description

External \varnothing D	53 mm
Shape	A
Overhang dimension A	100 mm
Clamping range	2 - 20 mm
for ER collets	32
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	HSK-A 100 A = 100
Arbor standard	ISO 12164-1
Arbor standard	DIN 69893
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