



HSK-T Werkzeugspannsysteme Tooling Systems



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MEMBER OF
MACHINING
INNOVATIONS NETWORK

HSK-T ISO 12164-3

Der HSK-T Hohlenschaftkegel wurde entwickelt für Anwendungen beim Drehen. Das große Interesse am Einsatz von HSK zum Drehen hat zu der weltweit gültigen ISO Norm HSK-T 12164-3 geführt.

HSK-T interface was developed to maximize cutting ability of multi-tasking machines.

HSK-T interface became ISO standard (ISO121 164-3:2008) in 2008

HSK-T Merkmale 1

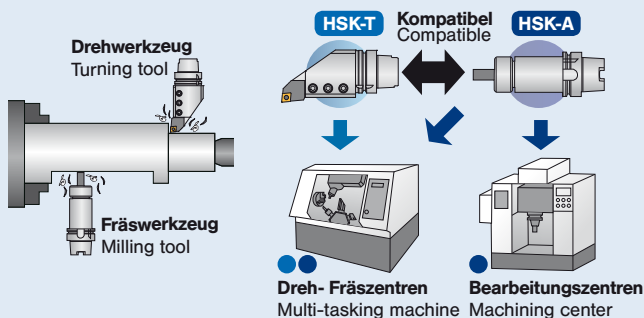
Features 1

Der HSK-T Hohlenschaftkegel ist kompatibel mit dem HSK-A für rotierende Anwendungen.
HSK-T shank is compatible with HSK-A shank that is used for machining centers.

Dreh- Fräszentren

HSK-T Werkzeugsysteme bieten minimale Wechselzeiten und höchste Genauigkeit auf Drehmaschinen und Dreh- Fräszentren - herstellerunabhängig

Multi-tasking machine combines milling and turning processes, which were conventionally processed on multiple machines, onto one machine



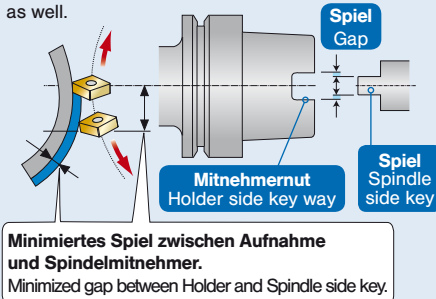
HSK-T Merkmale 2

Features 2

Erhöhte Produktivität bei der Drehbearbeitung.
Increased cutting accuracy at turning process.

Der Unterschied zu den HSK-Formen für rotierende Anwendungen liegt in den enger tolerierten Mitnehmernuten. Sie garantieren die für das Drehen wichtige radiale Positioniergenauigkeit.

HSK-T shank was designed to minimize the gap between the key and key way. Consequently, cutting edge height was sustained accurately and cutting accuracy was improved. Invariant cutting diameter was realized as well.



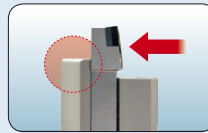
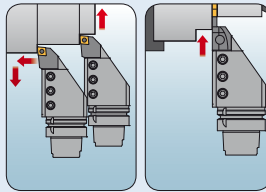
- **Hohe Wechsel- und Wiederholgenauigkeit**
• High change and repeat accuracy
- **Hohe Passgenauigkeit**
• High fitting accuracy
- **Hohe Steifigkeit**
• High rigidity
- **Exakte radiale Positioniergenauigkeit**
• Precise radial position accuracy
- **Hohe Flexibilität**
• High flexibility
- **Korrosionsgeschützt**
• Rust proofed
- **Eine Schnittstelle für Drehen und Fräsen**
• One interface for turning and milling

SBV

Werkzeughalter für
Klemmhalter mit
4kant-Schaft

Toolholders for
External / Cut-off

□20, □25, □32



Hohe Steifigkeit durch
optimiertes Design

High rigidity by bit support design.

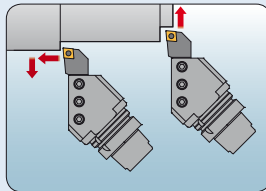


SBN

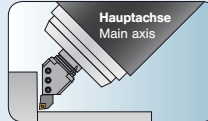
Werkzeughalter für
Klemmhalter mit
4kant-Schaft

Toolholders for
External / Facing

□20, □25, □32



Optimierte Störkontur für schwer
zugängliche Werkstückstellen.
Interference with work piece can
be avoided by tilting main axis.

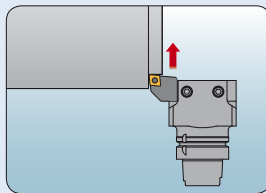


SBH

Werkzeughalter für
Klemmhalter mit
4kant-Schaft

Toolholders for Facing

□20, □25, □32



Mit einstellbaren Kühlmitteldüsen,
für Links- und Rechtslauf.



Coolant feeding enabled for both
Right- and Left-hand.

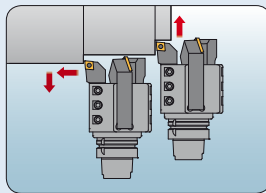


SBT

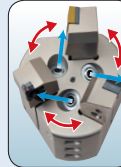
Werkzeughalter für
Klemmhalter mit
4kant-Schaft

Toolholders for
External / Facing

□20, □25



Axial, 3fach mit einstellbaren
Kühlmitteldüsen



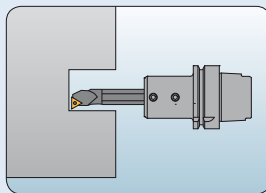
Coolant feeding
enabled for all
three bits.



TSB

Bohrstangenhalter
Boring bar holders

ø 8-50



Flexibel durch Reduzierhülsen
Mit Innenkühlung



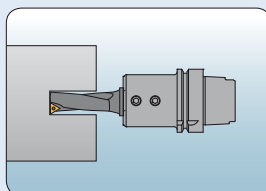
Coolant/Size reduction sleeve.
Coolant feeding enabled for
boring bar without oil
hole using TSS sleeve.



TSD

Werkzeughalter für
Wendeplattenbohrer
Toolholders for Drills

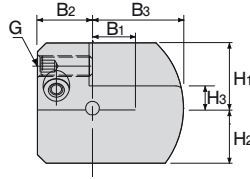
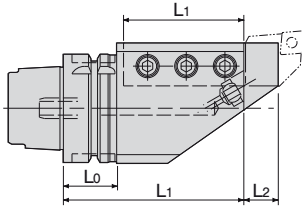
ø 16-50



Mit Innenkühlung

Coolant feeding enabled

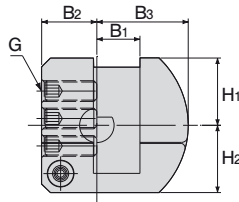
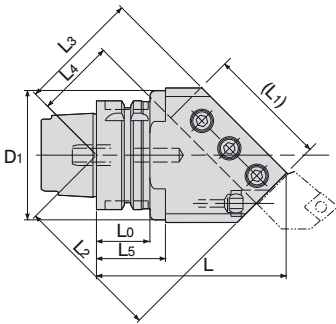




Modell Model			L	L1	L2	B1	B2	B3	H1	H2	H3	L0	G
HSK50T	-SBV2020	R	95	60	15	20	25	43,5	25	25	5	31	M10
		L	95	60	15	20	25	43,5	25	25	5	31	M10
HSK63T	-SBV2020	R	95	60	15	20	32	43,5	33	32	13	32	M10
		L	95	60	15	20	32	43,5	33	32	13	32	M10
	-SBV2525	R	105	70	20	25	32	45	30	30	5	32	M12
		L	105	70	20	25	32	45	30	30	5	32	M12
HSK100T	-SBV2525	R	150	110	20	25	37	59	48	43	23	35	M12
		L	150	110	20	25	37	59	48	43	23	35	M12
	-SBV3232	R	150	110	20	32	40	68,5	45	43	15	35	M14
		L	150	110	20	32	40	68,5	45	43	15	35	M14

1. Kühlmitteldüsen einstellbar.

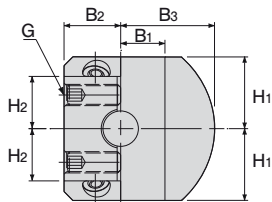
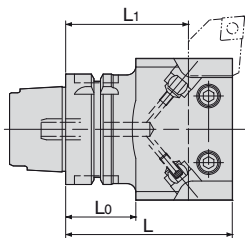
1. Direction of coolant nozzle can be adjusted.



Modell Model			L	(L1)	L2	L3	L4	L5	D1	B1	B2	B3	H1	H2	L0	G
HSK50T	-SBN2020	R	110	60	83,1	72,8	52,8	-	-	20	25	43,5	35	35	31	M10
		L	110	60	83,1	72,8	52,8	-	-	20	25	43,5	35	35	31	M10
HSK63T	-SBN2020	R	110	60	83,1	72,8	52,8	-	-	20	32	43,5	35	35	32	M10
		L	110	60	83,1	72,8	52,8	-	-	20	32	43,5	35	35	32	M10
	-SBN2525	R	110	70	85,2	70,8	45,8	40	90	25	32	53	39	39	32	M12
		L	110	70	85,2	70,8	45,8	40	90	25	32	53	39	39	32	M12
HSK100T	-SBN2525	R	135	70	102,9	88,5	63,5	-	-	25	32	59	43	43	35	M12
		L	135	70	102,9	88,5	63,5	-	-	25	32	59	43	43	35	M12
	-SBN3232	R	140	85	109,9	89	59	-	-	32	37	68,5	48	43	35	M14
		L	140	85	109,9	89	59	-	-	32	37	68,5	48	43	35	M14

1. Kühlmitteldüsen einstellbar.

1. Direction of coolant nozzle can be adjusted.



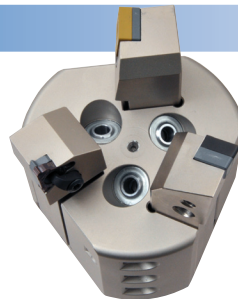
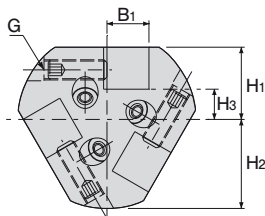
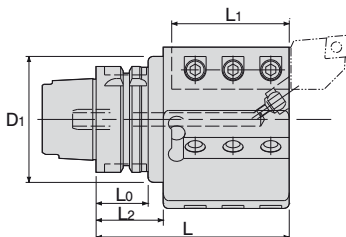
	Modell Model		L	L1	B1	B2	B3	H1	H2	L0	G
HSK50T	-SBH2020	N -90	90	70	20	25	43,5	27,5	-	40	M10
		N -120	120	100	20	25	43,5	27,5	-	70	M10
HSK63T	-SBH2020	N -90	90	70	20	32	43,5	30	-	40	M10
		N -120	120	95	25	32	53	40,5	29,5	70	M12
HSK100T	-SBH2525	N -105	105	80	25	32	59	48	37	35	M12
		N -150	150	125	25	32	59	48	37	35	M12
	-SBH3232	N -105	105	75	32	40	68,5	57	43	35	M14

1. Kühlmitteldüsen einstellbar.

2. Eine Verschlusschraube für Kühlmitteldüsen (M5x15) ist im Lieferumfang enthalten.

1. Direction of coolant nozzle can be adjusted.

2. One plug screw for coolant nozzle (M5x15) is included.



	Modell Model		L	L1	L2	D1	B1	H1	H2	H3	L0	G
HSK50T	-SBT2020	R -95	95	60	-	-	20	35	43,5	15	31	M10
		L -95	95	60	-	-	20	35	43,5	15	31	M10
HSK63T	-SBT2020	R -95	95	60	-	-	20	35	43,5	15	32	M10
		L -95	95	60	-	-	20	35	43,5	15	32	M10
HSK100T	-SBT2525	R -115	115	70	40	90	25	43	53	18	32	M12
		L -115	115	70	40	90	25	43	53	18	32	M12
HSK100T	-SBT2525	R -150	150	110	-	-	25	48	59	23	35	M12
		L -150	150	110	-	-	25	48	59	23	35	M12

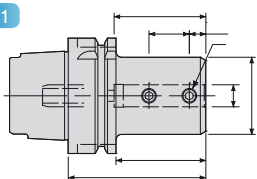
1. Kühlmitteldüsen einstellbar.

2. Zwei Verschlusschraube für Kühlmitteldüsen (M5x15) sind im Lieferumfang enthalten.

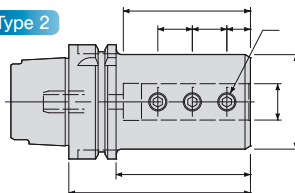
1. Direction of coolant nozzle can be adjusted.

2. Two plug screw for coolant nozzle (M5x15) is included.

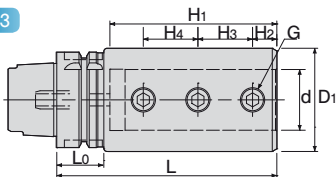
Type 1



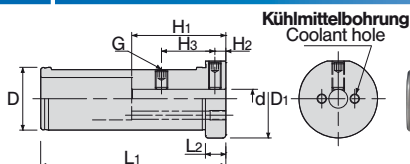
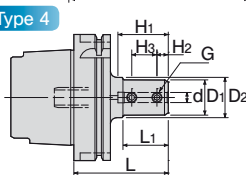
Type 2



Type 3



Type 4

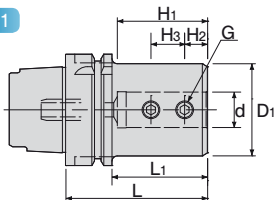


1. Für Anwendungen mit IKZ, Kühlmittelbohrung verschließen (M6x10, im Lieferumfang enthalten).
2. Flexibel durch die Verwendung von Reduzierhülsen.

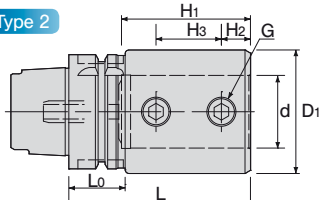
1. For coolant use, plug one of the two coolant holes with plug screw (M6x10 included in delivery).
2. Various sizes of boring bars can be clamped by using reduction sleeves.

Modell Model		d	L ₁	L ₂	D	D ₁	H ₁	H ₂	H ₃	G
TSS40	-8	8	118	13	40	50	50	7	34	M8
	-10	10	118	13	40	50	50	7	34	M8
	-12	12	118	13	40	50	60	7	34	M8
	-16	16	118	13	40	50	70	7	34	M8

Type 1



Type 2


Bestellbeispiel • Ordering Example

HSK63T - **TSD** **25** - **85**
 Nenngröße d L
 Size

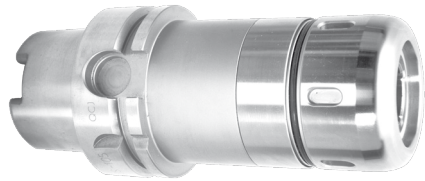
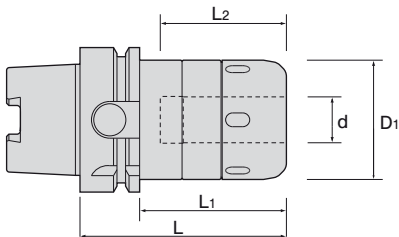
Kühlmittelrohr im Lieferumfang enthalten
 Coolant pipe included in delivery

	Modell Model		Type	d	L	L ₁	D ₁	D ₂	H ₁	H ₂	H ₃	H ₄	L ₀	G
HSK50T	-TSB8	-65	1	8	65	39	28	-	40	9	20	-	-	M8
	-TSB10	-70	1	10	70	44	35	-	45	9	22	-	-	M8
	-TSB12	-75	1	12	75	49	42	-	50	9	22	-	-	M8
	-TSB16	-95	2	16	95	69	48	-	70	14	18	18	-	M10
	-TSB20	-95	3	20	95	-	52	-	70	14	18	18	31	M10
	-TSB25	-110	3	25	110	-	62	-	85	14	26	26	31	M12
	-TSB32	-125	3	32	125	-	62	-	100	14	30	30	31	M12
HSK63T	-TSB8	-65	1	8	65	39	28	-	40	9	20	-	-	M8
	-TSB10	-70	1	10	70	44	35	-	45	9	22	-	-	M8
	-TSB12	-75	1	12	75	49	42	-	50	9	22	-	-	M8
	-TSB16	-100	2	16	100	74	48	-	70	14	18	18	-	M10
	-TSB20	-100	2	20	100	74	52	-	70	14	18	18	-	M10
	-TSB25	-115	2	25	115	89	62	-	85	14	26	26	-	M12
	-TSB32	-130	2	32	130	104	62	-	100	14	30	30	-	M12
HSK100T	-TSB40	-145	3	40	145	-	68	-	115	16	36	36	32	M16
	-TSB8	-75	4	8	75	36	28	32	40	9	20	-	-	M8
	-TSB10	-80	1	10	80	51	35	-	45	9	22	-	-	M8
	-TSB12	-85	1	12	85	56	42	-	50	9	22	-	-	M8
	-TSB16	-105	2	16	105	76	48	-	70	14	18	18	-	M10
	-TSB20	-105	2	20	105	76	52	-	70	14	18	18	-	M10
	-TSB25	-120	2	25	120	91	62	-	85	14	26	26	-	M12
	-TSB32	-135	2	32	135	106	72	-	100	14	30	30	-	M12
	-TSB40	-150	2	40	150	121	82	-	115	16	36	36	-	M16
	-TSB50	-180	2	50	180	151	92	-	145	18	38	38	-	M16

Bestellbeispiel • Ordering Example

HSK63T - **TSB** **10** - **70**
 Nenngröße d L
 Size

	Modell Model		Type	d	L	L ₁	D ₁	H ₁	H ₂	H ₃	L ₀	G
HSK50T	-TSD16	-75	1	16	75	49	48	49	14	18	-	M10
	-TSD20	-80	2	20	80	-	52	51	14	18	31	M10
	-TSD25	-85	2	25	85	-	62	57	14	26	31	M12
	-TSD32	-90	2	32	90	-	62	61	14	30	31	M12
HSK63T	-TSD16	-75	1	16	75	49	48	49	14	18	-	M10
	-TSD20	-80	1	20	80	54	52	51	14	18	-	M10
	-TSD25	-85	1	25	85	59	62	57	14	26	-	M12
	-TSD32	-90	1	32	90	64	62	61	14	30	-	M12
	-TSD40	-100	2	40	100	-	68	71	16	36	32	M16
HSK100T	-TSD16	-85	1	16	85	56	48	49	14	18	-	M10
	-TSD20	-85	1	20	85	56	52	51	14	18	-	M10
	-TSD25	-90	1	25	90	61	62	57	14	26	-	M12
	-TSD32	-95	1	32	95	66	72	61	14	30	-	M12
	-TSD40	-105	1	40	105	76	82	71	16	36	-	M16
	-TSD50	-115	1	50	115	86	92	81	18	38	-	M16


3.0
32.0
0.005
3xD
max.
20.000
min⁻¹

IKZ
HPC

ISO 12 164-3

Modell	d	D1	L	L1	L2		
HSK63T -CT20S -90	20	52	90	64	60	MC20-d	HS-2-20
-CT32S -105	32	73	105	-	75	MC32-d	HS-3-32

1. Detaillierte Informationen zu den passenden Spannhülsen und Spannschlüsseln finden Sie im Hauptkatalog.

1. Detailed informations for suitable Collets and Spanners can be found in our general catalogue.

-  **Höchste Drehmomente**
-  **Hohe Rundlaufgenauigkeit**
-  **Großer Spannbereich**



-  High clamping forces
-  High run out accuracy
-  Large clamping range

