

夹持系统 Clamping Systems



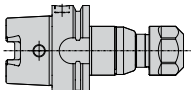
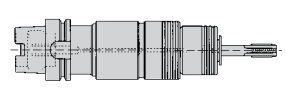
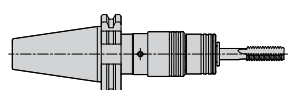
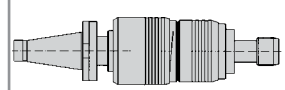
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快换钻削刀柄

Quick change drilling chucks

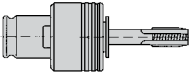
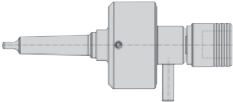
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钻削 DRILLING

											
同步攻丝刀柄 Synchro Tapping Chucks		快换攻丝刀柄 Quick change tapping chucks		快换攻丝刀柄 Quick change tapping chucks		攻丝装置 Tapping attachments		快换攻丝刀柄 Quick change tapping chucks			
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攻丝 TAPPING

	圆跳动 Concentricity		扳手 Wrench
	长度调整 Length adjustment		密封垫圈 Sealing disc
	长度补偿压缩 Length compensation compression		弹簧筒夹 Collet
	长度补偿拉伸 Length compensation tension		螺钉 Screw
	径向浮动 Radial parallel float		夹紧螺母 Collet nut
	安全夹紧装置 Safety clutch		SBK快换刀柄 Quick change chuck SBK
	最小微量冷却 (MQL) 10 bar Minimum quantity lubrication (MQL) 10 bar		SEK快换夹头 Quick change adapter SEK
	硬启动, 仅压缩, 非WFLK 尺寸0 Hard start, only with compression, not at WFLK size 0		WES快换夹头 Quick change adapter WES
	带球轴承 Ball carried		螺纹尺寸 Thread size
	冷却供给 Coolant feed		带开口槽 with cotter slot
	冷却供给 Coolant feed		WEK快换夹头 Quick change adapter WEK
	Rubber-Flex® Rubber-Flex®		攻丝刀柄 Tapping chuck

														
快换攻丝刀柄 Quick change tapping chucks			攻丝装置 Tapping attachments			丝锥延长杆 Tap extension			攻丝刀柄 Tapping chucks			攻丝装置 Tapping attachments		
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应用：Gewindeschneiden, -formen

在机床上以同步进给（速度/进给同步）进行攻丝和螺纹挤压

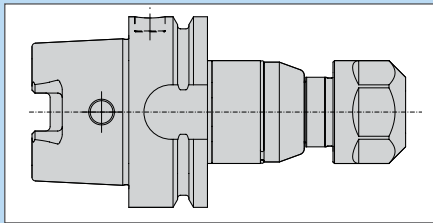
机器型号：

用于攻丝操作的具有同步进给的加工中心、数控车削和特殊用途机床

Application: tapping, roll forming

on machines with synchronized feed (speed/feed synchronisation, also named Rigid Tapping)

Machine type: machining centres, CNC-turning and special purpose machines with synchronized feed for the tapping operation



市场需求激发了BILZ同步攻丝刀柄新设计的研发。可以从刀柄的两侧对丝锥长度进行预调，优化了最小微量冷却，确保喷到丝锥的应用过程中无泄漏。

拉伸和压缩长度补偿（ $\pm 0,15 \text{ mm}$ ）结合径向抑制作用，可以补偿细微的同步和位置异常。

通过这个清晰的补偿应用，用户得到了小的丝锥侧面磨损并极大地减少了切削负载，从而提高丝锥寿命，并使之更好的与机床配合。

“高弹体”阻尼元件和长度补偿元件的使用使形状更稳定，它们还能抵御现代工业中使用的所有冷却液物质。阻尼元件因预定了长度补偿而保持稳定，因此消除了任何潜在的塑性变形。用户将从由此产生的恒定切削条件中获得效益。

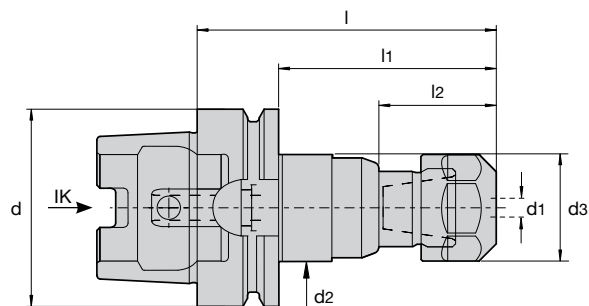
Market demands have triggered the development of the new design BILZ synchro chucks. Adjustment of the chuck with regard to the taps pre-setting position can be completed from both sides of the chuck, the minimum quantity lubrication has been optimised and comes with an absolute leak free application of lubrication flow to the tap.

The tension and compression length compensation, (e.g. $\pm 0,15 \text{ mm}$) in combination with radial dampening effect compensates small synchronisation and location anomalies.

Through this defined application compensation the user achieves reduced tap flank wear in combination with considerably less cutting loads which in turn increases tap life and is more machine friendly.

The use of the “Elastomere” dampening and length compensating elements are form-secure, they are also resistant to all coolant substances used in today’s modern industries. Dampening elements remain stable due to the predetermined length compensation thus eliminating any potential plastic deformation. This results in a constant cutting condition and therefore the user benefits.

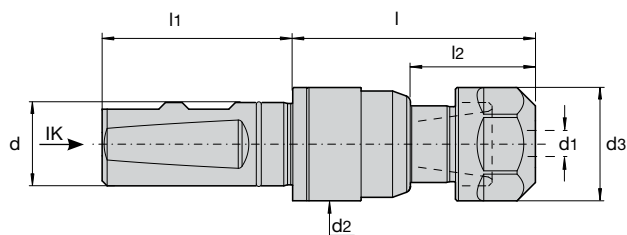
特点:	优势:	效益:
■ 最小拉伸/压缩补偿	■ 螺纹侧面的压力减小 ■ 当主轴反转时同步误差补偿	■ 丝锥使用寿命更长，所需刀具更少 ■ 丝锥断裂的风险降低 ■ 螺纹质量更高
Features:	Advantages:	Benefits:
■ minimum compensation on tension/compression	■ reduction of the pressure on the thread flanks ■ compensation of the synchronisation error, while reversing the spindle	■ higher life time of the taps, less number of tools required ■ reduced risk of tool breakage ■ better thread quality



SCK/HSK-A – ESX

型号/订货号 Designation/Id. No.									  		
		d	d1	d2	d3	l	l1	l2	关于夹紧装置和组件， 请参见第10 – 12， 26 – 29页 Clamping units and components see page 10 – 12, 26 – 29		
SCK0-69/HSK-A40-ESX12-BL 5015729	+/-0,15	40	M2 – M8 2,8 – 6,0	25	25	69	49	24,5		DIN902-17 6953508	EX12-Ø-IC
SCK0-75/HSK-A50-ESX12-BL 5040620	+/-0,15	50	M2 – M8 2,8 – 6,0	25	25	75	49	24,5		DIN902-17 6953508	EX12-Ø-IC
SCK1-89,5/HSK-A40-ESX20-BL 5053602	+/-0,15	40	M4 – M12 4,5 – 11,2	34	34	89,5	69,5	37,5		DIN 984-30 6934034	EX20-IC 6931227
SCK1-94/HSK-A50-ESX20-BL 5052056	+/-0,15	50	M4 – M12 4,5 – 11,2	34	34	93,5	67,5	37,5		DIN 984-30 6934034	EX20-IC 6931227
SCK1-95,5/HSK-A63-ESX20-BL 5010567	+/-0,15	63	M4 – M12 4,5 – 11,2	34	34	95,5	69,5	37,5		DIN 894-30 6934034	EX20-IC 6931227
SCK1-160/HSK-A63-ESX20-BL 5013409	+/-0,15	63	M4 – M12 4,5 – 11,2	34	34	160	134	37,5		DIN 894-30 6934034	EX20-IC 6931227
SCK1-100/HSK-A80-ESX20-BL 5053619	+/-0,15	80	M4 – M12 4,5 – 11,2	34	34	100	74	37,5		DIN984-30 6934034	EX20-IC 6931227
SCK1-102/HSK-A100-ESX20-BL 5012119	+/-0,15	100	M4 – M12 4,5 – 11,2	34	34	102	73	37,5		DIN 894-30 6934034	EX20-IC 6931227
SCK2-124/HSK-A50-ESX32-BL 5040633	+/-0,15	50	M8 – M20 6 – 18	50	50	124	104	43,5		E32 6921609	EX32-IC 6933897
SCK2-109/HSK-A63-ESX32-BL 5011981	+/-0,15	63	M8 – M20 6 – 18	50	50	109	83	43,5		E 32 6921609	EX32-IC 6933897
SCK2-113,5/HSK-A80-ESX32-BL 5040636	+/-0,15	80	M8 – M20 6 – 18	50	50	113,5	87,5	43,5		E32 6921609	EX32-IC 6933897
SCK2-115,5/HSK-A100-ESX32-BL 5012062	+/-0,15	100	M8 – M20 6 – 18	50	50	115,5	86,5	43,5		E 32 6921609	EX32-IC 6933897
SCK3-146,5/HSK-A63-ESX40-BL 5017524	+/-0,8	63	M14 – M30 11 – 22	63	58,5	146,5	120,5	50,3		E 40 6921610	EX40-IC 6948425
SCK3-136/HSK-A80-ESX40-BL 5040638	+/-0,8	80	M14 – M30 11 – 22,0	63	58,5	136	110	50,3		E40 6021610	EX40-IC 6948425
SCK3-138/HSK-A100-ESX40-BL 5017526	+/-0,8	100	M14 – M30 11 – 22	63	58,5	138	109	50,3		E 40 6921610	EX40-IC 6948425
SCK4-205/HSK-A100-ESX50-BL 5085403	+/-2,0	100	M30 – M42 22 – 32	100	78	205	176	66	E 50 6951711	EX50-IC 5085410	

包括冷却液管。不包含夹紧装置（第10–12页）和调节扳手（第26–29页）。
 Coolant tube included. Clamping unit (page 10 – 12) and wrench (page 26 – 29) not included.



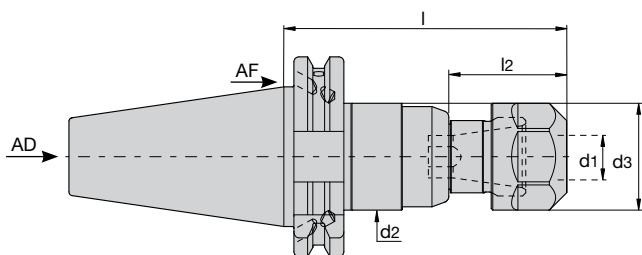
DIN
1835
B+E



SCK/W – ESX											
型号/订货号 Designation/Id. No.		d	d1	d2	d3	l	l1	l2			
SCK0-50/W16-ESX12-BL 5053631	+/-0,15	16	M2 – M8 2,8 – 6,0	25	25	50	49	24,5	关于夹紧装置和组件, 请参见第10 – 12, 26 – 29页 Clamping units and components see page 10 – 12, 26 – 29	DIN902-17 6953508	EX12-Ø-IC
SCK1-73/W20-ESX20-BL 5053635	+/-0,15	20	M4 – M12 4,5 – 11,2	34	34	73	51	37,5		DIN894-30 6934034	EX20-IC 6931227
SCK1-73/W25-ESX20-BL 5012220	+/-0,15	25	M4 – M12 4 – 11,2	34	34	73	57	37,5		DIN 894-30 6934034	EX20-IC 6931227
SCK2-87,5/W25-ESX32-BL 5012276	+/-0,15	25	M8 – M20 6 – 20	50	50	87,5	57	43,5		E 32 6921609	EX32-IC 6933897
SCK3-113,5/W32-ESX40-BL 5017528	+/-0,8	32	M14 – M30 11 – 22	63	58,5	113,5	61	50,3		E 40 6921610	EX40-IC 6948425
SCK4-176/W40-ESX50-BL 5085404	+/-2,0	40	M30 – M42 22 – 32	100	78	176	71	66		E 50 6951711	EX50-IC 5085410

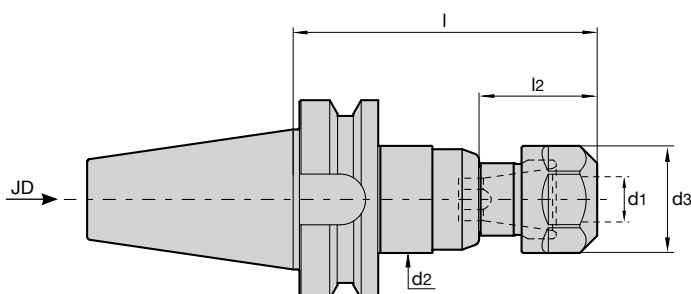
SCK0... /ESX12交货时不包括螺帽 (看第10页SPE)

SCK0... /ESX12 are delivered without nut (see SPE, page 10)



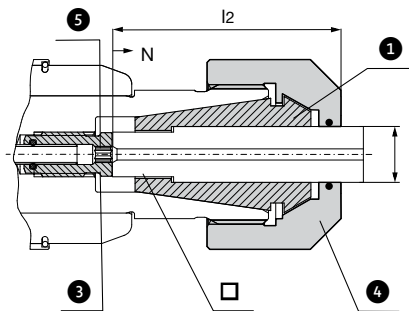
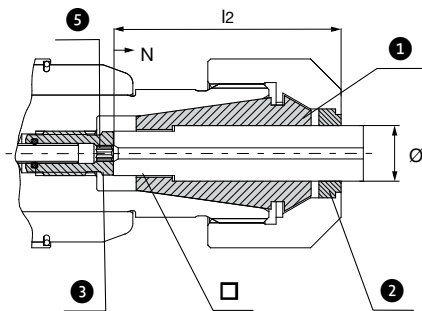
SCK/ADF – ESX (Alt/Old: DIN 69871, ADB)										
型号/订货号 Designation/Id. No.	 						  			
		d1	d2	d3	l	l2				
SCK1-90/ADB40-ESX20-BL 5053645	+/-0,15	M4–M12 4,5 – 11,2	34	34	90	37,5	关于夹紧装置和组件，请参见第10 – 12，26 – 29页 Clamping units and components see page 10 – 12, 26 – 29	DIN 894-30 6934034	EX20-IC 6931227	
SCK1-90/ADB50-ESX20-BL 5053646	+/-0,15	M4–M12 4,5 – 11,2	34	34	90	37,5		DIN 894-30 6934034	EX20-IC 6931227	
SCK2-101/ADB40-ESX32-BL 5053647	+/-0,15	M8–M20 6 – 18	50	50	101	43,5		E 32 6921609	EX32-IC 6933897	
SCK2-101/ADB50-ESX32-BL 5053648	+/-0,15	M8–M20 6 – 18	50	50	101	43,5		E 32 6921609	EX32-IC 6933897	
SCK3-123/ADB50-ESX40-BL 5053649	+/-0,8	M14–M30 11 – 22	63	58,5	123	50,3		E 40 6921610	EX40-IC 6948425	
SCK4-212/ADB50-ESX50-BL 5085407	+/-2,0	M30 – M42 22 – 32	100	78	212	66		E 50 6951711	EX50-IC 5085410	

不包含夹紧装置（第10–12页）和调节扳手（第26–29页）。
 Clamping unit (page 10–12) and wrench (page 26–29) not included.



SCK/JD – ESX (Alt/Old: MAS403, BT)												
型号/订货号												
Designation/Id. No.			d1	d2	d3	l	l2					
SCK1-91,5/BT30-ESX20-BL 5049400	+/-0,15		M4–M12 4,5–11,2	34	34	91,5	37,5	关于夹紧装置和组件，请参见第10 – 12, 26 – 29页 Clamping units and components see page 10 – 12, 26 – 29			DIN984-30 6934034	EX20-IC 6931227
SCK1-96,5/BT40-ESX20-BL 5053652	+/-0,15		M4–M12 4,5–11,2	34	34	96,5	37,5			DIN 894-30 6934034	EX20-IC 6931227	
SCK1-107,5/BT50-ESX20-BL 5053653	+/-0,15		M4–M12 4,5–11,2	34	34	107,5	37,5			DIN 894-30 6934034	EX20-IC 6931227	
SCK2-120/BT30-ESX32-BL 5053654	+/-0,15		M8–M20 6–18	50	50	120	43,5			E 32 6921609	EX32-IC 6933897	
SCK2-110/BT40-ESX32-BL 5053655	+/-0,15		M8–M20 6–18	50	50	110	43,5			E 32 6921609	EX32-IC 6933897	
SCK2-121/BT50-ESX32-BL 5053656	+/-0,15		M8–M20 6–18	50	50	121	73,5			E 32 6921609	EX32-IC 6933897	
SCK3-141,5/BT50-ESX40-BL 5053658	+/-0,8		M14–M30 11–22	63	58,5	141,5	50,3				E 40 6921610	EX40-IC 6948425

不包含夹紧装置（第10–12页）和调节扳手（第26–29页）。
 Clamping unit (page 10–12) and wrench (page 26–29) not included.



N = 调节量
Adjustment
l2 = 插入深度
Insert depth
Ø = 柄部直径
Shank diameter
□ = 驱动方尾
Drive square

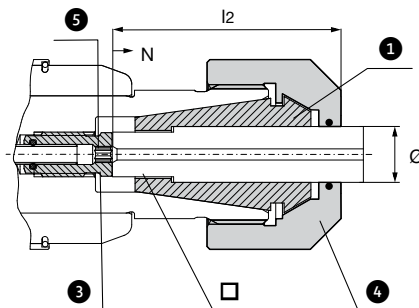
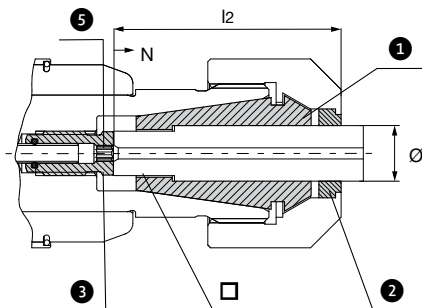


ESX DIN/ISO

C版ESX 夹紧装置 Clamping unit ESX Version C

组成部分: consisting of:

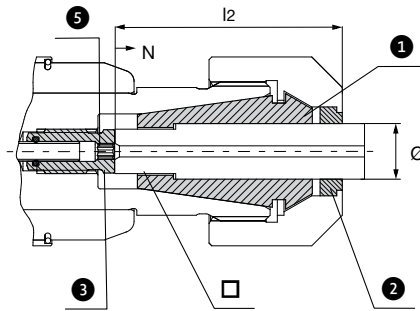
型号/订货号 Designation/Id. No.	SCK.../ ESX...	 Ø x □	DIN	ISO	l2	N	 ①	 ②	 ③	 ⑤
SPE4x3,2C-ESX12 5020194	SCK0/ ESX12	4 x 3,15/3,2		M4 M5	23,5	2	ESX12GB-4x3,15/3,2 5020195	EX12-4-IC 5020211	SCK010C-4x3,2 5020198	2
SPE4,5x3,4C-ESX12 5020214		4,5 x 3,4	M4 M6	23,5	ESX12GB-4,5x3,4 5020217		EX12-4,5-IC 5020219	SCK010C-4,5x3,4 5020221		
SPE5x4C-ESX12 5020215		5,0 x 4,0		M5	24,5		ESX12GB-5x4 5020218	EX12-5-IC 5020220	SCK010C-5x4 5020222	
SPE6x4,9C-ESX12 5020216		6,0 x 4,9	M5, M6, M8		25,5		ESX12GB-6x4,9 6950826	EX12-6-IC 6952625	SCK010C-6x4,9 5020223	
SPE4,5x3,4C-ESX20 5013770		4,5 x 3,4	M4 M6		29		ESX20GB-4,5x3,4 6948389	DS/ER20-4,5 6948386	SCK110C-4,5x3,4 5013780	
SPE5x4C-ESX20 5013774	SCK1/ ESX20	5,0 x 4,0		M5	30	3	ESX20GB-5x4 6949763	DS/ER20-5 6953236	SCK110C-5x4 5013781	2,5
SPE6x4,9C-ESX20 5012479		6,0 x 4,9	M5, M6, M8	31	ESX20GB-6x4,9 6948390		DS/ER20-6 6943901	SCK110C-6x4,9 5012783		
SPE6,3x5C-ESX20 5073202		6,3 x 5,0			M6 M8		ESX20GB-6,3x5 6951397	DS/ER20-6,5 6953031	SCK110C-6x4,9 5012783	
SPE7x5,5C-ESX20 5012480		7,0 x 5,5	M7, M9, M10		ESX20GB-7x5,5 6949767		DS/ER20-7 6950178	SCK110C-7x5,5 5012792		
SPE7,1x5,6C-ESX20 5073203		7,1 x 5,6		M9	ESX20GB-7,1x5,6 6953228		DS/ER20-7,5 6953237	SCK110C-7x5,5 5012792		
SPE8x6,2/6,3C-ESX20 5012481		8,0 x 6,2/6,3	M8 M11	M8 M10	36		ESX20GB-8x6,2/6,3 6949202	DS/ER20-8 6946991	SCK110C-8x6,2 5012793	
SPE9x7/7,1C-ESX20 5012482		9,0 x 7,0/7,1	M9 M12	M12	37		ESX20GB-9x7/7,1 6947338	DS/ER20-9 6947339	SCK110C-9x7 5012796	
SPE10x8C-ESX20 5012483		10,0 x 8,0	M10	M10	41		ESX20GB-10x8 6949111	DS/ER20-10 6931347	SCK110C-10x8 5012809	
SPE11x9C-ESX20 5013775		11,0 x 9,0	M14		42		ESX20GB-11x9 6949177	DS/ER20-11 6944294	SCK110C-11x9 5013782	
SPE11,2x9C-ESX20 5035343		11,2 x 9,0					ESX20GB-11,2x9 6949353	DS/ER20-11,5 6953239	SCK110C-11x9 5013782	
SPE6x4,9C-ESX32 5013821	SCK2/ ESX32	6,0 x 4,9	M5, M6, M8	31	3	ESX32GB-6x4,9 6949997	DS/ER32-6 6948674	SCK210C-6x4,9 5013824	3	
SPE6,3x5C-ESX32 5073204		6,3 x 5,0				ESX32GB-6,3x5 6946964	DS/ER32-6,5 6954198	SCK210C-6x4,9 5013824		
SPE7x5,5C-ESX32 5013822		7,0 x 5,5	M7, M9, M10			ESX32GB-7x5,5 6950029	DS/ER32-7 6953637	SCK210C-7x5,5 5013825		
SPE7,1x5,6C-ESX32 5073205		7,1 x 5,6		ESX32GB-7,1x5,6 6951552		DS/ER32-7,5 6954199	SCK210C-7x5,5 5013825			
SPE8x6,2/6,3C-ESX32 5013823		8,0 x 6,2/6,3	M8 M11	M8 M10		36	ESX32GB-8x6,2/6,3 6949769	DS/ER32-8 6949999		SCK210C-8x6,2 5013826
SPE9x7/7,1C-ESX32 5012485		9,0 x 7,0/7,1	M9 M12	M12		37	ESX32GB-9x7/7,1 6946965	DS/ER32-9 6949298		SCK210C-9x7 5012864
SPE10x8C-ESX32 5012486		10,0 x 8,0	M10	M10		41	ESX32GB-10x8 6949998	DS/ER32-10 6948675		SCK210C-10x8 5012868
SPE11x9C-ESX32 5012487		11,0 x 9,0	M14			42	ESX32GB-11x9 6946104	DS/ER32-11 6948387		SCK210C-11x9 5012869
SPE11,2x9C-ESX32 5073206		11,2 x 9,0					ESX32GB-11,2x9 6951219	DS/ER32-11,5 6951274		SCK210C-11x9 5012869



N = 调节量
Adjustment
l2 = 插入深度
Insert depth
Ø = 柄部直径
Shank diameter
□ = 驱动方尾
Drive square



ESX DIN/ISO											
C版ESX夹紧装置 Clamping unit ESX Version C						组成部分: consisting of:					
型号/订货号 Designation/Id. No.	SCK.../ ESX...	 Ø x □	DIN	ISO	l2	N	 ①	 ②	 ③	 ⑤	
SPE12x9C-ESX32 5012488	SCK2/ ESX32	12,0 x 9,0	M12 M16		42	3	ESX32GB-12x9 6946106	DS/ER32-12 6946689	SCK210C-11x9 5012869	3	
SPE14x11/11,2C-ESX32 5012489		14,0 x 11,0/11,2	M18	M18	44		ESX32GB-14x11/11,2 6947337	DS/ER32-14 6946613	SCK210C-14x11 5012870		
SPE16x12/12,5C-ESX32 5012490		16,0 x 12,0/12,5	M20	M22	45		ESX32GB-16x12/12,5 6948391	DS/ER32-16 6946822	SCK210C-16x12 5012871		
SPE18x14,5C-ESX32 5013787		18,0 x 14,5	M22		47		ESX32GB-18x14,5 6950206	DS/ER32-18 6946002	SCK210C-18x14,5 5013789		
SPE10x8C-ESX40 5016652		SCK3/ ESX40	10,0 x 8,0	M10	M10		41	3	ESX40GB-10x8 9080012		DS/ER40-10 6952199
SPE11x9C-ESX40 5016653	11,0 x 9,0		M14		42	ESX40GB-11x9 6955398	DS/ER40-11 6954278		SCK310C-11x9 5016662		
SPE11,2x9C-ESX40 5073207	11,2 x 9			M14		ESX40GB-11,2x9 5069535	DS/ER40-11,5 6954279		SCK310C-11x9 5016662		
SPE12x9C-ESX40 5016654	12,0 x 9,0		M12 M16			ESX40GB-12x9 9074741	DS/ER40-12 6954280		SCK310C-11x9 5016662		
SPE14x11/11,2C-ESX40 5016655	14,0 x 11,0/11,2		M18	M18	44	ESX40GB-14x11/11,2 9074742	DS/ER40-14 6954284		SCK310C-14x11 5016663		
SPE16x12/12,5C-ESX40 5016656	16,0 x 12,0/12,5		M20	M22	45	ESX40GB-16x12/12,5 9080073	DS/ER40-16 6946054		SCK310C-16x12 5016664		
SPE18x14,5C-ESX40 5016657	18,0 x 14,5		M22		47	ESX40GB-18x14,5 6952207	DS/ER40-18 6946120		SCK310C-18x14,5 5016665		
SPE20x16C-ESX40 5016658	20,0 x 16,0		M27	M27 M30	52	ESX40GB-20x16 6948903	DS/ER40-20 6952971		SCK310C-20x16 5016666		
SPE22x18C-ESX40 5016659	22,0 x 18,0		M30		54	ESX40GB-22x18 6949124	DS/ER40-22 6949887		SCK310C-22x18 5016667		
SPE22x18C-ESX50 5085426	SCK4/ ESX50		22 x 18	M30		69	4		ESX50GB-22x18 5065799	DS/ER50-22 5085415	SCK410-1-BZ53/3 5088463
SPE25x20C-ESX50 5085427		25 x 20	M33		71	ESX50GB-25x20 5065800		DS/ER50-25 5085420			
SPE28x22C-ESX50 5085428		28 x 22	M36		73	ESX50GB-28x22 5065801		DS/ER50-28 5085421			
SPE32x24C-ESX50 5085429		32 x 24	M39 M42		75	ESX50GB-32x24 5065802		DS/ER50-32 5085422			



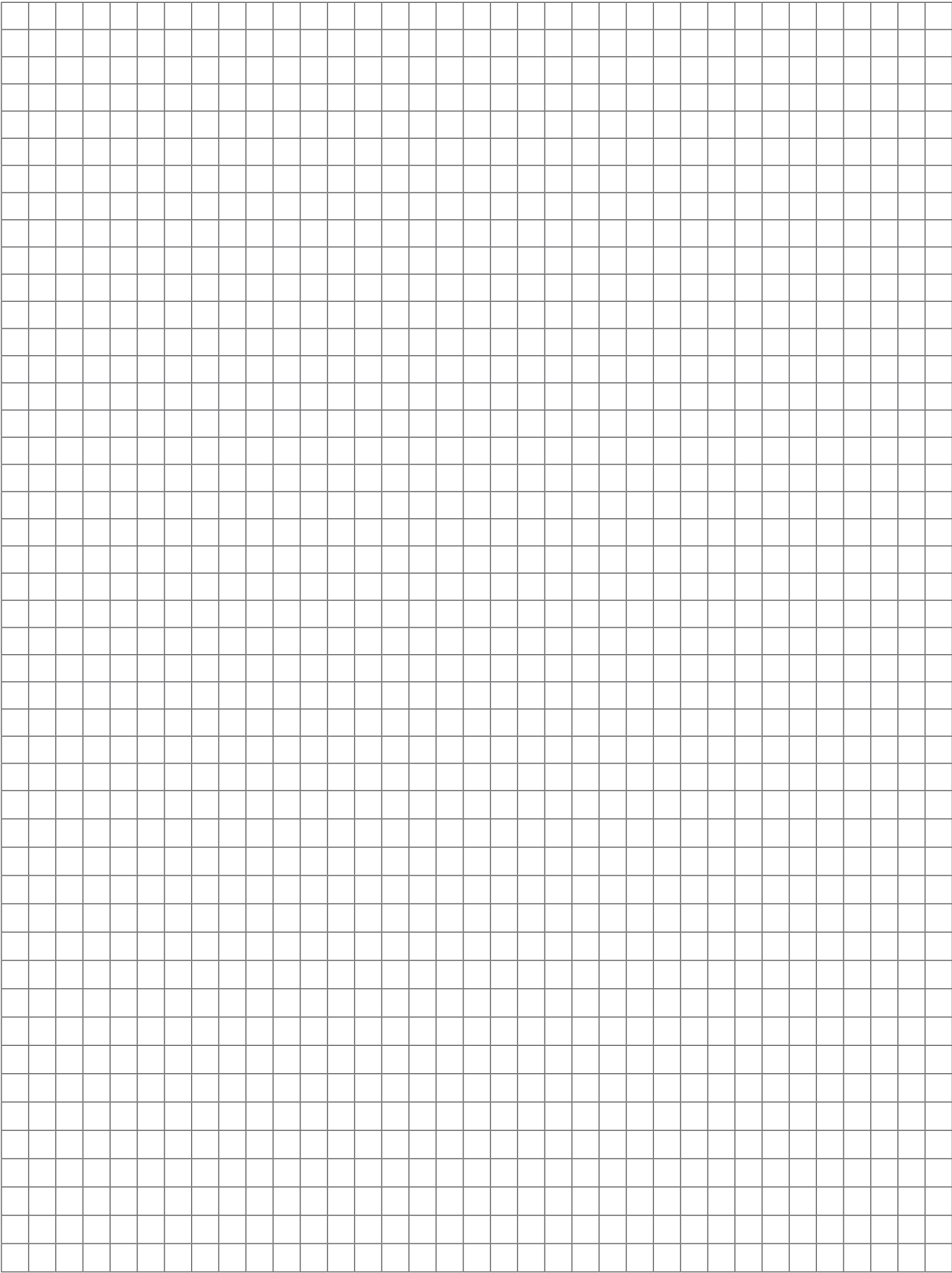
N = 调节量
Adjustment
l2 = 插入深度
Insert depth
Ø = 柄部直径
Shank diameter
□ = 驱动方尾
Drive square

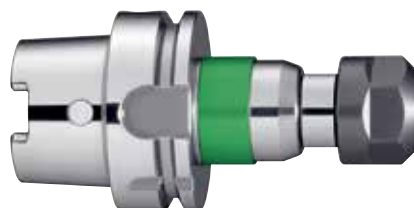
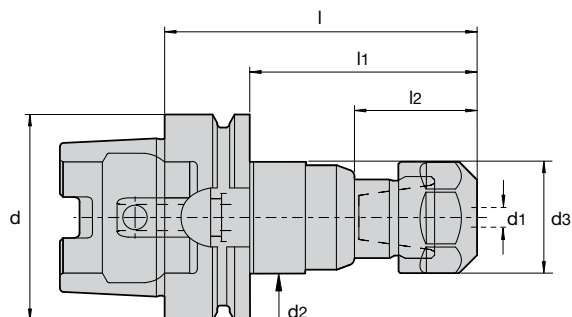


ESX JIS												
C版ESX夹紧装置 Clamping unit ESX Version C					组成部分: consisting of:							
型号/订货号 Designation/Id. No.	SCK.../ ESX...	 Ø x □	JIS	l2	N	 ①	 ②	 ③	 ⑤			
SPE5,0x4,0C-ESX20 5013774	SCK1/ ESX20	5,0 x 4,0	M4, M4,5	30	3	ESX20GB-5x4 6949763	DS/ER20-5 6949763	SCK110C-5x4 5013781	2,5			
SPE5,5x4,5C-ESX20 5068609		5,5 x 4,5	M5			ESX20GB-5,5x4,5 6949765	DS/ER20-5,5 6952104	SCK110C-5x4 5013781				
SPE6,0x4,5C-ESX20 5068620		6,0 x 4,5	M6	ESX20GB-6x4,5 6949766		DS/ER20-6 6943901	SCK110C-5x4 5013781					
SPE6,2x5,0C-ESX20 5068623		6,2 x 5,0	M7, M8	ESX20GB-6,2x5,0 5049187		DS/ER20-6,5 6953031	SCK110C-6x4,9 5012783					
SPE7,0x5,5C-ESX20 5012480		7,5 x 5,5	M9, M10	ESX20GB-7x5,5 6949767		DS/ER20-7 6950178	SCK110C-7x5,5 5012792					
SPE8,5x6,5C-ESX20 5035341		8,5 x 6,5	M12	ESX20GB-8,5x6,5 6949768		DS/ER20-8,5 6953238	SCK110C-8x6,2 5012793					
SPE10,5x8,0C-ESX20 5035342		10,5 x 8,0	M14	ESX20GB-10,5x8 6953229		DS/ER20-10,5 6952196	SCK110C-11x8 5012809					
SPE6,2x5,0C-ESX32 5068629		SCK2/ ESX32	6,2 x 5,0	M7, M8		31	3	ESX32GB-6,2x5 5069533		DS/ER32-6,5 6954198	SCK210C-6x4,9 5013824	3
SPE7,0x5,5C-ESX32 5013822			7,5 x 5,5	M9, M10				ESX32GB-7x5,5 6950029		DS/ER32-7 6953637	SCK210C-7x5,5 5013825	
SPE8,5x6,5C-ESX32 5068632			8,5 x 6,5	M12		ESX32GB-8,5x6,5 6953221		DS/ER32-8,5 6954200		SCK210C-8x6,2 5013826		
SPE10,5x8,0C-ESX32 5068635	10,5 x 8,0		M14	ESX32GB-10,5x8 6952835	DS/ER32-10,5 6952918	SCK210C-10x8 5012868						
SPE12,5x10,0C-ESX32 5035344	12,5 x 10,0		M16	ESX32GB-12,5x10 6951553	DS/ER32-12,5 6951275	SCK210C-11x9 5012869						
SPE13,0x10,0C-ESX32★ 5068628	13,0 x 10,0		M17	ESX32-13★ 6921677	DS/ER32-13 6952973	SCK210C-11x9 5012869						
SPE14,0x11,0/11,2C-ESX32 5012489	14,0 x 11,0/11,2		M18	ESX32GB-14x11/11,2 6947337	DS/ER32-14 6946613	SCK210C-14x11 5012870						
SPE15,0x12,0C-ESX32 5035345	15,0 x 12,0		M20	ESX32GB-15x12 6953222	DS/ER32-15 6954204	SCK210C-16x12 5012871						
SPE17,0x13,0C-ESX32 5068637	17,0 x 13,0		M22	ESX32GB-17x13 5066606	DS/ER32-17 6954207	SCK210C-16x12 5012871						
SPE12,5x10,0C-ESX40 5068639	SCK3/ ESX40		12,5 x 10,0	M16	42	3		ESX40GB-12,5x10 6951493	DS/ER40-12,5 6954281	SCK310C-11x9 5016662	4	
SPE13,0x10,0C-ESX40★ 5068640		13,0 x 10,0	M17	ESX40-13★ 6921694			DS/ER40-13 6954284	SCK310C-11x9 5016662				
SPE14,0x11,0C-ESX40 5016655		14,0 x 11,0	M18	ESX40GB-14x11,2 9074742	DS/ER40-14 6954114		SCK310C-14x11 5016663					
SPE15,0x12,0C-ESX40 5068641		15,0 x 12,0	M20	ESX40GB-15x12 5066068	DS/ER40-15 6954288		SCK310C-16x12 5016664					
SPE17,0x13,0C-ESX40 5068646		17,0 x 13,0	M22	ESX40GB-17x13 5066609	DS/ER40-17 6954115		SCK310C-16x12 5016664					
SPE20,0x15,0C-ESX40★ 5068648		20,0 x 15,0	M27	ESX40-20★ 6921701	DS/ER40-20 6952971		SCK310C-20x16 5016666					
SPE21,0x17,0C-ESX40★ 5068649		21,0 x 17,0	M28	ESX40-21★ 6921702	DS/ER40-21 9071745		SCK310C-20x16 5016666					
SPE23,0x17,0C-ESX40★ 5068650		23,0 x 17,0	M30	ESX40-23★ 6921704	DS/ER40-23 9071747		SCK310C-20x16 5016666					

*带星号的筒夹不带方尾, 你可以直接使用普通ER筒夹。

* These ESX...GB style collets for JIS taps are not available. Here you can use normal ER/ESX collets.



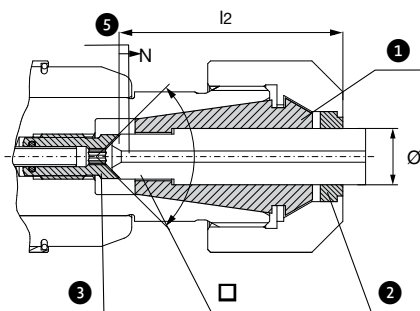


N
- +

SCK/HSK-A – ESX -1通道最小微量冷却 1 channel MQL											
型号/订货号 Designation/Id. No.	 								  		
		d	d1	d2	d3	l	l1	l2			
SCK1-95,5/HSK-A63-ESX20-GN 5010561	+/-0,15	63	M4 – M12 4,5 – 11,2	34	34	95,5	69,5	37,5	关于夹紧装置和组件，请参见第15，26 – 29页 Clamping units and components see page 15, 26 – 29	DIN 894-30	EX20-IC
SCK1-160/HSK-A63-ESX20-GN 5024594	+/-0,15	63	M4 – M12 4,5 – 11,2	34	34	160	134	37,5		6934034	6931227
SCK1-102/HSK-A100-ESX20-GN 5012121	+/-0,15	100	M4 – M12 4,5 – 11,2	34	34	102	73	37,5		DIN 894-30	EX20-IC
SCK2-109/HSK-A63-ESX32-GN 5011986	+/-0,15	63	M8 – M20 6 – 18	50	50	109	83	43,5		6934034	6931227
SCK2-160/HSK-A63-ESX32-GN 5024254	+/-0,15	63	M8 – M20 6 – 18	50	50	160	83	43,5		E 32	EX32-IC
SCK2-115,5/HSK-A100-ESX32-GN 5012066	+/-0,15	100	M8 – M20 6 – 18	50	50	115,5	86,5	43,5		6921609	6933897
SCK3-146,5/HSK-A63-ESX40-GN 5024613	+/-0,8	63	M14 – M30 11 – 22	63	58,5	146,5	120,5	50,3		E 32	EX32-IC
SCK3-138/HSK-A100-ESX40-GN 5024615	+/-0,8	100	M14 – M30 11 – 22	63	58,5	138	109	50,3		6921609	6933897
										E 40	EX40-IC
										6921610	6948425

SCK/HSK-A – ESX -2通道最小微量冷却 2 channel MQL													
型号/订货号													
Designation/Id. No.			d	d1	d2	d3	l	l1	l2				
SCK1-B-95,5/HSK-A63-ESX20-GN 5011971	+/-0,15	63	M4 – M12 4,5 – 11,2	34	34	95,5	69,5	37,5	关于夹紧装置和组件，请参见第15， 26 – 29页 Clamping units and components see page 15, 26 – 29	DIN 894-30 6934034	EX20-IC 6931227		
SCK1-B-160/HSK-A63-ESX20-GN 5024976	+/-0,15	63	M4 – M12 4,5 – 11,2	34	34	160	134	37,5		DIN 894-30 6934034	EX20-IC 6931227		
SCK1-B-102/HSK-A100-ESX20-GN 5012122	+/-0,15	100	M4 – M12 4,5 – 11,2	34	34	102	73	37,5		DIN 894-30 6934034	EX20-IC 6931227		
SCK2-B-109/HSK-A63-ESX32-GN 5011987	+/-0,15	63	M8 – M20 6 – 18	50	50	109	83	43,5		E 32 6921609	EX32-IC 6933897		
SCK2-B-160/HSK-A63-ESX32-GN 5024978	+/-0,15	63	M8 – M20 6 – 18	50	50	160	83	43,5		E 32 6921609	EX32-IC 6933897		
SCK2-B-115,5/HSK-A100-ESX32-GN 5012067	+/-0,15	100	M8 – M20 6 – 18	50	50	115,5	86,5	43,5		E 32 6921609	EX32-IC 6933897		
SCK3-B-146,5/HSK-A63-ESX40-GN 5052547	+/-0,8	63	M14 – M30 11 – 22	63	58,5	146,5	120,5	50,3		E 40 6921610	EX40-IC 6948425		
SCK3-B-138/HSK-A100-ESX40-GN 5016680	+/-0,8	100	M14 – M30 11 – 22	63	58,5	138	109	50,3		E 40 6921610	EX40-IC 6948425		

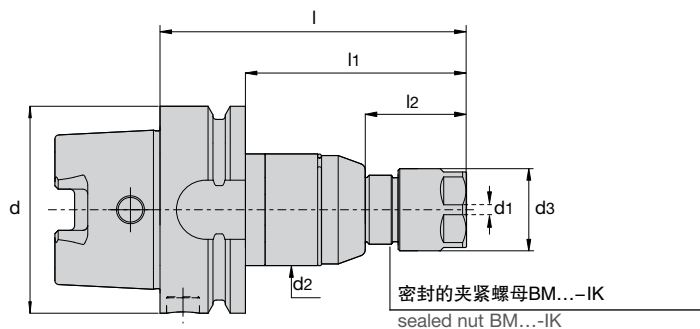
Clamping unit (page 15) and wrench (page 26 – 29) not included.



N = 调节量
Adjustment
l2 = 插入深度
Insert depth
Ø = 柄部直径
Shank diameter
□ = 驱动方尾
Drive square



ESX												
B版ESX夹紧装置 Clamping unit ESX Version B						组成部分: consisting of:						
型号/订货号 Designation/Id. No	SCK.../ ESX...	 Ø x □	DIN	ISO	l2	N	 ①	 ②	 ③	 ⑤		
SPE4,5x3,4B-ESX20 5047586	SCK1/ ESX20	4,5 x 3,4	M4, M6,		29	2	ESX20GB-4,5x3,4 6948389	DS/ER20-4,5 6948386	SCK110B-4,5x3,4 5047555	2,5		
SPE5x4B-ESX20 5047587		5,0 x 4,0		M5	30		ESX20GB-5x4 6949763	DS/ER20-5 6953236	SCK110B-5x4 5010618			
SPE6x4,9B-ESX20 5011485		6,0 x 4,9	M5, M6, M8		31	3	ESX20GB-6x4,9 6948390	DS/ER20-6 6943901	SCK110B-6x4,9 5010622			
SPE7x5,5B-ESX20 5011486		7,0 x 5,5	M7, M8, M10		31		ESX20GB-7x5,5 6949767	DS/ER20-7 6950178	SCK110B-7x5,5 5010623			
SPE8x6,2/6,3B-ESX20 5011487		8,0 x 6,2/6,3	M8, M11	M8, M10	36	3	ESX20GB-8x6,2/6,3 6949202	DS/ER20-8 6946991	SCK110B-8x6,2 5010626			
SPE9x7/7,1B-ESX20 5011488		9,0 x 7,0/7,1	M9, M12	M12	37		ESX20GB-9x7/7,1 6947338	DS/ER20-9 6947339	SCK110B-9x7 5010628			
SPE10x8B-ESX20 5011489		10,0 x 8,0	M10	M10	41		ESX20GB-10x8 6949111	DS/ER20-10 6931347	SCK110B-10x8 5010646			
SPE11x9B-ESX20 5045461		11,0 x 9,0	M14		42		ESX20GB-11x9 6949177	DS/ER20-11 6944294	SCK110B-11x9 5010649			
SPE9x7/7,1B-ESX32 5012108		SCK2/ ESX32	9,0 x 7,0/7,1	M9, M12	M12	37	3	ESX32GB-9x7/7,1 6946965	DS/ER32-9 6949298		SCK210B-9x7 5010674	3
SPE10x8B-ESX32 5012109			10,0 x 8,0	M10	M10	41		ESX32GB-10x8 6949998	DS/ER32-10 6948675		SCK210B-10x8 5010679	
SPE11x9B-ESX32 5012110	11,0 x 9,0		M14		42	ESX32GB-11x9 6946104		DS/ER32-11 6948387	SCK210B-11x9 5010680			
SPE12x9B-ESX32 5012111	12,0 x 9,0		M12, M16			ESX32GB-12x9 6946106		DS/ER32-12 6946689	SCK210B-11x9 5010680			
SPE14x11B-ESX32 5012112	14,0 x 11,0		M18	M18	44	ESX32GB-14x11 6947337		DS/ER32-14 6946613	SCK210B-14x11 5010682			
SPE16x12,5B-ESX32 5012113	16,0 x 12,0/12,5		M20	M20	45	ESX32GB-16x12,5 6948391		DS/ER32-16 6946822	SCK210B-16x12 5010683			
SPE10x8B-ESX40 5016689	SCK3/ ESX40	10,0 x 8,0	M10	M10	41	3	ESX40GB-10x8 9080012	DS/ER40-10 6952199	SCK310B-10x8 5016699	4		
SPE11x9B-ESX40 5016690		11,0 x 9,0	M14		42		ESX40GB-11x9 6955398	DS/ER40-11 6954278	SCK310B-11x9 5016701			
SPE12x9B-ESX40 5016691		12,0 x 9,0	M12, M16				ESX40GB-12x9 9074741	DS/ER40-12 6954280	SCK310B-11x9 5016701			
SPE14x11/11,2B-ESX40 5016694		14,0 x 11,0/11,2	M18	M18	44		ESX40GB-14x11/11,2 9074742	DS/ER40-14 6954284	SCK310B-14x11 5016702			
SPE16x12/12,5B-ESX40 5016695		16,0 x 12,0/12,5	M20	M20	45		ESX40GB-16x12/12,5 9080073	DS/ER40-16 6946054	SCK310B-16x12 5016703			
SPE18x14,5B-ESX40 5016696		18,0 x 14,5	M22		47		ESX40GB-18x14,5 6952207	DS/ER40-18 6946120	SCK310B-18x14,5 5016704			
SPE20x16B-ESX40 5016697		20,0 x 16,0	M27	M27, M30	52		ESX40GB-20x16 6948903	DS/ER40-20 6952971	SCK310B-20x16 5016705			
SPE22x18B-ESX40 5016698		22,0 x 18,0	M30		54		ESX40GB-22x18 6949124	DS/ER40-22 6949887	SCK310B-22x18 5016706			



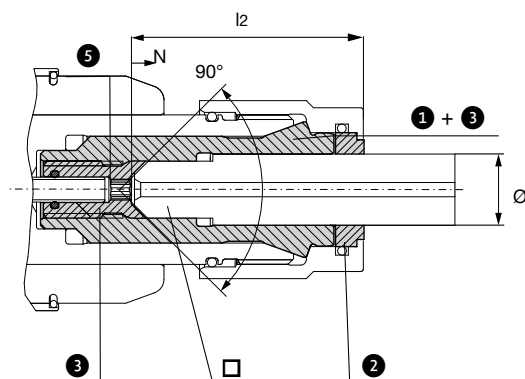
SCK/HSK-A – BZ -1通道最小微量冷却 1 channel MQL

型号/订货号 Designation/Id. No.		d	 d1	d2	d3	l	l1	l2	 关于夹紧装置和组件，请参见第17，26 – 29页 Clamping units and components see page 17, 26 – 29	 DIN3110-21x23 6952334
SCK1-86/HSK-A63-BZ18-GN 5013556	+/-0,15	63	M3,5-M14 4,0 – 10,0	34	25	86	60	28		DIN3110-21x23 6952334
SCK1-92,5/HSK-A100-BZ18-GN 5024602	+/-0,15	100	M3,5-M14 4,0 – 10,0	34	25	92,5	63,5	28		DIN3110-21x23 6952334
SCK2-104/HSK-A63-BZ25-GN 5024596	+/-0,15	63	M10-M20 10,0 – 18,0	50	34	104	78	38,5		DIN894-30 6934034
SCK2-110,5/HSK-A100-BZ25-GN 5024604	+/-0,15	100	M10-M20 10,0 – 18,0	50	34	110,5	81,5	38,5		DIN894-30 6934034

SCK/HSK-A – BZ -2通道最小微量冷却 2 channel MQL

型号/订货号 Designation/Id. No.		d	 d1	d2	d3	l	l1	l2	 关于夹紧装置和组件，请参见第17，26 – 29页 Clamping units and components see page 17, 26 – 29	 DIN3110-21x23 6952334
SCK1-B-86/HSK-A63-BZ18-GN 5022432	+/-0,15	63	M3,5-M14 4,0 – 10,0	34	25	86	60	28		DIN3110-21x23 6952334
SCK1-B-92,5/HSK-A100-BZ18-GN 5024981	+/-0,15	100	M3,5-M14 4,0 – 10,0	34	25	92,5	63,5	28		DIN3110-21x23 6952334
SCK2-B-104/HSK-A63-BZ25-GN 5024983	+/-0,15	63	M10-M20 10,0 – 18,0	50	34	104	78	38,5		DIN894-30 6934034
SCK2-B-110,5/HSK-A100-BZ25-GN 5024984	+/-0,15	100	M10-M20 10,0 – 18,0	50	34	110,5	81,5	38,5		DIN894-30 6934034

不包含夹紧装置（第17页）和调节扳手（第28+29页）。
 Clamping unit (page 17) and wrench (page 28+29) not included.

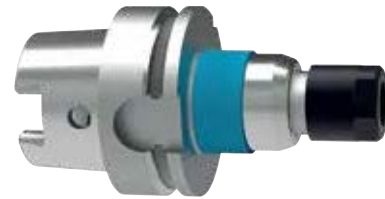
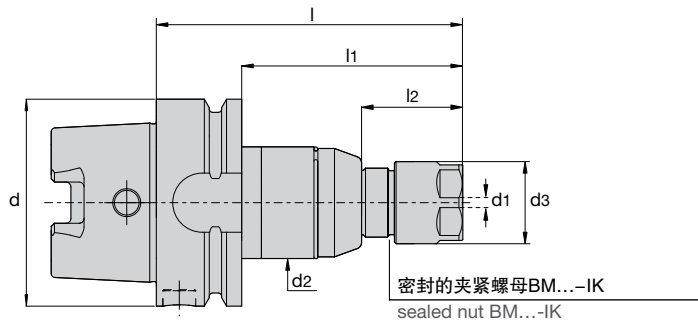


N = 调节量
Adjustment
l2 = 插入深度
Insert depth
Ø = 柄部直径
Shank diameter
□ = 驱动方尾
Drive square

BZK											
B版ESX夹紧装置 Clamping unit ESX Version B						组成部分: consisting of:					
型号/订货号 Designation/Id. No	SCK.../ BZ...	 Ø x □	 DIN	 ISO	l2	N	 ① + ③	 ②	 ③	 ⑤	
SPE6x4,9B-BZ18 5011572	SCK1/ BZ18	6 x 4,9	M5, M6, M8		29	2	BZK18B-6x4,9 5011035	DS/ER20-6 6943901	SCK110B-BZ18-6x4,9 5010725	2,5	
SPE7x5,5B-BZ18 5012025		7 x 5,5	M7, M8, M10				BZK18B-7x5,5 5012002	DS/ER20-7 6950178	SCK110B-BZ18-7x5,5 5012023		
SPE8x6,2B-BZ18 5011571		8 x 6,2	M8, M11	M8 M10	30	3	BZK18B-8x6,2 5011036	DS/ER20-8 6946991	SCK110B-BZ18-8x6,2 5010726		
SPE9x7B-BZ18 5012031		9x 7,0	M9, M12	M12	31		BZK18B-9x7 5012003	DS/ER20-9 6947339	SCK110B-BZ18-9x7 5010727		
SPE10x8B-BZ18 5012039		10 x 8,0	M10	M10	32		BZK18B-10x8 5012041	DS/ER20-10 6931347	SCK110B-BZ18-10x8 5012042		
SPE11x9B-BZ18 5071686		11 x 9,0	M14		33		BZK18B-11x9 —	DS/ER20-11 6944294	SCK110B-BZ18-11x9 —		
SPE9x7B-BZ25 5013677		SCK2/ BZ25	9 x 7,0	M9, M12	M12	40	3	BZK25B-9x7 5013672	DS/ER25-9 6941679		SCK210B-BZ25-9x7 5013675
SPE10x8B-BZ25 5013679	10 x 8,0		M10	M10	41	BZK25B-10x8 5012005		DS/ER25-10 6943423	SCK210B-BZ25-10x8 5013646		
SPE11x9B-BZ25 5013680	11 x 9,0		M14		42	BZK25B-11x9 5012006		DS/ER25-11 6943534	SCK210B-BZ25-11x9 5013648		
SPE12x9B-BZ25 5013681	12 x 9,0		M12, M16			BZK25B-12x9 5013664		DS/ER25-12 6943424	SCK210B-BZ25-11x9 5013648		
SPE14x11B-BZ25 5013683	14 x 11,0		M18	M18	44	BZK25B-14x11 5013666		DS/ER25-14 6943342	SCK210B-BZ25-14x11 5013650		
SPE16x12B-BZ25 5013684	16 x 12,0		M20	M22	45	BZK25B-16x12 5013670		DS/ER25-16 6943422	SCK210B-BZ25-16x12 5013652		
SPE18x14,5B-BZ25★ 5013725	18 x 14,5		M22			BZK25B-18x14,5 5013724		DS/ER25-18 9088550	SCK210B-BZ25-18x14,5 5013654		

★ 仅适用于轻加工; 最大90 Nm

★ for light machining only; max 90 Nm



SCK/HSK-A – BZ

型号/订货号 Designation/Id. No.	 								  	
		d	d1	d2	d3	l	l1	l2		
SCK1-86/HSK-A63-BZ18-BL 5014929	+/-0,15	63	M3,5-M14 4,0 – 10,0	34	25	86	60	28	关于夹紧装置和组件，请参见第19，26 – 29页 Clamping units and components see page 19, 26 – 29	DIN3110-21x23 6952334
SCK1-92,5/HSK-A100-BZ18-BL 5017529	+/-0,15	100	M3,5-M14 4,0 – 10,0	34	25	92,5	63,5	28		DIN3110-21x23 6952334
SCK2-104/HSK-A63-BZ25-BL 5017530	+/-0,15	63	M10-M20 10,0 – 18,0	50	34	104	78	38,5		DIN894-30 6934034
SCK2-110,5/HSK-A100-BZ25-BL 5017531	+/-0,15	100	M10-M20 10,0 – 18,0	50	34	110,5	81,5	38,5		DIN894-30 6934034

包括冷却液管。不包含夹紧装置（第19页）和调节扳手（第28+29页）。
 Coolant tube included. Clamping unit (page 19) and wrench (page 28+29) not included.

相比传统的ER型弹簧筒夹刀柄，BILZ的BZK弹簧筒夹丝锥夹紧系统支持细长设计组合，因而避免或克服了狭窄区域加工的问题。此外，弹簧筒夹用于丝锥的直接驱动机构支持丝锥无扭转应用或者消除了丝锥旋转。

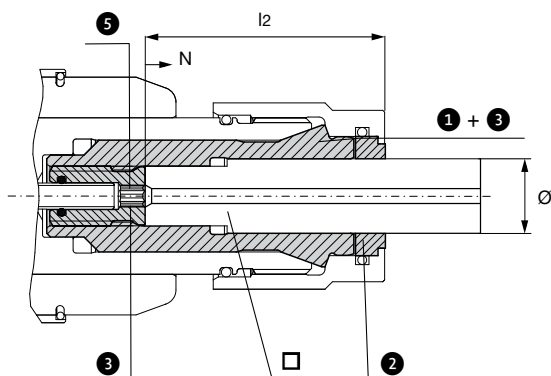
更多效益包括：

- 易于调节丝锥长度。
- 在弹簧筒夹的夹紧过程中的夹紧声音是没有关系的，止动螺丝对丝锥的压力保持恒定。

The BILZ, BZK-collet tap clamping system allows slim build combinations when compared to conventional ER collet chucks they therefore avoid or overcome problematic and difficult access applications. In addition, the direct drive mechanism of the collet to the tap allows twist free applications or eliminates tap spinning.

Further benefits are:

- Easy length setting of the tap.
- Irrespective of the clamping stroke of the collet during the tightening process the backstop screw pressure remains constant in relation to the tap.



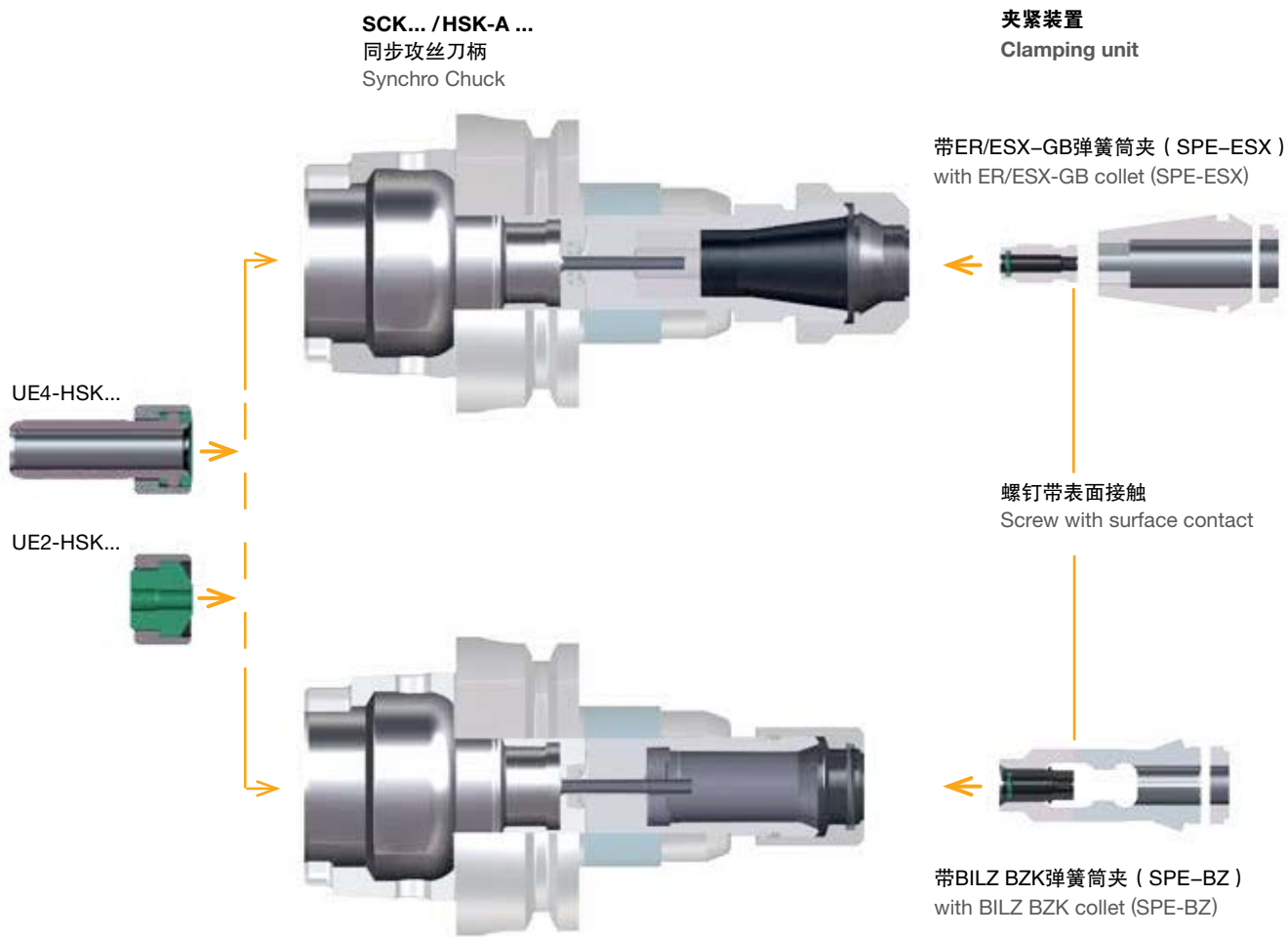
N = 调节量
Adjustment
l2 = 插入深度
Insert depth
Ø = 柄部直径
Shank diameter
□ = 驱动方尾
Drive square

BZK										
C版ESX夹紧装置 Clamping unit ESX Version C						组成部分: consisting of:				
型号/订货号 Designation/Id. No	SCK.../ BZ...	 Ø x □	DIN	ISO	L2	N	 1 + 3	 2	 3	 5
SPE4,5x3,4C-BZ18 5025987	SCK1/ BZ18	4,5 x 3,4	M4, M6		27	2	BZK18C-4,5x3,4 5025978	DS/ER20-4,5 6948386	SCK110C-BZ18-4,5x3,4 5025981	2,5
SPE5x4C-BZ18 5025986		5 x 4,0		M5	28		BZK18C-5x4 5025977	DS/ER20-5 6953236	SCK110C-BZ18-5x4 5025980	
SPE6x4,9C-BZ18 5012926		6 x 4,9	M5, M6, M8		29		BZK18C-6x4,9 5012934	DS/ER20-6 6943901	SCK110C-BZ18-6x4,9 5012939	
SPE7x5,5C-BZ18 5012927		7 x 5,5	M7, M8, M10		29		BZK18C-7x5,5 5012935	DS/ER20-7 6950178	SCK110C-BZ18-7x5,5 5012940	
SPE8x6,2C-BZ18 5012928		8 x 6,2	M8, M11	M8 M10	30	3	BZK18C-8x6,2 5012936	DS/ER20-8 6946991	SCK110C-BZ18-8x6,2 5012941	
SPE9x7C-BZ18 5012929		9 x 7,0	M9, M12	M12	31		BZK18C-9x7 5012937	DS/ER20-9 6947339	SCK110C-BZ18-9x7 5012942	
SPE10x8C-BZ18 5012930		10 x 8,0	M10	M10	32		BZK18C-10x8 5012938	DS/ER20-10 6931347	SCK110C-BZ18-10x8 5012943	
SPE11x9C-BZ18 5026031		11 x 9,0	M14		33		BZK18C-11x9 5026027	DS/ER20-11 6944294	SCK110C-BZ18-11x9 5026028	
SPE9x7C-BZ25 5029319	SCK2/ BZ25	9 x 7,0	M9, M12	M12	40		BZK25C-9x7 5029318	DS/ER25-9 6941679	SCK210C-BZ25-9x7 5029317	3
SPE10x8C-BZ25 5029322		10 x 8,0	M10	M10	41		BZK25C-10x8 5029328	DS/ER25-10 6943423	SCK210C-BZ25-10x8 5029340	
SPE11x9C-BZ25 5029323		11 x 9,0	M14		42		BZK25C-11x9 5029329	DS/ER25-11 6943534	SCK210C-BZ25-11x9 5029341	
SPE12x9C-BZ25 5029324		12 x 9,0	M12, M16		42	3	BZK25C-12x9 5029330	DS/ER25-12 6943424	SCK210C-BZ25-11x9 5029341	
SPE14x11C-BZ25 5029325		14 x 11,0	M18	M18	44		BZK25C-14x11 5029331	DS/ER25-14 6943342	SCK210C-BZ25-14x11 5029343	
SPE16x12C-BZ25 5029326		16 x 12,0	M20	M22			BZK25C-16x12 5029332	DS/ER25-16 6943422	SCK210C-BZ25-16x12 5029344	
SPE18x14,5C-BZ25* 5029327		18 x 14,5	M22		45		BZK25C-18x14,5 5029333	DS/BZ25-18 9088550	SCK210C-BZ25-18x14,5 5029345	

* 仅适用于轻加工; 最大90 Nm
* for light machining only; max 90 Nm

UE-HSK SCK冷却装置总览 — IK

UE-HSK Overview Coolant Units SCK – IK



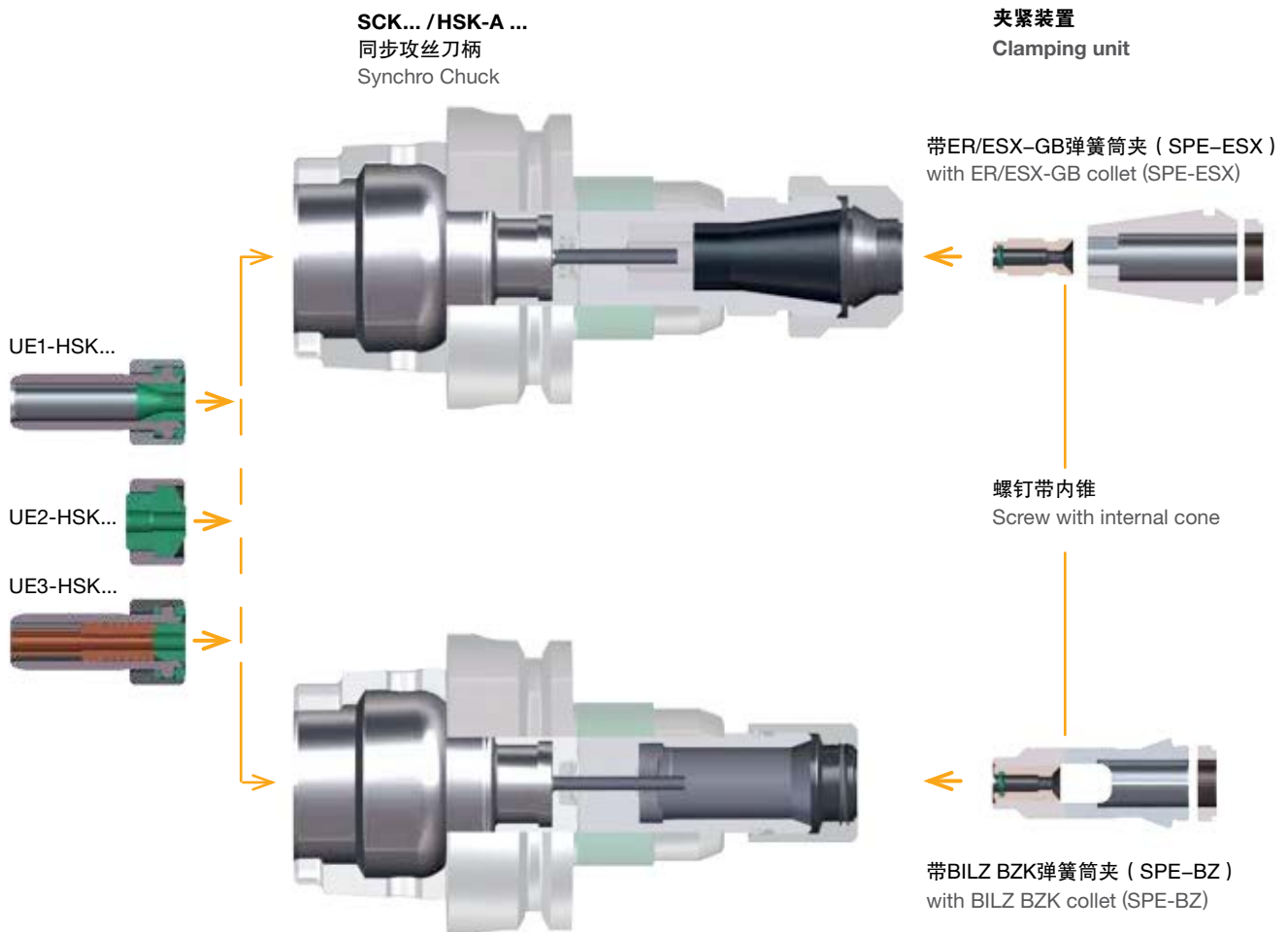
UE4 HSK A 型 FormA		UE2 HSK AC 型 FormAC	
自动换刀 IK内冷 automatic tool change IK internal coolant		手动换刀 IK内冷 manual tool change IK internal coolant	
型号 Designation	订货号 Ident No.	型号 Designation	订货号 Ident No.
UE4/HSK32	5064893	UE2/HSK32AC	5026724
UE4/HSK40	5028425	UE2/HSK40AC	5023961
UE4/HSK50	5028426	UE2/HSK50AC	5023060
UE4/HSK63	5025376	UE2/HSK63AC	5021993
UE4/HSK80	5028427	UE2/HSK80AC	5023939
UE4/HSK100	5028428	UE2/HSK100AC	5023940

说明: UE — 冷却装置包含在刀柄中

Note: UE – Coolant unit supplied with the chuck

UE-HSK SCK冷却装置总览 — MQL

UE-HSK Overview Coolant Units SCK – MQL



UE1 HSK A 型 FormA		UE2 HSK AC 型 FormAC		UE3 HSK A 型 FormA	
自动换刀 MQL 1 通道系统 automatic tool change MQL 1 channel system		手动换刀 MQL 1/2 通道系统 manual tool change MQL 1 and 2 channel system		自动换刀 MQL 2 通道系统 automatic tool change MQL 2 channel system	
型号 Designation	订货号 Ident No.	型号 Designation	订货号 Ident No.	型号 Designation	订货号 Ident No.
UE1/HSK32	5040137	UE2/HSK32AC	5026724		
UE1/HSK40	5023928	UE2/HSK40AC	5023061	UE3/HSK40	5023934
UE1/HSK50	5023933	UE2/HSK50AC	5023060	UE3/HSK50	5023935
UE1/HSK63	5004090	UE2/HSK63AC	5021993	UE3/HSK63	5004093
UE1/HSK80	5003462	UE2/HSK80AC	5023939	UE3/HSK80	5023937
UE1/HSK100	5012117	UE2/HSK100AC	5023940	UE3/HSK100	5012068

说明: UE — 冷却装置包含在刀柄中

Note: UE – Coolant unit supplied with the chuck

SCK操作说明

1. 安全

BILZ SCK同步攻丝刀柄的特色不仅仅在于出色的技术特点，还包括易于装卸和免维护的特性。

为确保正确应用，请注意以下几点：

1.1 符号说明

如果使用了此符号，如忽略BILZ的说明，可能威胁人员或财产安全。

1.2 应用领域

BILZ SCK同步攻丝刀柄适用于刀具夹紧。

只可在指定技术范围内使用此产品。这包括由制造商为安装、操作、装配、维护和工作环境设置的条件。超出这些条件的使用将被视为不当使用。制造商将不对此类使用提供任何担保。

1.3 安全建议

1.3.1 不得超出以下技术范围。（参见下表）

说明	夹紧范围 丝锥尺寸	柄部	螺母 最大扭矩	补偿 压缩/拉伸	冷却液 最大压力	最大 空转速度	最小 插入深度
SCK0...-ESX12	M2-M8	2,8-6,0mm	18Nm	± 0,15mm	50bar	15.000min ⁻¹	23,5-25,5mm
SCK1...-ESX20	M4-M12	4,5-11,2mm	< Ø 6,5, 32Nm > Ø 7, 37Nm	± 0,15mm	50bar	15.000min ⁻¹	29-42mm
SCK2...-ESX32	M4-M20	4,5-18,0mm	136Nm	± 0,15mm	50bar	15.000min ⁻¹	31-47mm
SCK3...-ESX40	M10-M30	10,0-22,0mm	176Nm	± 0,80mm	50bar	15.000min ⁻¹	41-54mm
SCK4...-ESX50	M30-M42	22,0-32,0mm	300Nm	± 2,0mm	50bar	15.000min ⁻¹	63-69mm

1.3.2 对于旋转应用，必须使用符合EC机械指令22006/42/EG的防护盖。

1.3.3 只可由受过技术培训且已熟悉操作说明的员工在机床上执行刀具夹紧和同步丝锥刀柄的安装。

基本规则：

- 在更换刀具时应佩戴手套，以免受伤。
- 在释放刀具时，握紧刀具以免其坠落并损坏刀具和工件。
- 请勿超过最大刀具尺寸。
- 每次应用的最大切削速度和供给值。请勿超过这些值。

2. 保修：

在使用正确并遵守操作和维护说明的情况下，保修期为自交付之日起12个月（参见第2页第6点）。

3. 安装

3.1 使用抹布清洁刀柄以去除油脂。

重要信息：请勿使用强效溶剂。只可使用无绒布。

3.2 攻丝刀具用ER/ESX..GB., DIN6499-B型弹簧筒夹固定。

3.3 弹簧筒夹和丝锥的装配

为防止污染弹簧筒夹，并且如果使用了冷却液或最小微量冷却，必须首先将密封垫圈安装到夹紧螺母内。

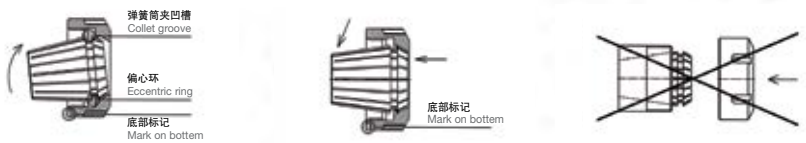
4. 夹紧/释放

4.1 刀柄必须无毛刺或污垢。

4.2 弹簧筒夹的装配：

安装弹簧筒夹，使其凹槽对准夹紧螺母偏心环上的标记位置。沿反方向倾斜弹簧筒夹，直至听到“咔哒”一声，表示其锁定到位，插入刀具。在弹簧筒夹锁定后，将夹紧螺母拧到刀柄的螺纹上。建议使用扭矩扳手拧紧弹簧筒夹，并用扳手的平面进行固定（参见第1.3点中的表格了解拧紧扭矩）。

错误装卸将影响弹簧筒夹的同心度，并可能损坏夹紧螺母。只可将正确安装了弹簧筒夹的夹紧螺母插入弹簧筒夹刀柄内。



4.3 密封垫圈的装配:
在将密封垫圈插入夹紧螺母时，必须能够从后方看到密封垫圈上的标记。
将密封垫圈插入弹簧筒夹并向前推，直至发出“咔哒”声，表示正确就位。正确装配的密封垫圈与螺母齐平。

4.4 密封垫圈的拆卸:
如需拆卸密封垫圈，从外侧按压垫圈直至其脱离。



必须从正面插入刀具，否则将损坏密封环上的O型环
在插入刀具时，确保没有将密封垫圈推回。

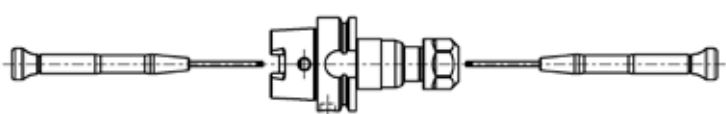


4.5 在将刀具插入刀柄时，必须插到最小插入深度（参见第1页的表格）。

4.6 弹簧筒夹的拆卸:
在拧下螺帽后，按压弹簧筒夹的正面，同时通过从标记的对面按压后部，将弹簧筒夹按压出夹紧螺母。

5 长度调节

5.1 可以通过机床主轴那面，或使用艾伦扳手通过弹簧筒夹进行长度调节。



5.2 调节螺钉上的最大扭矩不得超过4Nm。

5.3 请确保对丝锥柄部使用合适的调节螺钉（参见第5.3点中的表格），最大长度调节为3mm。

同步攻丝 刀柄的说明	调节螺钉 IK	攻丝 Ø x □													
		4,5x3,4	5x4	6x4,9	7x5,5	8x6,2	9x7	10x8	11x9	12x9	14x11	16x12	18x14,5	20x16	22x18
SCK1...- ESX20	SCK110C-...	5013780	5013781	5012783	5012792	5012793	5012796	5012809	5013782						
SCK2...- ESX32	SCK210C-...			5013824	5013825	5013826	5012864	5012868	5012869	5012869	5012870	5012871	5013789		
SCK3...- ESX40	SCK310C-...							5016661	5016662	5016662	5016663	5016664	5016665	5016666	5016667

5.4 在长度调节螺钉的后方，有一个用于阻尼的弹性体。在拧紧夹紧螺母时，它可以防止损坏丝锥或长度调节螺钉。



注意!
在达到最大拧紧深度后，必须将调节螺钉松开一圈。
(确保弹簧系统的功能)
只可使用BILZ提供的套筒扳手。
请勿在刀具已夹紧时移动调节螺钉。

6. 保养和维护

6.1 定期用抹布清洁。请勿使用强效溶剂，并且只可使用无绒布。
6.2 在储存之前，确保已清除了所有冷却液和其他残留物，并用防腐剂喷涂刀具。

Operating Instructions SCK

1. Safety

The BILZ SCK synchro chuck is not only characterised by its outstanding technical features, but also by its easy handling and maintenance free properties

Please note to the following points in order to ensure correct application.

1.1 Explanation of Symbols

If this symbol is used, disregard of our instructions can lead to danger to people and property.

1.2 Area of Application

BILZ SCK synchro chucks are suitable for tool clamping.

The product may only be used within the given technical limits. This includes the conditions set down by the manufacturer for installation, operation, assembly, maintenance and working environment. Usage above and beyond these conditions is considered as not correct for purpose. The manufacturer will not give any guarantee on such usage.

1.3 Safety Advice

1.3.1 The following technical limits must not be exceeded. (see table below)

Description	Clamping Range Tap Size	Shank	Nut Torque max.	Compensation Compression/Tension	Coolant Pressure max.	Idle Running Speed max.	Minimum Insert Depth
SCK0..-ESX12	M2-M8	2,8-6,0mm	< Ø 3; 8Nm > Ø 3; 16Nm	± 0,15mm	50bar	15.000min-1	23,5-25,5mm
SCK1..-ESX20	M4-M12	4,5-11,2mm	< Ø 6,5; 32Nm > Ø 7,0; 35Nm	± 0,15mm	50bar	15.000min-1	29-42mm
SCK2..-ESX32	M8-M20	6,0-18,0mm	136Nm	± 0,15mm	50bar	15.000min-1	31-47mm
SCK3..-ESX40	M14-M30	11,0-22,0mm	176Nm	± 0,80mm	50bar	15.000min-1	41-54mm
SCK4..-ESX50	M30-M42	22,0-32,0mm	300Nm	± 2,0mm	50bar	15.000min-1	63-69mm

1.3.2. For rotation applications, a protective cover according to EC Machinery Directive 2006/42/EG must be used.

1.3.3 Tool clamping and installation of the synchro chuck in a machine may only be carried out by technically trained staff who have familiarised themselves with the operating instructions.

Basic rules:

- Wear gloves when changing tools to avoid injury.
- When releasing the tool, hold it tightly to prevent it falling and damaging both the tool and workpiece.
- Do not exceed the max. tool dimensions.
- Maximum cutting speed and feed values exist for every application. Do not exceed these values.

2. Warranty:

The warranty period is 12 months from delivery date, if used correctly and in adherence to the operating and maintenance instructions (See Page 2, Point 6)

3. Installation

3.1 Clean chuck with a cloth in order to remove oil.

Important: Do not use aggressive solvents. Only use lint-free cloths.

3.2 The tapping tool is held by means of a collet type ER/ESX..GB. , DIN6499-B

3.3 Assembly of the collets and tap

To prevent soiling of the collet, and if you are using coolant or MQL, the sealing disc must first be fitted into the clamp nut.

4. Clamping / Releasing

4.1. The tool shank must be free of burrs and dirt.

4.2. Assembly of the collets:

Mount the collet groove on the marked position on the eccentric ring of the clamp nut. Tilt the collet in the opposite direction until this locks audibly. Insert the tool. Screw the clamp nut with the locked collet onto the thread of the holder. We recommend tightening the collet with a torque wrench and use the spanner flat to hold against this (tightening torques see table under Point 1.3).

Incorrect handling will affect the concentricity of the collet and can damage the clamping nut.
Only clamping nuts with a correctly mounted collet should be inserted into the collet holder.

Operating Instructions SCK



4.3. Assembly of the sealing disc:

When inserting the sealing disc into the clamping nut, the marking on the sealing disc must be legible from behind. Insert the sealing disc into the coilet and push it forward until it clicks. The correct assembled sealing disc is plane with the nut.

4.4 Removal of the sealing disc:

To remove the sealing disc, press on the disc from the outside until it jumps out.



It is essential to insert the tool from the front, otherwise the O-ring in the sealing ring will be damaged. When inserting the tool, make sure that the sealing disc is not pushed back.



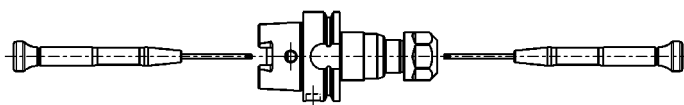
4.5 The tool must be inserted into the chuck at least to the minimum insert depth (see table Page 1).

4.6 Removal of the collets:

After unscrewing the holder, press the front of the coilet and at the same time press the coilet out of the clamping nut by pressing the back part, opposite the marking.

5. Length Adjustment

5.1. The length adjustment is operated through the connection on the machine side, or through the coilet by means of an Allen key.



5.2. The max. torque on the adjustment screw must not exceed 4Nm.

5.3. Please ensure that the suitable adjusting screw for the tap shank is used (see table under Point 5.3)
Max. length adjustment 3mm.

Description Synchro Chuck	Adjusting Screw IC	Tap Ø x □													
		4,5x3,4	5x4	6x4,9	7x5,5	8x6,2	9x7	10x8	11x9	12x9	14x11	16x12	18x14,5	20x16	22x18
SCK1..-ESX20	SCK110C-...	5013780	5013781	5012783	5012792	5012793	5012796	5012809	5013782						
SCK2..-ESX32	SCK210C-...			5013824	5013825	5013826	5012864	5012868	5012869	5012869	5012870	5012871	5013789		
SCK3..-ESX40	SCK310C-...							5016661	5016662	5016662	5016663	5016664	5016665	5016666	5016667

5.4. Behind the length adjustment screw there is elastomer for damping. So we prevent damage of the tap or length adjustment screw while tightening the clamping nut.

5.5. SCK4-ESX50; SCK410G-M16x1, 5065065, one screw for all tap shanks 22-32 mm



ATTENTION!

The setting screw must be released by one turn after reaching the max. screwing depth.

(to ensure the function of the spring system)

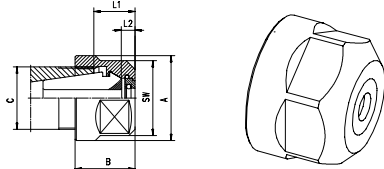
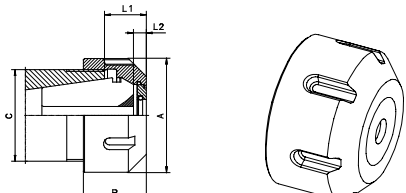
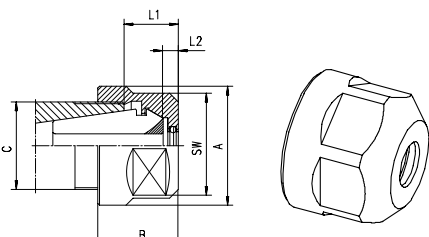
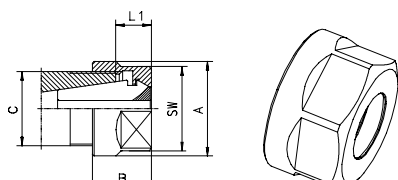
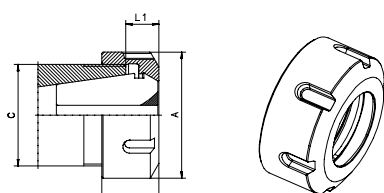
Only use the socket wrenches provided.

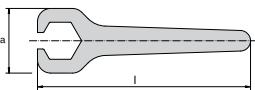
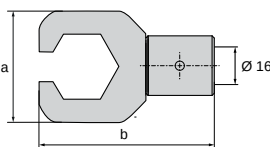
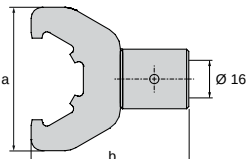
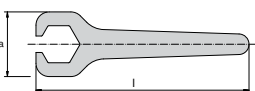
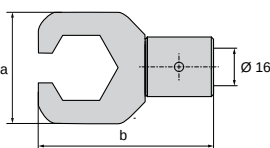
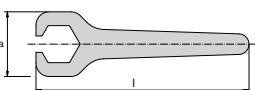
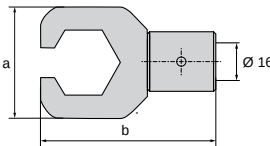
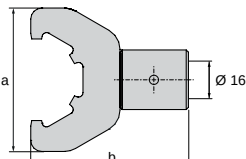
Do not move the adjusting screw when the tool is clamped.

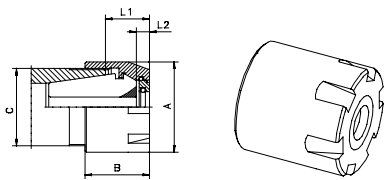
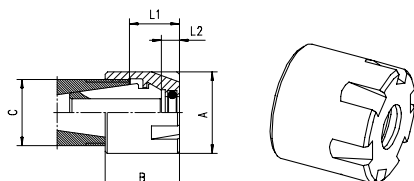
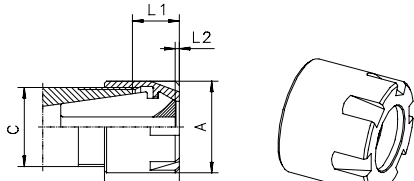
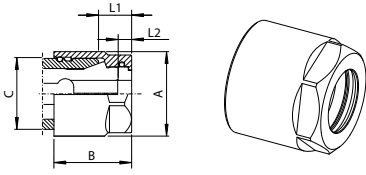
6. Care and Maintenance

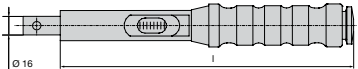
6.1. Clean regularly with a cloth. Do not use aggressive solvents and only use lint-free cloths.

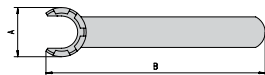
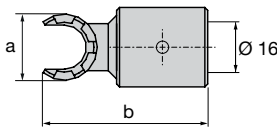
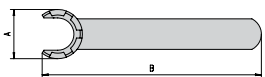
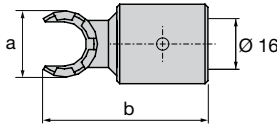
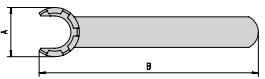
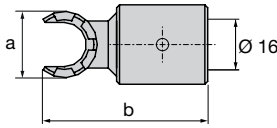
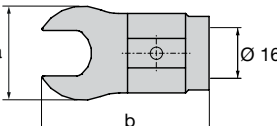
6.2. Before storage ensure that all coolant and other residue is removed and the tools are sprayed with an anticorrosion agent.

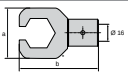
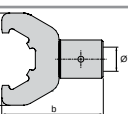
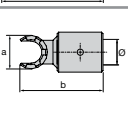
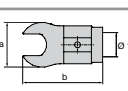
型号/订货号 Designation/Id. No.		A	B	C	L1	L2	SW	
夹紧螺母和密封垫圈/扳手 Clamping Nut with sealing disc/wrench								
EX16-IC 6931372		28	22,5	M22x1,5	12,0-15,5	5	25	
EX20-IC 6931227		34	24	M25x1,5	13,0-16,5	5	30	
EX25-IC 6941678		42	25	M32x1,5	13,5-17,0	5		
EX32-IC 6933897		50	27,5	M40x1,5	14,5-18,0	5		
EX40-IC 6948425		63	30,5	M50x1,5	16,5-20,0	5		
EX50-IC 5085410		78	40,3	M64x2	19,0-26,0	7		
整体夹紧螺母密封圈/扳手 Clamping Nut with integrated seal/wrench								
EX12-3-IC 5058947 EX12-3,5-IC 5055118 EX12-4-IC 5020211 EX12-4,5-IC 5020219 EX12-5-IC 5020220 EX12-5,5-IC 5058948 EX12-6-IC 6952625 EX12-6,5-IC 5058949 EX12-7-IC 5058950		19	14,6	M14x0,75	8,10-9,80	3,5	17	
夹紧螺母不用密封圈/扳手 Clamping Nut without sealing disc/wrench								
EX12 6919083 EX16 6919040		19	11,3	M14x0,75	4,9-6,6		17	
		28	17,5	M22x1,5	7,0-10,5		25	
EX20 6918743		34	19	M25x1,5	8,0-11,5		30	
EX25 6919084		42	20	M32x1,5	8,5-12,0			
EX32 6918697		50	22,5	M40x1,5	9,5-13,0			
EX40 6919085		63	25,5	M50x1,5	11,5-15,0			
EX50 6951202		78	35,3	M64x2,0	14,0-21,0			

订货号/Id-No.			ESX	Ø mm	ESX-GB	型号/订货号 Des./Id.No.	TORCO-FIX 安装扳手 Fitting key
E16P-25 5105244			8 Nm	1		A-E16P	
			20 Nm	1,5–3,5		6953670	
			40 Nm	4,0–4,5	40 Nm		
			56 Nm	5,0–10,0	44 Nm		
			16 Nm	1		A-E20P	
			32 Nm	1,5–6,5	32 Nm	5003125	
E20P-30 5105245			80 Nm	7,0–13,0	35 Nm		
E25 6921608			24 Nm	1,0–3,5		A-E25	
			56 Nm	4,0–4,5	56 Nm	6953671	
			80 Nm	5,0–7,5	80 Nm		
			104 Nm	8,0–17,0	104 Nm		
E32 6921609			24 Nm	2,0–2,5		A-E32	
E40 6921610			136 Nm	3,0–22,0	136 Nm	6952304	
E50 6951711			176 Nm	3,0–26,0	176 Nm	A-E40 5000742	
			300 Nm	22,0–32,0	300 Nm	A-E50 5003124	
E11P-17 5105243			24 Nm	3,0–7,0	24 Nm	A-E11P 5047900	
E11P-17 5105243			24 Nm	3,0–7,0	24 Nm	A-E11P 5047900	
E16P-25 5105244			8 Nm	1		A-E16P	
			20 Nm	1,5–3,5		6953670	
			40 Nm	4,0–4,5	40 Nm		
			56 Nm	5,0–10,0	44 Nm		
E20P-30 5105245			16 Nm	1		A-E20P	
			32 Nm	1,5–6,5	32 Nm	5003125	
			80 Nm	7,0–13,0	35 Nm		
E25 6921608			24 Nm	1,0–3,5		A-E25	
			56 Nm	4,0–4,5	56 Nm	6953671	
			80 Nm	5,0–7,5	80 Nm		
			104 Nm	8,0–17,0	104 Nm		
E32 6921609			24 Nm	2,0–2,5		A-E32	
E40 6921610			136 Nm	3,0–22,0	136 Nm	6952304	
E50 6951711			176 Nm	3,0–26,0	176 Nm	A-E40 5000742	
			300 Nm	22,0–32,0	300 Nm	A-E50 5003124	

型号/订货号 Designation/Id. No.		A	B	C	L1	L2	SW	
迷你夹紧螺母密封圈/扳手 Mini Clamping Nut with sealing disc/wrench								
EX16-MC 6944416		22	22	M19x1,0	11,5–15,0	4,5		
EX20-MC 6951224		28	24	M24x1,0	13,0–16,5	5		
EX25-MC 6955533		35	25	M30x1,0	13,5–17,0	5		
迷你整体夹紧螺母密封圈/扳手 Mini Clamping Nut with integrated seal/wrench								
EX12-...-MC auf Anfrage, Ø angeben on request, state Ø		16	14,6	M13x0,75	8,1–9,8	3,5		
迷你夹紧螺母不用密封圈/扳手 Mini Clamping Nut without sealing disc/wrench								
EX12-M 6941535		16	12	M13x0,75	5,7–7,5	0,4		
EX16-M 6932504		22	18,4	M19x1	8,0–11,5	0,9		
EX20-M 6940464		28	19	M24x1	8,0–11,5			
EX25-M 6951256		35	20	M30x1	8,5–12,0			
BILZ夹紧螺母密封圈/扳手 BILZ Clamping Nut with sealing disc/wrench								
BM12-D-BG 5022101		17	18	M14x1			15	
BM18-D-BG 5003288		25	18	M21x1			23	
BM25-D-BG 5003981		34	24	M30x1			30	

扭矩扳手TORCO-FIX Torque wrench TORCO-FIX				
	型号 Designation	订货号 Id.No.	I 1	扭矩 Torque Nm
	TORCO-FIX I	6734177	335	5 – 50
	TORCO-FIX II	6734178	465	20 – 200
	TORCO-FIX III	6734179	565	60 – 300

订货号/Id-No.			ESX	Ø mm	ESX-GB	型号/订货号 Des./Id.No.	TORCO-FIX 安装扳手 Fitting key
E16M 6932510		8 Nm	1		A-E 16M		
		20 Nm	1,5–3,5		5047902		
		40 Nm	4,0–10,0	24 Nm			
E20M 6934089		16 Nm	1		A-E 20M		
E25M		28 Nm	1,5–13,0	28 Nm	5047903		
6933989		24 Nm	1,0–3,5		A-E 25M		
		32 Nm	4,0–17,0	32 Nm	5076778		
E11M 6942650		8 Nm	1,0–2,9		A-E 11M		
		16 Nm	3,0–7,0	13 Nm	5047901		
E11M 6942650		8 Nm	1,0–2,9	8 Nm	A-E 11M		
6942650		16 Nm	3,0–7,0	13 Nm	5047901		
E16M 6932510		8 Nm	1		A-E 16M		
		20 Nm	1,5–3,5		5047902		
E20-M 6934089		24 Nm	4,0–10,0	24 Nm			
		16 Nm	1		A-E 20M		
		28 Nm	1,5–13	28 Nm	5047903		
E25-M 6933989		24 Nm	1,0–3,5		A-E 25M		
	32 Nm	4,0–217,0	32 Nm	5076778			
			BZK				
			18 Nm			16Z-SW15 5056892	
DIN3110-21x23 6952334			30 Nm			16Z-SW23 5056896	
DIN894-30 6934034			40 Nm			16Z-SW30 5056897	

安装扳手TORCO-FIX Fitting keys TORCO-FIX					
	型号 Des.	订货号 No	TORCO-FIX	a	b
	A-E11P	5047900	I	32	61
	A-E16P	6953670	I, II	44	71
	A-E20P	5003125	II	52	81
	A-E25	6953671	II	70	72
	A-E32	6952304	II, III	80	72
	A-E40	5000742	II, III	96	82
	A-E50	5003124	III	111	94
	A-E11M	5047901	I	16,8	54,4
	A-E16M	5047902	I, II	22,5	56,2
	A-E20M	5047903	I, II	29	68,2
	A-E25M	5076778	I, II	36	70,0
	16Z-SW15	5056892	I	34,5	32
	16Z-SW23	5056896	I, II	56	32
	16Z-SW30	5056897	I, II	68	32

A technical line drawing of the assembly device, which is an L-shaped metal bracket. Dimension 'h' is the vertical height of the flange, 'l' is the horizontal length of the flange, and 'b' is the width of the vertical plate. The vertical plate has four mounting holes, and the horizontal flange has three mounting holes.

A photograph showing a person's hand using a hex key to tighten a nut on the assembly device. The device is mounted on a wall, and a copper pipe is being connected to it.

安装配置

Assembly device

型号/订货号

Designation/Id. No.

V-V274

5069450

SCK0-3

h

mm

105

l

mm

105

b

mm

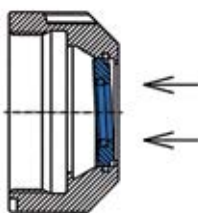
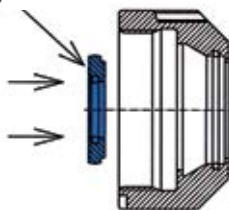
170

DS/ER 密封垫圈

DS/ER Sealing disc



标记
Marking



装配

将垫圈的直径较小一端插入冷却液螺母的中心并均匀施加压力，直至垫圈正确的卡入螺母。

Assembling

The disc must be flush with the outside of the nut and the marking on the disc must be seen inside the nut.

垫圈必须与螺母的外侧齐平，且必须能够从螺母内侧看到垫圈上的标记。

Insert the small diameter of the disc into the center of the coolant nut and apply even pressure until the disc is properly seated into the nut.

拆卸

如需拆卸垫圈，只需均匀地按压垫圈的外侧，直至其脱离。

Removing

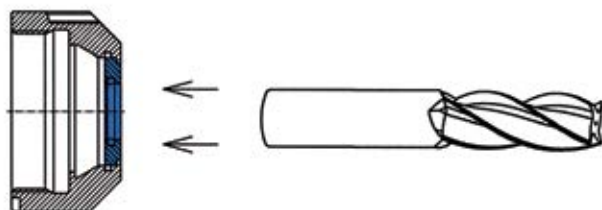
To remove the disc, simply press on the outside of the disk evenly until it snaps out.



从正面插入刀具。如从后面插入切削刀具，必将损坏O型圈。



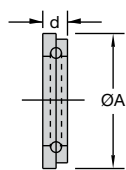
Insert tool from the front. O-ring will be damaged if cutting tool is inserted from the back.



在插入刀具时应注意，不要将密封垫圈推回。



Take care when inserting the tool that you do not push back the sealing disc.

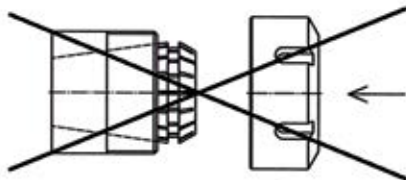
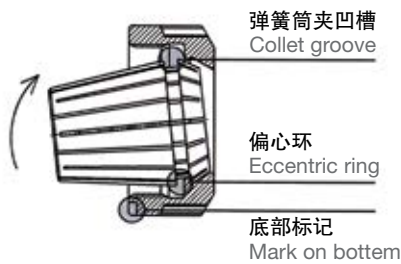


DS/ER							
密封范围 Sealing Range mm	 ESX12*	订货号 / Id. No.					
		DS/ER 16 (d x A) 4x13 mm	DS/ER 20 (d x A) 4x16 mm	DS/ER 25 (d x A) 4x21 mm	DS/ER 32 (d x A) 4x27 mm	DS/ER 40 (d x A) 4x33,5 mm	DS/ER 50 (d x A) 5,5x42,5 mm
3,00 – 2,50		6953629	6954178	6954181	6954194	6954264	
3,50 – 3,00		6954176	6948385	6947674	6954195	6954265	
4,00 – 3,50	5020211	6952696	6953235	6954182	6954112	6954266	
4,50 – 4,00	5020219	6944324	6948386	6954183	6954196	6954267	
5,00 – 4,50	5020220	6952972	6953236	6954184	6954113	6954268	
5,50 – 5,00		6954177	6952104	6954185	6954197	6954269	
6,00 – 5,50	6952625	6931371	6943901	6953215	6948674	6954270	
6,50 – 6,00		6943060	6953031	6954186	6954198	6954271	
7,00 – 6,50		6940533	6950178	6943420	6953637	6954272	
7,50 – 7,00		6952195	6953237	6943421	6954199	6954273	
8,00 – 7,50		6941539	6946991	6943419	6949999	6952197	
8,50 – 8,00		6946898	6953238	6952198	6954200	6954274	
9,00 – 8,50		6941992	6947339	6941679	6949298	6954275	
9,50 – 9,00		6946897	6954179	6946744	6954201	6954276	
10,00 – 9,50		6942300	6931347	6943423	6948675	6952199	
10,50 – 10,00			6952196	6954187	6952918	6954277	
11,00 – 10,50			6944294	6943534	6948387	6954278	
11,50 – 11,00			6953239	6954188	6951274	6954279	
12,00 – 11,50			6943902	6943424	6946689	6954280	
12,50 – 12,00			6954180	6954189	6951275	6954281	
13,00 – 12,50			6947968	6948123	6952973	6954282	
13,50 – 13,00				6954190	6954202	6954283	
14,00 – 13,50				6943342	6946613	6954284	
14,50 – 14,00				6954191	6954203	6954285	
15,00 – 14,50				6954192	6954204	6954114	
15,50 – 15,00				6954193	6954205	6954286	
16,00 – 15,50				6943422	6946822	6946054	
16,50 – 16,00					6954206	6954287	
17,00 – 16,50					6954207	6954288	
17,50 – 17,00					6954208	6954289	
18,00 – 17,50					6946002	6946120	
18,50 – 18,00					6954209	6952210	
19,00 – 18,50					6954210	6954115	
19,50 – 19,00					6954211	6954290	
20,00 – 19,50					6933868	6952971	
20,50 – 20,00						6954291	
21,00 – 20,50						9071745	
21,50 – 21,00						6954292	
22,00 – 21,50						6949887	5085415
22,50 – 22,00						6952212	
23,00 – 22,50						9071747	
23,50 – 23,00						6954293	
24,00 – 23,50						9071748	
24,50 – 24,00						6954294	
25,00 – 24,50						6948426	5085420
25,50 – 25,00						6954295	
26,00 – 25,50						9072720	
28,00 – 27,50							5085421
32,00 – 31,50							5085422
36,00 – 35,50							5085423

说明: *ESX12无密封垫圈/只有密封螺母
Note: *ESX12 no sealing disc/sealing nut only

Hi-Q® 夹紧螺母

Hi-Q® Clamping Nut



装配弹簧筒夹:

在螺帽底部标记的地方把弹簧筒夹的槽插入到夹紧螺帽的偏心环里，沿着箭头方向推动筒夹直至卡进去。插入刀具。将带弹簧筒夹的螺母拧到刀柄上。

Assembling Collet:

Insert groove of the collet into eccentric ring of the clamping nut at the mark on the bottom of the nut. Push collet in the direction of the arrow until it clicks in.

Insert tool. Screw nut with collet onto tool holder.

取下弹簧筒夹:

在从刀柄上拧下螺母后，按住弹簧筒夹的表面，同时从标记的对面向侧面推弹簧筒夹的背面，直至其脱离夹紧装置。

Removing Collet:

After the nut is unscrewed from the toolholder, press on the face of the collet while simultaneously pushing sideways on the back of the collet opposite the mark until it disengages from the clamping nut.

不正确的装配可能永久性损坏弹簧筒夹的同心度，并可能导致夹紧装置的损坏。

■ 只可安装已正确插入了弹簧筒夹的螺母！

切勿在没有将弹簧筒夹装配到螺母中的情况下直接将其放置到刀柄内。

Improper assembly can permanently damage the concentricity of the collet and may result in the destruction of the clamping nut.

Only mount nuts with correctly inserted collets.

Never place the collet into the holder without first assembling into the nut.

为避免损坏同步攻丝刀柄，在拧紧螺母时，请使用扳手 **2** (SW) 固定刀柄。Siehe auch Montagevorrichtung Seite 29.

不包含调节扳手。

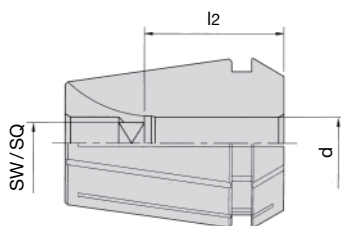
To avoid any damage of the synchro chuck

use key **2** (SW) to hold the chuck while tightening the nut.

See also assembly device page 29.

Setting key not included.

SCK	ESX	2 (SW)	DIN	订货号 / Id. No.
1	20	23 mm	DIN 3110-21 x 23	6952334
2	32	38 mm	DIN 894-38	5058889
3	40	46 mm	DIN 894-46	5058890



用于丝锥的带驱动方头的ESX...GB弹簧筒夹
ESX ... GB collet with drive square for taps

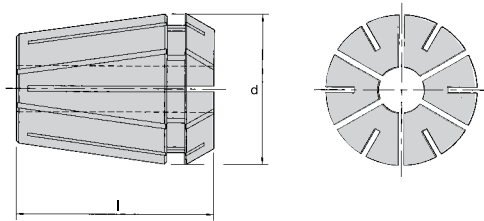
d x SW	l2	DIN 371	DIN 374	DIN 376	JIS B 4430 1988	ISO		订货号 / Id.No.						
							①	ESX 12 GB	ESX 16 GB	ESX 20 GB	ESX 25 GB	ESX 32 GB	ESX 40 GB	ESX 50 GB
2,8 x 2,1	12	M2-2,5	M4	M4				5073435						
3,5 x 2,7	14	M3	M5	M4,5 M5				5055115						
4,0 x 3,0	14	M3,5	M5,5					5073436						
4,0 x 3,15	*14/15				M3			5020195	6954588	6949762		6950665		
4,0 x 3,2					M3,5									
4,5 x 3,4	*14/15	M4	M6	M6				5020217	6951393	6948389	6951218	6952585		
5,0 x 4,0	*14/18				M4 M4,5		M5	5020218	6954872	6949763	5073850	5069529		
5,5 x 4,3	18		M7	M7					6954656	6949764	5073851	5069531		
5,5 x 4,5	18				M5				6952288	6949765	5073852	5069532		
6,0 x 4,5	18				M6				6952289	6949766	5073853	6953220		
6,0 x 4,9	*14/18	M4,5 M6	M8	M8				6950826	6951392	6948390	6951544	6949997		
6,2 x 5,0	18				M7 M8				5073846	5049187	5073854	5069533		
6,3 x 5,0	18					M8	M6		6946901	6951397	6951217	6946964		
7,0 x 5,5	18	M7	M9 M10	M9 M10	M9 M10				6947340	6949767	6951797	6950029		
7,1 x 5,6	18								5073847	6953228	5073855	6951552		
8,0 x 6,2	22	M8	M11			M10	M8		6946213	6949202	6951214	6949769	6955396	
8,0 x 6,3														
8,5 x 6,5	22				M12				5073849	6949768	6954875	6953221	5069534	
9,0 x 7,0	22	M9	M12	M12		M12			6947393	6947338	6951216	6946965	6955397	
9,0 x 7,1														
10,0 x 8,0	25	M10					M10			6949111	6951215	6949998	9080012	
10,5 x 8,0	25				M14					6953229	6954876	6952835	5066607	
11,0 x 9,0	25		M14	M14						6949177	6946167	6946104	6955398	
11,2 x 9,0	25					M14				6949353	6951551	6951219	5069535	
12,0 x 9,0	25	M12	M16	M16						9206617	6950343	6946106	9074741	
12,5 x 10,0	25				M16	M16					6951398	6951553	6951493	
14,0 x 11,0	25		M18	M18	M18	M18					6951559	6947337	9074742	
14,0 x 11,2														
15,0 x 12,0	25				M20						5073856	6953222	5066608	
16,0 x 12,0	25		M20	M20							6951399	6948391	9080073	
16,0 x 12,5														
17,0 x 13,0	25				M22							5066606	5066609	
18,0 x 14,0	25		M22	M22		M24						6950206	6952207	
18,0 x 14,5			M24	M24										
20,0 x 16,0	28		M27	M27		M27 M30						6948392	6948903	
22,0 x 18,0	28		M30	M30									6949124	
22,0 x 18,0	41		M30	M30										5065799
25,0 x 20,0	41		M33	M33		M36								5065800
28,0 x 22,0	41		M36	M36										5065801
32,0 x 24,0	41		M39	M39										5065802
			M42	M42										

① 加固柄部

① Reinforced shank

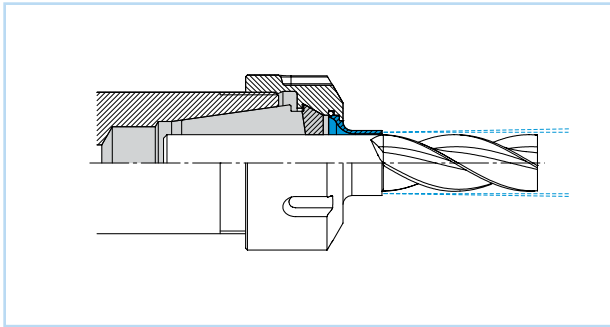
* ESX12 = 14

* ESX16-32 = 15 bzw. 18



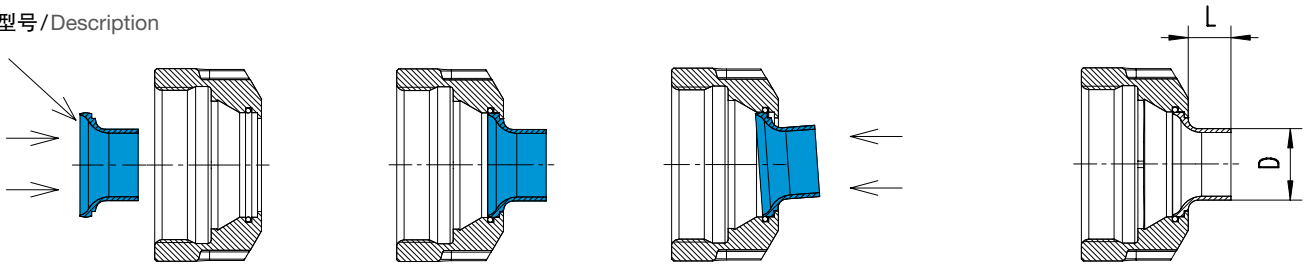
			ER8	ER11	ER16	ER20	ER25	ER32	ER40
夹持范围 Clamping range			ESX 8 l = 13,6 d = 8,5	ESX 12 l = 18,0 d = 11,5	ESX 16 l = 27,5 d = 17,0	ESX 20 l = 31,5 d = 21,0	ESX 25 l = 34,0 d = 26,0	ESX 32 l = 40,0 d = 33,0	ESX 40 l = 46,0 d = 41,0
mm	英寸/inch		订货号/Id. No.	订货号/Id. No.	订货号/Id. No.	订货号/Id. No.	订货号/Id. No.	订货号/Id. No.	订货号/Id. No.
	名义上的/nominal	分数/fractional							
1,00 - 0,50	0,0394...0,1097	1/32"	5118029	6921612					
1,50 - 1,00	0,0591...0,0394		5118031	6921613					
2,00 - 1,50	0,0787...0,0591	1/16"	5118032	6921614					
2,50 - 2,00	0,0984...0,0787	3/32"	5118033	6921615					
3,00 - 2,50	0,1184...0,0984		5118034	6921616					
3,50 - 3,00	0,1378...0,1181	1/8"	5118035	6927917					
4,00 - 3,50	0,1575...0,1378	5/32"	5118036	6921617					
4,50 - 4,00	0,1772...0,1575		5118037	6927918					
5,00 - 4,50	0,1969...0,1772	3/16"	5118038	6921618					
5,50 - 5,00	0,2165...0,1969			6927919					
6,00 - 5,50	0,2362...0,2165	7/32"		6921619					
6,50 - 6,00	0,2559...0,2362	1/4"		6927920					
7,00 - 6,50	0,2756...0,2559			6921620					
1,00 - 0,50	0,0394...0,1097	1/32"			6921621	6954299	6952416		
1,50 - 1,00	0,0591...0,0394				6951299	6921634	6954309		
2,00 - 1,00	0,0787...0,0394				6921623	6921635	6949055	6951900	
3,00 - 2,00	0,1181...0,0787				6921625	6921637	6921652	6921667	6953179
4,00 - 3,00	0,1575...0,1181	5/32"			6921626	6921638	6921653	6921668	6921685
5,00 - 4,00	0,1969...0,1575	3/16"			6921627	6921639	6921654	6921669	6921686
6,00 - 5,00	0,2362...0,1969	7/32"			6921628	6921640	6921655	6921670	6921687
7,00 - 6,00	0,2756...0,2362				6921629	6921641	6921656	6921671	6921688
8,00 - 7,00	0,3150...0,2756	5/16"			6921630	6921642	6921657	6921672	6921689
9,00 - 8,00	0,3543...0,3150	11/32"			6921631	6921643	6921658	6921673	6921690
10,00 - 9,00	0,3937...0,3543				6921632	6921644	6921659	6921674	6921691
11,00 - 10,00	0,4330...0,3937					6921645	6921660	6921675	6921692
12,00 - 11,00	0,4724...0,4375	15/32"				6921646	6921661	6921676	6921693
13,00 - 12,00	0,5118...0,4724	1/2"				6921647	6921662	6921677	6921694
14,00 - 13,00	0,5512...0,5118						6921663	6921678	6921695
15,00 - 14,00	0,5905...0,5512						6921664	6921679	6921696
16,00 - 15,00	0,6300...0,5905	5/8"					6921665	6921680	6921697
17,00 - 16,00	0,6693...0,6300	21/32"						6921681	6921698
18,00 - 17,00	0,7087...0,6693							6921682	6921699
19,00 - 18,00	0,7480...0,7078							6921683	6921700
20,00 - 19,00	0,7874...0,7480	25/32"						6921684	6921701
21,00 - 20,00	0,8268...0,7874	13/16"							6921702
22,00 - 21,00	0,8661...0,8268								6921703
23,00 - 22,00	0,9055...0,8661								6921704
24,00 - 23,00	0,9449...0,9055	15/16"							6921705
25,00 - 24,00	0,9843...0,9449	31/32"							6921706
26,00 - 25,00	1,0236...0,9843								6921707
27,00 - 26,00	1,0630...1,0236	1.1/16"							6923957
28,00 - 27,00	1,1024...1,0630	1.3/32"							6954680
29,00 - 28,00	1,1417...1,1024	1.1/8"							6954966
30,00 - 29,00	1,1811...1,1417	1.5/32"							6953214

用于工具的外围冷却 / For peripheral cooling of the tools



安装 / Ausbau Assembly / Disassembly

型号 / Description



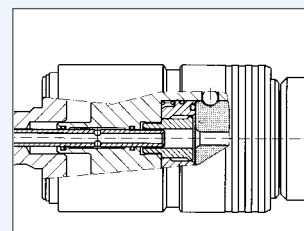
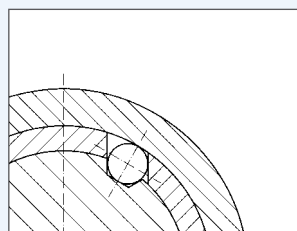
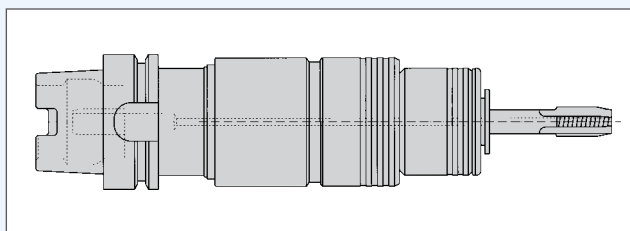
型号 Designation	订货号 Id. No.	L mm	D mm	型号 Designation	订货号 Id. No.	L mm	D mm
KS/ER16-3,0	5083082	11,0	6,4	KS/ER25-3,0	5083090	11,0	6,4
KS/ER16-4,0	5083083	11,0	7,4	KS/ER25-4,0	5083091	11,0	7,4
KS/ER16-5,0	5083084	11,0	8,4	KS/ER25-5,0	5083092	11,0	8,4
KS/ER16-6,0	5083085	11,0	9,4	KS/ER25-6,0	5083093	11,0	9,4
KS/ER16-7,0	5083086	11,0	12,0	KS/ER25-7,0	5083094	11,0	10,4
KS/ER16-8,0	5083087	11,0	11,0	KS/ER25-8,0	5083095	11,0	11,3
KS/ER16-9,0	5083088	3,0	11,0	KS/ER25-9,0	5083096	11,0	12,4
KS/ER16-10,0	5083089	3,0	11,0	KS/ER25-10,0	5083097	11,0	13,4
KS/ER20-3,0	5083073	11,0	6,4	KS/ER25-12,0	5083098	11,0	15,4
KS/ER20-4,0	5083074	11,0	7,4	KS/ER25-14,0	5083099	11,0	17,4
KS/ER20-5,0	5083075	11,0	8,4	KS/ER25-16,0	5083100	11,0	19,0
KS/ER20-6,0	5069262	11,0	9,4	KS/ER32-3,0	5083101	11,0	6,4
KS/ER20-7,0	5083077	11,0	10,4	KS/ER32-4,0	5083102	11,0	7,4
KS/ER20-8,0	5083078	11,0	11,4	KS/ER32-5,0	5083103	11,0	8,4
KS/ER20-9,0	5083079	11,0	12,4	KS/ER32-6,0	5083104	11,0	9,4
KS/ER20-10,0	5083080	11,0	14,4	KS/ER32-7,0	5083105	11,0	10,4
KS/ER20-12,0	5083081	3,0	14,4	KS/ER32-8,0	5083106	11,0	11,4
				KS/ER32-9,0	5083107	11,0	12,4
				KS/ER32-10,0	5083108	11,0	13,4
				KS/ER32-12,0	5083109	11,0	15,4
				KS/ER32-14,0	5083110	11,0	17,4
				KS/ER32-16,0	5083111	11,0	19,4
				KS/ER32-18,0	5083112	11,0	19,4
				KS/ER32-20,0	5083113	11,0	24,0

应用：攻丝，螺纹挤压

机器型号：加工中心，生产线，专机，钻床和铣床

Application: tapping, roll forming

Machine type: machining centres, transfer lines, special purpose, drilling and milling machines



在攻丝和螺纹冷挤压的一种新观念

Bilz WFLC和WFLC K带伸缩功能，专为手动机床和数控机床而设计。

通过球轴承的不对称排列以及由此而引起的力的优化分配，使轴向伸缩明显优于以前的系统。结合最初的硬切削力，确保了在困难的加工条件下的精度和有效操作。

长度补偿通过流体静力学的冷却液自然进行，WFLC K攻丝刀柄允许最大50bar的内冷压力。丝锥快换夹头简单高效，并且不会影响攻丝刀柄系统。

由于是模块化柄部系统，可以和Bilz WA刀杆配合使用，使和Bilz WFLC众多的机械结构一起使用成为可能。

WFLC和WFLC K都是免维护的攻丝系统，因此可以长时间保持在高效水平上。

A new concept in tapping and cold forming of threads

The Bilz range of WFLC and WFLC K tapping systems with extension and compression are designed for use on both manual and numerically controlled machines.

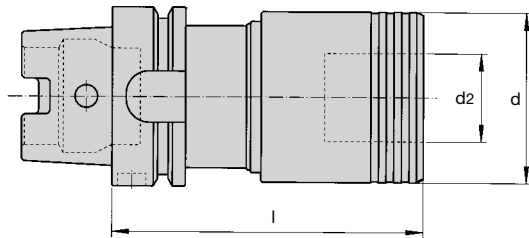
The new concept is characterised by the asymmetric arrangement of the balls which results in the optimum distribution of force, thus making the length compensation superior to previous systems, which, when combined with a stiff initial cutting pressure, ensures accuracy and effective operation under the most difficult of machining conditions.

The length compensation is unaffected by the hydrostatic neutral coolant feed, and the WFLC K chuck is designed to operate with internal coolant up to 50 bar pressure. The changing of tap adaptors is simple and effective and does not affect the systems of the chuck.

Because of its modular shank system and by utilising the Bilz WA toolholder, it is possible to use the Bilz WFLC on numerous machine configurations.

Both the WFLC and WFLC K tapping systems are maintenance free and therefore maintain a high level of long term efficiency.

特点:	优势:	效益:
▪ 偏心钢珠构造	▪ 最佳的力的分配	▪ 更少的维护需求
▪ 带更高轴向力的硬启动, 不可调	▪ 避免刚开始攻丝时刀柄启动压缩功能	▪ 减少了故障发生率
▪ 冷却液压力最大50bar	▪ 拉伸时主轴轴向没有移动, 即使冷却液被堵住	▪ 没有碰撞和丝锥崩刃的风险
▪ 更好的密封	▪ 没有污染造成的故障	▪ 更长的保养周期
▪ MS, W模块式柄部系统	▪ 更高的灵活性	▪ 减少了需求的刀具数量
▪ 可用于卧式和立式	▪ 更高的灵活性	▪ 减少了需求的刀具数量
▪ 可用于左旋和右旋螺纹	▪ 更高的灵活性	▪ 减少了需求的刀具数量
Features:	Advantages:	Benefits:
▪ out of centre ball configuration	▪ optimal force distribution	▪ less maintenance required
▪ hard start with higher axial force, not adjustable	▪ to avoid the chuck getting into compression during the start of the tap	▪ reduction of error rate
▪ hydrostatic pressure compensation max. 50 bar	▪ no axial movement of the spindle into tension, even when the coolant flow is blocked	▪ no risk of collision or tap breakage
▪ better sealing	▪ no malfunction due to contamination	▪ longer maintenance sequences
▪ modular shank system MS, W	▪ higher flexibility	▪ reduced number of tools required
▪ horizontally, vertically applicable	▪ higher flexibility	▪ reduced number of tools required
▪ applicable for left and right handed threads	▪ higher flexibility	▪ reduced number of tools required

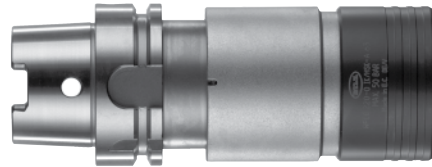
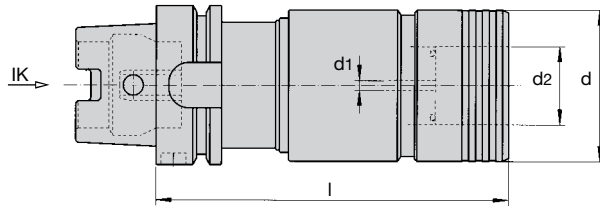


DIN
69 893 A



WFLC/HSK-A...											
型号 Designation					d	d2		HSK50	HSK63	HSK80	HSK100
WFLC012/HSK-A...	0	M2-M8	6	6	28	13	I	–	66	–	–
							Id. No.	–	9163079	–	–
WFLC115/HSK-A...	1	M3-M12	7,5	7,5	39	19	I	72	72	75	80
							Id. No.	6728133	6727989	6728062	6728020
WFLC115-0/HSK-A...	1	M3-M12	0	12,5	39	19	I	64,5	64,5	67,5	72,5
							Id. No.	6728083	6728015	6728157	6728078
WFLC220/HSK-A...	2	M8-M20	10	10	60	31	I	110	110	95	100
							Id. No.	6728386	6728293	6728335	6728286
WFLC220-0/HSK-A...	2	M8-M20	0	16,5	60	31	I	100	100	85	90
							Id. No.	–	6728292	6728403	6728284
WFLC335/HSK-A...	3	M14-M33	17,5	17,5	86	48	I	–	141	141	144
							Id. No.	–	6728463	–	6728469
WFLC335-0/HSK-A...	3	M14-M33	0	35	86	48	I	–	123,5	123,5	126,5
							Id. No.	–	6728474	–	6728533
WFLC440/HSK-A...	4	M22-M48	20	20	107	60	I	–	164	164	167
							Id. No.	–	6728551	–	6728571

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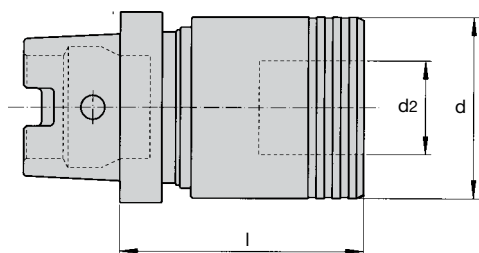
WFLC..IK/HSK-A...															
型号 Designation					d	d1	d2		HSK32	HSK40	HSK50	HSK63	HSK80	HSK100	
WFLC012-0-IK/HSK-A...	0	M2-M8	0	12	28	2	13	I	84	80	—	86	—	—	
								Id. No.	6727938	6727939	—	5060281	—	—	
WFLC115-IK/HSK-A...	1	M3-M12	7,5	7,5	39	2,5	19	I	—	—	103	105	110	112	
								Id. No.	—	—	6728134	6728000	6728129	6728026	
WFLC115-0-IK/HSK-A...	1	M3-M12	0	15	39	2,5	19	I	—	—	95,5	97,5	102,5	104,5	
								Id. No.	—	—	6728067	6728001	6728121	6728068	
WFLC220-IK/HSK-A...	2	M8-M20	10	10	60	4	31	I	—	—	140	140	142	144	
								Id. No.	—	—	6728342	6728256	6728385	6728294	
WFLC220-0-IK/HSK-A...	2	M8-M20	0	20	60	4	31	I	—	—	130	130	132	134	
								Id. No.	—	—	6728339	6728282	6728369	6728285	
WFLC335-IK/HSK-A...	3	M14-M33	17,5	17,5	86	5	48	I	—	—	—	203	208	210	
								Id. No.	—	—	—	6728526	—	6728477	
WFLC335-0-IK/HSK-A...	3	M14-M33	0	35	86	5	48	I	—	—	—	185,5	190,5	192,5	
								Id. No.	—	—	—	6728512	6728525	6728535	
WFLC440-IK/HSK-A...	4	M22-M48	20	20	107	6	60	I	—	—	—	—	—	235	
								Id. No.	—	—	—	—	—	6728577	
WFLC440-0-IK/HSK-A...	4	M22-M48	0	35	107	6	60	I	—	—	—	—	—	215	
								Id. No.	—	—	—	—	—	6728581	

合适的快换攻丝夹头见第98–132页
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包括冷却液管。
Coolant tube included.

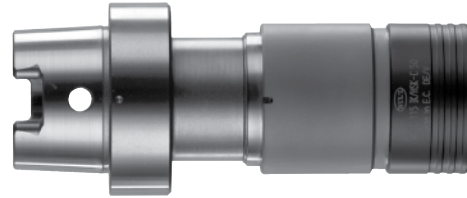
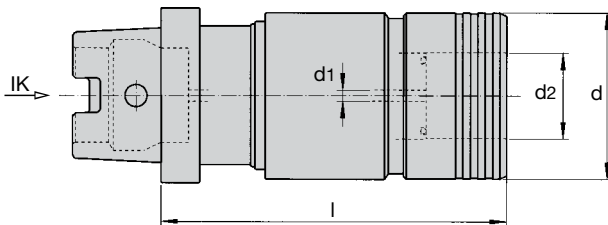
DIN
69893A





WFLC/HSK-C...													
型号 Designation					d	d2		HSK32	HSK40	HSK50	HSK63	HSK80	HSK100
WFLC012/HSK-C...	0	M2-M8	6	6	28	13	I	53	—	52	—	—	—
							Id. No.	6727899	—	6773366	—	—	—
WFLC012-0/HSK-C...	0	M2-M8	0	12	28	13	I	47	47	52	—	—	—
							Id. No.	6727898	6727903	6727901	—	—	—
WFLC115/HSK-C...	1	M3-M12	7,5	7,5	39	19	I	—	—	59	62	66	66
							Id. No.	—	—	6728012	6727965	—	6728024
WFLC115-0/HSK-C...	1	M3-M12	0	12,5	39	19	I	—	—	51,5	54,5	58,5	58,5
							Id. No.	—	—	6728018	6728088	—	—
WFLC220/HSK-C...	2	M8-M20	10	10	60	31	I	—	—	81	81	90	90
							Id. No.	—	—	6728287	6728281	—	—
WFLC220-0/HSK-C...	2	M8-M20	0	16,5	60	31	I	—	—	71	71	80	80
							Id. No.	—	—	6728253	6728296	6728384	—
WFLC335/HSK-C...	3	M14-M33	17,5	17,5	86	48	I	—	—	115	115	115	—
							Id. No.	—	—	—	6728467	—	—
WFLC335-0/HSK-C...	3	M14-M33	0	35	86	48	I	—	—	97,5	97,5	97,5	—
							Id. No.	—	—	—	6728472	—	—
WFLC440/HSK-C...	4	M22-M48	20	20	107	60	I	—	—	—	135	—	—
							Id. No.	—	—	—	9077564	—	—

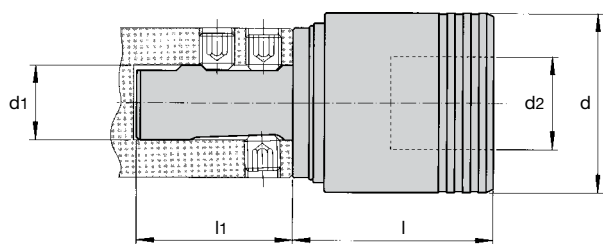
合适的快换攻丝夹头见第98–132页
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WFLC...IK/HSK-C...														
型号 Designation					d	d1	d2		DIN 69893 C					
									HSK32	HSK40	HSK50	HSK63	HSK80	HSK100
WFLC012-0-IK/HSK-C...	0	M2-M8	0	12	28	2	13	I	72	72	—	—	—	—
								Id. No.	6727924	5001509	—	—	—	—
WFLC115-IK/HSK-C...	1	M3-M12	7,5	7,5	39	2,5	19	I	—	—	93	93	96	96
								Id. No.	—	—	6728058	6727999	—	—
WFLC115-0-IK/HSK-C...	1	M3-M12	0	15	39	2,5	19	I	—	—	85,5	85,5	88,5	88,5
								Id. No.	—	—	6728060	6728074	—	—
WFLC 220-IK/HSK-C...	2	M8-M20	10	10	60	4	31	I	—	—	125	125	128	128
								Id. No.	—	—	6728329	6728353	—	—
WFLC220-0-IK/HSK-C...	2	M8-M20	0	20	60	4	31	I	—	—	115	115	118	118
								Id. No.	—	—	6728346	6728352	—	—
WFLC335-IK/HSK-C...	3	M14-M33	17,5	17,5	86	5	48	I	—	—	—	191	194	194
								Id. No.	—	—	—	—	—	—
WFLC335-0-IK/HSK-C...	3	M14-M33	0	35	86	5	48	I	—	—	—	173,5	176,5	176,5
								Id. No.	—	—	—	6728507	—	—

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WFLC/MS

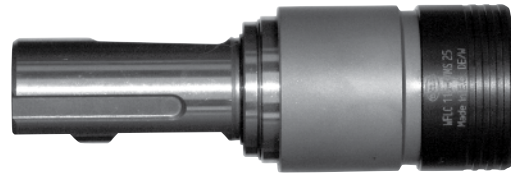
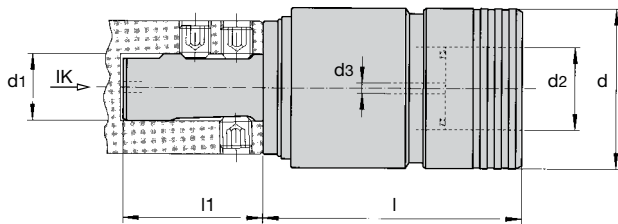
带有Bilz模块式柄部MS，与DIN 1835相似，与Bilz-WA刀座组合使用。

With Bilz modular shank MS similar to DIN 1835 to combine with toolholder Bilz-WA

型号/订货号 Designation/Id. No.					d	d1	d2	l	l1
WFLC012/MS16 6727907	0	M2-M8	6	6	28	16	13	39,5	40
WFLC012-0/MS16 6727909	0	M2-M8	0	12	28	16	13	39,5	40
WFLC115/MS25 6728583	1	M3-M12	7,5	7,5	39	25	19	45	53
WFLC115-0/MS25 6728584	1	M3-M12	0	12,5	39	25	19	37,5	53
WFLC220/MS25 6728595	2	M8-M20	10	10	60	25	31	68	53
WFLC220-0/MS25 6728597	2	M8-M20	0	16,5	60	25	31	58	53
WFLC335/MS32 6728601	3	M14-M33	17,5	17,5	86	32	48	99	60
WFLC335-0/MS32 6728602	3	M14-M33	0	35	86	32	48	81,5	60
WFLC440/MS40 6728603	4	M22-M48	20	20	107	40	60	122	68
WFLC440-0/MS40 6728604	4	M22-M48	0	40	107	40	60	102	68

合适的快换攻丝夹头见第98–132页

Suitable quick change adaptors see page 98 – 132



WFLC...K/MS

带有Bilz模块式柄部MS，与DIN 1835相似，与Bilz-WA刀座组合使用并带冷却液供给。

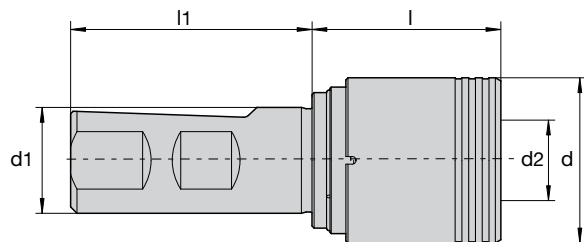
With Bilz modular shank MS... similar to DIN 1835 to combine with toolholder Bilz-WA with coolant feed

型号/订货号 Designation/Id. No.					d	d1	d2	d3	l	l1
WFLC012-K/MS16 6727908	0	M2-M8	6	6	28	16	13	2	54	40
WFLC012-0K/MS16 6727906	0	M2-M8	0	12	28	16	13	2	48	40
WFLC115-K/MS25 6728606	1	M3-M12	7,5	7,5	39	25	19	2,5	62	53
WFLC115-0K/MS25 6728609	1	M3-M12	0	15	39	25	19	2,5	54,5	53
WFLC220-K/MS25 6728611	2	M8-M20	10	10	60	25	31	4	98	53
WFLC220-0K/MS25 6728614	2	M8-M20	0	20	60	25	31	4	88	53
WFLC335-K/MS32 6728620	3	M14-M33	17,5	17,5	86	32	48	5	147	60
WFLC335-0K/MS32 6728621	3	M14-M33	0	35	86	32	48	5	129,5	60
WFLC440-K/MS40 6728625	4	M22-M48	20	20	107	40	60	6	172	68
WFLC440-0K/MS40 6728627	4	M22-M48	0	40	107	40	60	6	152	68

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DIN
1835
B+E



WFLC/W

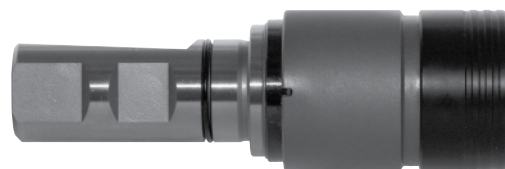
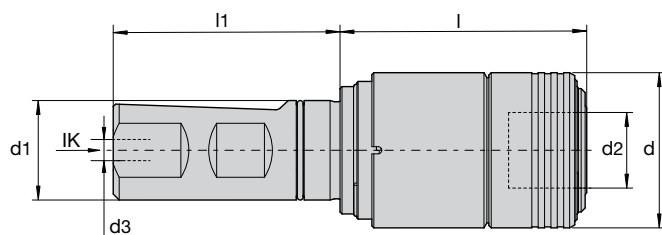
侧固式，与用于立铣刀的侧固刀柄DIN 1835 B+E组合使用

Shank Weldon, Whistle-Notch acc. DIN 1835 B+E for end mill holder

型号/订货号 Designation/Id. No.					d	d1	d2	l	l1
WFLC115/W25 9078378	1	M3-M12	7,5	7,5	39	25	19	45	57
WFLC115-0/W25 5075970	1	M3-M12	0	12,5	39	25	19	37,5	57
WFLC220/W25 9078379	2	M8-M20	10	10	60	25	31	68	57
WFLC220-0/W25 5075971	2	M8-M20	0	16,5	60	25	31	58	57
WFLC335/W32 9078380	3	M14-M33	17,5	17,5	86	32	48	99	61
WFLC335-0/W32 5075972	3	M14-M33	0	35	86	32	48	81,5	61

合适的快换攻丝夹头见第98–132页

Suitable quick change adaptors see page 98 – 132



WFLC...K/W

侧固式，与用于立铣刀的侧固刀柄DIN 1835 B+E组合使用

Shank Weldon, Whistle-Notch acc. DIN 1835 B+E for end mill holder

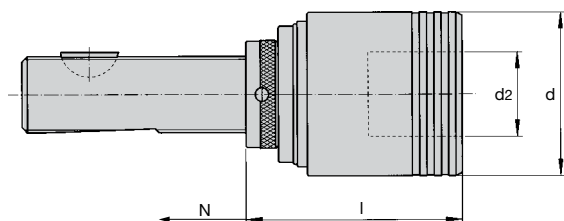
型号/订货号 Designation/Id. No.					d	d1	d2	d3	l	l1
WFLC115-K/W25 9078428	1	M3-M12	7,5	7,5	39	25	19	2,5	62	57
WFLC115-0K/W25 5075973	1	M3-M12	0	15	39	25	19	2,5	54,5	57
WFLC220-K/W25 9078429	2	M8-M20	10	10	60	25	31	4	98	57
WFLC220-0K/W25 5075974	2	M8-M20	0	20	60	25	31	4	88	57
WFLC335-K/W32 9078431	3	M14-M33	17,5	17,5	86	32	48	5	147	68
WFLC335-0K/W32 5075976	3	M14-M33	0	35	86	32	48	5	129,5	68

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DIN
1835
B+E





DIN
6327



WFLC/TR												
型号 Designation					d	d2		TR16	TR20	TR28	TR36	TR48
WFLC012/TR...	0	M2-M8	6	6	28	13	I	45,5	–	–	–	–
							Id. No.	–	–	–	–	–
WFLC012-0/TR...	0	M2-M8	0	12	28	13	I	39,5	–	–	–	–
							Id. No.	6727902	6727922	–	–	–
WFLC115/TR...	1	M3-M12	7,5	7,5	39	19	I	57	57	57	–	–
							Id. No.	6727967	6727966	6727968	–	–
WFLC115-0/TR...	1	M3-M12	0	12,5	39	19	I	49,5	49,5	49,5	–	–
							Id. No.	6728076	6727996	6728041	–	–
WFLC220/TR...	2	M8-M20	10	10	60	31	I	–	80	80	82	–
							Id. No.	–	6728258	6728259	6728260	–
WFLC220-0/TR...	2	M8-M20	0	16,5	60	31	I	–	70	70	72	–
							Id. No.	–	6728303	6728305	6728309	–
WFLC335/TR...	3	M14-M33	17,5	17,5	86	48	I	–	–	111	113	117
							Id. No.	–	–	6728449	6728450	6728451
WFLC335-0/TR...	3	M14-M33	0	35	86	48	I	–	–	93,5	95,5	99,5
							Id. No.	–	–	6728481	6728482	–
WFLC440/TR...	4	M22-M48	20	20	107	60	I	–	–	–	–	140
							Id. No.	–	–	–	–	6728553
WFLC440-0/TR...	4	M22-M48	0	40	107	60	I	–	–	–	116	120
							Id. No.	–	–	–	–	–

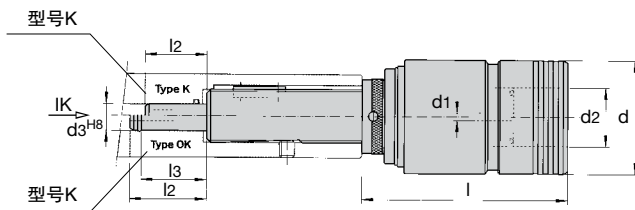
合适的快换攻丝夹头见第98–132页

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长度调节量

Length adjustment

SM	N
TR16	28
TR20	28
TR28	30
TR36	36
TR48	47



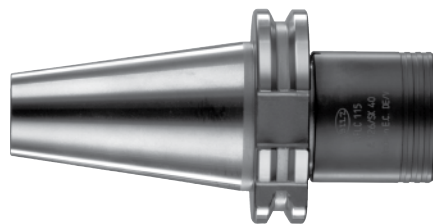
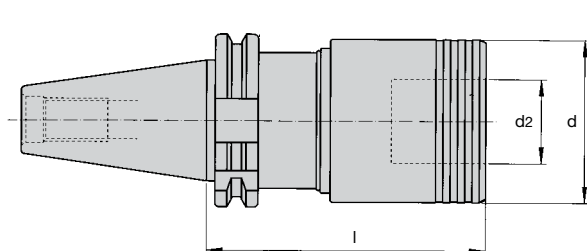
	Type	d3	l2	l3
TR 20x2	K	8	41	—
	OK	12	47	41
TR 28x2	K	12	43	—
	OK	16	51	45
TR 36x2	K	14	50	—
	OK	16	61	54
TR 48x2	K	18	62	—
	OK	18	77	70

型号IK: 没有密封栓，在夹紧螺帽里进行密封。
Type IK: Without plug. Seal at clamping nut.

WFLC...-K/TR...															
型号 Designation															
					d	d1	d2		TR16	TR20	TR28	TR36	TR48		
WFLC012-IK/TR...	0	M2-M8	6	6	28	2	13	I	66	—	—	—	—		
			Id. No.	6727931				—	—	—	—				
WFLC012-0-K/TR...			0	12				I	60	60	—	—	—		
								Id. No.	—	6727934	—	—	—		
WFLC012-0-OK/TR...								I	60	—	—	—	—		
	Id. No.	6727911			—	—	—	—							
WFLC012-0-IK/TR...								I	60	—	—	—	—		
								Id. No.	6727910	—	—	—	—		
WFLC115-K/TR...	1	M3-M12	7,5	7,5	39	2,5	19	I	—	74	74	—	—		
								Id. No.	—	6727992	6727980	—	—		
WFLC115-OK/TR...								I	—	—	—	—	—		
								Id. No.	—	6728005	6727979	—	—		
WFLC115-IK/TR...								I	—	—	—	—	—		
								Id. No.	—	6727955	6727943	—	—		
WFLC115-0-K/TR...	1	M3-M12	0	15	39	2,5	19	I	—	66,5	66,5	—	—		
								Id. No.	—	6728033	6728040	—	—		
WFLC115-0-OK/TR...								I	—	—	—	—	—		
								Id. No.	—	6727997	6727998	—	—		
WFLC115-0-IK/TR...								I	—	—	—	—	—		
								Id. No.	—	6728013	6727956	—	—		
WFLC220-K/TR...	2	M8-M20	10	10	60	4	31	I	—	—	110	112	—		
								Id. No.	—	—	6728273	6728257	—		
WFLC220-OK/TR...								I	—	—	—	—	—		
								Id. No.	—	—	6728288	6728289	—		
WFLC220-IK/TR...								I	—	—	—	—	—		
								Id. No.	—	—	6728224	6728272	—		
WFLC220-0-K/TR...	2	M8-M20	0	20	60	4	31	I	—	—	100	102	—		
								Id. No.	—	—	6728304	6728321	—		
WFLC220-0-OK/TR...								I	—	—	—	—	—		
								Id. No.	—	—	6728280	6728322	—		
WFLC220-0-IK/TR...								I	—	—	—	—	—		
								Id. No.	—	—	6728246	6728393	—		
WFLC335-K/TR...	3	M14-M33	17,5	17,5	86	5	48	I	—	—	159	161	165		
								Id. No.	—	—	6728484	6728462	6728448		
WFLC335-OK/TR...								I	—	—	—	—	—		
								Id. No.	—	—	6728487	6728489	—		
WFLC335-IK/TR...								I	—	—	—	—	—		
								Id. No.	—	—	6728446	6728442	6728460		
WFLC335-0-K/TR...	3	M14-M33	0	35	86	5	48	I	—	—	141,5	143,5	147,5		
								Id. No.	—	—	6728485	6728486	—		
WFLC335-0-OK/TR...								I	—	—	—	—	—		
								Id. No.	—	—	6728488	6728490	—		
WFLC335-0-IK/TR...								I	—	—	—	—	—		
								Id. No.	—	—	6728445	—	—		
WFLC440-IK/TR...	4	M22-M48	20	20	107	6	60	I	—	—	—	186	190		
									Id. No.	—	—	—	6728552	6728557	
WFLC440-0-IK/TR...									I	—	—	—	166	170	
			0	40				Id. No.	—	—	—	—	—		

注意! 根据不同的柄部直径, 内冷压力是不同的。
Attention! Typ IK coolant pressure different, acc to shank Ø

合适的快换攻丝夹头见第98–132页
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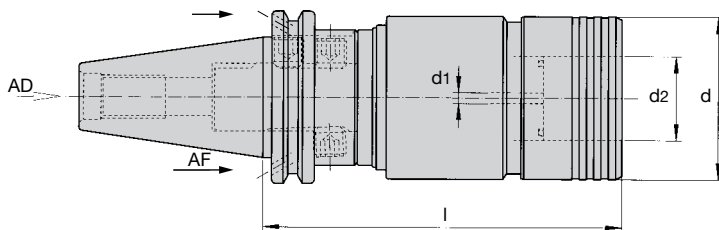


DIN
69871



WFLC/A126/SK... (Alt/Old: DIN 69871)											
型号											
Designation					d	d2		SK30	SK40	SK45	SK50
WFLC115/A126/SK...	1	M3-M12	7,5	75	39	19	I	65	65	65	65
							Id. No.	6727975	6727958	6727977	9082571
WFLC115-0/A126/SK...	1	M3-M12	0	12,5	39	19	I	57,5	57,5	57,5	57,5
							Id. No.	6728123	6727982	–	–
WFLC220/A126/SK...	2	M8-M20	10	10	60	31	I	103	103	88	88
							Id. No.	6728268	6728248	6728269	6728249
WFLC220-0/A126/SK...	2	M8-M20	0	16,5	60	31	I	93	93	78	78
							Id. No.	6728351	6728298	6728388	6728324
WFLC335/A126/SK...	3	M14-M33	17,5	17,5	86	48	I	–	134	134	134
							Id. No.	–	6728443	6728458	6728444
WFLC335-0/A126/SK...	3	M14-M33	0	35	86	48	I	–	116,5	116,5	116,5
							Id. No.	–	6728483	–	6728480
WFLC440-A126/SK...	4	M22-M48	20	20	107	60	I	–	157	157	157
							Id. No.	–	6728559	6728561	6728578
WFLC440-0/A126/SK...	4	M22-M48	0	40	107	60	I	–	–	137	137
							Id. No.	–	–	–	6728582

合适的快换攻丝夹头见第98–132页
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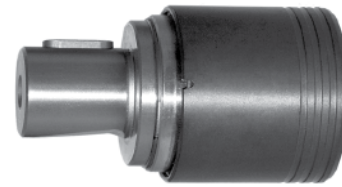
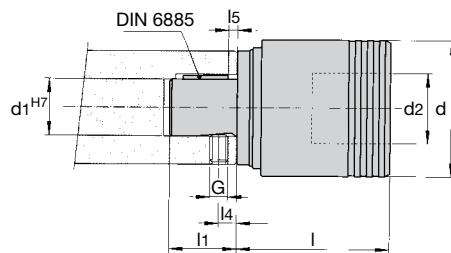


WFLC...M/A126/... (Alt/Old: DIN 69871, ADB) WFLC... K/MS... 与刀柄WA.../A126组合, 带冷却液供给B或者AD WFLC...K/MS... combined with toolholder WA.../A126, with coolant feed B or AD											
型号 Designation					d	d1	d2		AD40/B40	AD45/B45	AD50/B50
WFLC115M/A126/AD...	1	M3-M12	7,5	7,5	39	2,5	19	I	97	97	97
WFLC115M/A126/B...								Id. No.	6727949	—	6727946
WFLC115-0M/A126/AD...	1	M3-M12	0	15	39	2,5	19	I	89,5	89,5	89,5
WFLC115-0M/A126/B...								Id. No.	6728036	—	6728061
WFLC220M/A126/AD...	2	M8-M20	10	10	60	4	31	I	133	133	133
WFLC220M/A126/B...								Id. No.	6728232	6728334	6728231
WFLC220-0M/A126/AD...	2	M8-M20	0	20	60	4	31	I	—	—	—
WFLC220-0M/A126/B...								Id. No.	6728227	6728238	6728228
WFLC335M/A126/AD...	3	M14-M33	17,5	17,5	86	5	48	I	123	123	123
WFLC335M/A126/B...								Id. No.	6728254	—	6728325
WFLC335-0M/A126/AD...	3	M14-M33	0	35	86	5	48	I	—	—	—
WFLC335-0M/A126/B...								Id. No.	6728326	—	6728283
WFLC440M/A126/AD...	4	M22-M48	20	20	107	6	60	I	192	182	182
WFLC440M/A126/B...								Id. No.	6728440	6728508	6728436
WFLC440-0M/A126/AD...	4	M22-M48	0	40	107	6	60	I	—	—	—
WFLC440-0M/A126/B...								Id. No.	6728441	—	6728437
WFLC440M/A126/AD...	4	M22-M48	20	20	107	6	60	I	174,5	164,5	164,5
WFLC440M/A126/B...								Id. No.	6728491	—	6728492
WFLC440-0M/A126/AD...	4	M22-M48	0	40	107	6	60	I	—	—	—
WFLC440-0M/A126/B...								Id. No.	6728493	—	6728494
WFLC440M/A126/AD...	4	M22-M48	20	20	107	6	60	I	287	242	217
WFLC440M/A126/B...								Id. No.	—	—	6728548
WFLC440-0M/A126/AD...	4	M22-M48	0	40	107	6	60	I	287	242	217
WFLC440-0M/A126/B...								Id. No.	6728573	—	6728549
WFLC440M/A126/AD...	4	M22-M48	20	20	107	6	60	I	267	222	197
WFLC440M/A126/B...								Id. No.	—	—	6728575
WFLC440-0M/A126/AD...	4	M22-M48	0	40	107	6	60	I	267	222	197
WFLC440-0M/A126/B...								Id. No.	—	—	—

合适的快换攻丝夹头见第98–132页
Suitable quick change adaptors see page 98 – 132

DIN
69871





WFLC/A 308

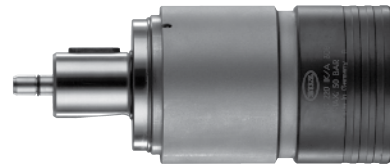
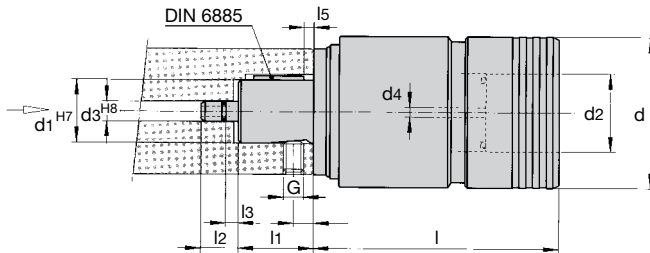
带半圆键的圆柱形柄部DIN 6885第2篇和第3篇，短型结构，根据图纸紧固到主轴孔内。

Cylindrical shank with woodruff key DIN 6885 sheet 2 and 3. Short design. Fitting into spindle bore as per drawing

型号/订货号 Designation/Id. No.					d	d1	d2	l	l1	l4	l5	G	DIN 6885
WFLC012/A308	0	M2-M8	6	6	28	16	13	39,5	18	6	3	M5	A5x3x12
—													
WFLC012-0/A308	0	M2-M8	0	12	28	16	13	33,5	18	6	3	M5	A5x3x12
—													
WFLC115/A308	1	M3-M12	7,5	7,5	39	20	19	45	24	6	3	M6	A6x4x16
6727976													
WFLC115-0/A308	1	M3-M12	0	12,5	39	20	19	37,5	24	6	3	M6	A6x4x16
6728047													
WFLC220/A308	2	M8-M20	10	10	60	25	31	68	30	8	4	M8	A6x6x20
6728270													
WFLC220-0/A308	2	M8-M20	0	16,5	60	25	31	58	30	8	4	M8	A6x6x20
6728320													
WFLC335/A308	3	M14-M33	17,5	17,5	86	36	48	99	46	10	5	M10	A10x6x32
6728459													
WFLC335-0/A308	3	M14-M33	0	35	86	36	48	81,5	46	10	5	M10	A10x6x32
6728495													
WFLC440/A308	4	M22-M48	20	20	107	48	60	122	60	12	6	M12	A10x6x45
—													
WFLC440-0/A308	4	M22-M48	0	40	107	48	60	102	60	12	6	M12	A10x6x45
6728560													

合适的快换攻丝夹头见第98–132页

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WFLC-IK/A308

圆柱形柄部带驱动键DIN 6885第2篇和第3篇，按照每个图纸紧固到主轴孔内，带冷却液供给。

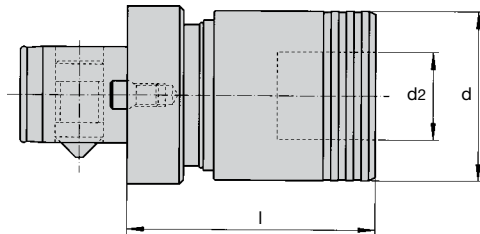
Cylindrical shank with woodruff key DIN 6885 sheet 2 and 3. Fitting into spindle bore as per drawing. With coolant feed

型号/订货号 Designation/Id. No.					d	d1	d2	d3	d4	l	l1	l2	l3	l4	l5	G	DIN 6885
WFLC012-IK/A308 6727897	0	M2-M8	6	6	28	16	13	5	2	54	18	12	2,5	6	3	M5	A5x3x12
WFLC012-0-IK/A308 6727920	0	M2-M8	0	12	28	16	13	5	2	48	18	12	2,5	6	3	M5	A5x3x12
WFLC115-IK/A308 6728004	1	M3-M12	7,5	7,5	39	20	19	7	2,5	62	24	11	3	6	3	M6	A6x4x16
WFLC115-0-IK/A308 6728064	1	M3-M12	0	15	39	20	19	7	2,5	54,5	24	11	3	6	3	M6	A6x4x16
WFLC220-IK/A308 6728350	2	M8-M20	10	10	60	25	31	8	4	98	30	15	5	8	4	M8	A6x6x20
WFLC220-0-IK/A308 6728382	2	M8-M20	0	20	60	25	31	8	4	88	30	15	5	8	4	M8	A6x6x20
WFLC335-IK/A308 -	3	M14-M33	17,5	17,5	86	36	48	10	5	147	46	15	3,5	10	5	M10	A10x6x32
WFLC335-0-IK/A308 -	3	M14-M33	0	35	86	36	48	10	5	129,5	46	15	3,5	10	5	M10	A10x6x32

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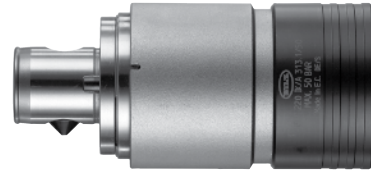
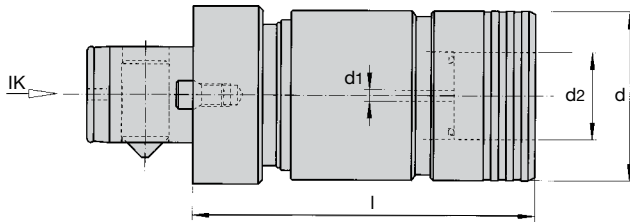


WFLC/A 313.1/... Komet ABS 系统

型号 Designation					d	d2		.../25	.../32	.../40	.../50	.../63	.../80	.../100
WFLC012/A313.1/...	0	M2-M8	6	6	28	13	I	46	48	—	—	—	—	—
							Id.No.	6727930	6727912	—	—	—	—	—
WFLC012-0/A313.1/...	0	M2-M8	0	12	28	13	I	40	42	—	—	—	—	—
							Id.No.	—	—	—	—	—	—	—
WFLC115/A313.1/...	1	M3-M12	7,5	7,5	39	19	I	—	47	56	55	56	—	—
							Id.No.	—	6727993	6728003	6728007	6728132	—	—
WFLC115-0/A313.1/...	1	M3-M12	0	12,5	39	19	I	—	39,5	48,5	47,5	50	—	—
							Id.No.	—	6728008	6728045	6728046	6728102	—	—
WFLC220/A313.1/...	2	M8-M20	10	10	60	31	I	—	—	—	70	81	—	—
							Id.No.	—	—	6728373	6728276	6728336	—	—
WFLC220-0/A313.1/...	2	M8-M20	0	16,5	60	31	I	—	—	—	60	71	—	—
							Id.No.	—	—	6728377	6728319	6728377	—	—
WFLC335/A 313.1/...	3	M14-M33	17,5	17,5	86	48	I	—	—	—	—	103	117	—
							Id.No.	—	—	—	—	6728464	6728529	—
WFLC335-0/A313.1/...	3	M14-M33	0	35	86	48	I	—	—	—	—	85,5	99,5	—
							Id.No.	—	—	—	—	6728510	6728509	—
WFLC440/A313.1/...	4	M22-M48	20	20	107	60	I	—	—	—	—	132	125	144,5
							Id.No.	—	—	—	—	6728566	6728574	6728579
WFLC440-0/A313.1/...	4	M22-M48	0	40	107	60	I	—	—	—	—	112	105	124,5
							Id.No.	—	—	—	—	—	—	—

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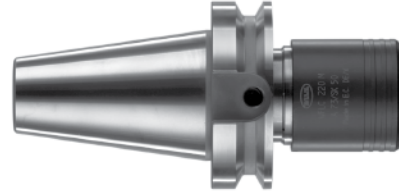
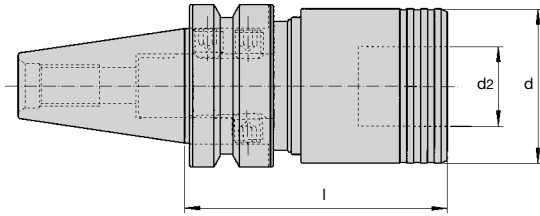
Suitable quick change adaptors see page 98 – 132



WFLC-IK/A313.1/... Komet ABS 系统															
型号 Designation															
					d	d1	d2		.../32	.../40	.../50	.../63	.../80	.../100	
WFLC012-IK/A313.1/...	0	M2-M8	6	6	28	2	13	I	62	64	—	—	—	—	
								Id.No.	6727925	6727929	—	—	—	—	
WFLC012-0-IK/A313.1/...	0	M2-M8	0	12	28	2	13	I	56	58	—	—	—	—	
								Id.No.	6727932	6727915	—	—	—	—	
WFLC115-IK/A313.1/...	1	M3-M12	7,5	7,5	39	2,5	19	I	69	73	72	74	—	—	
								Id.No.	6727960	6727981	6727984	6727985	—	—	
WFLC115-0-IK/A313.1/...	1	M3-M12	0	15	39	2,5	19	I	61,5	65,5	64,5	66,5	78,5	—	
								Id.No.	6728048	6728017	6728049	6728016	6728201	—	
WFLC 220-IK/A313.1/...	2	M8-M20	10	10	60	4	31	I	—	111	98	111	—	—	
								Id.No.	—	6728299	6728230	6728277	—	—	
WFLC220-0-IK/A313.1/...	2	M8-M20	0	20	60	4	31	I	—	101	88	101	—	—	
								Id.No.	—	—	6728301	6728251	—	—	
WFLC335-IK/A313.1/...	3	M14-M33	17,5	17,5	86	5	48	I	—	—	—	160	165	—	
								Id.No.	—	—	—	6728466	6728519	—	
WFLC335-0-IK/A313.1/...	3	M14-M33	0	35	86	5	48	I	—	—	—	142,5	147,5	—	
								Id.No.	—	—	—	—	—	—	
WFLC440-IK/A313.1/...	4	M22-M48	20	20	107	6	60	I	—	—	—	—	186	195	
								Id.No.	—	—	—	—	6728558	9156282	
WFLC440-0-IK/A313.1/...	4	M22-M48	0	40	107	6	60	I	—	—	—	—	166	175	
								Id.No.	—	—	—	—	5069417	—	

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DIN
69871



WFLC...M/A73/SK... (Alt/Old: MAS403, BT)

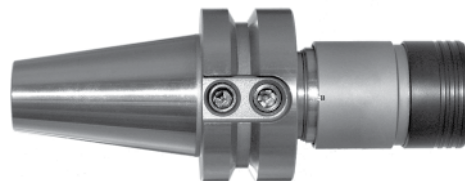
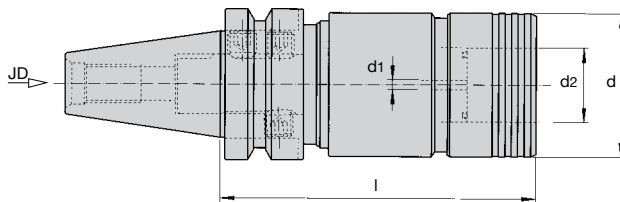
WFLC.../MS... 与刀柄 WA.../A73/SK...MAS 403 (BT)刀柄组合

WFLC.../MS... combined with toolholder WA.../A73/SK... to MAS 403

型号 Designation					d	d2		SK30	SK40	SK45	SK50
WFLC012M/A73/SK...	0	M2-M8	6	6	28	13	I	74,5	–	–	–
							Id. No.	–	–	–	–
WFLC012-0M/A73/SK...	0	M2-M8	0	12	28	13	I	68,5	–	–	–
							Id. No.	–	–	–	–
WFLC115M/A73/SK...	1	M3-M12	7,5	7,5	39	19	I	80	80	80	80
							Id. No.	–	6728014	–	6727959
WFLC115-0M/A73/SK...	1	M3-M12	0	12,5	39	19	I	72,5	72,5	72,5	72,5
							Id. No.	–	6728210	–	6728116
WFLC220M/A73/SK...	2	M8-M20	10	10	60	31	I	103	103	103	103
							Id. No.	–	6728340	–	6728250
WFLC220-0M/A73/SK...	2	M8-M20	0	16,5	60	31	I	86,5	93	93	93
							Id. No.	–	6728312	5005034	6728291
WFLC335M/A73/SK...	3	M14-M33	17,5	17,5	86	48	I	–	144	134	134
							Id. No.	–	6728497	–	6728498
WFLC335-0M/A73/SK...	3	M14-M33	0	35	86	48	I	–	126,5	116,5	116,5
							Id. No.	–	–	–	–
WFLC440M/A73/SK...	4	M22-M48	20	20	107	60	I	–	–	–	167
							Id. No.	–	–	–	6728564
WFLC440-0M/A73/SK...	4	M22-M48	0	40	107	60	I	–	–	–	147
							Id. No.	–	–	–	–

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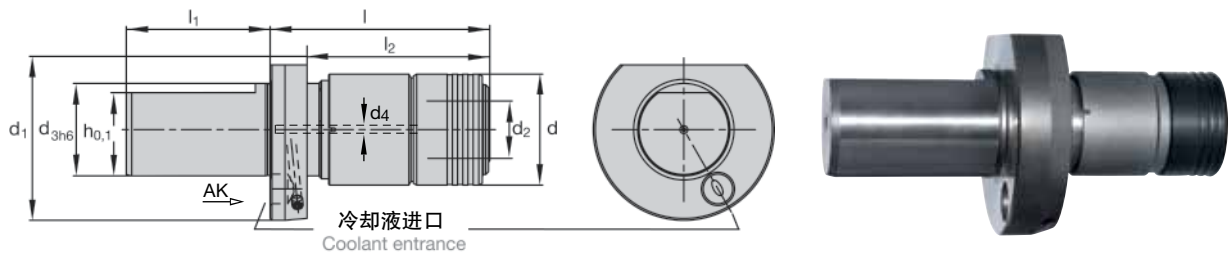
Suitable quick change adaptors see page 98 – 132



WFLC...M-IK/A73/SK... (Alt/Old: MAS403, BT)													
WFLC... K/MS... 与刀柄 WA.../A73/SK...MAS 403 (BT)刀柄组合, 带冷却液供给													
WFLC... K/MS... combined with toolholder WA.../A73/SK... to MAS 403, with coolant feed													
型号 Designation					d	d1	d2		SK30	SK40	SK45	SK50	
WFLC012M-IK/A73/SK...	0	M2-M8	6	6	28	2	13	I	89	–	–	–	
								Id. No.	–	–	–	–	
WFLC012-0M-IK/A73/SK...	0	M2-M8	0	12	28	2	13	I	83	–	–	–	
								Id. No.	–	–	–	–	
WFLC115M-IK/A73/SK...	1	M3-M12	7,5	7,5	39	2,5	19	I	97	97	97	97	
								Id. No.	5082079	6728218	–	9158588	
WFLC115-0M-IK/A73/SK...	1	M3-M12	0	15	39	2,5	19	I	89,5	89,5	89,5	89,5	
								Id. No.	–	–	–	–	
WFLC220M-IK/A73/SK...	2	M8-M20	10	10	60	4	31	I	133	133	133	133	
								Id. No.	–	6728429	–	6728430	
WFLC220-0M-IK/A73/SK...	2	M8-M20	0	20	60	4	31	I	123	123	123	123	
								Id. No.	–	6728411	–	–	
WFLC335M-IK/A73/SK...	3	M14-M33	17,5	17,5	86	5	48	I	–	–	182	182	
								Id. No.	–	–	–	9158600	
WFLC335-0M-IK/A73/SK...	3	M14-M33	0	35	86	5	48	I	–	–	164,5	164,5	
								Id. No.	–	–	–	5045923	
WFLC440M-IK/A73/SK...	4	M22-M48	20	20	107	6	60	I	–	–	–	217	
								Id. No.	–	–	–	6728572	
WFLC440-0M-IK/A73/SK...	4	M22-M48	0	40	107	6	60	I	–	–	–	197	
								Id. No.	–	–	–	–	

合适的快换攻丝夹头见第98–132页

Suitable quick change adaptors see page 98 – 132



WFLC...-AK/A65/...

无齿系统，类似于DIN 69880

without tooth system, similar DIN 69880

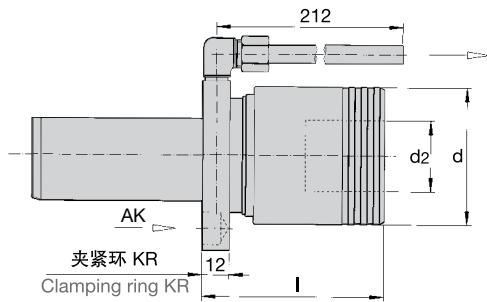
型号/订货号 Designation/Id. No.					d	d1	d2	d3 h6	d	h	l ± 0,05	l1	l2
WFLC115-AK/A65/20 6728215	1	M3-M12	7,5	7,5	39	50	19	20	2,5	18	85	40	65,5
WFLC115-AK/A65/30 6728194						68		30		27	82	55	62,5
WFLC115-AK/A65/40 6727995						83		40		36	82	63	62,5
WFLC115-AK/A65/50 6728066						98		50		45	82	78	62,5
WFLC220-AK/A65/30 6728395	2	M8-M20	10	10	60	68	31	30	4	27	119	55	98,5
WFLC220-AK/A65/40 6728391						83		40		36	119	63	98,5
WFLC220-AK/A65/50 6728421						98		50		45	119	78	98,5
WFLC220-AK/A65/60 —						123		60		55	119	94	98,5
WFLC335-AK/A65/40 6728543	3	M14-M33	17,5	17,5	86	83	48	40	5	36	181	63	—
WFLC335-AK/A65/50 9107934						98		50		45	172	78	148
WFLC335-AK/A65/60 —						123		60		55	172	94	148

提示：请订购A65.2带齿

Hint: Please order with serration A65.2

合适的快换攻丝夹头见第98–132页

Suitable quick change adaptors see page 98 – 132



WFLC/A82/...

无齿系统，类似于DIN 69880

without tooth system, similar DIN 69880

型号 Designation					d	d2		Ø20	Ø25	Ø30	Ø40	Ø50	Ø60
WFLC115/A82/	1	M3-M12	7,5	7,5	39	19	I	57	57	61	61	61	–
							Id. No.	6728051	6728055	6728023	6728002	6728144	–
WFLC115-0/A82/	1	M3-M12	0	12,5	39	19	I	49,5	49,5	53,5	53,5	53,5	–
							Id. No.	6728052	–	6728053	6728054	9070935	–
WFLC220/A82/	2	M8-M20	10	10	60	31	I	–	80	80	80	80	–
							Id. No.	–	6728390	6728271	6728278	6728297	–
WFLC220-0/A82/	2	M8-M20	0	16,5	60	31	I	–	70	70	70	70	–
							Id. No.	–	–	6728327	6728328	6728392	–
WFLC335/A82/	3	M14-M33	17,5	17,5	86	48	I	–	–	–	111	111	111
							Id. No.	–	–	–	6728476	9082987	6728544
WFLC335-0/A82/	3	M14-M33	0	35	86	48	I	–	–	–	93,5	93,5	93,5
							Id. No.	–	–	–	6728537	–	6728540
夹紧环 Clamping ring								KR20	KR25	KR30	KR40	KR50	KR60
							Id. No.	6804000	6804007	6804001	6804002	6804003	6804004

提示：请订购A82.2带齿
Hint: Please order with serration A82.2

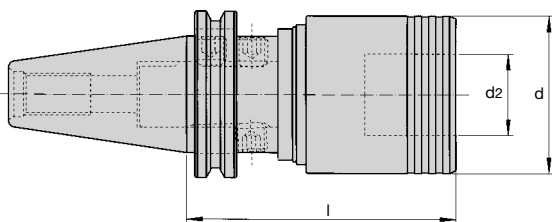
合适的快换攻丝夹头见第98–132页
Suitable quick change adaptors see page 98 – 132

DIN
69880



50 bar



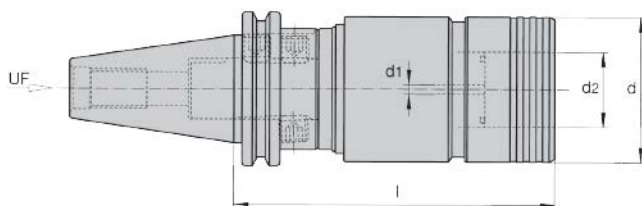


WFLC...M/A86/SK... (Alt/Old: ANSI B5.50, CAT)

WFLC.../MS... 与刀柄WA.../A 86/SK... ANSI B5.50 & CAT 组合

WFLC.../MS... combined with tool holder WA.../A86/SK... to ISO 7388-1

型号 Designation					d	d2		SK40	SK45	SK50
WFLC115M/A86/SK...	1	M3-M12	7,5	7,5	39	19	I	80	80	80
							Id. No.	—	—	6728091
WFLC115-0M/A86/SK...	1	M3-M12	0	12,5	39	19	I	72,5	72,5	72,5
							Id. No.	—	—	—
WFLC220M/A86/SK...	2	M8-M20	10	10	60	31	I	103	103	103
							Id. No.	—	—	6728394
WFLC220-0M/A86/SK...	2	M8-M20	0	16,5	60	31	I	93	93	93
							Id. No.	—	—	—
WFLC335M/A86/SK...	3	M14-M33	17,5	17,5	86	48	I	—	134	134
							Id. No.	—	—	—
WFLC335-0M/A86/SK...	3	M14-M33	0	35	86	48	I	—	116,5	116,5
							Id. No.	—	—	—



WFLC...M-IK/A86/SK... (Alt/Old: ANSI B5.50, CAT)

WFLC...K/MS... 与刀柄 WA.../A86/SK... ANSI B5.50 & CAT 组合，带冷却液供给

WFLC...K/MS... combined with toolholder WA.../A86/SK... to ISO 7388-1, with coolant feed

型号 Designation					d	d1	d2		SK40	SK45	SK50
WFLC115M-IK/A86/SK...	1	M3-M12	7,5	7,5	39	2,5	19	I	97	97	97
								Id. No.	6728206	—	6728109
WFLC115-0M-IK/A86/SK...	1	M3-M12	0	15	39	2,5	19	I	89,5	89,5	89,5
								Id. No.	6728130	—	—
WFLC220M-IK/A86/SK...	2	M8-M20	10	10	60	4	31	I	133	133	133
								Id. No.	—	—	6728243
WFLC220-0M-IK/A86/SK...	2	M8-M20	0	20	60	4	31	I	123	123	123
								Id. No.	—	—	—
WFLC335M-IK/A86/SK...	3	M14-M33	17,5	17,5	86	5	48	I	—	182	182
								Id. No.	—	—	6728468
WFLC335-0M-IK/A86/SK...	3	M14-M33	0	35	86	5	48	I	—	164,5	164,5
								Id. No.	—	—	—

提示：0号和4号按需定制
Hint: Size 0 + 4 on request

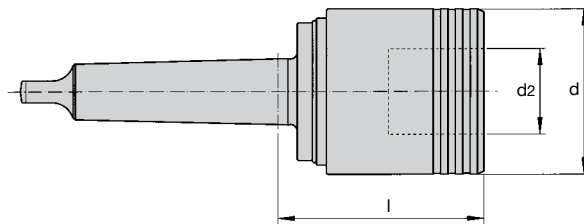
合适的快换攻丝夹头见第98–132页
Suitable quick change adaptors see page 98 – 132

DIN
69871

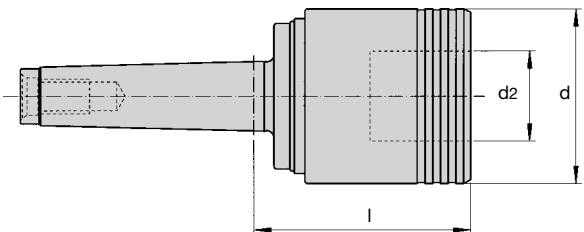


DIN
69871





WFLC/MK											
型号 Designation					d	d2		MK2	MK3	MK4	MK5
WFLC115/MK...	1	M3-M12	7,5	7,5	39	19	I	52	52	–	–
							Id. No.	6727971	6727972	–	–
WFLC115-0/MK...	1	M3-M12	0	12,5	39	19	I	44,5	44,5	–	–
							Id. No.	6728042	6728043	–	–
WFLC220/MK...	2	M8-M20	10	10	60	31	I	75	75	76	–
							Id. No.	6728417	6728264	6728265	–
WFLC220-0/MK...	2	M8-M20	0	16,5	60	31	I	65	65	66	–
							Id. No.	6728424	6728323	6728360	–
WFLC335/MK...	3	M14-M33	17,5	17,5	86	48	I	–	–	107	107,5
							Id. No.	–	–	6728454	6728455
WFLC335-0/MK...	3	M14-M33	0	35	86	48	I	–	–	89,5	90
							Id. No.	–	–	6728523	–
WFLC440/MK...	4	M22-M48	20	20	107	60	I	–	–	130	127,5
							Id. No.	–	–	5050890	6728569
WFLC440-0/MK...	4	M22-M48	0	40	107	60	I	–	–	110	107,5
							Id. No.	–	–	–	–



WFLC/MK...A											
型号 Designation					d	d2		MK2	MK3	MK4	MK5
WFLC115/MK...A	1	M3-M12	7,5	7,5	39	19	I	52	52	–	–
							Id. No.	6727973	6727974	–	–
WFLC115-0/MK...A	1	M3-M12	0	12,5	39	19	I	44,5	44,5	–	–
							Id. No.	6728098	6728099	–	–
WFLC220/MK...A	2	M8-M20	10	10	60	31	I	75	75	76	–
							Id. No.	–	6728266	6728267	–
WFLC220-0/MK...A	2	M8-M20	0	16,5	60	31	I	65	65	66	–
							Id. No.	–	6728412	6728413	–
WFLC335/MK...A	3	M14-M33	17,5	17,5	86	48	I	–	–	107	107,5
							Id. No.	–	–	6728456	6728457
WFLC335-0/MK...A	3	M14-M33	0	35	86	48	I	–	–	89,5	90
							Id. No.	–	–	6728545	–

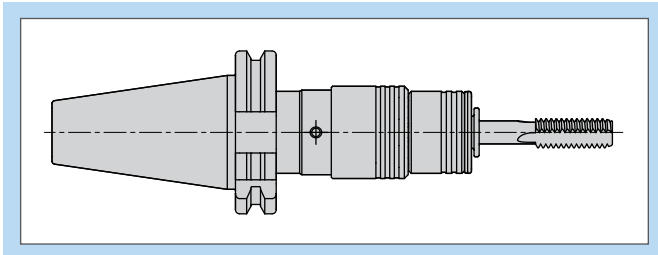
合适的快换攻丝夹头见第98–132页
Suitable quick change adaptors see page 98 – 132

应用：攻丝，螺纹挤压

机器型号： 加工中心，生产线，专机，钻床和铣床

Application: tapping, roll forming

Machine type: machining centres, transfer lines, special purpose, drilling and milling machines



攻丝和螺纹冷挤压

Bilz WFLK快换攻丝刀柄主要应用在机械地和数控机床上。使用合理的操作方法可以实现所有螺纹的攻丝公差要求。

快换刀柄的特征是适合各种各样的快换夹头且带长度补偿。当更换快换夹头时，长度补偿被完全压缩。当使用3号或者更大型号的快换刀柄时，可以通过拔出拉伸补偿脱开。

拉伸和压缩的长度补偿用于补偿丝锥螺距和机床产生的误差，并防止螺纹侧面切伤。

长度补偿位于轴承向套内，因此特别容易操作，即使是高扭矩应用。快换刀柄定位在零点位置，在延长区域预备强压力弹簧。

Bilz WFLK刀柄可以在立式和卧式机床上使用，以及用于右旋螺纹和左旋螺纹。

Tapping and cold-forming

Bilz quick change tapping chucks type WFLK are mainly used on mechanically and numerically controlled machines. They fulfill all the requirements for tapping tolerance compliant threads whilst operating rationally.

The quick change feature is suitable for various adaptors and is activated by means of the length compensation. When changing the adaptors, the length compensation is completely compressed. When using chuck size 3, and bigger uncoupling can also be carried out by pulling out the extension compensation.

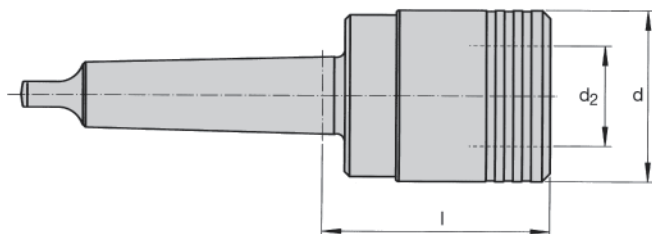
The integrated length compensation on extension and compression compensates for differences between tap pitch and machine feed and prevents cuts on the thread flanks.

The length compensation is situated in a ball cage sleeve and is therefore particularly easy-running, even when high torques are applied.

It is positioned in the zero position and is equipped with a strong pressure spring for the extension area.

Bilz WFLK chucks can be applied horizontally or vertically and can be used for right or left-handed threads.

特点:	优势:	效益:
■ 带更高轴向力的硬启动, 不可调	■ 避免刚开始攻丝时刀柄启动压缩功能	■ 减少了故障发生率
■ 更好的密封	■ 没有污染造成的故障	■ 更长的保养周期
■ MS, W模块式柄部系统	■ 更高的灵活性	■ 减少了需求的刀具数量
■ 可用于卧式和立式	■ 更高的灵活性	■ 减少了需求的刀具数量
■ 可用于左旋和右旋螺纹	■ 更高的灵活性	■ 减少了需求的刀具数量
Features:	Advantages:	Benefits:
■ hard start with higher axial force, adjustable	■ to avoid the chuck getting into compression during the start of the tap	■ reduction of error rate
■ better sealing	■ no malfunction due to contamination	■ longer maintenance sequences
■ modular shank system MS, W	■ higher flexibility	■ reduced number of tools required
■ horizontally, vertically applicable	■ higher flexibility	■ reduced number of tools required
■ applicable for left and right handed threads	■ higher flexibility	■ reduced number of tools required



DIN
228 B



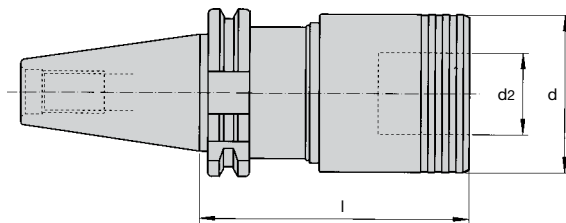
WFLK/MK												
型号 Designation					d	d2		MK2	MK3	MK4	MK5	MK6
WFLK013/MK...	0	M1-M10	6,5	6,5	26	13	I	45	–	–	–	–
Id. No.								6709984	–	–	–	–
WFLK013B/MK... ①							I	45	–	–	–	–
Id. No.								6710070	–	–	–	–
WFLK115/MK...	1	M3-M12	7,5	7,5	36	19	I	47	47	47	–	–
Id. No.								6709998	6710000	6710002	–	–
WFLK115B/MK... ①							I	47	47	47	–	–
Id. No.								6710082	6710084	–	–	–
WFLK225/MK...	2	M8-M20	12,5	12,5	53	31	I	–	71	72	–	–
Id. No.								–	6710018	6710020	–	–
WFLK225B/MK... ①							I	–	71	72	–	–
Id. No.								–	6710097	6710099	–	–
WFLK340/MK...	3	M14-M33	20,0	20,0	78	48	I	–	–	105	105,5	–
Id. No.								–	–	6710036	6710038	–
WFLK340B/MK... ①							I	–	–	105	105,5	–
Id. No.								–	–	6710111	6710113	–
WFLK445/MK...	4	M22-M48	22,5	22,5	96	60	I	–	–	–	116,5	118,5
Id. No.								–	–	–	6710051	6710053
WFLK445B/MK... ①							I	–	–	–	116,5	118,5
Id. No.								–	–	–	6710123	6710124

① = WFLK...B 不带轴承衬套

① = WFLK...B without ball cage sleeve

合适的快换攻丝夹头见第98–132页

Suitable quick change adaptors see page 98 – 132



WFLK/A126/SK... (Alt/Old: DIN 69871)												
型号 Designation					d	d2			SK30	SK40	SK45	SK50
WFLK115/A126/SK...	1	M3-M12	7,5	75	36	19	I	64	60	60	60	
							Id. No.	6709173	6709128	6709137	6709351	
WFLK115B/A126/SK... ①	1	M3-M12	7,5	75	36	19	I	64	60	60	60	
							Id. No.	6709251	6709168	6709196	9079390	
WFLK225/A126/SK...	2	M8-M20	12,5	12,5	53	31	I	99	98	84	84	
							Id. No.	6709485	6709435	6709438	6709436	
WFLK225B/A126/SK... ①	2	M8-M20	12,5	12,5	53	31	I	99	98	84	84	
							Id. No.	6709571	6709474	6709504	6709487	
WFLK340/A126/SK...	3	M14-M33	20,5	20,5	78	48	I	–	150	146	139	
							Id. No.	–	6709698	6709700	6709699	
WFLK340B/A126/SK... ①	3	M14-M33	20,5	20,5	78	48	I	–	150	146	139	
							Id. No.	–	6709733	6709734	6709735	
WFLK445/A126/SK...	4	M22-M48	22,5	22,5	96	60	I	–	165	160	152	
							Id. No.	–	6709838	6709837	6709836	
WFLK445B/A126/SK... ①	4	M22-M48	22,5	22,5	96	60	I	–	165	160	152	
							Id. No.	–	6709862	6709863	6709856	

① = WFLK...B 不带轴承衬套

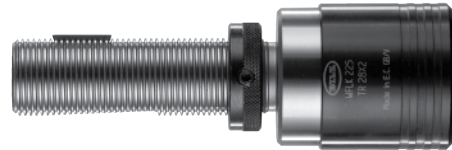
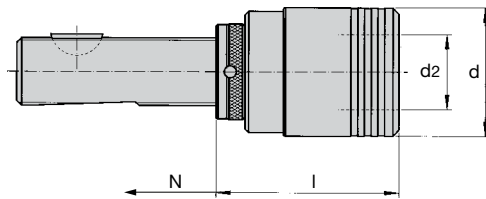
① = WFLK...B without ball cage sleeve

合适的快换攻丝夹头见第98–132页

Suitable quick change adaptors see page 98 – 132

DIN
69871





DIN
6327



WFLK/TR												
型号 Designation					d	d2		TR16	TR20	TR28	TR36	TR48
WFLK013/TR...	0	M1-M10	6,5	6,5	26	13	I	50	50	–	–	–
Id. No.							6709982	6709983	–	–	–	–
WFLK013B/TR... ①	1	M3-M12	7,5	7,5	36	19	I	50	50	–	–	–
Id. No.							6710068	6710069	–	–	–	–
WFLK115/TR...	1	M3-M12	7,5	7,5	36	19	I	52	52	52	54	–
Id. No.							6709993	6709994	6709995	6709996	–	–
WFLK115B/TR... ①	2	M8-M20	12,5	12,5	53	31	I	52	52	52	54	–
Id. No.							6710078	6710079	6710080	6710081	–	–
WFLK225/TR...	2	M8-M20	12,5	12,5	53	31	I	–	76	76	78	–
Id. No.							–	6710014	6710015	6710017	–	–
WFLK225B/TR... ①	3	M14-M33	20,0	20,0	78	48	I	–	76	76	78	–
Id. No.							–	6710094	6710095	6710096	–	–
WFLK340/TR...	3	M14-M33	20,0	20,0	78	48	I	–	–	109	111	115
Id. No.							–	–	6710031	6710033	6710035	–
WFLK340B/TR... ①	4	M22-M48	22,5	22,5	96	60	I	–	–	109	111	115
Id. No.							–	–	6710108	6710109	6710110	–
WFLK445/TR...	4	M22-M48	22,5	22,5	96	60	I	–	–	–	122	126
Id. No.							–	–	–	6710048	6710050	–
WFLK445B/TR... ①							I	–	–	–	122	126
Id. No.							–	–	–	6710121	6710122	–

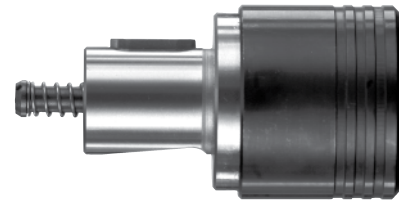
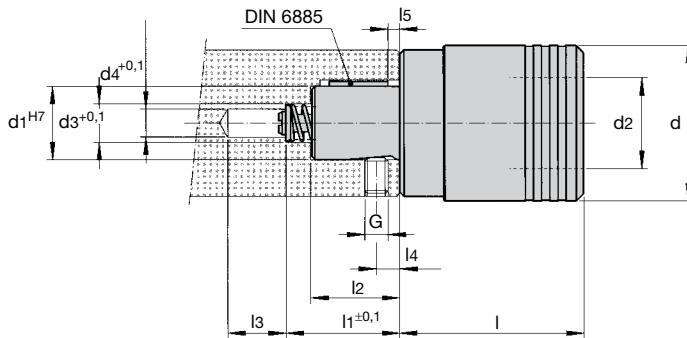
① = WFLK...B 不带轴承衬套

② = WFLK...B without ball cage sleeve

合适的快换攻丝夹头见第98–132页

Suitable quick change adaptors see page 98 – 132

长度调节量 Length adjustment	
SM	N
TR16	28
TR20	28
TR28	30
TR36	36
TR48	47



WFLK/A308

圆柱形柄部带驱动键DIN 6885第2篇和第3篇，按照每个图纸紧固到主轴孔内

Cylindrical shank with driving key DIN 6885 sheet 2 and 3. Fitting into spindle bore as per drawing

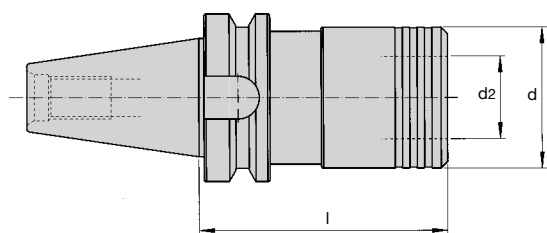
型号/订货号 Designation/Id. No.					d	d1	d2	d3	d4	l	l1	l2	l3	l4	l5	G	DIN 6885
WFLK013/A308 6708995	0	M1-M10	6,5	6,5	26	15	13	8,2	6	37	32	18,5	11	6	3	M 5	A5x3x12
WFLK013B/A308 ① 6709026																	
WFLK115/A308 6709159	1	M3-M12	7,5	7,5	36	20	19	11,2	9	39	33	24,5	11	6	3	M 6	A6x4x16
WFLK115B/A308 ① 6709241																	
WFLK225/A308 6709479	2	M8-M20	12,5	12,5	53	25	31	13,2	9,5	63	39	30,5	20	8	4	M 8	A6x6x20
WFLK225B/A308 ① 6709547																	
WFLK340/A308 6709743	3	M14-M33	20,5	20,5	78	36	48	19,3	14	97	64,5	46,5	23	10	5	M10	A10x6x32
WFLK340B/A308 ① -																	

① = WFLK...B 不带轴承衬套

① = WFLK...B without ball cage sleeve

合适的快换攻丝夹头见第98-132页

Suitable quick change adaptors see page 98 – 132



DIN
69871



WFLK/A73/SK... (Alt/Old: MAS403, BT)

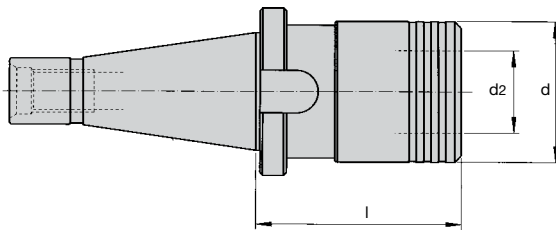
型号 Designation					d	d2		SK30	SK40	SK45	SK50
WFLK013/A73/SK...	0						l	59	–	–	–
							Id. No.	6709049	–	–	–
WFLK115/A73/SK...	1	M3-M12	7,5	7,5	36	19	l	61,5	67,5	73,5	–
							Id. No.	–	6709115	6709132	–
WFLK115B/A73/SK...							l	61,5	67,5	–	–
							Id. No.	6709317	6709154	–	–
WFLK225/A73/SK...	2	M8-M20	12,5	12,5	53	31	l	95	94,5	97,5	102,5
							Id.No.	6709568	6709418	6709441	6709423
WFLK225B/A73/SK...							l	95	94,5	–	102,5
							Id.No.	6709610	6709460	6709461	6709462
WFLK340/A73/SK...	3	M14-M33	20,0	20,0	78	48	l	–	164	154,5	142,5
							Id.No.	–	6709688	6709721	6709683
WFLK340B/A73/SK...							l	–	164	–	142,5
							Id.No.	–	6709710	–	6709711
WFLK445/A73/SK...	4	M22-M48	22,5	22,5	96	60	l	–	167	–	165,5
							Id.No.	–	6709846	–	6709830
WFLK445B/A73/SK...							l	–	167	172,5	165,5
							Id.No.	–	6709904	6709891	6709842

① = WFLK...B 不带轴承衬套

② = WFLK...B without ball cage sleeve

合适的快换攻丝夹头见第98–132页

Suitable quick change adaptors see page 98 – 132



WFLK/SK...											
型号 Designation					d	d2		SK30	SK40★	SK50	SK60
WFLK115/SK...	1	M3-M12	7,5	7,5	36	19	I	59	50	–	–
							Id. No.	6710003	6710004	–	–
WFLK115B/SK... ①	1	M3-M12	7,5	7,5	36	19	I	59	50	–	–
							Id.No	6710086	6710087	–	–
WFLK225/SK...	2	M8-M20	12,5	12,5	53	31	I	97	78	80	–
							Id.No	6710023	6710024	6710025	–
WFLK225B/SK... ①	2	M8-M20	12,5	12,5	53	31	I	97	78	80	–
							Id. No.	6710100	6710101	6710102	–
WFLK340/SK...	3	M14-M33	20	20	78	48	I	–	143	130	–
							Id. No.	–	6710041	6710042	–
WFLK340B/SK... ①	3	M14-M33	20	20	78	48	I	–	143	130	–
							Id. No.	–	6710115	6710116	–
WFLK445/SK...	4	M22-M48	22,5	22,5	96	60	I	–	157	144	127
							Id. No.	–	6710055	6710056	6709875
WFLK445B/SK... ①	4	M22-M48	22,5	22,5	96	60	I	–	157	144	127
							Id. No.	–	6710125	6710126	–

① = WFLK...B 不带轴承衬套

① = WFLK...B without ball cage sleeve

* SK40带Ott夹紧槽

* SK40 with Ott clamping groove

合适的快换攻丝夹头见第98–132页

Suitable quick change adaptors see page 98 – 132

DIN
2080

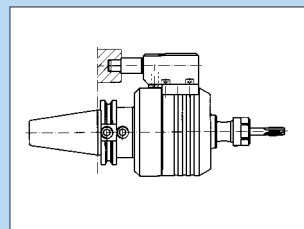
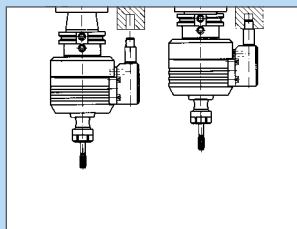
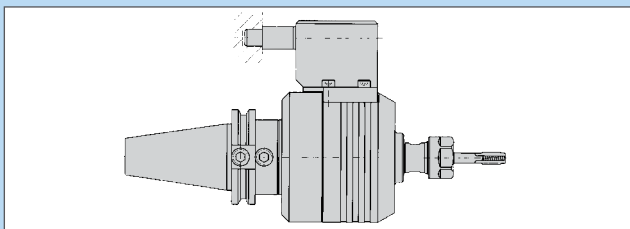


应用：攻丝，螺纹挤压

机器型号：加工中心，专用机床

Application: tapping, roll forming

Machine type: machining centres and special purpose machines



高性能攻丝装置带完整的反转齿轮

BILZ攻丝装置是模块化结构，因此可以按照机器的特殊要求进行匹配，它们可以用于带自动换刀装置的加工中心以及专用机器。

因为在GNCN和GNCK中有了内置式、免维护的转向齿轮，所以在转向时不需要更换机床主轴的方向。

拉伸长度补偿有一个球释放系统，当反转时，保证有60.15mm的螺纹深度及最高转速可达4000转。GNCK攻丝装置带冷却供给，能促使压力最高达到50bar。

精密筒夹确保丝锥被安全夹牢，额外的方尾驱动可用于加工时产生高扭矩的情况，如螺纹挤压。

扭矩支座的锁紧和主轴相关，因此自动换刀成为可能。当自动换刀时，锁紧系统松开扭矩支座实现自动换刀。

因为使用了反转齿轮，使提高攻丝速度成为可能，与常规攻丝相比循环时间显著缩短。

加长的主轴按需定制。

High performance tapping attachments with integrated reversing gear

BILZ tapping attachments are of modular design and can therefore meet the specific requirements of individual machines. They can be used on machining centres with automatic tool changers and on special purpose machines.

Because of the integrated maintenance free reversing gear, changes in direction of the machine spindle are unnecessary.

The length compensation on extension, with a ball release system which operates when in reverse, guarantees thread depths of $\pm 0,15$ mm up to a speed of 4000 rpm. The GNCK tapping unit with coolant feed, can facilitate pressures up to a maximum of 50 bar.

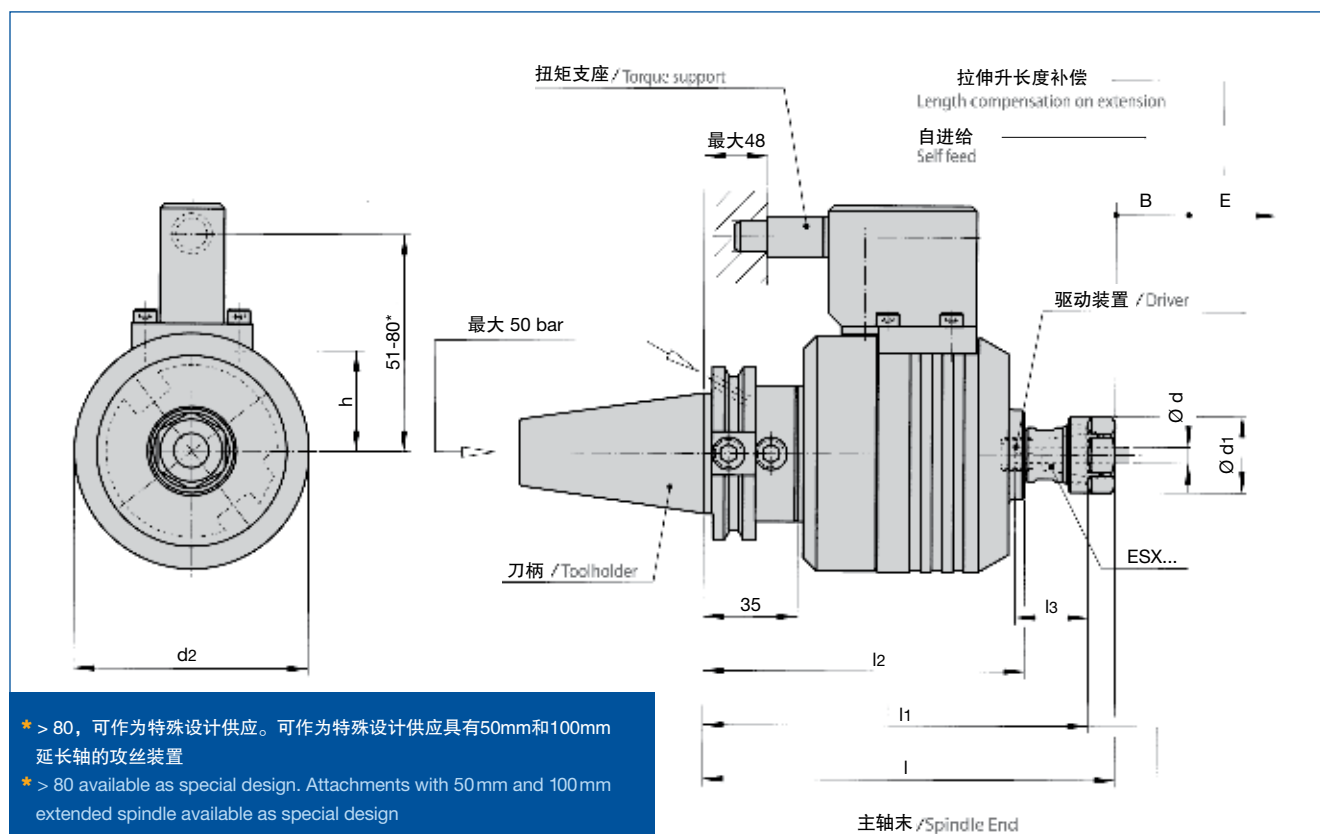
Precision collets ensure that the tap is securely clamped, and additional square drivers can be utilised where high torque is being generated, for example, when thread forming.

The torque support locks the unit relative to the spindle, thus making automatic tool changing possible. When tool changing takes place, the locking mechanism releases the torque support and allows the tool changing operation to be effected.

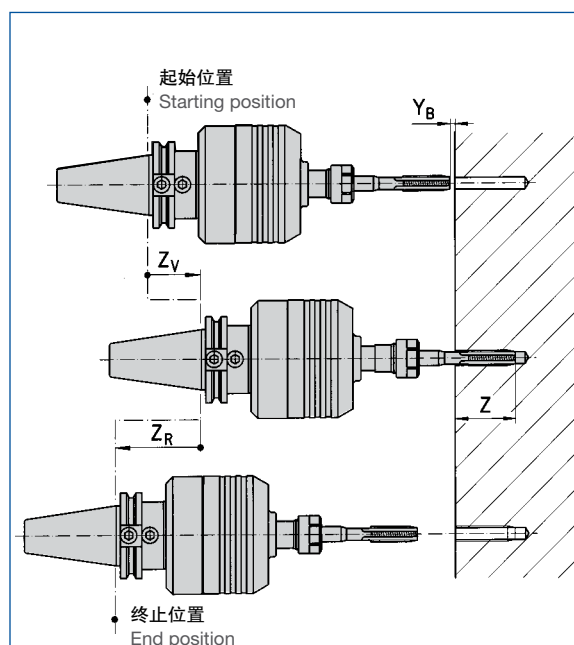
Because of the use of the reversing gears, high tapping speeds are possible resulting in significantly shorter cycle times compared to conventional tapping.

Extended spindles on request.

特点:	优势:	效益:
自反转齿轮	不需要机床主轴反转	- 最短的加工时间成为可能 - 每个螺纹最少可节约200–400毫秒 - 大大的减少了电能消耗
直接筒夹夹持	高同心度	更好的刀具寿命，减少了磨损，减少了不平衡量
在主轴驱动键和连接衬套里有阻尼单元	避免了过早的磨损	更少的维护
连接单元里使用了钢珠	准确的释放点	- 精确的螺纹深度 - 高重复精度
静水压力补偿用于带内冷的装置	拉伸时主轴轴向没有移动，即使冷却液被堵住。	没有碰撞和丝锥崩刃的风险
恒定的攻丝速度（通过嵌入式的反向齿轮）	理想的切削条件	长的刀具寿命
可换式驱动BN17...	丝锥和主轴驱动间正向的扭矩传输	丝锥在筒夹里不会扭转或者打滑
嵌入式的调节螺钉	丝锥可以按需调节长度	机床长度补偿没有输入错误（没有碰撞的风险）
密封的，稳定的止动臂	没有由于污染或者止动臂太多空隙造成的故障	- 减少了机床停机时间，预防碰撞 - 没有来自止动臂移位产生的损坏
Features:	Advantages:	Benefits:
self reversing gear	reversing of machine spindle not required	- shortest processing time possible - minimum time saving 200 – 400 ms per thread - substantially less electrical power consumption
direct collet location	high concentricity	- better life time of the tool, reduced wear, - less unbalanced mass
damping elements between drive key in the spindle and the coupling sleeve	avoiding premature wear	less maintenance intensive
balls used in the couplings elements	exact disengaging point	- exact thread depth - high repeat accuracy
hydrostatic pressure compensation for IC version	no axial movement of the spindle into tension, even when the coolant flow is blocked	no risk of collision through extended tool
constant tapping speed (through built-in reversing gear)	ideal cutting conditions	longer tool life time
exchangeable drivers BN17...	positive torque transmission of the tap and of the driver in the spindle	no twisting or slipping of the tap in the collet
built-in length adjustment screw	taps can be set to the required length	no input data error of tool length in machine offset (no risk of collision)
sealed, stable version of the stop arm	no malfunction due to contamination or through too much gap in the stop arm	- reduced down time of the machine, prevention of collision - no damage from displaced stop arm



- * > 80, 可作为特殊设计供应。可作为特殊设计供应具有50mm和100mm延长轴的攻丝装置
- * > 80 available as special design. Attachments with 50mm and 100mm extended spindle available as special design



- | | | |
|---------------------|----------|---------------------------|
| Z | = 攻丝深度 | Tapping depth |
| Z _V | = 轴提前 | Spindle advance |
| Z _R | = 轴返回 | Spindle return |
| Y _(A, B) | = 安全高度 | Safety margin |
| B | = 自进给 | Self feed |
| E | = 拉伸长度补偿 | Compensation on extension |

编程示例:

在已选择好安全距离Y_B的起始位置, 得出下列等式:

$$Z_V = Y_B + Z - 0,5 B$$

$$Z_R = Z + E + 0,5 B + 1$$

使用GNCN/GNCK在加工中心上进行攻丝操作, 在机床编程时应该考虑下列情况:

- 机床主轴没有转向变化, 因为反转通过GNCN/GNCK实现
- 进给 = 螺距的95%
- 没有延时时间
- 丝锥不同的切削槽型
- 自转速度
- 松开后的拉伸补偿

Programming example

At the starting position with a selected safety margin Y_B the following equations give:

$$Z_V = Y_B + Z - 0,5 B$$

$$Z_R = Z + E + 0,5 B + 1$$

For tapping operations on machining centres using GNCN/GNCK, the following should be taken into account when programming the machine:

- No change in direction of rotation of the machine spindle, as this is carried out by the GNCN/GNCK
- Feed = 95% of thread pitch
- No dwelling time
- Varying cutting geometry of the tap
- Self speed
- Compensation on extension after release

型号 Designation			$\varnothing d$	n_{max} min ⁻¹	P_{max} bar	B	E	d1	d2	h	l	l1	l2	l3
GNC6-MMS	ESX12	M3-M6	3-7	4000	10	4	6	19	70	27	–	–	106	13/21
GNC12-MMS	ESX16	M4-M12	3-10	2500	10	5	9	28	87	37	–	–	119	25/45
GNC20-MMS	ESX25	M12-M20	7,1-16	1500	10	8	10	42	100	45	187	175	142	29/42
GNCN6C-ESX12/	ESX12	M3-M6	3-7	4000	–	3,5	6,5	19	70	27	132	125	106	13/21
GNCK6C-ESX12/	ESX12	M3-M6	3-7	4000	50	3,5	6,5	19	70	27	132	125	106	13/21
GNCK6V-ESX12/	ESX12	M3-M6	3-7	4000	50	4	6,5	19	70	27	142	135	116	13/21
GNCN12C-ESX16/	ESX16	M4-M12	3-10	2500	–	5	9	28	87	37	153	143	119	25/45
GNCK12C-ESX16/	ESX16	M4-M12	3-10	2500	50	5	9	28	87	37	153	143	119	25/45
GNCK12V-ESX16/	ESX16	M4-M12	3-10	2500	50	5	9	28	87	37	172	162	138	25/45
GNCN20C-ESX25/	ESX25	M12-M20	7,1-16	1500	–	8	10	42	100	45	187	175	142	29/42
GNCK20C-ESX25/	ESX25	M12-M20	7,1-16	1500	50	8	10	42	100	45	187	175	142	29/42
重量 Weights														
单位 Unit GNCN/GNCK 6 C 约为 1,75 kg approx. 1,75 kg GNCN/GNCK 12 C 约为 3,10 kg approx. 3,10 kg GNCN/GNCK 20 C 约为 5,15 kg approx. 5,15 kg														
扭矩支座 Torque Support 约为0,5 – 1,0 kg, 具体取决于设计。 Depending on design approx. 0,5 – 1,0 kg														
柄部 Shank 约为0,8 – 3,0 kg, 具体取决于设计。 Depending on design approx. 0,8 – 3,0 kg														

询价时需提供:	For inquiries please add:
■ 机器制造商 ■ 机器型号 ■ 机器序列号 ■ 主轴位置/尺寸 ■ 带/不带冷却 ■ 螺纹尺寸	■ machine manufacturer ■ machine type ■ serial number machine ■ spindle location/size ■ with/without coolant ■ thread size

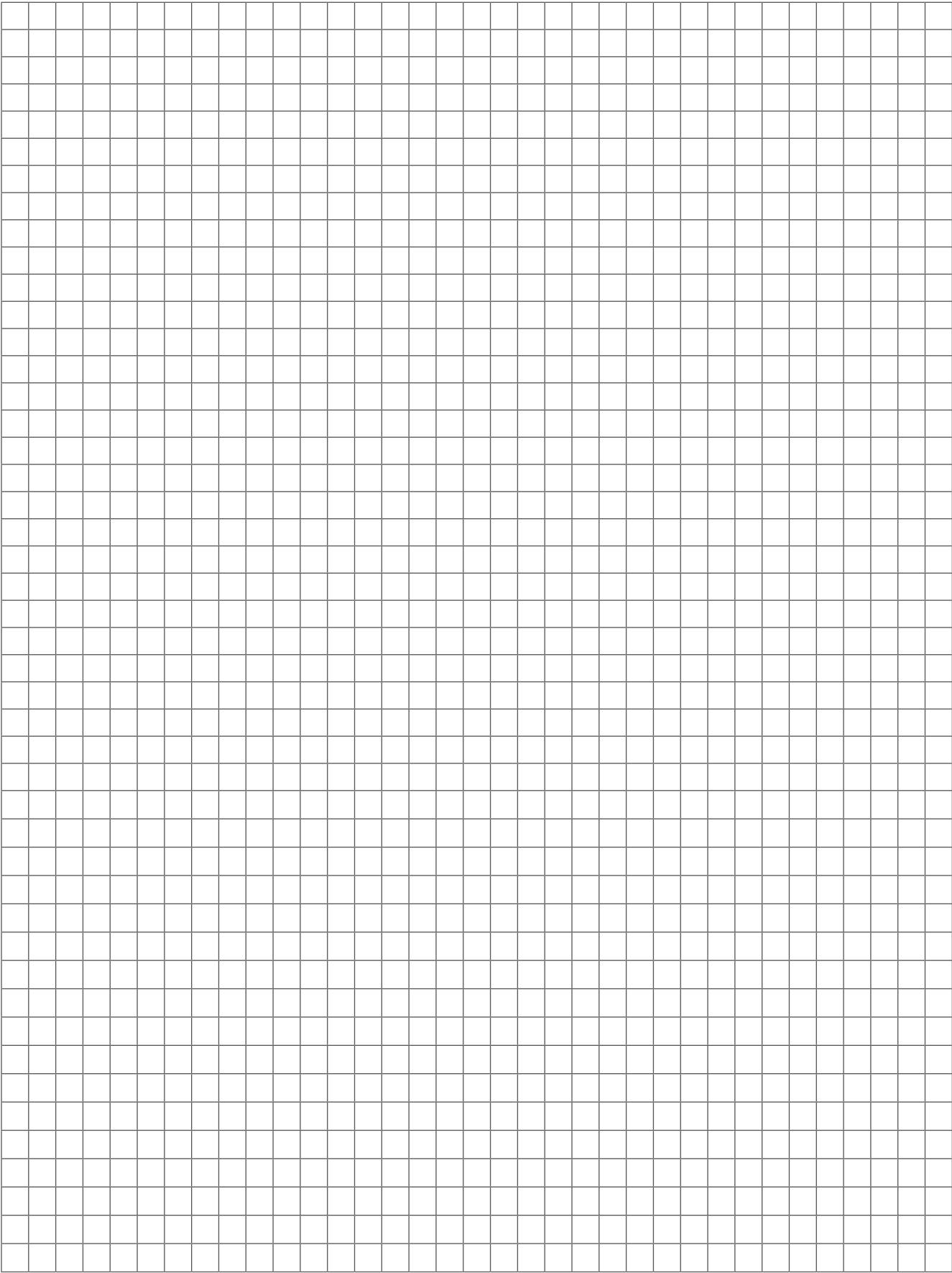
注意! 按照材料和加工过程必须选择合适的丝锥，并且必须遵守丝锥制造商推荐的切削速度!

Attention! The tap must be suitable for the material and the process.
 Please respect the recommended speed of the tap manufacturers!

合适的筒夹见第33页
 Suitable collets see page 33

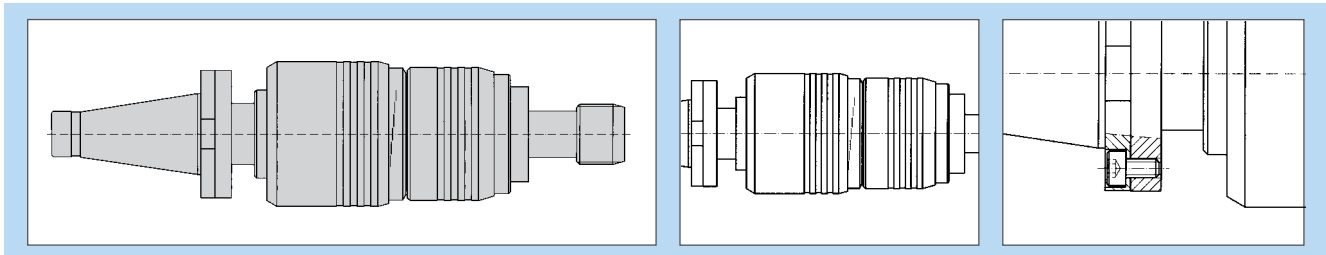
型号 Designation		驱动装置 Driver	方尾 Square	l ₃		 套装 Set
GNC6-MMS GNCN6C-ESX12 GNCK6C-ESX12	I	—	2,7 - 5	13 - 21	I	GNCK-ESX12
	Id. No.	—	—	—	Id. No.	6831955
	I	—	—	—	I	—
	Id. No.	—	—	—	Id. No.	—
	I	—	—	—	I	—
	Id. No.	—	—	—	Id. No.	—
GNC12-MMS GNCN12C-ESX16 GNCK12C-ESX16	I	BN1716-4	4	27	I	GNCK-ESX16
	Id. No.	6930574	—	—	Id. No.	6831954
	I	BN1716-4,5	4,5	28	I	—
	Id. No.	6930575	—	—	Id. No.	—
	I	BN1716-5	4,9 - 5	29	I	—
	Id. No.	6930576	—	—	Id. No.	—
	I	BN1716-5,6	5,5 - 5,6	29	I	—
	Id. No.	6930577	—	—	Id. No.	—
	I	BN1716-6,3	6,2 - 6,3	30	I	—
	Id. No.	6930578	—	—	Id. No.	—
	I	BN1716-6,5	6,5	30	I	—
	Id. No.	6930579	—	—	Id. No.	—
	I	BN1716-6,8	6,8	31	I	—
	Id. No.	6930581	—	—	Id. No.	—
GNC20-MMS GNCN20C-ESX25 GNCK20C-ESX25	I	—	<5	29	I	GNCK-ESX25
	Id. No.	—	—	—	Id. No.	6831956
	I	BN1725-5,6	5 - 5,6	35	I	—
	Id. No.	6943252	—	—	Id. No.	—
	I	BN1725-6,5	6,2 - 6,5	36	I	—
	Id. No.	6943253	—	—	Id. No.	—
	I	BN1725-7,1	7,1	38	I	—
	Id. No.	6941587	—	—	Id. No.	—
	I	BN1725-8	7 - 8	38	I	—
	Id. No.	6931467	—	—	Id. No.	—
	I	BN1725-9	8 - 9	40	I	—
	Id. No.	6943834	—	—	Id. No.	—
	I	BN1725-10	9 - 10	40	I	—
	Id. No.	6931468	—	—	Id. No.	—
	I	BN1725-11,2	11,2	42	I	—
	Id. No.	6943835	—	—	Id. No.	—
	I	BN1725-12	11 - 12	42	I	—
	Id. No.	6931469	—	—	Id. No.	—
						

套装包括：扳手，内六角
Set contents: wrench, allen key



应用： 机床、引擎、涡轮机和发电站工程设计中的大尺寸内螺纹的攻丝
机器型号： 制造中心、龙门铣削、钻削和特殊用途的机床

Application: tapping of big internal threads in machine, engine, turbine and power station engineering
Machine type: manufacturing centres, portal milling, drilling and special purpose machines



攻丝夹头和刀柄用于生产较大的螺纹

WFSL攻丝系统用于涡轮和反应堆工业所必需的大尺寸螺纹的生产。

WFSL攻丝系统可以用在手动和数控机床上。

刀柄中可换式的凸缘安装座机构确保适合各种各样的主轴类型，并且带长度补偿。快换夹头上的可调节的安全夹紧装置确保了即使是最困难的加工条件下也能高效、准确的攻丝。这种攻丝系统也可带冷却液供给。

这种攻丝系统设计了用单支丝锥攻丝或者成套丝锥攻丝。

当使用成套丝锥攻丝时，使用成套丝锥中的第一支最初产生最狭窄的螺纹。攻成的最初的螺纹形状，已经锁住了快换夹头，因此必须手动旋入，防止2次攻丝。当用主轴顺着快换夹头能自动啮合，然后最终的攻丝才能进行。

还可供应具备内部冷却液供给的攻丝刀柄和夹头。

Tapping chucks and adaptors for the production of larger threads

The WFSL tapping system is used for the production of larger size threads as required in the turbine and reactor industries.

The system can be used on both manual or numerically controlled machines.

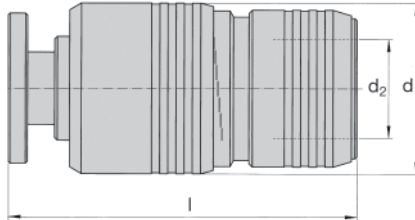
The interchangeable flange mounting configuration of the chucks ensures the adaptability to a variety of machine spindle types. Also the length compensation on the chucks, plus the adjustable safety clutch on the adaptors, ensure effective and accurate tapping under the most difficult conditions. In addition to this, the system is designed for rapid and easy adaptor change. The system is also available with coolant feed.

The system is designed to accommodate tapping both with a single tap or series taps.

When tapping with series taps, a narrow thread is produced initially, using the first of the series taps. Prior to the tapping of the full thread form, the plug tap, already locked into the adaptor, must be engaged by hand into the thread in order to prevent double threading. When engaged the spindle drives with rotation against the adaptor which clutches in automatically, then the final tapping can take place.

Tapping chucks and adaptors are also available with internal coolant feed.

特点:	优势:	效益:
■ 具备丝锥夹头快换机制	■ 刀具快换	■ 减少了机床停机时间 ■ 生产率更高
■ 刀柄中具备可调节安全夹紧装置	■ 无需带安全夹紧装置的快换夹头	■ 系统成本降低
■ 模块化柄部系统	■ 可以更灵活的改变位置，刀柄可以用在不同的机床上	■ 刀具库存更低 ■ 成本降低
■ 拉伸和压缩长度补偿	■ 丝锥螺距和机床供给之间的螺距差补偿	■ 即使在困难条件下，也可保证螺纹攻丝处于公差范围内且质量良好
■ 可调节长度补偿	■ 可以根据制造工艺的要求调节	■ 高度灵活性
■ 滚珠导套	■ 即使在高扭矩时也能进行平稳的长度补偿	■ 即使在困难条件下，也可保证螺纹攻丝处于公差范围内且质量良好
■ 夹头自动连接 (一组丝锥，例如管用丝锥)	■ 可以手动拧入一组丝锥，并在丝锥柄部接触到夹头时自动锁定	■ 可以使用成组丝锥 ■ 易于装卸
Features:	Advantages:	Benefits:
■ quick change mechanism for tap adaptors	■ quick tool change	■ reduction of machine down time ■ higher productivity
■ adjustable safety clutch in the chuck	■ no quick change adaptors with safety clutch required	■ cost reduction for the system
■ modular shank system	■ more flexibility by changing the location, chuck can be used on different machines	■ smaller number of tools in stock ■ reduced cost
■ length compensation on tension and compression	■ compensation of pitch differences between tap pitch and feed of the machine	■ tapping of threads in tolerance and good quality even under difficult conditions
■ adjustable length compensation	■ can be adjusted acc. to the manufacturing process requirement	■ high flexibility
■ ball cage sleeve	■ smooth length compensation even under high torque	■ tapping of threads in tolerance and good quality even under difficult conditions
■ automatic coupling of the adaptors (set of taps e.g. pipe taps)	■ set of taps can be screwed in by hand and will be engaged automatically when the chuck contacts the adaptor	■ application of tap sets possible ■ easy handling



WFSL

型号/订货号 Designation/Id. No.	 WEK		max.* Nm			d	d2	l	 50 bar
WFSL60 6709939	60	M30–M120*	1400	20	20	125	72	257	
WFSL60-IK 6709942	60-IK								X
WFSL60/A4 6709940	60		1800						
WFSL60-IK/A4 6709943	60-IK								
WFSL100 6709945	100	M48–M200*	2400			156	92	323	
WFSL100-IK 6709947	100-IK				X				
WFSL100/A4 6709946	100		3000						

长度补偿设置可以拉伸0mm/压缩40mm，也可以拉伸40mm/压缩0mm。出厂设置为拉伸20mm/压缩20mm。

请参见第78 – 81页了解关于调节的信息

Length compensation adjustable from tension 0 mm /compression 40 mm bzw. tension 40 mm /compression 0 mm.

Setting from factory tension 20 mm /compression 20 mm.

Adjustment see page 78 – 81

关于合适的快换夹头，请参见第77页

Suitable quick change adaptors see page 77

- * 刀柄选择:
- 最大的螺纹尺寸/节距
 - 在第82 – 84页的章节中可以检查扭矩
 - 或者使用扭矩公式来计算
 - 然后选择刀柄

- * Chuck selection:
- max. thread size/pitch
 - check torque in chart page 82 – 84
 - or use formula “torque” for calculation
 - then choose chuck

举例 Example

→ 根据第83页的图标 acc. chart page 83

M 76 x 6 = 1915 Nm

针对于抗拉强度达到1000 N/mm² for material up to 1000 N/mm²

= **WFSL 100 ...** 是满足要求的 required

→ 根据第84页的图标 acc. formula page 84

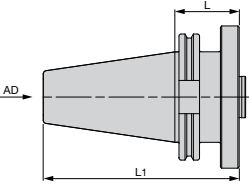
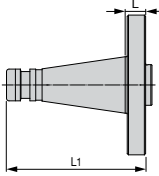
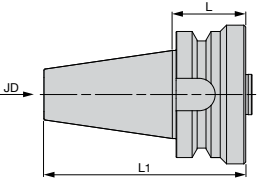
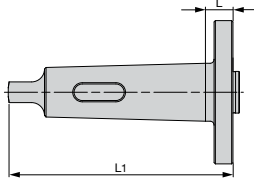
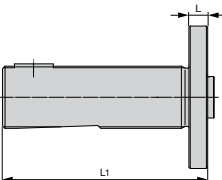
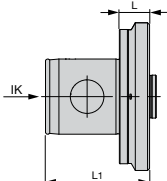
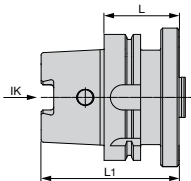
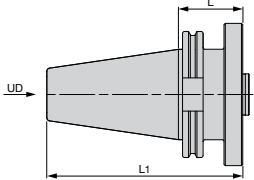
M 76 x 6 是针对材料6620，抗拉强度1600的 for material **6620**, **k_C = 1600**

M_D = $\frac{1600 \times 6^2 \times 76}{8000} \times 2 = 1094$ Nm für for **6620**

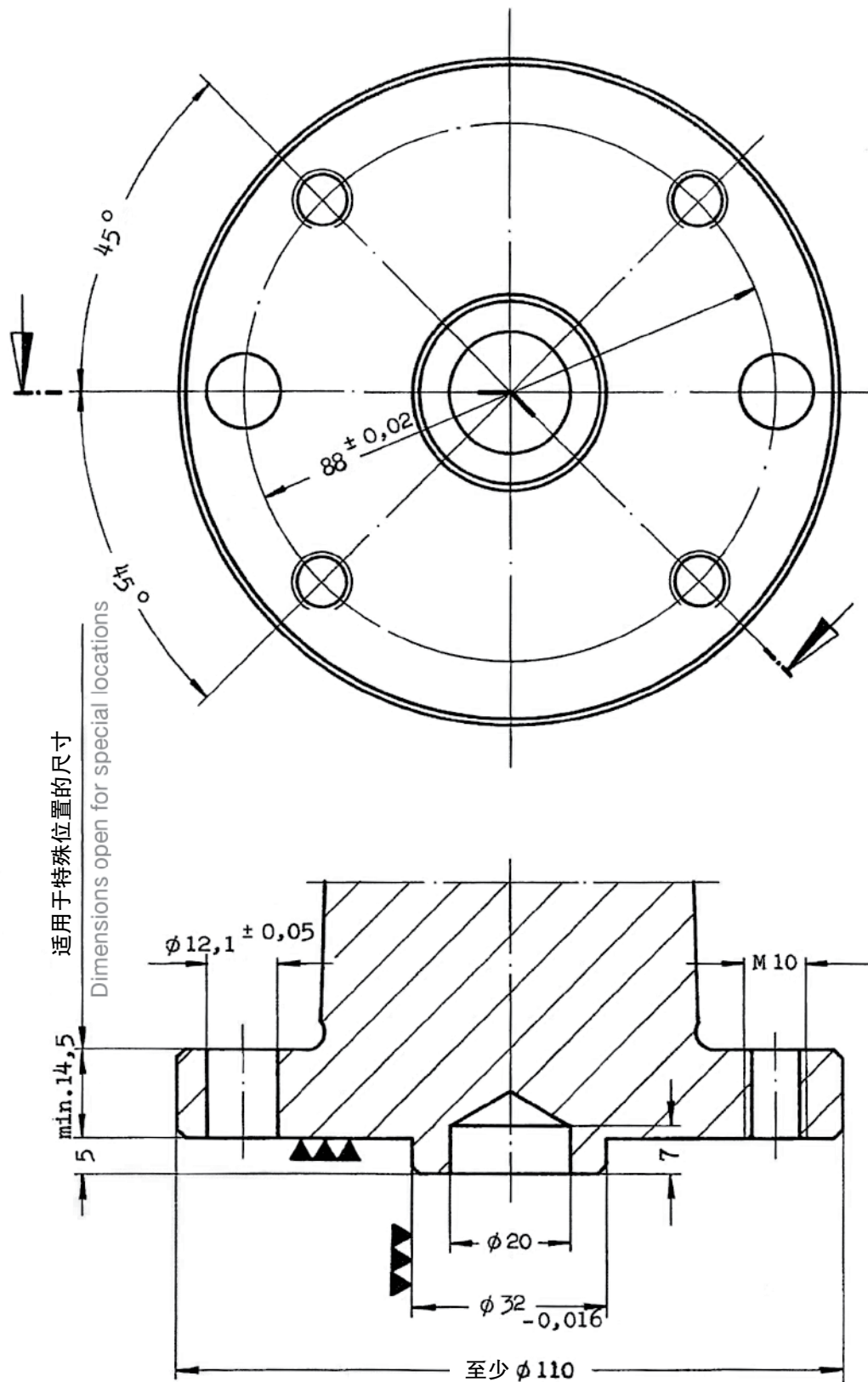
= **WFSL 60 ...** 是满足要求的 adequate

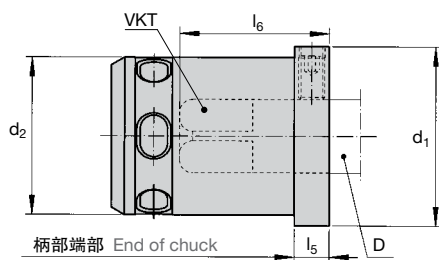
WFSL619 — 用于WFSL攻丝刀柄的柄部
WFSL619 – Shanks for WFSL tapping chucks



	型号/订货号 Designation/Id. No.	L1 (mm)	L (mm)	刀柄完整的描述 Complete Description chuck/location 订货号 Id. No.	
	DIN ISO 7388-1				
	WFSL619/A126/SK40 6709965	118,5	49,6		
	WFSL619/A126/SK50 6709958	152,5	50,75	WFSL60/A126/SK50 9078838	
	WFSL619/A126/SK60 5017160	181,9	19,1		
	DIN 2080				
	WFSL619/SK40 6930547	109,5	15,6	WFSL60/SK40 6708984	
	WFSL619/SK50 6930846	144,5	17,2	WFSL60/SK50 6708985	WFSL100/SK50 6708990
	WFSL619/SK60 6709952	217,0	18,0	WFSL60/SK60 6708986	WFSL100/SK60 6708991
	DIN ISO 7388-2				
	WFSL619/A73/SK50 6709961	160,0	58,0	WFSL60/BT50 5042300	
	DIN 228 B				
	WFSL619/MK5 6709948	172,5	23,0	WFSL60/MK5 6708987	WFSL100/MK5 6708992
	WFSL619/MK6 6709949	235,0	25,0	WFSL60/MK6 6708988	WFSL100/MK6 6708993
	DIN 6327				
	WFSL619/TR48-BG 6709962	158,5	14,5		
	KOMET ABS				
	WFSL619/ABS100-BG 5002493	77,5	22,5		
	WFSL619/ABS125 6955004	102,5	32,5		
	DIN 69893, HSK				
	WFSL619-IK/HSK-A100-BG 6709964	109,5	59,5		WFSL100/HSK-A100 5022725
	DIN ISO 7388-1				
	WFSL619/CAT50 5042307	152,5	50,75	WFSL60/CAT50 5042302	

材料: Material: 16Mn Cr 5
表面硬化: case hardened: 1mm





WEK/WEK ... IK			
型号 Designation		WEK60	WEK100
WEK适合WFSL柄部类型 用螺纹销夹紧丝锥 WEK suitable for chuck types WFSL Tap clamped by thread pin		M30-M120 x 4	M48-M200 x 3
		WFSL 60	WFSL 100
	d1	82	110
	d2	72	92
	l5	16	24
	l6	D > 32 mm 88 D < 32 mm 76	D > 36 mm 115 D < 36 mm 107

用于符合DIN标准的丝锥

For taps according to DIN

型号 Designation	订货号 Id. No.	l6	DIN	型号 Designation	订货号 Id. No.	l6
WEK60-22 x 18	9157267	76	M30	—	—	—
WEK60-22 x 18	5028424	76	M30	—	—	—
WEK60-25 x 20	9157268	76	M33	—	—	—
WEK60-28 x 22	6721599	76	M36	—	—	—
WEK60-32 x 24	9157269	76	M39	—	—	—
WEK60-36 x 29	6721598	88	M45 / M48	WEK100-36 x 29	9157270	107
WEK60-40 x 32	6721575	88	M52	WEK100-40 x 32	9157263	107
WEK60-40 x 32	6721600	88	M52	—	—	—
WEK60-45 x 35	6721576	88	M56	WEK100-45 x 35	6721641	107
WEK60-45 x 35	6721601	88	M56	—	—	—
WEK60-50 x 39	6721578	88	M64	WEK100-50 x 39	6721640	115
WEK60-50 x 39	6721602	88	M64	—	—	—
WEK60-56 x 44	6721580	88	M68	WEK100-56 x 44	6721642	115

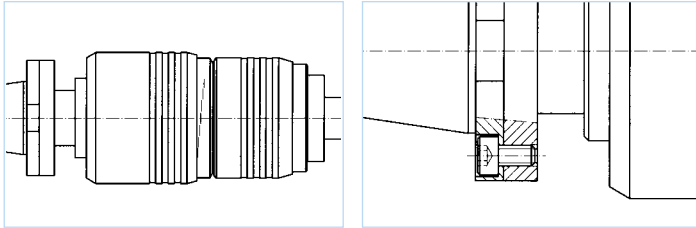
用于符合ISO标准的丝锥

For taps according to ISO

型号 Designation	订货号 Id. No.	l6	ISO	型号 Designation	订货号 Id. No.	l6
WEK60-22,4 x 18	—	76	M33	—	—	—
WEK60-25 x 20	9157268	76	M36	—	—	—
WEK60-28 x 22,4	—	76	M39-M42	—	—	—
WEK60-31,5 x 25	—	76	M45-M48	WEK100-31,5 x 25	—	102
WEK60-35,5 x 28	—	88	M52-M56	WEK100-35,5 x 28	—	107
WEK60-40 x 31,5	6721574	88	M60-M64	WEK100-40 x 31,5	—	107
WEK60-45 x 35,5	6721577	88	M68-M75	WEK100-45 x 35,5	—	107
WEK60-50 x 40	6721579	88	M76/M80-M90	WEK100-50 x 40	—	115
WEK60-56 x 45	6721581	88	M92-M100	WEK100-56 x 45	6721643	115

安装和操作说明

WFSL快换攻丝刀柄结合WEK等类型的快换攻丝夹头



应用范围与领域

用于大型引擎、涡轮机、反应器和设备制造中大尺寸内螺纹的攻丝和螺纹挤压用在机械或数字控制的机床上，例如龙门铣削和摇臂钻床或坐标镗床。

我们非常高兴您决定购买BILZ的产品。

本手册将描述该产品的正确使用和装卸。在使用之前务必仔细阅读说明书，并且只能以BILZ规定的方式使用该产品。

安装说明

保持机床主轴中刀柄位置的清洁。

在更换刀具时应握紧刀具，以便在释放刀具时，刀具不会坠入机床内部并损坏刀具和/或工件。

请记录刀具尺寸和机床制造商。

WFSL-柄部采用模块化设计，通过改变位置可以与所有标准后端（DIN69871、MAS-BT、ANSI-CAT、ABS、SK-DIN2080、TR-DIN6327、MK-DIN228A、HSK-DIN69893）进行组合，因此，可以将它们用在具有不同主轴位置的不同类型的机床上。

关于特定于客户的主轴设计、具有内部冷却液供应或用于更大扭矩的柄部，请联系BILZ技术服务部门。

长度补偿可以在压缩0 mm /拉伸40 mm或压缩40 mm /拉伸0 mm的范围内进行调节。标准设置为压缩20 mm/拉伸20 mm。如需调节长度补偿，请使用6mm的六角扳手旋入或旋出快换装置中心的内六角螺钉，但是只能到看到红色环时为止。（参见图片）



重要信息！

为防止财产损失或人身伤害，请严格按照说明进行操作。

只可在主轴停止时更换刀具！

请勿拆解产品，并且不得进行任何改装。这可能导致产品损坏和功能故障！

只可使用BILZ提供的攻丝柄部和夹头。与其他产品结合使用可能导致产品损坏或功能故障！

攻丝柄部为免维护产品，如发生任何故障，请勿继续使用该产品。请联系BILZ技术服务部门。

Reinigung:

In periodischen Abständen empfehlen wir die Futter mit einem Handlappen zu reinigen. Dies ist abhängig vom Verschmutzungsgrad. Keine aggressiven Lösungsmittel verwenden.

Keine fasernden Materialien wie z.B. Putzwolle verwenden.

Ausserbetriebnahme:

Wird das Futter außer Betrieb genommen ist folgendes zu beachten.

Futter mit einem Handlappen reinigen.

Futter mit einem Konservierungsschutzöl einsprühen oder einreiben, um die Bildung von Rost zu vermeiden und die Leichtgängigkeit des Futters zu bewahren. Vor dem Einlagern sollten Bearbeitungsrückstände sowie Kühlmittel beseitigt sein.

Benutzen Sie das Produkt nur für die von BILZ empfohlene Anwendung.

Bei Fragen wenden sie sich bitte an BILZ. www.bilz.de

BILZ Werkzeugfabrik GmbH & Co. KG,
73760 Ostfildern, Vogelsangstr. 8
Tel: +49 711 34801 0; E-Mail: info@bilz.de

操作说明

如需释放夹头，必须向前拉动弹簧加载的切换套筒。它将自动保持在此位置。如需进行连接，只需将夹头插入柄部的快换装置（图1 + 2）并转动（图3），随后它将被自动锁定。



图1



图2



图3

调节安全夹紧装置



旋出螺钉



调节扭矩



重新旋入螺钉

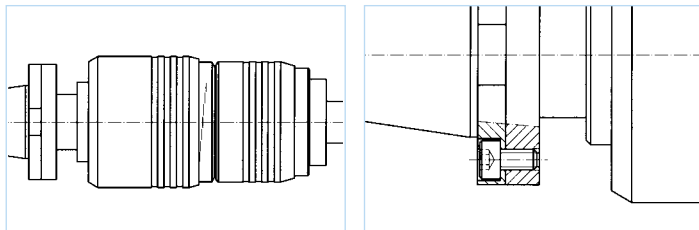
为使生成的螺纹处于容差范围内且质量良好，应将机床供给调节至小于丝锥螺距不超过5%。

主轴停止后的超程不得大于可用拉伸补偿，否则刀具将发生过载断裂。（这在旧式和/或大型机床上时有发生）。

反转主轴，过载保护重置，丝锥退出。

Installation and operating instructions

WFSL quick change tapping chucks in combination with quick change tapping adaptors type WEK...



Scope and areas of application

For tapping and roll forming of big internal threads in large engines, turbine, reactor and plant construction. On mechanical or numerically controlled machines e.g. Portal milling and radial drilling machines or jig boring machines

We are pleased that you have decided to purchase a BILZ product. This manual describes the proper use and handling of the product.

Read the instructions carefully before use and use the product only in the manner specified by us.

Installation Instructions

Keep the tool holder location in the machine spindle clean.

Hold the tool securely when changing tools, so when releasing the tool, the tool does not fall into the machine interior and damage the tool and/or work piece.

Note the tool dimensions and the machine manufacturer.

WFSL-chucks have a modular design and by changing the location can be combined with all standard back ends (DIN69871, MAS-BT, ANSI-CAT, ABS, SK-DIN2080, TR-DIN6327, MK-DIN228A, HSK-DIN69893) therefore they can be used on different kinds of machines with different spindle locations.

For customer-specific spindle designs, chucks with internal coolant supply or for higher torque, please contact BILZ Technical Service.

The length compensation is adjustable within the range of tension 0 mm / compression 40 mm bzw. tension 40 mm / compression 0 mm. Setting from factory tension 20 mm / compression 20 mm. To adjust the length compensation, turn in or out the screw with the internal hexagon in the centre of the quick change feature with a 6mm hexagon key, but only until you can see the red ring. (see pictures)



Important information!

To prevent damage or injury, please follow the instructions exactly.

Tool change only with standing spindle!

Do not disassemble the products and do not make any modifications. This may result in damage and malfunction!

Use only BILZ tapping chucks and adaptors.

The combination with other products may cause damage or malfunction!

The tapping chucks are maintenance-free, should there be any faults, please use do not continue using the products. Please contact the BILZ Technical Service.

Cleaning:

We recommend periodically cleaning the chucks with a cleaning rag. This depends on the degree of contamination. Do not use aggressive solvent. Do not use fibrous materials like such as cleaning wool

Out of operation:

If the chuck is taken out of operation, proceed as follows: Clean the chuck with a cleaning rag.

Spray or rub the chuck with a preservation oil to prevent the formation of rust and preserve the smoothness of the chuck. Prior to storage, coolant and processing residues should be removed.

Use the product only for the BILZ recommended application.

If you have any questions please contact BILZ. www.bilz.de
BILZ Werkzeugfabrik GmbH & Co. KG,
73760 Ostfildern, Vogelsangstr. 8
Fon: +49 711 34801 0; Mail: info@bilz.de

Operating Instructions

To release the adaptor, the spring loaded switching sleeve must be pulled forward. It will be automatically held in this position. For coupling the adaptor simply insert it into the quick change feature of the chuck (Picture 1 + 2), turn (Picture 3) and then it will be locked automatically.



Picture 1



Picture 2



Picture 3

Adjusting safety clutch



turn out screw



adjust torque

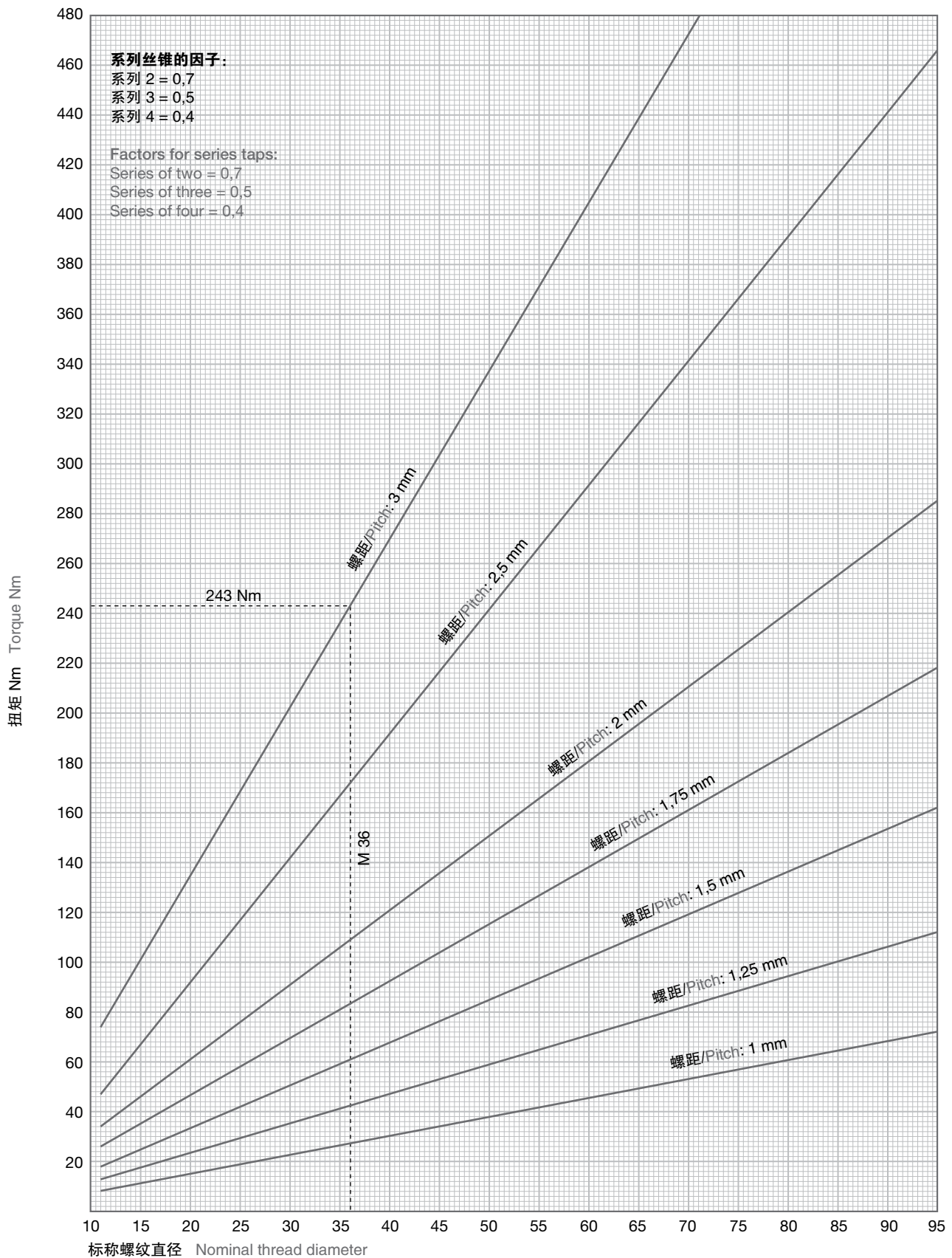


turn in screw again

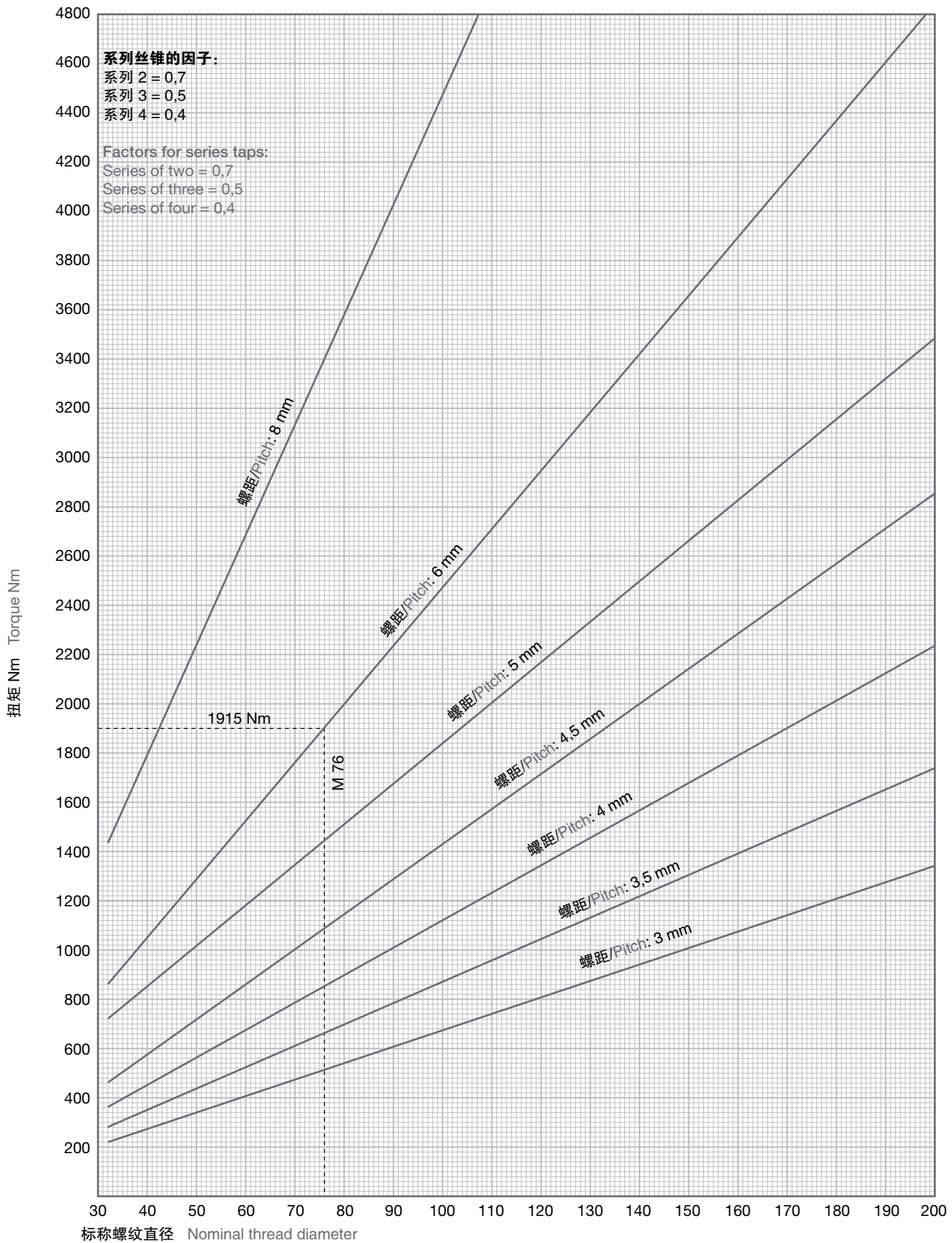
The machine feed should be up to 5% smaller than the pitch of the tap to produce threads in tolerance and good quality.

After spindle stop the over run must not be greater than the available tension compensation otherwise overload breakages of the tools will occur. (this sometimes happens with old and/or large machines).

Reversing the spindle resets the clutch and screws the tap out.



对于抗拉强度高达1000 N/mm² 的材料
 For materials with a tensile strength of up to 1000 N/mm²



对于抗拉强度高达1000 N/mm² 的材料
For materials with a tensile strength of up to 1000 N/mm²

扭矩 — 攻丝功耗计算

Torque – Power consumption calculation tapping

适用于 for: **M, MF, MJ, UNC, UNF, UNEF, UN, G, Rp, NPSM, BSW, W zyl.**

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扭矩 Torque	$M_D = \frac{k_c \cdot h^2 \cdot d_1}{8000} \times 2$	Nm	$k_c \dots$ 切削力 Cutting force (N/mm²) (图表 chart) $h \dots$ 螺距 Thread pitch (mm) $d_1 \dots$ 螺纹尺寸 –Ø Thread size-Ø (mm) 2 Stumpfungszuschlag Gewindebohrer Factor Wornout taps
丝锥的功耗 Power consumption at tap	$P = \frac{M_D \cdot n}{9500}$	kW	$n \dots$ 转数 number of revolutions (Umdr./Minute rpm)
机床驱动功率 Machine drive power	$P_M = \frac{P}{\pi_M}$	kW	$P_M \dots$ 所需机床驱动功率 required machine drive power $\pi_M \dots$ 机床效率 $\pi_M < 1$ machine efficiency $\pi_M < 1$

材料 Material	k_c - 值 Value N/mm²)
钢 Steel 1000 – 1300N/mm²	3200
钢 Steel 800 – 1000N/mm²	2600
钢 Steel 600 – 850N/mm²	2500
钢 Steel < 600N/mm²	2300
不锈钢 Stainless steel	3200
铸造青铜 Cast bronze	1900
GG-20 (HB 170)	1600
GTW 硬质 GTW hard	1250
铜 Copper	1100
GTW 软质 GTW soft	900
黄铜 Brass	720
Al-Si 合金 Al-Sialloy	680
锌合金 Zince alloy	440

计算示例:

螺纹: M36; 螺距: 4 mm,
待加工材料:
钢 900 N/mm²,
速度: 50 rpm
机床效率 π_M

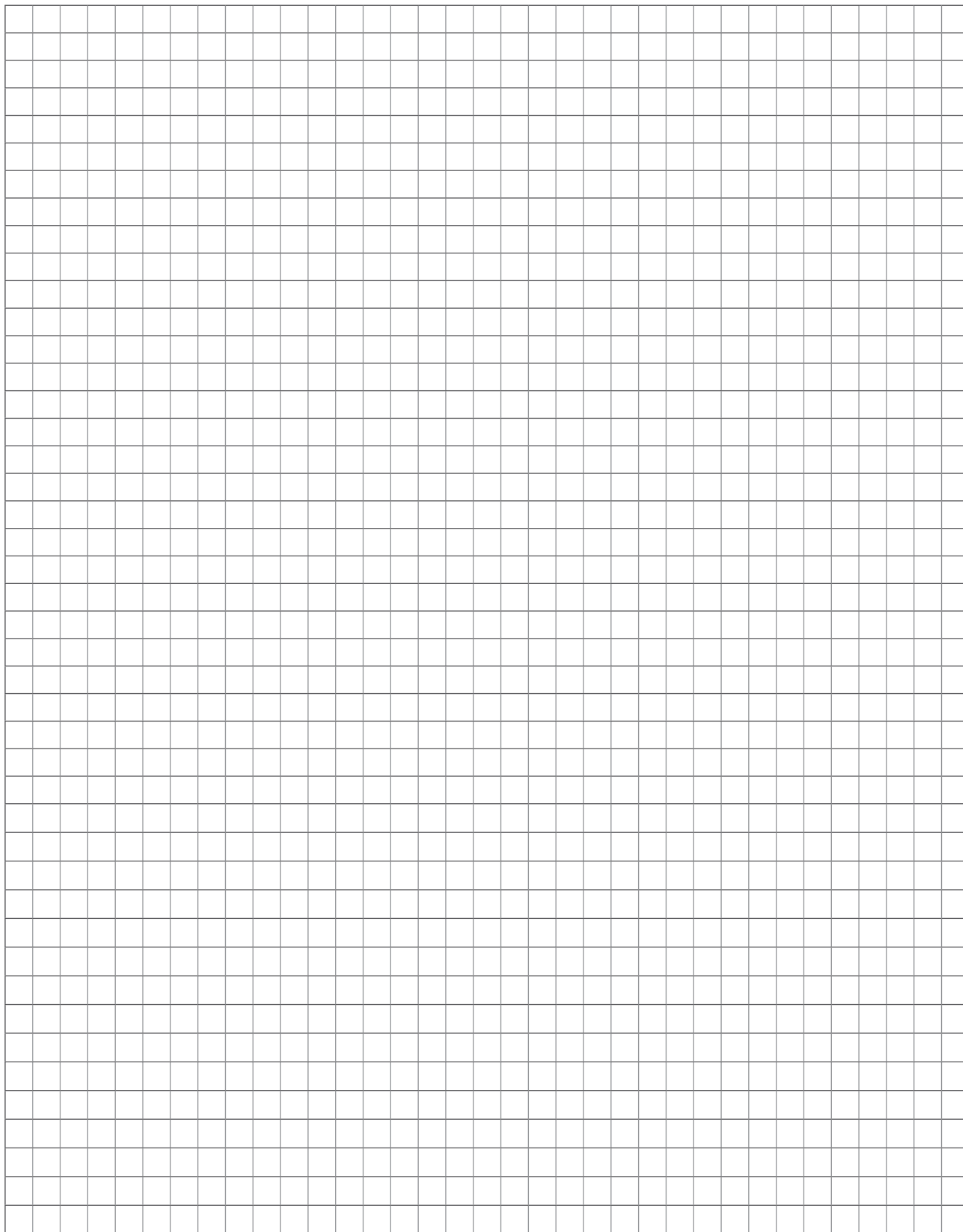
Calculation example:

Thread M36, Pitch 4 mm,
Material to be processed:
Steel 900 N/mm²,
Speed: 50 rpm
Machine efficiency π_M

扭矩 Torque	$M_D = \frac{k_c \cdot h^2 \cdot d_1}{8000}$	$= \frac{2600 \cdot 4^2 \cdot 36}{8000}$	= 187 Nm
丝锥的功耗 Power consumption at tap	$P = \frac{M_D \cdot n}{9500}$	$= \frac{187 \cdot 50}{9500}$	= 0,98 kW
机床驱动功率 Machine drive power	$P_M = \frac{P}{\pi_M}$	$= \frac{0,98}{0,6}$	= 1,6 kW

上述计算对新丝锥有效。对于磨损的丝锥，扭矩可能高出多达3倍，同样的原因会成比例的增加所需机床的驱动功率。

The above calculation is valid for new taps. For worn out taps the torque could be up to 3 times higher, which increases the required machine drive power by the same factor



WF – WFLP

快换攻丝刀柄 Quick Change Tapping Chuck

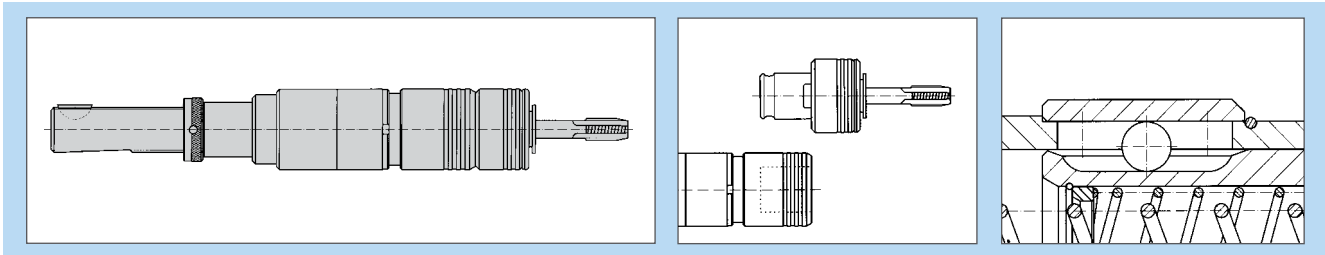
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应用：攻丝，螺纹挤压

机器型号：生产线，多主轴机床和专机

Application: tapping, roll forming

Machine type: transfer lines, multispindle heads and special purpose machines



在流水线和专机上攻丝和螺纹挤压。

BILZ WFLP-WF刀柄是为多主轴攻丝应用而设计的，与WES-WE快换夹头结合使用，也提供冷却液供给。这套系统也为快换夹头快速容易更换而设计，快换夹头能自动的插入到快换刀柄中。

拉伸和压缩的长度补偿允许主轴供给和螺距之间存在任何波动，因此可使用变化的螺距进行多轴攻丝，而无需平衡转数和供给速率。

可以根据各种各样的需要选择伸缩比，自动定心浮动仅在主轴轴向和工件的孔之间大于0.2mm误差时响应。

WFLP-WF刀柄可以根据需要提供内冷供给。

Tapping and thread forming on transfer lines and special purpose machines

BILZ WFLP-WF chucks are designed for multi-spindle tapping applications and are used in conjunction with the WES-WE adaptors. The system is designed for rapid and easy adaptor change, which are automatically locked by insertion into the chuck.

The length compensation on extension and compression allows any fluctuations which may occur between the spindle feed and the thread pitch, so that multi-spindle tapping with varying pitches is possible, without the need to balance revolutions and feed rates.

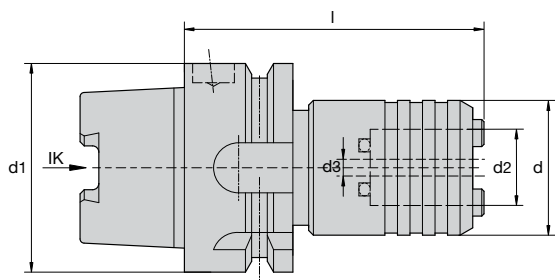
The ratio of compression and extension can be chosen to suit varying requirements. The self centring float mechanism only responds when any misalignment is > 0,2 mm, between the machine spindle axis and core holes in the component.

WFLP-WF chucks with internal coolant feed are available on request.

特点:	优势:	效益:
快换机构用于攻丝夹头	快速换刀	- 减少机床停机时间 - 更高的生产效率
根据需求，长度拉伸或者压缩补偿	补偿丝锥螺距和机床进给间螺距误差	即使在困难工况下也保证攻丝在螺纹公差内和好的螺纹质量
带强壮弹簧的压缩	在攻丝起始状态不会进入压缩	攻丝深度可以按照程序设定实现
细长设计	特别适合主轴间距离小的情况	孔间距小的情况成为可能，需要更少的多主轴机床
径向浮动机构（WFP，WFLP）	用于补偿工件上机床主轴和预钻孔之间的偏差	好的螺纹质量
珠导向长度补偿	光顺的长度补偿	好的螺纹质量
Features:	Advantages:	Benefits:
quick change mechanism for tap adaptors	quick tool change	- reduction of machine down time - higher productivity
length compensation on tension and/or compression, acc. to the requirements	compensation of pitch differences between tap pitch and feed of the machine	tapping of threads in tolerance and good quality even under difficult conditions
compression with strong spring	not getting into compression while starting the tapping operation	tapping depth is realised as programmed
slim design	specially for close centre distance	realisation of close centre distance, fewer multispindle heads necessary
radial floating mechanism (WFP, WFLP)	to compensate misalignment/offset between machine spindle and the drill hole in the component	good thread quality
ball guided length compensation	smooth length compensation	good thread quality

WF — 快换攻丝刀柄带内冷供给

WF – Quick change tapping chucks with internal coolant feed



DIN
69893

50 bar

WF...IKP/HSK-A...

型号 Designation	订货号 Id. No.			d	d1	d2	d3	l
WF0-IKP/HSK-A50	—	0	M1-M10*	23	50	13	3	59
WF1-IKP/HSK-A40	5065100	1	M3-M12	32	40	19	4	65
WF1-IKP/HSK-A50	—	1	M3-M12	32	50	19	4	68
WF1-IKP/HSK-A63	6708921	1	M3-M12	32	63	19	4	68
WF1-IKP/HSK-A100	—	1	M3-M12	32	100	19	4	75
WF2-IKP/HSK-A50	—	2	M8-M 20	50	50	31	6	97
WF2-IKP/HSK-A63	6708922	2	M8-M 20	50	63	31	6	90
WF2-IKP/HSK-A100	5048828	2	M8-M 20	50	100	31	6	97
WF3-IKP/HSK-A63	9204793	3	M14-M 33	72	63	48	6	125
WF3-IKP/HSK-A100	6708566	3	M14-M 33	72	100	48	6	130

DIN
69893

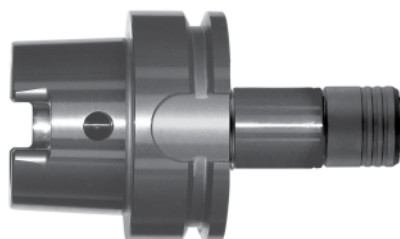
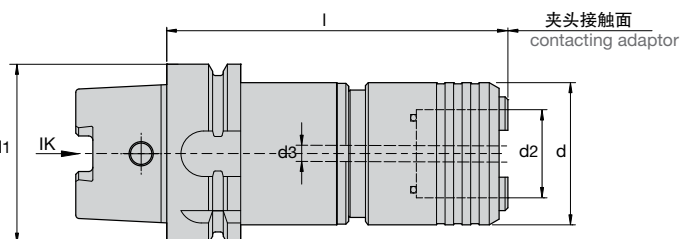
带径向平行浮动
with radial parallel float

20 bar

WFP...IKP/HSK-A...

带径向平行浮动
with radial parallel float

型号 Designation	订货号 Id. No.				d	d1	d2	d3	l
WFP1-IKP/HSK-A63	6708380	1	M3-M12	0,5	32	63	19	6	90
WFP2-IKP/HSK-A63	9073903	2	M8-M 20	1	50	63	31	6	120



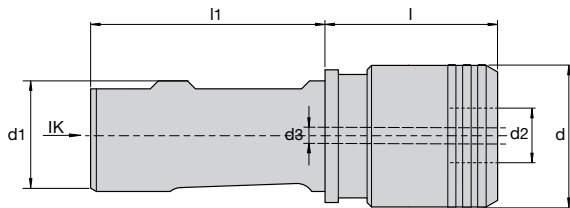
* > M6仅用于轻载加工 (最大.5Nm)

* > M6 for light machining only (max. 5 Nm)

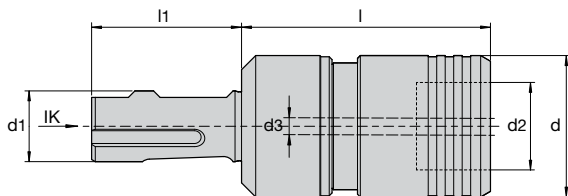
合适的快换夹头见第98–117页

Suitable quick change adaptors see page 98 – 117

WF – Quick change tapping chucks with internal coolant feed

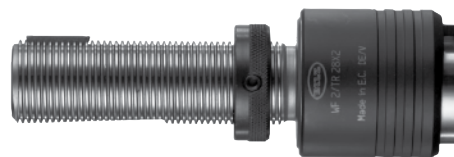
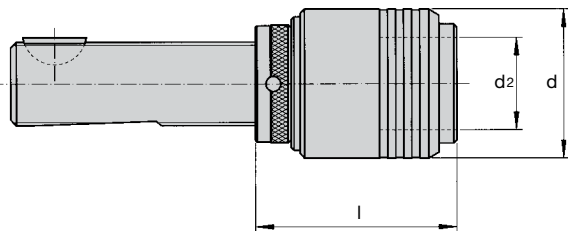


型号/订货号 Designation/Id.No.			d	d1	d2	d3	l	l1
WF0-KP/MS16 6708871	0	M1-M10★	23	16	13	2,5	33	48
WF1-KP/MS25 6708872	1	M3-M12	32	25	19	4	39	53
WF2-KP/MS25 6708873	2	M8-M20	50	25	31	6	54	53
WF3-KP/MS32 6708874	3	M14-M33	72	32	48	6	83	60
WF4-KP/MS40 6708870	4	M22-M48	95	40	60	8	102	68



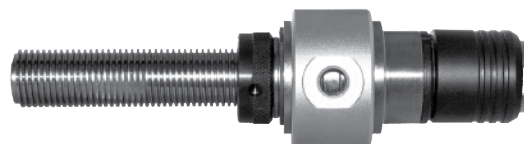
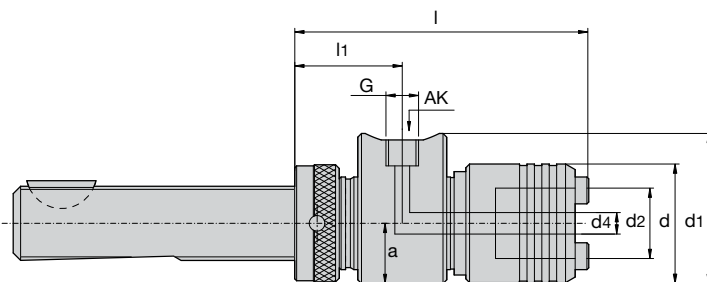
型号/订货号									
Designation/Id.No.				d	d1	d2	d3	l	l1
WFP0-KP/MS16	0	M1-M10 [★]	0,25	23	16	15	2,5	57	40
—									
WFP1-KP/MS25	1	M3-M12	0,5	32	25	19	3	62	53
6708907									
WFP2-KP/MS25	2	M8-M20	1,0	50	25	31	6	88	53
6708925									
WFP3-KP/MS32	3	M14-M33	1,5	72	32	48	6	128	60
—									

WF
WFLP



DIN
6327

WF/TR										
型号 Designation			d	d2		TR16	TR20	TR28	TR36	TR48
WF0/TR...	0	M1-M10*	23	13	I	45	45	–	–	–
					Id. No.	6708463	6708464	–	–	–
WF1/TR...	1	M3-M12	32	19	I	49	49	49	–	–
					Id. No.	6708477	6708478	6708479	–	–
WF2/TR...	2	M8-M20	50	31	I	–	66	66	68	–
					Id. No.	–	6708519	6708520	6708521	–
WF3/TR...	3	M14-M33	72	48	I	–	–	95	97	–
					Id. No.	–	–	6708550	6708553	–
WF4/TR...	4	M22-M48	95	60	I	–	–	–	124	118
					Id. No.	–	–	–	6708570	6708571



DIN
6327

20 bar

WF-AKP/TR...											
型号/订货号 Designation/Id. No.			d	d1	d2	d4	a	G	l	l1	速度 Speed 最高转速 max. rpm
WF0-AKP/TR16 6708689	0	M3-M10*	23	35	13	3	13,5	G1/8"	75	47,5	1600
WF1-AKP/TR20 6708690	1	M3-M12	32	40,5	19	3,5	16,2	G1/8"	80	51	1250
WF1-AKP/TR28 6708767				47			19,5		83	52,5	1050
WF2-AKP/TR20 6708908	2	M8-M20	50	47	31	6,0	19,5	G1/8"	99	67,5	1050
WF2-AKP/TR28 6708901				47			19,5		99	67,5	1050
WF2-AKP/TR36 5058993				54			23,5		105	68,5	850
WF3-AKP/TR28 6708564	3	M14-M33	72	80	48	6,0	40	G1/4"	141	99,5	550

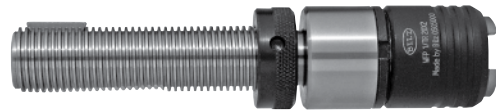
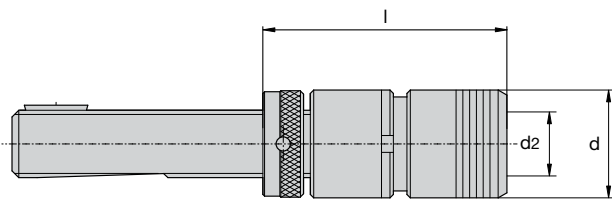
* > M6仅用于轻载加工 (最大.5Nm)

* > M6 for light machining only (max. 5 Nm)

合适的快换夹头见第98–117页

Suitable quick change adaptors see page 98 – 117

WFP — 快换攻丝刀柄
WFP – Quick change tapping chucks

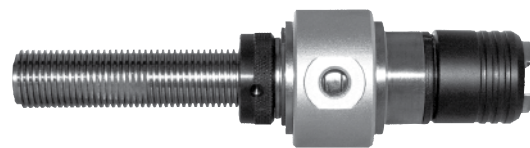
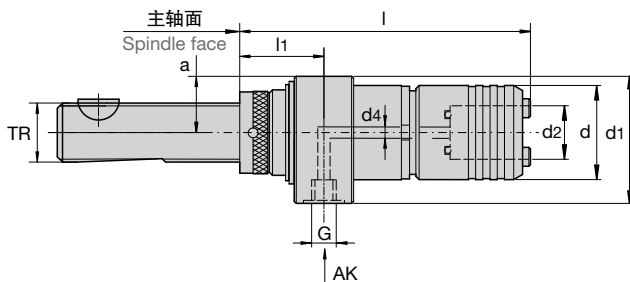


WFP/TR

带径向平行浮动
 with radial parallel float

型号 Designation				d	d2		TR16x1,5	TR20x2	TR28x2	TR36x2	TR48x2
WFP0/TR...	0	M1-M10*	0,25	23	13	I	65	65	—	—	—
						Id. No.	6708330	6708332	—	—	—
WFP1/TR...	1	M3-M12	0,5	32	19	I	70	70	70	—	—
						Id. No.	6708345	6708346	6708349	—	—
WFP2/TR...	2	M8-M20	1	50	31	I	—	96	96	98	—
						Id. No.	—	6708400	6708402	6708403	—
WFP3/TR...	3	M14-M33	1,5	72	48	I	—	—	136	138	—
						Id. No.	—	—	6708436	6708438	—
WFP4/TR...	4	M22-M48	2	95	60	I	—	—	—	167	171
						Id. No.	—	—	—	6708450	6708451
WFP40/TR...	40	M6-M18	0,75	40	26	I	—	89	89	—	—
						Id. No.	—	6708456	6708457	—	—

WFP — 快换攻丝刀柄
WFP – Quick change tapping chucks



WFP-AKP/TR...

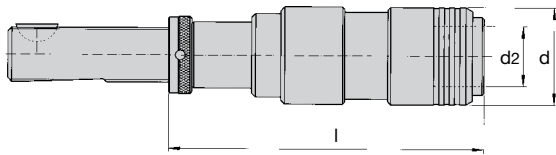
带径向平行浮动和外部冷却液供给
 with radial parallel float and external coolant feed

型号 Designation				d	d1	d2	d4	a	G		TR 20 I	TR 20 l1 min.	TR 28 I	TR 28 l1 min.	TR 36 I	TR 36 l1 min.	速度 Speed 最高转速 max. rpm
WFP1-AKP/TR...	1	M3-M12	0,5	32	47	19	3	19,5	G1/8"	I	103	32	103	32	—	—	1250
										Id. No.	6708947		6708900				
WFP2-AKP/TR...	2	M8-M20	1	50	62	31	6	27,5	G1/8"	I	132	36	132	36	134	38	950
										Id. No.	—		6708949		—		

* > M6仅用于轻载加工 (最大.5Nm)
 * > M6 for light machining only (max. 5 Nm)

合适的快换夹头见第98–117页
 Suitable quick change adaptors see page 98 – 117





DIN
6327



WFL/TR

带压缩/拉伸长度补偿

with length compensation on compression/extension

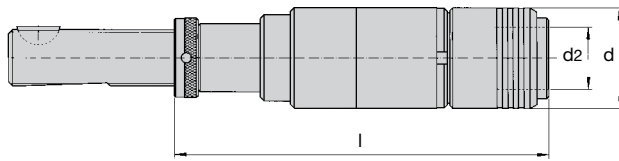
型号 Designation					d	d2		TR16	TR20	TR28	TR36
WFL020-20/TR...	0	M1-M10*	20	0	23	13	I	107	107	–	–
							Id. No.	6707969	6707971	–	–
WFL030-30/TR...	0	M1-M10*	30	0	23	13	I	127	127	–	–
							Id. No.	6707979	6707980	–	–
WFL030-20/TR...	0	M1-M10*	20	10	23	13	I	117	117	–	–
							Id. No.	6707991	6707992	–	–
WFL030-15/TR...	0	M1-M10*	15	15	23	13	I	112	112	–	–
							Id. No.	6708002	6708003	–	–
WFL030-0/TR...	0	M1-M10*	0	30	23	13	I	97	97	–	–
							Id. No.	6708013	6708014	–	–
WFL130-30/TR...	1	M3-M12	30	0	35	19	I	139	139	139	–
							Id. No.	6708036	6708037	6708039	–
WFL140-40/TR...	1	M3-M12	40	0	35	19	I	159	159	159	–
							Id. No.	6708057	6708058	6708059	–
WFL140-30/TR...	1	M3-M12	30	10	35	19	I	149	149	149	–
							Id. No.	6708084	6708085	6708086	–
WFL140-20/TR...	1	M3-M12	20	20	35	19	I	139	139	139	–
							Id. No.	6708099	6708100	6708102	–
WFL140-0/TR...	1	M3-M12	0	40	35	19	I	119	119	119	–
							Id. No.	6708122	6708123	6708124	–
WFL230-30/TR...	2	M8-M20	30	0	50	31	I	–	163	163	165
							Id. No.	–	6708158	6708159	6708160
WFL240-40/TR...	2	M8-M20	40	0	50	31	I	–	183	183	185
							Id. No.	–	6708171	6708172	6708173
WFL240-30/TR...	2	M8-M20	30	10	50	31	I	–	173	173	175
							Id. No.	–	6708197	6708198	6708199
WFL240-20/TR...	2	M8-M20	20	20	50	31	I	–	163	163	165
							Id. No.	–	6708208	6708209	6708210
WFL240-0/TR...	2	M8-M20	0	40	50	31	I	–	143	143	145
							Id. No.	–	6708231	6708232	6708233
WFL32.40-40/TR...	1	M3-M12	40	0	32	19	I	159	159	–	–
							Id. No.	6708297	6708298	–	–
WFL32.40-30/TR...	1	M3-M12	30	10	32	19	I	149	149	–	–
							Id. No.	6708301	6708302	–	–
WFL32.40-20/TR...	1	M3-M12	20	20	32	19	I	139	139	–	–
							Id. No.	6708304	6708305	–	–
WFL32.40-0/TR...	1	M3-M12	0	40	32	19	I	119	119	–	–
							Id. No.	6708309	6708310	–	–
WFL40.40-40/TR...	40	M6-M18	40	0	40	26	I	–	176	176	–
							Id. No.	–	6708312	6708313	–
WFL40.40-30/TR...	40	M6-M18	30	10	40	26	I	–	166	166	–
							Id. No.	–	6708320	6708321	–
WFL40.40-20/TR...	40	M6-M18	20	20	40	26	I	–	156	156	–
							Id. No.	–	6708324	6708325	–
WFL40.40-0/TR...	40	M6-M18	0	40	40	26	I	–	136	136	–
							Id. No.	–	6708327	6708328	–

* > M6仅用于轻载加工 (最大 5Nm)

* > M6 for light machining only (max. 5 Nm)

合适的快换攻丝夹头见第98–132页

Suitable quick change adaptors see page 98 – 132



WFLP/TR

带压缩/拉伸长度补偿和径向平行浮动

with length compensation on compression/extension and radial parallel float

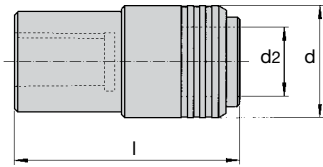
型号 Designation						d	d2		TR16	TR20	TR28	TR36
WFLP020-20/TR...	0	M1-M10*	0,25	20	0	23	13	I	129	129	–	–
								Id. No.	6707577	6707579	–	–
WFLP030-30/TR...	0	M1-M10*	0,25	30	0	23	13	I	149	149	–	–
								Id. No.	6707593	6707594	–	–
WFLP030-20/TR...	0	M1-M10*	0,25	20	10	23	13	I	139	139	–	–
								Id. No.	6707610	6707611	–	–
WFLP030-15/TR...	0	M1-M10*	0,25	15	15	23	13	I	134	134	–	–
								Id. No.	6707620	6707621	–	–
WFLP030-0/TR...	0	M1-M10*	0,25	0	30	23	13	I	119	119	–	–
								Id. No.	6707630	6707631	–	–
WFLP130-30/TR...	1	M3-M12	0,5	30	0	35	19	I	154	154	154	–
								Id. No.	6707664	6707666	6707668	–
WFLP140-40/TR...	1	M3-M12	0,5	40	0	35	19	I	174	174	174	174
								Id. No.	6707688	6707689	6707691	–
WFLP140-30/TR...	1	M3-M12	0,5	30	10	35	19	I	164	164	164	–
								Id. No.	6707728	6707729	6707730	–
WFLP140-20/TR...	1	M3-M12	0,5	20	20	35	19	I	154	154	154	–
								Id. No.	6707743	6707744	6707746	–
WFLP140-0/TR...	1	M3-M12	0,5	0	40	35	19	I	134	134	134	–
								Id. No.	6707765	6707766	6707767	–
WFLP230-30/TR...	2	M8-M20	1,0	30	0	50	31	I	–	–	188	190
								Id. No.	–	–	6707799	6707801
WFLP240-40/TR...	2	M8-M20	1,0	40	0	50	31	I	–	208	208	210
								Id. No.	–	6707816	6707817	6707819
WFLP240-30/TR...	2	M8-M20	1,0	30	10	50	31	I	–	198	198	200
								Id. No.	–	6707841	6707842	6707843
WFLP240-20/TR...	2	M8-M20	1,0	20	20	50	31	I	–	188	188	190
								Id. No.	–	6707848	6707849	6707850
WFLP240-0/TR...	2	M8-M20	1,0	0	40	50	31	I	–	168	168	170
								Id. No.	–	6707872	6707873	6707874
WFLP32.40-40/TR...	1	M3-M12	0,5	40	0	32	19	I	174	174	–	–
								Id. No.	–	6707945	–	–
WFLP32.40-30/TR...	1	M3-M12	0,5	30	10	32	19	I	164	164	–	–
								Id. No.	6707946	6707947	–	–
WFLP32.40-20/TR...	1	M3-M12	0,5	20	20	32	19	I	154	154	–	–
								Id. No.	6707948	6707949	–	–
WFLP32.40-0/TR...	1	M3-M12	0,5	0	40	32	19	I	134	134	–	–
								Id. No.	6707950	6707951	–	–
WFLP40.40-40/TR...	40	M6-M18	0,75	40	0	40	26	I	–	201	201	–
								Id. No.	–	6707952	6707953	–
WFLP40.40-30/TR...	40	M6-M18	0,75	30	10	40	26	I	–	191	191	–
								Id. No.	–	6707958	6707959	–
WFLP40.40-20/TR...	40	M6-M18	0,75	20	20	40	26	I	–	181	181	–
								Id. No.	–	6707961	6707962	–
WFLP40.40-0/TR...	40	M6-M18	0,75	0	40	40	26	I	–	161	161	–
								Id. No.	–	6707964	6707965	–

* > M6仅用于轻载加工 (最大.5Nm)

* > M6 for light machining only (max. 5 Nm)

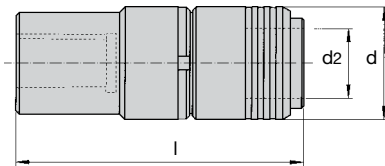
合适的快换攻丝夹头见第98–132页

Suitable quick change adaptors see page 98 – 132



DIN
238

WF/B											
型号											
Designation			d	d2		B10	B12	B16	B18	B22	B24
WF0/B...	0	M1-M10*	23	13	I	51	55	–	–	–	–
					Id. No.	6708469	6708470	–	–	–	–
WF1/B...	1	M3-M12	32	19	I	–	59	65	73	–	–
					Id. No.	–	6708491	6708492	6708493	–	–
WF2/B...	2	M8-M20	50	31	I	–	–	84	92	101	–
					Id. No.	–	–	6708528	6708529	6708530	–
WF3/B...	3	M14-M33	72	48	I	–	–	–	–	126	136
					Id. No.	–	–	–	–	6708560	6708561



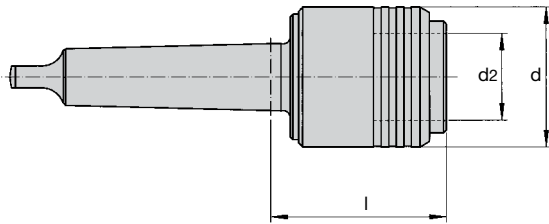
DIN
238



WFP/B 带径向平行浮动 with radial parallel float													
型号 Designation													
				d	d2		B10	B12	B16	B18	B22	B24	
WFP0/B...	0	M3-M10★	0,25	23	13	I	72	76	83	–	–	–	
						Id. No.	6708337	6708338	6708339	–	–	–	
WFP1/B...	1	M3-M12	0,5	32	19	I	–	79	85	95	–	–	
						Id. No.	–	6708359	6708360	6708361	–	–	
WFP2/B...	2	M8-M20	1,0	50	31	I	–	–	112	119	129	–	
						Id. No.	–	–	6708414	6708415	6708416	–	
WFP3/B...	3	M14-M33	1,5	72	48	I	–	–	–	156	165	175	
						Id. No.	–	–	–	6708444	6708445	6708446	
WFP4/B...	4	M22-M48	2,0	95	60	I	–	–	–	–	196	206	
						Id. No.	–	–	–	–	–	6708455	

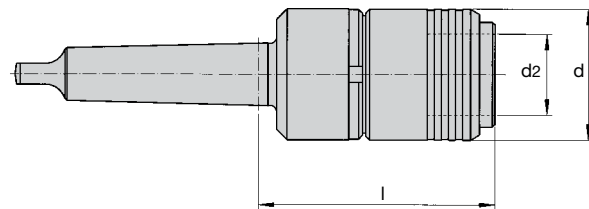
* > M6仅用于轻载加工 (最大.5Nm)
* > M6 for light machining only (max. 5 Nm)

合适的快换夹头见第98–117页
Suitable quick change adaptors see page 98 – 117



DIN
228B

WF/MK										
型号 Designation			d	d2		MK1	MK2	MK3	MK4	MK5
WF0/MK	0	M1-M10*	23	13	l	39	40	–	–	–
					Id. No.	6708467	6708468	–	–	–
WF1/MK	1	M3-M12	32	19	l	43	44	44	–	–
					Id. No.	6708485	6708486	6708488	–	–
WF2/MK	2	M8-M20	50	31	l	–	61	61	62	–
					Id. No.	–	6708525	6708526	6708527	–
WF3/MK	3	M14-M33	72	48	l	–	–	90	91	–
					Id. No.	–	–	6708558	6708559	–
WF4/MK	4	M22-M48	95	60	l	–	–	–	110	109
					Id. No.	–	–	–	6708573	6708574



DIN
228B



WFP/MK 带径向平行浮动 with radial parallel float											
型号 Designation				d	d2		MK1	MK2	MK3	MK4	MK5
WFP0/MK...	0	M3-M10★	0,25	23	13	I	59	60	—	—	—
						Id. No.	6708335	6708336	—	—	—
WFP1/MK...	1	M3-M12	0,5	32	19	I	64	65	65	—	—
						Id. No.	6708356	6708357	6708358	—	—
WFP2/MK...	2	M8-M20	1	50	31	I	—	91	91	92	—
						Id. No.	—	6708411	6708412	6708413	—
WFP3/MK...	3	M14-M33	1,5	72	48	I	—	—	131	132	—
						Id. No.	—	—	6708442	6708443	—
WFP4/MK...	4	M22-M48	2	95	60	I	—	—	—	161	162
						Id. No.	—	—	—	6708453	6708454

* > M6仅用于轻载加工 (最大.5Nm)
* > M6 for light machining only (max. 5 Nm)

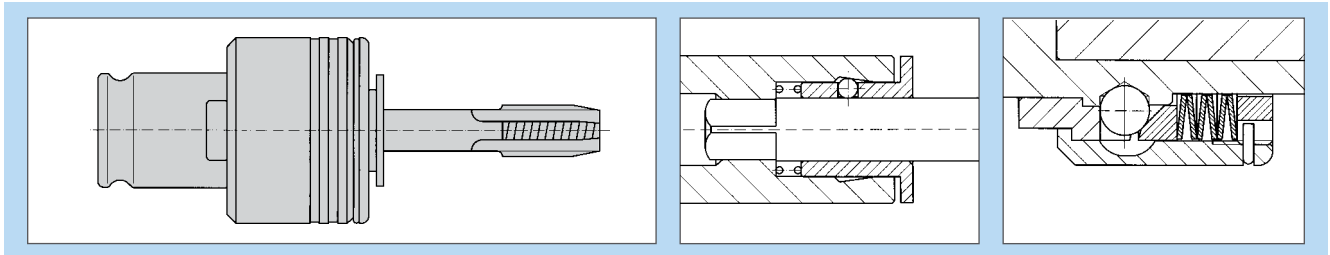
合适的快换夹头见第98–117页
Suitable quick change adaptors see page 98 – 117

应用：丝锥和挤压丝锥的夹持

刀柄类型：所有带快换机构的攻丝刀柄 (WF...)

Application: clamping of taps and roll forming taps

Chuck type: all tapping chucks with quick change mechanism style (WF...)



用于攻丝和螺纹挤压的快换夹头

通过Bilz攻丝夹头和Bilz快换攻丝刀柄的结合使用，换刀时间可以被尽可能的减少。从而降低了流水线和专机上加工的高额费用。

快换夹头为最佳效率而设计。在攻丝刀柄中快速移除和置换快换夹头，以及丝锥在快换夹头中的定位和锁紧都非常简单高效。

所有案例的丝锥驱动都是靠方尾。丝锥柄部通过快换锁紧机构夹持住。

快换夹头带长度调节，可以在机器外设置，延长型夹头用在入口难加工区域，可调安全夹紧夹头，这些都很容易避免丝锥崩裂。

在所有的案例中，每种不同柄部尺寸的丝锥需要相应的快换夹头。

快换夹头其它的应用，如可接受的弹簧筒夹、用于外螺纹的板牙或者加粗或者减小的丝锥柄部尺寸都完善了这一产品家族。

Quick change adaptors for tapping and thread forming

By using the combination of Bilz tapping adaptors and Bilz quick change tapping chucks, tool changing times can be minimized. On transfer lines and special application machines where down time costs are high, these efficiencies represent significant savings.

The adaptors are designed for optimum efficiency. Removal and replacement in the chuck is rapid and the location and locking of the tap in the adaptor is simple and effective.

In all cases the drive of the tap is realised by the square. The tap shank is held in position by a quick locking mechanism.

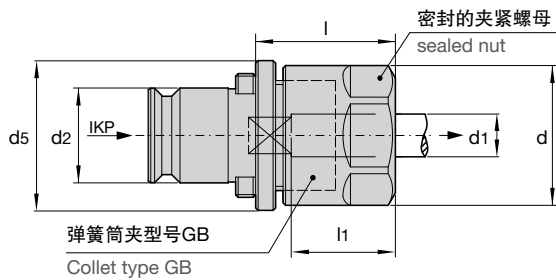
Adaptors with length adjustment are available for setting off the machine, extended length adaptors are available for areas of difficult access, adjustable safety clutch adaptor, facilitates the avoidance of tap breakage.

In all cases, a different adaptor is required for each size of tap shank.

Adaptors for other applications, such as those for accepting collets, and dies for external threads or for increased shank or reduction facility complete this product family.

特点:	优势:	效益:
■ 适合丝锥的快换系统	■ 在机床上快速更换丝锥	■ 减少了机床停机时间
■ 用于刀柄上的丝锥夹头的快换系统	■ 快速更换丝锥夹头和丝锥	■ 减少了停机时间
■ 安全保护（所有的WES...）	■ 预防丝锥崩刃	■ 更少的停机时间，减少了加工费用
■ 安全保护带钢珠机构（所有的WES...）	■ 更低的摩擦	■ 更低的磨损，更少的维护需求
■ 长度调节（所有的WEN...）	■ 在机床外长度调节成为可能	■ 减少了机床停机时间
■ 丝锥方尾正向驱动	■ 丝锥在夹头里没有打滑或者扭转	■ 预防了丝锥崩刃
■ 延长的夹头成为可能	■ 深腔螺纹或者型腔干涉时的加工无需非标刀具	■ 减少费用
Features:	Advantages:	Benefits:
■ quick change system for taps and roll forming taps	■ quick change of taps in the machine	■ reduced down time of the machine
■ quick change system for tap adaptors in the chuck	■ quicker tool change of the adaptors/ taps	■ reduced down time
■ safety clutch (all types WES...)	■ prevents tap breakage	■ less down time reduced remanufacturing costs
■ safety clutch (all types WES...) with ball mechanism	■ low friction	■ lower wear, less maintenance required
■ length adjustment (all types WEN...)	■ length adjustment outside of the machine possible	■ reduced down time of the machine
■ positive drive of the tap at the square	■ no slipping or twisting of the tap in the adaptor	■ prevention of tool breakage
■ extended adaptors possible	■ manufacturing of deep lying threads or contour obstructions without special tools	■ cost reduction

WE — 用于带驱动方头DIN6499-B的弹簧筒夹的快换夹头
WE – Quick change adaptor for collets with drive square DIN6499-B



DIN
6499B

50 bar

WE1-IKP/ESX16GB
WE2-IKP/ESX25GB

型号/订货号 Designation/Id. No.													
			d1 x Vkt d1 x Square	订货号 Id. No.	d	d2	d5	l	l1 max			d1	订货号 Id. No.
WE1-IKP/ESX16GB 6711424	1	M4-M10	ESX16GB - 4,5x3,4	6951393	28	19	31	28	18	SW30		DS/ER16-5	6952972
			ESX16GB - 5,5x4,3	6954656								DS/ER16-6	6954177
			ESX16GB - 6,0x4,9	6951392								DS/ER16-6	6954177
			ESX16GB - 7,0x5,5	6947340								DS/ER16-7	6940533
			ESX16GB - 8,0x6,2/6,3	6946213								DS/ER16-8	6941539
			ESX16GB - 9,0x7,0/7,1	6947393								DS/ER16-9	6941992
WE2-IKP/ESX25GB 6715360	2	M8-M20	ESX25GB - 4,5x3,4	6951218	42	31	48	33,5	23	E25		DS/ER25-5	6954184
			ESX25GB - 6,0x4,9	6951544								DS/ER25-6	6953215
			ESX25GB - 7,0x5,5	6951797								DS/ER25-7	6943420
			ESX25GB - 8,0x6,2/6,3	6951214								DS/ER25-8	6943419
			ESX25GB - 9,0x7,0/7,1	6951216								DS/ER25-9	6941679
			ESX25GB - 10,0x8,0	6951215								DS/ER25-10	6943423
			ESX25GB - 11,0x9,0	6946167								DS/ER25-11	6943534
			ESX25GB - 12,0x9,0	6950343								DS/ER25-12	6943424
			ESX25GB - 14,0x11,0/11,2	6951559								DS/ER25-14	6943342
			ESX25GB - 16,0x12,0/12,5	6951399								DS/ER25-16	6943422

密封垫圈见第31页
 Sealing discs see page 31

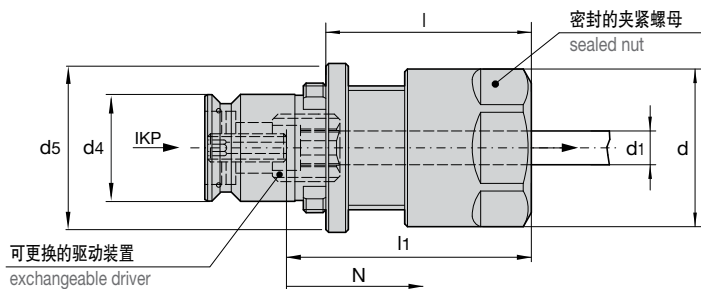
筒夹见第33页
 Collet see page 33

扳手见第27页
 Wrench see page 27

紧固扭矩螺母见第26页
 Tightening torque nut see page 26

请单独订购密封垫圈和弹簧筒夹。
 Please order sealing disc and collet separately.

WE — 快换夹头带ESX弹簧筒夹
WE – Quick change adaptor with ESX-collet

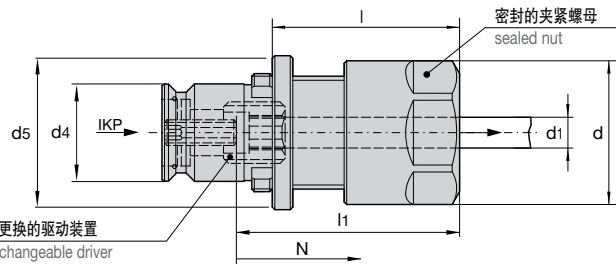


WE1-IKP/ESX16-... WE2-IKP/ESX25-...														
型号/订货号 Designation/Id. No.			d	d1	d4	d5	l	l1	N			驱动装置 Driver		
WE1-IKP/ESX16-5x4 9124567	1	M5-M12	28	5	19	30	36,5	43,5	4		ESX16-5	DS/ER16-5	BN1716-4	EX16-IC 6931372
											Id. No. 6921627	6952972	6930574	
WE1-IKP/ESX16-5,6x4,5 —				5,6							ESX16-6	DS/ER16-6	BN1716-4,5	
											Id. No. 6921628	6931371	6930575	
WE1-IKP/ESX16-6x4,9 6711380				6							ESX16-6	DS/ER16-6	BN1716-5	
											Id. No. 6921628	6931371	6930576	
WE1-IKP/ESX16-6,3x5 6711381				6,3							ESX16-7	DS/ER16-6,5	BN1716-5	
											Id. No. 6921629	6943060	6930576	
WE1-IKP/ESX16-7x5,5 6711382				7							ESX16-7	DS/ER16-7	BN1716-5,6	
											Id. No. 6921629	6940533	6930577	
WE1-IKP/ESX16-7,1x5,6 9095125				7,1							ESX16-8	DS/ER16-7,5	BN1716-5,6	
											Id. No. 6921630	6952195	6930577	
WE1-IKP/ESX16-8x6,2 6711383				8							ESX16-8	DS/ER16-8	BN1716-6,3	
											Id. No. 6921630	6941539	6930578	
WE1-IKP/ESX16-8x6,3 5014306				8							ESX16-8	DS/ER16-8	BN1716-6,3	
											Id. No. 6921630	6941539	6930578	
WE1-IKP/ESX16-9x7/7,1 6711384				9							ESX16-9	DS/ER16-9	BN1716-7,1	
											Id. No. 6921631	6941992	6931079	
WE1-IKP/ESX16-9x7,1 6711385				9							ESX16-9	DS/ER16-9	BN1716-7,1	
											Id. No. 6921631	6941992	6931079	
WE1-IKP/ESX16-10x8 6711386				10							ESX16-10	DS/ER16-10	—	
											Id. No. 6921632	6942300	—	
WE2-IKP/ESX25-7x5,5 6715339	2	M8-M20	42	7	31	48	48	57,5	4		ESX25-7	DS/ER25-7	BN1725-5,6	EX25-IC 6941678
											Id. No. 6921656	6943420	6943252	
WE2-IKP/ESX25-7,1x5,6 6715340				7,1							ESX25-8	DS/ER25-7,5	BN1725-5,6	
											Id. No. 6921657	6943421	6943252	
WE2-IKP/ESX25-8x6,2/6,3 6715350				8							ESX25-8	DS/ER25-8	BN1725-6,5	
											Id. No. 6921657	6943419	6943253	
WE2-IKP/ESX25-9x7/7,1 6715341				9							ESX25-9	DS/ER25-9	BN1725-7,1	
											Id. No. 6921658	6941679	6941587	
WE2-IKP/ESX25-10x8 6715342				10							ESX25-10	DS/ER25-10	BN1725-8	
											Id. No. 6921659	6943423	6931467	
WE2-IKP/ESX25-11x9 6715343				11							ESX25-11	DS/ER25-11	BN1725-9	
											Id. No. 6921660	6943534	6943834	

夹头包括筒夹，密封垫圈，驱动装置和螺母。
 Adaptor includes collet, sealing disc, driver and nut.

紧固扭矩螺母见第26页
 Tightening torque nut see page 26

WE — 快换夹头带ESX弹簧筒夹
WE – Quick change adaptor with ESX-collet



WE1-IKP/ESX16-...
WE2-IKP/ESX25-...

型号/订货号 Designation/Id. No.													驱动装置 Driver	
WE2-IKP/ESX25-11,2x9 5068697	2	M8-M20	42	11,2	31	48	48	57,5	4				BN1725-9	EX25-IC 6941678
WE2-IKP/ESX25-12x9 6715344										ESX25-12	DS/ER25-12	BN1725-9		
WE2-IKP/ESX25-12,5x10 6715347										ESX25-13	DS/ER25-13	BN1725-10		
WE2-IKP/ESX25-14x11 6715345										ESX25-14	DS/ER25-14	BN1725-11,2		
WE2-IKP/ESX25-14x11,2 6715346										ESX25-14	DS/ER25-14	BN1725-11,2		
WE2-IKP/ESX25-16x12 6715348										ESX25-16	DS/ER25-16	BN1725-12		

夹头包括筒夹，密封垫圈，驱动装置和螺母。
 Adaptor includes collet, sealing disc, driver and nut.

紧固扭矩螺母见第26页
 Tightening torque nut see page 26

T...WEN 用于硬质合金丝锥的热胀夹头
T...WEN Shrink fit adaptor for carbide taps



T.../WEN									
型号/订货号 Designation/Id. No.		d1	d2	d3	d4	d5	A	l1 max	N
T0600-40/WEN1 6727767	1	6	19	22	19	30	40	31	5
T0700-40/WEN1 6727768	1	7	19	22	19	30	40	31	
T0800-40/WEN1 6727769	1	8	19	22	19	30	40	32	
T0900-40/WEN1 6727783	1	9	19	22	19	30	40	33	
T1000-40/WEN1 6727770	1	10	19	22	19	30	40	34	
T0600-40/WEN2 6727798	2	6	19	22	31	48	40	31	
T0700-40/WEN2 6727799	2	7	19	22	31	48	40	31	
T0800-40/WEN2 6727800	2	8	19	22	31	48	40	32	
T0900-40/WEN2 6727801	2	9	19	22	31	48	40	33	
T1000-40/WEN2 6727779	2	10	19	22	31	48	40	34	
T1100-60/WEN2 6727773	2	11	27	34	31	48	60	46	
T1200-60/WEN2 6727802	2	12	27	34	31	48	60	46	
T1400-60/WEN2 6727772	2	14	27	34	31	48	60	48	
T1600-60/WEN2 6727803	2	16	27	34	31	48	60	49	

热胀夹头用于攻丝刀柄，仅适用于柄部公差H6的硬质合金丝锥，并且不需要丝锥柄部的方尾。

对于HSS和HM按需定制。

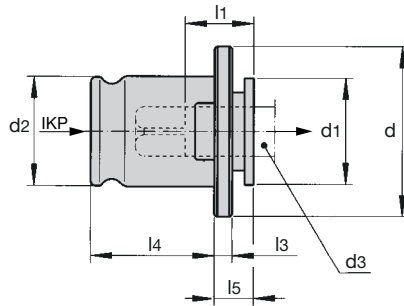
所有的热胀夹头都适合中心冷却。

Shrink Fit adaptors for tapping chucks. For carbide taps with shank tolerance H6 only. The square at the shank is not required

For HSS and HM on request

All shrinking adaptors are suitable for central coolant feed





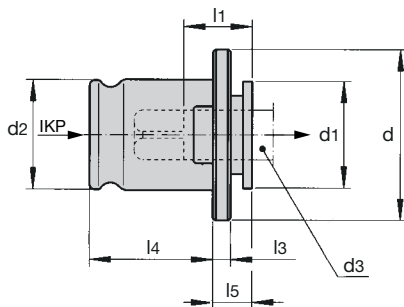
WE..., DIN

型号 Designation		WE 0	WE 1	WE 2	WE 3	WE 4	WE 40
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-8	3,5-11,3	7-18	11-28	18-36	6-14
		0	1 + 32	2	3	4	40
	d	22	30	48	70	92	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	4	4	5	6	13	5
	l4	19,5	21,5	35	55,5	63	32
	l5	7	7	11	14	42	13

用于符合DIN标准的丝锥
For taps according to DIN

柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
2,80	2,10	M1-M2,5	M3,5-M4		6722536					
3,50	2,70	M3	M5		6722546	6711244				
4,00	3,00	M3,5			6722551	6711248				
4,50	3,40	M4	M6		6722556	6711253				6721907
5,50	4,50		M7		6722564	6711313				
6,00	4,90	M4,5			6722568	6711268				6721886
6,00	4,90	M5			6722568	6711268				6721886
6,00	4,90	M6	M8		6722568	6711268	6715185			6721886
7,00	5,50	M7	M9-M10		6722576	6711279	6715189			6721888
8,00	6,20	M8			6722580	6711287	6715196			6721889
9,00	7,00	M9	M12			6711294	6715203			6721892
10,00	8,00	M10				6711302	6715208			6721896
11,00	9,00		M14			6711308	6715211	6718393		6721899
12,00	9,00	M12	M16				6715215	6718395		6721901
14,00	11,00		M18				6715224	6718400		6721903
16,00	12,00		M20				6715232	6718404		
18,00	14,50		M22-M24				6715242	6718411	6720626	
20,00	16,00		M27					6718415	6720627	
22,00	18,00		M30					6718419	6720628	
25,00	20,00		M33					6718425	6720630	
28,00	22,00		M36					6718428	6720632	
32,00	24,00		M39-M42						6720635	
36,00	29,00		M45-M48						6720637	

也适用于中心冷却供给 (IKP)
Also suitable for central coolant feed (IKP)

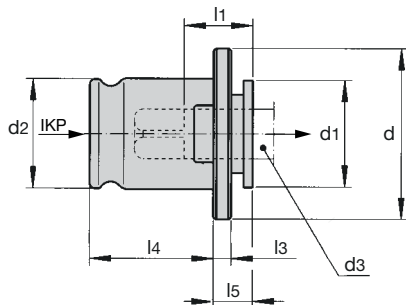


WE..., ISO							
型号 Designation		WE 0	WE 1	WE 2	WE 3	WE 4	WE 40
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-8	3,5-11,3	7-18	11-28	18-36	6-14
		0	1 + 32	2	3	4	40
	d	22	30	48	70	92	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	4	4	5	6	13	5
	l4	19,5	21,5	35	55,5	63	32
	l5	7	7	11	14	42	13

用于符合ISO标准的丝锥
For taps according to ISO

柄径 D	方尾 VKT	ISO529	ISO529 加强型 reinforced	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
2,24	1,80	M3		6722583	6711235				
2,50	2,00	M3,5	M2	6722533	6711236				
2,80	2,24		M2,2-M2,5	6722537	6711239				
3,15	2,50	M4	M3	6722540	6711242				
3,55	2,80	M4,5	M3,5	6722547	6711245				
4,00	3,15	M5	M4	6722552	6711249				
4,50	3,55	M6		6722557	6711254				
5,00	4,00		M5	6722562	6711260				
5,60	4,50	M7		6722566	6711264	6715183			
6,30	5,00	M8	M6	6722572	6711274				
7,10	5,60	M9	M7	6722577	6711281	6715191			
8,00	6,30	M10	M8	6722581	6711288	6715197			6721890
9,00	7,10	M12			6711295	6715204			6721893
10,00	8,00		M10		6711302	6715208			6721896
11,20	9,00	M14			6711310	6715213	6718394		6721900
12,50	10,00	M16				6715218	6718397		6721902
14,00	11,20	M18				6715225	6718401		6721906
16,00	12,50	M22				6715233	6718405		
18,00	14,00	M24				6715241	6718410	6720641	
20,00	16,00	M27					6718415	6720627	
22,40	18,00	M33					6718420	6720640	
25,00	20,00	M36					6718425	6720630	
28,00	22,40	M39					6718429	6720639	
31,50	25,00	M45-M48						6720642	
35,50	28,00	M52-M56						6720643	

也适用于中心冷却供给 (IKP)
Also suitable for central coolant feed (IKP)



WE...,JIS

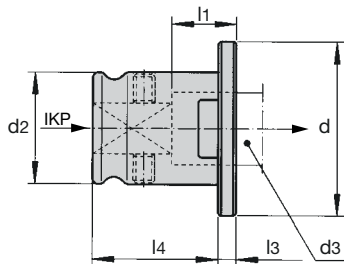
型号 Designation		WE 0	WE 1	WE 2	WE 3	WE 4	WE 40
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-8	3,5-11,3	7-18	11-28	18-36	6-14
		0	1 + 32	2	3	4	40
	d	22	30	48	70	92	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	4	4	5	6	13	5
	l4	19,5	21,5	35	55,5	63	32
	l5	7	7	11	14	42	13

用于符合JIS标准的丝锥
For taps according to JIS

柄径 D	方尾 VKT	JIS		Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
3,5	2,0	M2,5							
4,0	3,2	M3-M3,5		6722586	6711320				
5,0	4,0	M4-M4,5		6722562	6711260				
5,5	4,5	M5		6722564	6711313				x
6,0	4,5	M6		6722582	6711266	6715184			x
6,2	5,0	M7-M8		6722571	6711317	6715247			6721904
7,0	5,5	M9-M10		6722576	6711279	6715189			6721888
8,0	6,5	M11			6711318	6715246			x
8,5	6,5	M12			6711292	6715248			x
10,5	8,0	M14			6711304	6715209	6718391		6721897
12,5	10,0	M16				6715218	6718397		6721902
13,0	10,0	M17				6715221	6718398		x
14,0	11,0	M18				6715224	6718400		6721903
15,0	12,0	M20				6715230	6718403		
17,0	13,0	M22				6715243	x	6720646	
19,0	15,0	M24					6718434	x	
20,0	15,0	M27					6718414	6720644	
21,0	17,0	M28					x	x	
23,0	17,0	M30					6718435	x	
24,0	19,0	M32					9117836	x	
25,0	19,0	M33					x	x	
26,0	21,0	M34-M35					x	x	
28,0	21,0	M36-M38					6718445	x	
30,0	23,0	M39-M40						x	
32,0	26,0	M42						x	
35,0	26,0	M45						x	
38,0	29,0	M48						x	

也适用于中心冷却供给 (IKP)
Also suitable for central coolant feed (IKP)

x – 按需定制
x - on request



WEK

使用调节螺钉延长夹紧范围

extended clamping range with set screws

型号 Designation		WEK1	WEK2	WEK3	WEK4
		M16	M27 - M30	M39 - M48	M52 - M60
	d3	11,3-12	18-22	28-36	36-45
		1 + 32	2	3	4
	d	30	48	70	92
	d2	19	31	48	60
	l1	17	30	44	50
	l3	4	5	6	21
	l4	21,5	35	55,5	63

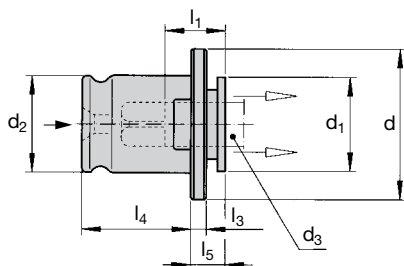
用于符合DIN标准的丝锥

For taps according to DIN

柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.	Id.No.
11,00	9,00		M14		6711375			
12,00	9,00	M12	M16		6711374			
14,00	11,00		M18					
16,00	12,00		M20			6715315		
18,00	14,50		M22-M24			6715317		
20,00	16,00		M27			6715309		
22,00	18,00		M30			6715310		
25,00	20,00		M33				6718507	
28,00	22,00		M36				6718485	
32,00	24,00		M39-M42				6718479	
36,00	29,00		M45-M48				6718483	6720658
40,00	32,00		M52					6720651
45,00	35,00		M56-M60					6720652

也适用于中心冷却供给 (IKP)

Also suitable for central coolant feed (IKP)



WE...KP, DIN

用于无内部冷却液供应的丝锥和挤压丝锥

for taps, roll former without internal coolant supply

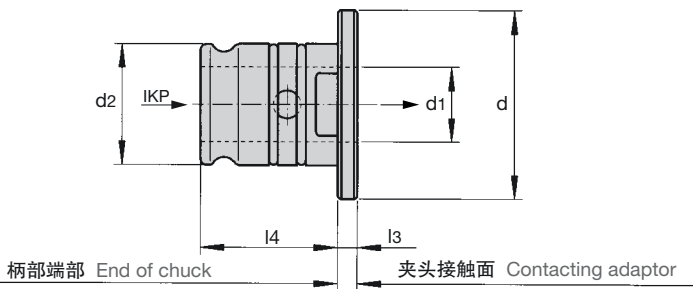
型号 Designation		WE 1-KP	WE 2-KP	WE 3-KP
		M3-M12	M8-M20	M14-M33
	d3	3,5-11,3	7-18	11-28
		1+32	2	3
	d	30	48	70
	d1	19	30	48
	d2	19	31	48
	l1	17	30	44
	l3	4	5	6
	l4	21,5	35	55,5
	l5	7	11	14

用于符合DIN标准的丝锥

For taps according to DIN

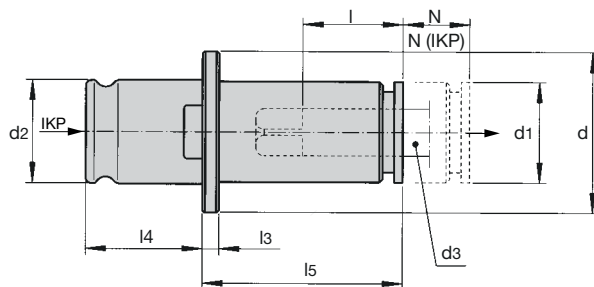
柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.
2,80	2,10	M1-M2,5	M3,5-M4		6711520		
3,50	2,70	M3	M5		6711506		
4,00	3,00	M3,5			6711507		
4,50	3,40	M4	M6		6711503		
5,50	4,50		M7		—		
6,00	4,90	M4,5			6711504		
6,00	4,90	M5			6711504		
6,00	4,90	M6	M8		6711504		
7,00	5,50	M7	M9-M10		6711502	6715432	
8,00	6,20	M8			6711495	6715412	
9,00	7,00	M9	M12		6711497	6715414	
10,00	8,00	M10	M10		6711499	6715416	
11,00	9,00		M14		6711500	6715417	6718596
12,00	9,00	M12	M16			6715419	6718598
14,00	11,00		M18			6715421	6718591
16,00	12,00		M20			6715423	6718601
18,00	14,50		M22-M24			6715426	6718589
20,00	16,00		M27				6718594
22,00	18,00		M30				6718592
25,00	20,00		M33				6718595
28,00	22,00		M36				6718596

WRE — 快换夹头
WRE – Quick change adaptor



WRE 减径夹头 Reducing adaptor								
型号 Designation			d	d1	d2	l3	l4	Id. No.
WRE1/0	1	0	30	13	19	4	21,5	6711434
WRE2/0	2	0	48	13	31	5	35	6715362
WRE2/1	2	1	48	19	31	5	35	6715363
WRE3/1	3	1	70	19	48	6	55,5	6718562
WRE3/2	3	2	70	31	48	6	55,5	6718563
WRE4/2	4	2	92	31	60	13	63	6720688
WRE4/3	4	3	92	48	60	13	63	6720689

也适用于中心冷却供给 (IKP)
 Also suitable for central coolant feed (IKP)



WEN..., DIN

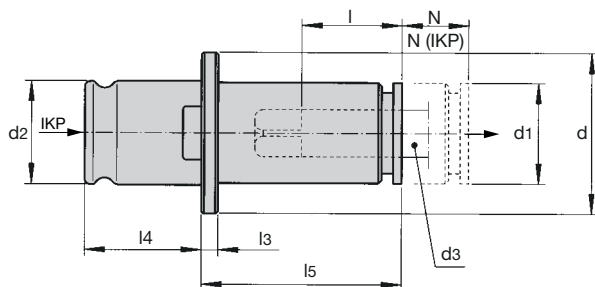
型号 Designation		WEN 0	WEN 1*	WEN 2*	WEN 3*	WEN 4*	WEN 40*
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-7,2	3,5-11,3	7-18	11-28	18-36	6-14
		0	1 + 32	2	3	4	40
	d	22	30	48	70	92	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	4	4	5	6	13	5
	l4	19,5	21,5	35	55,5	63	32
	l5	29	34	60	83	137	54
	N +	8	10	15	25	25	15
	(IKP)	–	6,5	14	25	25	10

用于符合DIN标准的丝锥
For taps according to DIN

柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
2,80	2,10	M1-M2,5	M3,5-M4		6722760					
3,50	2,70	M3	M5		6722763	6711829				
4,00	3,00	M3,5			6722766	6711833				
4,50	3,40	M4	M6		6722769	6711836				6721945
5,50	4,50		M7		6722775	6711877				
6,00	4,90	M4,5			6722778	6711844				
6,00	4,90	M5			6722778	6711844				
6,00	4,90	M6	M8		6722778	6711844	6715688			6721920
7,00	5,50	M7	M9-M10		6722784	6711852	6715691			6721923
8,00	6,20	M8				6711857	6715693			6721925
9,00	7,00	M9	M12			6711863	6715697			6721929
10,00	8,00	M10	M10			6711871	6715701			6721933
11,00	9,00		M14			6711874	6715704	6718774		6721936
12,00	9,00	M12	M16				6715707	6718776		6721938
14,00	11,00		M18				6715712	6718780		6721940
16,00	12,00		M20				6715719	6718783		
18,00	14,50		M22-M24				6715725	6718788	6720728	
20,00	16,00		M27					6718790	6720729	
22,00	18,00		M30					6718792	6720730	
25,00	20,00		M33					6718795	6720731	
28,00	22,00		M36					6718797	6720733	
32,00	24,00		M39-M42						6720736	
36,00	29,00		M45-M48						6720738	

* 也适用于中心冷却供给 (IKP)

* Also suitable for central coolant feed (IKP)



WEN..., ISO							
型号 Designation		WEN 0	WEN 1*	WEN 2*	WEN 3*	WEN 4*	WEN 40*
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-7,2	3,5-11,3	7-18	11-28	18-36	6-14
		0	1+32	2	3	4	40
	d	22	30	48	70	92	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	4	4	5	6	13	5
	l4	19,5	21,5	35	55,5	63	32
	l5	29	34	60	83	137	54
		8	10	15	25	25	15
	(IKP)	–	6,5	14	25	25	10

用于符合ISO标准的丝锥
For taps according to ISO

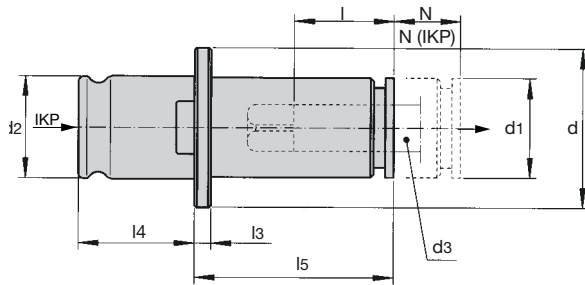
柄径 D	方尾 VKT	ISO529	ISO529 加强型 reinforced	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
2,24	1,80	M3		6722789	6711823				
2,50	2,00	M3,5	M2	6722758	6711824				
2,80	2,24		M2,2-M2,5	6722761	6711827				
3,15	2,50	M4	M3	6722762	6711828				
3,55	2,80	M4,5	M3,5	6722764	6711830				
4,00	3,15	M5	M4	6722767	6711834				
4,50	3,55	M6		6722770	6711837				
5,00	4,00		M5	6722772	6711839				
5,60	4,50	M7		6722777	6711842				
6,30	5,00	M8	M6	6722782	6711847	6715689			6721921
7,10	5,60	M9	M7	6722785	6711853				
8,00	6,30	M10	M8		6711858	6715694			6721926
9,00	7,10	M12			6711864	6715698			6721930
10,00	8,00		M10		6711871	6715701			6721933
11,20	9,00	M14			6711876	6715706	6718775		6721937
12,50	10,00	M16				6715709	6718777		6721939
14,00	11,20	M18				6715713	6718781		6721944
16,00	12,50	M22				6715720	6718784		
18,00	14,00	M24				6715724	6718787	6720742	
20,00	16,00	M27					6718790	6720729	
22,40	18,00	M33					6718793	6720741	
25,00	20,00	M36					6718795	6720731	
28,00	22,40	M39						6720740	
31,50	25,00	M45-M48						6720743	

* 也适用于中心冷却供给 (IKP)

* Also suitable for central coolant feed (IKP)

WEN — 快换夹头
WEN – Quick change adaptor

bilz



WEN..., JIS

型号 Designation		WEN 0	WEN 1*	WEN 2*	WEN 3*	WEN 4*	WEN 40*
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-7,2	3,5-11,3	7-18	11-28	18-36	6-14
		0	1 + 32	2	3	4	40
	d	22	30	48	70	92	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	4	4	5	6	13	5
	l4	19,5	21,5	35	55,5	63	32
	l5	29	34	60	83	137	54
		8	10	15	25	25	15
	(IKP)	–	6,5	14	25	25	10

用于符合JIS标准的丝锥
 For taps according to JIS

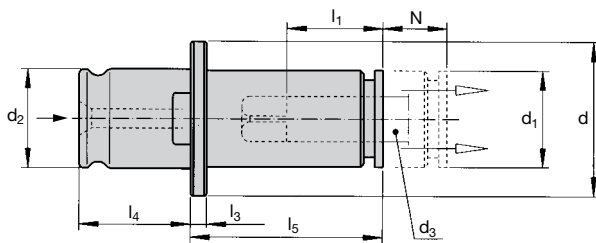
柄径 D	方尾 VKT	JIS	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
3,5	2,0	M2,5	x					
4,0	3,2	M3 – M3,5	x	x				
5,0	4,0	M4 – M4,5	6722772	6711839				
5,5	4,5	M5	6722775	6711877				
6,0	4,5	M6	6722788	6711843				6721919
6,2	5,0	M7 – M8	6722781	6711878				6721941
7,0	5,5	M9 – M10	6722784	6711852	6715691			6721923
8,0	6,5	M11		x	6715727			x
8,5	6,5	M12		6711862	6715728			6721943
10,5	8,0	M14		6711872	6715702			6721934
12,5	10,0	M16			6715709	6718777		6721939
13,0	10,0	M17			6715710	6718778		x
14,0	11,0	M18			6715712	6718780		6721940
15,0	12,0	M20			6715718	6718782		
17,0	13,0	M22			6715726	x		
19,0	15,0	M24				x	x	
20,0	15,0	M27				x	x	
21,0	17,0	M28				x	x	
23,0	17,0	M30				x	x	
24,0	19,0	M32				x	x	
25,0	19,0	M33				x	x	
26,0	21,0	M34 – M35				x	x	
28,0	21,0	M36 – M38				x	x	
30,0	23,0	M39 – M40					x	
32,0	26,0	M42					x	
35,0	26,0	M45					x	
38,0	29,0	M48						

* 也适用于中心冷却供给 (IKP)

* Also suitable for central coolant feed (IKP)

x – 按需定制

x - on request



WEN...-KP, DIN

用于无内部冷却液供应的丝锥和挤压丝锥

for taps, roll former without internal coolant supply

型号

Designation

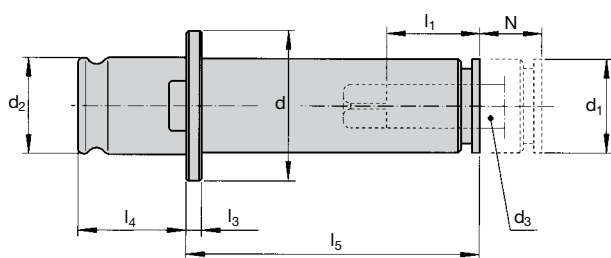
		WEN 1-KP	WEN 2-KP	WEN 3-KP
		M3-M12	M8-M20	M14-M33
	d3	3,5-11,3	7-18	11-28
		1	2	3
	d	30	48	70
	d1	19	30	48
	d2	19	31	48
	l1	17	30	44
	l3	4	5	6
	l4	21,5	35	55,5
	l5	34	60	83
		6,5	14	25

用于符合DIN标准的丝锥

For taps according to DIN

柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.
3,50	2,70	M3	M5		6713054		
4,00	3,00	M3,5			6713055		
4,50	3,40	M4	M6		6713051		
5,50	4,50		M7		—		
6,00	4,90	M4,5			6713052		
6,00	4,90	M5			6713052		
6,00	4,90	M6	M8		6713052		
7,00	5,50	M7	M9-M10		6713050	6716477	
8,00	6,20	M8			6713042	6716456	
9,00	7,00	M9	M12		6713044	6716458	
10,00	8,00	M10	M10		6713046	6716460	
11,00	9,00		M14		6713047	6716461	6719217
12,00	9,00	M12	M16			6716463	6719225
14,00	11,00		M18			6716465	6719218
16,00	12,00		M20			6716467	6719228
18,00	14,50		M22-M24			6716470	6719216
20,00	16,00		M27				6719221
22,00	18,00		M30				6719219
25,00	20,00		M33				6719222
28,00	22,00		M36				6719223

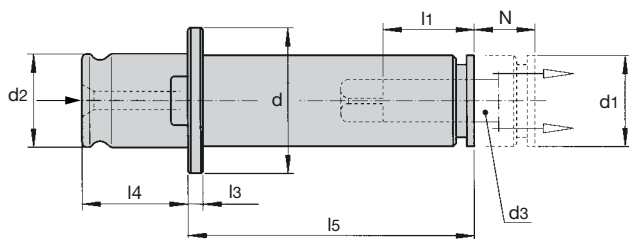
WEN — 快换夹头
WEN – Quick change adaptor



WEN-...

型号 Designation						d	d1	d2	l1	l3	l4	l5																
WEN0-...	M 1 – M 10	2,5 - 7,2	0	8	22	13	13	15	4	19,5	40	50	60	70	80	90	100	110	120									
WEN1-...	M 3 – M 12	3,5 - 11,3	1 + 32	10	30	19	19	17	4	21,5	40	50	60	70	80	90	100	110	120	130	140							
WEN2-...	M 8 – M 20	7,0 - 18	2	15	48	31	31	30	5	35	70	80	90	100	110	120	130	140	150	160								
WEN3-...	M14 – M 33	11 - 28	3	25	70	48	48	44	6	55,5	100	120	140	160	180													
WEN40-...	M 6 – M 18	6,0 - 14	40	15	40	25	26	30	5	32	60	70	80	90	100	110	120	130	140	150								

订购示例 Example for ordering
 Bilz WEN 1-90-7x5,5



WEN...-KP...

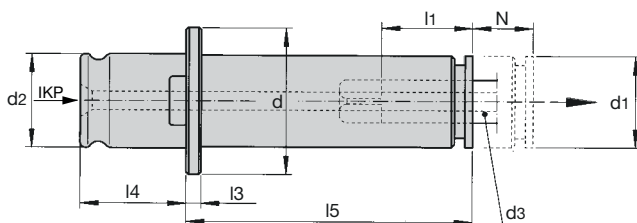
用于无内部冷却液供应的丝锥和挤压丝锥

for taps, roll former without internal coolant supply

型号 Designation				d	d1	d2	l1	l3	l4	l5													
WEN1-KP...	M 3 - M 12	3,5 - 11,3	1	6,5	30	19	19	17	4	21,5	40	50	60	70	80	90	100	110	120	130	140		
WEN2-KP...	M 8 - M 20	7,0 - 18	2	14	48	30	31	30	5	35	70	80	90	100	110	120	130	140	150	160			
WEN3-KP...	M14 - M 33	11 - 28	3	25	70	48	48	44	6	55,5	100	120	140	160	180								

订购示例 Example for ordering

Bilz WEN2-KP-70-11 x 9



WEN...-IKP...

用于带内部冷却液供应的丝锥和挤压丝锥

for taps, roll former with internal coolant supply

型号 Designation				d	d1	d2	l1	l3	l4	l5													
WEN1-IKP...	M 3 - M 12	3,5 - 11,3	1	6,5	30	19	19	17	4	21,5	40	50	60	70	80	90	100	110	120	130	140		
WEN2-IKP...	M 8 - M 20	7,0 - 18	2	14	48	30	31	30	5	35	70	80	90	100	110	120	130	140	150	160			
WEN3-IKP...	M14 - M 33	11 - 28	3	25	70	48	48	44	6	55,5	100	120	140	160	180								

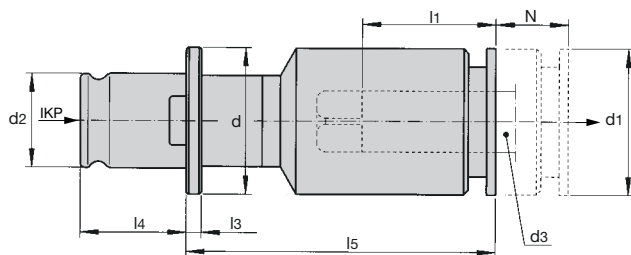
也适用于中心冷却供给 (IKP)

Also suitable for central coolant feed (IKP)

订购示例 Example for ordering

Bilz WEN1-IKP-100-6 x 4,9

WENE — 快换夹头
WENE – Quick change adaptor



WENE..., DIN

延长了夹持范围

extended clamping range

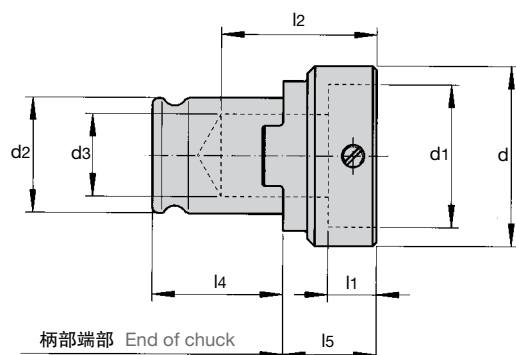
型号 Designation		WENE 0	WENE 1	WENE 2
		M12-M14	M16-M18	M27-M30
	d3	7,2-11	11,3-14	18-22
		0	1-32	2
	d	22	30	48
	d1	19	30	48
	d2	13	19	31
	l1	17	30	44
	l3	4	4	5
	l4	19,5	21,5	35
	l5	48	62	102
		8	10	15

用于符合DIN标准的丝锥
 For taps according to DIN

柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.
8,00	6,20	M8			6722797		
9,00	7,00	M9	M12		6722801		
10,00	8,00	M10	M10		6722807		
11,00	9,00		M14		6722808		
12,00	9,00	M12	M16			6711920	
14,00	11,00		M18			6711924	
18,00	14,50		M22-M24				6715777
20,00	16,00		M27				6715771
22,00	18,00		M30				6715774

也适用于中心冷却供给 (IKP)

Also suitable for central coolant feed (IKP)



WE/SCH

Zur Aufnahme von Schneideisen DIN-EN 22568

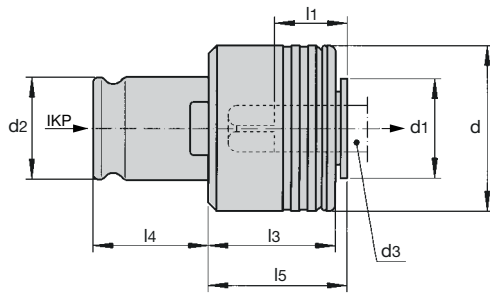
For dies DIN-EN 22568

型号

Designation

型号 Designation					WE1		WE2		WE3		
						M1 – M15		M3 – M20		M10 – M36	
					d3	12,5 – 14,2		18 – 22		25 – 37	
						1 + 32		2		3	
					d	25 – 48		30 – 57		60 – 82	
					d2	19		31		48	
					l1	4,8 – 13		4,8 – 17		10 – 23	
					l2	28 – 38		55 – 64		85 – 93	
					l4	21,5		35		55,5	
					l5	14 – 24		20 – 29		30 – 38	
SCH	M...	M... 细牙 /fine	惠氏螺纹	惠氏螺纹 G	Id. No.	l2	Id. No.	l2	Id. No.	l2	
16 x 5	M 1 - M 2,6	M 1 - M 2,6			6711408	28					
20 x 5	M 3 - M 4	M 3 - M 6			6711409	28	6774094	55			
20 x 7	M 5 + M 6		1/4"		6711410	30	6715354	56			
25 x 9	M 7 - M 9	M 7 - M 9	5/16"		6711411	33	6774096	55			
30 x 11	M10 + M11	M10 + M11	3/8" + 7/16"		6711412	35	6715355	57	6718541	85	
38 x 10		M12 - M15		G 1/8" + G 1/4"	6711413	34	6774100	56	6718542	83	
38 x 14	M12 + M14		1/2"		6711414	38	6774102	60	6718543	87	
45 x 14		M16 - M20		G 3/8" + G 1/2"			6774104	60	6718544	87	
45 x 18	M16 - M20		5/8" + 3/4"				6774106	64	6718546	91	
55 x 16		M22 - M26	7/8" + 1"	G 5/8"			6774108	62	6718547	85	
55 x 22	M22 + M24								6718549	90	
65 x 18		M27 - M36		G 3/4" + G 1"					6718550	87	
65 x 25	M27 - M36		1 1/8" + 1 3/8"						6718551	93	

WES — 带安全夹紧装置的快换夹头
WES – Quick change adaptor with safety clutch



WES...B, DIN

型号 Designation		WES 0 B	WES 1 B	WES 2 B	WES 3 B	WES 4 B	WES 40 B
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-8	3,5-11,3	7-18	11-28	18-36	6-14
		0	1+32	2	3	4	40
	d	23	32	50	72	95	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	20	25	31	41	61	27
	l4	19,5	21,5	35	55,5	63	32
	l5	21	25	34	45	68	30

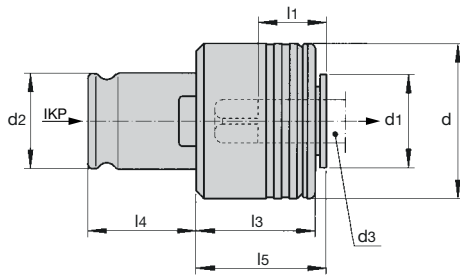
用于符合DIN标准的丝锥
 For taps according to DIN

柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
2,50	2,10	M1			6722736					
2,50	2,10	M1,1								
2,50	2,10	M1,2								
2,50	2,10	M1,4			9075774					
2,50	2,10	M1,6			9075781					
2,50	2,10	M1,8								
2,80	2,10	M2			6722737					
2,80	2,10	M2,2								
2,80	2,10	M2,5			9070010					
2,80	2,10		M3,5							
2,80	2,10		M4		6722648	6711571				
3,50	2,70	M3			6722739	6711785				
3,50	2,70		M5		6722747	6711796				
4,00	3,00	M3,5			6722740	6711786				
4,50	3,40	M4			6722742	6711788				
4,50	3,40		M6		6722749	6711798				6722161
5,50	4,50		M7		6722681	6711655				
6,00	4,90	M4,5								
6,00	4,90	M5			6722743	6711790				
6,00	4,90	M6			6722750	6711799				6722146
6,00	4,90		M8		6722753	6711804	6715677			6721915
7,00	5,50	M7				6711801				
7,00	5,50		M9							
7,00	5,50		M10		6722692	6711614	6715492			6722148
8,00	6,20	M8			6722696	6711624	6715498			6722149
9,00	7,00	M9								
9,00	7,00		M12			6711633	6715503			6722151
10,00	8,00	M10				6711646	6715511			6722153

也适用于中心冷却供给 (IKP)
 Also suitable for central coolant feed (IKP)



WES — 带安全夹紧装置的快换夹头
WES – Quick change adaptor with safety clutch



WES...B, DIN							
型号 Designation		WES 0 B	WES 1 B	WES 2 B	WES 3 B	WES 4 B	WES 40 B
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-8	3,5-11,3	7-18	11-28	18-36	6-14
		0	1+32	2	3	4	40
	d	23	32	50	72	95	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	20	25	31	41	61	27
	l4	19,5	21,5	35	55,5	63	32
	l5	21	25	34	45	68	30

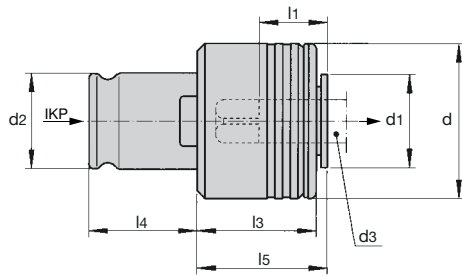
用于符合DIN标准的丝锥
 For taps according to DIN

柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
11,00	9,00	M12	M14			6711793	6715514	6718671		6722154
12,00	9,00						6715672			
12,00	9,00		M16				6715521	6718673		6722157
14,00	11,00		M18				6715532	6718677		6722159
16,00	12,00		M20				6715543	6718680		
18,00	14,50		M22				6715676	6718764	6720713	
18,00	14,50		M24				6715680	6718770	6720720	
20,00	16,00		M27					6718689	6720714	
22,00	18,00		M30					6718766	6720930	
25,00	20,00		M33					6718767	6720715	
28,00	22,00		M36					6718768	6720933	
32,00	24,00		M39						6720716	
32,00	24,00		M42						6720723	
36,00	29,00		M45						6720717	
36,00	29,00		M48						6720724	

也适用于中心冷却供给 (IKP)
 Also suitable for central coolant feed (IKP)



WES — 带安全夹紧装置的快换夹头
WES – Quick change adaptor with safety clutch



WES...B, ISO

型号 Designation		WES 0 B	WES 1 B	WES 2 B	WES 3 B	WES 4 B	WES 40 B
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-8	3,5-11,3	7-18	11-28	18-36	6-14
		0	1+32	2	3	4	40
	d	23	32	50	72	95	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	20	25	31	41	61	27
	l4	19,5	21,5	35	55,5	63	32
	l5	21	25	34	45	68	30

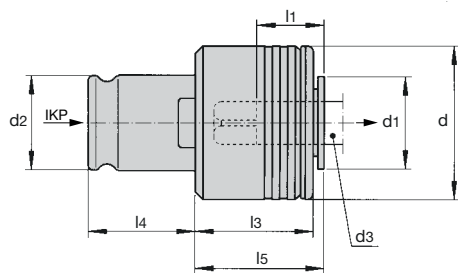
用于符合ISO标准的丝锥 For taps according to ISO

柄径 D	方尾 VKT	ISO 529	ISO 529 加强型 reinforced		Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
2,24	1,80	M3		6722703	6711568				
2,50	2,00		M2	6722645	6711569				
2,50	2,00	M3,5		6722645	6711569				
2,80	2,24		M2,2	6722649	6711572				
2,80	2,24		M2,5	6722649	6711784				
3,15	2,50	M4		6722746	6711795				
3,15	2,50		M3	6722738	6711576				
3,55	2,80	M4,5		6722660					
3,55	2,80		M3,5	6722660	6711581				
4,00	3,15	M5		6722748	6711797				
4,00	3,15		M4	6722741	6711787				
4,50	3,55	M6		6722671	6711588				
5,00	4,00		M5	6722676	6711596				
5,60	4,50	M7		6722683	6711600				
6,30	5,00	M8		6722751	6711800	6715489			6722147
6,30	5,00		M6	6722744	6711791	6715669			
7,10	5,60	M9	M7	6722693	6711615				
8,00	6,30	M10		6722752	6711802	6715678			6721916
8,00	6,30		M8	6722745	6711792	6715670			6722150
9,00	7,10	M12			6711634	6715504			6722152
10,00	8,00		M10		6711646	6715511			6722153
11,20	9,00	M14			6711653	6715517	6718672		6722156
12,50	10,00	M16				6715524	6718675		6722158
14,00	11,20	M18				6715673	6718763		6722160
14,00	11,20	M20				6715679	6718769		
16,00	12,50	M22				6715674	6718681		
18,00	14,00	M24				6715675	6718685	6720944	
20,00	16,00	M27					6718689	6720714	
20,00	16,00	M30					6718771	6720721	
22,40	18,00	M33					6718693	6720943	
25,00	20,00	M36					6718772	6720722	
28,00	22,40	M39					6718702	6720718	
28,00	22,40	M42						6720725	
31,50	25,00	M45						6720719	
31,50	25,00	M48						6720726	
35,50	28,00	M52-M56						6720946	

也适用于中心冷却供给 (IKP)

Also suitable for central coolant feed (IKP)

WES — 带安全夹紧装置的快换夹头
WES – Quick change adaptor with safety clutch



WES...B, JIS							
型号 Designation		WES 0 B	WES 1 B	WES 2 B	WES 3 B	WES 4 B	WES 40 B
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-8	3,5-11,3	7-18	11-28	18-36	6-14
		0	1+32	2	3	4	40
	d	23	32	50	72	95	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	20	25	31	41	61	27
	l4	19,5	21,5	35	55,5	63	32
	l5	21	25	34	45	68	30

用于符合JIS标准的丝锥
 For taps according to JIS

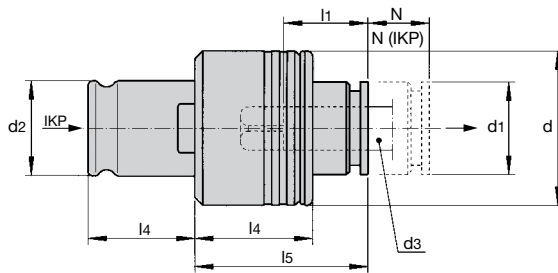
柄径 D	方尾 VKT	JIS	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
3,5	2,0	M2,5						
4,0	3,2	M3-M3,5	6722720	6711663				
5,0	4,0	M4-M4,5	6722676	6711596				
5,5	4,5	M5	6722681	6711655				
6,0	4,5	M6	6722697	6711602				
6,2	5,0	M7-M8	6722687	6711659	6715558			x
7,0	5,5	M9-M10	6722692	6711614	6715492			6722148
8,0	6,5	M11		6711660	6715557			x
8,5	6,5	M12		6711631	6715559			x
10,5	8,0	M14		6711648	6715512	6718669		x
12,5	10,0	M16			6715524	6718675		6722158
13,0	10,0	M17			6715527	6718676		x
14,0	11,0	M18			6715532	6718677		6722159
15,0	12,0	M20			6715538	6718679		
17,0	13,0	M22			6715553	6718713		
19,0	15,0	M24				6718707	x	
20,0	15,0	M27				6718688	x	
21,0	17,0	M28					x	
23,0	17,0	M30				6718708	6720949	
24,0	19,0	M32				6718697	x	
25,0	19,0	M33				6718710	x	
26,0	21,0	M34-M35				6718706	x	
28,0	21,0	M36-M38				6718718	6720953	
30,0	23,0	M39-M40					6720955	
32,0	26,0	M42					6720947	
35,0	26,0	M45					6720950	
38,0	29,0	M48					6720958	

也适用于中心冷却供给 (IKP)
 Also suitable for central coolant feed (IKP)

x – 按需定制
 x - on request

WESN — 带安全夹紧装置的快换夹头
WESN – Quick change adaptor with safety clutch

bilz



WESN...B, DIN

型号 Designation		WESN 0 B	WESN 1 B *	WESN 2 B *	WESN 3 B *	WESN 4 B *	WESN 40 B *
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-7,2	3,5-11,3	7-18	11-28	18-36	6-14
		0	1+32	2	3	4	40
	d	23	32	50	72	95	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	20	25	31	41	61	27
	l4	19,5	21,5	35	55,5	63	32
	l5	29	34	60	83	137	54
		8	10	15	25	25	15
	(IKP)	–	6,5	14	25	25	10

用于符合DIN标准的丝锥
 For taps according to DIN

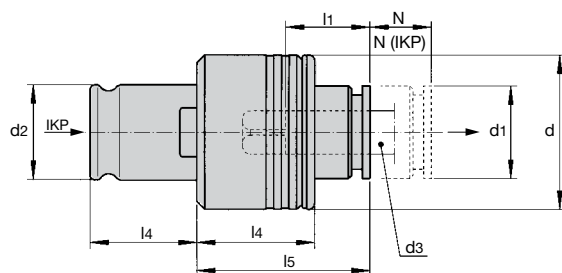
柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
2,80	2,10	M1								
2,80	2,10	M1,1								
2,80	2,10	M1,2								
2,80	2,10	M1,4								
2,80	2,10	M1,6								
2,80	2,10	M1,8								
2,80	2,10	M2								
2,80	2,10	M2,2								
2,80	2,10	M2,5								
2,80	2,10		M3,5							
2,80	2,10		M4		6723018	6713762				
3,50	2,70	M3			6723067	6713858				
3,50	2,70		M5		6723074	6713867				
4,00	3,00	M3,5			6723025	6713768				
4,50	3,40	M4			6723069	6713860				
4,50	3,40		M6		6723076	6713869				
5,50	4,50		M7							
6,00	4,90	M4,5				6713780				
6,00	4,90	M5			6723070	6713861				
6,00	4,90	M6			6723077	6713870				6722169
6,00	4,90		M8		6723079	6713874	6717142			6722191
7,00	5,50	M7			6723072	6713872				
7,00	5,50		M9							
7,00	5,50		M10		6723041	6713786	6717017			6722171
8,00	6,20	M8				6713792	6717019			6722173
9,00	7,00	M9					6717140			
9,00	7,00		M12			6713797	6717024			6722175
10,00	8,00	M10				6713803	6717029			6722178

* 也适用于中心冷却供给 (IKP)

* Also suitable for central coolant feed (IKP)



WESN — 带安全夹紧装置的快换夹头
WESN – Quick change adaptor with safety clutch



WESN...B, DIN							
型号 Designation		WESN 0 B	WESN 1 B *	WESN 2 B *	WESN 3 B *	WESN 4 B *	WESN 40 B *
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-7,2	3,5-11,3	7-18	11-28	18-36	6-14
		0	1 + 32	2	3	4	40
	d	23	32	50	72	95	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	20	25	31	41	61	27
	l4	19,5	21,5	35	55,5	63	32
	l5	29	34	60	83	137	54
	N +	8	10	15	25	25	15
	(IKP)	–	6,5	14	25	25	10

用于符合DIN标准的丝锥
 For taps according to DIN

柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
11,00	9,00	M12	M14			6717032	6719568			6722180
12,00	9,00									
12,00	9,00		M16			6717035	6719570			6722182
14,00	11,00		M18			6717042	6719572			6722184
16,00	12,00		M20			6717047	6719575			
18,00	14,50		M22			6717053	6719619	6721123		
18,00	14,50		M24			6717053	6719623	6721139		
20,00	16,00		M27				6719620	6721124		
22,00	18,00		M30				6719586	6721125		
25,00	20,00		M33				6719621	6721126		
28,00	22,00		M36					6721127		
32,00	24,00		M39					6721129		
32,00	24,00		M42					6721142		
36,00	29,00		M45					6721131		
36,00	29,00		M48					6721143		

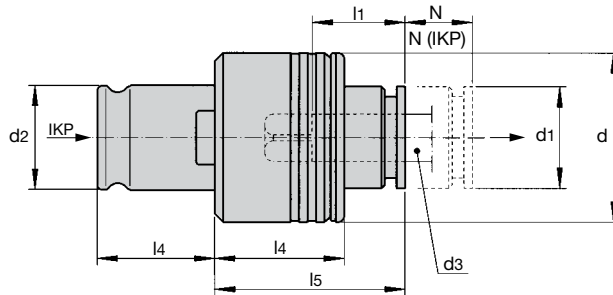
* 也适用于中心冷却供给 (IKP)

* Also suitable for central coolant feed (IKP)

WESN — 快换攻丝夹头带过载保护和长度调节

WESN – Quick change adaptor with safety clutch and length adjustment

bilz



WESN...B, ISO

型号 Designation		WESN 0 B	WESN 1 B*	WESN 2 B*	WESN 3 B*	WESN 4 B*	WESN 40 B*
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-7,2	3,5-11,3	7-18	11-28	18-36	6-14
		0	1+32	2	3	4	40
	d	23	32	50	72	95	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	20	25	31	41	61	27
	l4	19,5	21,5	35	55,5	63	32
	l5	29	34	60	83	137	54
		8	10	15	25	25	15
	(IKP)	–	6,5	14	25	25	10

用于符合ISO标准的丝锥
For taps according to ISO

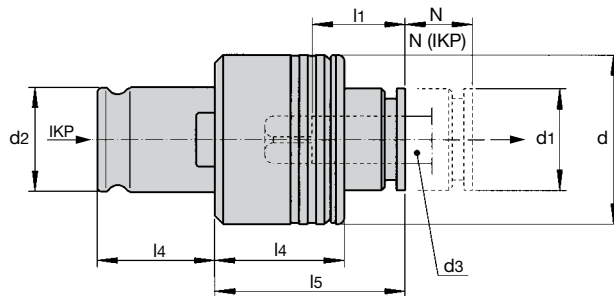
柄径 D	方尾 VKT	ISO 529	ISO 529 加强型 reinforced	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
2,24	1,80	M3		6723045	6713759				
2,50	2,00		M2	6723016	6713760				
2,50	2,00	M3,5		6723016	6713760				
2,80	2,24		M2,2	6723019					
2,80	2,24		M2,5	6723019					
3,15	2,50	M4		6723073	6713866				
3,15	2,50		M3	6723066	6713857				
3,55	2,80	M4,5		6723023	6713765				
3,55	2,80		M3,5	6723023	6713765				
4,00	3,15	M5		6723075	6713868				
4,00	3,15		M4	6723068	6713859				
4,50	3,55	M6		6723029	6713772				
5,00	4,00		M5	6723031	6713774				
5,60	4,50	M7		6723034	6713778				6722168
6,30	5,00	M8		6723078	6713871	6717016			6722170
6,30	5,00		M6	6723071	6713862				
7,10	5,60	M9	M7	6723042	6713787	6717018			6722172
8,00	6,30	M10			6713873	6717143			6722192
8,00	6,30		M8		6713864	6717139			6722174
9,00	7,10	M12			6713798	6717025			6722176
10,00	8,00		M10		6713803	6717029			6722178

* 也适用于中心冷却供给 (IKP)

* Also suitable for central coolant feed (IKP)



WESN — 快换攻丝夹头带过载保护和长度调节
WESN – Quick change adaptor with safety clutch and length adjustment



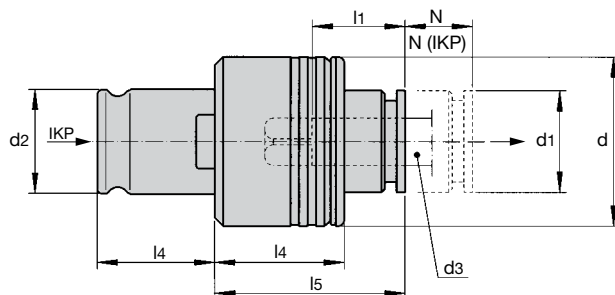
WESN...B, ISO									
型号 Designation				WESN 0 B	WESN 1 B★	WESN 2 B★	WESN 3 B★	WESN 4 B★	WESN 40 B★
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18		
	d3	2,5-7,2	3,5-11,3	7-18	11-28	18-36	6-14		
		0	1+32	2	3	4	40		
	d	23	32	50	72	95	40		
	d1	13	19	30	48	60	25		
	d2	13	19	31	48	60	26		
	l1	15	17	30	44	71	30		
	l3	20	25	31	41	61	27		
	l4	19,5	21,5	35	55,5	63	32		
	l5	29	34	60	83	137	54		
	(IKP)	8	10	15	25	25	15		
		–	6,5	14	25	25	10		
用于符合ISO标准的丝锥 For taps according to ISO									
柄径 D	方尾 VKT	ISO 529	ISO 529 加强型 reinforce	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
11,20	9,00	M14				6717034	6719569		6722181
12,50	10,00	M16				6717038	6719571		6722183
14,00	11,20	M18				6717141	6719618		6722185
14,00	11,20	M20				6717144	6719622		
16,00	12,50	M22				6417048	6719576		
18,00	14,00	M24				6717052	6719580	6721134	
20,00	16,00	M27					6719620	6721124	
20,00	16,00	M30					6719624	6721140	
22,40	18,00	M33					6719587	6721133	
25,00	20,00	M36					6719590	6721141	
28,00	22,40	M39					6719593	6721132	
28,00	22,40	M42						6721144	
31,50	25,00	M45						6721135	
31,50	25,00	M48						6721145	
35,50	28,00	M52-M56						6721136	

* 也适用于中心冷却供给 (IKP)

* Also suitable for central coolant feed (IKP)

WESN — 带安全夹紧装置的快换夹头
WESN – Quick change adaptor with safety clutch

bilz



WESN...B, JIS

型号 Designation		WESN 0 B	WESN 1 B*	WESN 2 B*	WESN 3 B*	WESN 4 B*	WESN 40 B*
		M1-M10	M3-M12	M8-M20	M14-M33	M22-M48	M6-M18
	d3	2,5-7,2	3,5-11,3	7-18	11-28	18-36	6-14
		0	1 + 32	2	3	4	40
	d	23	32	50	72	95	40
	d1	13	19	30	48	60	25
	d2	13	19	31	48	60	26
	l1	15	17	30	44	71	30
	l3	20	25	31	41	61	27
	l4	19,5	21,5	35	55,5	63	32
	l5	29	34	60	83	137	54
		8	10	15	25	25	15
	(IKP)	–	6,5	14	25	25	10

用于符合JIS标准的丝锥
 For taps according to JIS

柄径 D	方尾 VKT	JIS	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.	Id. No.
3,5	2,0	M2,5	x	x				
4,0	3,2	M3 – M3,5	x	x				
5,0	4,0	M4 – M4,5	6723031	6713774				
5,5	4,5	M5	x	x				
6,0	4,5	M6	6723044	6713779				x
6,2	5,0	M7 – M8	6723037	6713809				x
7,0	5,5	M9 – M10	6723041	6713786	6717017			6722171
8,0	6,5	M11		6713810	x			x
8,5	6,5	M12		6713796	x			x
10,5	8,0	M14		x	6717030			x
12,5	10,0	M16			6717038	6719571		6722183
13,0	10,0	M17			6717039	x		x
14,0	11,0	M18			6717042	6719572		6722184
15,0	12,0	M20			6717046	x		
17,0	13,0	M22			x	x		
19,0	15,0	M24				x	x	
20,0	15,0	M27				x	x	
21,0	17,0	M28				x	x	
23,0	17,0	M30				x	x	
24,0	19,0	M32				x	x	
25,0	19,0	M33				x	x	
26,0	21,0	M34 – M35				x	x	
28,0	21,0	M36 – M38				x	x	
30,0	23,0	M39 – M40					x	
32,0	26,0	M42					x	
35,0	26,0	M45					x	
38,0	29,0	M48						

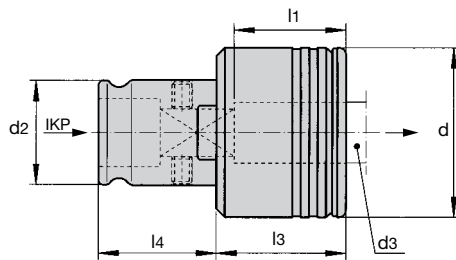
* 也适用于中心冷却供给 (IKP)

* Also suitable for central coolant feed (IKP)

x – 按需定制

x - on request

WESK — 带安全夹紧装置的快换夹头
WESK – Quick change adaptor with safety clutch



WESK...B, DIN

使用调节螺钉延长夹紧范围

extended clamping range with set screws

型号 Designation		WESK 1	WESK 2	WESK 3	WESK 4
		M16	M27 - M30	M39 - M48	M52 - M60
	d3	11,2-12	18-22	28-36	36-45
		1	2	3	4
	d	32	50	72	95
	d2	19	31	48	60
	l1	27,5	32,5	40	54
	l3	25	31	41	61
	l4	21,5	35	55,5	63

用于符合DIN标准的丝锥

For taps according to DIN

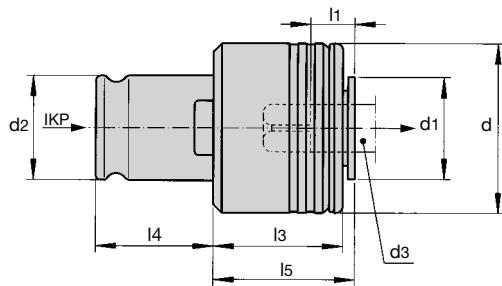
柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.	Id. No.
12,00	9,00	M12	M16		6713642			
18,00	14,50		M22-M24			6716808		
20,00	16,00		M27			6716800		
22,00	18,00		M30			6716801		
28,00	22,00		M36				6719421	
32,00	24,00		M39-M42				6719417	
36,00	29,00		M45-M48				6719420	6720992
40,00	32,00		M52					6720983
45,00	35,00		M56-M60					6720984
仅适合轻载加工! For light machining only!			max. Nm		40 M 14	160 M 24	630 M 42	900 M 48

也适用于中心冷却供给 (IKP)

Also suitable for central coolant feed (IKP)



WESR — 带安全夹紧装置的快换夹头
WESR – Quick change adaptor with safety clutch



WESR...B, DIN

插入深度减小

with reduced inserting depth

型号 Designation		WESR2B	WESR3B	WESR4B
		M8-M20	M14-M33	M22-M48
	d3	7-18	11-28	18-36
		2	3	4
	d	50	72	95
	d1	30	48	60
	d2	31	48	61
	l1	21	25	46
	l3	31	41	61
	l4	35	55,5	63
	l5	34	45	68

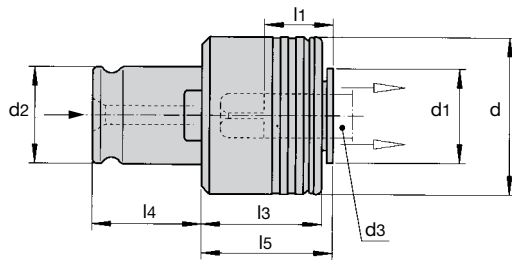
用于符合DIN标准的丝锥

For taps according to DIN

柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.
7,00	5,5				6716840		
8,00	6,20	M8			6716846		
9,00	7,00	M9	M12		6716847		
11,00	9,00		M14		6716825	6719444	
12,00	9,00	M12			6716829	6719445	
12,00	9,00		M16		6716829	6719445	
14,00	11,00		M18		6716817	6719442	
16,00	12,00		M20		6716827	6719446	
18,00	14,50		M22		6716842	6719440	6721031
20,00	16,00		M27			6719449	6721013
22,00	18,00		M30			6719453	6721029
25,00	20,00		M33			6719439	6721010
28,00	22,00		M36			—	6721004
32,00	24,00		M39				6721003
32,00	24,00		M42				6721003
36,00	29,00		M45				6721014
36,00	29,00		M48				6721014

也适用于中心冷却供给 (IKP)

Also suitable for central coolant feed (IKP)



WES...B-KP

用于无内部冷却液供应的丝锥和挤压丝锥
 for taps, roll former without internal coolant supply

型号 Designation		WES1B-KP	WES2B-KP	WES3B-KP
		M3-M12	M8-M20	M14-M33
	d3	3,5-11,3	7-18	11-28
		1	2	3
	d	32	50	72
	d1	19	30	48
	d2	19	31	48
	l1	17	30	44
	l3	25	31	41
	l4	21,5	35	55,5
	l5	25	34	45

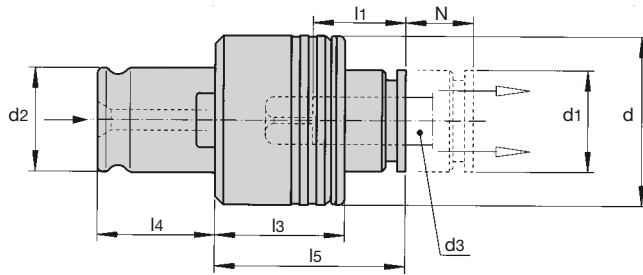
用于符合DIN标准的丝锥
 For taps according to DIN

柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.
3,50	2,70	M3	M5		6713704		
4,00	3,00	M3,5			6713705		
4,50	3,40	M4	M6		6713701		
5,50	4,50		M7		6713717		
6,00	4,90	M4,5			—		
6,00	4,90	M5			6713702		
6,00	4,90	M6	M8		6713758	6716921	
7,00	5,50	M7	M9-M10		6713700	6716923	
8,00	6,20	M8			6713692	6716902	
9,00	7,00	M9	M12		6713694	6716904	
10,00	8,00	M10	M10		6713696	6716906	
11,00	9,00		M14		6713697	6716907	6719513
12,00	9,00	M12	M16			6716909	6719521
14,00	11,00		M18			6716911	6719514
16,00	12,00		M20			6716913	6719524
18,00	14,50		M22-M24			6716916	6719512
20,00	16,00		M27				6719517
22,00	18,00		M30				6719515
25,00	20,00		M33				6719518
28,00	22,00		M36				6719519



50 bar

WESN — 带安全夹紧装置的快换夹头
WESN – Quick change adaptor with safety clutch



WESN...B-KP

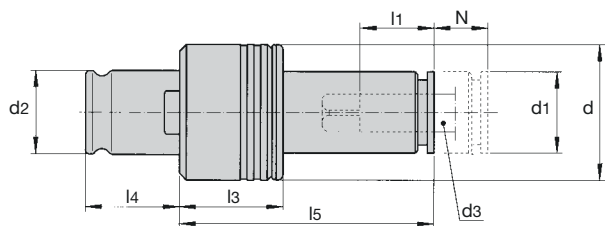
用于无内部冷却液供应的丝锥和挤压丝锥
 for taps, roll former without internal coolant supply

型号 Designation		WESN1B-KP	WESN2B-KP	WESN3B-KP
		M3-M12	M8-M20	M14-M33
	d3	3,5-11,3	7-18	11-28
		1	2	3
	d	32	50	72
	d1	19	30	48
	d2	19	31	48
	l1	17	30	44
	l3	25	31	41
	l4	21,5	35	55,5
	l5	34	60	83
		6,5	14	25

用于符合DIN标准的丝锥
 For taps according to DIN

柄径 D	方尾 VKT	DIN 371	DIN 374	DIN 376	Id. No.	Id. No.	Id. No.
3,50	2,70	M3	M5		6714437		
4,00	3,00	M3,5			6714438		
4,50	3,40	M4	M6		6714434		
5,50	4,50		M7		—		
6,00	4,90	M4,5			6714435		
6,00	4,90	M5			6714435		
6,00	4,90	M6	M8		6714435		
7,00	5,50	M7	M9-M10		6714433	6717600	
8,00	6,20	M8			6714425	6717579	
9,00	7,00	M9	M12		6714427	6717581	
10,00	8,00	M10	M10		6714429	6717583	
11,00	9,00		M14		6714430	6717584	6720033
12,00	9,00	M12	M16			6717586	6720041
14,00	11,00		M18			6717588	6720034
16,00	12,00		M20			6717590	6720044
18,00	14,50		M22-M24			6717593	6720032
20,00	16,00		M27				6720037
22,00	18,00		M30				6720035
25,00	20,00		M33				6720038
28,00	22,00		M36				6720039

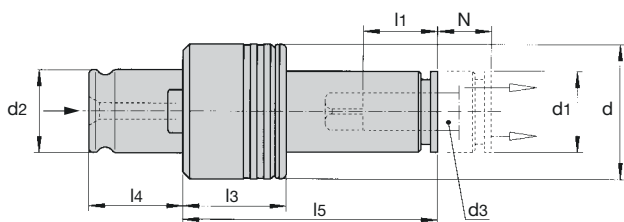
WESN — 带安全夹紧装置的快换夹头
WESN – Quick change adaptor with safety clutch



WESN...B-...

型号 Designation					d	d1	d2	l1	l3	l4	l5													
WESN0B-...	M 1 - M 10	2,5 - 7,2	0	8	23	13	13	15	20	19,5	40	50	60	70	80	90	100	110	120					
WESN1B-...	M 3 - M 12	3,5 - 11,3	1 + 32	10	32	19	19	17	25	21,5	40	50	60	70	80	90	100	110	120	130	140			
WESN2B-...	M 8 - M 20	7,0 - 18,0	2	15	50	30	31	30	31	35	70	80	90	100	110	120	130	140	150	160				
WESN3B-...	M14 - M 33	11,0 - 28,0	3	25	72	48	48	44	41	55,5	100	120	140	160	180									
WESN40B-...	M 6 - M 18	6,0 - 14,0	40	15	40	25	26	30	27	32	60	70	80	90	100	110	120	130	140	150				

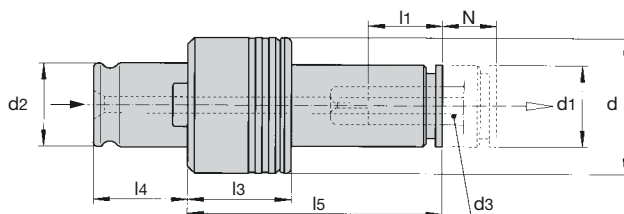
订购示例 Example for ordering
 Bilz WESN1B-80-M8 DIN 371



WESN...B-KP-...

型号 Designation					d	d1	d2	l1	l3	l4	l5													
WESN1B-KP...	M 3 - M 12	3,5 - 11,3	1	6,5	32	19	19	17	25	21,5	40	50	60	70	80	90	100	110	120	130	140			
WESN2B-KP...	M 8 - M 20	7,0 - 18	2	14	50	30	31	30	31	35	70	80	90	100	110	120	130	140	150	160				
WESN3B-KP...	M14 - M 33	11 - 28	3	25	72	48	48	44	41	55,5	100	120	140	160	180									

订购示例 Example for ordering
 Bilz WESN1B-KP-80-M8 DIN 371



WESN...-IKP-...

型号 Designation					d	d1	d2	l1	l3	l4	l5													
WESN1B-IKP...	M 3 - M 12	3,5 - 11,3	1	6,5	32	19	19	17	25	21,5	40	50	60	70	80	90	100	110	120	130	140			
WESN2B-IKP...	M 8 - M 20	7,0 - 18	2	14	50	30	31	30	31	35	70	80	90	100	110	120	130	140	150	160				
WESN3B-IKP...	M14 - M 33	11 - 28	3	25	72	48	48	44	41	55,5	100	120	140	160	180									

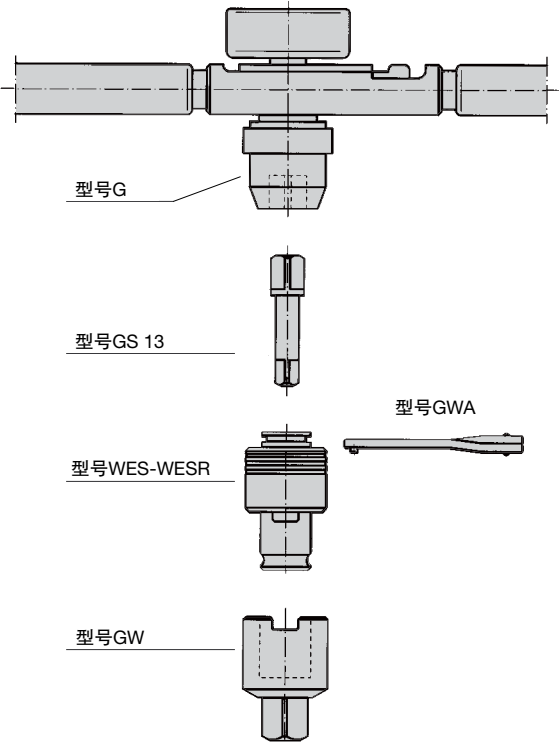
也适用于中心冷却供给 (IKP)
 Also suitable for central coolant feed (IKP)

订购示例 Example for ordering
 Bilz WESN1B-IKP-80-M8 DIN 371

G-GE

用于快换夹头调节和检测扭矩保护的装置。
For quick change adaptors to adjust and check the safety clutch.

用于0-3号的快换夹头
For adaptors size 0-3



G	= 调节扳手	Adjustment Wrench
GS	= 设置柄	Setting shank
WES-WESR	= 快换夹头	Adaptor
GW	= 设置座	Setting socket
GWA	= 调节销扳手	Adjustable pin wrench
RD	= 棘轮扳手	Ratchet with insert
GE	= 调节设置	Adjustment unit

附件 Accessories

		G	Bereich Range	Mt _{max} Nm	GS 13	GS 25	GWA	GW
0	I	G0	M3 – M8	0,5 – 15	2,5-7,2	–	GWA0	GW0
	Id. No.	6721675				–	6721800	6721790
1	I	G1	M5 – M12	2,5 – 30	3,5-11,3	–	GWA1	GW1
	Id. No.	6721680				–	6721801	6721791
40	I	G2	M8 – M20	10 – 120	6-14	–	GWA40	GW40
	Id. No.	6721684				–	6721803	6721794
2	I	G2	M8 – M20	10 – 120	7-18	–	GWA40	GW2
	Id. No.	6721684				–	6721803	6721792
3	I	G3	M14 – M33	45 – 300	11-28	–	GWA3	GW3
	Id. No.	6721688				–	6721804	6721795

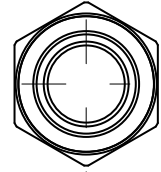
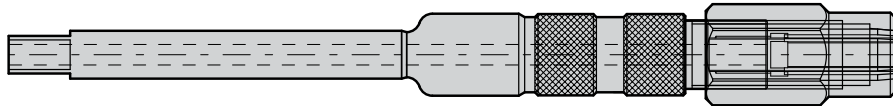
当订购设置柄型号GS，请说明柄部直径和方尾尺寸，或者螺纹或者在快换夹头中使用的DIN标准丝锥。

When ordering setting shanks Type GS, please state shank Ø and square, or thread and DIN of tap used in the adaptor.

型号 Designation	Ø x □	Ø x □	Ø x □	尺寸 Size 0	尺寸 Size 1	尺寸 Size 40	尺寸 Size 2	尺寸 Size 3	DIN	ISO	JIS	订货号 Id. No.
GS13-POS.004-2,1x1,6	2,24 x 1,8			x						x		6721694
GS13-POS.003-2,4x2	2,5 x 2,0			x						x		6721696
GS13-POS.004-2,5x2,1	2,8 x 2,1			x					x			6721697
GS13-POS.005-2,8x2,3	2,8 x 2,24			x						x		6721698
GS13-POS.063-3,1x2,5	3,15 x 2,5			x						x		6721751
GS13-POS.003-2,4x2,0	3,5 x 2,0			x	x						x	6721696
GS13-POS.007-3,5x2,5	3,5 x 2,7			x	x				x			6721700
GS13-POS.006-3,25x2,6	3,55 x 2,8			x	x					x		6721699
GS13-POS.009-3,8x3	4,0 x 3,0			x	x				x			6721702
GS13-POS.010-4,0x3,2	4,0 x 3,2	4,0 x 3,15		x	x					x	x	6721703
GS13-POS.011-4,4x3,4	4,5 x 3,4	4,5 x 3,55		x	x				x	x		6721704
GS13-POS.065-5x3,8	5,0 x 4,0			x	x					x	x	6721752
GS13-POS.016-5x4,2	5,5 x 4,3	5,5 x 4,5		x	x				x		x	6721709
GS13-POS.075-5,5x4,5	5,6 x 4,5	6,0 x 4,5		x	x					x	x	6721760
GS13-POS.018-5,9x4,8	6,0 x 4,9	6,2 x 5,0	6,3 x 5,0	x	x	x			x	x	x	6721711
GS13-POS.022-7x5,4	7,0 x 5,5	7,1 x 5,6		x	x	x	x		x	x	x	6721715
GS13-POS.027-7,9x6	8,0 x 6,2	8,0 x 6,3			x	x	x		x	x		6721718
GS13-POS.029-8,5x6,2	8,5 x 6,5				x	x	x				x	6721720
GS13-POS.031-9x7	9,0 x 7,0	9,0 x 7,1			x	x	x		x	x		6721722
GS13-POS.034-9,8x7,75	10,0 x 8,0				x	x	x		x	x		6721725
GS13-POS.077-10,5x8	10,5 x 8,0				x	x	x				x	6721762
GS13-POS.037-10,9x9	11,0 x 9,0	11,2 x 9,0			x	x	x	x	x	x		6721728
GS13-POS.038-11,8x9	12,0 x 9,0					x	x	x	x			6721729
GS13-POS.039-11,8x10	12,5 x 10,0					x	x	x		x	x	6721730
GS13-POS.042-13x10	13,0 x 10,0					x	x	x			x	6721733
GS13-POS.045-14x11	14,0 x 11,0	14,0 x 11,2				x	x	x	x	x	x	6721736
GS13-POS.048-15x12	15,0 x 12,0						x	x			x	6721739
GS13-POS.050-16x12	16,0 x 12,0	16,0 x 12,5					x	x	x	x		6721741
GS13-POS.052-17x13	17,0 x 13,0						x	x		x	x	6721743
GS13-POS.055-18x14	18,0 x 14,5						x	x	x			6721745
GS13-POS.056-20x15	20,0 x 15,0	20,0 x 16,0						x	x	x	x	6721746
GS13-POS.067-21x17	21,0 x 17,0							x			x	6721754
GS13-POS.068-22x18	22,0 x 18,0	22,4 x 18,0						x	x	x		6721755
GS13-POS.067-21x17	23,0 x 17,0							x			x	6721754
GS13-POS.058-24x18	24,0 x 19,0	25,0 x 19,0						x			x	6721748
GS13-POS.069-25x20	25,0 x 20,0	26,0 x 21,0	28,0 x 21,0					x	x	x	x	6721756
GS13-POS.070-27,5x22	28,0 x 22,0	28,0 x 22,4						x	x	x		6721757
调节工具尺寸 Adjustment tools Size 0 / M3-M8 / 0,5-15 Nm												0
G0, (0,5-15Nm)												6721675
GW0												6721790
GWA0												6721800
GS13-POS.												s.o./s.a.
调节工具尺寸 Adjustment tools Size 1 / M5-M12 / 2,5-30 Nm												1
G1, (2,5-30Nm)												6721680
GW1												6721791
GWA1												6721801
GS13-POS.												s.o./s.a.
调节工具尺寸 Adjustment tools Size 40 / M8-M20 / 10-120 Nm												40
G2, (10-120Nm)												6721684
GW40												6721792
GWA40												6721802
GS13-POS.												s.o./s.a.
调节工具尺寸 Adjustment tools Size 2 / M8-M20 / 10-120 Nm												2
G2, (10-120Nm)												6721684
GW2												6721792
GWA2												6721802
GS13-POS.												s.o./s.a.
调节工具尺寸 Adjustment tools Size 3 / M14-M33 / 45-300 Nm												3
G3, (45-300Nm)												6721688
GW3												6721795
GWA3												6721804
GS13-POS.												s.o./s.a.

应用：攻丝
机器型号：所有类型的机床

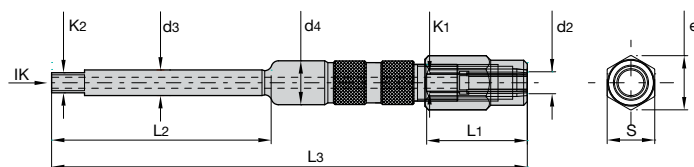
Application: tapping
Machine type: on all types of machines



在工件上进行深度内螺纹攻丝，或贴近铸铁件壁、夹具交叉处以及带肩部攻丝时，需要对丝锥安装一个加长杆，使用加长杆很多时候可避免备用专用丝锥。

For tapping operations in work pieces with extremely deep internal threads or for tapping close to cast iron walls, interference edges or shoulders of fixtures there is the need of taps with an extended shank. To avoid special taps extensions are useful.

特点：	优势：	效益：
柄部公差h6	- 更好的圆跳动精度 - 延长杆可用热胀刀柄或者液压刀柄夹持	- 丝锥寿命更长 - 更好的圆跳动精度
冷却剂压力最大50 ba	- 更好的去除铁屑 - 基孔冲洗	- 延长丝锥寿命 - 无需额外清洗
细长设计	尽可能的接近工件最终轮廓形状	- 无需专用丝锥，节约费用 - 一次性购买
柄部带方尾	- 延长杆可以跟丝锥一样装入快换系统 - 功率传输简单	- 减少机床换刀时的停机时间 - 丝锥无扭转
六角锁紧螺母	丝锥锁紧安全可靠	加强了加工过程的安全性
Features:	Advantages:	Benefits:
Shank tolerance h6	- Better run out accuracy - Shank can be clamped in shrinking chucks or hydraulic chucks.	- Longer tool life - Better run out accuracy
Coolant pressure max. 50 bar	- Better chip removal - Rinsing of the base hole	- Extended tool life of the tap - No additional cleaning required
Slim design	Closer distances to the interfering contour possible	- No special taps required. Cost saving. - One off purchase.
Shank with square	- Extensions can be fixed such as taps in quick-change inserts - Easy power transmission	- Reduced down time of the machine during tool change. - No twisting of the tap
Clamping nut with hexagon	Safe clamping of the tap.	Increased process safety

GBV — 丝锥延长杆 (仅用于丝锥)
GBV – Tap extension (for tapping only)


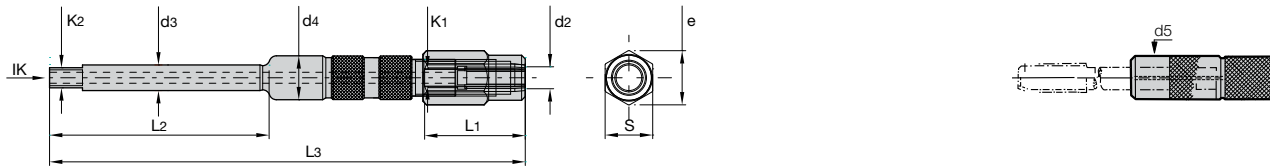
型号 Designation	DIN 371	DIN 374 376	Ø d2	□ K1	L1	Ø d3	□ K2	Ø d4	e	S	L2	L3	Id. No.
GBV2x35x27x130	M3	M4,5 / M5	3,5	2,7	24,0	6	4,9	7,5	9,0	8	60	130	5063404
GBV2x35x27x230 *			3,5	2,7	24,0	6	4,9	7,5	9,0	8	60	230	5063406*
GBV3x45x34x130	M4	M6	4,5	3,4	24,0	6	4,9	8,4	10,2	9	60	130	5063407
GBV3x45x34x230 *			4,5	3,4	24,0	6	4,9	8,4	10,2	9	60	230	5063408*
GBV4x60x49x130	M4,5/M6	M8	6,0	4,9	27,5	7	5,5	12,0	14,8	13	60	130	5062047
GBV4x60x49x230			6,0	4,9	27,5	7	5,5	12,0	14,8	13	60	230	5062048
GBV4x60x49-80x62x130	M4,5/M6	M8	6,0	4,9	27,5	8	6,2	12,0	14,8	13	60	130	5062049
GBV4x60x49-80x62x230			6,0	4,9	27,5	8	6,2	12,0	14,8	13	60	230	5062050
GBV5x70x55x130	M7	M9/M10	7,0	5,5	27,5	7	5,5	12,0	14,8	13	60	130	5062051
GBV5x70x55x230			7,0	5,5	27,5	7	5,5	12,0	14,8	13	60	230	5062052
GBV5x70x55-80x62x130	M7	M9/M10	7,0	5,5	27,5	8	6,2	12,0	14,8	13	60	130	5062053
GBV5x70x55-80x62x230			7,0	5,5	27,5	8	6,2	12,0	14,8	13	60	230	5062054
GBV6x80x62x130	M8	M11	8,0	6,2	30,0	8	6,2	13,0	15,6	14	60	130	5062055
GBV6x80x62x230			8,0	6,2	30,0	8	6,2	13,0	15,6	14	80	230	5062056
GBV7x90x70x130	M9	M12	9,0	7,0	31,0	9	7,0	15,0	17,9	16	60	130	5062057
GBV7x90x70x230			9,0	7,0	31,0	9	7,0	15,0	17,9	16	80	230	5062058
GBV7x90x70-100x80x130	M9	M12	9,0	7,0	31,0	10	8,0	15,0	17,9	16	60	130	5062059
GBV7x90x70-100x80x230			9,0	7,0	31,0	10	8,0	15,0	17,9	16	80	230	5062060
GBV8x100x80x130	M10		10,0	8,0	33,0	10	8,0	15,0	17,9	16	60	130	5062061
GBV8x100x80x230			10,0	8,0	33,0	10	8,0	15,0	17,9	16	80	230	5062062
GBV9x110x90x130		M14	11,0	9,0	36,0	11	9,0	18,0	21,4	19	90	130	5062063
GBV9x110x90x230			11,0	9,0	36,0	11	9,0	18,0	21,4	19	90	230	5062064
GBV9x110x90-120x90x130		M14	11,0	9,0	36,0	12	9,0	18,0	21,4	19	90	130	5062065
GBV9x110x90-120x90x230			11,0	9,0	36,0	12	9,0	18,0	21,4	19	90	230	5062066
GBV10x120x90x130		M16	12,0	9,0	36,0	12	9,0	19,0	21,4	19	90	130	5062067
GBV10x120x90x230			12,0	9,0	36,0	12	9,0	19,0	21,4	19	90	230	5062068
GBV11x140x110x200		M18	14,0	11,0	46,0	14	11,0	22,0	26,0	23	100	200	5062069
GBV11x140x110x330			14,0	11,0	46,0	14	11,0	22,0	26,0	23	100	330	5062070
GBV12x160x120x200		M20	16,0	12,0	46,0	16	12,0	22,0	26,0	23	100	200	5062072
GBV12x160x120x330			16,0	12,0	46,0	16	12,0	22,0	26,0	23	100	330	5062073
GBV13x180x145x200		M22/M24	18,0	14,5	47,0	18	14,5	26,0	30,5	27	100	200	5062074
GBV13x180x145x330			18,0	14,5	47,0	18	14,5	26,0	30,5	27	100	330	5062075
GBV14x200x160x200		M27	20	16,0	52,0	20	16,0	28,0	33,5	30	100	200	5062076
GBV14x200x160x330			20	16,0	52,0	20	16,0	28,0	33,5	30	100	330	5062077
GBV15x220x180x200		M30	22	18,0	55,0	22	18,0	30,0	40,5	36	100	200	5062078
GBV15x220x180x330			22	18,0	55,0	22	18,0	30,0	40,5	36	100	330	5062079
GBV16x250x200x200		M33	25	20,0	56,0	25	20,0	35,0	40,5	36	100	200	5062080
GBV16x250x200x330			25	20,0	56,0	25	20,0	35,0	40,5	36	100	330	5062081
GBV17x280x220x200		M36	28	22,0	58,0	28	22,0	40,0	52,0	46	100	200	5062082
GBV17x280x220x330			28	22,0	58,0	28	22,0	40,0	52,0	46	100	330	5062083
GBV18x320x240x200		M39/M42	32	24,0	60,0	32	24,0	44,0	52,0	46	100	200	5062084
GBV18x320x240x330			32	24,0	60,0	32	24,0	44,0	52,0	46	100	330	5062085

* 不带内冷供给

* With out internal coolant supply

要求有螺帽

Knurled nut on request



型号 Designation	S/螺帽 S/Nut	e mm	外六方/订货号 Hex. - Nut/Id. Nr.	Nm	型号/订货号 Des/Id. Nr.	TORCO-FIX 安装扳手 Fitting key	螺帽 Knurled nut	Ø d5 mm
GBV 2	8	9,0	GBVM2-SKT	3	16Z-SW8		GBVM2-RD	7,5
			5088694		5091123		5070238	
GBV 3	9	10,2	GBVM3-SKT	5	16Z-SW9		GBVM3-RD	8,4
			5088695		5091125		5070239	
GBV 4	13	14,8	GBVM4-SKT	6	16Z-SW13		GBVM4-RD	12,1
			5088696		5091126		5070240	
GBV 5	13	14,8	GBVM5-SKT	7	16Z-SW13		GBVM5-RD	12,1
			5088697		5091126		5070241	
GBV 6	14	15,6	GBVM6-SKT	9	16Z-SW14		GBVM6-RD	13,0
			5088698		5091129		5070242	
GBV 7	16	17,9	GBVM7-SKT	12	16Z-SW16		GBVM7-RD	15,0
			5088699		5091134		5070243	
GBV 8	16	17,9	GBVM8-SKT	14	16Z-SW16		GBVM7/8-RD	15,0
			5088700		5091134		5070244	
GBV 9	19	21,4	GBVM9-SKT	16	16Z-SW19		GBVM9-RD	18,0
			5088701		5091137		5070245	
GBV 10	19	21,4	GBVM10-SKT	18	16Z-SW19		GBVM10-RD	18,0
			5088702		5091137		5070246	
GBV 11	23	26,0	GBVM11-SKT	20	16Z-SW23		GBVM11-RD	22,0
			5088703		5056896		5070247	
GBV 12	23	26,0	GBVM12-SKT	22	16Z-SW23		GBVM12-RD	22,0
			5088704		5056896		5070248	
GBV 13	27	30,5	GBVM13-SKT	30	16Z-SW27		GBVM13-RD	26,0
			5093668		5091140		5091146	
GBV 14	30	33,5	GBVM14-SKT	35	16Z-SW30		GBVM14-RD	28,0
			5093669		5056897		5091147	
GBV 15	36	40,5	GBVM15-SKT	40	16Z-SW36		GBVM15-RD	30,0
			5093670		5091143		5091148	
GBV 16	36	40,5	GBVM16-SKT	45	16Z-SW36		GBVM16-RD	35,0
			5093671		5091143		5091149	
GBV 17	46	52,0	GBVM17-SKT	50			GBVM17-RD	40,0
			5093672				5091150	
GBV 18	46	52,0	GBVM18-SKT	50			GBVM18-RD	44,0
			5093673				5091151	

请注意: 如果外六方的尺寸过大, 需要配备螺帽。

Please note: Knurled nut on request if the diameter of the hex. nut is too big

TORCO-FIX 扭力扳手 Torque wrench TORCO-FIX				
	型号 Designation	订货号 Id.No.	l 1	扭矩 Torque Nm
	TORCO-FIX 0	5093674	290	2 – 25
	TORCO-FIX I	6734177	335	5 – 50

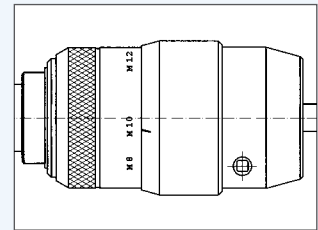
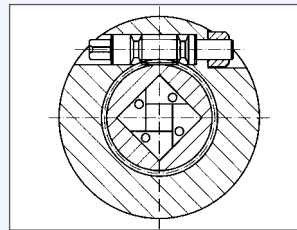
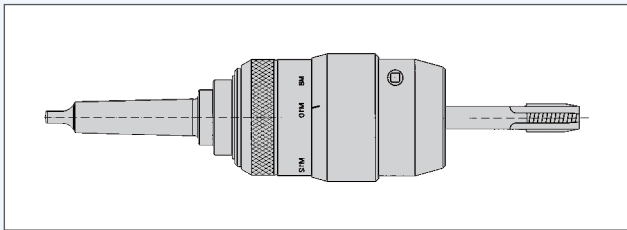


应用：攻丝和螺纹挤压，
并且频繁变换螺纹规格，如小企业，维修部门等等

机器型号：可翻转的钻床和攻丝机，立卧镗床，专机，车床和数控机床

Application: tapping and roll forming
with frequently changing thread sizes, e.g. small firms, repair departments etc. etc.

Machine type: reversible drilling and tapping machines | radial, horizontal boring machines | special purpose, turning and NC-machines



攻丝刀柄应用于钻床和攻丝机

使用一个双夹紧系统将丝锥牢固地夹持在柄部和方尾上，该装置夹持范围广泛，通过使用一个方扳手调节刀柄上面的调节螺丝。

可调节的安全夹紧装置避免丝锥破损，转矩系统确保夹紧装置上的磨损程度最小，夹紧装置松开后，丝锥在返程时会自动被锁紧。

所采用的浮动系统是用来补偿丝锥和工件孔之间可能产生的任何轴位移。

长度补偿在压缩和拉伸上起作用，用于补偿丝锥刀柄和机床之间产生的任何螺距变化。通过零点精确定位，该装置可以在机器上使用手动和自动进给。

Tapping chuck for use on drilling and tapping machines

The tap is securely clamped on both the shank and square using a double clamping system. The wide clamping range of this unit is operated by using a key on the rectangular head adjustment screw within the body of the unit.

The adjustable safety clutch prevents tap breakage and the torque system ensures minimum wear on the clutch. The tap is automatically locked on return after the clutch has slipped.

The floating system employed compensates for any misalignment that may occur between the tap and the hole in the workpiece.

The length compensation acts on tension and compression to compensate for any pitch variation between the machine and the tapping chuck, the unit can be used on machines with both manual and automatic feed, built-in exact zero-position.

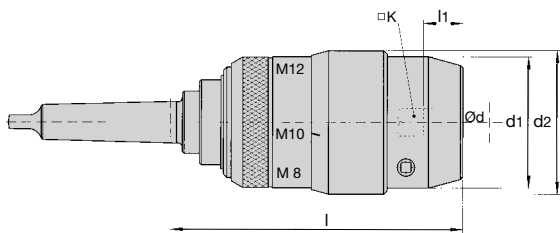
D – DSPL

攻丝刀柄 Tapping Chuck

bilz

特点:	优势:	效益:
■ 大夹持范围的双夹持	■ 直接夹持丝锥	■ 无需快换夹头
■ 可调节的安全保护	■ 避免丝锥崩刃	■ 更低的刀具和二次精加工费用
■ 长度拉伸和压缩补偿	■ 用于补偿机床进给和丝锥螺距间的误差	■ 纠正螺纹达到好的质量，更少的丝锥磨损
■ 浮动功能	■ 应用补偿预钻孔和主轴间的定位误差	■ 好的螺纹质量
Features:	Advantages:	Benefits:
■ double chucking with big clamping range	■ direct clamping of the taps	■ no quick change adaptors required
■ adjustable safety clutch	■ to avoid tap breakage	■ less tooling and refinishing costs
■ length compensation on tension and compression	■ to compensate the difference between tap pitch and feed rate of the machine	■ correct threads in a good quality, less tap wear
■ float function	■ to compensate misalignment between core drill hole and spindle	■ good thread quality

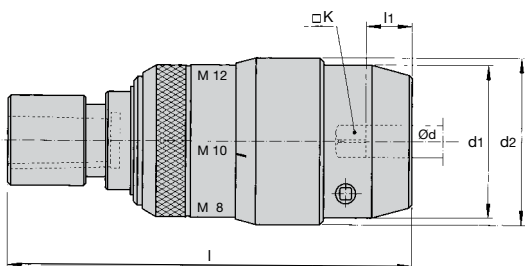
DSPL — 攻丝刀柄
DSPL – Tapping chucks



DSPL/MK

型号/订货号 Designation/Id. No.	Ø d	□ K			惠氏螺纹/G max Nm				d1	d2	l	l1	
DSPL12/MK2 6707468	2,5-10	0-8	M3-M12	1/8"-1/2"	28	1	10	20	53	58	135	18-20	V 12-SW 4,5 6707459
DSPL12/MK3 6707469	2,5-10	0-8	M3-M12	1/8"-1/2"									V 12-SW 4,5 6707459
DSPL20/MK3* 6707489	6-16	4,7-12	M8-M20	1/4"-13/16"	90	1,5	10	20	76	83	170	23-28	V 20-SW 6 6707460
DSPL20/MK4* 6707490	6-16	4,7-12	M8-M20	1/4"-13/16"									V 20-SW 6 6707460
DSPL30/MK4* 6707508	11-23	0-18	M14-M30	9/16"-1.1/8"	280	2	10	30	100	106	230	25-34	V 30-SW 9 6707466
DSPL30/MK5* 6707509	11-23	0-18	M14-M30	9/16"-1.1/8"									V 30-SW 9 6707466
DSPL42/MK5* 6707526	14-32	11-24	M18-M42	11/16"-1.5/8"	630	2	10	30	120	125	269	41-48	V 42-SW 10 6707467
DSPL42/MK6* 6707527	14-32	11-24	M18-M42	11/16"-1.5/8"									V 42-SW 10 6707467

* DIN 1806



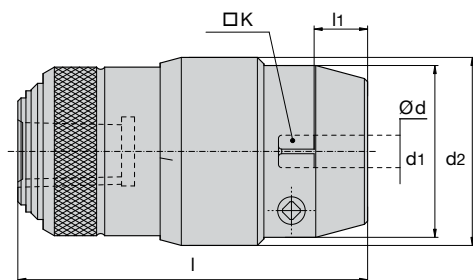
DSPL/B

型号/订货号 Designation/Id. No.	Ø d	□ K			惠氏螺纹/G max Nm				d1	d2	l	l1	
DSPL12/B16 6707473	2,5-10	0-8	M3-M12	1/8"-1/2"	28	1	10	20	53	58	148	18-20	V 12-SW 4,5 6707459
DSPL20/B22 6707493	6-16	4,7-12	M8-M20	1/4"-13/16"	90	1,5	10	20	76	83	188	23-28	V 20-SW 6 6707460
DSPL30/B24 6707513	11-23	0-18	M14-M30	9/16"-1.1/8"	280	2	10	30	100	106	257	25-34	V 30-SW 9 6707466

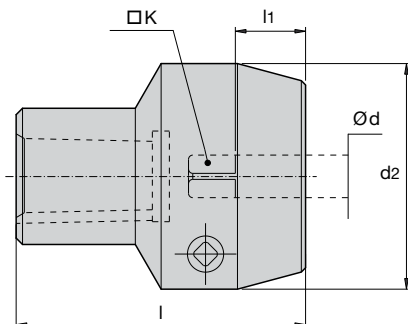
DIN 228 B



DSP-D — 攻丝刀柄
DSP-D – Tapping chucks

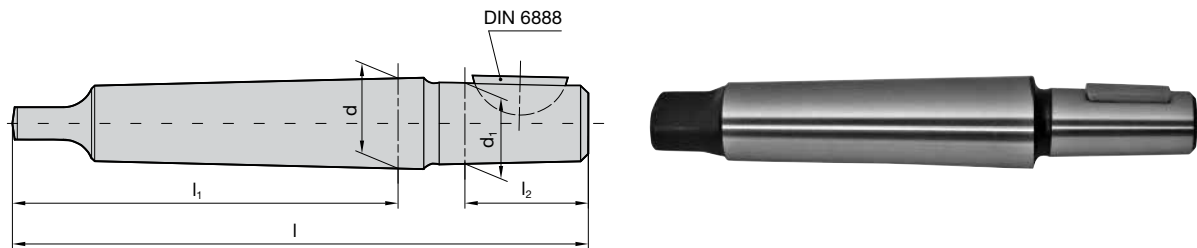


DSP/B											
型号/订货号 Designation/Id. No.	Ø d	□ K		惠氏螺纹/G 	max Nm		d1	d2	l	l1	
DSP12/B16 6707479	2,5-10	0-8	M3-M12	1/8"-1/2" 1/8"	28	1	53	58	108	18-20	V 12-SW 4,5 6707459
DSP20/B18 6707498	6-16	4,7-12	M8-M20	1/4"-13/16" 1/8"-1/2"	90	1,5	76	83	142	23-28	V 20-SW 6 6707460
DSP20/B22 6707499	6-16	4,7-12	M8-M20	1/4"-13/16" 1/8"-1/2"	90	1,5	76	83	142	23-28	V 20-SW 6 6707460
DSP30/B24 6707516	11-23	0-18	M14-M30	9/16"-1/8" 1/4"-7/8"	280	2	100	106	204	25-34	V 30-SW 9 6707466



D/B									
型号/订货号 Designation/Id. No.	Ø d	□ K		惠氏螺纹/G 	max Nm	d2	l	l1	
D12/B16 6707482	2,5-10	0-8	M3-M12	1/8"-1/2" 1/8"	28	53	60	18-20	V 12-SW 4,5 6707459
D20/B18 6707501	6-16	4,7-12	M8-M20	1/4"-13/16" 1/8"-1/2"	90	76	79	23-28	V 20-SW 6 6707460
D20/B22 6707502	6-16	4,7-12	M8-M20	1/4"-13/16" 1/8"-1/2"		76	88	23-28	V 20-SW 6 6707460
D30/B24 6707517	11-23	0-18	M14-M30	9/16"-11/8" 1/4"-7/8"	280	100	123	25-34	V 30-SW 9 6707466
D42/B24 6707530	14-32	11-24	M18-M42	11/16"-15/8" 1/2"-11/4"	620	120	152	41-48	V 42-SW 10 6707467

接柄见第142页
 Arbor see page 142



柄DIN 238带半圆键DIN6888

Arbor DIN 238 with woodruff key DIN 6888

型号/订货号 Designation/Id. No.		Ø d	Ø d1	l	l1	l2	DIN6888
B16xMK2 6816002	DSP12/B16	17,780	15,733	112	75	24	4 x 7,5
B16xMK3 6816003	D12/B16	23,825	15,733	134	94	24	4 x 7,5
B18xMK3 6818003	DSP20/B18	23,825	17,780	140	94	32	5 x 9
B18xMK4 6818004	D20/B18	31,267	17,780	165	117,5	32	5 x 9
B22xMK3 6822003	DSP20/B22	23,825	21,793	147	94	40,5	5 x 9
B22xMK4 6822004	D20/B22	31,267	21,793	176	117,5	40,5	5 x 9
B24xMK4 6824004	DSP30/B24	31,267	23,825	186	117,5	50,5	6 x 9
B24xMK5 6824005	D30/B24	44,399	23,825	221	149,5	50,5	6 x 9
B24xMK5 6824005	D42/B24	44,399	23,825	221	149,5	50,5	6 x 9



V-SW

型号 Designation	订货号 Id. No.	用于 for	D, DSPL, DSP
V 12-SW 4,5	6707459	12	
V 20-SW 6	6707460	20	
V 30-SW 9	6707466	30	
V 42-SW 10	6707467	42	

安装说明

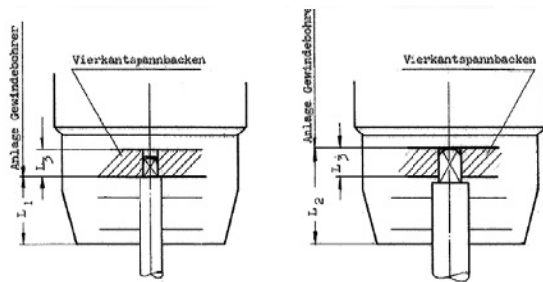
机床接口位置保持干净。

当夹持丝锥时确保丝锥被安全夹住，这样当松开取下丝锥时不会□入工件，损坏丝锥或者工件。

注意刀具尺寸和机床制造商。

双夹持（三爪和四爪）

** 看丝锥夹持操作手册的注释



通过双夹持夹具达到了高的夹持力。因此只要稍微拧紧方形扳手。

优选的主轴是：莫式刀柄MT-DIN228A，孔锥度 B-DIN238

针对客户定制的主轴设计，请联系BILZ公司的技术服务部门

操作手册

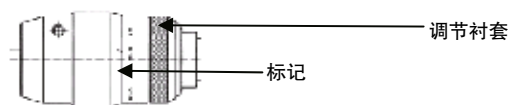
丝锥的夹持：

当夹持丝锥时要确保丝锥方尾被四爪夹住，丝锥方尾损角不应被夹住。

最好的检测方式是当四爪轻松夹住时转动丝锥，如果丝锥不能被转动就是正确的。当四爪没有正常工作时，丝锥肯定能旋转一点，小的丝锥的方尾长度小于四爪深度时，丝锥应该被拉出一点。

安全保护装置的调节：

通过有节的衬套调节扭矩，轴向往刀柄头部方向拉动衬套，然后转动衬套直到需要的螺纹尺寸和刻度标记相对，然后退回衬套。



径向浮动（平行的）：

丝锥和工件间的偏移量被补偿了，因此不管什么样的螺纹公差等级都能达到，也极大的保护了丝锥。

长度补偿（拉伸和压缩）：

拉伸和压缩补偿了丝锥螺距和机床进给间的误差，这应该是可能的，总是在拉伸区域很容易的工作。进给大概是少5%。

期间的解释：

D 只有双夹持特别

DSP 双夹持、安全保护和平行浮动

DSPL 双夹持、安全保护和平行浮动，长度补偿

Installation Instruction

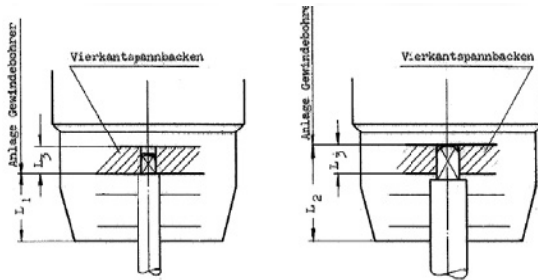
Keep clean the tool holder location in the machine spindle.

Hold the tool safe when changing tools, so when releasing the tool, the tool does not fall into the engine room and damaging the tool and / or work piece.

Note the tool dimensions and the machine manufacturer.

Double chucking (three- und four set of jaws)

** See note at "clamping taps" in operating manual



By the double chucking fixture a high clamping force is reached. It suffices therefore a little tension with the square key.

Favorite locations are: Morse taper MT-DIN228A and bore taper B-DIN238

For customer-specific spindle designs, please contact the Technical Service of the company BILZ.

Operating Manual

Clamping of taps:

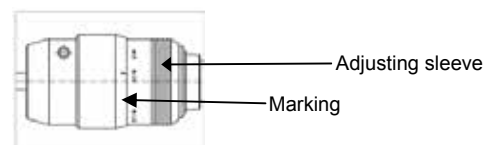
When clamping of the tool is to make sure that the square jaw set rests on the square of the tap. The square should not be clamped around the corner.

This is best checked when the jaws slightly open and tried to turn the tool. If the tool can not be turned it is correct. When the driving is not working properly, the tool must be rotated a little, and at smaller taps whose square may be shorter than the height of the square jaw set, the taps should be pulled out a little.

Adjusting of the safety clutch:

For adjusting the torque is the knurled sleeve. Move axially in the direction of the clamping head, and then the scale twisted until the desired thread size to the horizontal mark visible.

Reversing the spindle re-engages the clutch and the tap is automatically turned out of the thread.



Axial floating (parallel):

Thus offset between tap and work piece are compensated, so that nevertheless tolerance-thread can be achieved and also the tap is largely protected.

Length compensation (tension and compression):

The tension and compression compensates differences between the thread pitch and the feed. It should be possible, always worked easily in the tensile zone. The feed should be about 5% less.

Explanation of the term:

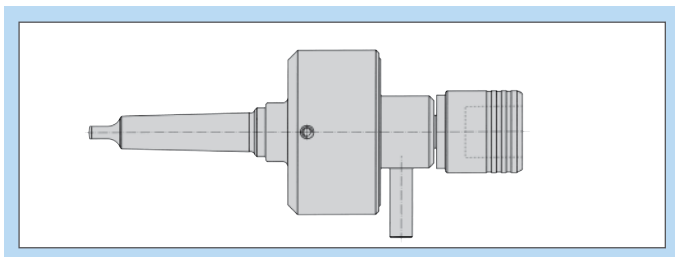
D only double chucking feature

DSP double chucking, safety clutch and parallel float

DSPL double chucking, safety clutch and parallel float, length compensation

应用：在机床动力头和手动进给下的攻丝和螺纹挤压
机器型号：钻床和带动力头的机床

Application: tapping, roll forming on machines with a driven spindle and manual feed
Machine type: drilling machines, machines with driven spindle



这个自反转攻丝装置是为那些只有手动进给装置并且主轴不能反转的钻床而设计的。

刀具设计简单、高效并且在实际中是免维护的，该装置借助于其莫氏锥柄安装到机器主轴上，通过安装在钻床立柱上的制动臂保证功能正常有效，该装置这样设计是为了能进行向右或者向左的攻丝操作。

该装置这样设计，是为了在不改变机器主轴方向的前提下实现攻丝和反转。

当达到了所需要的螺纹深度，该装置就会自动改变方向。

使用Bilz WE和WES快换夹头夹紧丝锥，有助于快速更换丝锥，不同尺寸的丝锥锥柄需要不同的快换夹头。

WES快换夹头带有过载保护机构，为避免丝锥破损给了附加的保护。

This self reversing tapping attachment is designed for use on drilling machines which have only manual feed facilities and which do not have a reversible spindle.

The tool design is simple, effective, and is virtually maintenance free. The unit is fitted into the machine spindle by virtue of its morse taper shank, with the stop arm located against the column of the drilling machine to ensure effective and positive action. The design of the units is such that it can be used for either right or left handed tapping operations.

The design of the unit is such that tapping and reversing is possible without changing the direction of the machine spindle.

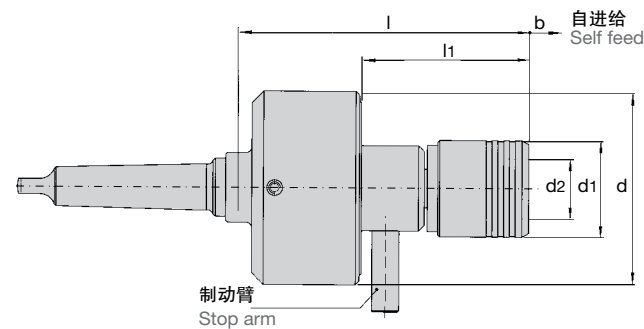
The unit automatically changes direction when the required thread depth has been achieved.

The unit accepts both Bilz WE and WES tap adaptors which facilitate quick tap change, a separate tap adaptor is required for each size of tap shank.

The use of WES tap adaptors gives additional security against tap breakage by means of the clutch mechanism.

特点:	优势:	效益:
■ 用于丝锥夹头的快换系统	■ 快速换刀	■ 换刀时无需额外的工具
■ 可更换的，柄部锁入	■ 更高的灵活性	■ 通过更换柄部，此装置可用在不同机床不同主轴接口上
■ 反向动作时双倍的进给率	■ 更短的加工时间由于反向时更高的进给率	■ 更短的加工时间
■ 装置中没有嵌入式安全保护装置	■ 便宜的装置价格	■ 带安全保护的夹头需要时可提供，如基准孔
■ 免维护	■ 由于装置的免维护而没有停机时间	■ 减少了停机时间，无需备件
■ 装置可用于左旋和右旋螺纹	■ 只需一个装置	■ 减少了刀具数量
■ 完整的反向齿轮	■ 通过使用装置的长度补偿启动自反转	■ 由于不反转机床主轴减少了时间，由于主轴不用加减速保护了机床。节能！
Features:	Advantages:	Benefits:
■ quick change system for tap adaptors	■ quick tool change	■ no additional tools required for the tool change
■ exchangeable, screwed-in shank	■ higher flexibility	■ by changing the shank, the unit can be used on different machines with other spindle locations
■ double feed rate on reverse motion	■ shorter processing time due to higher feed rate on reverse motion	■ shorter processing time
■ no built-in safety clutch in the unit	■ unit price is cheaper	■ application adaptors with safety clutch only when it is necessary e.g. ground holes
■ free of maintenance	■ no down time due to service of the unit	■ reduction of the down time, no spare units required
■ unit can be used for right and left handed threads	■ just one unit required	■ reduction of the number of tools
■ integrated reversible gear	■ self reversing by using the length compensation of the unit	■ time reduction due to not reversing the machine spindle, machine protection due to not slowing down and speeding up the machine. Energy saving!

TA — 攻丝装置
TA – Tapping attachment



DIN
228 B



TA/MK-WF											
型号/订货号 Designation/Id. No.			$n_{max.}$ [min ⁻¹] [rpm]	b	d	d1	d2	l	l1		i
TA12/MK2-WF 6705096	1	M3-M12	1200	6	80	32	19	140	60	12,5	1,73
TA12/MK3-WF 6705099	1	M3-M12	1200	6	80	32	19	140	60	12,5	1,73
TA20/MK3-WF 6705097	2	M8-M20	500	8	100	50	31	170	86	16,5	1,88
TA20/MK4-WF 6705100	2	M8-M20	500	8	100	50	31	170	86	16,5	1,88

i = 逆时针齿轮传动比
i = gear ratio anti clockwise

合适的快换攻丝夹头见第98–132页
Suitable quick change adaptors see page 98 – 132

应用：

该攻丝附件是为那些带莫氏锥度主轴并且主轴转动方向没有任何变化的立式钻床而设计的。

Application:

The tapping attachment is designed for use on vertical drilling machines which use a morse taper spindle location, the attachment is designed to be used without any change in the spindle direction.

操作：

在操作之前，制动臂应该放置在攻丝附件主体上的螺纹孔中并且拧紧定位，制动臂的另一端应该或者连结在钻床的立柱上或者连接在已安装到机器上的一个相应的制动装置上，目的是避免攻丝附件转动，主轴移出时要使用大约两倍的进给速度。

Operation:

Before operation, the stop arm should be located in the tapped hole on the main body of the tapping attachment and screwed into position. The other end of the stop arm should then be in contact with either the main pillar of the drilling machine or an appropriate stop device mounted on the machine, the purpose of this is to prevent the tapping attachment rotating. On the way out use approximately double feed rate.

维护：

该攻丝附件是免维护的。

Maintenance:

The tapping attachment is maintenance free.

安全预防措施：

在刀柄中更换夹头时，应该注意确保夹头在本附件的刀柄中正确放置，不允许用手握制动臂，在操作人员和机器之间的安全距离应该大于制动臂的长度。

TA 12的最大转速是每分钟1200

TA 20的最大转速是每分钟500

TA 12的攻丝范围是M3-M12

TA 20的攻丝范围是M8-M20

在盲孔攻丝时，必须使用带安全夹紧装置的快换夹头。

Safety precautions:

When changing adaptors in the chuck head, care should be taken to ensure that the adaptor is correctly located in the chuck of the attachment. The stop arm must not be held in the hand and a safe distance between the operator and the machine should be greater than the length of the stop arm.

Max. RPM for TA 12 is 1200 per minute

Max. RPM for TA 20 is 500 per minute

The tapping range for TA 12 is M 3 - M 12

The tapping range for TA 20 is M 8 - M 20.

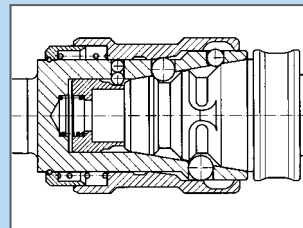
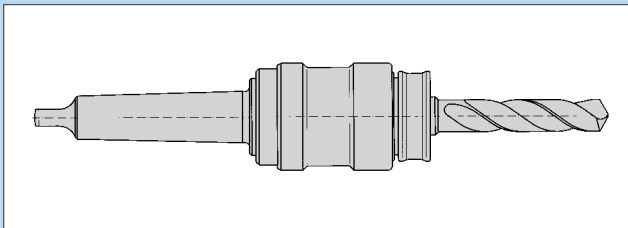
Quick change adaptors with safety clutch must be used when tapping blind holes.

如不遵循上述预防措施，操作员可能面临受伤风险！

Risk of injury to the operator if the above precautions are not followed!

应用：攻丝，螺纹挤压，钻孔，钻沉孔，倒角，铰削
机器型号：加工中心和专机

Application: tapping, roll forming, drilling, counterboring, chamfering, reaming,
Machine type: machining centres and special purpose machines



快换式钻夹头和刀柄用于钻削、铰削和攻丝刀具

SBK快换系统适用于钻床、摇臂钻床或NC-控制的钻床，系统结构设计为：使用一个刀杆就能完成多种功能。

独特的双轴承紧系统确保安全的转矩传递以及SEK夹头在刀柄中的精确定位。放置钻头、铰刀、平底扩孔钻或者攻丝工具的刀柄不需要使用其它的辅助工具就可以很快地更换，并且在夹刀柄中自动定位。通过在轴向缩回刀柄的外部套筒，夹头被松开然后很方便地取出。

在机器的主轴停止工作时或者主轴运行速度在最大值2,000rpm以内时都可以换刀。

装置中的陡峭锥度允许快速换刀。快换系统可以在水平面和垂直面操作，并且可以左转和右转。

SBK刀柄和SEK夹头根据需要可以配备内冷供给。

在非标设计的结构中，这种快换系统也可以用于特殊机器上的全自动换刀装置。

说明：

不适用于带有径向力的操作，例如：铣削和拉伸负荷，例如背镗孔。

Quick change drilling chucks and adaptors for drilling, reaming, and tapping tools

The SBK quick change system is for use on drilling machines, either manual, radial or NC controlled. The system is designed to enable numerous functions to be carried out whilst utilising a single toolholder.

The unique double ball clamping gives a positive drive and allows the precise location of the SEK adaptor in the chuck. The adaptors, which take drills, reamers, counterbores or tapping equipment, can be changed quickly without the use of additional tools, and are automatically located in the chuck. They are released by retracting the outer sleeve of the chuck axially, which then allows the adaptor to be removed with ease.

The changing of tools can take place either when the machine spindle is stopped.

The steep location taper of the unit allows a rapid tool change and the system is designed that the unit can operate in both the vertical or horizontal plane, and for left or right hand rotation.

SBK holders and SEK adaptors can be supplied with internal coolant feed on request.

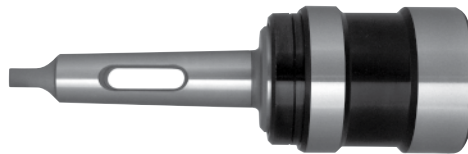
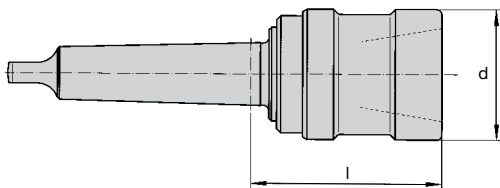
A custom design of this quick change system is available for fully automatic tool change units on special machines.

Note:

Not suitable for operations with radial forces. E.g. milling and tension forcer e.g. back spotfacing.

特点:	优势:	效益:
夹头在刀柄中自锁并带快换特点	换刀时无需额外的工具和附件	- 不需要寻找附件 - 减少了机床停机时间
夹头在刀柄中高同心度 (3/100)	- 更高的精度 - 更少的刀具磨损	更好的工件质量, 刀具费用减少
轴向径向运动自如	高同心度	更好的工件质量, 刀具费用减少
刀柄和夹头间锥度接合	轴向和径向无间隙	由于锥度接合缩短了换刀方式
由于锥度接合缩短了换刀方式	减少了位移, 主轴移动	减少了时间
可用在立式和卧式机床上	更高的灵活性	更少的装夹刀具
适合左旋和右旋	更高的灵活性	更少的装夹刀具
刀柄总是在机床主轴里	快换系统只需更换夹头	- 在莫式刀柄上无需费力的换刀 - 机床主轴更少的磨损
Features:	Advantages:	Benefits:
quick change feature with automatic locking of the adaptors in the chuck	no additional tools/accessories required for the tool change	- Search for accessories not applicable - Reduced down time of the machine
high concentricity of the adaptors in the chuck (3/100)	higher accuracy, less tool wear	better work piece quality, cost reduction for tooling
free of axial and radial play	high concentricity	better work piece quality, cost reduction for tooling
conical location between chuck and adaptor	axial and radial free of gap	short tool changing ways through conical location
short tool changing ways through conical location	reduced travels, spindle movements	time reduction
can be used horizontally or vertically	higher flexibility	less clamping tools required
suitable for right and left hand rotation	higher flexibility	less clamping tools required
chuck always stays in the machine spindle	only the adaptors will be changed by the quick change system	- no laborious tool change of the tools with morse taper any more - less wear at the machine spindle

SBK — 快换钻削刀柄
SBK – Quick change drilling chucks

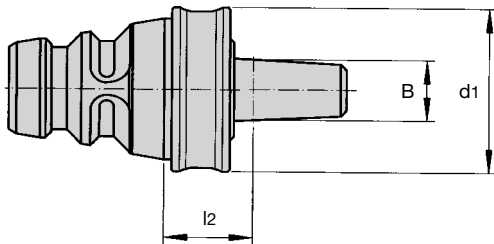


DIN
238

SBK/MK							
莫氏锥度 DIN 228 B Morse taper DIN 228 B							
型号 Designation		d		MK2	MK3	MK4	MK5
SBK2/MK...	2	50	l	75	75	–	–
			Id. No.	6723619	6723620	–	–
SBK3/MK...	3	60	l	–	88	89	–
			Id. No.	–	6723648	6723649	–
SBK4/MK...	4	72	l	–	–	102	102
			Id. No.	–	–	6723668	6723669

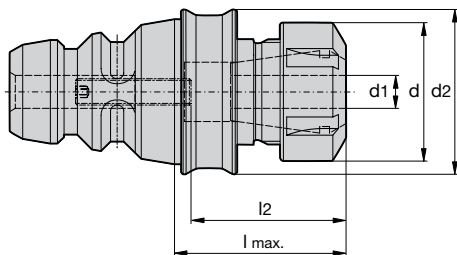
从 MK 3 开始带十字楔槽
 From MK3 with cross wedge groove

SEK — 快换夹头
SEK – Quick change adaptor



DIN
238

SEK/B					
带有短粗锥体 DIN 238，用于钻头带有短粗锥体 With stub taper DIN 238. For tools with stub taper					
型号 Designation		d1		B12	B16
SEK2/B...	SBK2	42	l2	21,5	23
			Id. No.	6723632	6723633
SEK3/B...	SBK3	50	l2	–	25,5
			Id. No.	–	6723657
SEK4/B...	SBK4	60	l2	–	38,5
			Id. No.	–	6723680

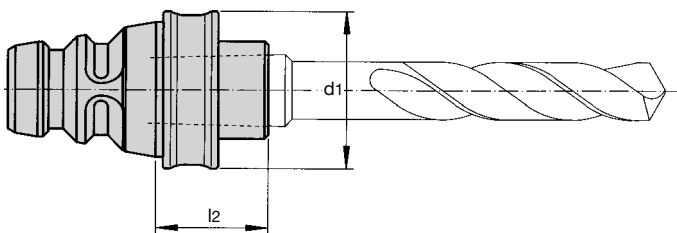


SEK/ESX

用于弹簧筒夹类型ER/ESX, DIN 6499
For collets type ER/ESX, DIN 6499

型号/订货号 Designation/Id. No.			d1	l2		d	d2	l
				min	max			
SEK2/ESX16 6723783	SBK2/...	ESX 16	1-3	21	33	32	42	40
SEK2/ESX20 6723640			> 3-10	31	43			
SEK3/ESX25 6723744		ESX 20	1-6,5	22	34	34	42	46
SEK3/ESX32 6723790			> 6,5-13	35	47			
SEK3/ESX40 6723780	SBK3/...	ESX 25	2-5	24	36	42	50	52
SEK3/ESX32 6723790			> 5-16	31	51			
SEK3/ESX40 6723780		ESX 32	3-6	29	41	50	50	53
SEK4/ESX32 5071653			> 6-20	44	56			
SEK4/ESX40 6723686	SBK4/...	ESX 40	4-6	35	47	63	60	73
			> 6-26	42	62			
		ESX 32	3-6	29	41	50	60	63
			> 6-20	44	56			
		ESX 40	4-6	35	47	63	60	70
			> 6-26	42	62			

ESX筒夹见第34页
ESX-collets see page 34

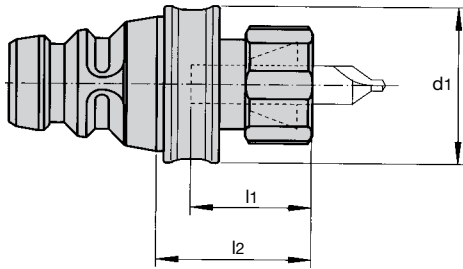


SEK/MK

带内莫氏锥度DIN 228 B, 用于带扁尾的莫氏锥柄
With internal morse taper DIN 228 B. For morse taper shanks with flat tang

型号 Designation		d1		MK1	MK2	MK3	MK4
SEK2/MK...	SBK2	42	l2	18	30,5	–	–
			Id. No.	6723630	6723631	–	–
SEK3/MK...	SBK3	50	l2	20,5	20,5	38,5	–
			Id. No.	6723653	6723654	6723655	–
SEK4/MK...	SBK4	60	l2	33,5	33,5	33,5	56
			Id. No.	6723674	6723675	6723676	6723677

SEK — 快换夹头
SEK – Quick change adaptor

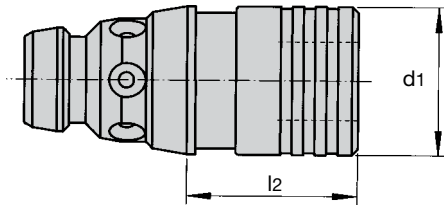


DIN
6343

SEK/RF											
用于Rubber-Flex®弹簧筒夹。用于带圆柱形柄部的刀具 For Rubber-Flex®-collets. For tools with cylindrical shank											
型号/订货号			l1	l2		Rubber-Flex® 423	Rubber-Flex® 420	Rubber-Flex® 422	Rubber-Flex® 443	Rubber-Flex® 440	
Designation/Id. No.		d1	min.	max.		Ø 2 – 4,5	Ø 4,5 – 8	Ø 6,5 – 10	Ø 2,8 – 7	Ø 7 – 13	
SEK2/RF42	SBK 2	42	30	50	l2	42	42	42	–	–	RF42
6723641					Id.No.	6909312	6909309	6909311	–	–	6910200
SEK3/RF44	SBK 3	50	40	60	l2	–	–	–	51	51	RF44
6723659					Id. No.	–	–	–	6909314	6909313	6910201
SEK4/RF44	SBK 4	60	40	60	l2	–	–	–	63	63	RF44
6723688					Id. No.	–	–	–	6909314	6909313	6910201

请单独订购Rubber-Flex®弹簧筒夹和扳手
Please order Rubber-Flex® collets and wrench separately

SELK — 快换夹头
SELK – Quick change adaptor



SELK							
带完整的轴向伸缩，WES攻丝夹头带过载保护。 With integrated length compensation. For tapping adaptors with safety clutch type WES							
型号/订货号 Designation/Id. No.						d1	l2
SELK2/1 6723643	SBK2/...	WES1 B	M3 – M12	7,5	7,5	36	42
SELK2/2 6723644		WES2 B	M8 – M20	12,5	12,5	53	72
SELK3/1 6723661	SBK3/...	WES1 B	M3 – M12	7,5	7,5	36	42
SELK3/2 6723662		WES2 B	M8 – M20	12,5	12,5	53	66
SELK3/3 6723663		WES3 B	M14 – M33	20	20	78	126
SELK4/1 6723691	SBK4/...	WES1 B	M3 – M12	7,5	7,5	36	42
SELK4/2 6723692		WES2 B	M8 – M20	12,5	12,5	53	66
SELK4/3 6723693		WES3 B	M14 – M33	20	20	78	121
SELK4/4 6723694		WES4 B	M22 – M48	22,5	22,5	96	135

合适的快换攻丝夹头见第98–132页
 Suitable quick change adaptors see page 98 – 132

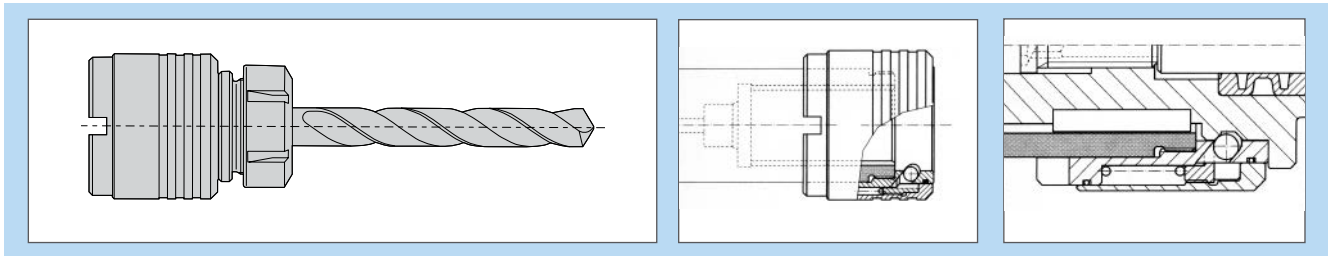


应用：钻削，深孔枪钻操作

机器型号：深孔钻床，专机，生产线，多主轴机床

Application: drilling, deep gun drilling operations

Machine type: deep gun drilling, special purpose machines, transfer lines, multi spindle heads



短钻夹持系统用于高速钢HSS和硬质合金短钻以及特殊钻头的应用

Bilz短钻夹持系统由ASR快换钻削刀柄和WZHR刀杆组成。用于流水线和专机上，它短的伸出长度确保了刚性和精度，非常理想的适用于没有衬套的钻削应用。

ASR快换钻削刀柄直接旋入到机床主轴上，通过一种微型压缩的粘合剂固定位置，这样能提供安全的粘结，当需要移除刀柄的时候也很容易松开。

WZHR刀杆自动锁到快换钻削刀柄中，通过新开发的棍子机构消除了轴向间隙。精密的制造公差和准确的驱动结合确保了刚性和同心度。

这套系统可以在机器外设置，内置的调整螺母可以非常容易的设置长度。

WZHR现有的刀杆可以接受ESX筒夹和DIN 1835型柄部钻头。这套系统适合左旋和右旋操作，且如果需要可以非常容易的提供冷却液供给。

可根据需求供应此系列刀具的特殊版本。

Stub drill system for HSS and Carbide stub drills and special drill applications

The Bilz stub drilling system consists of the ASR drill chuck used in conjunction with a WZHR toolholder.

It is designed for use on transfer lines and special purpose machines, the short projection length of the unit ensures rigidity and accuracy and is ideal for drilling applications without the need for bushing.

The ASR chuck is screwed directly onto the machine spindle, and is locked in position using a micro-encapsulated adhesive which provides a secure bond and can be easily cracked when the chuck is required to be removed.

The WZHR toolholder is automatically locked into the chuck and axial play is eliminated by means of a newly developed roller mechanism. The close manufacturing tolerances and positive drive combine to ensure rigidity and concentricity.

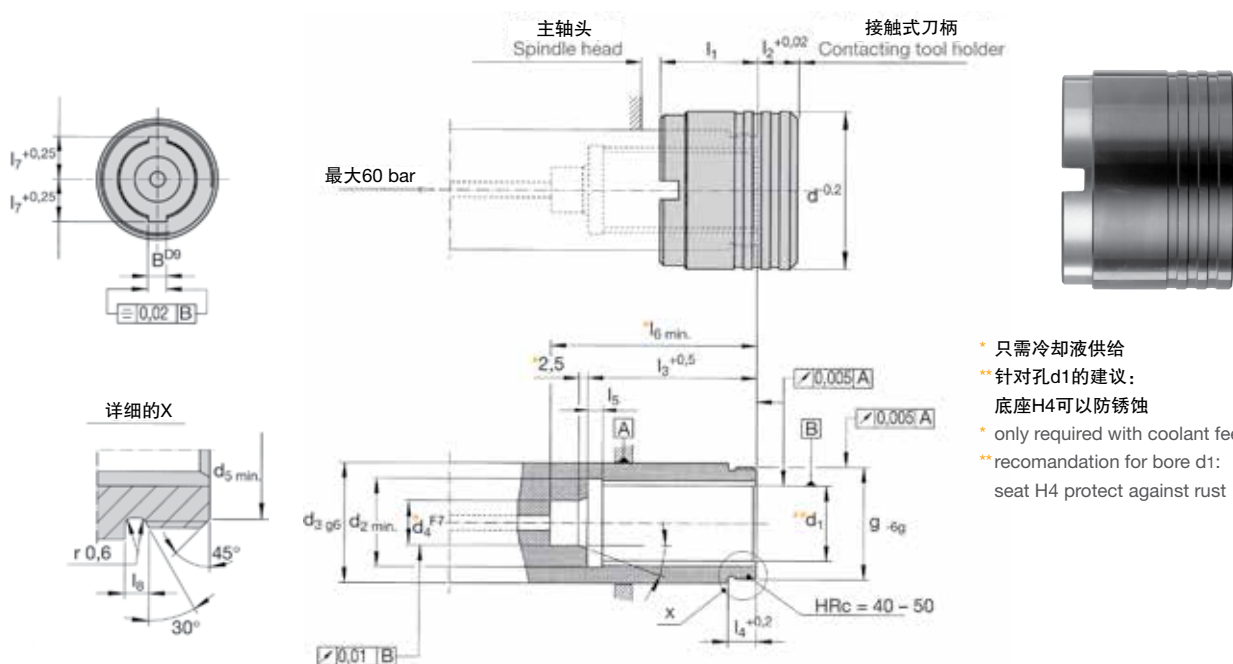
The tools can be set off the machine and the internal adjusting screw allows for easy length setting.

WZHR has versions which accept ESX collets and DIN 1835 shanks.

The system is suitable for both right and left hand operation, and it can also be supplied with a coolant feed facility if required.

Special versions of this range of tooling can be supplied on request.

特点:	优势:	效益:
■ 主轴上的快换刀柄	■ 快换系统 ■ 刀柄快速更换	■ 减少了机床停机时间
■ 短的悬伸长度	■ 高的刚性 ■ 无需导向轴衬	■ 高同心度 ■ 更长的刀具寿命 ■ 更少的刀具更换
■ 紧的主轴孔公差 (h4) 和刀柄柄部公差 (-0.002 — -0.005)	■ 高同心度	■ 适合硬质合金刀具 ■ 更长的刀具寿命 ■ 更少的刀具更换
■ 刀柄带嵌入式长度调节 (WZHR)	■ 在机床外长度调节成为可能	■ 减少了机床停机时间
■ 滚柱设计	■ 轴向自由移动	■ 刀具崩刃风险小
■ 快换系统 ■ 刀柄里自锁	■ 刀柄快速更换	■ 减少了机床停机时间
Features:	Advantages:	Benefits:
■ over spindle quick change chuck	■ quick change system, ■ quick change of the tool holders	■ reduced down time of the machine
■ short projection length	■ high rigidity ■ no guide bushing required	■ high concentricity ■ longer tool life ■ less tool changes
■ tight tolerance in the spindle bore (h4) ■ and at the tool holder shank ■ (-0.002 to -0.005)	■ high concentricity	■ applicable for carbide tools ■ longer tool life ■ less tool changes
■ tool holder with built-in length ■ adjustment (WZHR)	■ length adjustment outside of ■ the machine possible	■ reduced down time of the machine
■ roller design	■ free of axial play	■ less risk of tool breakage
■ quick change system ■ automatic locking of the tool holders ■ in the chuck	■ quick change of the tool holder	■ reduced down time of the machine



- * 只需冷却液供给
- ** 针对孔d1的建议:
底座H4可以防锈蚀
- * only required with coolant feed
- ** recommendation for bore d1:
seat H4 protect against rust



ASR

用于符合图纸的主轴头

For spindle heads according to drawing

型号 Designation	d	d1 H4	d2 min.	d3	d4	d5 min.	l1	l2	l3	l4	l5	l6	l7	l8	B D9	g	Id. No.
ASR 16-35	35	16	20	25	10	22,5	26	10,5	35	6,5	5	45	9,3	1,6	5	M24 x 1	6725266
ASR 20-42	42	20	24	32	12	28,5	26	11	45	7,5	5	55	11,3	1,6	5	M30 x 1	6725267
ASR 25-50	50	25	30	37	12	34,5	29	13	55	7,5	5	65	14,2	1,6	6	M36 x 1	6725268
ASR 28-52	52	28	33	40	16	36,5	29	13	61	7,5	7	73	15,7	1,6	6	M38 x 1	6725269
ASR 32-60	60	32	37	45	16	40	33	14	69,5	8,0	7	81,5	17,7	2,5	8	M42 x 1,5	6725270
ASR 36-68	68	36	41	50	16	46	37	16	80	8,5	7	92	19,7	2,5	8	M48 x 1,5	6725271
ASR20/A1-42	42	20	24	32	12	28,5	26	11	45	7,5	5	55	11,3	1,6	5	M30 x 1	6725377
ASR25/A1-50	50	25	30	37	12	34,5	29	13	55	7,5	5	65	14,2	1,6	6	M36 x 1	6725427
ASR28/A1-52	52	28	33	40	16	36,5	29	13	61	7,5	7	73	15,7	1,6	6	M38 x 1	6725378
ASR32/A1-60	60	32	37	45	16	40	33	14	69,5	8,0	7	81,5	17,7	2,5	8	M42 x 1,5	6725415
ASR36/A1-68	68	36	41	50	16	46	37	16	80	8,5	7	92	19,7	2,5	8	M48 x 1,5	6725428
ASR20/A5-42	42	20		32		28,5	26	10,9		7,5			11,3	1,6	5	M30 x 1	6725616
ASR25/A5-50	50	25		37		34,5	29	12,9		7,5			14,2	1,6	6	M36 x 1	9117359
ASR28/A5-52	52	28		40		36,5	29	12,9		7,5			15,7	1,6	6	M38 x 1	6725572
ASR32/A5-60	60	32		45		40	33	13,9		8,0			17,7	2,5	8	M42 x 1,5	6725554
ASR36/A5-68	68	36		50		46	37	15,9		8,5			19,7	2,5	8	M48 x 1,5	6725555

标准/Standard: < 5000 min-1 + < 50 bar, 适合WZHR刀柄 suitable tool holders WZHR

A1-版本/A1-Version: > 5000 min-1 + > 50 bar, 适合WZHR刀柄 suitable tool holders WZHR

A5-版本/A5-Version: 对于可调节夹头, 务必使用SSM...M螺母 (参见第164页) for adjustable adaptor, always use SSM...M nut see page 168

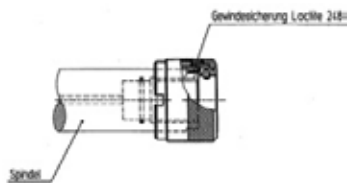
ASR

安装说明

去除带螺纹的主轴，在三点上应用粘结剂。然后把ASR旋入主轴且按一定的扭矩旋紧。

螺钉锁紧会在大约8小时后变硬。

刀柄尺寸	旋紧的扭矩值
ASR16-35	10 Nm
ASR20-42	15 Nm
ASR25-50	20 Nm
ASR28-52	25 Nm
ASR32-60	35 Nm
ASR36-68	50 Nm
ASR48-95	85 Nm



注意!

仅使用BILZ指定的粘结剂Loctite248或者相类似的产品，为了确保刀柄在主轴上防止松动。

机床主轴必须按照我们图纸的规格说明实施（见样本）。

为了防锈我们推荐主轴上H4适配公差，最好的办法是预先做防锈涂层。

需要更多的主轴尺寸，更高的冷却液压力或者结合可调节的快换夹头/SSM螺帽，你应该联系BILZ的技术服务部门。

操作手册

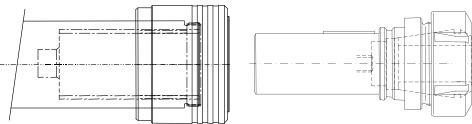
转动刀柄，因此主轴上的方向关键点可以锁到槽里。引入WZHR到机床主轴，ASR的转换套必须被撤回。

通过2个圆柱滚柱，WZHR的V型槽自动锁紧。

移除WZHR刀柄须推回衬套和从主轴上取出刀柄。

转动衬套 ← 推回

刀柄 → 拉出



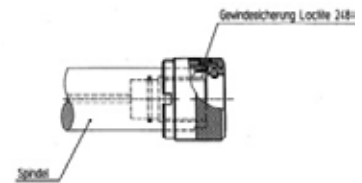
Installation Instruction

Degrease the threaded spindle, apply the adhesive at three points. Then screw the ASR on the thread at the spindle and tighten with the specified torque.

The screw lock will be harden after approx. 8 hours.

Chuck size Tightening torque

Fuller-Groesse	Anzugsmoment max.
ASR16-35	10 Nm
ASR20-42	15 Nm
ASR25-50	20 Nm
ASR28-52	25 Nm
ASR32-60	35 Nm
ASR36-68	50 Nm
ASR48-95	85 Nm



Attention!

Use only the specified BILZ adhesive LOCTITE 248 or comparable products in order to secure the chuck on the machine spindle against loosening.

The machine spindle must be executed according to our drawing specifications. (see catalog).

We recommend the H4 adaptation in the spindle to protect against rust. The best way is advanced anti-corrosive coating.

Need food for other spindle dimensions, higher coolant pressures or in combination with adjustable adaptors / SSM nuts you should contact the Technical Service of the BILZ company.

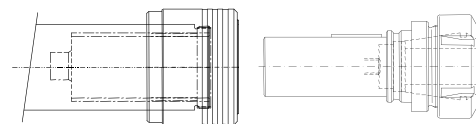
Operating Manual

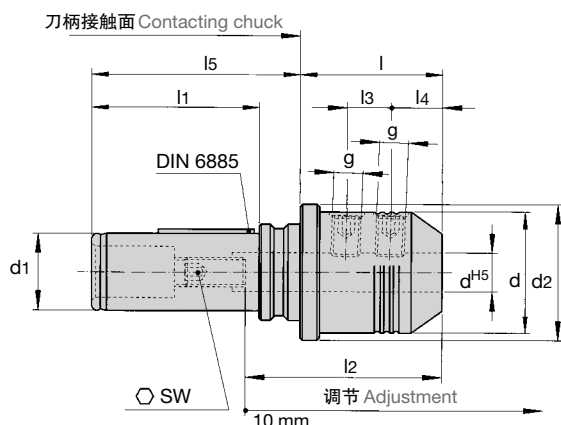
Rotate the tool holder so that the key points in the direction of the spindle located in the groove. To introduce the WZHR holder in the machine spindle the shifting sleeve of the ASR has to be withdrawn.

By the two cylindrical rollers, and the V-groove in the holder WZHR this is automatically locked.

To remove the WZHR holder push back the sleeve and take out the holder from the spindle.

Switching sleeve ← push back tool holder → pull out





WZHR N/E

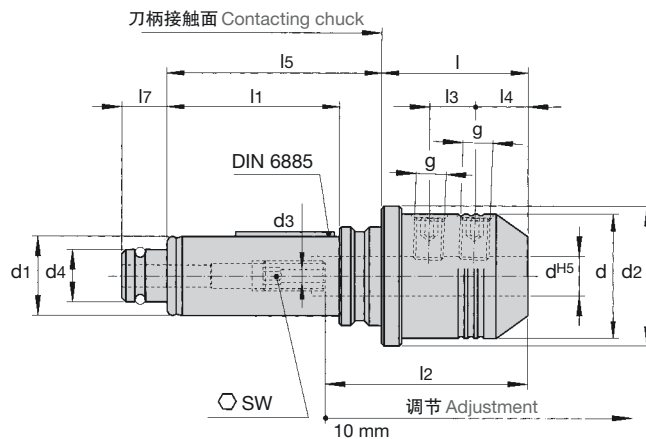
用于具有DIN 1835 E型圆柱形柄部的刀具

For tools with cylindrical shank DIN 1835 form E

型号 Designation	ASR	DIN 1835	ØdH5 Bilz- 标准/Standard	l2 max.	d	d1	d2	l	l1	l3	l4	l5	SW	g
WZHR16 N/E...	16	6	6,1- 7,9	35	25	16	28	25	35	—	18	44,5	2,5	M6
		8	8,1- 9,9	35	28	16	28	25	35	—	18	44,5	3	M8
WZHR20 N/E...	20	8	8,1- 9,9	35	28	20	35	31	44	—	18	55	3	M8
		10	10,1-11,9	39	35	20	35	31	44	—	20	55	4	M10
		12		44	38	20	38	31	44	—	22,5	55	4	M12
WZHR25 N/E...	25	8	8,1- 9,9	35	28	25	42	34	55	—	18	67	3	M8
		10	10,1-11,9	39	35	25	42	34	55	—	20	67	4	M10
		12	12,1-15,9	44	42	25	42	34	55	—	22,5	67	4	M12
		16		47	45	25	45	34	55	—	24	67	4	M14
WZHR28 N/E...	28	10	10,1-11,9	39	35	28	44	36	60	—	20	72	4	M10
		12	12,1-15,9	44	42	28	44	36	60	—	22,5	72	4	M12
		16	16,1-19,9	47	48	28	48	36	60	—	24	72	4	M14
		20		49	48	28	48	36	60	—	25	72	5	M16
WZHR32 N/E...	32	12	12,1-15,9	44	42	32	48	37	68	—	22,5	81,5	4	M12
		16	16,1-19,9	47	48	32	48	37	68	—	24	81,5	4	M14
		20		49	52	32	52	37	68	—	25	81,5	5	M16
WZHR36 N/E...	36	16	16,1-19,9	47	48	36	55	60	78	—	24	94	4	M14
		20	20,1-24,9	49	52	36	55	60	78	—	25	94	5	M16
		25		54	60	36	60	60	78	22	24	94	6	M18x2

订购示例 WZHR 16N/E6,5

Example for ordering WZHR 16N/E6,5



WZHR NK/E

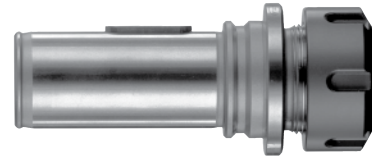
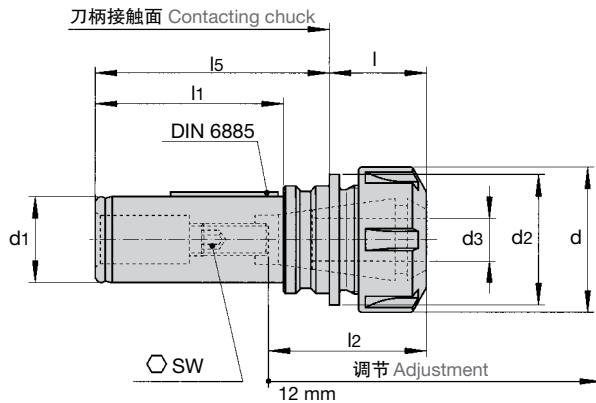
用于具有DIN 1835 E型圆柱形柄部的刀具

For tools with cylindrical shank DIN 1835 form E

型号 Designation	ASR	DIN 1835	ØdH5 Bilz- 标准/Standard	l2 max.	d	d1	d2	d3	d4	l	l1	l3	l4	l5	l7	SW	g
WZHR16 N K/E...	16	6	6,1- 7,9	35	25	16	28	2,5	10	25	35	–	18	44,5	10	2,5	M6
		8	8,1- 9,9	35	28	16	28	3	10	25	35	–	18	44,5	10	3	M8
WZHR20 N K/E...	20	8	8,1- 9,9	35	28	20	35	3	12	31	44	–	18	55	10	3	M8
		10	10,1-11,9	39	35	20	35	4	12	31	44	–	20	55	10	4	M10
		12		44	38	20	38	4	12	31	44	–	22,5	55	10	4	M12
WZHR25 N K/E...	25	8	8,1- 9,9	35	28	25	42	3	12	34	55	–	18	67	10	3	M8
		10	10,1-11,9	39	35	25	42	4	12	34	55	–	20	67	10	4	M10
		12	12,1-15,9	44	42	25	42	4	12	34	55	–	22,5	67	10	4	M12
		16		47	45	25	45	4	12	34	55	–	24	67	10	4	M14
WZHR28 N K/E...	28	10	10,1-11,9	39	35	28	44	4	16	36	60	–	20	72	12	4	M10
		12	12,1-15,9	44	42	28	44	4	16	36	60	–	22,5	72	12	4	M12
		16	16,1-19,9	47	48	28	48	4	16	36	60	–	24	72	12	4	M14
		20		49	48	28	48	5	16	36	60	–	25	72	12	5	M16
WZHR32 N K/E...	32	12	12,1-15,9	44	42	32	48	4	16	37	68	–	22,5	81,5	12	4	M12
		16	16,1-19,9	47	48	32	48	4	16	37	68	–	24	81,5	12	4	M14
		20		49	52	32	52	5	16	37	68	–	25	81,5	12	5	M16
WZHR36 N K/E...	36	16	16,1-19,9	47	48	36	55	4	16	60	78	–	24	94	12	4	M14
		20	20,1-24,9	49	52	36	55	5	16	60	78	–	25	94	12	5	M16
		25		54	60	36	60	6	16	60	78	22	24	94	12	6	M18x2

订购示例 WZHR 16N-K/E6,5

Example for ordering WZHR 16N-K/E6,5



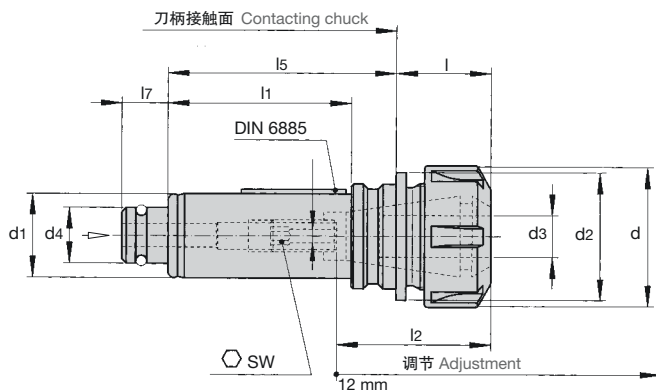
WZHR/ESX

用于ER/ESX DIN 6499 B型弹簧筒夹
For collets type ER/ESX DIN 6499 B

型号/订货号 Designation/Id. No.	ASR/ ASBRA		d3	l2 max.	d	d1	d2	l	l1	l5	SW	订货号 Id. No.
WZHR16 /ESX12 6724639	16	ESX12	1,0 - 2,5 >2,5 - 7,0	24 32	19	16	28	21	35	44,5	3	DIN 894-17 6927729
WZHR16 /ESX16 6724640	16	ESX16	1,0 - 3,0 >3,0 - 10,0	33 43	28	16	28	27	35	44,5	3	DIN 894-25 6927733
WZHR20 /ESX16 6724644	20	ESX16	1,0 - 3,0 >3,0 - 10,0	33 43	28	20	35	27	44	55	3	DIN 894-25 6927733
WZHR20 /ESX20 6724646	20	ESX20	2,0 - 5,0 >5,0 - 13,0	34 47	34	20	35	29	44	55	4	DIN 894-30 6934034
WZHR25 /ESX20 6724649	25	ESX20	2,0 - 5,0 >5,0 - 13,0	34 47	34	25	42	29	55	67	4	DIN 894-30 6934034
WZHR25 /ESX25 6724650	25	ESX25	2,0 - 5,0 >5,0 - 16,0	36 51	42	25	42	30,5	55	67	4	E 25 6921608
WZHR28 /ESX25 6724654	28	ESX25	2,0 - 5,0 >5,0 - 16,0	36 51	42	28	44	30,5	60	72	4	E 25 6921608
WZHR28 /ESX32 6724656	28	ESX32	3,0 - 6,0 >6,0 - 20,0	41 56	50	28	44	38	60	72	5	E 32 6921609
WZHR32 /ESX25 6724658	32	ESX25	2,0 - 5,0 >5,0 - 16,0	36 51	42	32	48	30,5	68	81,5	4	E 25 6921608
WZHR32 /ESX32 6724659	32	ESX32	3,0 - 6,0 >6,0 - 20,0	41 53	50	32	48	32,5	68	81,5	5	E 32 6921609
WZHR36 /ESX32 6724662	36	ESX32	3,0 - 6,0 >6,0 - 20,0	41 56	50	36	55	32,5	78	94	5	E 32 6921609
WZHR36 /ESX40 6724663	36	ESX40	4,0 - 6,0 >6,0 - 25,0	47 62	63	36	55	42	78	94	5	E 40 6921610

ESX12筒夹按0.5mm递增供应，其它型号按1mm递增供应，见第34页。

ESX12 available in steps of 0,5 mm, all other sizes available in steps of 1 mm see page 34



WZHR K/ESX

用于ER/ESX DIN 6499 B型弹簧筒夹
For collets type ER/ESX DIN 6499 B

型号/订货号 Designation/Id. No.	ASR/ ASBRA		d3	l2 max.	d	d1	d2	d4	l	l1	l5	l7	SW	订货号 Id. No.
WZHR16 - K/ESX12 6725245	16	ESX12	1,0 - 2,5 >2,5 - 7,0	24 32	19	16	28	10	21	35	44,5	10	3	DIN 894-17 6927729
WZHR16 - K/ESX16 6725030	16	ESX16	1,0 - 3,0 >3,0 - 10,0	33 43	28	16	28	10	27	35	44,5	10	3	DIN 894-25 6927733
WZHR20 - K/ESX16 6725178	20	ESX16	1,0 - 3,0 >3,0 - 10,0	33 43	28	20	35	12	27	44	55	10	3	DIN 894-25 6927733
WZHR20 - K/ESX20 6725010	20	ESX20	2,0 - 5,0 >5,0 - 13,0	34 47	34	20	35	12	29	44	55	10	4	DIN 894-30 6934034
WZHR25 - K/ESX20 6725049	25	ESX20	2,0 - 5,0 >5,0 - 13,0	34 47	34	25	42	12	29	55	67	10	4	DIN 894-30 6934034
WZHR25 - K/ESX25 6724958	25	ESX25	2,0 - 5,0 >5,0 - 16,0	36 51	42	25	42	12	30,5	55	67	10	4	E 25 6921608
WZHR28 - K/ESX25 6724972	28	ESX25	2,0 - 5,0 >5,0 - 16,0	36 51	42	28	44	16	30,5	60	72	12	4	E 25 6921608
WZHR28 - K/ESX32 6725016	28	ESX32	3,0 - 6,0 >6,0 - 20,0	41 56	50	28	44	16	38	60	72	12	5	E 32 6921609
WZHR32 - K/ESX25 -	32	ESX25	2,0 - 5,0 >5,0 - 16,0	36 51	42	32	48	16	30,5	68	81,5	12	4	E 25 6921608
WZHR32 - K/ESX32 6725264	32	ESX32	>3,0 - 6,0 >6,0 - 20,0	41 53	50	32	48	16	32,5	68	81,5	12	5	E 32 6921609
WZHR36 - K/ESX32 -	36	ESX32	3,0 - 6,0 >6,0 - 20,0	41 56	50	36	55	16	32,5	78	94	12	5	E 32 6921609
WZHR36 - K/ESX40 6725017	36	ESX40	4,0 - 6,0 >6,0 - 26,0	47 62	63	36	55	16	42	78	94	12	5	E 40 6921610

ESX12筒夹按0.5mm递增供应，其它型号按1mm递增供应，见第34页。
ESX12 available in steps of 0,5 mm, all other sizes available in steps of 1 mm see page 34

请注意：螺帽不含密封圈
Please note: Clamping nut with out sealing disc

ASB – ASBA

可换式快换钻削刀柄

Over Spindle Quick Change Drilling Chuck

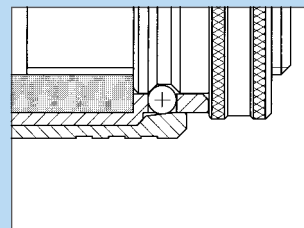
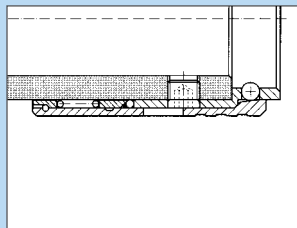
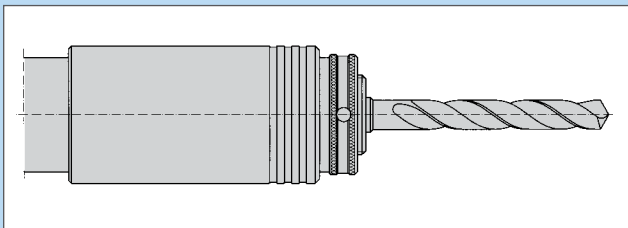
bilz

应用：钻削，钻沉孔，倒角，铰削，磨削

机器型号：生产线，多主轴钻床，专机

Application: drilling, counterboring, chamfering, reaming, honing

Machine type: transfer lines, multispindle drilling, special purpose machines



主轴上的快换刀柄用于钻削，铰削和沉孔加工

主轴上的快换钻削刀柄可以被固定在DIN55058的机床主轴上。通过一种特殊螺孔固定。这种螺孔位于机床主轴的锥度孔上，钻削刀柄内部的衬套上有6个孔，可以容纳主轴上的锥度孔的位置公差，确保自由定位。

这些刀柄结合Bilz SSM可调锁紧螺母，为可快换夹头和DIN 6327的梯形柄刀杆提供了快速有效的快换系统。它们可以用在多主轴机床上、流水线上和转机上。

刀具可以快速容易的更换，并且自动锁到快换系统里。

刀具通过从里面向前拉开快换刀柄上的衬套，然后从主轴上移除刀具。

这个快换系统确保在机床主轴上安全和自由夹紧。刀具更换仅在主轴停止进行，即使如在多主轴机床上受限制的位置也容易取出。

Over spindle quick change chucks for drilling, reaming and counterboring tools

The over spindle quick change drilling chucks can be fixed to the noses of machine spindles in conformity with DIN 55058. They are located on the spindle by means of a special screw which locks the chuck on to the spindle nose. This screw locates in a tapped hole in the spindle. The inner sleeve of the chuck has six holes which accommodate the positional tolerance of the tapped hole in the spindle and ensure free of play positioning.

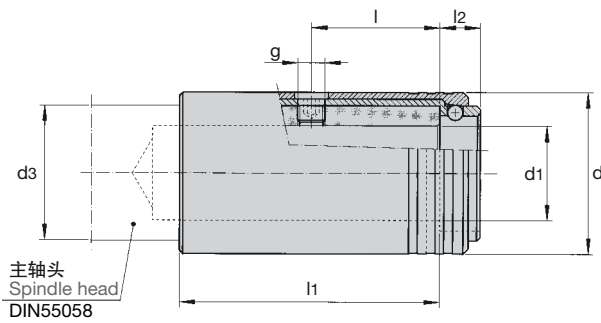
These chucks, combined with the Bilz SSM adjustable lock nuts provide a rapid and effective quick change system for adjustable adaptors and toolholders with DIN 6327 trapezoidal shanks. They can be used on multi-spindle machines, transfer lines and special purpose machines.

Tools can be changed quickly and easily, the tools are automatically locked into the unit.

The tools are released by pulling forward the outer sleeve of the chuck and removing the tool from the spindle.

This quick change system ensures the safe, play-free clamping in the spindle. Tool change is carried out only when the spindle is stopped and the tools are easily handled even in restricted locations on equipment such as multi-spindle heads.

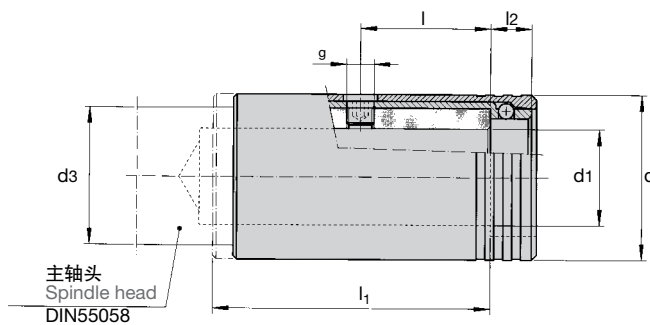
特点:	优势:	效益:
■ 钻削刀柄可被用在DIN55058主轴上或者BS 1935;1972(ACME)主轴上	■ 多主轴头可以很容易被翻新	■ 专机/机床停机时间会被减少，生产效率被提高
■ 快换系统（也用于主轴间距离小的情况）	■ 主轴不旋转时快速换刀无需附加刀具	■ 短的换刀时间
■ SSM螺母替换了现有的SM螺母	■ 当快换夹头插入刀柄SSM螺母自动锁紧 ■ 在机床外进行长度调节成为可能 ■ 刀柄夹住可调节的夹头，轴向没有移动	■ 短的换刀时间 ■ 减少了机床停机时间 ■ 少的刀具崩刃危险
Features:	Advantages:	Benefits:
■ drilling chucks can be used on spindles acc. to DIN55058 or acc. to BS 1935: 1972 (ACME)	■ multi spindle heads can be retrofitted easily	■ down time of the transfer line/ machine will be reduced and the productivity increased
■ quick change system (also for close center distances)	■ quick tool change without additional tool and while the spindle is not rotating	■ short tool changing time
■ SSM-nut replaces the existing SM-nut	■ automatic locking of the SSM nut when inserting the adaptor into the chuck ■ possible length adjustment outside of the machine ■ adjustable adaptors are hold in the chuck without axial play	■ short tool changing time ■ reduction of the machine down time ■ less danger of tool breakage



ASB

型号 Designation	订货号/Id. No.		d	d1	d3	l	l1	l2	g		订货号 Id. No.
ASB 12	6724516	SSM 12	24	12	20	22	42	9	M5	BN 138-62	6917761
ASB 16	6724526	SSM 16	30	16	25	34	65	9,5	M6	BN 138-25	6920256
ASB 20	6724543	SSM 20	38	20	32	34	67	11	M6	BN 138- 2	6907012
ASB 25	6724562	SSM 25	45	25	37	38	76	12	M8	BN 138- 4	6907014
ASB 28	6724576	SSM 28	48	28	40	38	78	12	M8	BN 138- 4	6907014
ASB 36	6724607	SSM 36	60	36	50	45	98	16	M8	BN 138- 5	6907015

双手操作
Two – hand operation

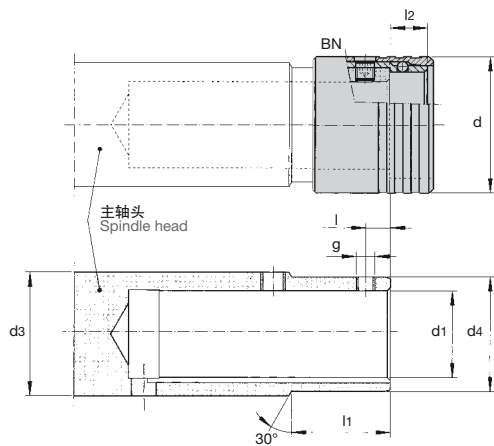


ASBA

型号 Designation	订货号/Id. No.		d	d1	d3	l	l1	l2	g		订货号 Id. No.
ASBA 12	6724515	SSM 12	24	12	20	22	52	9	M5	BN 138-62	6917761
ASBA 16	6724523	SSM 16	30	16	25	34	67	9,5	M6	BN 138-25	6920256
ASBA 20	6724540	SSM 20	38	20	32	34	72	11	M6	BN 138- 2	6907012
ASBA 25	6724561	SSM 25	45	25	37	38	79	12	M8	BN 138- 4	6907014
ASBA 28	6724573	SSM 28	48	28	40	38	81	12	M8	BN 138- 4	6907014
ASBA 36	6724605	SSM 36	60	36	50	45	100	16	M8	BN 138- 5	6907015

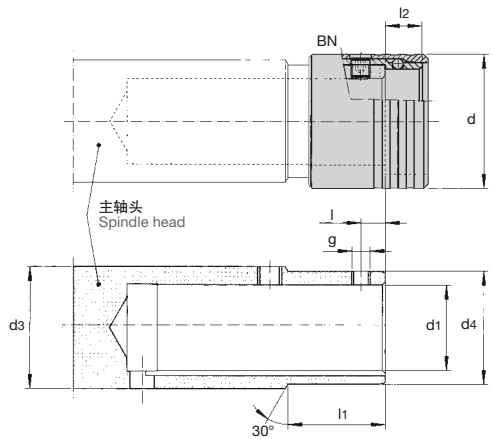
单手操作
One – hand operation

ASBV-ASBVA — 快换钻削刀柄
ASBV-ASBVA – Quick change drilling chucks



ASBV												
修改了的外径减小的主轴头DIN 55058												
With reduced outer diameter Spindle head DIN 55058 modified												
型号	订货号/Id. No.		d	d1	d3	d4	l	l1	l2	g		订货号
Designation	Id. No.											Id. No.
ASBV16	6724532	SSM 16	27	16	25	22	8	30	9,5	M5	BN 138-11	6907017
ASBV20	6724552	SSM 20	34	20	32	28	8	30	11	M5	BN 138-11	6907017
ASBV25	6724567	SSM 25	41	25	37	34,5	8	32	12	M6	BN 138- 2	6907012
ASBV28	6724586	SSM 28	44	28	40	37	8	32	12	M6	BN 138-25	6920256
ASBV32	6724601	SSM 32	49	32	45	41	9	39	13,5	M6	BN 138- 2	6907012
ASBV36	6724617	SSM 36	55	36	50	46	9	39	16	M6	BN 138- 2	6907012
ASBV48	6724631	SSM 48	73	48	67	61	11	51	20	M8	BN 138- 5	6907015

双手操作
Two – hand operation

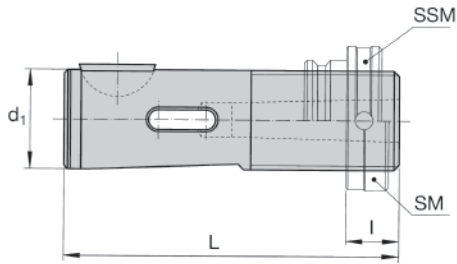


ASBVA												
修改了的外径减小的主轴头DIN 55058												
With reduced outer diameter. Spindle head DIN 55058 modified												
型号	订货号/Id. No.		d	d1	d3	d4	l	l1	l2	g		订货号
Designation	Id. No.											Id. No.
ASBVA16	6724533	SSM 16	27	16	25	22	8	30	9,5	M5	BN 138-11	6907017
ASBVA20	6724553	SSM 20	34	20	32	28	8	30	11	M5	BN 138-11	6907017
ASBVA25	6724568	SSM 25	41	25	37	34,5	8	32	12	M6	BN 138- 2	6907012
ASBVA28	6724587	SSM 28	44	28	40	37	8	32	12	M6	BN 138-25	6920256
ASBVA32	6724602	SSM 32	49	32	45	41	9	39	13,5	M6	BN 138- 2	6907012
ASBVA36	6724618	SSM 36	55	36	50	46	9	39	16	M6	BN 138- 2	6907012
ASBVA48	6724632	SSM 48	73	48	67	61	11	51	20	M8	BN 138- 5	6907015

单手操作
One – hand operation

D型和H型可调节夹头
Adjustable adaptors Type D and Type H

bilz

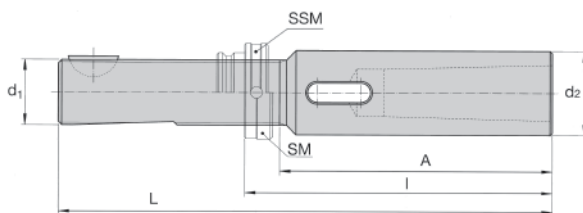


DIN
6327



D型/Type D

型号 Designation	MK...	d1	SSM l min	SSM l max	SM l min	SM l max	L	订货号 Id. No.
DIN6327- D 12 x ME6	Metr. 6	12	9	25	12	28	62	6724665
DIN6327- D 16 x 0	MK0	16	9	37	12	40	85	6724670
DIN6327- D 16 x 1	MK1	16	9	37	12	40	85	6724671
DIN6327- D 20 x 1	MK1	20	9	37	12	40	88	6724676
DIN6327- D 25 x 1	MK1	25	10	38	12	42	95	6724685
DIN6327- D 25 x 2	MK2	25	10	38	12	42	95	6724686
DIN6327- D 28 x 1	MK1	28	10	38	12	42	95	6724694
DIN6327- D 28 x 2	MK2	28	10	38	12	42	95	6724695
DIN6327- D 32 x 2	MK2	32	10	46	12	48	116	6724700
DIN6327- D 32 x 3	MK3	32	10	46	12	48	116	6724701
DIN6327- D 36 x 2	MK2	36	10	46	14	50	118	6724708
DIN6327- D 36 x 3	MK3	36	10	46	14	50	118	6724709
DIN6327- D 48 x 3	MK3	48	14	61	18	65	144	6724721
DIN6327- D 48 x 4	MK4	48	14	61	18	65	144	6724722



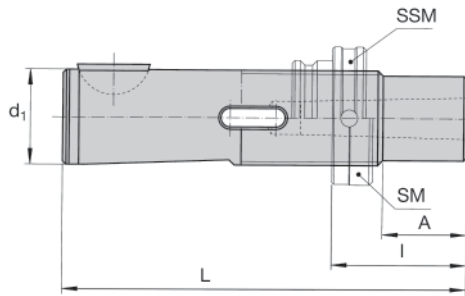
DIN
6327



H型/Type H

型号 Designation	MK...	A	d1	d2	SSM l min	SSM l max	SM l min	SM l max	L	订货号 Id. No.
DIN6327- H12 x 0	MK0	73	12	18	82	100	85	103	135	6724897
DIN6327- H16 x 1	MK1	79	16	20	88	116	91	119	164	6724908
DIN6327- H16 x 2	MK2	94	16	25	103	131	106	134	179	6724917
DIN6327- H20 x 2	MK2	94	20	28	103	131	106	134	182	6724911
DIN6327- H25 x 3	MK3	117	25	36	127	157	129	159	212	6724975
DIN6327- H28 x 3	MK3	117	28	36	127	157	129	159	212	6724885
DIN6327- H36 x 4	MK4	146	36	48	156	192	160	196	264	6724913

F型可调节夹头
Adjustable adaptors Type F



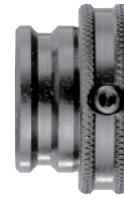
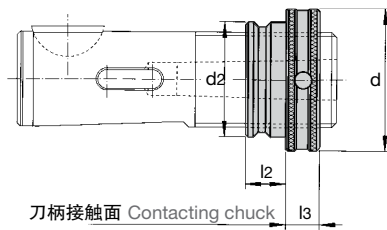
F型/Type F									
型号 Designation	MK...	A	d1	SSM l min	SSM l max	SM l min	SM l max	L	订货号 Id. No.
DIN6327- F 12 x ME6 x 20	Metr.6	20	12	29	45	32	48	82	6724726
DIN6327- F 16 x 0 x 25	MK0	25	16	34	62	37	65	110	6724732
DIN6327- F 16 x 0 x 50	MK0	50	16	59	87	62	90	135	6724733
DIN6327- F 16 x 0 x 75	MK0	75	16	84	112	87	115	160	6724734
DIN6327- F 16 x 0 x 100	MK0	100	16	109	137	112	140	185	6724735
DIN6327- F 16 x 1 x 25	MK1	25	16	34	62	37	65	110	6724736
DIN6327- F 16 x 1 x 50	MK1	50	16	59	87	62	90	135	6724737
DIN6327- F 16 x 1 x 75	MK1	75	16	84	112	87	115	160	6724738
DIN6327- F 16 x 1 x 100	MK1	100	16	109	137	112	140	185	6724739
DIN6327- F 20 x 1 x 25	MK1	25	20	34	62	37	65	113	6724754
DIN6327- F 20 x 1 x 50	MK1	50	20	59	87	62	90	138	6724755
DIN6327- F 20 x 1 x 75	MK1	75	20	84	112	87	115	163	6724756
DIN6327- F 20 x 1 x 100	MK1	100	20	109	137	112	140	188	6724757
DIN6327- F 28 x 1 x 25	MK1	25	28	35	63	37	67	120	6724793
DIN6327- F 28 x 1 x 50	MK1	50	28	60	88	62	92	145	6724794
DIN6327- F 28 x 1 x 75	MK1	75	28	85	113	87	117	170	6724795
DIN6327- F 28 x 1 x 100	MK1	100	28	110	138	112	142	195	6724796
DIN6327- F 28 x 2 x 25	MK2	25	28	35	63	37	67	120	6724797
DIN6327- F 28 x 2 x 50	MK2	50	28	60	88	62	92	145	6724798
DIN6327- F 28 x 2 x 75	MK2	75	28	85	113	87	117	170	6724799
DIN6327- F 28 x 2 x 100	MK2	100	28	110	138	112	142	195	6724800
DIN6327- F 36 x 2 x 30	MK2	30	36	40	76	44	80	148	6724838
DIN6327- F 36 x 2 x 60	MK2	60	36	70	106	74	110	178	6724839
DIN6327- F 36 x 2 x 90	MK2	90	36	100	136	104	140	208	6724840
DIN6327- F 36 x 2 x 120	MK2	120	36	130	166	134	170	238	6724841
DIN6327- F 36 x 3 x 30	MK3	30	36	40	76	44	80	148	6724843
DIN6327- F 36 x 3 x 60	MK3	60	36	70	106	74	110	178	6724844
DIN6327- F 36 x 3 x 90	MK3	90	36	100	136	104	140	208	6724845
DIN6327- F 36 x 3 x 120	MK3	120	36	130	166	134	170	238	6724846

长度调节量 Length adjustment	
SM	I
TR 16	28
TR 20	28
TR 28	30
TR 36	36
TR 48	47

DIN
6327



SSM调节螺母类型, 用于具有快换系统的钻夹头
Adjusting nut type SSM for drilling chucks with quick change system



SSM

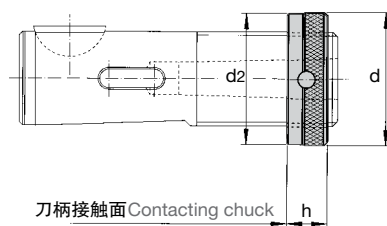
使用双引导表面调节螺母, 以便获得精确的钻削和镗孔深度。用于可调节夹头DIN 6327

Adjusting nuts with double guidance surface, for accurate drilling and counterboring depths. For adjustable adaptors DIN 6327

型号 Designation	d	d2	l2	l3	订货号 Id. No.
SSM 12	22	16,4	9	9	6724517
SSM 16	26	19,9	9,5	9	6724527
SSM 16 M					6725253
SSM 20	33	25,4	11	9	6724544
SSM 20 M					6725167
SSM 25	40	31,9	12	10	6724563
SSM 25 M					6725235
SSM 28	42	33,9	12	10	6724577
SSM 28 M					6725318
SSM 32	47	37,9	13,5	10	6724595
SSM 32 M					6724603
SSM 36	54	43,4	16	10	6724608
SSM 36 M					6724620
SSM 48	72	57,9	20	14	6724627

SM型调节螺母

Adjusting nut type SM

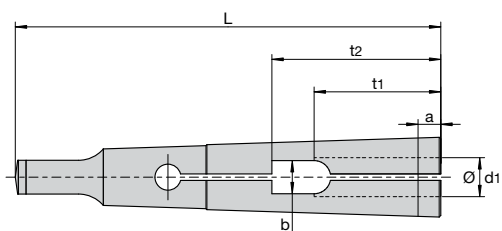


SM

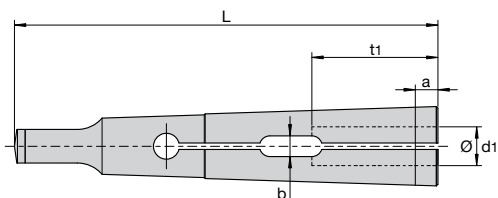
用于可调节夹头DIN 6327的调节螺母

Adjusting nuts for adjustable adaptors DIN 6327

型号 Designation	d	d2	h	订货号 Id. No.
SM 12	19,7	19	12	6805012
SM 16	24,6	24	12	6805016
SM 20	31,6	31	12	6805020
SM 25	36,6	36	12	6805025
SM 28	39,6	39	12	6805028
SM 32	44,6	44	12	6805032
SM 36	49,6	49	14	6805036
SM 48	66,6	66	18	6805048



DIN 6328 用于带圆柱柄和方尾的刀具 For tools with cylindrical shank and square												(丝维 Tap)	
		MK 0			MK 1			MK 2			MK 3		
d1 ^{H7}	L	59,5			65,5			80			99		
	a	3			3,5			5,0			5,0		
Ø		b	t1	t2	b	t1	t2	b	t1	t2	b	t1	t2
2,47 – 2,83		2,2	15	19	2,2	15	19						
2,83 – 3,20		2,5	15	19	2,5	15	19						
3,20 – 3,60		2,8	16	21	2,8	16	21						
3,60 – 4,01		3,1	16	21	3,1	16	21						
4,01 – 4,53		3,5	16	21	3,5	16	21						
4,53 – 5,08					4,0	18	24	4,0	18,0	24			
5,08 – 5,79					4,5	18	24	4,5	18,0	24			
5,79 – 6,53					5,1	19,5	26	5,1	19,5	26			
6,53 – 7,33					5,7	19,5	26	5,7	19,5	26			
7,33 – 8,27					6,4	19,5	27	6,4	19,5	27			
8,27 – 9,46								7,3	22,0	30	7,3	22	30
9,46 –10,67								8,3	23,0	32	8,3	23	32
10,67 –12,00								9,3	24,0	34	9,3	24	34
12,00 –13,33											10,3	25	36
13,33 –14,67											11,3	26	38
14,67 –16,00											12,3	27	40
16.00 –17.33										13.3	30	44	



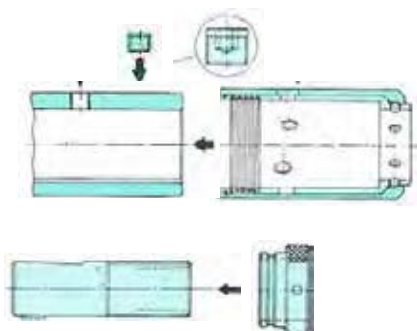
DIN 6329 用于带圆柱柄驱动的刀具 For tools with cylindrical shank and driver (麻花钻 Drill)									
Ø	L	MK 0		MK 1		MK 2		MK 3	
		59,5		65,5		80		99	
d1 ^{H7}	a	3		3,5		5,0		5,0	
Ø		b	t1	b	t1	b	t1	b	t1
1,6 – 2,9			16						
2,9 – 3,5		1,8	20	1,8	20				
3,5 – 4,0		2,2	20	2,2	20				
4,0 – 4,5		2,4	20	2,4	20				
4,5 – 5,5		2,7	20	2,7	20				
5,5 – 6,5				3,2	22	3,2	22		
6,5 – 8,0				3,8	22	3,8	22		
8,0 – 9,5						4,8	25	4,8	25
9,5 – 11,0						5,3	28	5,3	28
11,0 – 13,0						6,3	28	6,3	28
13,0 – 15,0								7,4	32
15,0 – 18,0								8,4	32

ASB, ASBV, ASBA, ASBVA

安装说明

推动快换夹头到机床主轴（DIN55058）。转动内衬套，这样6个钢珠中的1个在螺纹上方的正确位置（孔偏置大概0.1mm，中心点位置用一个点标记）。转入包含的设置螺钉。

当装配好后，旋转外衬套90度，这样螺钉轴被覆盖。然后检测衬套的光顺移动。



注意！

仅使用BILZ提供的设置螺钉，没有标准的设置螺钉，因为这会造成损坏和故障。

机床主轴必须根据DIN55058设计。

对于其它主轴尺寸，请联系BILZ公司的技术服务部门。

操作手册

转动刀柄使槽的指示方向的关键点定位在主轴上。插入刀柄到机床主轴，在ASB/ASBV上必须转动轴撤回衬套。ASB/ASBV足够推动刀柄到主轴。通过夹持机构和SSM螺母的V型槽，刀柄自动锁紧。

刀柄被夹持住



取出刀柄



推动衬套

夹持刀柄



推进刀柄（ASBA）

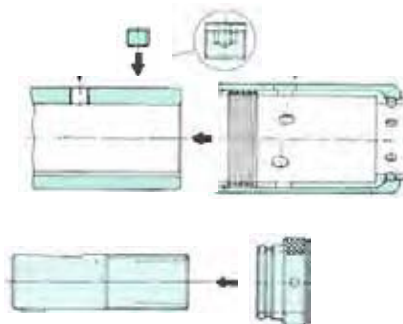
从主轴上移除刀柄，拉回后面的衬套。钢珠松开了刀柄，刀柄可以容易的被移除。刀柄万一换成ASB，通过一只手撤回转换衬套，用另外一只手移除刀柄。在ASBA（单手操作）中足够的转移衬套滑回，也就是被锁的位置，然后用同只手移除刀柄。

ASBV快换刀柄减少了外径（细长型）能实现工件非常靠近主轴的应用。ASBVA快换刀柄相当于细长型和为自动锁紧设计（单手操作）

Installation Instruction

Push the quick change on the machine spindle (DIN55058). Twist the inner sleeve so that one of the bore 6 is above the thread in the correct position (the holes are offset by 0,1 mm, the centre position marked with a dot). Turn in the included set screw.

After assembly, rotate the outer sleeve by 90 °, so that the screw shaft is covered. Then check the smooth movement of the sleeve.



Attention!

Use only the supplied set screws of BILZ, no standard set screws, as this will cause damage and malfunction.

The machine spindle must be designed according to DIN 55058.

For other spindle sizes please contact the Technical Service of the company BILZ.

Operating Manual

Rotate the tool holder so that the key points in the direction of the groove located in the spindle. For insertion of the holder in the machine spindle at the ASB / ASBV must shift the sleeve to be withdrawn. At ASBA / ASBVA chucks it is enough to push the holder into the spindle. By the clamping mechanism, and the V-groove in the nut of the SSM holder is automatically locked.

Holder clamped



Take out holder



Pull sleeve

Clamp holder



Push in holder (ASBA)

To remove the holder from the spindle, pull back the black sleeve. The balls release the holder and it can be freely removed. The tool holder exchange is in the case of ASB, by retraction of the switching sleeve with one hand and the removal of the holder with the other hand. In ASBA (hand operation), it is sufficient to shift sleeve to slide back, which is locked there, and then remove the holder with the same hand.

ASBV quick change have to be able to realize a reduced outer diameter (slim version) at distances closer spindle. ASBVA quick change are equally slim and designed for automatic lock (one hand operation).

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攻丝和冷挤压操作的建议扭矩

Recommended torques for tapping and cold forming operations

bilz



Nm	M	惠氏螺纹 BSW	惠氏螺纹 G BSP parallel	BSF	BSP	BA	PG	NPT	UNC	UNF	ft.lbs
0,3	M 2					Nr. 9				Nr. 2	0,22
0,4	M 2,5					Nr. 8				Nr. 3	0,29
0,5	M 3					Nr. 7					0,36
0,6						Nr. 6			Nr. 3	Nr. 4	0,43
0,8	M 3,5					Nr. 5			Nr. 4	Nr. 5	0,58
1		1/8"				Nr. 4			Nr. 5		0,72
1,2						Nr. 4				Nr. 6	0,87
1,6	M 4								Nr. 6	Nr. 8	1,16
2		5/32"				Nr. 3			Nr. 8		1,45
2,5	M 5			3/16"		Nr. 2				Nr. 10	1,81
3										Nr. 12	2,17
4		3/16"		7/32"		Nr. 1			Nr. 10	1/4"	2,89
5	M 6	7/32"		1/4"		Nr. 0			Nr. 12		3,62
6			G 1/8"	9/32"						5/16"	4,34
8		1/4"		5/16"					1/4"	3/8"	5,79
10	M 8										7,23
12		5/16"		3/8"			PG 7		5/16"	7/16"	8,68
16										1/2"	11,58
18	M 10	3/8"	G 1/4"	7/16"	1/8"				3/8"		13,02
20							PG 9	1/8"			14,47
22							PG 11			9/16"	15,91
25				1/2"			PG 13,5			5/8"	18,08
28	M 12	7/16"	G 3/8"				PG 16		7/16"		20,25
32				9/16"							23,15
36										3/4"	26,04
40				5/8"					1/2"		28,93
45	M 14	1/2"		11/16"			PG 21				32,55
50	M 16		G 1/2"		1/4"				9/16"		36,17
56			G 5/8"					1/4"		7/8"	40,51
63		5/8"		3/8"			PG 29		5/8"		45,57
70			G 3/4"	3/4"				3/8"			50,63
80	M 18		G 7/8"	13/16"			PG 36				57,86
90	M 20	3/4"		7/8"			PG 42		3/4"	1"	65,10

这些规定的扭矩适用于攻丝和冷挤压操作。

它们适合的材料抗拉强度为1000N/mm²。

攻丝的扭矩值包括了100%的磨损因素。

如果必要，这些数值在攻丝时可以提高至20%，在冷挤压操作可提高至50%。

The given torques are for tapping and cold forming operations.

They pertain to material with a tensile strength of σ_B 1000 N/mm².

The torque values for tapping include a wear factor of 100 %.

If necessary, these values can be increased by up to 20 % for tapping and by up to 50 % for cold forming operations.



攻丝和冷挤压操作的建议扭矩

Recommended torques for tapping and cold forming operations



Nm	M	惠氏螺纹 BSW	惠氏螺纹 G BSP parallel	BSF	BSP	BA	PG	NPT	UNC	UNF	ft.lbs
100	M 22	7/8"					PG 48			1 1/8"	72,33
110										1 1/4"	79,56
125				1"					7/8"	1 3/8"	90,41
140			G 1"							1 1/2"	101,26
160	M 24	1"	G 1 1/8"		1/2"			1/2"			115,73
180	M 27		G 1 1/4"	1 1/8"							130,19
200			G 1 3/8"	1 1/4"	3/4"			3/4"	1"		144,66
220			G 1 1/2"								159,13
240		1 1/8"	G 1 3/4"								173,59
260			G 2"	1 3/8"							188,06
280	M 30	1 1/4"							1 1/8"		202,53
300			G 2 1/4"	1 1/2"							216,99
320	M 33			1 5/8"					1 1/4"		231,46
340			G 2 1/2"		1"			1"			245,92
360			G 2 3/4"								260,37
400			G 3"								289,32
420	M 36	1 3/8"	G 3 1/4"								303,79
450		1 1/2"	G 3 1/2"	1 3/4"	1 1/4"			1 1/4"			325,49
480	M 39		G 3 3/4"						1 3/8"		347,19
500			G 4"	2"					1 1/2"		361,65
560					1 1/2"			1 1/2"			405,04
630	M 42	1 5/8"									455,68
710	M 45	1 3/4"		2 1/4"	2"			2"			513,55
800				2 1/2"							578,64
900	M 48			2 3/4"					1 3/4"		650,97
1000	M 52	2"			2 1/2"						723,30
1100											795,63
1250	M 56	2 1/4"							2"		904,13
1400		2 1/2"		3"	3"			2 1/2"			1012,62
2000								3"			1446,61
2200											1591,27

这些规定的扭矩适用于攻丝和冷挤压操作。

它们适合的材料抗拉强度为1000N/mm²。

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The given torques are for tapping and cold forming operations.

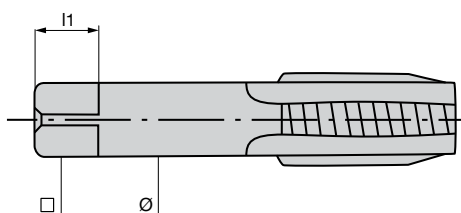
They pertain to material with a tensile strength of σ_B 1000 N/mm².

The torque values for tapping include a wear factor of 100 %.

If necessary, these values can be increased by up to 20 % for tapping and by up to 50 % for cold forming operations.

丝锥柄部尺寸符合DIN/JIS标准

Tap shank dimensions to DIN/JIS

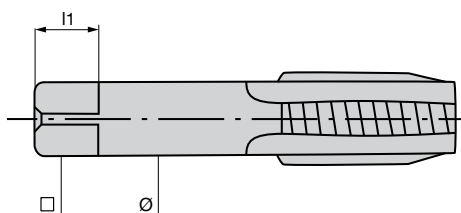


Ø x □	□ l1	DIN 371	DIN 374	DIN 376	JIS B 4430 1988	DIN 2182 BSW	DIN 2183 BSW	DIN 5156 DIN 5157	DIN 371 UNF	DIN 371 UNC	DIN 374 UNF	DIN 376 UNC
2,5 x 2,1	5	M1		M3,5		1/16"						
		M1,1	M3,5									
		M1,2										
		M1,4										
		M1,6							Nr. 2 – 64			Nr. 6 – 32
		M1,8							Nr. 3 – 56		Nr. 6 – 40	Nr. 8 – 32
2,8 x 2,1	5	M2	M4	M4		3/32"	5/32"					
		M2,2								Nr. 2 – 56		
		M2,5								Nr. 3 – 48	Nr. 8 – 36	
3,0 x 2,5	5				M1,0 – M1,2							
					M1,4 – M1,7							
					M1,8 – M2,2							
					M2,3 – M2,6							
3,5 x 2,7	6	M3	M5	M4,5+M5		1/8"			Nr. 5 – 44	Nr. 5 – 40		
4,0 x 3,0	6	M3,5	M5,5			7/32"			Nr. 6 – 40	Nr. 6 – 32	Nr. 12 – 28	Nr. 12 – 24
4,0 x 3,2	6				M3							
					M3,5							
4,5 x 3,4	6	M4	M6	M6		5/32"	1/4"		Nr. 8 – 36	Nr. 8 – 32	1/4" – 28	1/4" – 20
5,0 x 4,0	7				M4							
					M4,5							
5,5 x 4,3	7		M7	M7								
5,5 x 4,5	7				M5							
6,0 x 4,5	7				M6							
6,0 x 4,9	8	M4,5						G 1/16"	Nr. 10 – 32			5/16" – 18
		M5							Nr. 12 – 28	Nr. 10 – 24		
		M6	M8	M8						Nr. 12 – 28		
6,2 x 5,0	8				M7							
					M8							
7,0 x 5,5	8	M7	M9,M10	M9,M10	M9	1/4"	3/8"	G 1/8"	1/4" – 28	1/4" – 20	3/8" – 24	3/8" – 16
					M10							
8,0 x 6,2	9	M8	M11			5/16"	7/16"		5/16" – 24	5/16" – 18		
8,0 x 6,5	9				M11							
8,5 x 6,5	9				M12							
9,0 x 7,0	10	M9	M12	M12		3/8"	1/4"		3/8" – 24	3/8" – 16	1/2" – 20	1/2" – 13
10,0 x 8,0	11	M10										
10,5 x 8,0	11				M14							
11,0 x 9,0	12		M14	M14		9/16"	G 1/4"				5/8" – 18	5/8" – 11
12,0 x 9,0	12	M12	M16	M16			5/8"	G 3/8"				
12,5 x 10,0	13				M16							
13,0 x 10,0	13				M17						3/4" – 16	3/4" – 10

■ 柄部直径加强
■ Shank diameter reinforced



丝锥柄部尺寸符合DIN/JIS标准 Tap shank dimensions to DIN/JIS

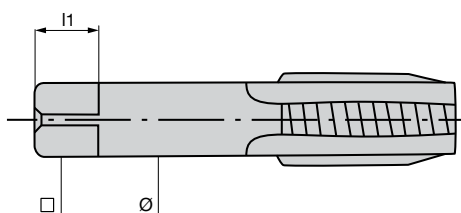


Ø x □	□ l1	· DIN 371	DIN 374	DIN 376	JIS B 4430 1988	DIN 2182 BSW	DIN 2183 BSW	DIN 5156 DIN 5157	· DIN 371 UNF	DIN 371 UNC	DIN 374 UNF	DIN 376 UNC
14,0 x 11,0	14		M18	M18	M18, M19		11/16"					
15,0 x 12,0	15				M20							
16,0 x 12,0	15		M20	M20	M21		13/16"	G 1/2"				
17,0 x 13,0	16				M22							
18,0 x 14,0	17				M23							
18,0 x 14,5	17		M22	M22			7/8"	G 5/8"				
			M24	M24			15/16"					
19,0 x 15,0	18				M24, M25							
20,0 x 15,0	18				M26, M27							
20,0 x 16,0	19		M27	M27			1"	G 3/4"				
21,0 x 17,0	20				M28							
22,0 x 18,0	21		M30	M30			1 1/8"	G 7/8"				
23,0 x 17,0	20				M30							
24,0 x 19,0	22				M32							
25,0 x 19,0	22				M33							
25,0 x 20,0	23		M33	M33			1 1/4"	G 1"				
26,0 x 21,0	24				M34, M35							
28,0 x 21,0	24				M36-M38							
28,0 x 22,0	25		M36	M36			1 3/8"	G 1 1/8"				
30,0 x 23,0	26				M39							
32,0 x 24,0	27		M39	M39			1 1/2"	G 1 1/4"				
			M42	M42			1 5/8"					
32,0 x 26,0	30				M42							
35,0 x 26,0	30				M45							
36,0 x 29,0	32		M45	M45			1 3/4"	G 1 3/8"				
			M48	M48			1 7/8"	G 1 1/2"				
							2"	G 1 3/4"				
							2 1/4"	G 2"				
38,0 x 29,0	32				M48							
40,0 x 32,0	35		M52	M52	M50			G 2 1/4"				
42,0 x 32	35				M52							
44,0 x 35	38				M55, M56							
45,0 x 35,0	38			M56				G 2 1/2"				
				M60								
46,0 x 35,0	38				M58, M60							
48,0 x 38,0	42				M62, M64							
50,0 x 39,0	42			M64				G 2 3/4"				
				M68				G 3"				
56,0 x 44,0	47						2 3/4"	G 3 1/4"				
							3"					

■ 柄部直径加强
Shank diameter reinforced

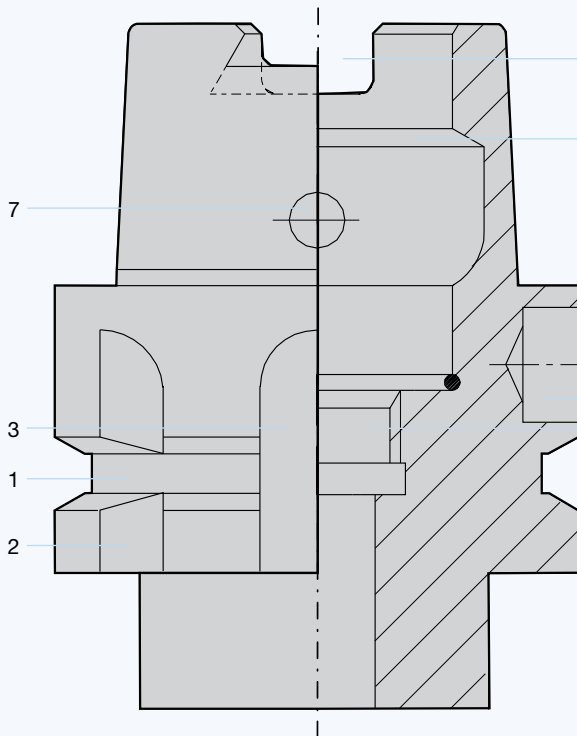
丝锥柄部尺寸符合ISO标准

Tap shank dimensions to ISO



Ø x □	□ l1	M		UNC		ISO 529 – 1975				BSF		BA	
			.		.	UNF		BSW		.		.	
2,24 x 1,8	4	M3		Nr. 5-40		Nr.5-44		⅛"-40				Nr.5	
2,5 x 2,0	4	M3,5	M2	Nr. 6-32	Nr.1-64	Nr.6-40	Nr.0-80						Nr.11
							Nr.1-72					Nr.10	
													Nr.9
2,8 x 2,24	5		M2,2		Nr.2-56		Nr.2-64						Nr.8
			M2,5		Nr.3-48		Nr.3-56					Nr.7	
												Nr.6	
3,15 x 2,5	5	M4	M3		Nr.4-40		Nr.4-48						Nr.5
				Nr.8-32	Nr.5-40	Nr.8-36	Nr.5-44					Nr.3	
3,55 x 2,8	5	M4,5	M3,5	Nr.10-24	Nr.6-32	Nr.10-32	Nr.6-40	⅜"-24		⅜"-32		Nr.2	Nr.4
4,0 x 3,15	6	M5	M4	Nr.12-24		Nr.12-28				7/32"-24		Nr.1	
4,5 x 3,55	6	M6		¼"-20	Nr.8-32	¼"-28	Nr.3-36	¼"-20		¼"-26		Nr.0	Nr.3
5,0 x 4,0	7		M5		Nr.10-24		Nr.10-32		⅜"-24		⅜"-32		Nr.2
5,6 x 4,5	7				Nr.12-24		Nr.12-28			9/32"-26	7/32"-28		Nr.1
6,3 x 5,0	8	M8	M6	⅝"-18	¼"-20	⅝"-24	¼"-28	⅝"-18	¼"-20	⅝"-32	¼"-26		Nr.0
7,1 x 5,6	8			⅜"-16		⅜"-24		⅜"-16		⅜"-20	9/32"-26		
8,0 x 6,3	9	M10	M8	7/16"-14	⅝"-18	7/16"-20		⅜"-16	⅝"-18	7/16"-18	⅝"-22		
9,0 x 7,1	10	M12		½"-13		½"-20		½"-13		½"-12			
10,0 x 8,0	11		M10		⅜"-16		⅜"-24		⅜"-16		⅜"-20		
11,2 x 9,0	12	M14		9/16"-12		9/16"-18		9/16"-12		9/16"-16			
12,5 x 10,0	13	M16		⅝"-11		⅝"-18		⅝"-11		⅜"-14			
14,0 x 11,2	14	M18		¾"-10		¾"-16		11/16"-14		11/16"-14			
		M20						¾"-10		¾"-12			
16,0 x 12,5	16	M22		7/8"-9		7/8"-14		7/8"-9		7/8"-11			
18,0 x 14,0	18	M24		1"-8		1"-12		1"-8		1"-10			
20,0 x 16,0	20	M27		1⅛"-7		1⅛"-12		1⅛"-7		1⅛"-9			
		M30											
22,4 x 18,0	22	M33		1¼"-7		1¼"-12		1¼"-7		1¼"-9			
25,0 x 20,0	24	M36		1⅜"-6		1⅜"-12				1⅜"-8			
28,0 x 22,4	26	M39		1½"-6		1½"-12		1½"-6		1½"-8			
		M42								1⅝"-8			
31,5 x 25,0	28	M45		1¾"-5				1¾"-5		1¾"-7			
		M48											
35,5 x 28,0	31	M52		2"-4½				2"-4½		2"-7			
		M56											
40,0 x 31,5	34	M60		2¼"-4½				2¼"-4		2¼"-6			
		M64		2½"-4				2½"-4		2½"-6			
45,0 x 35,5	38	M68		2¾"-4				2¾"-3½		2¾"-6			
50,0 x 40,0	42			3"-4				3"-3½		3"-5			
				3¼"-4				3¼"-3¼		3¼"-5			
				3½"-4				3½"-3¼		3½"-4½			
56,0 x 45,0	46			3¾"-4				3¾"-3		3¾"-4½			
				4"-4				4"-3		4"-4½			

■ 柄部直径加强
■ Shank diameter reinforced

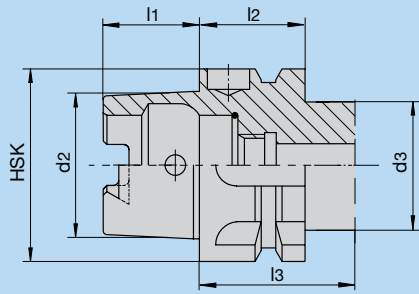


- 1 夹持槽 — 环形槽。
 - 2 转位凹槽 — 与夹持槽相交叉的镰刀形凹槽。
 - 3 轴环上的键槽 — 转位凹槽，如用于刀库。对HSK-B/D的主轴形成封闭式扭矩传递。
 - 4 轴环上的编码/识别孔用于识别系统的配件（代码单元）
 - 5 冷却管螺纹 — 用于冷却管配件。
 - 6 锥柄上的键槽 — 对主轴形成封闭式扭矩传递。
 - 7 锥柄上的径向孔 — 是手动夹紧系统所必需的。
 - 8 夹紧肩 — 环形倒角用于夹紧。
-
- 1 Gripper groove – circular groove
 - 2 Index notch – sickle-shaped notch across gripper groove
 - 3 Keyway on collar – index notch e.g. for tool magazines. Form closed torque transmission to spindle for HSK-B/D
 - 4 Coding/identification – hole in collar for attachment of identification system (code chip)
 - 5 Thread for coolant tube – for attachment of coolant tube
 - 6 Keyway on taper shank – form closed torque transmission to spindle
 - 7 Radial bore in taper shank – necessary for manual clamping systems
 - 8 Clamping shoulder – circular chamfer for clamping

刀柄规格和尺寸

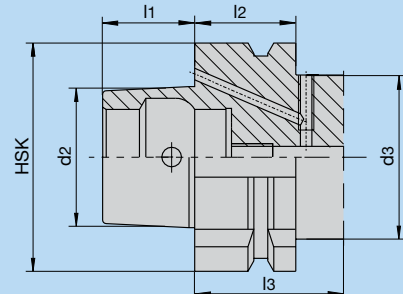
Location sizes and dimensions

A型
Shape A



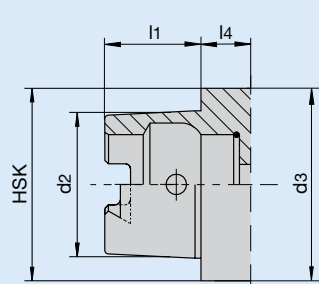
空心刀柄锥体适用于带夹持槽和定位槽的自动换刀。通过锥体上的检修孔能够进行手动操作。扭矩传递为正负皆可。

B型
Shape B



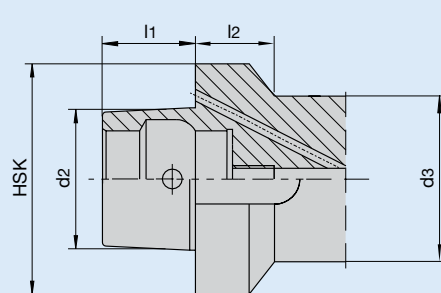
Hollow-shank taper for automatic tool changing with gripping and locating groove. Manual operation is possible through the access hole in the taper. Torque is transmitted both positively and non-positively.

C型
Shape C



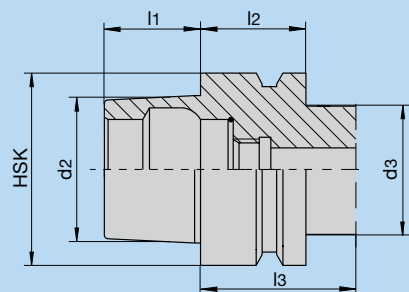
空心刀柄锥体适用于手动换刀。通过锥体上的检修孔能够进行操作。扭矩传递为正负皆可。

D型
Shape D



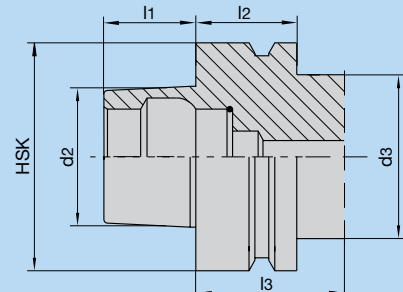
Hollow-shank taper for manual tool changing. Operation is possible through the access hole in the taper. Torque is transmitted both positively and non-positively.

E型
Shape E



空心刀柄锥体适用于自动换刀。扭矩传递为负。

F型
Shape F



Hollow-shank taper for automatic tool changing. Torque is transmitted non-positively.

HSK-A + C	d2	d3	l1	l2	l3	l4	HSK-B + D	d2	d3	l1	l2	l3
25	19	20	13	19	20	8	40	24	34	16	20	35
32	24	26	16	20	35	10	50	30	42	20	26	42
40	30	34	20	20	35	10	63	38	53	25	26	42
50	38	42	25	26	42	12,5	80	48	68	32	26	42
63	48	53	32	26	42	12,5	100	60	68	40	29	45
80	60	68	40	26	42	16						
100	75	68	50	29	45	16						
125	95	111	63	29	45	-						
160	120	144	80	31	47	-						
HSK-E	d2	d3	l1	l2	l3		HSK-F	d2	d3	l1	l2	l3
25	19	20	13	10	20		50	30	42	20	26	42
32	24	26	16	20	35		63	38	53	25	26	42
40	30	34	20	20	35		80	48	68	32	26	42
50	38	42	25	26	42							
63	48	53	32	26	42							

刀柄规格和尺寸

Location sizes and dimensions

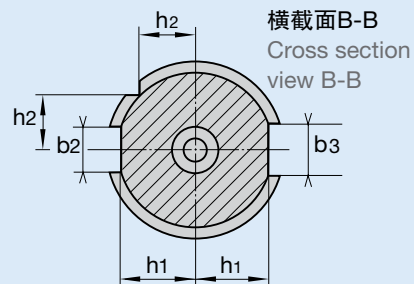
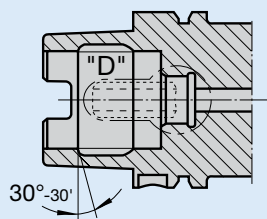
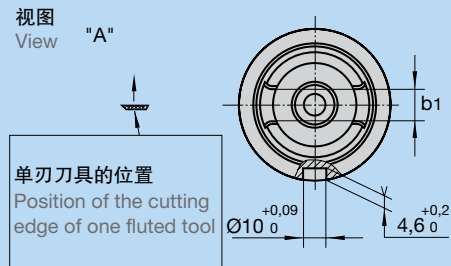
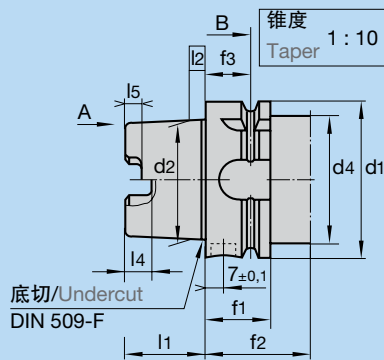


HSK面接触空心锥度刀柄用于自动换刀，根据DIN69893 — 第1部分 (A型)

由于锥度刀柄和面接触，一个非常高的定位精度和非常高等级的刚性，适合旋转刀具和刀库，包括测量工具。
根据DIN69893的锥度空心刀柄增补陡峭锥度用于自动换刀DIN69893 — 第1部分。没有给予可互换性。

Hollow tapered shanks with face contact (HSK) for automatic tool change to DIN 69893 – Part 1 (Form A)

Due to the tapered shank and face contact, a high positioning accuracy, and high grade of rigidity is suited for use with rotary and stationary tools including measuring instruments.
The taper hollow shank to DIN 69893 supplements the steep taper for automatic tool changes to DIN 69871 Part 1. Reciprocal interchangeability is not given.



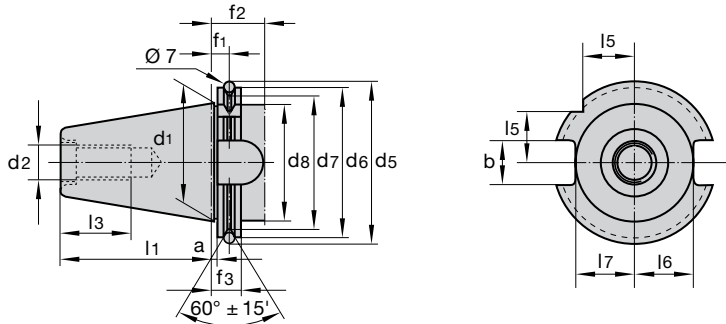
尺寸 Nominal size	b1	b2	b3	d2	d4	f1 0	f2	f3	h1	h2 0	l1 0	l2	l4 +0,2 0	l5 +0,2 0
d, H10	H10	H10	H10		max.	-0,1	min.	±0,1	-0,2	-0,3	-0,2			
25	6	6	7	19	20	19	20	4,5	10	7,5	13	2,5	4	2
32	7	7	9	24	26	20	35	16	13	9,5	16	3,2	5	3
40	8	9	11	30	34		35	16	17	12	20	4	6	3,5
50	10,5	12	14	38	42	26	42	18	21	15,5	25	5	7,5	4,5
63	12,5	16	18	48	53	25	42	18	26,5	20	32	6,3	10	6
80	16	18	20	60	67	26	42	18	34	25	40	8	12	8
100	20	20	22	75	85	29	45	20	44	31,5	50	10	15	10
125	25	25	28	95	105		45	20	55,5	39,5	63	12,5	19	12
160	30	32	36	120	130	31	47	22	72	50	80	16	23	16

刀柄规格和尺寸

Location sizes and dimensions

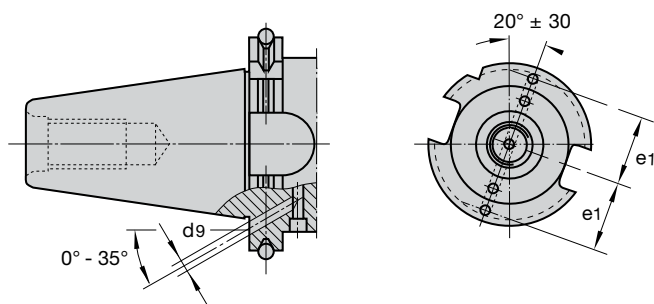


DIN ISO 7388-1 (DIN 69871 A) 7/24锥度用于自动换刀 7/24 step taper for automatic tool change



DIN ISO 7388-1																
SK	a ± 0,1	b 0/ +0,2	d1	d2	d5 ± 0,05	d6 0 - 0,1	d7 0 - 0,5	d8 max.	f1 ± 0,1	f2 min.	f3 0 - 0,1	l1 0 - 0,3	l3 min.	l5 0 - 0,3	l6 0 - 0,4	l7 0 - 0,4
30	3,2	16,1	31,75	M 12	59,30	50,00	44,30	45	11,1	35	19,1	47,80	24	15	16,3	18,8
40	3,2	16,1	44,45	M 16	72,30	63,55	56,25	50	11,1	35	19,1	68,40	32	18,5	22,7	25,0
45	3,2	19,3	57,15	M 20	91,35	82,55	75,25	63	11,1	35	19,1	82,70	40	24	29,1	31,3
50	3,2	25,7	69,85	M 24	107,25	97,50	91,25	80	11,1	35	19,1	101,75	47	30	35,5	37,7
60	3,2	25,7	107,95	M30	164,75	155,00	147,70	130	11,1	35	19,1	161,90	59	49	64,5	59,3

DIN ISO 7388-1 (DIN 69871 B) 7/24锥度带法兰面冷却 7/24 step taper with coolant supply via flange, AF



所有其它尺寸如7/24锥柄ISO 7388-1。
All other dimensions such as for 7/24 taper shanks to ISO 7388-1.

DIN ISO 7388-1		
SK	d9	e1 ± 0,1
30	4	21
40	4	27
45	5	35
50	6	42
60	8	66

包括7/24锥柄的锥度角度公差质量AT4，DIN2080第1部分。
Included taper angle tolerance quality of the 7/24 taper shank AT 4 to DIN 2080 Part 1.

刀柄规格和尺寸

Location sizes and dimensions

bilz

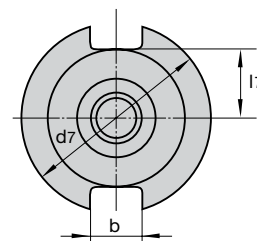
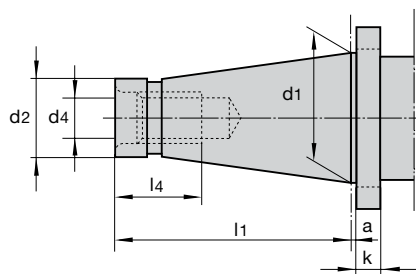
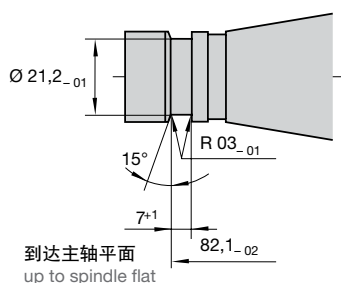
DIN 2080

7/24锥度用于手动换刀

7/24 step taper for manual tool change

SK 40带Maho圆槽

SK 40 with Maho Ring Groove



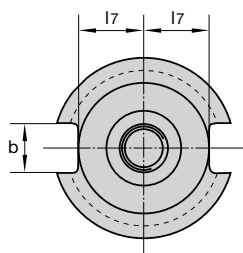
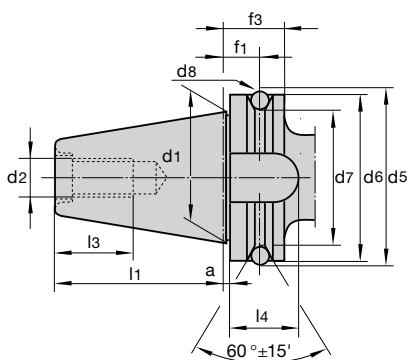
DIN 2080

SK	a ± 0,2	b H 12	d1	d2 a10	d4	d7 - 0,4	k ± 0,15	l1 0	l4 - 0,3	l7 max.
30	1,6	16,1	31,75	17,4	M 12	50	8	68,4	24	16,2
40	1,6	16,1	44,45	25,3	M 16	63	10	93,4	32	22,5
45	3,2	19,3	57,15	32,4	M 20	80	12	106,8	40	29
50	3,2	25,7	69,85	39,6	M 24	97,5	12	126,8	47	35,3
60	3,2	25,7	107,95	60,2	M 30	156	16	206,8	59	60

DIN ISO 7388-2 (MAS 403)

BT-用于自动换刀

BT-step taper for automatic tool change



DIN ISO 7388-2 (JMTBA标准 MAS 403-1975 to JMTBA-Standard MAS 403-1975)

(JMTBA=日本机床制造协会 / JMTBA = Japan Machine Tool Builders Association)

BT	a ± 0,4	b	d1	d2 6 H	d5 ± 0,05	d6 h8	d7 0-0,05	d8 ± 0,1	f1 ± 0,01	f3 min.	l1 ± 0,2	l3 min.	l4 min.	l7
BT 30	1,6	2	31,75	M 12	56,03	46	38	8	13,6	22	48,4	24	17	16,3
BT 40	1,6	2	44,45	M 16	75,56	63	53	10	16,6	27	65,4	30	21	22,6
BT 45	3,2	3	57,15	M 20	100,09	85	73	12	21,2	33	82,8	36	26	29,1
BT 50	3,2	3	69,85	M 24	118,89	100	85	15	23,2	38	101,8	45	31	35,4

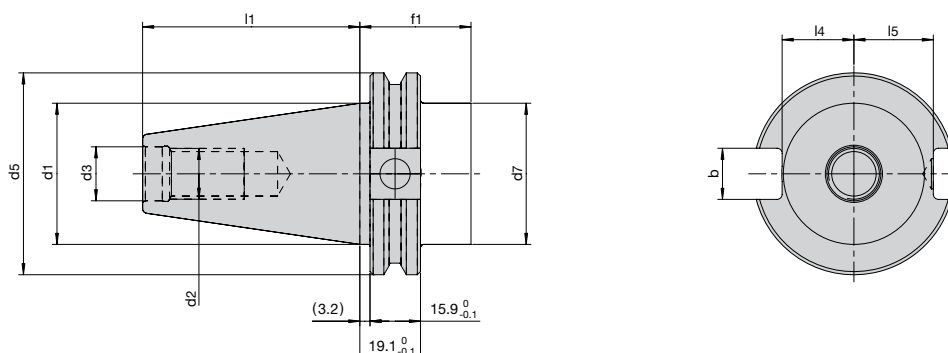
刀柄规格和尺寸

Location sizes and dimensions

bilz

DIN ISO 7388-1 (ANSI B5.50/CAT) 用于自动换刀的锥度

DIN ISO 7388-1 (ANSI B5.50/CAT) Step taper for automatic tool change



DIN ISO 7388-1 (ANSI B5.50/CAT, 公制/Metrisch)

	40	45	50
b ^{+0.2} / ₀	16,1	19,3	25,7
d1	44,45	57,15	69,95
d2	M 16	M 20	M 24
d3 _{H7}	17	21	25
d4 _{±0,05}	72,3	91,35	108,25
d5 ₀ / _{-0,01}	63,55	82,55	98,5
d6 ₀ / _{-0,05}	56,25	75,25	91,25
d7 _{±0,25}	44,45	57,15	69,95
f1 _{±0,25}	35	35	35
l1 ₀ / _{-0,03}	68,4	82,7	101,75
l4 ₀ / _{-0,04}	22,7	29,10	35,50
l5 ₀ / _{-0,04}	25	31,3	37,7

ANSI B5.50/CAT 英寸/Inch

	40	45	50
d2	UNC 5/8-11	UNC 3/4-10	UNC 1-8
d3 ^{+0.4} / ₀	16,3	19,45	26,2

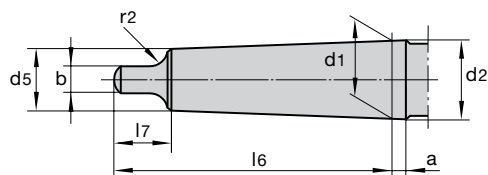
刀柄规格和尺寸

Location sizes and dimensions

bilz

莫氏锥柄带柄脚

Morse taper shanks with tang

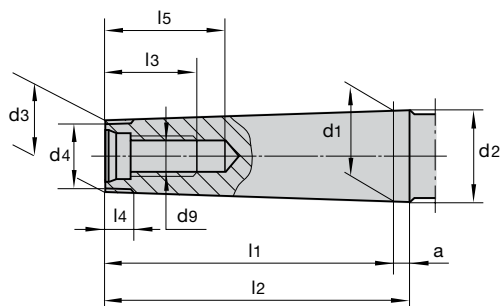


DIN 228 B

MK	a	b	d1	d2	d5	l6 0 -1	l7 max	r2
0	3,0 ^{+1,2}	3,9	9,045	9,2	6,1	56,5	10,5	4
1	3,5 ^{+1,4}	5,2	12,065	12,2	9,0	62,0	13,5	5
2	5,0 ^{+1,4}	6,3	17,780	18,0	14,0	75,0	16	6
3	5,0 ^{+1,7}	7,9	23,825	24,1	19,1	94,0	20	7
4	6,5 ^{+1,9}	11,9	31,267	31,6	25,2	117,5	24	8
5	6,5 ^{+1,9}	15,9	44,399	44,7	36,5	149,5	29	10
6	8,0 ^{+2,3}	19,0	63,348	63,8	52,4	210,0	40	13

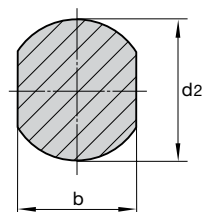
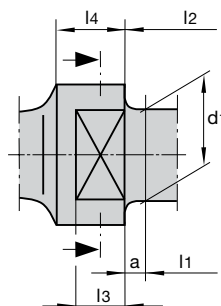
莫氏锥柄带螺纹拉杆

Morse taper shanks with draw-bar thread



带轴肩

With shoulder



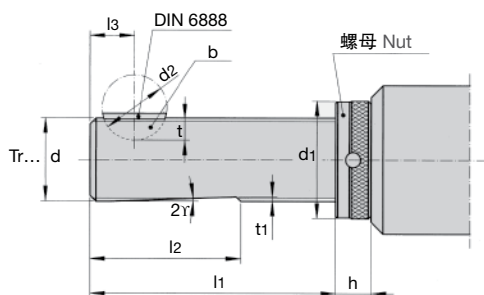
DIN 228 A

DIN 2207

MK	a	d1	d2 ≈	d3 ≈	d4 max.	d9	l1 max.	l2 max.	l3 min.	l4	l5 min.	带轴肩 With shoulder			
												b d9	d2	l3	l4
0	3,0 ^{+1,2}	9,045	9,2	6,4	6	—	50	53	—	4	—				
1	3,5 ^{+1,4}	12,065	12,2	9,4	9	M 6	53,5	57	16	5	22				
2	5,0 ^{+1,4}	17,780	18,0	14,6	14	M 10	64	69	24	5	31,5				
3	5,0 ^{+1,7}	23,825	24,1	19,8	19	M 12	81	86	24	7	33,5	24	24	12	18
4	6,5 ^{+1,9}	31,267	31,6	25,9	25	M 16	102,5	109	32	9	42,5	32	32	15	23
5	6,5 ^{+1,9}	44,399	44,7	37,6	35,7	M 20	129,5	136	40	10	52,5	45	45	18	28
6	8,0 ^{+2,3}	63,348	63,8	53,9	51	M 24	182	190	47	16	61,5	65	65	25	39

刀柄规格和尺寸 Location sizes and dimensions

bilz



TR...

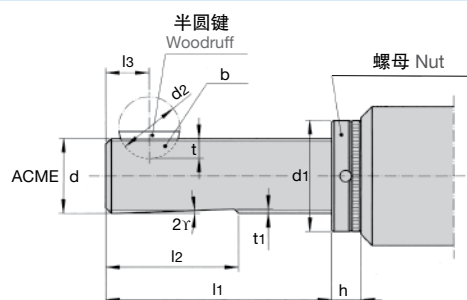
梯形螺纹柄DIN 6327带调节螺母

Trapezoidal threaded shank DIN 6327 with adjustment nut

型号 Designation	dg5	d1	d2	dp9	t	t1	l1	l2	l3	h	DIN6888
TR 6 x 1*	6	12	7	2	1,8	1	30	20	8	8	2 x 2,6
TR 8 x 1	8	13,5	10	2	2,9	1	40	26	10	10	2 x 3,7
TR 10 x 1,5	10	18	13	3	4,1	1	50	32	10	12	3 x 5
TR 12 x 1,5	12	19	13	3	4,1	1	50	32	10	12	3 x 5
TR 16 x 1,5	16	25	16	5	5,4	1,3	73	43	11	12	5 x 6,5
TR 20 x 2	20	32	19	5	6,4	1,3	76	46	13	12	5 x 7,5
TR 25 x 2	25	37	22	6	7,5	1,5	83	51	15	12	6 x 9
TR 28 x 2	28	40	22	6	7,5	1,5	83	51	15	12	6 x 9
TR 32 x 23	32	45	28	8	9,5	1,7	106	68	20	12	8 x 11
TR 36 x 2	36	50	28	8	9,5	1,7	104	65	20	14	8 x 11
TR 40 x 2*	40	58	28	10	9,1	2,2	128	76	24	16	10 x 11
TR 48 x 2	48	67	32	10	11,1	2,2	126	76	24	18	10 x 13
TR 55 x 2*	55	74	45	10	14,1	2,7	162	93	28	18	10 x 16

* Bilz-Standard

ASME/ANSI B1.5-1988



ACME...

美国国家梯形螺纹柄，ACME螺纹与福特和通用的标准相对应

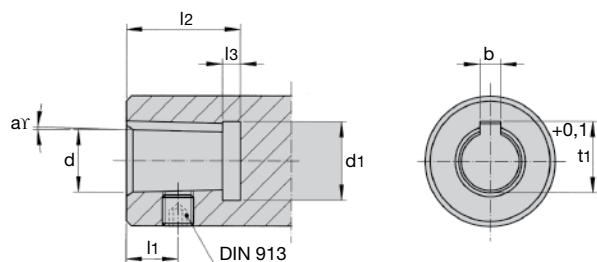
Trapezoidal threaded shank with AMERICAN NATIONAL ACME-thread Corresponds to standard of Ford-Motor-Company and General Motors

ACME...	d-0,01	d1	d2	b	t	t1	l1	l2	l3	h	键 woodruff-key
3/8" - 20*	9,51	16	12,7	2,357	3,84	1,2	55,5	35	10	8	3/8" x 1/2"
1/2" - 16	12,69	22	15,88	3,149	4,76	1,5	65,5	38	11,2	10,5	1/8" x 5/8"
5/8" - 16	15,85	25	15,88	3,945	4,37	1,5	65,5	38	12,7	10,5	5/32" x 5/8"
3/4" - 12	19,03	29	15,88	3,945	4,37	1,5	65,5	38	12,7	10,5	5/32" x 5/8"
7/8" - 12	22,21	32	19,05	4,732	5,57	1,5	81,5	47,5	12,7	10,5	3/16" x 3/4"
1"-12	25,38	38	22,23	4,732	7,15	1,5	81,5	47,5	15,7	10,5	3/16" x 7/8"
1 1/16" - 12	26,96	40	22,23	4,732	7,15	1,5	81,5	47,5	15,7	10,5	3/16" x 7/8"
1 3/8" - 12	34,9	48	25,4	6,317	7,95	1,5	106,5	66,5	19	10,5	1/4" x 1"
1 7/8" - 12	74,6	66	31,75	7,902	9,93	1,5	132,5	76	24	10,5	5/16" x 1 1/4"

* BILZ标准 / Bilz-Standard

刀柄规格和尺寸 Location sizes and dimensions

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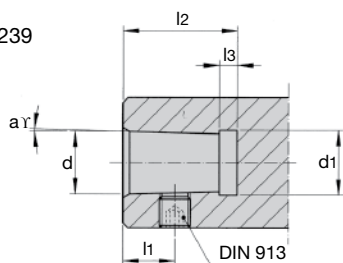
B...

锥孔DIN 238附加键和平头螺钉

Taper bore DIN 238 additionally with key way and grub screw

型号 Designation	d	d1	l1	l2	l3	bc11	t1	a°	DIN913
B 10	10,094	12,4	8	18	3,5	3	11,4	1°25'43"	M5 x 5
B 12	12,065	15,1	10	22	3,5	4	13,7	1°25'43"	M6 x 5
B 16	15,733	18,4	12	28	4	4	17,4	1°25'50"	M6 x 5
B 18	17,780	21,3	15	36	4	5	19,9	1°25'50"	M6 x 8
B 22	21,793	24,5	18	45	4,5	5	23,9	1°26'16"	M8 x 10
B 24	23,825	27,5	20	55	4,5	6	26,4	1°26'16"	M8 x 12

DIN/ISO 239



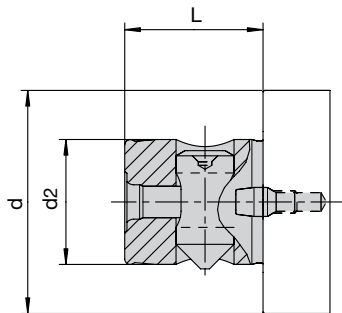
J...

Jacobs锥度带平头螺钉

Jacobs-taper with grub screw

型号 Designation	d	d1	l1	l2	l3	a°	DIN913
J 0	6,350	6,2	6	13	3	1°24'43"	M4 x 4
J 1	9,754	9,0	8	18	3,5	2°12'26"	M5 x 5
J 2	14,199	13,0	11	24	3,5	2°20' 8"	M6 x 6
J 2K	13,940	13,0	9	21	3,5	2°20' 8"	M6 x 6
J 3	20,599	19,5	14	34	4	1°31'31"	M8 x 10
J 4	28,550	27,0	18	45	4,5	1°30' 4"	M8 x 10
J 5	35,890	34,0	20	51	5	1°28'48"	M8 x 12
J 6	17,170	16,5	12	28	4	1°29' 9"	M6 x 8
J 33	15,850	14,8	12	28	4	1°49' 6"	M6 x 6
J E	20,030	19,5	10	23	3,5	1°29'19"	M8 x 10

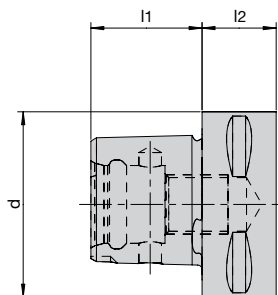
刀柄规格和尺寸 Location sizes and dimensions



ABS夹头 ABS Adaptors

型号 Designation	ABS-N	d	d1	L
ABS 25	ABS 25 N	25	13	20
ABS 32	ABS 32 N	32	16	23
ABS 40	ABS 40 N	40	20	26
ABS 50	ABS 50 N	50	28	31
ABS 63	ABS 63 N	63	34	38
ABS 80	ABS 80 N	80	46	43
ABS 100	ABS 100 N	100	56	55
ABS 125	ABS 125 N	125	70	70
ABS 160	ABS 160 N	160	90	90

DIN-ISO 26623-2

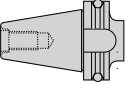
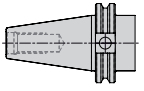
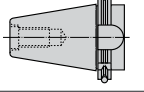
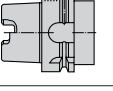
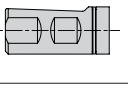
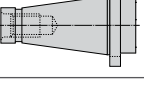


Polygon空心锥柄Aufnahmen Polygon taper Adaptors

尺寸 Size	d	l1	l2 min.
C3	32	19	15
C4	40	24	20
C5	50	30	20
C6	63	38	22
C8	80	48	30

特点 Features



HFP可能性 HFP possible (DIN 6327)			X	X	X											
MQL可能性 MQL possible					X			X								X
冷却可能性 Cooling possible	X	X	X	X	X	X		X								X
自反转 Automatic reverse												X	X		X	X
安全保护 Safety clutch						X				X	X					
径向平行浮动 Radial parallel float		X		X						X	X					
长度补偿 Length compensation			X	X	X	X	X		X				X	X	X	
快换 Quick change	X	X	X	X	X	X	X									
攻丝刀柄 Tapping Chucks	WF	WFP	WFL	WFLP	WFLC	WFSL	WFLK	SCK	DSPL	DSP	D	TA	GNCN	GNCK		
接口 Locations																
 ABS System Komet					X		X									
 JIS B 6339 (MAS 403 BT) 陡峭锥度 Steep taper	modular				X		X	modular					modular	modular		
 ASME B5.50 公制 metric 陡峭锥度 Steep taper	modular				X		X	modular					modular	modular		
 DIN 69871 A, AD, B 陡峭锥度 Steep taper	modular				X	X	X	modular					modular	modular		
 DIN 69893 C, HSK 空心锥柄 Hollow shank taper					X			X					modular	modular		
 DIN 69893 A, HSK 空心锥柄 Hollow shank taper	X				X	X		X					modular	modular		
 DIN 1835 B + E 侧固式 Weldon	X				X			X					X	X		
 DIN ISO 10889 (former DIN 69880, VDI 3425)					X		X									
 DIN 2080 陡峭锥度 Steep taper						X	X									
 DIN 6327 梯形螺纹柄 Trapezoidal shank	X	X	X	X	X		X									
 DIN 238 锥度轴 Taper shaft	X	X							X	X	X					
 DIN 228 B (ASME B5.10) 莫氏锥度 Morse taper	X	X	X	X		X	X		X		X	X				

请注意：其他地方有需要！ Note: Other locations on request!

问卷：攻丝操作错误和问题

Questionnaire: Errors/Problems tapping operations

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机床 Machine
机床的牌子 machine manufacturer
机床的型号 machine type
主轴接口 spindle location/size
进给方式：螺纹导入，手动，液压/气动，数控？ type of feed: lead screw, manual, hydr./pneum., NC
是否是同步进给：是/否 synchronized feed, yes/no
使用的刀柄和夹头 Chuck/adaptor in use
攻丝刀柄型号及厂家 chuck, manufacturer, description
攻丝夹头型号及厂家 adaptor, manufacturer, description
螺纹数据 Thread data
螺纹规格 thread/size
丝锥方尾的标准：ISO，德标，日标？ shank dimensions tap, DIN, ISO
攻丝还是挤压 tapping/roll forming
工件材料及硬度 material, hardness
通孔还是盲孔 through/blind hole
螺距 thread depth
螺纹孔是否有倒角：是/否 hole chamfered, yes/no
螺纹预钻的底孔直径 pre-drilled diameter
钻孔深度 drilling depth
丝锥型号 type of tap
丝锥质量，如6h等 tap quality
丝锥材质 HM, HSS...
加工数据 Process dat
速度 speed
进给 feed
安全高度 clearance
冷却方式 lubricant
冷却气/液压力 coolant pressure
附加信息 Additional information
偏差 misalignment
干涉轮廓 obstructing edges
问题 Problem
请描述 please describe



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- you decide whether to go ahead with a repair
- or renewal after receiving our cost estimate
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- an non-binding quote for a new product
- repair and return will be carried out as quickly as possible
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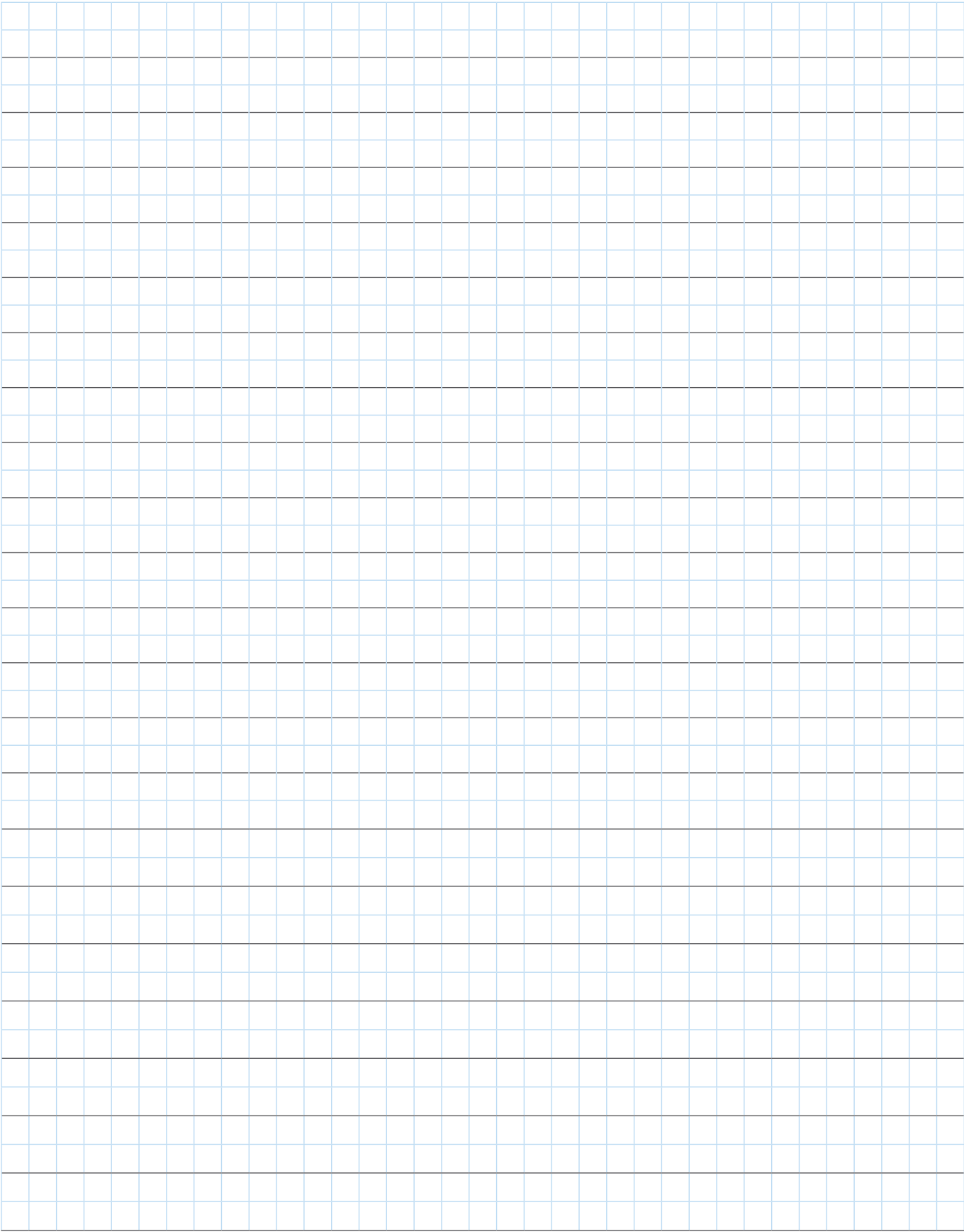


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A large rectangular area filled with a light blue grid, intended for taking notes. The grid is composed of small squares, with horizontal lines slightly more prominent than the vertical ones, creating a series of rows across the page.



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