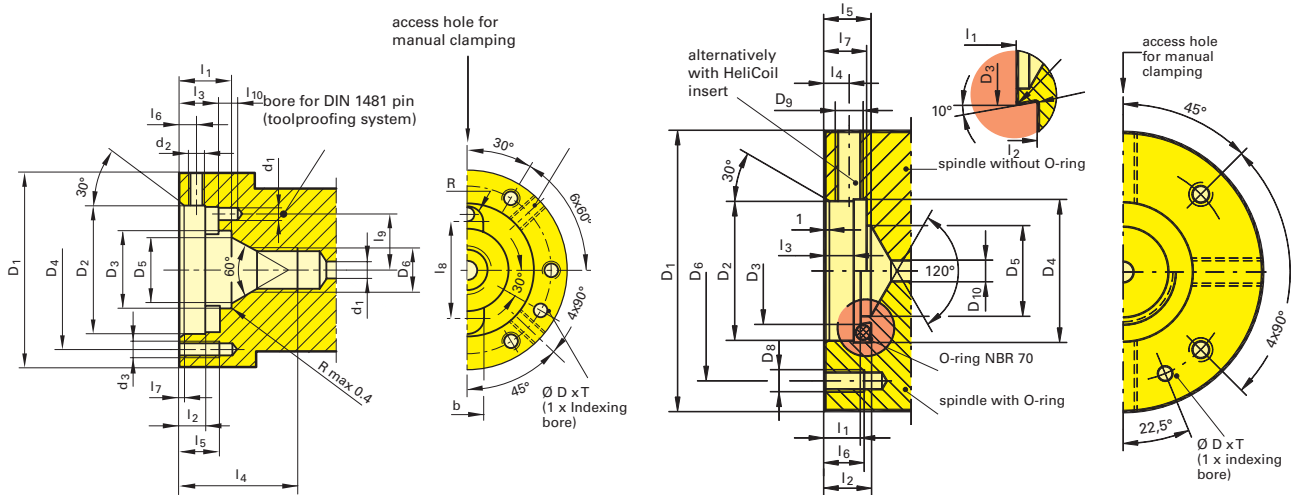


683.385

683.386 and 683.586



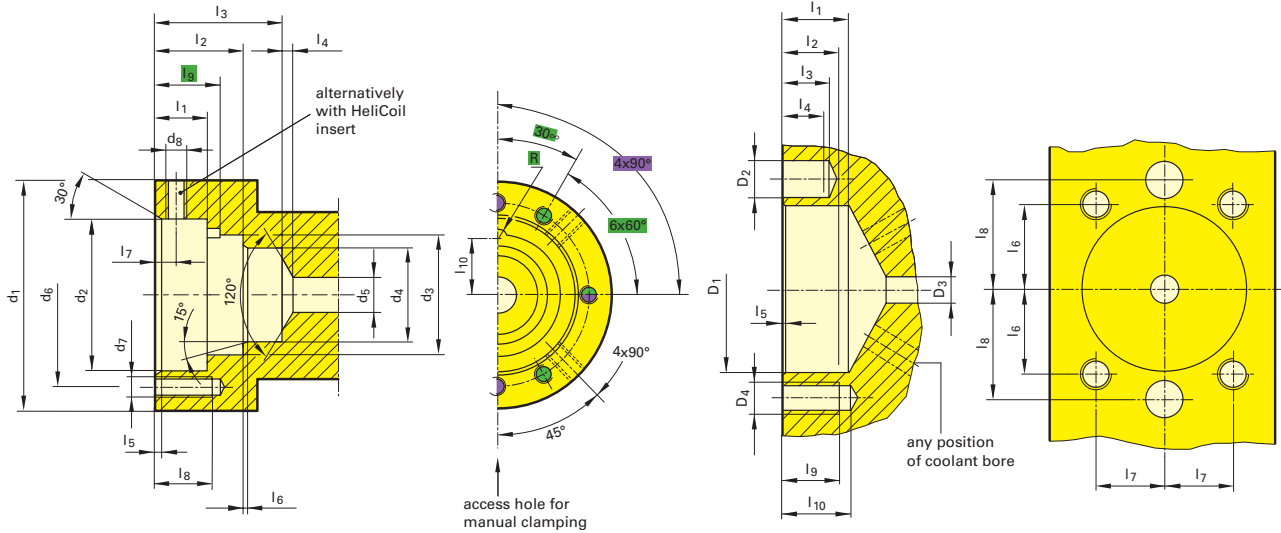
683.385		holder-Ø		holder-Ø	pitch circle-Ø	counter sinking-Ø	thread	coolant bore	thread	thread	locating pin bore	
for HSK	external-Ø	D1	D2	tolerance	D3	D4	D5	D6	d1	d2	d3	d4
code no.												
32	24,000	40	27.0	+0.15...+0.10	16.7	32.0	12.5	M 10	4.0	M 3	M 3	2
40	30,000	50	33.5	+0.15...+0.10	20.6	40.5	16.0	M 12	5.0	M 4	M 4	3
50	38,000	63	42.0	+0.15...+0.10	25.5	52.0	20.0	M 16	6.0	M 5	M 5	4
63	48,000	80	55.0	+0.15...+0.10	33.0	66.0	25.0	M 20	8.0	M 6	M 6	4
80	60,000	100	68.0	+0.15...+0.10	41.0	82.0	32.0	M 24	10.2	M 8	M 8	5

683.385		clamping depth	holder length	milling length	thread depth	thread depth	thread dist.	chamfer length	centre dist.	bore distance	depth of bore	width of keyway	keyway radius	bore-Ø	depth of bore	locating pin DIN 1481	
continued	tolerance	l1	l2	l3	l4	l5	l6	l7	l8	l9	l10	b	R	D	T		
32	24,000	9.0	±0.015	4.0	6.5	22	10	2.5	0.6	20.5	11.5	3.5	7.0	3.0	3.5	3.0	2 x 6
40	30,000	12.0	±0.02	5.5	8.7	30	11	3.5	0.6	25.0	14.5	5.0	8.0	4.0	4.0	3.5	3 x 8
50	38,000	16.0	±0.03	8.0	12.0	36	12	5.0	0.8	31.5	18.3	6.0	10.5	5.0	4.0	3.5	4 x 10
63	48,000	20.0	±0.04	10.0	15.0	48	15	6.0	1.0	41.0	22.5	5.0	12.5	6.0	4.0	3.5	4 x 10
80	60,000	25.6	±0.04	13.0	19.3	60	14	7.5	1.0	50.0	28.0	6.0	16.0	7.5	5.0	4.5	5 x 12

683.386		holder-Ø		holder-Ø	pitch circle-Ø	counter sinking-Ø	thread	indexing bore	thread	threaded bore	coolant bore	clamping depth	holder length	milling depth	thread depth	thread depth	thread depth	chamfer dist.	depth of bore	O-ring	
683.586	external-Ø	D1	D2	tolerance	D3	D4	D5	D6	D7	D8	D9	D10	l1	l2	l3	l4	l5	l6	l7	T	
25	19,000	45	23	+0.053..0.020	16.5	24	-	35	-	M5	M5	3.2	8.2	9.5	6.2	4.5	-	14	9	-	16x2
32	24,000	60	30	+0.053..0.020	23.5	31	-	44	5	M5	M8x1	4.0	10.3	12.4	8.3	7.0	-	11	12	3.5	23x3
40	30,000	70	35	+0.064..0.025	28.5	36	22	53	5	M6	M8x1	5.0	10.3	12.4	8.3	7.0	12	14	12	3.5	28x3
50	38,000	80	40	+0.064..0.025	30.5	41	26	63	5	M6	M8x1	6.0	10.3	13.3	8.3	7.0	12	14	12	3.5	30x4
63	48,000	100	50	+0.064..0.025	38.5	51	34	79	5	M8	M10x1	8.0	12.3	16.1	10.3	8.0	15	15	14	3.5	38x5
80	60,000	117	60	+0.076..0.030	47.5	61	38	96	6	M8	M10x1	10.2	12.3	16.1	10.3	8.0	20	15	14	4.5	47x5
100	75,000	140	80	+0.076..0.030	65	81	53	119	6	M10	M10x1	12.0	12.3	16.1	10.3	8.0	20	20	14	4.5	65x5

683.581 and 683.584

683.582



683.581		external- ϕ	holder- ϕ	counter-sinking ϕ	counter-sinking ϕ	coolant bore	graduated circle- ϕ	4 x thread	thread	holder length	counter-sinking length	counter-sinking length	depth of bore	chamfer length	chamfer length	thread dist.	thread length
code no.		d1	d2	d3	d4	d5	d6	d7	d8	l1	l2	l3	l4	l5	l6	l7	l8
25 19,000		45	23	-	-	5	35	M5	M4	6.8	-	-	1.5	1	-	3.5	min.8
32 24,000		55	28	21.12	17	6.4	43.5	M6	M4	6	9.75	16.75	2	1	0.6	3.5	10
40 30,000		63	36	23.4	21	8	51.5	M6	M4	7	11.3	19.9	2.5	1	1	4	12
50 38,000		80	46	33	26	10	65	M8	M5	9	14.7	25.5	3	15	1	5	16
63 48,000		100	56	42.5	34	16	81.5	M10	M6	12	17.8	30	3.5	1.5	1	6	16
80 60,000		125	66	52.8	42	16	103	M12	M8	14	22.7	39.8	4	2	1.5	8	16
100 75,000		160	86	66	53	20	130	M16	M10	16	27.4	49	4.5	2	2	10	20

683.584		external- ϕ	holder- ϕ	counter-sinking ϕ	counter-sinking ϕ	coolant bore	graduated circle- ϕ	thread	6 x thread	holder length	counter-sinking length	counter-sinking length	depth of bore	chamfer length	chamfer length	thread dist.	thread length	length of recess	recess dist.	recess radius
code no.		d1	d2	d3	d4	d5	d6	d7	d8	l1	l2	l3	l4	l5	l6	l7	l8	l9	l10	R
32 24,000		40	27.0	21.12	17	6.4	32.0	M 3	M 4	8.8	14.80	21.75	2.0	1.0	0.6	3.5	10.0	11.9	10.10	2.0
40 30,000		50	33.5	26.40	21	8.0	40.5	M 4	M 4	11.0	18.85	27.40	2.5	1.0	1.0	4.0	12.0	13.9	12.40	2.0
50 38,000		63	42.0	33.00	26	10.0	52.0	M 5	M 5	15.5	24.75	35.50	3.0	1.5	1.0	5.0	12.0	18.4	15.56	2.5
63 48,000		80	55.0	42.50	34	16.0	66.0	M 6	M 6	17.9	30.35	42.50	3.5	1.5	1.0	6.0	16.0	23.9	20.00	3.0
80 60,000		100	68.0	52.80	42	16.0	82.0	M 8	M 8	24.3	40.25	57.30	4.0	2.0	1.5	8.0	16.0	32.9	24.80	3.5
100 75,000		125	88.0	66.00	53	20.0	106.0	M10	M10	34.4	54.45	76.00	4.5	1.5	2.0	10.0	16.0	42.4	31.40	4.5

683.582		connection- ϕ	fit- ϕ	coolant bore- ϕ	thread	depth of bore	length of fit	depth of bore	length of fit	chamfer length	thread distance	thread distance	thread depth	thread depth	depth of bore
code no.		d1	d2	d3	d4	l1	l2	l3	l4	l5	l6	l7	l8	l9	l10
50 38,000		50	7.95	10	M10	20.55	20	15	11	1	27.44	19.22	33.5	20	25
63 48,000		63	14.00	10	M12	25.00	21	18	16	1	31.70	26.00	41.0	22	26