

Technical information and advantages

Guhring has considerably expanded its ISO taper and MAS-BT tool holder program. Naturally, the tool holders are of the usual high Guhring quality. This means: ISO taper and MAS-BT tool holders are produced in a special, alloyed case hardened steel with a minimum tensile strength at the core of 900 N/mm², hardened in a low distortion hardening process to HRC 58 at a case hardening depth of 0.8 to 1.0 mm. For reasons of longevity, the surface of the tool holder is subjected to an abrasive blasting process and protected against corrosion..

Quality through precision

Guhring's demand for highest precision also applies to tool holders. Therefore, ISO taper and MAS-BT chucks are precision ground: in the vicinity of the ISO taper to Ra ≤ 0.2, at the holder face to Ra ≤ 0.4. The taper tolerance is better than AT 3 with a measuring accuracy of ≤ 1µm. Detailed information regarding the form and positional tolerances can be found for the individual tool holders on the respective pages in the catalogue. The tolerances of the holder bore and the spigot are approximately 2/3 of the DIN tolerance.

Balancing

Tool holders suitable for increased speeds are generally pre-balanced. For this purpose, we have determined the imbalance and entered the balancing areas as well as balancing bores on the drawings. This levels out the imbalance to a large extent and up to approximately 8000 rev./min precision balancing is unnecessary. For higher revolutions, the pre-balanced tool holders must be precision balanced to G 6.3 or G 2.5 respectively.

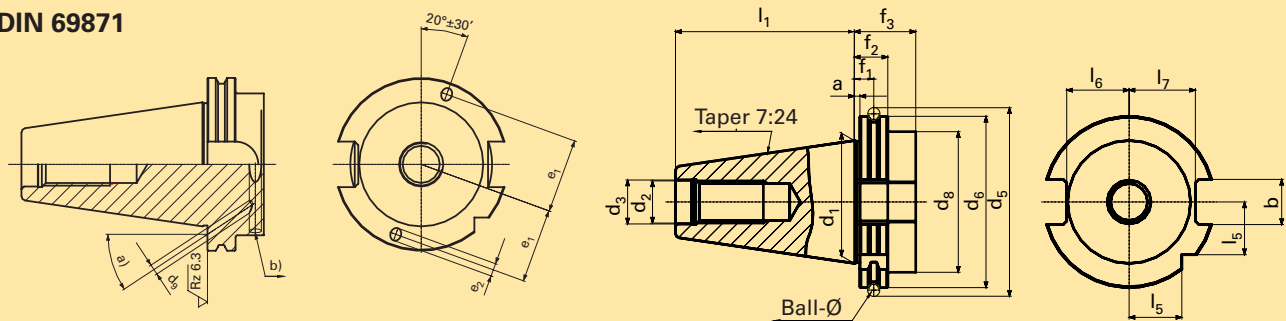
Type AD/B

ISO taper tool holders generally produced are type AD/B. Supplied is type AD, the coolant bores at the collar are sealed with screws.

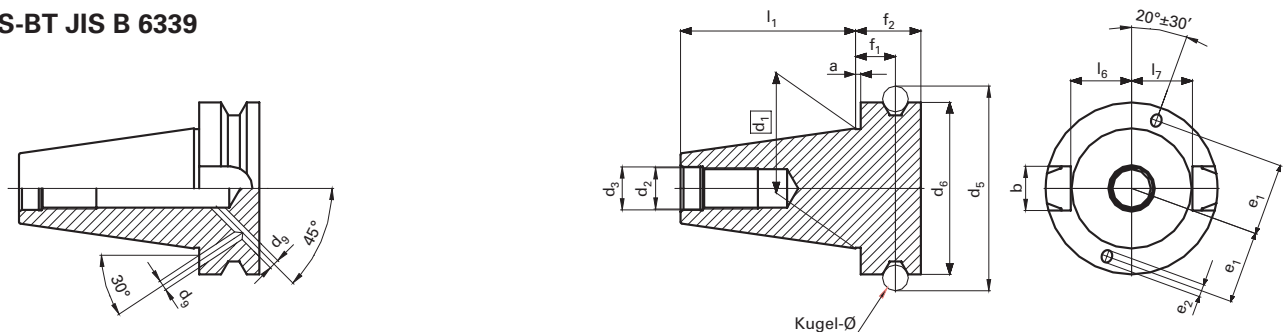
General dimensions and tolerances

The following dimensions apply to our ISO taper and MAS-BT tool holders:

SK DIN 69871



MAS-BT JIS B 6339



ISO taper	a	Ball Ø	b	d ₁	d ₂	d ₃	d ₅	d ₆	d ₈	d ₉	e ₁	f ₁	f ₂	f ₃	l ₁	l ₅	l ₆	l ₇
	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
SK40	3.2	7	16.1	44.45	M16	17	72.3	63.55	50	4	27	11.1	19.1	35	68.4	18.5	22.8	25.0
SK50	3.2	7	25.7	69.85	M24	25	107.25	97.50	80	6	42	11.1	19.1	35	101.75	30.0	35.5	37.7
BT40	2.0	10	16.1	44.45	M16	17	75.679	63.00	-	4	27	16.6	27.0	-	65.35	-	22.6	22.6
BT50	3.0	15	25.7	69.85	M24	25	119.019	100.00	-	5.4	42	23.2	38.0	-	101.75	-	35.4	35.4