FAHRION

FAR BEYOND PRECISION

AND ALL RUNS SMOOTHLY – 111 YEARS – EXPERIENCE

CENTRO|P premium

CLAMPING SYSTEMS FROM FAHRION



QUICK FINDER

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CENTRO|P
Tangible Benefits of the System

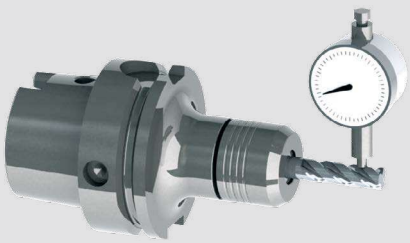
CENTRO|P is a high-precision system of collets, clamping nuts and chucks far superior to conventional collet chucks in all respects. The technological performance of CENTRO|P can be compared with systems such as hydraulic expansion technology, shrink-fit technology or the power chuck. CENTRO|P offers the full range of these technologies all in one system.



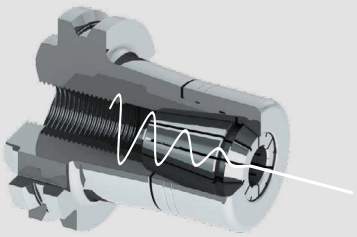
Precision clamping system consisting of:
- Precision Chuck CENTRO|P
- GERC-HP Precision Collet
- HPC Clamping Nut

Clamping is applied mechanically via a cone fit, which means:
- A high concentricity of < 3 µm due to special tuning of the cone tolerances
- System-based damping through the slots of the collet
- A constant clamping force, regardless of the tolerance position from bore to shaft, as the cone balances axially
- A maintenance-free solution, as neither media nor temperature are used for generating clamping force
- A long-lasting system, as neither leaks nor material changes take place

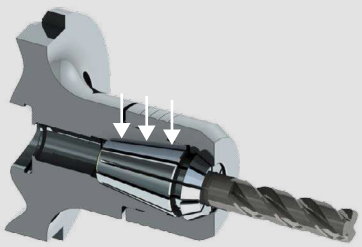
Concentricity of < 3 µm



System-based damping



Constant clamping force



FAHRION®
FAR BEYOND PRECISION

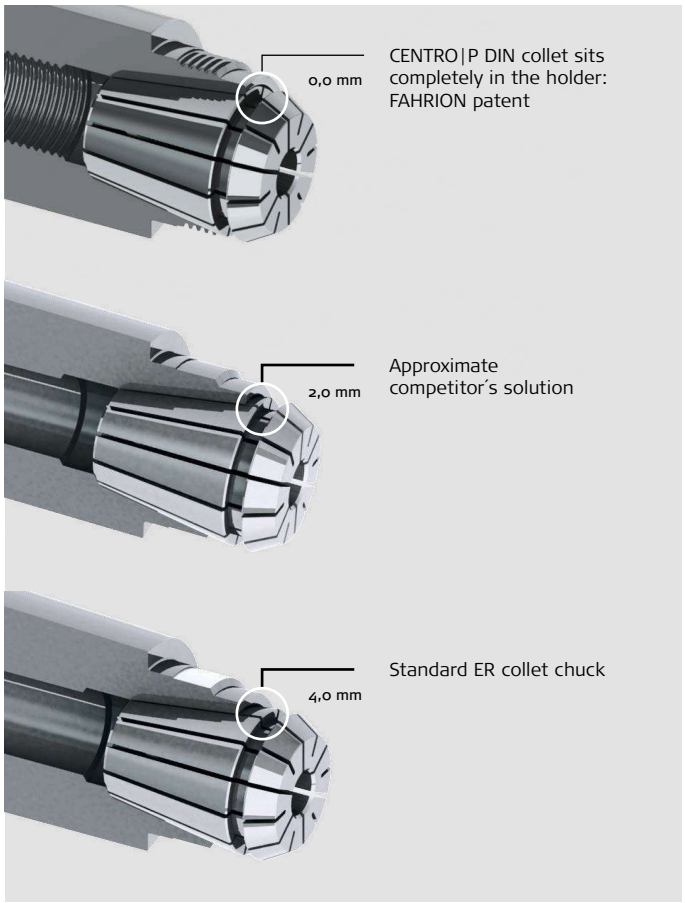
CENTRO|P

Proven Technology for your Benefit

The patented precision clamping system CENTRO|P offers a variety of advantages and, thanks to its highly reliable precision and quality, makes a considerable contribution to more efficient processing while also reducing production costs.

The most important design features are:

- The collet sits completely inside the cone
- A precisely ground double guide for the clamping nut
- A stable trapezoidal thread for transferring of the clamping force
- A chuck body with continuous maximum diameter

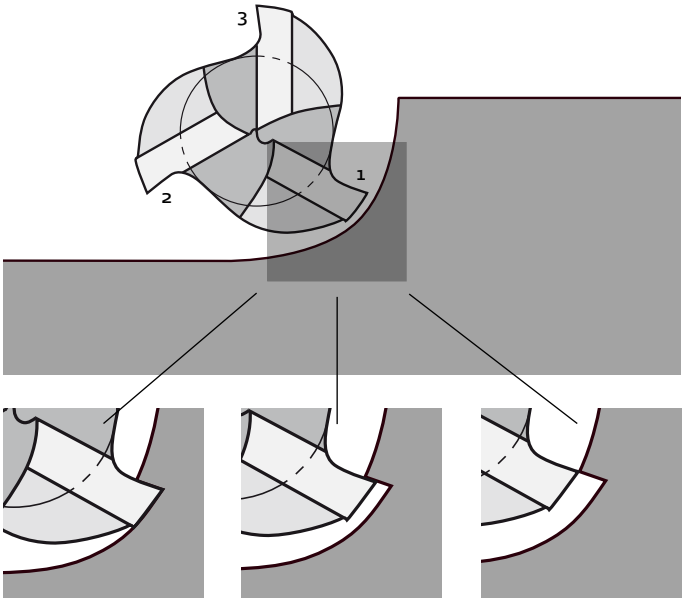






CENTRO|P
A Good Tool that Saves You Money

Effect of runout on the cutting edges

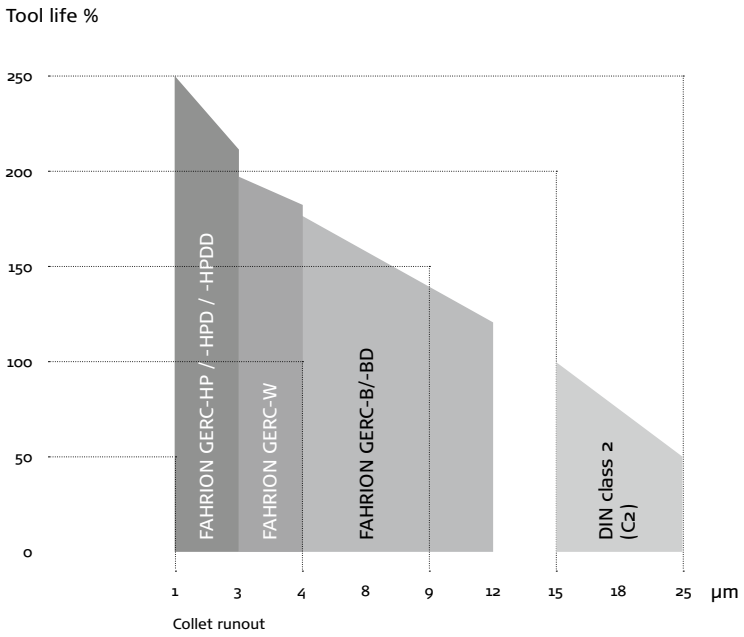


Cutting edge 1
Large chip volume

Cutting edge 2
Minimal chip volume

Cutting edge 3
No chip volume

Influence of collet accuracy on the life of carbide cutting tools



The problem
The higher the concentricity error, the greater the irregular load on the cutting edge. The consequences are increased tool wear and poorer surface finishes. For a good result, the feed must now be reduced.

Cost example for a carbide drill Ø 12 mm with collet DIN ISO 15488 - form B, type 470 E

Example 1: system concentricity ≤ 10 µm

Cost of a carbide drill	approx. 105.00 €
Cost FAHRION GERC32-B collet with concentricity 5 µm	approx. 21.30 €
Cost on basis of tool life of approx. 150 %	approx 126.30 €

Example 2: system concentricity ≤ 25 µm

Cost of a carbide drill	approx. 105.00 €
Cost CER32-K2 collet DIN class 2 with concentricity 20 µm	approx. 12.60 €
Cost on basis of tool life of approx. 55 %	approx 117.60 €
Cost for similar tool life of appprox. 150 %	approx 299.00 €

More than two carbide drills necessary!

Result: Cheap collets almost triple the cost!

CENTRO|P premium

Consistently One Step Ahead



Welcome to the world of high-precision machining with customer benefits, where we are always looking to improve.

As part of our CENTRO|P premium program, we offer you customised clamping systems, each with its own individual strengths and for a variety of applications.

Take advantage of other benefits, such as our FAHRION | Protect coating, tried and tested a million times, which is now also used on chucks and on clamping nuts. Pioneering technology that protects your complete tool clamping system and keeps it accurate and efficient for a long time.

CENTRO|P premium

Overview







	CENTRO|P premium		
	MPC Mini Precision Page 10	**DPC Dynamic Performance Page 14**	**UPC Ultra Power Page 18**
Dimensions			
Sizes	ER 8 - ER 16	ER 16 - ER 40	ER 32- ER 40
Clamping ranges	1 - 10 mm	1 - 26 mm	2 - 26 mm
ø Clamping Nuts	10 - 24 mm	30 - 63 mm	53 - 63 mm
Lengths	35- 200 mm	50 - 200 mm	65 - 100 mm
Concentricity at 3xD			
with HP / HPD / HPDD	0.003 mm	0.003 mm	0.003 mm
with B / BD	0.006 mm	0.006 mm	0.006 mm
with W	-	0.004 mm	0.004 mm
with GBD / GBDD	0.008 mm	0.008 mm	0.008 mm
Recommended applications			
Drilling	•••	•••	•
Finishing	•••	•••	
Roughing		•	•••
HSC milling	•••	••	
HPC milling	•	••	•••
Trochoidal milling		••	•••
Reaming			
Threads	•	••	
Lathe			

FAHRION® FAR BEYOND PRECISION

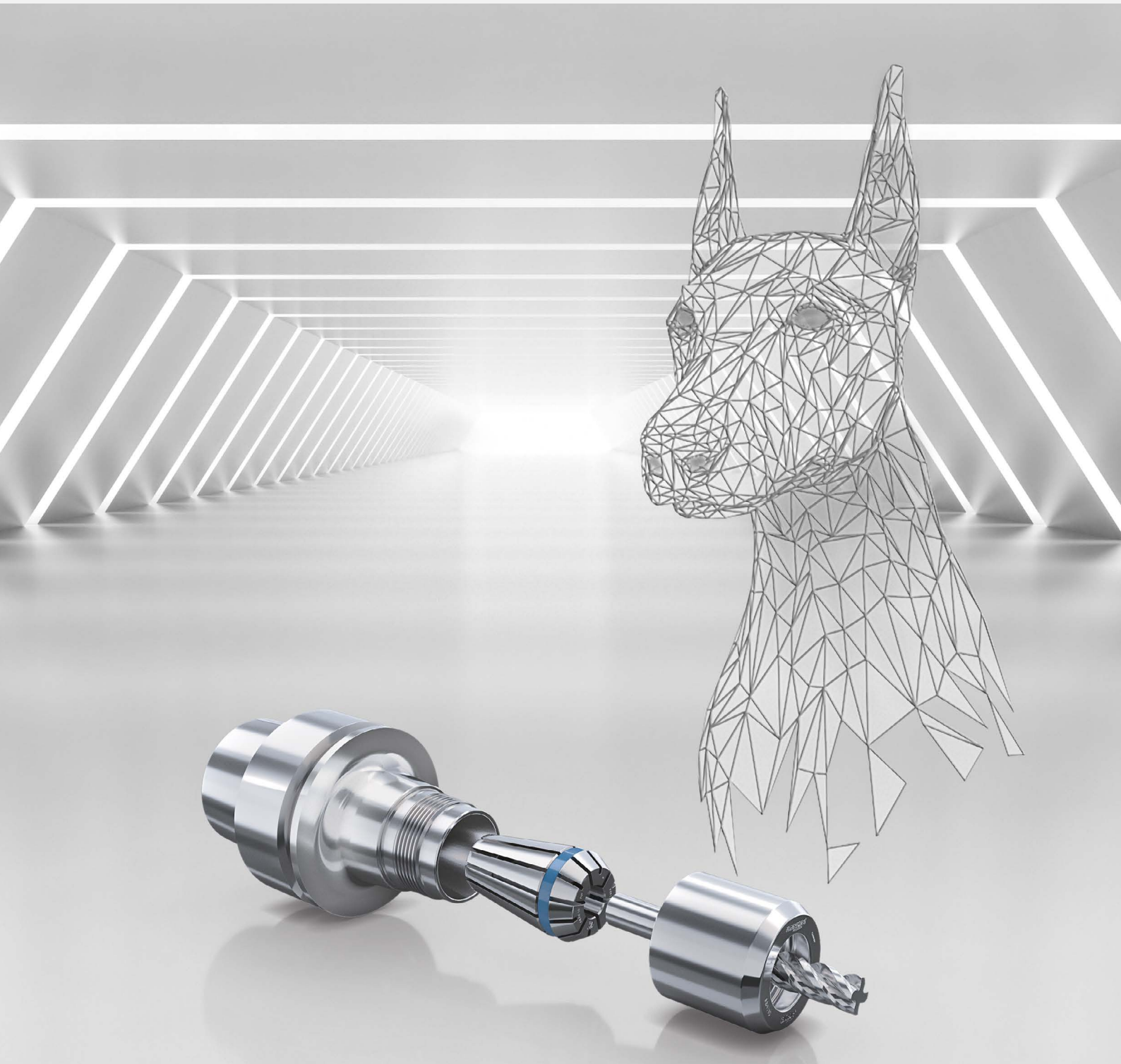





FPC **Full Performance** **Page 22**	**AFC** **Adjustable Finishing** **Page 26**	**MPC / DPC** **Tool Extensions** **Page 28**	**DPC / FPC** **Holders NC for Lathes** **Page 30**
ER 32 - ER 40	ER 25 - ER 40	ER 8 - ER 20	ER 25 - ER 40
2 - 26 mm	7 - 26 mm	1 - 13 mm	1 - 26 mm
50 - 63 mm	40 - 63 mm	10 - 32 mm	40 - 63 mm
60 - 200 mm	ab 100 mm	80 - 350 mm	54 - 68 mm
0.003 mm	0.001 mm	0.003 mm	0.010 mm
0.006 mm	-	0.006 mm	0.015 mm
0.004 mm	-	-	0.010 mm
0.008 mm	-	0.008 mm	0.016 mm
•		•••	
	••	•••	
•••			
•••			
•••			
	•••		
			•••

MPC, MINI PRECISION CHUCK

For High-Speed Spindles, Tight Spaces and Deep Immersion



The **MPC Mini Precision Chucks** excel in deep cavities on high speed machines with smaller tapers. They provide excellent stability and flexibility in medical and mold making applications.

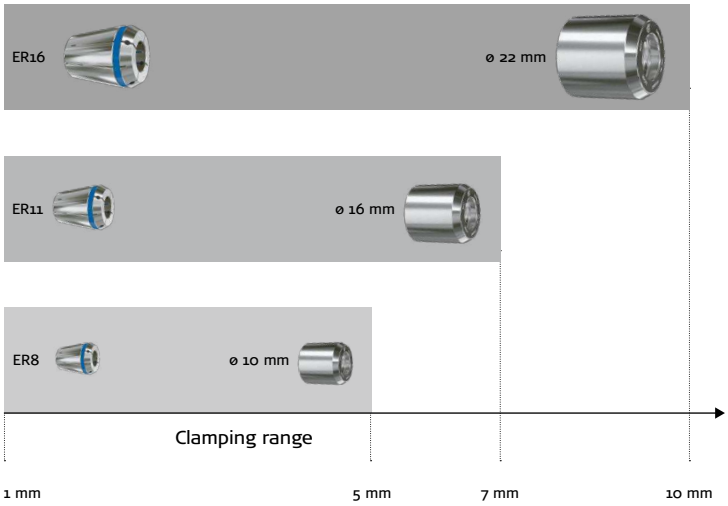
But even in tool and mould making or in the production of valves or manifolds, stable tool clamping at higher immersion depths is increasingly required - classic applications for the MPC system.

FAHRION® FAR BEYOND PRECISION

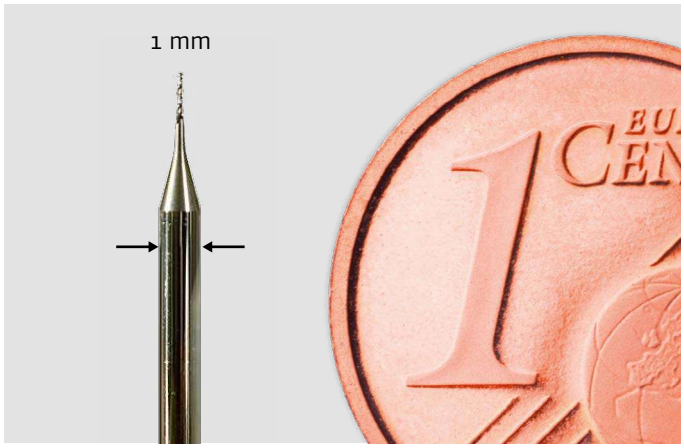
MPC, MINI PRECISION CHUCK

Features

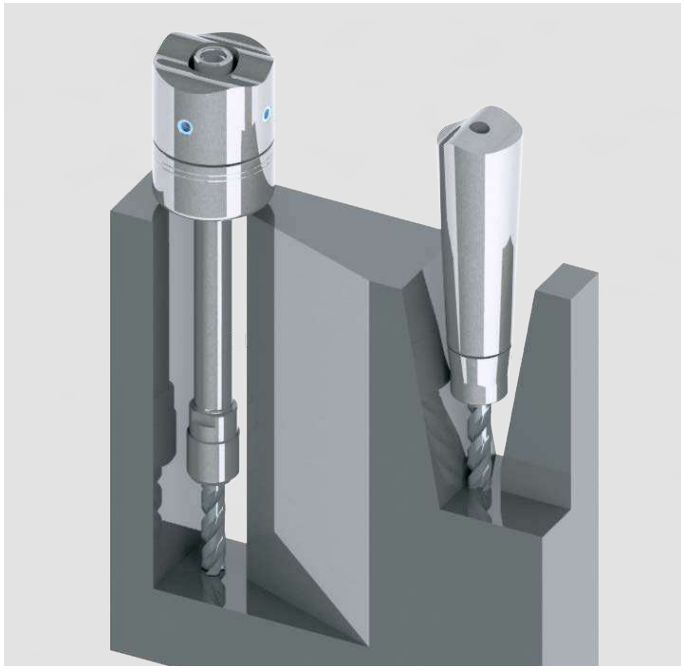
The MPC Mini Precision chucks are very slim precision chucks with optimal interference contour and therefore, ideal for HSC processing.



Cylindrical shafts can be reliably clamped from a shaft diameter of just 1 mm.
The outer diameter starts at 10 mm.



Alternatively, MPC chucks are also available in a slightly tapered yet slim design for more stability and deep immersion in components with draft angles in tool and mould making, for example.



MPC, MINI PRECISION CHUCK
Variants

Coolant supply variants through the matching collet
One system, several variants. The choice of collet determines the type of coolant supply.
For you this means:

- Better surface quality
- Longer tool life
- Easy chip removal
- Cooling and lubricating of the tool cutting edge



Without coolant supply
GERC-HP
GERC-B



Coolant through the centre
GERC-HPD
GERC-BD
GERC-GBD



Peripheral cooling
GERC-HPDD
GERC-GBDD

NEW

Process optimisation
Optimise your process and inquire about our collets with customised jet holes. Starting at 0.2 mm outlet diameter, jet holes can be designed for specific applications, e.g. for cryogen or aerosol cooling.

Variants with different clamping nuts for every application



Mini Clamping Nut MPC for
- Small outer diameter
- High speeds
- System accuracy up to 3 µm



Mini Clamping Nut HSS for
- Collet collapse up to 0.4 mm



Mini Clamping Nut MPC tapered for
- More stability
- High speeds
- System accuracy up to 3 µm



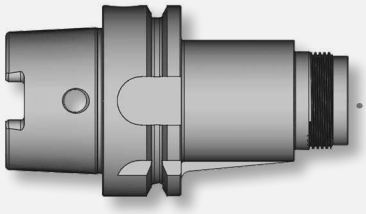
Mini Clamping Nut HSS tapered for
- More stability
- Collet collapse up to 0.4 mm

FAHRION® FAR BEYOND PRECISION

MPC, MINI PRECISION CHUCK

Overview

Interface:



Cylindrical or tapered version available

- HSK-A 32
- HSK-A 40
- HSK-A 50
- HSK-A 63
- HSK-E 25
- HSK-E 32
- HSK-E 40
- HSK-E 50
- SK 30
- SK 40
- BT 30 / BTP 30
- BT 40 / BTP 40
- CYL ø 10
- CYL ø 12
- CYL ø 16
- CYL ø 20

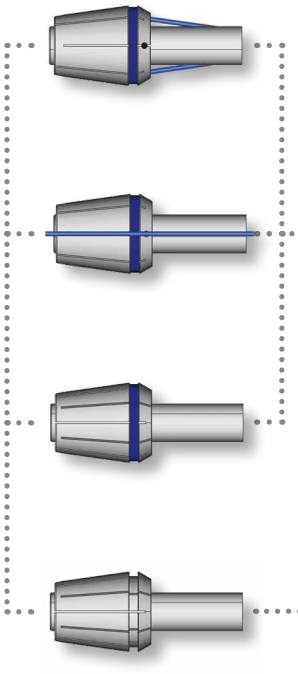
Execution:

- Cylindrical
- Tapered

Lengths:

- 35 mm to 75 mm
- 90 mm
- 100 mm / 105 mm
- 120 mm
- 130 mm
- 150 mm
- 160 mm
- 200 mm

Collets:

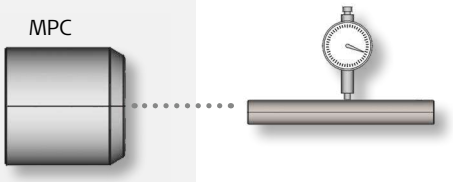


- GERC8-B
- GERC8-HP
- GERC11-B / BD
- GERC11-HP / HPD
- GERC16-B / BD
- GERC16-HP / HPD / HPDD

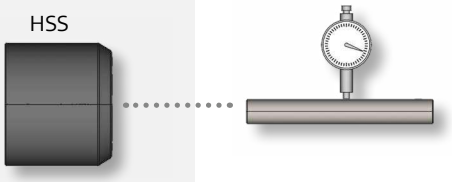
Clamping Nuts:

3 µm at 3xD with HP collets and MPC clamping nut
6 µm at 3xD with B collets and MPC clamping nut

MPC



HSS

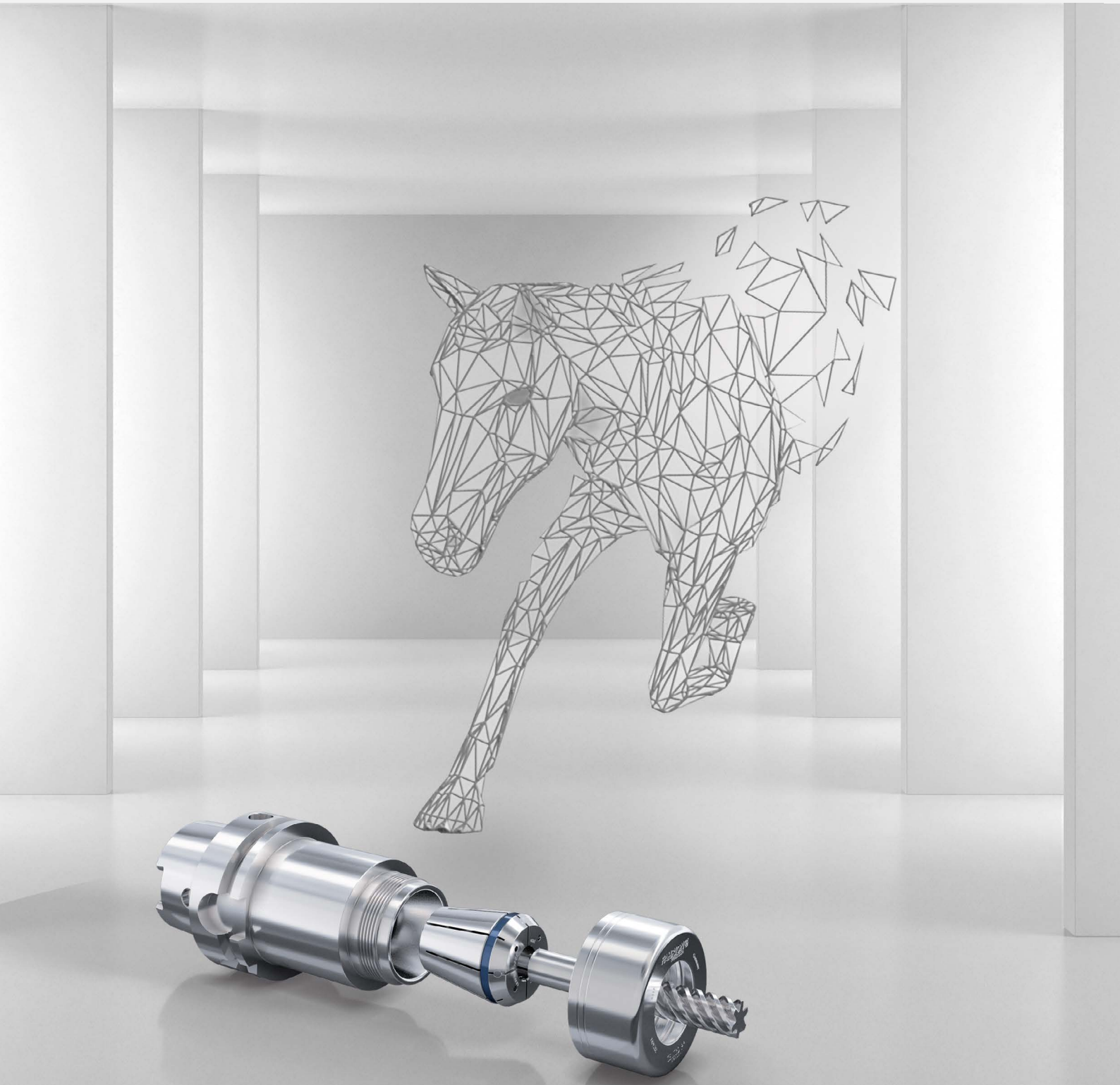


HSS clamping nut recommended for GERC-B collets for collet collapse up to max. - 0,4 mm

- MPC 8
- MPC 11
- MPC 16
- MPC 16 - HSS
- MPC 16 T
- MPC 16 T - HSS

DPC, DYNAMIC PERFORMANCE CHUCK

For Highly Dynamic Processes



The **DPC Dynamic Performance Chucks** are real universal all-rounders for demanding tasks, especially in HDC milling, but also for trimming, finishing and roughing. DPC holders are the first choice for high removal rates on dynamic machines with modern milling strategies, such as components for the tool and mold-making industry, automotive, machine, plant construction, high-end part suppliers, and contract manufacturers.

FAHRION® FAR BEYOND PRECISION

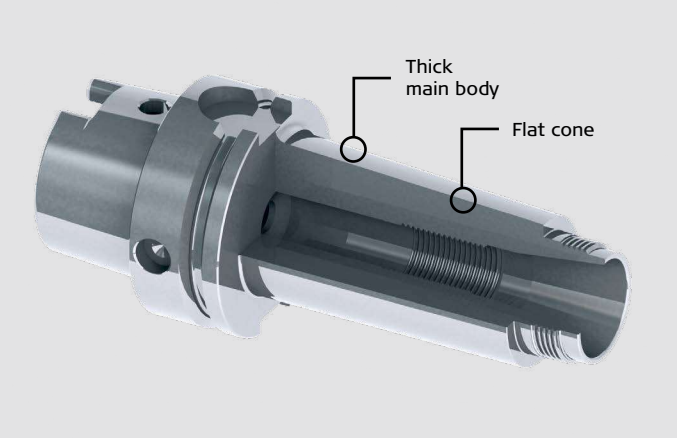
DPC, DYNAMIC PERFORMANCE CHUCK

Features

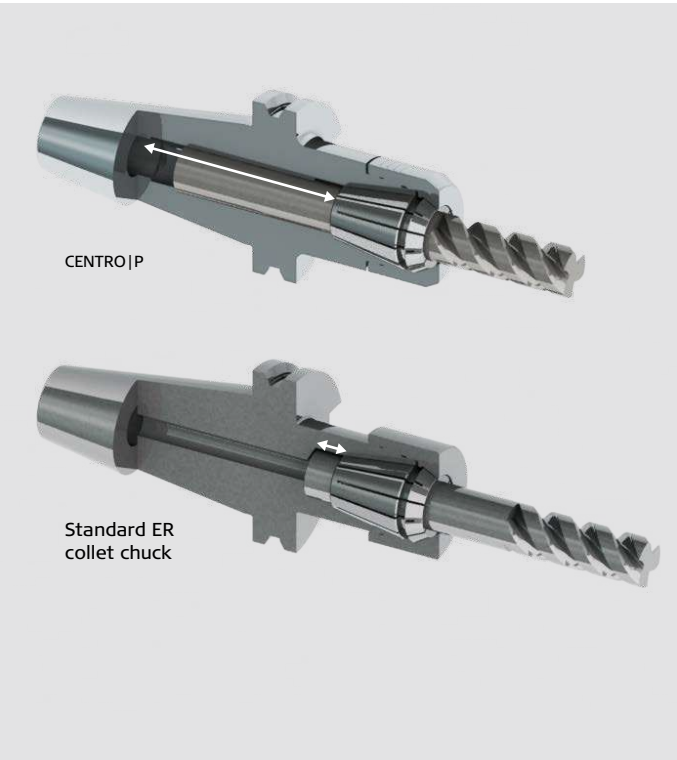
DPC chucks optimally combine high stability with excellent concentricity and best dynamics, preferably for drilling and milling.



The outer contour
DPC chucks have a stable, cylindrical outer contour with a maximum diameter (diameter of the clamping nut).
In addition, there are also tapered versions for even more rigidity and less vibration



The inner contour
Flexibility of projection is ensured by a large through diameter.



DPC, DYNAMIC PERFORMANCE CHUCK

Variants

Coolant supply variants through the matching collet
One system, several variants. The choice of collet determines the type of coolant supply. For you this means:

- Better surface quality
- Longer tool life
- Easy chip removal
- Cooling and lubricating of the tool cutting edge



Without coolant supply
GERC-HP
GERC-B



Coolant through the centre
GERC-HPD
GERC-BD
GERC-GBD



Peripheral cooling
GERC-HPDD
GERC-GBDD

NEW

Process optimisation
Optimise your process and inquire about our collets with customised jet holes. Starting at 0.2 mm outlet diameter, jet holes can be designed for specific applications, e.g. for cryogen or aerosol cooling.

Variants with different clamping nuts for every application



The Clamping Nut DPC
- Has a low friction coating
- Does not require grooves for the clamping wrench
- Has a stable trapezoidal thread and the FAHRION double guide for high clamping forces, optimum concentricity and minimal residual imbalance



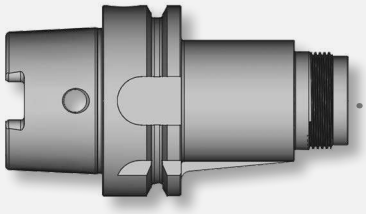
Clamping Nut HSS for
- Collet collapse up to 0.4 mm

FAHRION® FAR BEYOND PRECISION

DPC, DYNAMIC PERFORMANCE CHUCK

Overview

Interface:



Cylindrical or tapered version available

- HSK-A 32
- HSK-A 40
- HSK-A 50
- HSK-A 63
- HSK-A 100
- HSK-E 40
- HSK-E 50
- HSK-F 50
- HSK-F 63
- SK 30
- SK 40
- SK 50
- BT 30 / BTP 30
- BT 40 / BTP 40
- BT 50 / BTP 50
- PSC 50
- PSC 63
- PSC 80

- CYL ø 20
- CYL ø 25
- CYL ø 32
- CYL ø 40

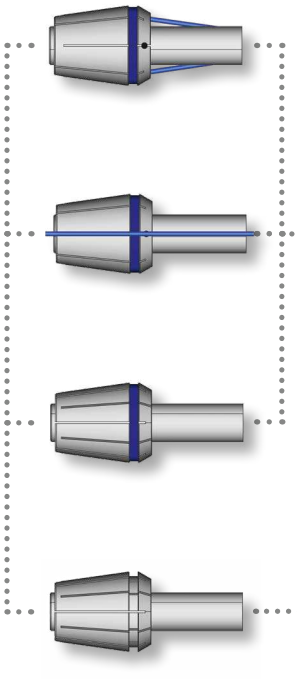
Execution:

- Cylindrical
- Tapered

Lengths:

- 50 mm to 75 mm
- 90 mm
- 100 mm / 105 mm
- 120 mm
- 130 mm
- 160 mm / 165 mm
- 200 mm

Collets:

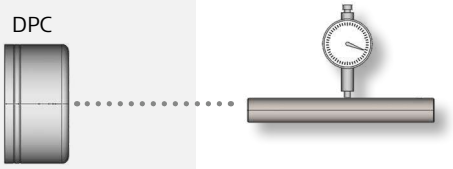


- GERC16-B / BD
- GERC16-HP / HPD / HPDD
- GERC20-B / BD
- GERC20-HP / HPD
- GERC25-B / BD
- GERC25-HP / HPD / HPDD
- GERC32-B / BD
- GERC32-HP / HPD / HPDD
- GERC40-B / BD
- GERC40-HP / HPD / HPDD

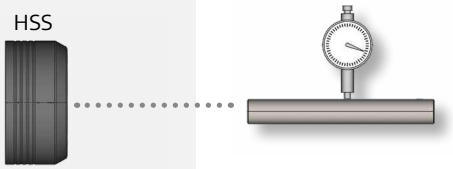
Clamping Nuts:

3 µm at 3xD with HP collets and DPC clamping nut
6 µm at 3xD with B collets and DPC clamping nut

DPC



HSS



HSS clamping nut recommended for GERC-B collets for collet collapse up to max. - 0,4 mm

- DPC 16
- DPC 16 - HSS
- DPC 20
- DPC 20 - HSS
- DPC 25
- DPC 25 - HSS
- DPC 32
- DPC 32 - HSS
- DPC 40

UPC, ULTRA POWER CHUCK

For Maximum Material Removal Rates



The **UPC Ultra Power Chucks** are extremely stiff precision chucks for the most demanding tasks with predominantly radial load. This is a reinforced version with a multi-part clamping nut for optimised damping and maximum stability. The wall thickness of the chuck body was increased to resolve more radial force and suppress vibration.

FAHRION® FAR BEYOND PRECISION

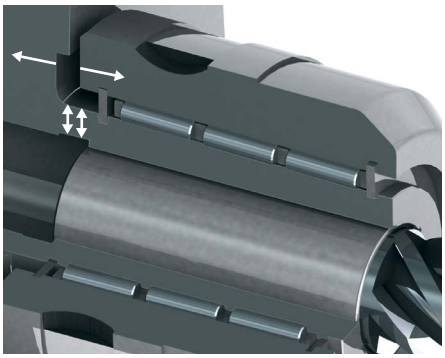
UPC, ULTRA POWER CHUCK

Features

- Optimal clamping force to eliminate collet twist
- Stable construction to reduce vibration build up
- Maximum dampening for vibration suppression
- Positive locking on the weldon surface to prevent micro creep
- New reinforced clamping nut with fine trapezoidal thread for improved locking
- The UPC reinforced chuck body for high radial loads is offered in a short version only. If longer reach is required use the FPC chuck

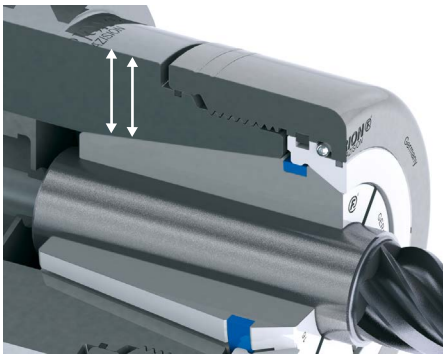


The problem

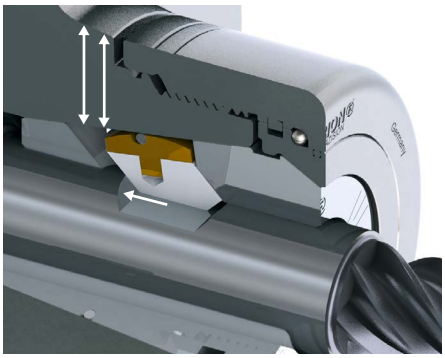


Conventional power chuck -
high radial transmittable torque -
unstable / weakened - only limited radial load capacity

The solution



FAHRION UPC -
stable basic body for increased radial load and additional safety due to mechanical pull-out protection

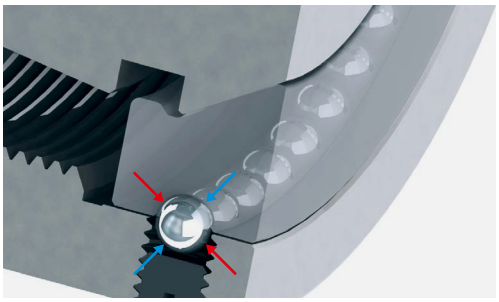


FAHRION UPC -
stable basic body for increased radial load with GERC-HP collets

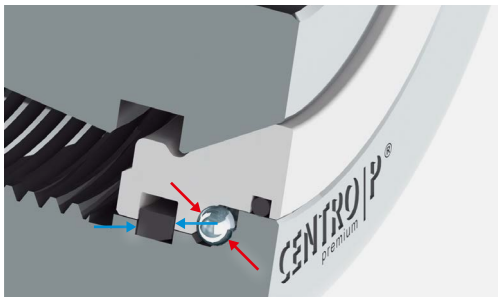
UPC, ULTRA POWER CHUCK

Ultra Power thanks to Angular Contact Ball Bearings and a Fine Thread

- New design of the clamping nut with an angular contact ball bearing and a compensating ring
- Special design with new trapezoidal fine thread and reinforced outer geometry for even better tightening of the clamping nut
- The ring allows clamping of the collet without radial forces. When tightening, the pressure on the collet is exerted only in the axial direction from top to bottom
- The multi-part nut increases the vibration damping.
- The tightening torques are identical to those of the PREMIUM DPC series
- As a result, the UPC clamping nut achieves a resultant clamping force of between 350 Nm and 380 Nm, more than sufficient, e.g. to secure a wedge collet with pull-out protection against twisting.



Conventional deep groove ball bearings:
Force flow during clamping (red) or release (blue) is transmitted exclusively via balls and bearing shells



Angular contact ball bearings at UPC:
Power flow during clamping (red) is transmitted via the balls, when releasing (blue) via the circlip

Coolant supply variants through the matching collet
One system, several variants. The choice of collet determines the type of coolant supply. For you this means:

- Better surface quality
- Longer tool life
- Easy chip removal
- Cooling and lubricating of the tool cutting edge



Without coolant supply
GERC-HP
GERC-B



Coolant through the centre
GERC-HPD
GERC-BD
GERC-GBD



Peripheral cooling
GERC-HPDD
GERC-GBDD

NEW

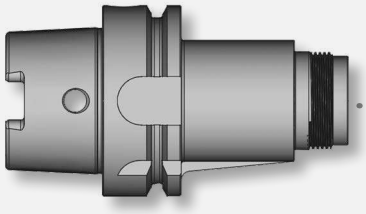
Process optimisation
Optimise your process and inquire about our collets with customised jet holes. Starting at 0.2 mm outlet diameter, jet holes can be designed for specific applications, e.g. for cryogen or aerosol cooling.

FAHRION® FAR BEYOND PRECISION

UPC, ULTRA POWER CHUCK

Overview

Interface:



Cylindrical or tapered version available

- HSK-A 63
- HSK-A 100
- SK 40
- SK 50
- BT 40 / BTP 40
- BT 50 / BTP 50
- PSC 80

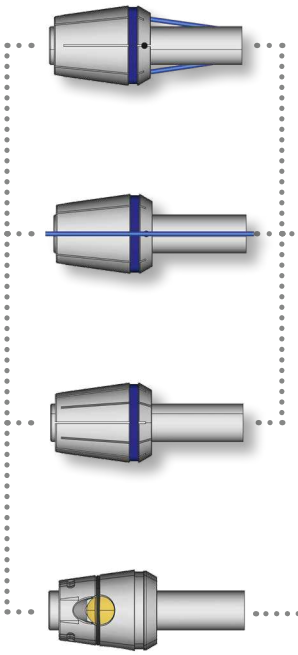
Execution:

- Cylindrical
- Tapered

Lengths:

- 65 mm to 80 mm
- 100 mm

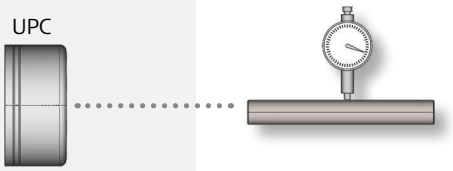
Collets:

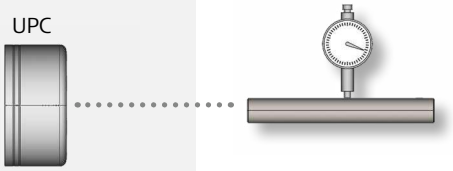


- GERC32-B / BD
- GERC32-HP / HPD / HPDD
- GERC32-W
- GERC40-B / BD
- GERC40-HP / HPD / HPDD
- GERC40-W

Clamping Nuts:

3 µm at 3xD with HP collets and UPC clamping nut
6 µm at 3xD with B collets and UPC clamping nut





4 µm at 3xD with W collets and UPC clamping nut

- UPC 32
- UPC 40

FPC, FULL PERFORMANCE CHUCKS

Higher Damping and More Holding Power



The **FPC Full Performance Chucks** are always the first choice, if the UPC cannot be used due to danger of collision.

The FPC chucks offer more holding power than the DPC and are leaner than the UPC.

FAHRION® FAR BEYOND PRECISION

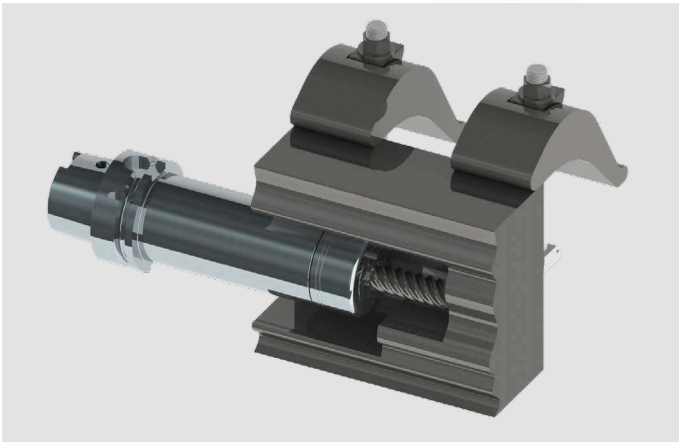
FPC, FULL PERFORMANCE CHUCKS

Features

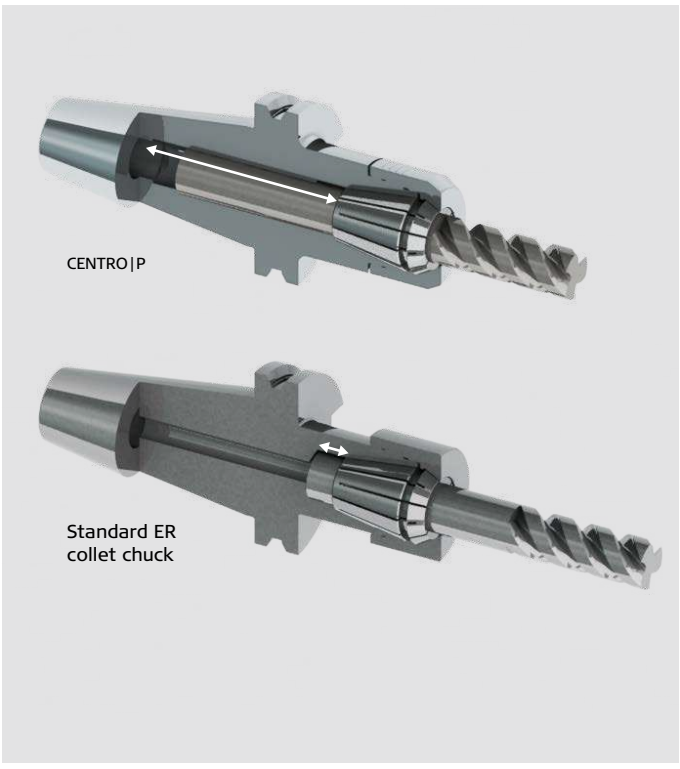
FPC holders have a multi-part clamping nut for good damping properties and due to their length are particularly suitable for axial loads on stable machines with modern milling strategies, for components in the aerospace, medical, mould&die, high-end part, and contract manufacturing industries.



FPC chucks extend the range of application of the CENTRO|P chuck to heavy chipping with high axial forces. Different lengths ensure best access to the work piece, even over devices and other interference contours.



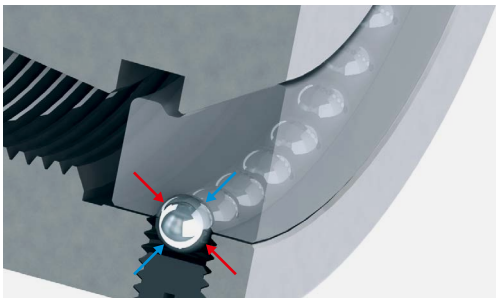
The inner contour
Flexibility of projection is ensured by a large through diameter.



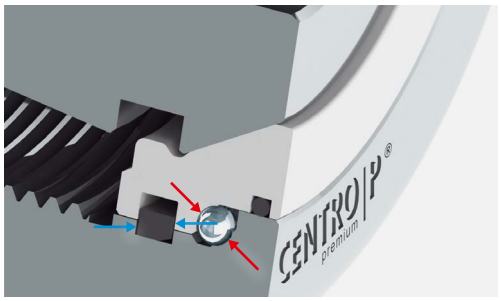
FPC, FULL PERFORMANCE CHUCKS

Full Performance thanks to Angular Contact Ball Bearings

- New design of the clamping nut with an angular contact ball bearing and a compensating ring
- Proven trapezoidal thread with CENTRO|P typical double guide
- The ring allows clamping of the collet without radial forces. When tightening, the pressure on the collet is exerted only in the axial direction from top to bottom
- The multi-part nut increases the vibration damping.
- The tightening torques are identical to those of the PREMIUM DPC series
- As a result, the FPC clamping nut achieves a resulting clamping force between 350 Nm and 380 Nm, which is higher than with hydraulic chucks



Conventional deep groove ball bearings:
Force flow during clamping (red) or release (blue) is transmitted exclusively via balls and bearing shells



Angular contact ball bearings at FPC:
Power flow during clamping (red) is transmitted via the balls, when releasing (blue) via the circlip

Coolant supply variants through the matching collet
One system, several variants. The choice of collet determines the type of coolant supply. For you this means:

- Better surface quality
- Longer tool life
- Easy chip removal
- Cooling and lubricating of the tool cutting edge



Without coolant supply
GERC-HP
GERC-B



Coolant through the centre
GERC-HPD
GERC-BD
GERC-GBD



Peripheral cooling
GERC-HPDD
GERC-GBDD

Process optimisation NEW

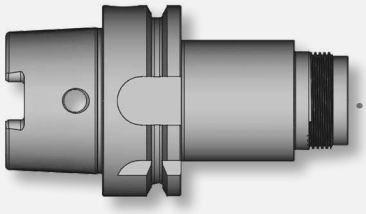
Optimise your process and inquire about our collets with customised jet holes. Starting at 0.2 mm outlet diameter, jet holes can be designed for specific applications, e.g. for cryogen or aerosol cooling.

FAHRION® FAR BEYOND PRECISION

FPC, FULL PERFORMANCE CHUCKS

Overview

Interface:



- HSK-A 63
- HSK-A 100
- HSK-F 63
- SK 40
- SK 50
- BT 40 / BTP 40
- BT 50 / BTP 50
- PSC 63
- PSC 80
- CYL 32
- CYL 40

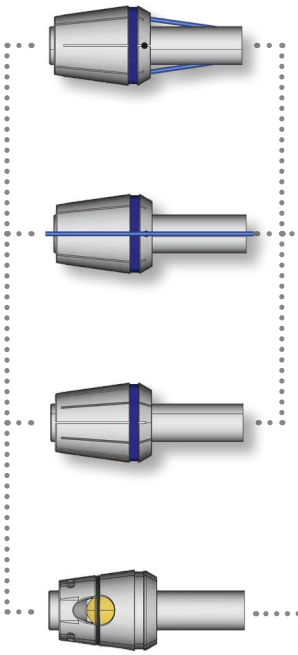
Execution:

- Cylindrical

Lengths:

- 60 mm to 75 mm
- 90 mm
- 100 mm / 105 mm
- 120 mm
- 130 mm / 135 mm
- 160 mm / 165 mm
- 200 mm

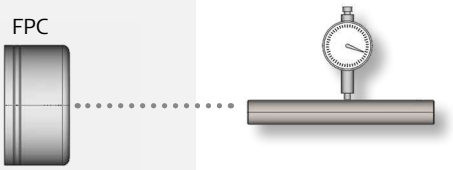
Collets:

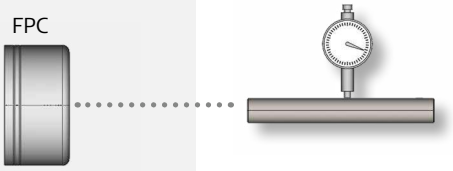


- GERC32-B / BD
- GERC32-HP / HPD / HPDD
- GERC32-W
- GERC40-B / BD
- GERC40-HP / HPD / HPDD
- GERC40-W

Clamping nuts:

3 µm at 3xD with HP collets and FPC clamping nut
6 µm at 3xD with B collets and FPC clamping nut



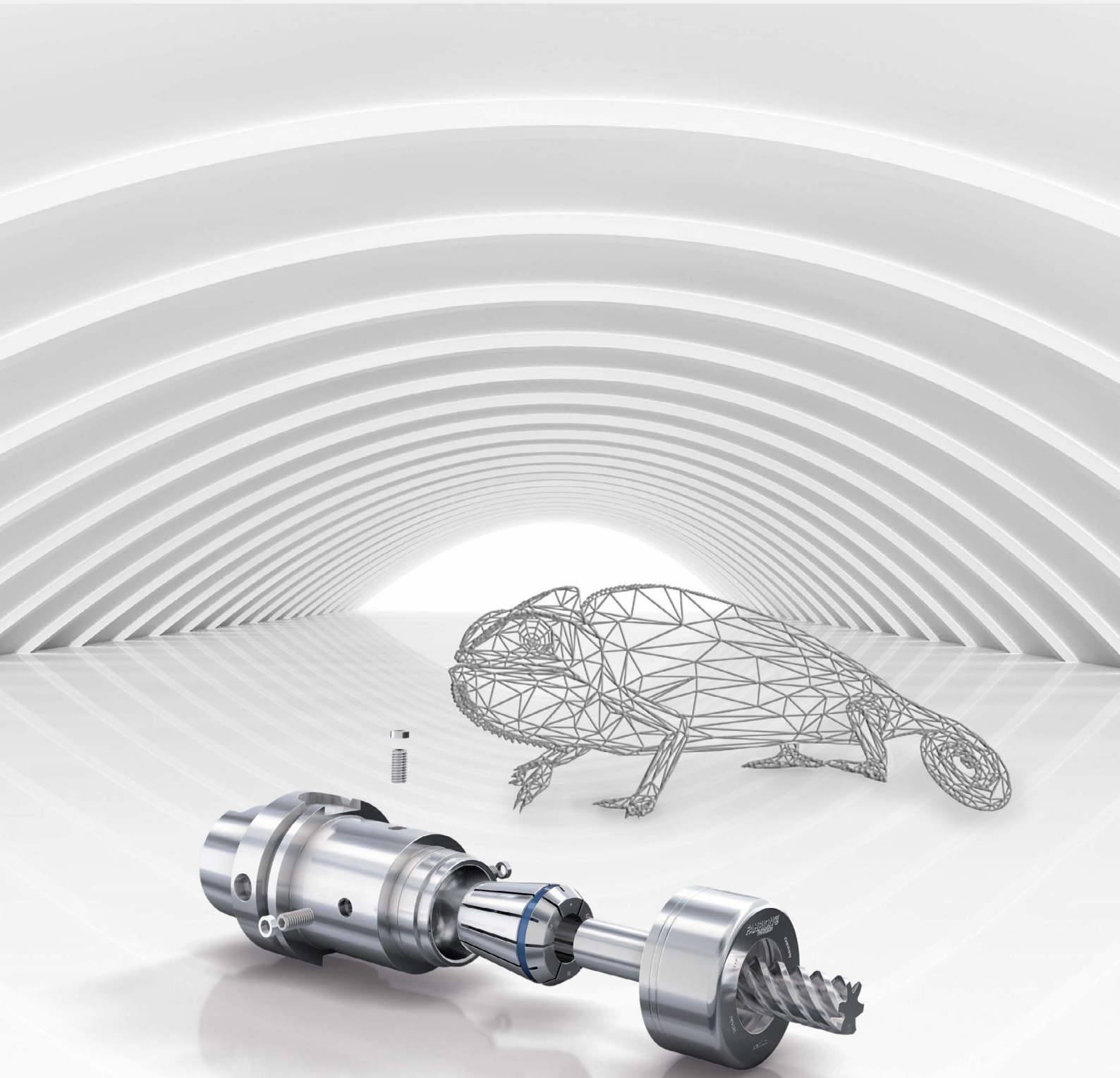


4 µm at 3xD with W collets
and FPC clamping nut

- FPC 32
- FPC 40

AFC, ADJUSTABLE FINISHING CHUCKS

Adjustable with Long Overhang



In order to achieve optimal machining results, e.g. during reaming, or also for other ultrafine machining, a perfect concentricity of the tool is essential. Adjustable chucks are used to eliminate concentricity errors of tool holder and machine spindle.

For the first time, the **AFC Adjustable Finishing Chucks** combine all the advantages of the CENTRO|P clamping system with the possibility of precisely adjusting the concentricity over four adjusting screws around the circumference of the chuck.

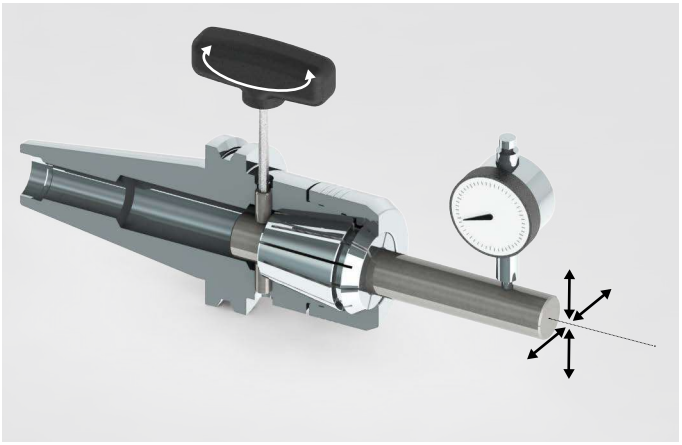
AFC, ADJUSTABLE FINISHING CHUCKS

Features

To ensure optimum concentricity, the AFC chuck must be adjusted in the machine spindle.

This is the only way to completely eliminate any concentricity deviations of the chuck, machine spindle, and or interface.





Coolant supply variants through the matching collet
One system, several variants. The choice of collet determines the type of coolant supply. For you this means:

- Better surface quality
- Longer tool life
- Easy chip removal
- Cooling and lubricating of the tool cutting edge



Without coolant supply
GERC-HP
GERC-B



Coolant through the centre
GERC-HPD
GERC-BD
GERC-GBD



Peripheral cooling
GERC-HPDD
GERC-GBDD

Process optimisation NEW

Optimise your process and inquire about our collets with customised jet holes. Starting at 0.2 mm outlet diameter, jet holes can be designed for specific applications, e.g. for cryogen or aerosol cooling.

MPC / DPC, CYLINDRICAL TOOL EXTENSIONS

Slim, Long, and Accurate - the Perfect Complement to the System



MPC / DPC Cylindrical Tool Extensions are particularly suitable for precision machining in hard-to-reach places and set standards in the areas of concentricity, set-up time and flexibility.

Instead of expensive special tools, a single change in length is often sufficient, which can be clamped more or less deeply into a CENTRO|P chuck as required.

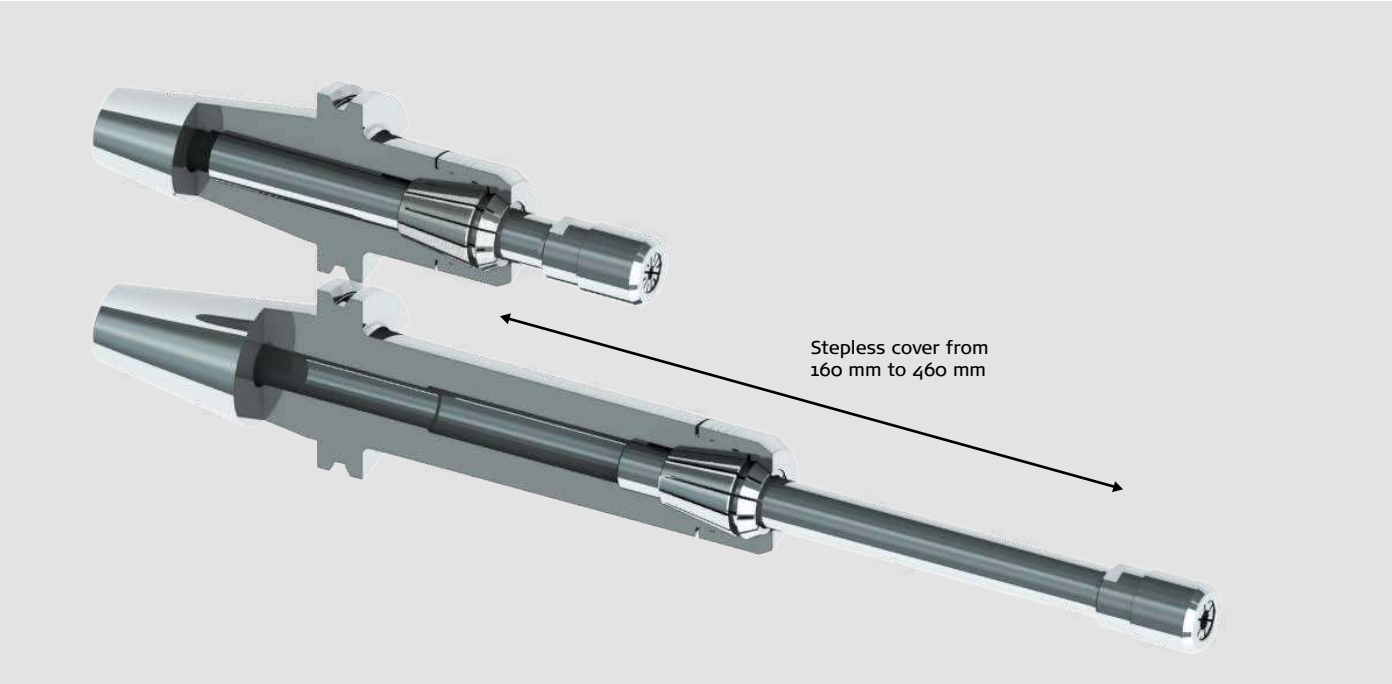
FAHRION® FAR BEYOND PRECISION

MPC / DPC, CYLINDRICAL TOOL EXTENSIONS

Features

Cylindrical extensions are ideal for flexible lengths with existing holders.

This can easily save time and costs for complex special geometries.



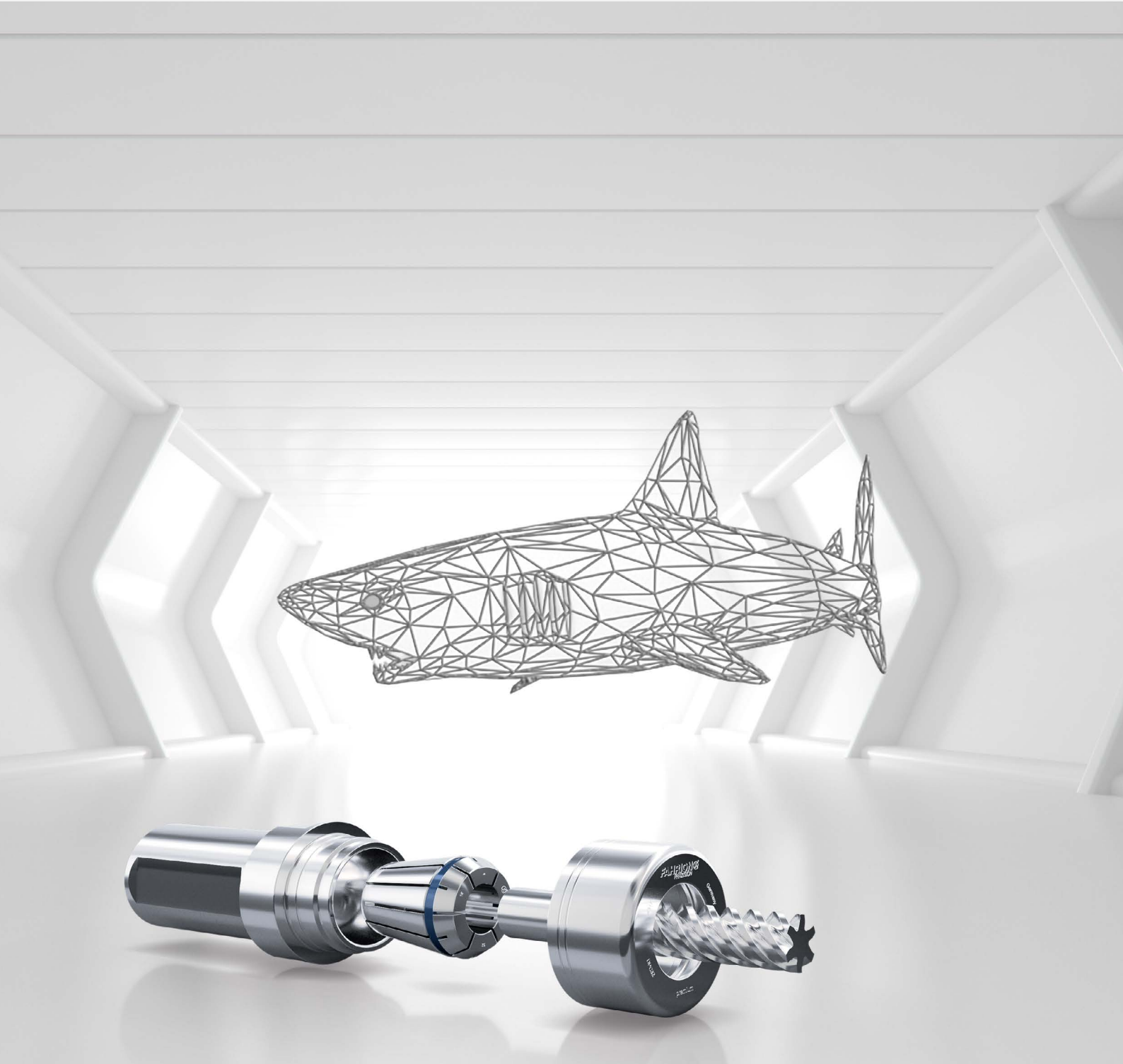
Basically, the longer the projection the more important the damping becomes with tool holders.
Additional interfaces (extension in the basic chuck via high-precision collet chuck) mean additional damping.

However, additional interfaces also mean poorer concentricity. When using the AFC holders as a basis, the concentricity can be set and thus optimised.



DPC / FPC, PERFORMANCE HOLDERS NC FOR LATHES

Versatile and Highly Precise



Versatile **DPC / FPC Performance Holders** for drilling, threading and reaming on NC lathes. The high-precision CENTRO|P chuck is clearly superior to conventional ER chucks.

The flange as a stop allows for a quick pre-setting of the cutting tool also outside the machine. The shaft can be inserted directly into the drill holder of the tool turret. This also protects the surface on the shaft.

FAHRION® FAR BEYOND PRECISION

DPC / FPC, PERFORMANCE HOLDERS NC FOR LATHES

Versatile and Highly Precise

Coolant supply variants through the matching collet
One system, several variants. The choice of collet determines the type of coolant supply. For you this means:

- Better surface quality
- Longer tool life
- Easy chip removal
- Cooling and lubricating of the tool cutting edge



Without coolant supply
GERC-HP
GERC-B



Coolant through the centre
GERC-HPD
GERC-BD
GERC-GBD



Peripheral cooling
GERC-HPDD
GERC-GBDD

NEW

Process optimisation
Optimise your process and inquire about our collets with customised jet holes. Starting at 0.2 mm outlet diameter, jet holes can be designed for specific applications, e.g. for cryogen or aerosol cooling.

Variants with different clamping nuts for every application



The Clamping Nut DPC
- Has a low friction coating
- Does not require grooves for the clamping wrench
- Has a stable trapezoidal thread and the FAHRION typical double guide for high clamping forces, optimum concentricity and minimal residual imbalance



Clamping Nut HSS for
- Collet collapse up to 0.4 mm

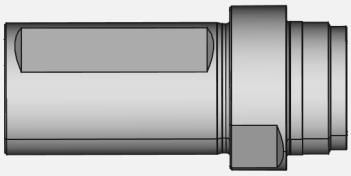


The Clamping Nut FPC
- With angular ball bearing and compression ring possesses all the characteristics of the DPC clamping nut while also increasing the vibration damping and holding force.

DPC / FPC, PERFORMANCE HOLDERS NC FOR LATHES

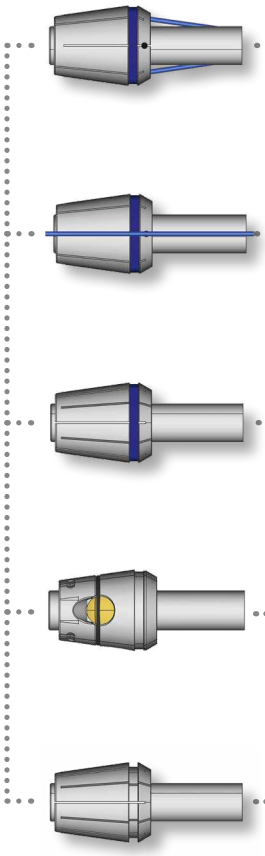
Overview

Interface:



- Cyl ø 25
- Cyl ø 32
- Cyl ø 40

Collets:

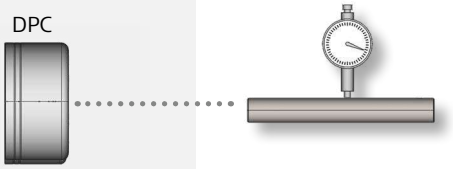


- GERC25-B/BD
- GERC25-HP/HPD/HPDD
- GERC32-B/BD
- GERC32-HP/HPD/HPDD
- GERC40-/BD
- GERC40-HP/HPD/HPDD

Clamping Nuts:

3 µm at 3xD with HP collets and DPC clamping nut
6 µm at 3xD with B collets and DPC clamping nut

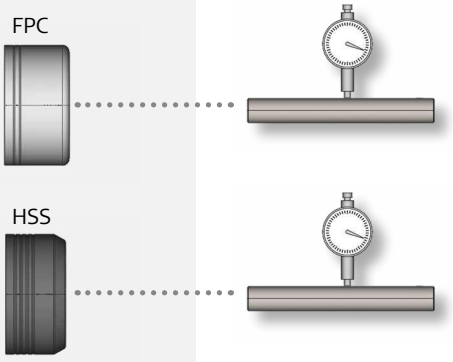
DPC



4 µm bel 3xD with W collets
and FPC clamping nut

FPC

HSS



HSS clamping nut recommended for GERC-B collets
for collet collapse up to max. - 0,4 mm

- DPC25
- DPC25-HSS
- DPC32
- DPC32-HSS
- DPC40
- FPC32
- FPC40

FAHRION® FAR BEYOND PRECISION

CHUCKS



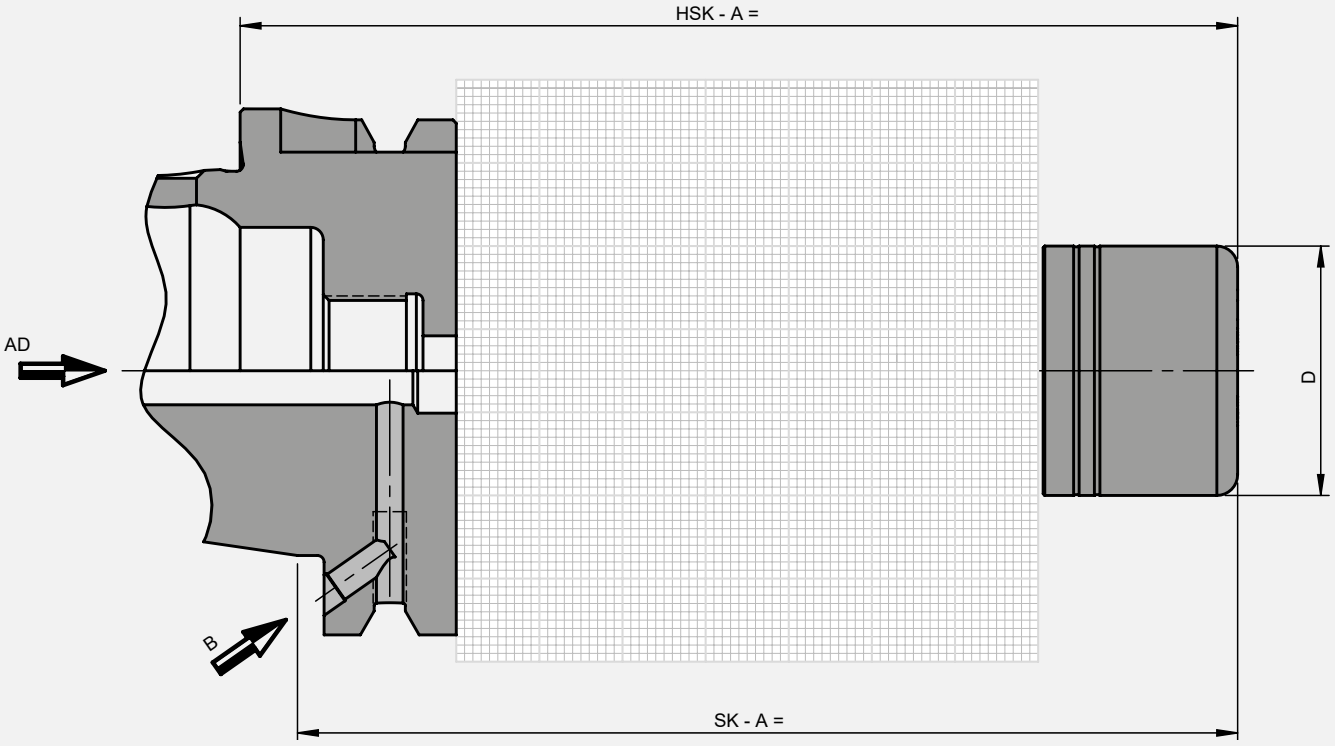
TAILOR MADE

FAHRION Chuck Configurator

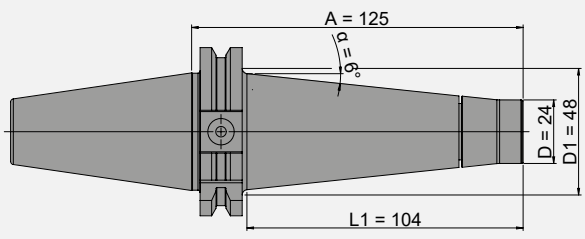
Use our special chuck configurator to significantly extend the service life of your cutting tools. Determine the optimal length and shape of your chuck. Sketch your idea and send it to us.

Tapered chucks, where space allows, tend to be more stable and stiffer than cylindrical chucks (example 1).
Chucks that are tapered in the rear and cylindrical in the front (example 2) or cylindrical chucks in the optimal length – as short as possible or as long as necessary.

Design the desired chuck below and we will deliver it to you. It's as simple as that!

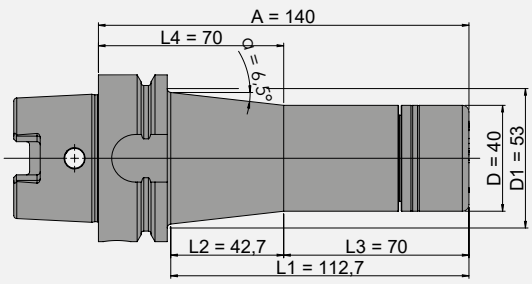


Example 1:



MPC16T-AD40-A=125 (tapered 6°)

Example 2:



DPC25-HSK-A63-A=140 (stepped - tapered 6,5°)

FAHRION® FAR BEYOND PRECISION

Please specify the following parameters and send them to us. You will receive a non-binding offer immediately:
Mail: sales@fahrion.de

Form for your individual CHUCK				
Spindle-Side Interface (see pages 170 / 171 in the Technical Section)				
Drilling for RFID chip	☐ Yes	☐ No		
Coolant Supply	☐ AD central	☐ B through the flange		
Shape	☐ cylindrical	☐ tapered	☐ stepped	
Dimension A (up to A = 300 mm)				

Clamping Nuts	D	Type	Collet	Clamping range
	☐ 10	MPC8	GERC8	1-5 mm
	☐ 16	MPC11	GERC11	1-7 mm
	☐ 22	MPC16	GERC16	1-10 mm
	☐ 24	MPC16T	GERC16	1-10 mm
	☐ 30	DPC16	GERC16	1-10 mm
	☐ 32	DPC20	GERC20	1-13 mm
	☐ 40	DPC25	GERC25	1-16 mm
	☐ 50	DPC32	GERC32	2-20 mm
	☐ 53	UPC32	GERC32	2-20 mm
	☐ 63	UPC40	GERC40	3-26 mm
	☐ 50	FPC32	GERC32	2-20 mm
	☐ 63	FPC40	GERC40	3-26 mm

Please select your desired version.

Minimum order quantity 5 pcs.
under- or over-supply of up to 10%
(but not less than 1 piece).

ONLINE SERVICE

Download the sketch template and the configuration form directly from our website at:

fahrion.de/downloads-en.html

HSK-A32
MPC

MPC MINI PRECISION CHUCKS

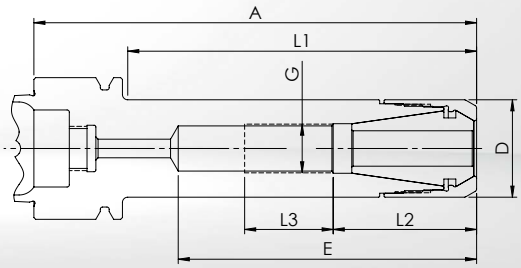
DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-HSK-A32-A=40	61131340405	---	16	50.000	24	20	---	---	---
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-HSK-A32-A=50	61133340505	61133340506	22	45.000	32	30	---	---	---
MPC16-HSK-A32-A=100	61133341005	61133341006	22	30.000	67	80	32	20	M11x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
Page 135ff	Page 162ff	Page 160	Page 161	Page 165	Page 165

FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

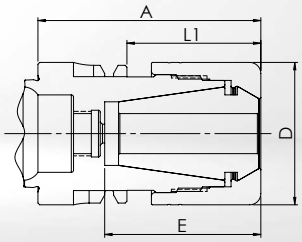
FORM AD - CENTRAL COOLANT SUPPLY

HSK-A32
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-HSK-A32-A=50	63134300505	63134300506	32	35	30	---	---	---

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
Page 142ff	Page 162ff	Page 160	Page 161	Page 165	Page 165

HSK-A40
MPC

MPC MINI PRECISION CHUCKS

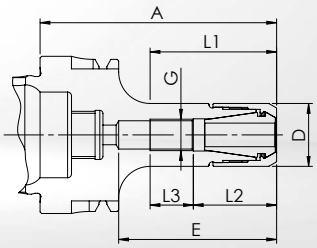
DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11								
MPC11-HSK-A40-A=60	61141340605	16	42.000	40	40	21	11	M8x1
MPC11-HSK-A40-A=130	61141341305	16	27.000	75	110	19	22	M8x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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FAHRION® FAR BEYOND PRECISION

MPC MINI PRECISION CHUCKS

DIN 69893-1/ISO 12164-1

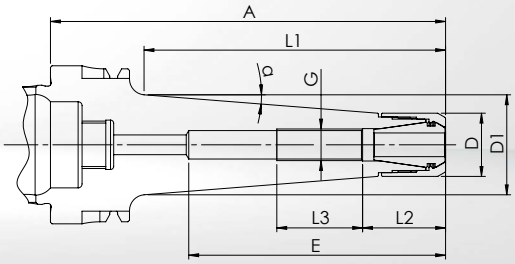
FORM AD - CENTRAL COOLANT SUPPLY

HSK-A40
MPC

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16										
MPC11C-HSK-A40-A=100	61141331005	16	40.000	65	25	4,5°	76	21	21	M8x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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HSK-A40
MPC

MPC MINI PRECISION CHUCKS

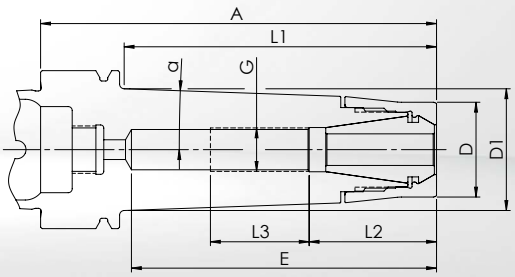
DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult cutting tasks and milling operations
Tapered design with tapered clamping nut for more stability and clamping force

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16T-HSK-A40-A=60	61143320605	61143320606	24	42.000	43	28	2°	40	---	---	---
MPC16T-HSK-A40-A=100	61143321005	61143321006	24	40.000	77	30	2°	80	32	25	M11x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

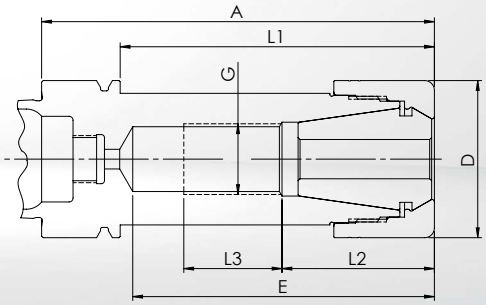
FORM AD - CENTRAL COOLANT SUPPLY

HSK-A40
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-HSK-A40-A=60	**63143300605**	**63143300606**	30	41	40	---	---	---
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-A40-A=60	**63145300605**	**63145300606**	40	39	40	---	---	---
DPC25-HSK-A40-A=100	63145301005	63145301006	40	77	80	39	25	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-HSK-A40-A=61	63146300615	63146300616	50	44,5	41,5	---	---	---

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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HSK-A50
MPC

MPC MINI PRECISION CHUCKS

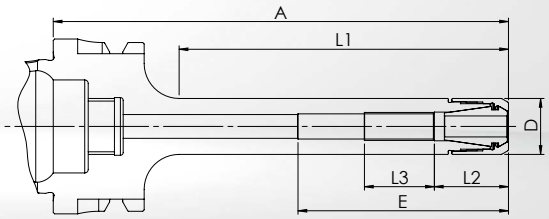
DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11								
MPC11-HSK-A50-A=130	61151341305	16	27.000	60	104	21	20	M8x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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FAHRION® FAR BEYOND PRECISION

MPC MINI PRECISION CHUCKS

DIN 69893-1/ISO 12164-1

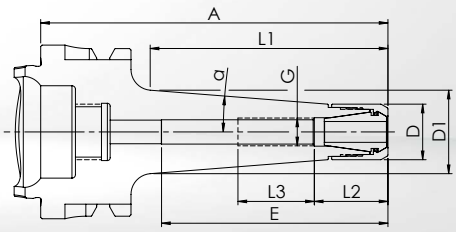
FORM AD - CENTRAL COOLANT SUPPLY

HSK-A50
MPC

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11										
MPC11C-HSK-A50-A=100	61151331005	16	30.000	60	24	4,5°	68	21	20	M8x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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HSK-A50
MPC

MPC MINI PRECISION CHUCKS

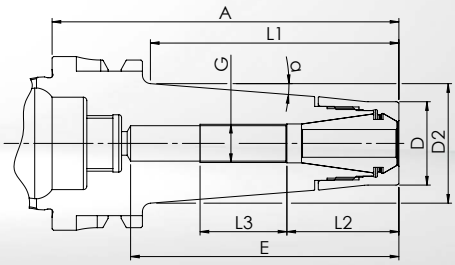
DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult cutting tasks and milling operations
Tapered design with tapered clamping nut for more stability and clamping force

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16T-HSK-A50-A=65	61153320655	61153320656	24	30.000	44	28,9	4,5°	36,5	---	---	---
MPC16T-HSK-A50-A=100	**61153321005**	**61153321006**	24	30.000	77	34,4	4,5°	71,5	32	25	M11x1
MPC16T-HSK-A50-A=130	61153321305	61153321306	24	30.000	102	39,4	4,5°	103	32	25	M11x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

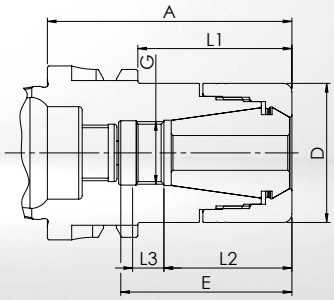
FORM AD - CENTRAL COOLANT SUPPLY

HSK-A50
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-A50-A=60	**63155300605**	**63155300606**	40	36,5	34,5	---	---	---
DPC25-HSK-A50-A=70	**63155300705**	**63155300706**	40	49,5	44	37	8	M18x1,5
DPC25-HSK-A50-A=100	63155301005	63155301006	40	76	74	39	25	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-HSK-A50-A=70	**63156300705**	**63156300706**	50	47,5	44	---	---	---

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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HSK-A63
MPC

MPC MINI PRECISION CHUCKS

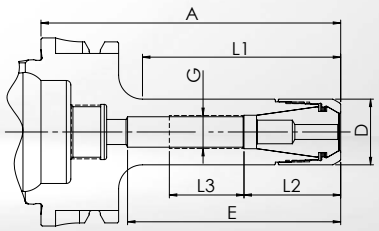
DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-HSK-A63-A=70	**61161340705**	---	16	25.000	48	34	19	20	M8x1
MPC11-HSK-A63-A=100	**61161341005**	---	16	25.000	78	64	19	25	M8x1
MPC11-HSK-A63-A=130	**61161341305**	---	16	25.000	108	94	19	20	M8x1
MPC11-HSK-A63-A=160	**61161341605**	---	16	25.000	138	124	19	25	M8x1
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-HSK-A63-A=70	**61163340705**	**61163340706**	22	25.000	47	39	32	10	M11x1
MPC16-HSK-A63-A=100	**61163341005**	**61163341006**	22	25.000	71	66	32	25	M11x1
MPC16-HSK-A63-A=130	**61163341305**	**61163341306**	22	25.000	102	96	32	28	M11x1
MPC16-HSK-A63-A=160	**61163341605**	**61163341606**	22	25.000	97	122	32	30	M11x1

Suitable Accessories

Collets



Page 135ff

Clamping Nuts



Page 162

Wrenches



Page 160

Mounting Devices



Page 161

Adjustable Stop Screws



Page 165

Coolant Supply Tubes and Wrenches



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FAHRION® FAR BEYOND PRECISION

MPC MINI PRECISION CHUCKS

DIN 69893-1/ISO 12164-1

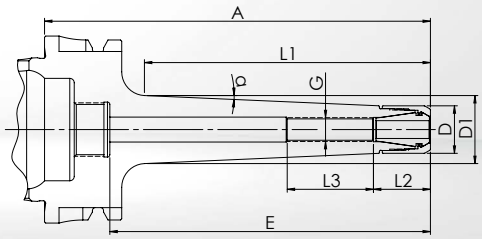
FORM AD - CENTRAL COOLANT SUPPLY

HSK-A63
MPC

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-HSK-A63-A=100	61161331005	---	16	25.000	78	21	2,5°	66	19	35	M8x1
MPC11C-HSK-A63-A=130	61161331305	---	16	25.000	108	23	2,5°	96	19	35	M8x1
MPC11C-HSK-A63-A=160	61161331605	---	16	25.000	138	25,5	2,5°	127	19	35	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-HSK-A63-A=100	61163331005	61163331006	22	25.000	71	26,5	2,5°	69	32	37	M11x1
MPC16C-HSK-A63-A=130	61163331305	61163331306	22	25.000	102	28,5	2,5°	99	32	37	M11x1
MPC16C-HSK-A63-A=160	61163331605	61163331606	22	25.000	97	31,5	2,5°	129	32	37	M11x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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HSK-A63
MPC

MPC MINI PRECISION CHUCKS

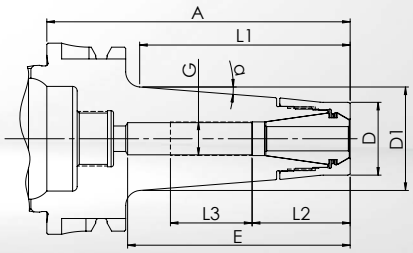
DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult cutting tasks and milling operations
Tapered design with tapered clamping nut for more stability and clamping force

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16T-HSK-A63-A=100	**61163321005**	**61163321006**	24	25.000	75	34,5	4,5°	67	32	27	M11x1
MPC16T-HSK-A63-A=130	61163321305	61163321306	24	25.000	103	39	4,5°	99	32	27	M11x1
MPC16T-HSK-A63-A=160	**61163321605**	**61163321606**	24	25.000	107	36	2,5°	127	32	27	M11x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

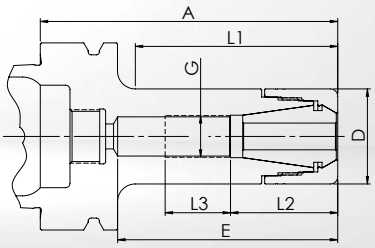
DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-HSK-A63-A=55	**63163300555**	**63163300556**	30	32	26,5	---	---	---
DPC16-HSK-A63-A=100	**63163301005**	**63163301006**	30	71	64	32	25	M11x1
DPC16-HSK-A63-A=130	**63163301305**	**63163301306**	30	97	94	32	28	M11x1
DPC16-HSK-A63-A=160	**63163301605**	**63163301606**	30	107	124	32	25	M11x1
DPC16-HSK-A63-A=200	63163302005	63163302006	30	137	164	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-HSK-A63-A=60	63164300605	63164300606	32	34,5	33	---	---	---
DPC20-HSK-A63-A=100	**63164301005**	**63164301006**	32	74	68	36	22	M14x1
DPC20-HSK-A63-A=130	63164301305	63164301306	32	104	98	36	25	M14x1
DPC20-HSK-A63-A=160	63164301605	63164301606	32	118	128	36	46	M14x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-A63-A=60	**63165300605**	**63165300606**	40	37	28	---	---	---
DPC25-HSK-A63-A=100	**63165301005**	**63165301006**	40	71	68	43	23	M18x1,5
DPC25-HSK-A63-A=130	**63165301305**	**63165301306**	40	89	98	43	28	M18x1,5
DPC25-HSK-A63-A=160	**63165301605**	**63165301606**	40	104	128	43	35	M18x1,5
DPC25-HSK-A63-A=200	63165302005	63165302006	40	149	168	43	35	M18x1,5

For other DPC chucks with HSK-A63, see following page.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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HSK-A63
DPC

DPC DYNAMIC PERFORMANCE CHUCKS

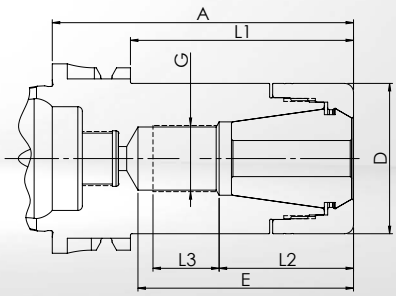
DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-HSK-A63-A=70	**63166300705**	**63166300706**	50	45	44	---	---	---
DPC32-HSK-A63-A=100	**63166301005**	**63166301006**	50	72	73	45	22	M22x1,5
DPC32-HSK-A63-A=130	**63166301305**	**63166301306**	50	102	103	45	35	M22x1,5
DPC32-HSK-A63-A=160	63166301605	63166301606	50	130	133	48	40	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-HSK-A63-A=80	**63167300805**	---	63	56	54	---	---	---
DPC40-HSK-A63-A=120	63167301205	---	63	90	94	56	30	M28x1,5
DPC40-HSK-A63-A=160	63167301605	---	63	90	134	56	30	M28x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

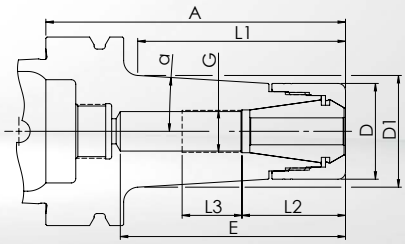
FORM AD - CENTRAL COOLANT SUPPLY

HSK-A63
DPC

Stable precision chuck for demanding tasks, especially in HDC milling
Tapered design for better damping and higher stability

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16										
DPC16C-HSK-A63-A=75	**63163310755**	**63163310756**	30	51	33	4,5°	42	32	15	M11x1
DPC16C-HSK-A63-A=100	**63163311005**	**63163311006**	30	75	35,5	3,5°	68	32	20	M11x1
DPC16C-HSK-A63-A=130	63163311305	63163311306	30	105	36,5	2,5°	97	32	20	M11x1
Clamping range Ø 1-13 mm - Collets GERC20										
DPC20C-HSK-A63-A=75	**63164310755**	**63164310756**	32	50	35	4,5°	45	34	10	M14x1
DPC20C-HSK-A63-A=100	**63164311005**	**63164311006**	32	75	37	3,5°	69	34	20	M14x1
DPC20C-HSK-A63-A=130	63164311305	63164311306	32	105	39	2,5°	99	34	20	M14x1
Clamping range Ø 1-16 mm - Collets GERC25										
DPC25C-HSK-A63-A=75	**63165310755**	**63165310756**	40	50	44	4,5°	45	---	---	---
DPC25C-HSK-A63-A=100	**63165311005**	**63165311006**	40	74	46	3,5°	71	43	25	M18x1,5
DPC25C-HSK-A63-A=130	63165311305	63165311306	40	104	47	2,5°	101	43	25	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32										
DPC32C-HSK-A63-A=75	63166310755	63166310756	50	51	51,5	4°	49	---	---	---

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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HSK-A63
UPC

UPC ULTRA POWER CHUCKS

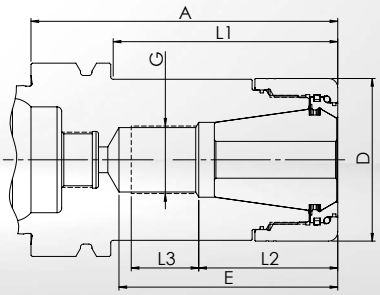
DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Cylindrical design with a multi-part clamping nut for optimised damping and maximum stability

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
UPC32-HSK-A63-A=70	**67166300705**	53	45	43	---	---	---
UPC32-HSK-A63-A=100	**67166301005**	53	72	74	45	22	M22x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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FAHRION® FAR BEYOND PRECISION

FPC FULL PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

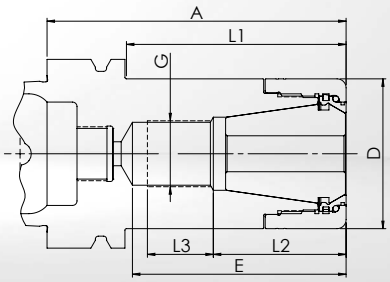
FORM AD - CENTRAL COOLANT SUPPLY

HSK-A63
FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-HSK-A63-A=70	**63166300709**	50	45	44	---	---	---
FPC32-HSK-A63-A=100	**63166301009**	50	72	73	45	22	M22x1,5
FPC32-HSK-A63-A=130	**63166301309**	50	102	103	45	35	M22x1,5
FPC32-HSK-A63-A=160	63166301609	50	130	133	48	40	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-HSK-A63-A=80	63167300809	63	56	54	---	---	---
FPC40-HSK-A63-A=120	63167301209	63	90	94	56	30	M28x1,5
FPC40-HSK-A63-A=160	63167301609	63	90	134	56	30	M28x1,5

Suitable Accessories

Collets

Page 150ff

Clamping Nuts

Page 164

Wrenches

Page 160

Mounting Devices

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Adjustable Stop Screws

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Coolant Supply Tubes and Wrenches

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HSK-A63
AFC

AFC ADJUSTABLE FINISHING CHUCKS

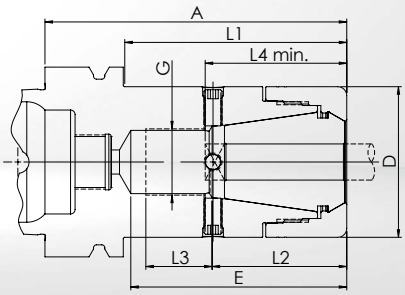
DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-HSK-A63-A=100	63165305235	40	71	68	43	23	M18x1,5
11-13	10,1-13,5	43	AFC25-HSK-A63-A=100	63165305245	40	71	68	43	23	M18x1,5
14-16	13,51-16	43	AFC25-HSK-A63-A=100	63165305265	40	71	68	43	23	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-HSK-A63-A=100	63166305245	50	72	73	45	22	M22x1,5
14-20	13,51-20	47	AFC32-HSK-A63-A=100	63166305265	50	72	73	45	22	M22x1,5
Collets GERC40										
10-16	9,51-16,5	55	AFC40-HSK-A63-A=120	63167305365	63	90	94	56	30	M28x1,5
17-22	16,51-22,5	55	AFC40-HSK-A63-A=120	63167305385	63	90	94	56	30	M28x1,5
23-26	22,51-26	55	AFC40-HSK-A63-A=120	63167305395	63	90	94	56	30	M28x1,5

Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø.
Other versions and clamping Ø can be offered after technical examination.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

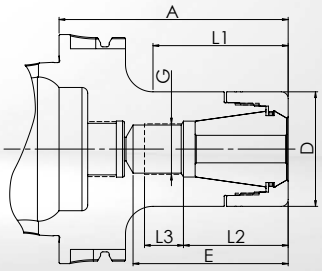
FORM AD - CENTRAL COOLANT SUPPLY

HSK-A100
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-HSK-A100-A=100	**63183301005**	**63183301006**	30	71	58	32	25	M11x1
DPC16-HSK-A100-A=130	63183301305	63183301306	30	101	89	32	25	M11x1
DPC16-HSK-A100-A=160	**63183301605**	**63183301606**	30	130	118	32	25	M11x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-A100-A=100	**63185301005**	**63185301006**	40	68	59	42	20	M18x1,5
DPC25-HSK-A100-A=130	63185301305	63185301306	40	98	89	42	35	M18x1,5
DPC25-HSK-A100-A=160	63185301605	63185301606	40	128	119	42	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-HSK-A100-A=100	**63186301005**	**63186301006**	50	67	59	45	17	M22x1,5
DPC32-HSK-A100-A=130	63186301305	63186301306	50	97	89	47	35	M22x1,5
DPC32-HSK-A100-A=160	**63186301605**	**63186301606**	50	99	119	47	35	M22x1,5
DPC32-HSK-A100-A=200	63186302005	63186302006	50	149	159	47	35	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-HSK-A100-A=100	63187301005	---	63	65	65	---	---	---
DPC40-HSK-A100-A=130	63187301305	---	63	90	95	56	30	M28x1,5
DPC40-HSK-A100-A=160	63187301605	---	63	90	125	56	35	M28x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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HSK-A100
UPC

UPC ULTRA POWER CHUCKS

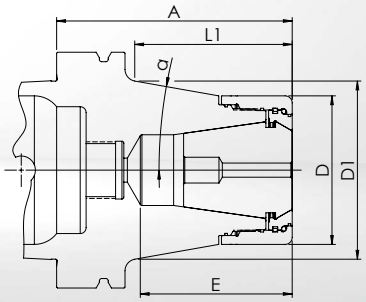
DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Tapered design with a multi-part clamping nut for optimised damping and maximum stability

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32									
UPC32C-HSK-A100-A=100	**67186311005**	53	68	66,5	10°	66	45	19	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40									
UPC40C-HSK-A100-A=100	**67187311005**	63	65	75,5	10°	66,5	---	---	---

Note about UPC40: For longer A dimensions in cylindrical form A=130 and A=160, see FPC page 57.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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FAHRION® FAR BEYOND PRECISION

FPC FULL PERFORMANCE CHUCKS

DIN 69893-1/ISO 12164-1

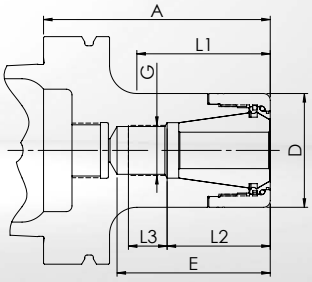
FORM AD - CENTRAL COOLANT SUPPLY

HSK-A100
FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-HSK-A100-A=100	**63186301009**	50	67	59	45	17	M22x1,5
FPC32-HSK-A100-A=130	63186301309	50	97	89	47	35	M22x1,5
FPC32-HSK-A100-A=160	**63186301609**	50	99	119	47	35	M22x1,5
FPC32-HSK-A100-A=200	63186302009	50	149	159	47	35	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-HSK-A100-A=100	63187301009	63	65	65	---	---	---
FPC40-HSK-A100-A=130	63187301309	63	90	95	56	30	M28x1,5
FPC40-HSK-A100-A=160	63187301609	63	90	125	56	35	M28x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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HSK-A100
AFC

AFC ADJUSTABLE FINISHING CHUCKS

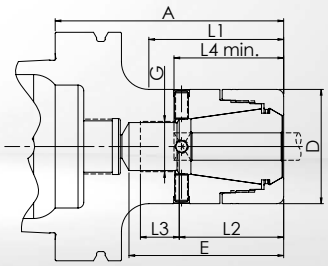
DIN 69893-1/ISO 12164-1

FORM AD - CENTRAL COOLANT SUPPLY

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-HSK-A100-A=100	63185305235	40	68	59	43	20	M18x1,5
11-13	10,1-13,5	43	AFC25-HSK-A100-A=100	63185305245	40	68	59	43	20	M18x1,5
14-16	13,51-16	43	AFC25-HSK-A100-A=100	63185305265	40	68	59	43	20	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-HSK-A100-A=100	63186305245	50	68	59	45	17	M22x1,5
14-20	13,51-20	47	AFC32-HSK-A100-A=100	63186305265	50	68	59	45	17	M22x1,5
Collets GERC40										
7-15	7-15,5	55	AFC40-HSK-A100-A=100	63187305245	63	65	65	---	---	---
16-26	15,51-26	55	AFC40-HSK-A100-A=100	63187305265	63	65	65	---	---	---

Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø.
Other versions and clamping Ø can be offered after technical examination.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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FAHRION® FAR BEYOND PRECISION

MPC MINI PRECISION CHUCKS

DIN 69893-5

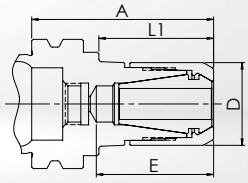
FORM AD - CENTRAL COOLANT SUPPLY

HSK-E25
MPC

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-5 mm - Collets GERC8									
MPC8-HSK-E25-A=35	61320340355	---	10	60.000	21	21	---	---	---
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-HSK-E25-A=35	61321340355	---	16	60.000	22,5	22	---	---	---
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-HSK-E25-A=45	**61323340455**	**61323340456**	22	60.000	30	34	---	---	---

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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HSK-E32
MPC

MPC MINI PRECISION CHUCKS

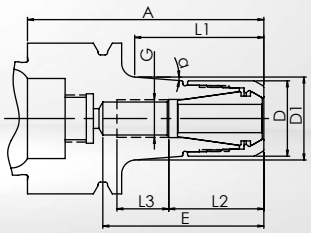
DIN 69893-5

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-5 mm - Collets GERC8											
MPC8C-HSK-E32-A=50	61330330505	---	10	50.000	33	12,5	4,5°	27,5	17	10	M5x0,8
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-HSK-E32-A=50	61331330505	---	16	50.000	34	17,5	4,5°	27	20	11	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-HSK-E32-A=55	**61333330555**	**61333330556**	22	50.000	32	23,2	2,5°	34	34	7	M6x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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FAHRION® FAR BEYOND PRECISION

MPC MINI PRECISION CHUCKS

DIN 69893-5

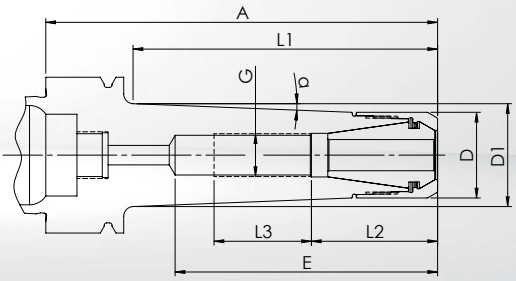
FORM AD - CENTRAL COOLANT SUPPLY

HSK-E40
MPC

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-HSK-E40-A=50	**61341330505**	---	16	42.000	31	17	4,5°	22,5	19	10	M8x1
MPC11C-HSK-E40-A=100	**61341331005**	---	16	40.000	65	25,5	4,5°	75,5	19	25	M8x1
MPC11C-HSK-E40-A=130	61341331305	---	16	35.000	65	30,5	4,5°	108	19	25	M8x1
MPC11C-HSK-E40-A=160	61341331605	---	16	27.000	65	32	4,5°	139	19	25	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-HSK-E40-A=55	**61343330555**	**61343330556**	22	42.000	32	23,5	4,5°	31,5	---	---	---
MPC16C-HSK-E40-A=100	**61343331005**	**61343331006**	22	40.000	67	26	2,5°	78	32	25	M11x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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DPC DYNAMIC PERFORMANCE CHUCKS

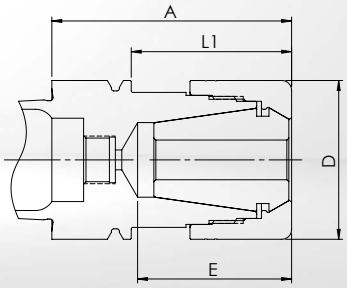
DIN 69893-5

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-E40-A=60	**63345300605**	**63345300606**	40	38,5	40	---	---	---

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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FAHRION® FAR BEYOND PRECISION

MPC MINI PRECISION CHUCKS

DIN 69893-5

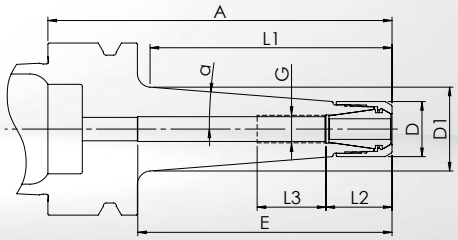
FORM AD - CENTRAL COOLANT SUPPLY

HSK-E50
MPC

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-HSK-E50-A=60	61351330605	---	16	30.000	37	18	4,5°	30	18,5	12	M8x1
MPC11C-HSK-E50-A=100	61351331005	---	16	30.000	73	24,5	4,5°	70	19	20	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-HSK-E50-A=60	61353330605	61353330606	22	30.000	32	23,5	4,5°	30	---	---	---
MPC16C-HSK-E50-A=100	**61353331005**	**61353331006**	22	30.000	73	26	2,5°	68,5	32	25	M11x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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HSK-E50
DPC

DPC DYNAMIC PERFORMANCE CHUCKS

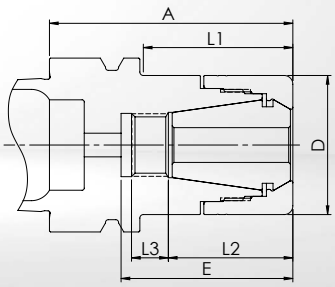
DIN 69893-5

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-E50-A=70	**63355300705**	**63355300706**	40	49	43	35	10	M11x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Coolant Supply Tubes and Wrenches
					
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69893-6

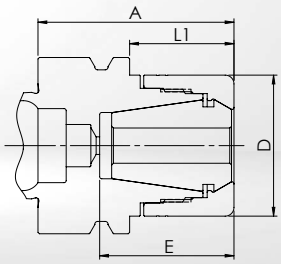
FORM AD - CENTRAL COOLANT SUPPLY

HSK-F50
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-F50-A=55	**63455300555**	**63455300556**	40	38	29	---	---	---

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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HSK-F63
DPC

DPC DYNAMIC PERFORMANCE CHUCKS

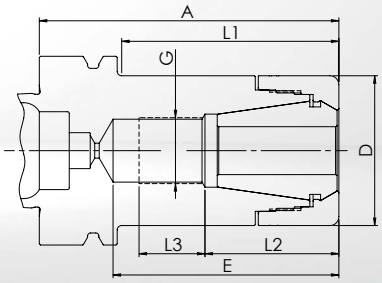
DIN 69893-6

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-HSK-F63-A=100	**63463301005**	**63463301006**	30	77	64	32	25	M11x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-HSK-F63-A=100	63465301005	63465301006	40	73	68	42	23	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-HSK-F63-A=65	**63466300655**	**63466300656**	50	45	38	---	---	---
DPC32-HSK-F63-A=100	63466301005	63466301006	50	75	72	44	22	M22x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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FAHRION® FAR BEYOND PRECISION

FPC FULL PERFORMANCE CHUCKS

DIN 69893-6

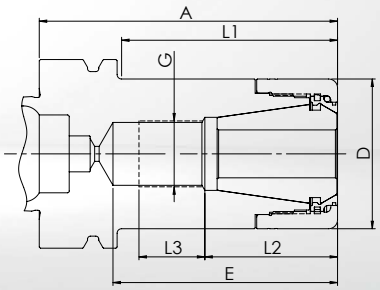
FORM AD - CENTRAL COOLANT SUPPLY

HSK-F63
FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-HSK-F63-A=65	**63466300659**	50	45	38	---	---	---
FPC32-HSK-F63-A=100	63466301009	50	75	72	44	22	M22x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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SK30
MPC

MPC MINI PRECISION CHUCKS

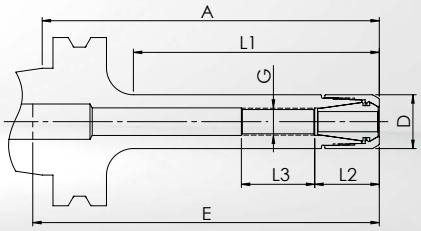
DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11								
MPC11-AD30-A=50	60121340505	16	25.000	60	23	19	17	M8x1
MPC11-AD30-A=100	60121341005	16	25.000	100	73	19	22	M8x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

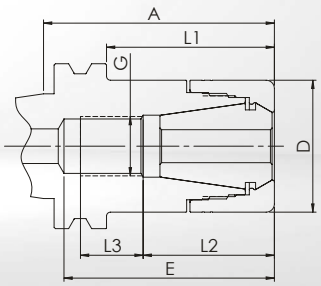
FORM AD - CENTRAL COOLANT SUPPLY

SK30
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-AD30-A=50	62123300505	62123300506	30	65	29	32	25	M11x1
DPC16-AD30-A=100	62123301005	62123301006	30	100	78	32	25	M11x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-AD30-A=70	62125300705	62125300706	40	64	50,5	40	19	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-AD30-A=70	62126300705	62126300706	50	76	51	45	23	M22x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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MPC MINI PRECISION CHUCKS

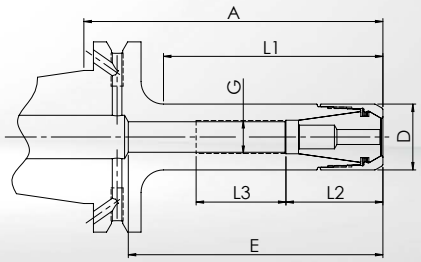
DIN 69871-1 (DIN ISO 7388-1)

FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-B40-A=70	**60241340705**	---	16	25.000	60	41	19	20	M8x1
MPC11-B40-A=100	**60241341005**	---	16	25.000	80	71	19	20	M8x1
MPC11-B40-A=130	60241341305	---	16	25.000	110	101	19	25	M8x1
MPC11-B40-A=160	**60241341605**	---	16	25.000	140	131	19	30	M8x1
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-B40-A=70	**60243340705**	**60243340706**	22	25.000	100	45	32	20	M11x1
MPC16-B40-A=100	**60243341005**	**60243341006**	22	25.000	100	73	32	30	M11x1
MPC16-B40-A=130	**60243341305**	**60243341306**	22	25.000	130	100	32	25	M11x1
MPC16-B40-A=160	**60243341605**	**60243341606**	22	25.000	140	130	32	30	M11x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

MPC MINI PRECISION CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

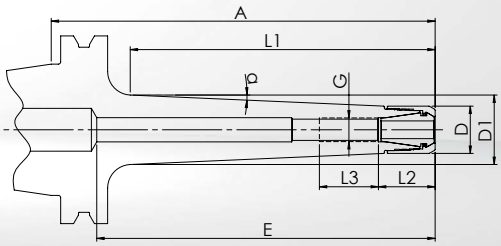
FORM AD - CENTRAL COOLANT SUPPLY

SK40
MPC

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-AD40-A=100	60141331005	---	16	25.000	100	21	2,5°	73	19	35	M8x1
MPC11C-AD40-A=130	60141331305	---	16	25.000	100	23,5	2,5°	103	19	35	M8x1
MPC11C-AD40-A=160	60141331605	---	16	25.000	130	26	2,5°	133	19	35	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-AD40-A=100	60143331005	60143331006	22	25.000	80	27	2,5°	76	32	35	M11x1
MPC16C-AD40-A=130	60143331305	60143331306	22	25.000	110	29	2,5°	106	32	35	M11x1
MPC16C-AD40-A=160	60143331605	60143331606	22	25.000	130	32	2,5°	136	32	35	M11x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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MPC MINI PRECISION CHUCKS

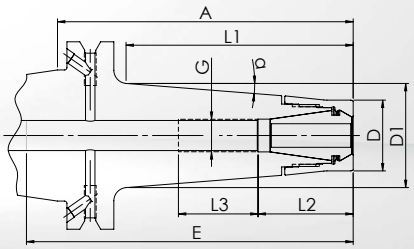
DIN 69871-1 (DIN ISO 7388-1)

FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

Slim precision chuck for difficult cutting tasks and milling operations
Tapered design with tapered clamping nut for more stability and clamping force

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16T-B40-A=100	**60243321005**	**60243321006**	24	25.000	100	35	4,5°	77	32	25	M11x1
MPC16T-B40-A=130	60243321305	60243321306	24	25.000	130	40	4,5°	106	32	25	M11x1
MPC16T-B40-A=160	**60243321605**	**60243321606**	24	25.000	140	37	2,5°	137	32	25	M11x1

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

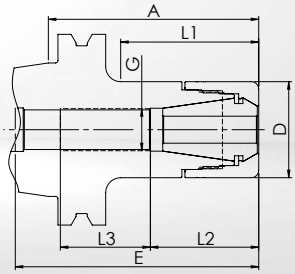
FORM AD - CENTRAL COOLANT SUPPLY

SK40
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-AD40-A=70	**62143300705**	**62143300706**	30	100	43,5	32	25	M11x1
DPC16-AD40-A=100	**62143301005**	**62143301006**	30	130	73,5	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-AD40-A=70	62144300705	62144300706	32	85	46	36	46	M14x1
DPC20-AD40-A=100	62144301005	62144301006	32	85	75	36	46	M14x1
DPC20-AD40-A=130	62144301305	62144301306	32	150	105	36	25	M14x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-AD40-A=70	**62145300705**	**62145300706**	40	110	48,5	45	30	M18x1,5
DPC25-AD40-A=100	**62145301005**	**62145301006**	40	130	79	45	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-AD40-A=50	**62146300505**	**62146300506**	50	84	31	48	29	M22x1,5
DPC32-AD40-A=70	**62146300705**	**62146300706**	50	99	51	48	40	M22x1,5
DPC32-AD40-A=100	**62146301005**	**62146301006**	50	114	81	45	50	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-AD40-A=70*	**62147300705**	---	63	83	50	56	22	M28x1,5
DPC40-AD40-A=100*	62147301005	---	63	83	81	56	20	M28x1,5

* Without clearance to DIN 69871 in front of the tool change flange.
For other DPC chucks with SK40 in AD/B, see following page.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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DPC DYNAMIC PERFORMANCE CHUCKS

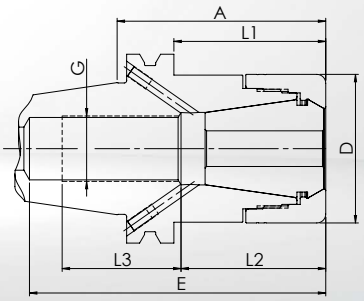
DIN 69871-1 (DIN ISO 7388-1)

FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-B40-A=70	**62243300705**	**62243300706**	30	100	43,5	32	25	M11x1
DPC16-B40-A=100	**62243301005**	**62243301006**	30	130	73,5	32	25	M11x1
DPC16-B40-A=130	62243301305	62243301306	30	160	103,5	32	25	M11x1
DPC16-B40-A=160	62243301605	62243301606	30	180	133,5	32	25	M11x1
DPC16-B40-A=200	62243302005	62243302006	30	220	173	32	25	M11x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-B40-A=45	**62245300455**	**62245300456**	40	80	26	43	25	M18x1,5
DPC25-B40-A=70	**62245300705**	**62245300706**	40	110	48,5	45	30	M18x1,5
DPC25-B40-A=100	**62245301005**	**62245301006**	40	130	79	45	35	M18x1,5
DPC25-B40-A=130	**62245301305**	**62245301306**	40	135	109	43	35	M18x1,5
DPC25-B40-A=160	62245301605	62245301606	40	118	139	43	35	M18x1,5
DPC25-B40-A=200	62245302005	62245302006	40	164	178	43	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-B40-A=50	**62246300505**	**62246300506**	50	84	31	48	29	M22x1,5
DPC32-B40-A=70	**62246300705**	**62246300706**	50	99	51	48	40	M22x1,5
DPC32-B40-A=100	**62246301005**	**62246301006**	50	114	81	45	50	M22x1,5
DPC32-B40-A=130	62246301305	62246301306	50	114	111	45	39	M22x1,5
DPC32-B40-A=160	62246301605	62246301606	50	149	141	45	47	M22x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

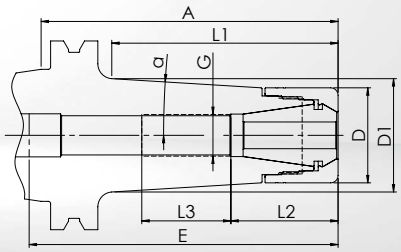
FORM AD - CENTRAL COOLANT SUPPLY

SK40
DPC

Stable precision chuck for demanding tasks, especially in HDC milling
Tapered design for better damping and higher stability

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16										
DPC16C-AD40-A=70	**62143310705**	**62143310706**	30	80	34	4,5°	48	32	25	M11x1
DPC16C-AD40-A=100	**62143311005**	**62143311006**	30	110	37	3,5°	78	32	25	M11x1
DPC16C-AD40-A=130	62143311305	62143311306	30	130	37	2,5°	108	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20										
DPC20C-AD40-A=70	**62144310705**	**62144310706**	32	100	35,5	4,5°	46	32	25	M14x1
DPC20C-AD40-A=100	**62144311005**	**62144311006**	32	120	38	3,5°	76	32	25	M14x1
DPC20C-AD40-A=130	62144311305	62144311306	32	140	39	2,5°	106	32	25	M14x1
Clamping range Ø 1-16 mm - Collets GERC25										
DPC25C-AD40-A=70	**62145310705**	**62145310706**	40	103	43	4,5°	48	44	30	M18x1,5
DPC25C-AD40-A=100	**62145311005**	**62145311006**	40	109	46	3,5°	80	43	35	M18x1,5
DPC25C-AD40-A=130	62145311305	62145311306	40	128	47	2,5°	109	43	35	M18x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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UPC ULTRA POWER CHUCKS

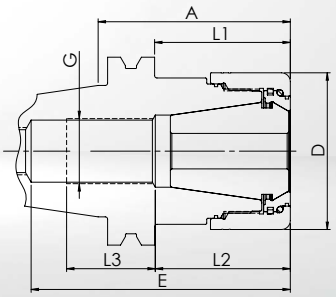
DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Cylindrical design with a multi-part clamping nut for optimised damping and maximum stability

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
UPC32-AD40-A=65	**66146300655**	53	87	45	45	30	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
UPC40-AD40-A=70	**66147300705**	63	83	50	56	27	M28x1,5

Note about UPC40: For longer A dimensions A=100, see FPC page 77.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

FPC FULL PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

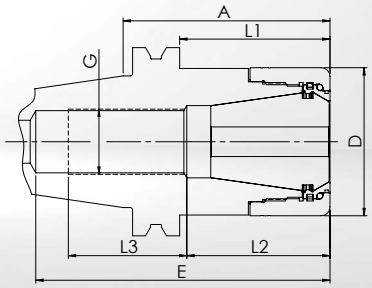
FORM AD - CENTRAL COOLANT SUPPLY

SK40
FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-AD40-A=50	**62146300509**	50	84	31	48	29	M22x1,5
FPC32-AD40-A=70	**62146300709**	50	99	51	48	40	M22x1,5
FPC32-AD40-A=100	**62146301009**	50	114	81	45	50	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-AD40-A=100*	62147301009	63	83	81	56	20	M28x1,5

* Without clearance to DIN 69871 in front of the tool change flange.
For other FPC chucks with SK40 in AD/B, see following page.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FPC FULL PERFORMANCE CHUCKS

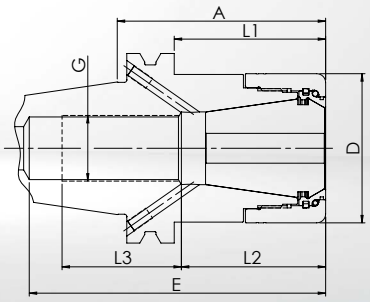
DIN 69871-1 (DIN ISO 7388-1)

FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-B40-A=50	**62246300509**	50	84	31	48	29	M22x1,5
FPC32-B40-A=70	**62246300709**	50	99	51	48	40	M22x1,5
FPC32-B40-A=100	**62246301009**	50	114	81	45	50	M22x1,5
FPC32-B40-A=130	62246301309	50	114	111	45	39	M22x1,5
FPC32-B40-A=160	62246301609	50	149	141	45	47	M22x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

AFC ADJUSTABLE FINISHING CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

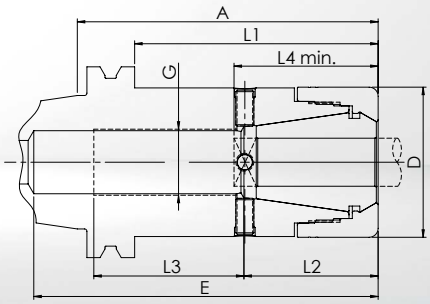
FORM AD - CENTRAL COOLANT SUPPLY

SK40
AFC

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-AD40-A=100	62145305235	40	130	79	45	35	M18x1,5
11-13	10,1-13,5	43	AFC25-AD40-A=100	62145305245	40	130	79	45	35	M18x1,5
14-16	13,51-16	43	AFC25-AD40-A=100	62145305265	40	130	79	45	35	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-AD40-A=100	62146305245	50	114	81	45	50	M22x1,5
14-20	13,51-20	47	AFC32-AD40-A=100	62146305265	50	114	81	45	50	M22x1,5
Collets GERC40										
7-15	7-15,5	55	AFC40-AD40-A=100*	62147305245	63	83	81	56	20	M28x1,5
16-26	15,51-26	55	AFC40-AD40-A=100*	62147305265	63	83	81	56	20	M28x1,5

* Without clearance to DIN 69871 in front of the tool change flange.
Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø.
Other versions and clamping Ø can be offered after technical examination.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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DPC DYNAMIC PERFORMANCE CHUCKS

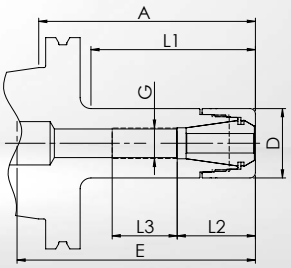
DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-AD50-A=70	62163300705	62163300706	30	110	39	32	23	M11x1
DPC16-AD50-A=100	62163301005	62163301006	30	140	69	32	30	M11x1
DPC16-AD50-A=160	62163301605	62163301606	30	200	129	32	30	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-AD50-A=100	62164301005	62164301006	32	130	76	36	46	M14x1
DPC20-AD50-A=160	62164301605	62164301606	32	160	106	36	46	M14x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-AD50-A=70	62165300705	62165300706	40	120	38	40	50	M18x1,5
DPC25-AD50-A=100	62165301005	62165301006	40	140	68	43	40	M18x1,5
DPC25-AD50-A=160	62165301605	62165301606	40	200	128	40	40	M18x1,5

For other DPC chucks with SK50 in AD/B, see following page.

Suitable Accessories

Collets

Page 138ff

Clamping Nuts

Page 162ff

Wrenches

Page 160

Mounting Devices

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Adjustable Stop Screws

Page 165

Pull Studs

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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

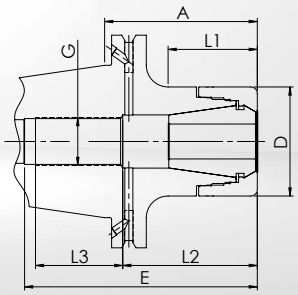
FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

SK50
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-B50-A=70	**62266300705**	**62266300706**	50	108	40	62	34	M22x1,5
DPC32-B50-A=100	**62266301005**	**62266301006**	50	120	70	45	40	M22x1,5
DPC32-B50-A=130	62266301305	62266301306	50	150	101	45	40	M22x1,5
DPC32-B50-A=160	62266301605	62266301606	50	150	130	47	40	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-B50-A=70	62267300705	---	63	90	46	56	30	M28x1,5
DPC40-B50-A=100	62267301005	---	63	90	76	56	30	M28x1,5
DPC40-B50-A=130	62267301305	---	63	90	106	56	30	M28x1,5
DPC40-B50-A=160	62267301605	---	63	90	136	56	40	M28x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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SK50
UPC

UPC ULTRA POWER CHUCKS

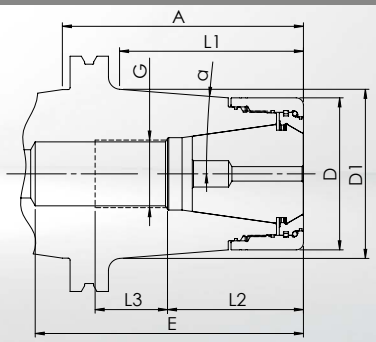
DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Tapered design with a multi-part clamping nut for optimised damping and maximum stability

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

SK

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32									
UPC32C-AD50-A=70	**66166310705**	53	91	59,5	10°	46,5	45,5	35	M22x1,5
UPC32C-AD50-A=100	66166311005	53	121	70,5	10°	77	45,5	38	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40									
UPC40C-AD50-A=70	**66167310705**	63	93	68	10°	46,5	56	30	M28x1,5
UPC40C-AD50-A=100	66167311005	63	140	70	4,5°	76,5	56	30	M28x1,5

Note about UPC40: For longer A dimensions in cylindrical form A=130 and A=160, see FPC page 83.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

FPC FULL PERFORMANCE CHUCKS

DIN 69871-1 (DIN ISO 7388-1)

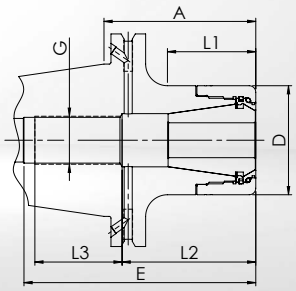
FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

SK50
FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-B50-A=70	**62266300709**	50	108	40	62	34	M22x1,5
FPC32-B50-A=100	**62266301009**	50	120	70	45	40	M22x1,5
FPC32-B50-A=130	62266301309	50	150	101	45	40	M22x1,5
FPC32-B50-A=160	62266301609	50	150	130	47	40	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-B50-A=70	62267300709	63	90	46	56	30	M28x1,5
FPC40-B50-A=100	62267301009	63	90	76	56	30	M28x1,5
FPC40-B50-A=130	62267301309	63	90	106	56	30	M28x1,5
FPC40-B50-A=160	62267301609	63	90	136	56	40	M28x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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AFC ADJUSTABLE FINISHING CHUCKS

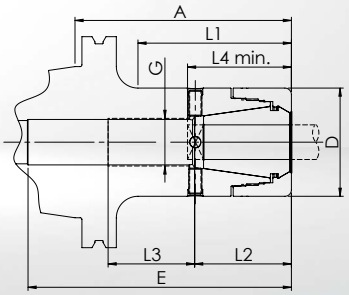
DIN 69871-1 (DIN ISO 7388-1)

FORM AD - CENTRAL COOLANT SUPPLY

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-AD50-A=100	62165305235	40	130	68	43	40	M18x1,5
11-13	10,1-13,5	43	AFC25-AD50-A=100	62165305245	40	130	68	43	40	M18x1,5
14-16	13,51-16	43	AFC25-AD50-A=100	62165305265	40	130	68	43	40	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-AD50-A=100	62166305245	50	114	70	45	40	M22x1,5
14-20	13,51-20	47	AFC32-AD50-A=100	62166305265	50	114	70	45	40	M22x1,5
Collets GERC40										
7-15	7-15,5	55	AFC40-AD50-A=100	62167305245	63	90	76	56	30	M28x1,5
16-26	15,51-26	55	AFC40-AD50-A=100	62167305265	63	90	76	56	30	M28x1,5

Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø.
Other versions and clamping Ø can be offered after technical examination.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2)

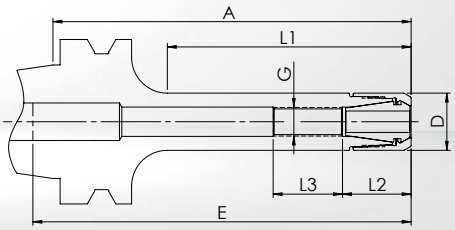
FORM AD - CENTRAL COOLANT SUPPLY

BT30
MPC

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-5 mm - Collets GERC8								
MPC8-BT30-A=75	60420340755	10	25.000	80	43	17	15	M5x0,8
Clamping range Ø 1-7 mm - Collets GERC11								
MPC11-BT30-A=50	**60421340505**	16	25.000	70	18	19	20	M8x1
MPC11-BT30-A=100	**60421341005**	16	25.000	120	68	19	20	M8x1

BT

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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BT30
MPC

MPC MINI PRECISION CHUCKS

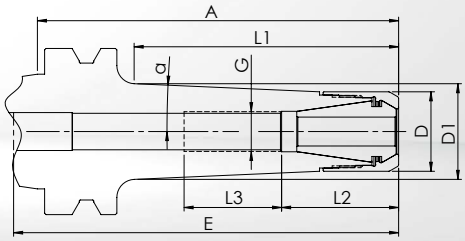
JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-BT30-A=100	60421331005	---	16	25.000	110	32	2,5°	73	19	40	M8x1
MPC11C-BT30-A=130	60421331305	---	16	25.000	140	32,5	5,5°	102,5	19	20	M8x1
MPC11C-BT30-A=160	60421331605	---	16	25.000	170	34,5	4,5°	133,5	19	20	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-BT30-A=100	60423331005	60423331006	22	25.000	100	30	2,5°	73	32	40	M11x1

BT

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2)

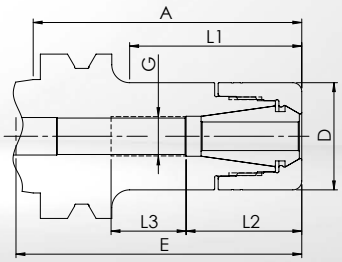
FORM AD - CENTRAL COOLANT SUPPLY

BT30
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-BT30-A=50	**62423300505**	**62423300506**	30	70	24	32	25	M11x1
DPC16-BT30-A=60	62423300605	62423300606	30	80	33	32	21	M11x1
DPC16-BT30-A=75	**62423300755**	**62423300756**	30	95	48	32	21	M11x1
DPC16-BT30-A=90	**62423300905**	**62423300906**	30	110	63	32	21	M11x1
DPC16-BT30-A=105	62423301055	62423301056	30	120	77	32	25	M11x1
DPC16-BT30-A=120	62423301205	62423301206	30	95	93	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-BT30-A=60	62424300605	62424300606	32	65	35	36	22	M14x1
DPC20-BT30-A=75	**62424300755**	**62424300756**	32	65	50	36	22	M14x1
DPC20-BT30-A=90	62424300905	62424300906	32	80	65	36	22	M14x1
DPC20-BT30-A=105	62424301055	62424301056	32	95	80	36	22	M14x1
DPC20-BT30-A=120	62424301205	62424301206	32	96	95	36	22	M14x1

For other DPC chucks with BT30, see following page.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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DPC DYNAMIC PERFORMANCE CHUCKS

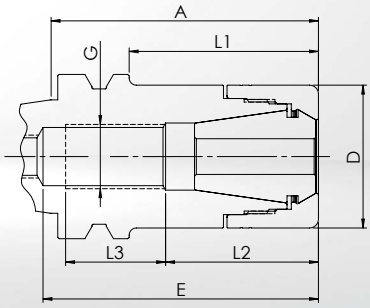
JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-BT30-A=60	**62425300605**	**62425300606**	40	77	36	42	24	M18x1,5
DPC25-BT30-A=75	**62425300755**	**62425300756**	40	77	51	42	28	M18x1,5
DPC25-BT30-A=90	62425300905	62425300906	40	87	66	42	35	M18x1,5
DPC25-BT30-A=105	62425301055	62425301056	40	92	81	42	44	M18x1,5
DPC25-BT30-A=120	62425301205	62425301206	40	112	96	42	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-BT30-A=60	**62426300605**	**62426300606**	50	63	38	46	20	M22x1,5
DPC32-BT30-A=75	**62426300755**	**62426300756**	50	80	53	46	23	M22x1,5
DPC32-BT30-A=90	62426300905	62426300906	50	90	68	46	30	M22x1,5
DPC32-BT30-A=105	62426301055	62426301056	50	90	78	46	28	M22x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2)

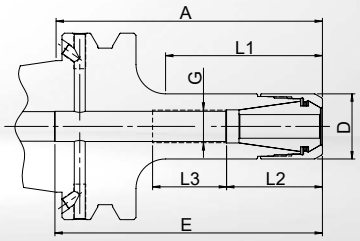
FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

BT40
MPC

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-BTB40-A=75	**60541340755**	---	16	25.000	105	38	19	20	M8x1
MPC11-BTB40-A=100	**60541341005**	---	16	25.000	130	63	19	30	M8x1
MPC11-BTB40-A=120	**60541341205**	---	16	25.000	150	83	19	20	M8x1
MPC11-BTB40-A=160	60541341605	---	16	25.000	180	123	19	28	M8x1
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-BTB40-A=75	60543340755	60543340756	22	25.000	110	38	32	25	M11x1
MPC16-BTB40-A=90	**60543340905**	**60543340906**	22	25.000	120	53	32	25	M11x1
MPC16-BTB40-A=120	**60543341205**	**60543341206**	22	25.000	105	83	32	25	M11x1
MPC16-BTB40-A=150	60543341505	60543341506	22	25.000	170	113	32	25	M11x1

BT

Suitable Accessories

Collets

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Clamping Nuts

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Wrenches

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Mounting Devices

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Adjustable Stop Screws

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Pull Studs

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BT40
MPC

MPC MINI PRECISION CHUCKS

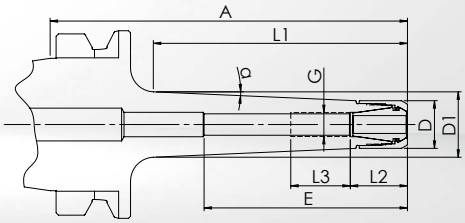
JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-BT40-A=100	60441331005	---	16	25.000	130	20	2,5°	63	19	30	M8x1
MPC11C-BT40-A=120	60441331205	---	16	25.000	150	22	2,5°	85	19	30	M8x1
MPC11C-BT40-A=160	60441331605	---	16	25.000	170	26	2,5°	125	19	30	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-BT40-A=100	60443331005	60443331006	22	25.000	130	26	2,5°	68	32	35	M11x1
MPC16C-BT40-A=120	60443331205	60443331206	22	25.000	150	28	2,5°	88	32	35	M11x1
MPC16C-BT40-A=160	60443331605	60443331606	22	25.000	180	31,5	2,5°	128	32	35	M11x1

BT

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2)

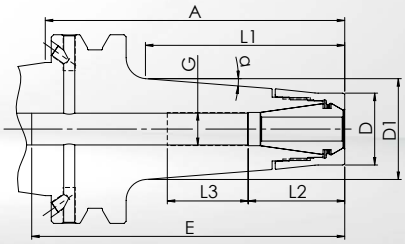
FORM AD/B - COOLANT SUPPLY CENTRAL / VIA THE COLLAR (= B)

BT40
MPC

Slim precision chuck for difficult cutting tasks and milling operations
Tapered design with tapered clamping nut for more stability and clamping force

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16T-BTB40-A=100	**60543321005**	**60543321006**	24	25.000	130	34	4,5°	68	32	27	M11x1
MPC16T-BTB40-A=135	60543321355	60543321356	24	25.000	165	39	4,5°	103	32	27	M11x1
MPC16T-BTB40-A=160	60543321605	60543321606	24	25.000	180	44	4,5°	128	32	27	M11x1

BT

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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BT40
DPC

DPC DYNAMIC PERFORMANCE CHUCKS

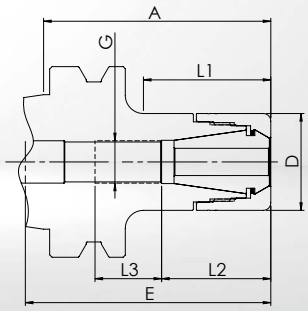
JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-BT40-A=75	**62443300755**	**62443300756**	30	100	38	32	25	M11x1
DPC16-BT40-A=90	**62443300905**	**62443300906**	30	120	53	32	25	M11x1
DPC16-BT40-A=105	**62443301055**	**62443301056**	30	130	68	32	30	M11x1
DPC16-BT40-A=120	**62443301205**	**62443301206**	30	150	83	32	30	M11x1
DPC16-BT40-A=150	62443301505	62443301506	30	180	113	32	30	M11x1
DPC16-BT40-A=165	62443301655	62443301656	30	190	127	32	30	M11x1
DPC16-BT40-A=200	62443302005	62443302006	30	220	162	32	30	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-BT40-A=75	62444300755	62444300756	32	95	42	36	20	M14x1
DPC20-BT40-A=90	62444300905	62444300906	32	110	57	36	22	M14x1
DPC20-BT40-A=105	62444301055	62444301056	32	125	72	36	22	M14x1
DPC20-BT40-A=120	62444301205	62444301206	32	135	87	36	22	M14x1
DPC20-BT40-A=150	62444301505	62444301506	32	165	117	36	46	M14x1
DPC20-BT40-A=165	62444301655	62444301656	32	180	132	36	22	M14x1

For other DPC chucks with BT40, see following page.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2)

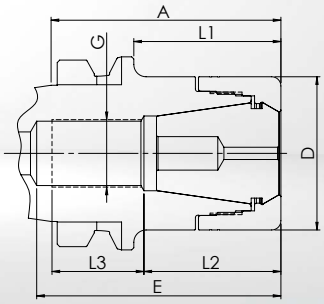
FORM AD - CENTRAL COOLANT SUPPLY

BT40
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-BT40-A=60	**62445300605**	**62445300606**	40	82	28	42	35	M18x1,5
DPC25-BT40-A=75	**62445300755**	**62445300756**	40	90	43	42	35	M18x1,5
DPC25-BT40-A=90	**62445300905**	**62445300906**	40	95	58	42	35	M18x1,5
DPC25-BT40-A=105	**62445301055**	**62445301056**	40	95	73	42	35	M18x1,5
DPC25-BT40-A=120	**62445301205**	**62445301206**	40	100	88	42	35	M18x1,5
DPC25-BT40-A=150	62445301505	62445301506	40	125	118	42	35	M18x1,5
DPC25-BT40-A=165	62445301655	62445301656	40	190	133	42	35	M18x1,5
DPC25-BT40-A=200	62445302005	62445302006	40	220	168	42	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-BT40-A=60	**62446300605**	**62446300606**	50	80	29	45	30	M22x1,5
DPC32-BT40-A=75	**62446300755**	**62446300756**	50	98	44	45	45	M22x1,5
DPC32-BT40-A=90	**62446300905**	**62446300906**	50	98	59	45	45	M22x1,5
DPC32-BT40-A=105	**62446301055**	**62446301056**	50	125	74	45	45	M22x1,5
DPC32-BT40-A=120	**62446301205**	**62446301206**	50	110	89	45	45	M22x1,5
DPC32-BT40-A=150	62446301505	62446301506	50	140	119	45	45	M22x1,5
DPC32-BT40-A=165	62446301655	62446301656	50	150	134	45	45	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-BT40-A=75	62447300755	---	63	85	48	56	21	M28x1,5
DPC40-BT40-A=105	62447301055	---	63	90	78	56	30	M28x1,5

Suitable Accessories


Collets
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Clamping Nuts
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Wrenches
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Mounting Devices
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Adjustable Stop Screws
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Pull Studs
Page 167ff

BT40
DPC

DPC DYNAMIC PERFORMANCE CHUCKS

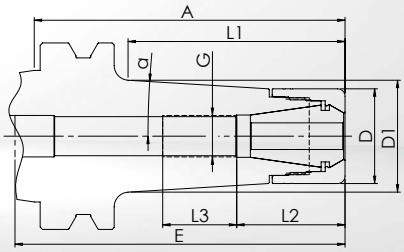
JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Stable precision chuck for demanding tasks, especially in HDC milling
Tapered design for better damping and higher stability

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16										
DPC16C-BT40-A=75	**62443310755**	**62443310756**	30	80	31,5	4,5°	33,5	32	25	M11x1
DPC16C-BT40-A=105	**62443311055**	**62443311056**	30	110	34,5	3,5°	63,5	32	25	M11x1
DPC16C-BT40-A=135	62443311355	62443311356	30	130	36	2,5°	93	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20										
DPC20C-BT40-A=75	**62444310755**	**62444310756**	32	80	34	4,5°	38	36	25	M14x1
DPC20C-BT40-A=105	**62444311055**	**62444311056**	32	110	37	3,5°	68	36	25	M14x1
DPC20C-BT40-A=135	62444311355	62444311356	32	140	38,5	2,5°	98	36	25	M14x1
Clamping range Ø 1-16 mm - Collets GERC25										
DPC25C-BT40-A=75	**62445310755**	**62445310756**	40	90	41,5	4,5°	38	43	35	M18x1,5
DPC25C-BT40-A=105	**62445311055**	**62445311056**	40	100	45	3,5°	68	43	35	M18x1,5
DPC25C-BT40-A=135	62445311355	62445311356	40	124	46	2,5°	98	43	35	M18x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

UPC ULTRA POWER CHUCKS

JIS B 6339 (DIN ISO 7388-2)

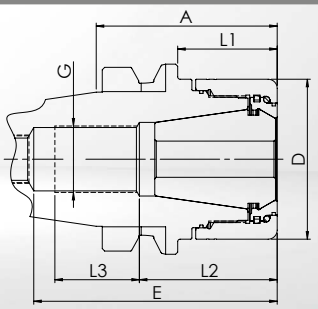
FORM AD - CENTRAL COOLANT SUPPLY

BT40
UPC

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Cylindrical design with a multi-part clamping nut for optimised damping and maximum stability

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
UPC32-BT40-A=60	**66446300605**	53	80	32	45	28	M22x1,5
UPC32-BT40-A=90	66446300905	53	85	63	45	28	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
UPC40-BT40-A=60	**66447300605**	63	84	47	56	21	M28x1,5
UPC40-BT40-A=90	66447300905	63	87	62	56	23	M28x1,5

Note about UPC40: For longer A dimensions A=75 and A=105, see FPC page 96.

BT

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FPC FULL PERFORMANCE CHUCKS

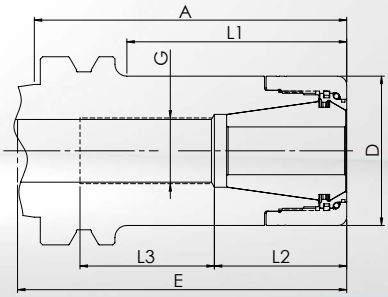
JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-BT40-A=60	**62446300609**	50	80	29	45	30	M22x1,5
FPC32-BT40-A=75	**62446300759**	50	98	44	45	45	M22x1,5
FPC32-BT40-A=90	**62446300909**	50	98	59	45	45	M22x1,5
FPC32-BT40-A=105	**62446301059**	50	125	74	45	45	M22x1,5
FPC32-BT40-A=120	**62446301209**	50	110	89	45	45	M22x1,5
FPC32-BT40-A=150	62446301509	50	140	119	45	45	M22x1,5
FPC32-BT40-A=165	62446301659	50	150	134	45	45	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-BT40-A=75	62447300759	63	85	48	56	21	M28x1,5
FPC40-BT40-A=105	62447301059	63	90	78	56	30	M28x1,5

Suitable Accessories

Collets

Page 150ff

Clamping Nuts

Page 164

Wrenches

Page 160

Mounting Devices

Page 161

Adjustable Stop Screws

Page 165

Pull Studs

Page 167ff

FAHRION® FAR BEYOND PRECISION

AFC ADJUSTABLE FINISHING CHUCKS

JIS B 6339 (DIN ISO 7388-2)

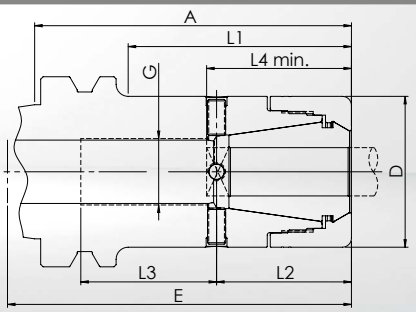
FORM AD - CENTRAL COOLANT SUPPLY

BT40
AFC

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-BT40-A=105	62445305235	40	95	73	42	35	M18x1,5
11-13	10,1-13,5	43	AFC25-BT40-A=105	62445305245	40	95	73	42	35	M18x1,5
14-16	13,51-16	43	AFC25-BT40-A=105	62445305265	40	95	73	42	35	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-BT40-A=105	62446305245	50	91	78	56	30	M22x1,5
14-20	13,51-20	47	AFC32-BT40-A=105	62446305265	50	91	78	56	30	M22x1,5
Collets GERC40										
7-15	7-15,5	55	AFC40-BT40-A=105	62447305245	63	90	78	56	30	M28x1,5
16-26	15,51-26	55	AFC40-BT40-A=105	62447305265	63	90	78	56	30	M28x1,5

Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø.
Other versions and clamping Ø can be offered after technical examination.

BT

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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BT50
DPC

DPC DYNAMIC PERFORMANCE CHUCKS

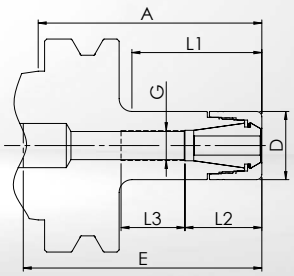
JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-BT50-A=105	62463301055	62463301056	30	150	55	31	24	M11x1
DPC16-BT50-A=135	62463301355	62463301356	30	180	85	31	24	M11x1
DPC16-BT50-A=165	62463301655	62463301656	30	200	115	31	41	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-BT50-A=105	62464301055	62464301056	32	140	61	36	46	M14x1
DPC20-BT50-A=135	62464301355	62464301356	32	170	91	36	46	M14x1
DPC20-BT50-A=165	62464301655	62464301656	32	200	121	36	46	M14x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-BT50-A=105	62465301055	62465301056	40	150	59	42	36	M18x1,5
DPC25-BT50-A=135	62465301355	62465301356	40	180	89	42	36	M18x1,5
DPC25-BT50-A=165	62465301655	62465301656	40	210	122	42	36	M18x1,5

For other DPC chucks with BT50, see following page.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2)

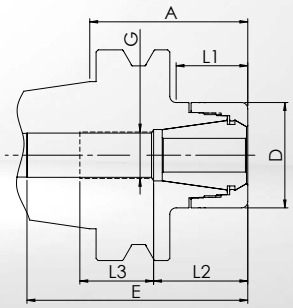
FORM AD - CENTRAL COOLANT SUPPLY

BT50
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-BT50-A=75	62466300755	62466300756	50	120	34	45	35	M22x1,5
DPC32-BT50-A=105	62466301055	62466301056	50	150	64	45	35	M22x1,5
DPC32-BT50-A=135	62466301355	62466301356	50	180	94	45	35	M22x1,5
DPC32-BT50-A=165	62466301655	62466301656	50	210	124	45	40	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-BT50-A=75	62467300755	---	63	90	32	56	30	M28x1,5
DPC40-BT50-A=105	62467301055	---	63	90	62	56	30	M28x1,5
DPC40-BT50-A=135	62467301355	---	63	90	93	56	35	M28x1,5
DPC40-BT50-A=165	62467301655	---	63	90	123	56	35	M28x1,5

BT

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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BT50
UPC

UPC ULTRA POWER CHUCKS

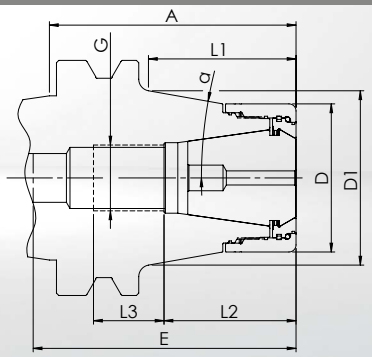
JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Tapered design with a multi-part clamping nut for optimised damping and maximum stability

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32									
UPC32C-BT50-A=75	**66466310755**	53	114	55	10°	33	45	45	M22x1,5
UPC32C-BT50-A=105	66466311055	53	140	65	10°	62	45	45	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40									
UPC40C-BT50-A=75	**66467310755**	63	95	64	10°	32,5	56	30	M28x1,5
UPC40C-BT50-A=105	66467311055	63	95	74,5	10°	62	56	30	M28x1,5

Note about UPC40: For longer A dimensions in cylindrical form A=130 and A=160, see FPC page 101.

BT

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

FPC FULL PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2)

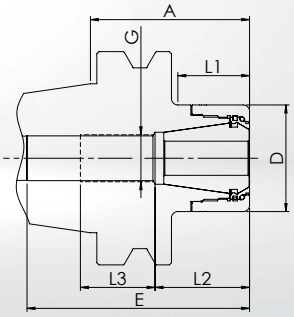
FORM AD - CENTRAL COOLANT SUPPLY

BT50
FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-BT50-A=75	62466300759	50	120	34	45	35	M22x1,5
FPC32-BT50-A=105	62466301059	50	150	64	45	35	M22x1,5
FPC32-BT50-A=135	62466301359	50	180	94	45	35	M22x1,5
FPC32-BT50-A=165	62466301659	50	210	124	45	40	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-BT50-A=75	62467300759	63	90	32	56	30	M28x1,5
FPC40-BT50-A=105	62467301059	63	90	62	56	30	M28x1,5
FPC40-BT50-A=135	62467301359	63	90	93	56	35	M28x1,5
FPC40-BT50-A=165	62467301659	63	90	123	56	35	M28x1,5

BT

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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AFC ADJUSTABLE FINISHING CHUCKS

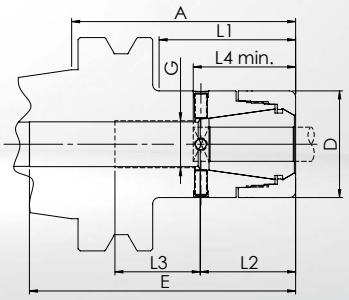
JIS B 6339 (DIN ISO 7388-2)

FORM AD - CENTRAL COOLANT SUPPLY

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-BT50-A=105	62465305235	40	150	59	42	36	M18x1,5
11-13	10,1-13,5	43	AFC25-BT50-A=105	62465305245	40	150	59	42	36	M18x1,5
14-16	13,51-16	43	AFC25-BT50-A=105	62465305265	40	150	59	42	36	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-BT50-A=105	62466305245	50	150	64	45	35	M22x1,5
14-20	13,51-20	47	AFC32-BT50-A=105	62466305265	50	150	64	45	35	M22x1,5
Collets GERC40										
7-15	7-15,5	55	AFC40-BT50-A=105	62467305245	63	90	62	56	30	M28x1,5
16-26	15,51-26	55	AFC40-BT50-A=105	62467305265	63	90	62	56	30	M28x1,5

Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø.
Other versions and clamping Ø can be offered after technical examination.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws	Pull Studs
					
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FAHRION® FAR BEYOND PRECISION

MPC MINI PRECISION CHUCKS

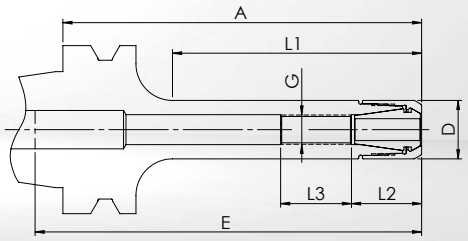
JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

BTP30
MPC

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. MPC clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11								
MPC11-BTP30-A=60	60431340605	16	25.000	70	29	19	20	M8x1
MPC11-BTP30-A=90	60431340905	16	25.000	100	59	19	20	M8x1
MPC11-BTP30-A=105	60431341055	16	25.000	115	74	19	20	M8x1

BTP

Suitable Accessories

Collets



Page 135ff

Clamping Nuts



Page 162

Wrenches



Page 160

Mounting Devices



Page 161

Adjustable Stop Screws



Page 165

BTP30
MPC

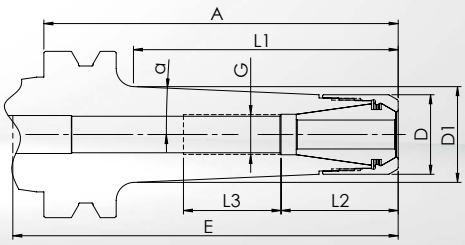
MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-BTP30-A=100	60431331005	---	16	25.000	100	32,5	2,5°	73	19	40	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-BTP30-A=100	60433331005	60433331006	22	25.000	110	30	2,5°	73	32	40	M11x1

BTP

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

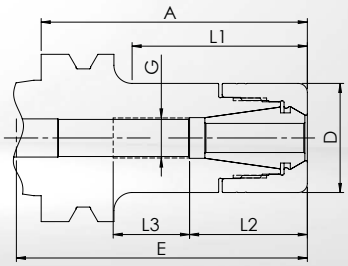
JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

BTP30
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-BTP30-A=60	62433300605	62433300606	30	75	34	32	21	M11x1
DPC16-BTP30-A=75	**62433300755**	**62433300756**	30	90	49	32	21	M11x1
DPC16-BTP30-A=90	62433300905	62433300906	30	105	64	32	21	M11x1
DPC16-BTP30-A=105	62433301055	62433301056	30	120	79	32	21	M11x1
DPC16-BTP30-A=120	62433301205	62433301206	30	130	94	32	21	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-BTP30-A=60	62434300605	62434300606	32	65	36,5	36	22	M14x1
DPC20-BTP30-A=75	62434300755	62434300756	32	65	51,5	36	22	M14x1
DPC20-BTP30-A=90	62434300905	62434300906	32	81	66,5	36	22	M14x1
DPC20-BTP30-A=105	62434301055	62434301056	32	96	81,5	36	22	M14x1
DPC20-BTP30-A=120	62434301205	62434301206	32	111	96,5	36	22	M14x1

For other DPC chucks with BTP30, see following page.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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BTP30
DPC

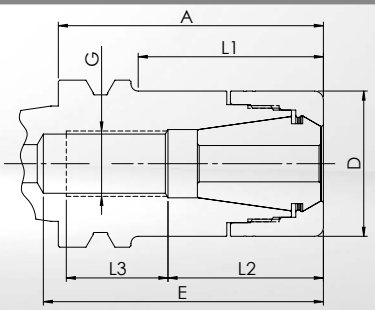
DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-BTP30-A=60	62435300605	62435300606	40	76	37	42	28	M18x1,5
DPC25-BTP30-A=75	**62435300755**	**62435300756**	40	77	52	42	28	M18x1,5
DPC25-BTP30-A=90	62435300905	62435300906	40	88	67	42	28	M18x1,5
DPC25-BTP30-A=105	62435301055	62435301056	40	98	81	42	28	M18x1,5
DPC25-BTP30-A=120	62435301205	62435301206	40	110	97	42	28	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-BTP30-A=60	62436300605	62436300606	50	70	39	46	20	M22x1,5
DPC32-BTP30-A=75	62436300755	62436300756	50	78	54	46	25	M22x1,5
DPC32-BTP30-A=90	62436300905	62436300906	50	90	69	46	32	M22x1,5
DPC32-BTP30-A=105	62436301055	62436301056	50	95	84	46	32	M22x1,5

Suitable Accessories

Collets



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Clamping Nuts



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Wrenches



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Mounting Devices



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Adjustable Stop Screws



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FAHRION® FAR BEYOND PRECISION

MPC MINI PRECISION CHUCKS

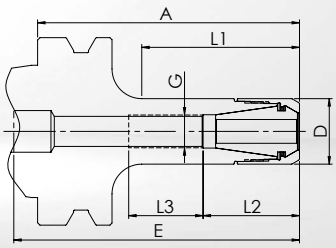
JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

BTP40
MPC

Very slim precision chuck with optimum interference contour, ideal for HSC machining
Cylindrical design for tight spaces





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-BTP40-A=90	60451340905	---	16	25.000	100	54	19	20	M8x1
MPC11-BTP40-A=120	60451341205	---	16	25.000	140	84	19	20	M8x1
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-BTP40-A=90	60453340905	60453340906	22	25.000	110	54	32	25	M11x1
MPC16-BTP40-A=120	60453341205	60453341206	22	25.000	140	84	32	25	M11x1

BTP

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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BTP40
MPC

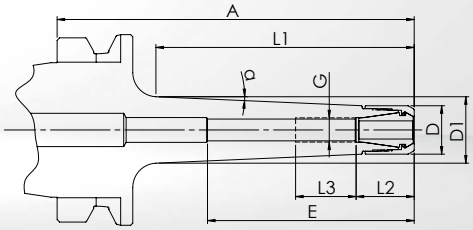
MPC MINI PRECISION CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

Slim precision chuck for difficult machining tasks and HSC machining
Tapered design for more stability





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	max. 1/min	E	D1	α	L1	L2	L3	G
Clamping range Ø 1-7 mm - Collets GERC11											
MPC11C-BTP40-A=100	60451331005	---	16	25.000	110	20	2,5°	65	19	20	M8x1
MPC11C-BTP40-A=120	60451331205	---	16	25.000	140	21,5	2,5°	85	19	20	M8x1
MPC11C-BTP40-A=160	60451331605	---	16	25.000	170	25,5	2,5°	125	19	20	M8x1
Clamping range Ø 1-10 mm - Collets GERC16											
MPC16C-BTP40-A=100	60453331005	60453331006	22	25.000	125	30,5	2,5°	67	32	27	M11x1
MPC16C-BTP40-A=120	60453331205	60453331206	22	25.000	140	32,5	2,5°	87	32	27	M11x1
MPC16C-BTP40-A=160	60453331605	60453331606	22	25.000	170	36	2,5°	127	32	27	M11x1

Suitable Accessories

Collets



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Clamping Nuts



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Wrenches



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Mounting Devices



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Adjustable Stop Screws



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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

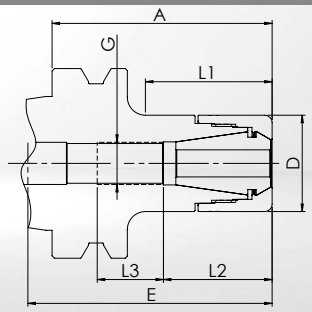
JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

BTP40
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-BTP40-A=75	62453300755	62453300756	30	100	39	32	20	M11x1
DPC16-BTP40-A=90	62453300905	62453300906	30	115	54	32	25	M11x1
DPC16-BTP40-A=105	62453301055	62453301056	30	130	69	32	25	M11x1
DPC16-BTP40-A=120	62453301205	62453301206	30	145	84	32	25	M11x1
DPC16-BTP40-A=150	62453301505	62453301506	30	175	114	32	25	M11x1
DPC16-BTP40-A=165	62453301655	62453301656	30	190	129	32	25	M11x1
DPC16-BTP40-A=200	62453302005	62453302006	30	225	164	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-BTP40-A=75	62454300755	62454300756	32	95	46,5	46	25	M14x1
DPC20-BTP40-A=90	62454300905	62454300906	32	110	61,5	43	25	M14x1
DPC20-BTP40-A=105	62454301055	62454301056	32	125	76,5	43	25	M14x1
DPC20-BTP40-A=120	62454301205	62454301206	32	135	91,5	43	25	M14x1
DPC20-BTP40-A=150	62454301505	62454301506	32	165	121,5	43	25	M14x1
DPC20-BTP40-A=165	62454301655	62454301656	32	180	136,5	43	25	M14x1

For other DPC chucks with BTP40, see following page.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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BTP40
DPC

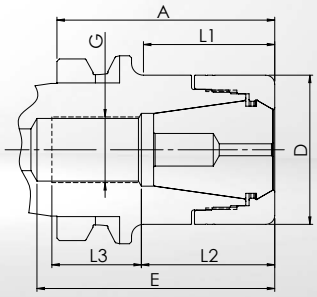
DPC DYNAMIC PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-BTP40-A=60	62455300605	62455300606	40	83	29	43	35	M18x1,5
DPC25-BTP40-A=75	62455300755	62455300756	40	84	44	43	35	M18x1,5
DPC25-BTP40-A=90	**62455300905**	**62455300906**	40	84	59	43	35	M18x1,5
DPC25-BTP40-A=105	62455301055	62455301056	40	98	74	43	35	M18x1,5
DPC25-BTP40-A=120	62455301205	62455301206	40	113	89	43	35	M18x1,5
DPC25-BTP40-A=150	62455301505	62455301506	40	144	119	43	35	M18x1,5
DPC25-BTP40-A=165	62455301655	62455301656	40	158	134	43	35	M18x1,5
DPC25-BTP40-A=200	62455302005	62455302006	40	190	159	43	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-BTP40-A=60	62456300605	62456300606	50	80	30	45	30	M22x1,5
DPC32-BTP40-A=75	**62456300755**	**62456300756**	50	80	45	45	30	M22x1,5
DPC32-BTP40-A=90	62456300905	62456300906	50	95	60	45	40	M22x1,5
DPC32-BTP40-A=105	62456301055	62456301056	50	100	75	45	40	M22x1,5
DPC32-BTP40-A=120	62456301205	62456301206	50	110	89,5	45	40	M22x1,5
DPC32-BTP40-A=150	62456301505	62456301506	50	140	119,5	45	40	M22x1,5
DPC32-BTP40-A=165	62456301655	62456301656	50	140	134,5	45	40	M22x1,5

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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FAHRION® FAR BEYOND PRECISION

UPC ULTRA POWER CHUCKS

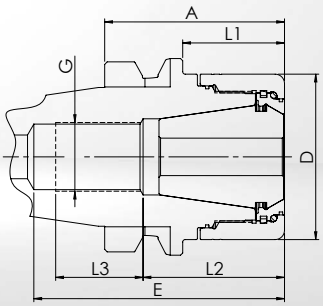
JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

BTP40
UPC

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Cylindrical design with a multi-part clamping nut for optimised damping and maximum stability





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
UPC32-BTP40-A=60	**66456300605**	53	80	33	45	28	M22x1,5
UPC32-BTP40-A=90	64456300905	53	95	63	45	30	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
UPC40-BTP40-A=60	**66457300605**	63	81	31	---	---	---
UPC40-BTP40-A=90	66457300905	63	86	61	56	25	M28x1,5

BTP

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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BTP40
FPC

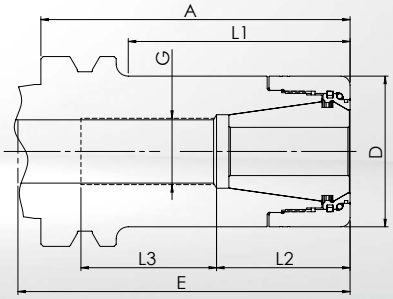
FPC FULL PERFORMANCE CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-BTP40-A=60	62456300609	50	80	30	45	30	M22x1,5
FPC32-BTP40-A=75	**62456300759**	50	80	45	45	30	M22x1,5
FPC32-BTP40-A=90	62456300909	50	95	60	45	40	M22x1,5
FPC32-BTP40-A=105	62456301059	50	100	75	45	40	M22x1,5
FPC32-BTP40-A=120	62456301209	50	110	89,5	45	40	M22x1,5
FPC32-BTP40-A=150	62456301509	50	140	119,5	45	40	M22x1,5
FPC32-BTP40-A=165	62456301659	50	140	134,5	45	40	M22x1,5

BTP

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

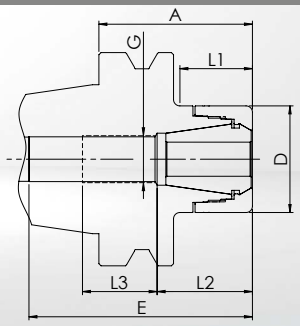
JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

BTP50
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-BTP50-A=105	62473301055	62473301056	30	150	56,5	31	22	M11x1
DPC16-BTP50-A=135	62473301355	62473301356	30	180	86,5	31	22	M11x1
DPC16-BTP50-A=165	62473301655	62473301656	30	210	116,5	31	41	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-BTP50-A=105	62474301055	62474301056	32	150	61	36	46	M14x1
DPC20-BTP50-A=135	62474301355	62474301356	32	180	91	36	46	M14x1
DPC20-BTP50-A=165	62474301655	62474301656	32	210	121	36	46	M14x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-BTP50-A=105	62475301055	62475301056	40	150	60,5	43	36	M18x1,5
DPC25-BTP50-A=135	62475301355	62475301356	40	180	90,5	43	36	M18x1,5
DPC25-BTP50-A=165	62475301655	62475301656	40	200	120,5	43	36	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-BTP50-A=75	62476300755	62476300756	50	120	34	45	35	M22x1,5
DPC32-BTP50-A=105	62476301055	62476301056	50	135	65,5	45	35	M22x1,5
DPC32-BTP50-A=135	62476301355	62476301356	50	165	95,5	45	35	M22x1,5
DPC32-BTP50-A=165	62476301655	62476301656	50	195	125,5	45	35	M22x1,5

Suitable Accessories

Collets



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Clamping Nuts



Page 162ff

Wrenches



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Mounting Devices



Page 161

Adjustable Stop Screws



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BTP50
UPC

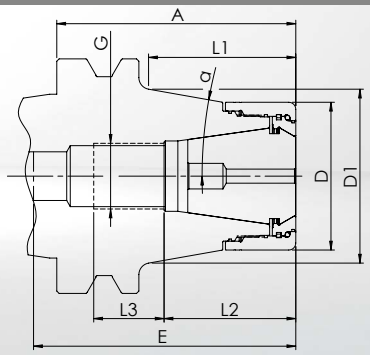
UPC ULTRA POWER CHUCKS

JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Tapered design with a multi-part clamping nut for optimised damping and maximum stability





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	D1	α	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32									
UPC32C-BTP50-A=75	**66476310755**	53	114	55,2	10°	34	46	45	M22x1,5
UPC32C-BTP50-A=105	66476311055	53	144	65,5	10°	64	46	45	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40									
UPC40C-BTP50-A=75	**66477310755**	63	91	64,2	10°	34	55	30	M28x1,5
UPC40C-BTP50-A=105	66477311055	63	101	74,5	10°	64	55	30	M28x1,5

Note about UPC32: For longer A dimensions in cylindrical form A=135 and A=165, see FPC page 115.

BTP

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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FAHRION® FAR BEYOND PRECISION

FPC FULL PERFORMANCE CHUCKS

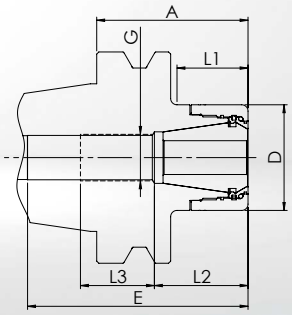
JIS B 6339 (DIN ISO 7388-2) WITH FACE CONTACT

FORM AD - CENTRAL COOLANT SUPPLY

BTP50
FPC

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-BTP50-A=75	62476300759	50	120	34	45	35	M22x1,5
FPC32-BTP50-A=105	62476301059	50	135	65,5	45	35	M22x1,5
FPC32-BTP50-A=135	62476301359	50	165	95,5	45	35	M22x1,5
FPC32-BTP50-A=165	62476301659	50	195	125,5	45	35	M22x1,5

BTP

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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PSC50
DPC

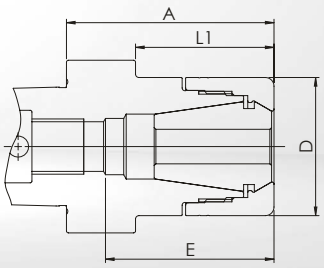
DPC DYNAMIC PERFORMANCE CHUCKS

ISO 26623-1

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-C5-A=60	62853300605	62853300606	30	46	39	32	13	M11x1
DPC16-C5-A=100	62853301005	62853301006	30	86	79	32	30	M11x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-C5-A=60	62855300605	62855300606	40	49	39	---	---	---
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-C5-A=60	62856300605	62856300606	50	50	27,5	---	---	---

PSC

Suitable Accessories

Collets



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Clamping Nuts



Page 162ff

Wrenches



Page 160

Mounting Devices



Page 161

Adjustable Stop Screws



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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE CHUCKS

ISO 26623-1

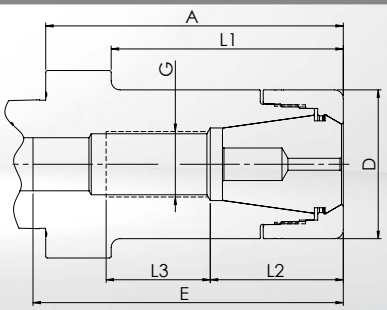
FORM AD - CENTRAL COOLANT SUPPLY

PSC63
DPC

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16								
DPC16-C6-A=60	62863300605	62863300606	30	56	33	---	---	---
DPC16-C6-A=100	**62863301005**	**62863301006**	30	90	73	32	30	M11x1
Clamping range Ø 1-13 mm - Collets GERC20								
DPC20-C6-A=60	62864300605	62864300606	32	56	37	---	---	---
DPC20-C6-A=100	62864301005	62864301006	32	80	77	36	35	M14x1
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-C6-A=60	62865300605	62865300606	40	56	35	---	---	---
DPC25-C6-A=100	**62865301005**	**62865301006**	40	83	75	43	35	M18x1,5
DPC25-C6-A=130	62865301305	62865301306	40	125	105	43	35	M18x1,5
DPC25-C6-A=160	62865301605	62865301606	40	140	135	43	35	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-C6-A=60	62866300605	62866300606	50	56	35	---	---	---
DPC32-C6-A=100	**62866301005**	**62866301006**	50	84	75	44	35	M22x1,5
DPC32-C6-A=130	62866301305	62866301306	50	98	104	44	30	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40								
DPC40-C6-A=65	62867300655	---	63	57	42	---	---	---
DPC40-C6-A=100	62867301005	---	63	87	77	54	25	M28x1,5

PSC

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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PSC63
FPC

FPC FULL PERFORMANCE CHUCKS

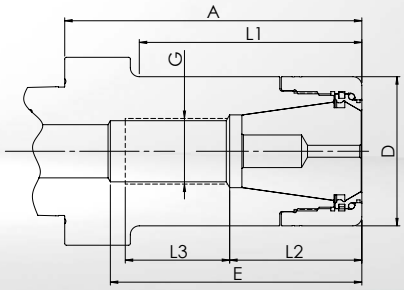
ISO 26623-1

FORM AD - CENTRAL COOLANT SUPPLY

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-C6-A=60	62866300609	50	56	35	---	---	---
FPC32-C6-A=100	**62866301009**	50	84	75	44	35	M22x1,5
FPC32-C6-A=130	62866301309	50	98	104	44	30	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
FPC40-C6-A=65	62867300659	63	57	42	---	---	---
FPC40-C6-A=100	62867301009	63	87	77	54	25	M28x1,5

PSC

Suitable Accessories

Collets



Page 150ff

Clamping Nuts



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Wrenches



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Mounting Devices



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Adjustable Stop Screws



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FAHRION® FAR BEYOND PRECISION

AFC ADJUSTABLE FINISHING CHUCKS

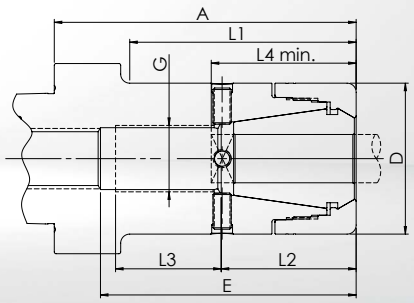
ISO 26623-1

FORM AD - CENTRAL COOLANT SUPPLY

PSC63
AFC

Adjustable precision chuck for reaming and other tasks with maximum concentricity
Design for adjustable concentricity with 4 screws on the circumference





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** DPC high accuracy clamping nut **without** collet collapse, for collets GERC-HP, adjustable runout, especially for long overhang and reamers.

Clamping diameter	Possible range	L4 min.	Description + A	Order-No. incl. DPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Collets GERC25										
7-10	7-10	43	AFC25-C6-A=100	62865305235	40	83	75	43	35	M18x1,5
10,5-13,5	10,1-13,5	43	AFC25-C6-A=100	62865305245	40	83	75	43	35	M18x1,5
14-16	13,51-16	43	AFC25-C6-A=100	62865305265	40	83	75	43	35	M18x1,5
Collets GERC32										
7-13	7-13,5	47	AFC32-C6-A=100	62866305245	50	84	75	44	35	M22x1,5
14-20	13,51-20	47	AFC32-C6-A=100	62866305265	50	84	75	44	35	M22x1,5
Collets GERC40										
7-15	7-15,5	55	AFC40-C6-A=100	62867305245	63	87	77	54	25	M28x1,5
16-26	15,51-26	55	AFC40-C6-A=100	62867305265	63	87	77	54	25	M28x1,5

Please note the minimum clamping length L4 required for the function and that the chuck is only approved for the respective clamping Ø.
Other versions and clamping Ø can be offered after technical examination.

PSC

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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PSC80
DPC

DPC DYNAMIC PERFORMANCE CHUCKS

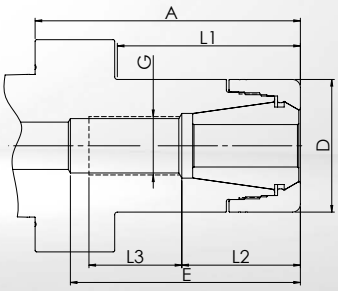
ISO 26623-1

FORM AD - CENTRAL COOLANT SUPPLY

Multifunctional precision chuck, especially for finishing and HDC milling
Cylindrical design for less interference contours

Protect





- **Chuck body and clamping nut separately balanced**
  G2,5 at 25.000 1/min or U ≤ 1 gmm
- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + A	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 1-16 mm - Collets GERC25								
DPC25-C8-A=100	62885301005	62885301006	40	90	67	43	30	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32								
DPC32-C8-A=100	62886301005	62886301006	50	87	69	45	35	M22x1,5

PSC

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Mounting Devices	Adjustable Stop Screws
				
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FAHRION® FAR BEYOND PRECISION

UPC ULTRA POWER CHUCKS

ISO 26623-1

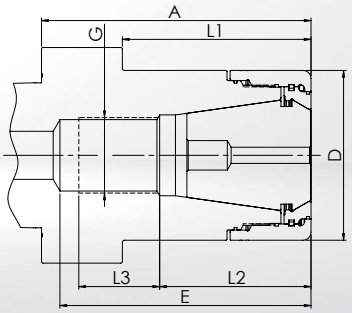
FORM AD - CENTRAL COOLANT SUPPLY

PSC80
UPC

Extremely stiff precision chuck for the most demanding tasks with predominantly radial load
Cylindrical design with a multi-part clamping nut for optimised damping and maximum stability

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** UPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. UPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
UPC32-C8-A=100	66886301005	53	85	70	45	35	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40							
UPC40-C8-A=100	66887301005	63	93	70	56	30	M28x1,5

PSC

Suitable Accessories

Collets



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Clamping Nuts



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Wrenches



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Mounting Devices



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Adjustable Stop Screws



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PSC80
FPC

FPC FULL PERFORMANCE CHUCKS

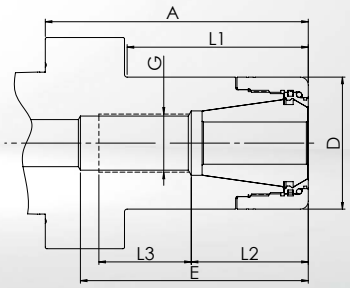
ISO 26623-1

FORM AD - CENTRAL COOLANT SUPPLY

Stable precision chuck, especially for trochoidal milling and other HPC milling strategies
Version with a multi-part clamping nut for optimised damping, especially for axial load

Protect





- **Chuck body and clamping nut separately balanced**
  G6,3 at 18.000 1/min
- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + A	Order-No. incl. FPC clamping nut	D = Wrench Ø	E	L1	L2	L3	G
Clamping range Ø 2-20 mm - Collets GERC32							
FPC32-C8-A=100	62886301009	50	87	69	45	35	M22x1,5

PSC

Suitable Accessories

Collets



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Clamping Nuts



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Wrenches



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Mounting Devices



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Adjustable Stop Screws



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FAHRION® FAR BEYOND PRECISION

MPC MINI PRECISION TOOL EXTENSIONS

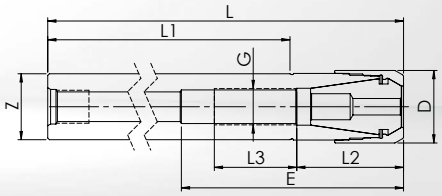
CYLINDRICAL SHANK

FORM AD - CENTRAL COOLANT SUPPLY

Slim extensions with optimum interference contour for deep immersion in tight spaces
Variable lengths possible due to different insertion depths in DPC or UPC chucks

Protect

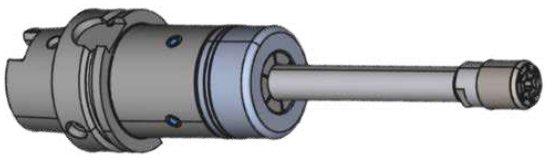




- **Standard:** MPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + L	Order-No. incl. MPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	Z	E	L1	L2	L3	G
Clamping range Ø 1-5 mm - Collets GERC8									
MPC8-Z10-L=80	60010340805	---	10	10	16	48	---	---	---
MPC8-Z10-L=150	**60010341505**	---	10	10	16	138	17	15	M5x0,8
MPC8-Z10-L=200	**60010342005**	---	10	10	16	188	17	15	M5x0,8
MPC8-Z12-L=120	60020341205	---	10	12	16	88	---	---	---
MPC8-Z12-L=160	60020341605	---	10	12	16	148	---	---	---
MPC8-Z12-L=200	60020342005	---	10	12	16	188	---	---	---
Clamping range Ø 1-7 mm - Collets GERC11									
MPC11-Z16-L=150	**60031341505**	---	16	16	68	133	20	25	M8x1
MPC11-Z16-L=200	**60031342005**	---	16	16	68	183	20	25	M8x1
Clamping range Ø 1-10 mm - Collets GERC16									
MPC16-Z16-L=150	**60033341505**	**60033341506**	22	16	68	117	32	25	M11x1
MPC16-Z16-L=200	**60033342005**	**60033342006**	22	16	68	167	32	25	M11x1
MPC16-Z20-L=150	**60043341505**	**60043341506**	22	20	68	117	32	25	M11x1
MPC16-Z20-L=200	**60043342005**	**60043342006**	22	20	68	167	32	25	M11x1

Optimal run-out for MPC Tool Extensions can be achieved when combined with the AFC Adjustable Chucks



Suitable Accessories

Collets



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Clamping Nuts



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Wrenches



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Adjustable Stop Screws



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DPC DYNAMIC PERFORMANCE TOOL EXTENSIONS

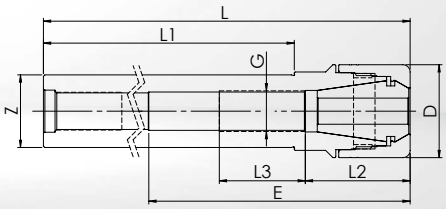
CYLINDRICAL SHANK

FORM AD - CENTRAL COOLANT SUPPLY

Slim extensions with optimum interference contour for deep immersion in tight spaces
Variable lengths possible due to different insertion depths in DPC or UPC chucks

Protect

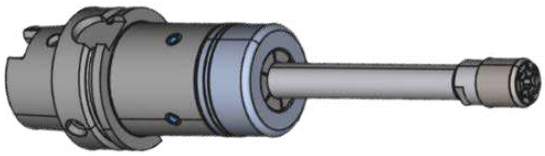




- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + L	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	Z	E	L1	L2	L3	G
Clamping range Ø 1-10 mm - Collets GERC16									
DPC16-Z20-L=150	62043301505	62043301506	30	20	70	113	32	25	M11x1
DPC16-Z20-L=250	62043302505	62043302506	30	20	70	213	32	25	M11x1
DPC16-Z20-L=350	62043303505	62043303506	30	20	70	313	32	25	M11x1
Clamping range Ø 1-13 mm - Collets GERC20									
DPC20-Z25-L=150	62054301505	62054301506	32	25	70	110	36	30	M14x1
DPC20-Z25-L=250	62054302505	62054302506	32	25	70	210	36	30	M14x1
DPC20-Z25-L=350	62054303505	62054303506	32	25	70	310	36	30	M14x1

Optimal run-out for DPC Tool Extensions can be achieved when combined with the AFC Adjustable Chucks



Suitable Accessories

Collets	Clamping Nuts	Wrenches	Adjustable Stop Screws
			
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FAHRION® FAR BEYOND PRECISION

DPC DYNAMIC PERFORMANCE HOLDERS NC

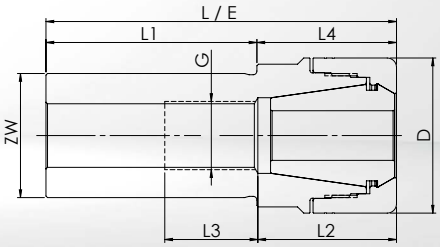
CYLINDRICAL SHANK WITH FLAT

FORM AD - CENTRAL COOLANT SUPPLY

Variable collet chuck with high clamping force for drilling, threading and reaming
Version with stop flange for quick pre-setting for CNC lathe

Protect





- **Standard:** DPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.
- **Alternative:** HSS clamping nut **with** 0,4 mm collet collapse. Concentricity of ≤ 10 µm with GERC-B collets. Not suitable for sealed collets.

Description + L1	Order-No. incl. DPC clamping nut	Order-No. incl. HSS clamping nut	D = Wrench Ø	ZW	E	L	L2	L3	L4	G
Clamping range Ø 1-16 mm - Collets GERC25										
DPC25-ZW25-L1=54	62955300545	62955300546	40	25	99	99	42,8	30	45	M18x1,5
Clamping range Ø 2-20 mm - Collets GERC32										
DPC32-ZW32-L1=58	**62966300585**	**62966300586**	50	32	103	103	45	30	45	M22x1,5
DPC32-ZW40-L1=68	**62976300685**	**62976300686**	50	40	113	113	45	30	45	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40										
DPC40-ZW40-L1=68	62977300685	---	63	40	123	123	55	35	55	M28x1,5

The advantages of CENTRO|P on the lathe machine:

- Precision guaranteed when drilling and reaming.
- Never again risk of injury due to slipping during tool assembly in the machine.
- High straightness for deep bores (e.g. deep hole drilling).
- High clamping force secures the tool in the axial direction, preventing it from being pushed towards you.

Suitable Accessories

Collets	Clamping Nuts	Wrenches	Adjustable Stop Screws
			
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FPC FULL PERFORMANCE HOLDERS NC

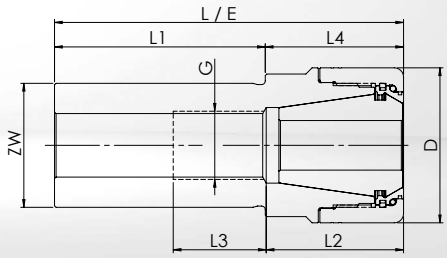
CYLINDRICAL SHANK WITH FLAT

FORM AD - CENTRAL COOLANT SUPPLY

Variable collet chuck with even higher clamping force for drilling, threading and reaming
Version with a multi-part clamping nut and stop flange for quick pre-setting for CNC lathe

Protect





- **Standard:** FPC high accuracy clamping nut **without** collet collapse. Concentricity of **≤ 3 µm** with GERC-HP collets.

Description + L1	Order-No. incl. FPC clamping nut	D = Wrench Ø	ZW	E	L	L2	L3	L4	G
Clamping range Ø 2-20 mm - Collets GERC32									
FPC32-ZW32-L1=58	**62966300589**	50	32	103	103	45	30	45	M22x1,5
FPC32-ZW40-L1=68	**62976300689**	50	40	113	113	45	30	45	M22x1,5
Clamping range Ø 3-26 mm - Collets GERC40									
FPC40-ZW40-L1=68	62977300689	63	40	123	123	55	35	55	M28x1,5

The advantages of CENTRO|P on the lathe machine:

- 3 µm precision guaranteed when drilling and reaming.
- Never again risk of injury due to slipping during tool assembly in the machine.
- High straightness for deep bores (e.g. deep hole drilling).
- Increased holding force due to multi-part clamping nut.

Suitable Accessories

Collets



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Clamping Nuts



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Wrenches



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Adjustable Stop Screws



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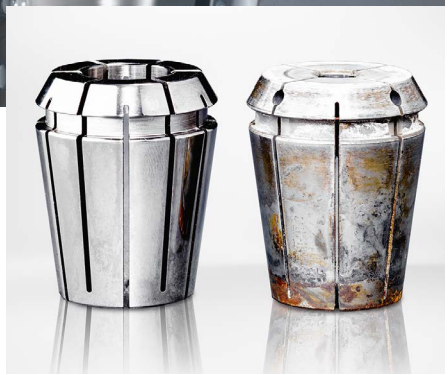
FAHRION® FAR BEYOND PRECISION

COLLETS



GERC – A CLASS OF ITS OWN





With and without FAHRION | Protect – after four months of normal use

Rust on collets reduces the life of your tools and leads to significant losses in precision. That's why we have developed FAHRION | Protect. A ground-breaking technology that provides long term protection against corrosion.

- The nominal geometry between the collet and the taper seat in the chuck is maintained for long lasting and precision surface contact without corrosion-related irregularities
- Hold component tolerances even longer during manufacturing: the number of quality parts increases.
- You can keep production processes on a high level for longer, you save time which leads to reduced delivery time.
- A higher concentricity extends the service life of your tools. Thus, you save time and money by reducing set-up time.
- Collets have to be replaced less frequently or can be used longer for precision applications.

FAHRION — Protect

This shows you the Performance and Characteristic of the FAHRION Collets

Blue Ring
Quality Feature for
2 µm Collets

Serial Number

Bore Diameter



Made in
Germany

Collet Size

The FAHRION Quality Mark for Tested Quality

Higher tool service life, lower tool costs and lower set-up times
= Lower production costs
= Better surface quality and tighter manufacturing tolerances
= Better quality

Advantages of FAHRION Collets
DIN ISO 15488 - GERC-B and GERC-HP (ER/ESX)

Precise
FAHRION Collets DIN ISO 15488-B (ER/ESX) set the standard of concentricity and repeatability, which is 5µm for the types GERC11-B up to GERC40-B and 2µm for the types GERC11-HP up to GERC40-HP.

Rigid
12 slots are sufficient to reach the required collapse to DIN ISO 15488. This is possible because of special steel produced for us and a particular harmonised heat treatment. Compared to 16 slot collets, our collets have fewer tendencies to distort.

Saving
All edges are not only deburred, but additionally rounded, which is a prerequisite to protect the inner cone of the collet chuck from marks. This process is important to guarantee a consistent repeatable high level of accuracy.

Due to its super-finished design, FAHRION | Protect achieves increased holding power and rigidity, higher load-bearing capacity, higher system accuracy and higher corrosion resistance in GERC-B and GERC-HP

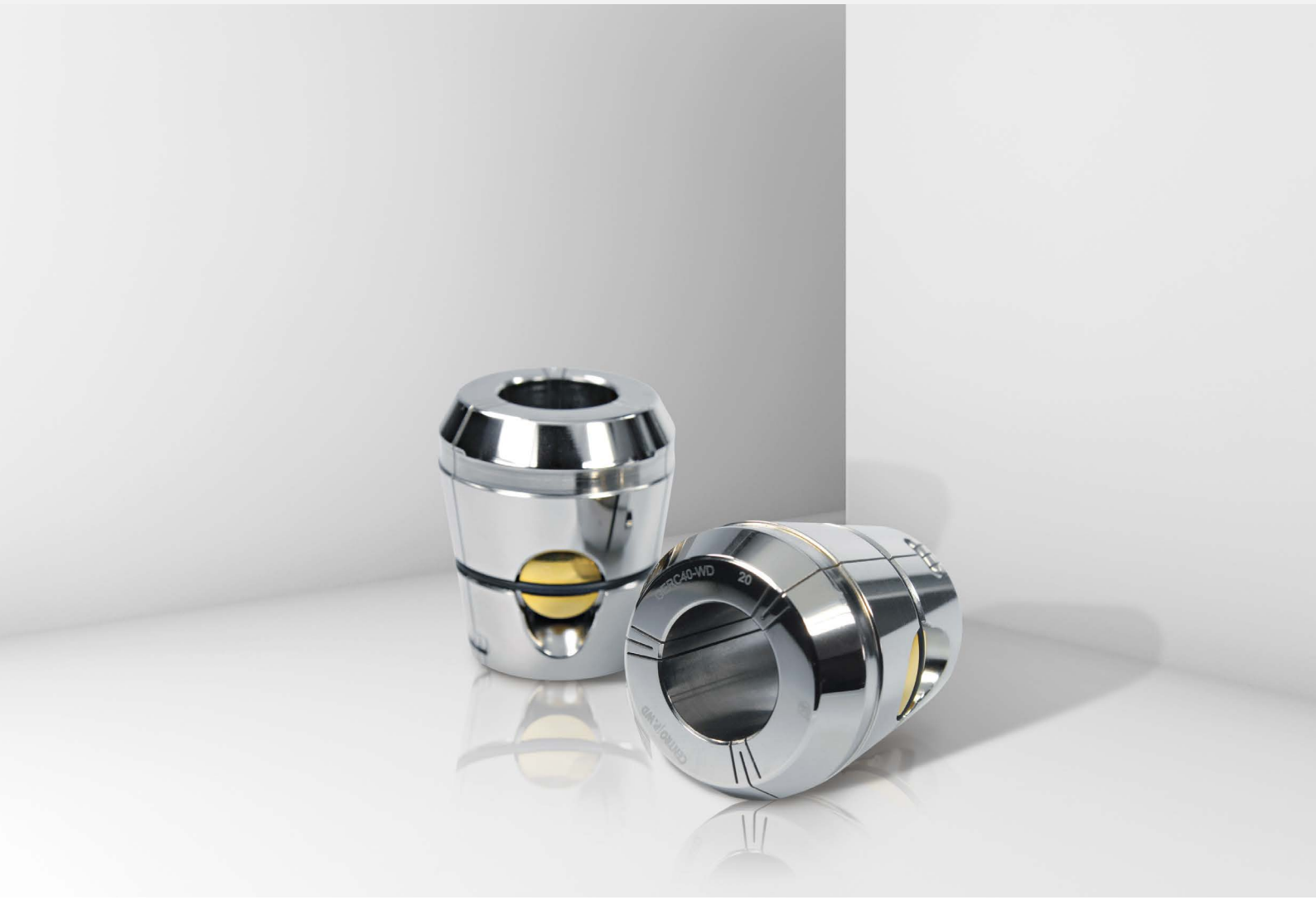
Powerful
The defined increased surface roughness of the clamping bore, combined with the optimised grinding pattern, ensure significantly higher retaining forces compared to standard collets.



Not only are the slots deburred on all sides, but the collets also have an average roughness depth of the R_z surface area = 1.6 µm

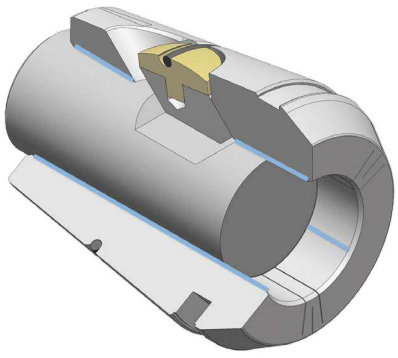
THE WEDGE COLLET GERC-W

Uncompromising Safety During Milling



No more tool pull out or micro creeping - 100% guaranteed. The solution is as simple as it is ingenious. It is an integrated wedge that rests on the Weldon surface. The user can be certain that no costly damage from tool pull out will occur, even if the tool system is overloaded.

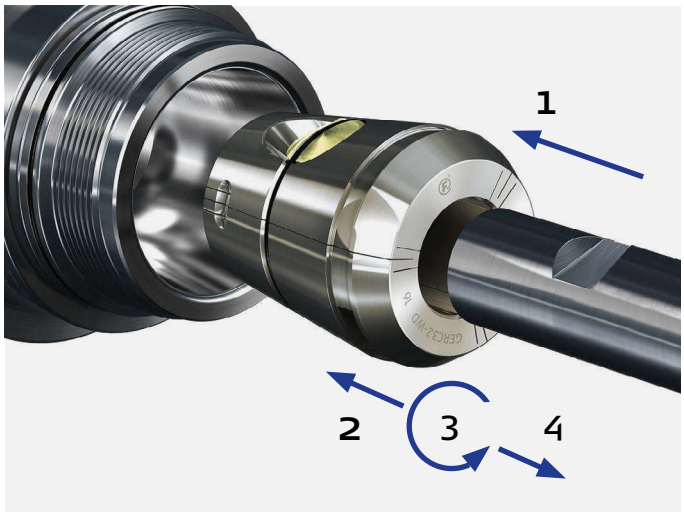
Higher Clamping Forces
When clamping, the wedge always lies against the slope of the Weldon surface and thus creates a positive lock without radially displacing the tool. The tool shank is clamped extensively on three lines, making it perfectly centered and allowing for larger clamping forces (with shank tolerances up to h9).



The three clamping lines on the tool (blue) centre the tool shank and generate impressive clamping forces as well as optimum concentricity.

FAHRION® FAR BEYOND PRECISION

Easy Handling
For assembly, you only have to insert the tool (1) until the wedge locks into place.
For disassembly, the tool is briefly inserted further (2), turned (3) and pulled out (4).



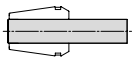
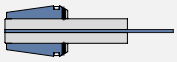
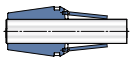
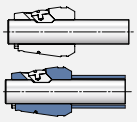
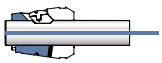
The pin pressure spring is locked in the receptor. The spring applies axial pressure on the tool to preload surface contact between the Weldon and locking wedge.



Optimal Damping
When using the **Wedge Collet GERC-W** together with the **UPC Ultra Power Chuck**, very good damping properties are achieved. The additional damping reduces vibrations which protects the spindle bearings.

Higher Service Life
Better tool concentricity increases the service life of your tools.
Your tool budget will thank you.

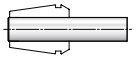
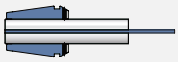
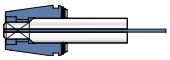
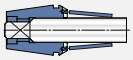
ABSOLUTELY TOP OF THE RANGE

The Features of Collets DIN ISO 15488 GERC-HP, GERC-HPD, GERC-HPDD, GERC-W					
Shape/Use	GERC-**HP**	GERC-**HPD**	GERC-**HPDD**	GERC-**W**	GERC-**WD**
					
	Standard	Sealed	Sealed with Jet Holes	Pull-Out Protec-tion	Sealed with Pull-Out Protection
					
Standard Collet Chuck	◪	◪	◪	□	□
Precision Collet Chuck CENTRO|P	■	■	■	◪	◪
Mini Precision Chuck MPC	■	■	■	□	□
Dynamic Power Chuck DPC	■	■	■	◪	◪
Ultra Power Chuck UPC	■	■	■	■	■
Full Performance Chucks FPC	■	■	■	■	■
Adjustable Finishing Chucks AFC	■	■	■	□	□
Concentricity, e.g. Ø 12.0 mm	2 µm	2 µm	2 µm	3 µm	3 µm
Repeatability	2 µm	2 µm	2 µm	3 µm	3 µm
Tool Shank Tolerance	h10	h8	h8	h8	h8
Through Tool Coolant	□	■	□	□	■

Use: ■ preferred ◪ limited □ unusable

FAHRION® FAR BEYOND PRECISION

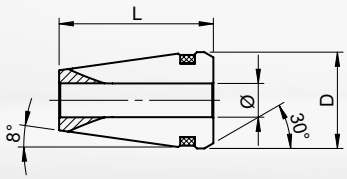
FLEXIBLE AND PRECISE

The Features of Collets DIN ISO 15488 GERC-B, GERC-BD, GERC-GBD, GERC-GBDD				
Shape/Use	GERC-**B**	GERC-**BD**	GERC-**GBD**	GERC-**GBDD**
				
	Standard	Sealed	Sealed for Taps	Sealed with Jet Holes for Taps
				
Standard Collet Chuck	■	■	■	■
Precision Collet Chuck CENTRO|P	◪	◪	■	■
Mini Precision Chuck MPC	◪	◪	◪	◪
Dynamic Power Chuck DPC	◪	◪	■	■
Ultra Power Chuck UPC	◪	◪	■	■
Full Performance Chucks FPC	◪	◪	■	■
Adjustable Finishing Chucks AFC	□	□	□	□
Concentricity, e.g. Ø 12.0 mm	5 µm	5 µm	10 µm	10 µm
Repeatability	3 µm	3 µm	5 µm	5 µm
Tool Shank Tolerance	h10	h8	h8	h8
Through Tool Coolant	□	■	■	□

Use: ■ preferred ◪ limited □ unusable

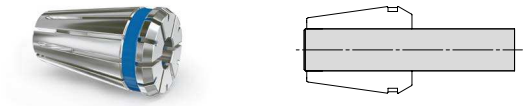
ACCESSORIES FOR CHUCKS
MPC8

High Precison Collets 5 µm



GERC8-**HP** Ø 1-5 mm

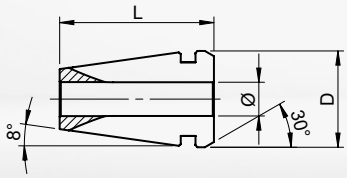
Standard



◰ =	5 µm
D =	8,5
L =	13,6

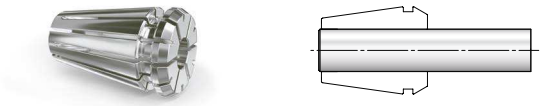
Ø mm	Order-No.	Ø inch	Order-No.
1,0	**13610010100**	1/16"	13610040159
1,5	**13610010150**	1/8"	**13610040318**
2,0	**13610010200**	3/16"	13610040476
2,5	**13610010250**		
2,8	**13610010280**		
3,0	**13610010300**		
3,5	**13610010350**		
4,0	**13610010400**		
4,5	**13610010450**		
5,0	**13610010500**		

Precision Collets 10 µm



GERC8-**B** Ø 1-5 mm

Standard



◰ =	10 µm
D =	8,5
L =	13,6

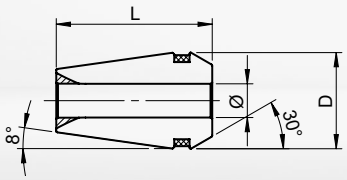
Ø mm	Order-No.	Ø inch	Order-No.
1,0	**13710010100**	1/16"	13710040159
1,5	**13710010150**	1/8"	**13710040318**
2,0	**13710010200**	3/16"	13710040476
2,5	**13710010250**		
3,0	**13710010300**		
3,5	**13710010350**		
4,0	**13710010400**		
4,5	**13710010450**		
5,0	**13710010500**		

GERC8-**B** Set

Content of set (Ø mm)	Order-No.	Set
1,0-5,0/ 0,5 Increments	1371016	9pieces

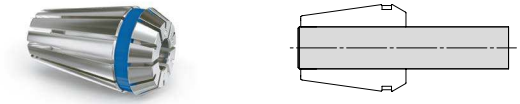
High Precison Collets 2 µm

Protect



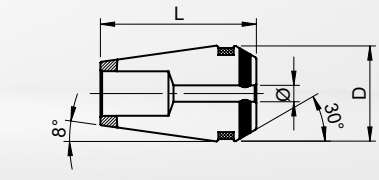
GERC11-**HP** Ø 1-7 mm

Standard



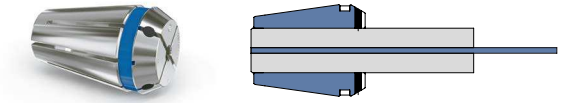
⍁ =	2 µm
D =	11,3
L =	18

Ø mm	Order-No.	Ø inch	Order-No.
1,0	**13611010100**	1/16"	**13611040159**
1,5	**13611010150**	3/32"	13611040238
2,0	**13611010200**	1/8"	**13611040318**
2,5	**13611010250**	5/32"	13611040397
2,8	**13611010280**	3/16"	**13611040476**
3,0	**13611010300**	7/32"	13611040556
3,5	**13611010350**	1/4"	**13611040635**
4,0	**13611010400**		
4,5	**13611010450**		
5,0	**13611010500**		
5,5	**13611010550**		
6,0	**13611010600**		
6,5	**13611010650**		
7,0	**13611010700**		



GERC11-**HPD** Ø 3-6 mm

Sealed for Inner Coolant Supply

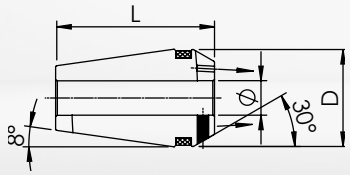


⍁ =	2 µm
D =	11,3
L =	18

Ø mm	Order-No.	Ø inch	Order-No.
3,0	**13621010300**	1/8"	**13621040318**
4,0	**13621010400**	3/16"	13621040476
5,0	13621010500	1/4"	**13621040635**
6,0	**13621010600**		

ACCESSORIES FOR CHUCKS
MPC11

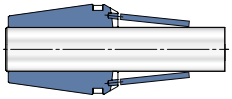
High Precison Collets 2 µm



GERC11-**HPDD** Ø 3-6 mm

Sealed for Inner Coolant Supply and Jet Holes



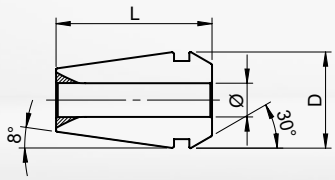


⍁ =	2 µm
D =	11,3
L =	18

Ø mm	Order-No.	Ø inch	Order-No.
3,0	**13631010300**	1/8"	13631040318
4,0	**13631010400**	3/16"	13631040476
6,0	**13631010600**	1/4"	13631040635

Precision Collets 5 µm

Protect



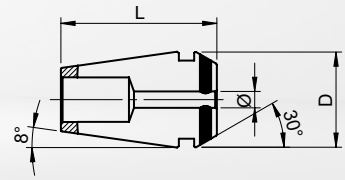
GERC11-**B** Ø 1-7 mm

Standard



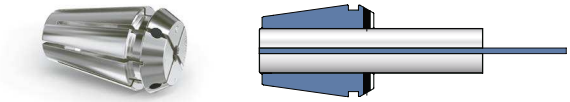
⍁ =	5 µm
D =	11,3
L =	18

Ø mm	Order-No.	Ø inch	Order-No.
1,0	**13711010100**	1/16"	**13711040159**
1,5	**13711010150**	3/32"	13711040238
2,0	**13711010200**	1/8"	**13711040318**
2,5	**13711010250**	5/32"	13711040397
3,0	**13711010300**	3/16"	**13711040476**
3,5	**13711010350**	7/32"	13711040556
4,0	**13711010400**	1/4"	**13711040635**
4,5	**13711010450**		
5,0	**13711010500**		
5,5	**13711010550**		
6,0	**13711010600**		
6,5	**13711010650**		
7,0	**13711010700**		



GERC11-**BD** Ø 3-6 mm

Sealed for Inner Coolant Supply



⍁ =	5 µm
D =	11,3
L =	18

Ø mm	Order-No.	Ø inch	Order-No.
3,0	**13721010300**	1/8"	**13721040318**
4,0	**13721010400**	3/16"	13721040476
5,0	13721010500	1/4"	**13721040635**
6,0	**13721010600**		

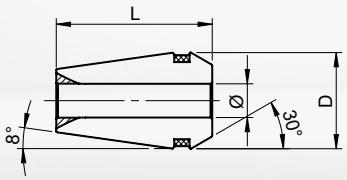
GERC11-**B** Set

Content of set (Ø mm)	Order-No.	Set
1,0-7,0/ 0,5 Increments	1371116	13pieces

ACCESSORIES FOR CHUCKS
MPC16 | DPC16

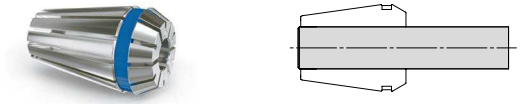
High Precison Collets 2 µm

Protect



GERC16-**HP** Ø 1-10 mm

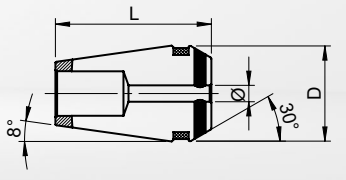
Standard



◰ =	2 µm
D =	17
L =	27,5

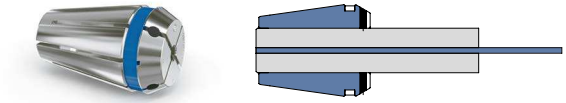
Ø mm	Order-No.	Ø mm	Order-No.
1,0	**13613010100**	4,5	13613010450
1,1	13613010110	5,0	**13613010500**
1,2	13613010120	5,5	13613010550
1,3	13613010130	5,6	13613010560
1,4	13613010140	6,0	**13613010600**
1,5	**13613010150**	6,3	13613010630
1,6	13613010160	6,5	13613010650
1,7	13613010170	7,0	**13613010700**
1,8	13613010180	7,1	13613010710
1,9	13613010190	7,5	13613010750
2,0	**13613010200**	8,0	**13613010800**
2,1	13613010210	8,5	13613010850
2,2	13613010220	9,0	**13613010900**
2,3	13613010230	9,5	13613010950
2,4	13613010240	10,0	**13613011000**
2,5	**13613010250**		
2,6	13613010260		
2,7	13613010270	Ø inch	Order-No.
2,8	13613010280	1/16"	**13613040159**
2,9	13613010290	3/32"	13613040238
3,0	**13613010300**	1/8"	**13613040318**
3,1	13613010310	5/32"	13613040397
3,2	13613010320	3/16"	**13613040476**
3,3	13613010330	7/32"	13613040556
3,4	13613010340	1/4"	**13613040635**
3,5	13613010350	9/32"	13613040714
3,6	13613010360	5/16"	**13613040794**
3,7	13613010370	11/32"	13613040873
3,8	13613010380	3/8"	**13613040953**
4,0	**13613010400**		

GERC16-**HP** Set		
Content of set (Ø mm)	Order-No.	Set
3,0•4,0•5,0•6,0•8,0•10,0	13613160060	6pieces



GERC16-**HPD** Ø 3-10 mm

Sealed for Inner Coolant Supply



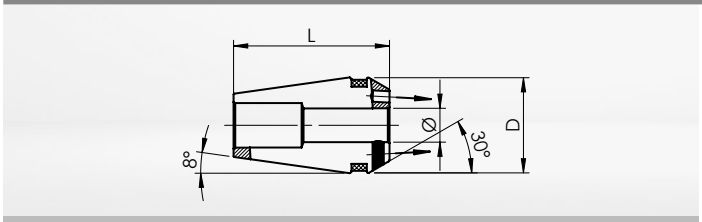
◰ =	2 µm
D =	17
L =	27,5

Ø mm	Order-No.	Ø inch	Order-No.
3,0	**13623010300**	1/8"	**13623040318**
4,0	**13623010400**	5/32"	13623040397
5,0	13623010500	3/16"	**13623040476**
6,0	**13623010600**	7/32"	13623040556
7,0	13623010700	1/4"	**13623040635**
8,0	**13623010800**	9/32"	13623040714
9,0	13623010900	5/16"	**13623040794**
10,0	**13623011000**	11/32"	13623040873
		3/8"	**13623040953**
		13/32"	13623041032

GERC16-**HPD** Set		
Content of set (Ø mm)	Order-No.	Set
3,0•4,0•5,0•6,0•8,0•10,0	13623160060	6pieces

FAHRION®
FAR BEYOND PRECISION

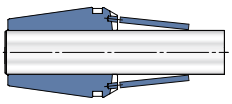
High Precison Collets 2 µm



GERC16-**HPDD** Ø 3-10 mm

Sealed for Inner Coolant Supply and Jet Holes



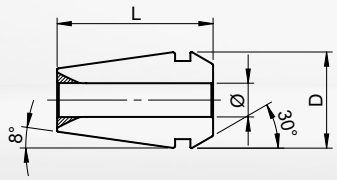


⍁ =	2 µm
D =	17
L =	27,5

Ø mm	Order-No.	Ø inch	Order-No.
3,0	**13633010300**	1/8"	13633040318
4,0	**13633010400**	3/16"	13633040476
6,0	**13633010600**	1/4"	13633040635
8,0	**13633010800**	5/16"	13633040794
10,0	**13633011000**	3/8"	13633040953

ACCESSORIES FOR CHUCKS
MPC16 | DPC16

Precision Collets 5 µm



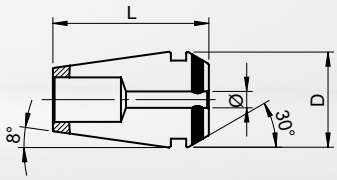
GERC16-**B** Ø 1-10 mm

Standard



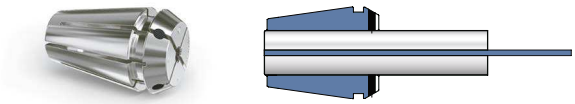
◪ =	5 µm
D =	17
L =	27,5

Ø mm	Order-No.	Ø inch	Order-No.
1,0	**13713010100**	1/16"	**13713040159**
1,5	**13713010150**	3/32"	13713040238
2,0	**13713010200**	1/8"	**13713040318**
2,5	**13713010250**	5/32"	13713040397
3,0	**13713010300**	3/16"	**13713040476**
3,5	13713010350	7/32"	13713040556
4,0	**13713010400**	1/4"	**13713040635**
4,5	13713010450	9/32"	13713040714
5,0	**13713010500**	5/16"	**13713040794**
5,5	13713010550	11/32"	13713040873
6,0	**13713010600**	3/8"	**13713040953**
6,5	13713010650	13/32"	13713041032
7,0	**13713010700**		
7,5	13713010750		
8,0	**13713010800**		
8,5	13713010850		
9,0	**13713010900**		
9,5	13713010950		
10,0	**13713011000**		



GERC16-**BD** Ø 3-10 mm

Sealed for Inner Coolant Supply



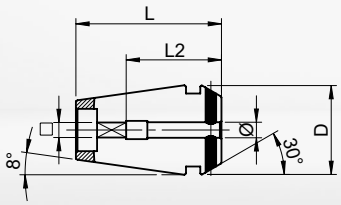
◪ =	5 µm
D =	17
L =	27,5

Ø mm	Order-No.	Ø inch	Order-No.
3,0	**13723010300**	1/8"	**13723040318**
4,0	**13723010400**	3/16"	13723040476
5,0	13723010500	1/4"	**13723040635**
6,0	**13723010600**	5/16"	13723040794
7,0	13723010700	3/8"	**13723040953**
8,0	**13723010800**		
9,0	13723010900		
10,0	**13723011000**		

GERC16-**B** Set		
Content of set (Ø mm)	Order-No.	Set
1,0-10,0/ 1,0 Increments	1371316	10pieces

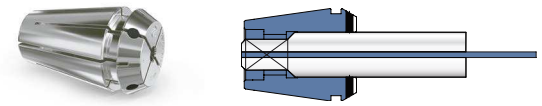
GERC16-**BD** Set		
Content of set (Ø mm)	Order-No.	Set
3,0•4,0•5,0•6,0•8,0•10,0	13723160060	6pieces

Tap Collets 10 µm



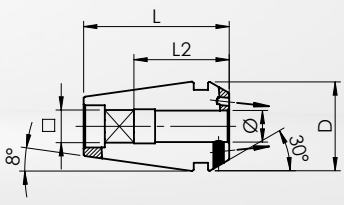
GERC16-**GBD** Ø 2,8-9 mm

Sealed for Inner Coolant Supply



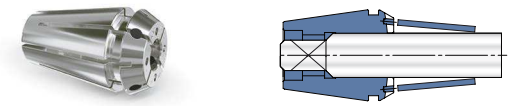
□ =		10 µm
D =		17
L =		27,5

Ø / □ mm	L2	Order-No.
2,8/2,1	18	13823010280
3,5/2,7	18	**13823010350**
4,0/3,2	18	13823010400
4,5/3,55	18	**13823010450**
5,0/4,0	18	13823010500
5,5/4,5	18	13823010550
6,0/5,0	18	**13823010600**
6,3/5,0	18	13823010630
7,0/5,6	18	**13823010700**
7,1/5,6	18	13823010710
8,0/6,3	22	**13823010800**
9,0/7,1	22	**13823010900**



GERC16-**GBDD** Ø 3,5-9 mm

Sealed for Inner Coolant Supply and Jet Holes



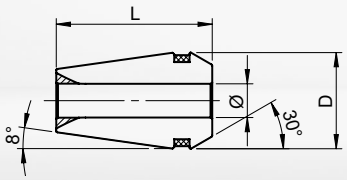
□ =		10 µm
D =		17
L =		27,5

Ø / □ mm	L2	Order-No.
3,5/2,7	18	**13833010350**
4,5/3,55	18	**13833010450**
6,0/5,0	18	**13833010600**
7,0/5,6	18	**13833010700**
8,0/6,3	22	**13833010800**
9,0/7,1	22	**13833010900**

ACCESSORIES FOR CHUCKS
DPC20

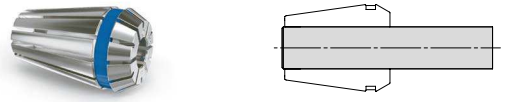
High Precison Collets 2 µm

Protect



GERC20-**HP** Ø 1-13 mm

Standard

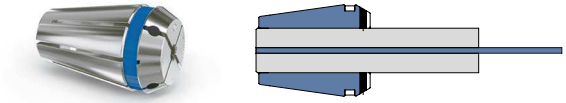


⍁ =	2 µm
D =	21
L =	31,5

Ø mm	Order-No.	Ø mm	Order-No.
1,0	**13614010100**	10,0	**13614011000**
1,5	13614010150	10,5	13614011050
2,0	**13614010200**	11,0	**13614011100**
2,5	13614010250	11,5	13614011150
3,0	**13614010300**	12,0	**13614011200**
3,5	13614010350	12,5	13614011250
4,0	**13614010400**	13,0	**13614011300**
4,5	13614010450		
5,0	**13614010500**		
5,5	13614010550	Ø inch	Order-No.
6,0	**13614010600**	1/8"	**13614040318**
6,5	13614010650	3/16"	13614040476
7,0	**13614010700**	1/4"	**13614040635**
7,5	13614010750	5/16"	13614040794
8,0	**13614010800**	3/8"	**13614040953**
8,5	13614010850	7/16"	13614041111
9,0	**13614010900**	1/2"	**13614041270**
9,5	13614010950		

GERC20-**HPD** Ø 3-12 mm

Sealed for Inner Coolant Supply



⍁ =	2 µm
D =	21
L =	31,5

Ø mm	Order-No.	Ø inch	Order-No.
3,0	**13624010300**	1/8"	**13624040318**
4,0	**13624010400**	3/16"	13624040476
5,0	13624010500	1/4"	**13624040635**
6,0	**13624010600**	5/16"	13624040794
7,0	13624010700	3/8"	**13624040953**
8,0	**13624010800**	7/16"	13624041111
9,0	13624010900	1/2"	**13624041270**
10,0	**13624011000**		
11,0	13624011100		
12,0	**13624011200**		

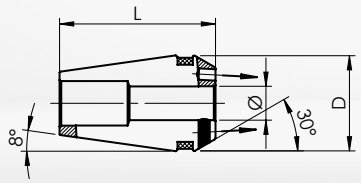
GERC

GERC20-**HP** Set		
Content of set (Ø mm)	Order-No.	Set
3,0•4,0•5,0•6,0•8,0•10,0•12,0	13614160070	7pieces

GERC20-**HPD** Set		
Content of set (Ø mm)	Order-No.	Set
3,0•4,0•5,0•6,0•8,0•10,0•12,0	13624160070	7pieces

FAHRION® FAR BEYOND PRECISION

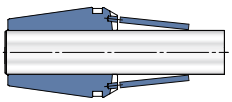
High Precison Collets 2 µm



GERC20-**HPDD** Ø 4-12 mm

Sealed for Inner Coolant Supply and Jet Holes



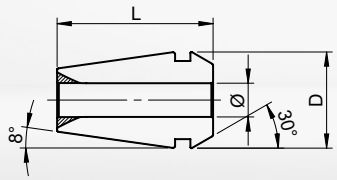


⍁ =	2 µm
D =	21
L =	31,5

Ø mm	Order-No.	Ø inch	Order-No.
4,0	13634010400	1/8"	13634040318
6,0	13634010600	3/16"	13634040476
8,0	13634010800	1/4"	13634040635
10,0	13634011000	5/16"	13634040794
12,0	13634011200	3/8"	13634040953
		7/16"	13634041111
		1/2"	13634041270

ACCESSORIES FOR CHUCKS
DPC20

Precision Collets 5 µm



GERC20-**B** Ø 1-13 mm

Standard

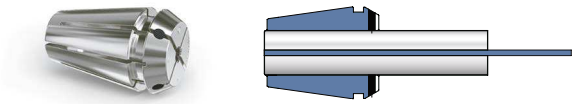


◪ =	5 µm
D =	21
L =	31,5

Ø mm	Order-No.	Ø mm	Order-No.
1,0	**13714010100**	10,0	**13714011000**
1,5	13714010150	10,5	13714011050
2,0	**13714010200**	11,0	**13714011100**
2,5	13714010250	11,5	13714011150
3,0	**13714010300**	12,0	**13714011200**
3,5	13714010350	12,5	13714011250
4,0	**13714010400**	13,0	**13714011300**
4,5	13714010450		
5,0	**13714010500**		
5,5	13714010550	Ø inch	Order-No.
6,0	**13714010600**	1/8"	**13714040318**
6,5	13714010650	3/16"	13714040476
7,0	**13714010700**	1/4"	**13714040635**
7,5	13714010750	5/16"	13714040794
8,0	**13714010800**	3/8"	**13714040953**
8,5	13714010850	7/16"	13714041111
9,0	**13714010900**	1/2"	**13714041270**
9,5	13714010950		

GERC20-**BD** Ø 3-12 mm

Sealed for Inner Coolant Supply



◪ =	5 µm
D =	21
L =	31,5

Ø mm	Order-No.	Ø inch	Order-No.
3,0	**13724010300**	1/8"	**13724040318**
4,0	**13724010400**	3/16"	13724040476
5,0	13724010500	1/4"	**13724040635**
6,0	**13724010600**	5/16"	13724040794
7,0	13724010700	3/8"	**13724040953**
8,0	**13724010800**	7/16"	13724041111
9,0	13724010900	1/2"	**13724041270**
10,0	**13724011000**		
11,0	13724011100		
12,0	**13724011200**		

GERC20-**B** Set

Content of set (Ø mm)	Order-No.	Set
2,0-13,0/ 1,0 Increments	1371416	12pieces

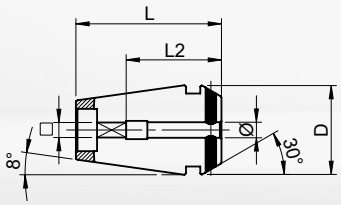
GERC20-**BD** Set

Content of set (Ø mm)	Order-No.	Set
3,0•4,0•5,0•6,0•8,0•10,0•12,0	13724160070	7pieces

FAHRION®
FAR BEYOND PRECISION

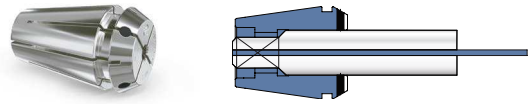
Tap Collets 10 µm

Protect



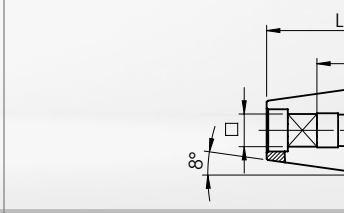
GERC20-**GBD** Ø 3,5-12 mm

Sealed for Inner Coolant Supply



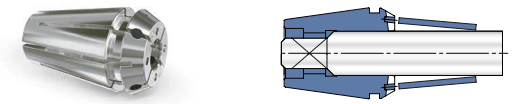
□ =		10 µm
D =		21
L =		31,5

Ø / □ mm	L2	Order-No.
3,5/2,7	18	13824010350
4,0/3,2	18	13824010400
4,5/3,55	18	**13824010450**
5,0/4,0	18	13824010500
5,5/4,5	18	13824010550
6,0/5,0	18	**13824010600**
6,3/5,0	18	13824010630
7,0/5,6	18	**13824010700**
7,1/5,6	18	13824010710
8,0/6,3	22	**13824010800**
9,0/7,1	22	**13824010900**
10,0/8,0	25	**13824011000**
11,0/9,0	25	**13824011100**
11,2/9,0	25	13824011120
12,0/9,0	25	**13824011200**



GERC20-**GBDD** Ø 4,5-12 mm

Sealed for Inner Coolant Supply and Jet Holes



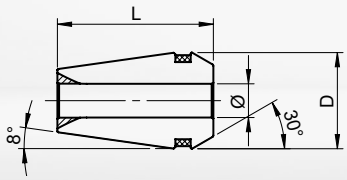
□ =		10 µm
D =		21
L =		31,5

Ø / □ mm	L2	Order-No.
4,5/3,55	18	**13834010450**
6,0/5,0	18	**13834010600**
7,0/5,6	18	**13834010700**
8,0/6,3	22	**13834010800**
9,0/7,1	22	**13834010900**
10,0/8,0	25	**13834011000**
11,0/9,0	25	**13834011100**
12,0/9,0	25	**13834011200**

ACCESSORIES FOR CHUCKS
DPC25 | AFC25

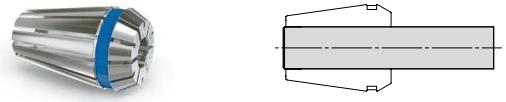
High Precison Collets 2 µm

Protect



GERC25-**HP** Ø 1-16 mm

Standard

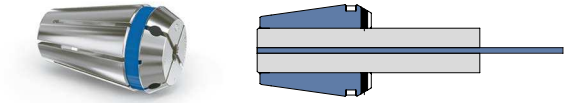


◿ =	2 µm
D =	26
L =	34

Ø mm	Order-No.	Ø mm	Order-No.
1,0	**13615010100**	12,0	**13615011200**
1,5	13615010150	12,5	13615011250
2,0	**13615010200**	13,0	**13615011300**
2,5	13615010250	13,5	13615011350
3,0	**13615010300**	14,0	**13615011400**
3,5	13615010350	14,5	13615011450
4,0	**13615010400**	15,0	**13615011500**
4,5	13615010450	15,5	13615011550
5,0	**13615010500**	16,0	**13615011600**
5,5	13615010550		
6,0	**13615010600**		
6,5	13615010650	Ø inch	Order-No.
7,0	**13615010700**	1/8"	**13615040318**
7,5	13615010750	3/16"	13615040476
8,0	**13615010800**	1/4"	**13615040635**
8,5	13615010850	5/16"	13615040794
9,0	**13615010900**	3/8"	**13615040953**
9,5	13615010950	7/16"	13615041111
10,0	**13615011000**	1/2"	**13615041270**
10,5	13615011050	9/16"	13615041429
11,0	**13615011100**	5/8"	**13615041588**
11,5	13615011150		

GERC25-**HPD** Ø 3-16 mm

Sealed for Inner Coolant Supply



◿ =	2 µm
D =	26
L =	34

Ø mm	Order-No.	Ø inch	Order-No.
3,0	**13625010300**	1/8"	**13625040318**
4,0	**13625010400**	3/16"	13625040476
5,0	13625010500	1/4"	**13625040635**
6,0	**13625010600**	5/16"	13625040794
7,0	13625010700	3/8"	**13625040953**
8,0	**13625010800**	7/16"	13625041111
9,0	13625010900	1/2"	**13625041270**
10,0	**13625011000**	9/16"	13625041429
11,0	13625011100	5/8"	**13625041588**
12,0	**13625011200**		
13,0	13625011300		
14,0	**13625011400**		
15,0	13625011500		
16,0	**13625011600**		

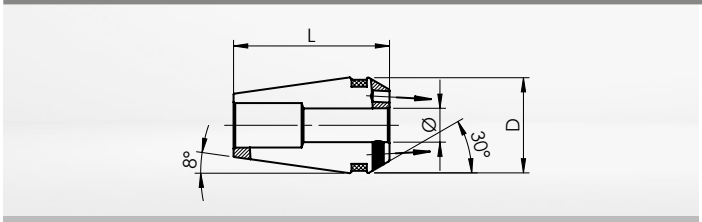
GERC

GERC25-**HP** Set		
Content of set (Ø mm)	Order-No.	Set
4,0•6,0•8,0•10,0•12,0•14,0•16,0	13615160070	7pieces

GERC25-**HPD** Set		
Content of set (Ø mm)	Order-No.	Set
4,0•6,0•8,0•10,0•12,0•14,0•16,0	13625160070	7pieces

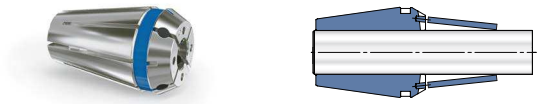
FAHRION® FAR BEYOND PRECISION

High Precison Collets 2 µm



GERC25-**HPDD** Ø 4-16 mm

Sealed for Inner Coolant Supply and Jet Holes

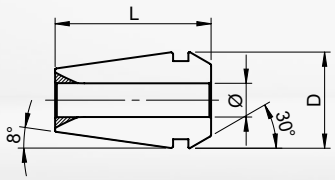


⍁ =	2 µm
D =	26
L =	34

Ø mm	Order-No.	Ø inch	Order-No.
4,0	**13635010400**	1/8"	13635040318
6,0	**13635010600**	3/16"	13635040476
8,0	**13635010800**	1/4"	13635040635
10,0	**13635011000**	5/16"	13635040794
12,0	**13635011200**	3/8"	13635040953
14,0	**13635011400**	7/16"	13635041111
16,0	**13635011600**	1/2"	13635041270
		9/16"	13635041429
		5/8"	13635041588

ACCESSORIES FOR CHUCKS
DPC25

Precision Collets 5 µm



GERC25-**B** Ø 1-16 mm

Standard

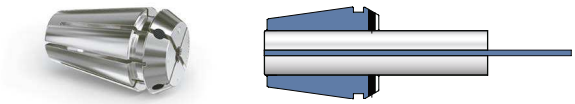


◪ =	5 µm
D =	26
L =	34

Ø mm	Order-No.	Ø mm	Order-No.
1,0	**13715010100**	12,0	**13715011200**
1,5	13715010150	12,5	13715011250
2,0	**13715010200**	13,0	**13715011300**
2,5	13715010250	13,5	13715011350
3,0	**13715010300**	14,0	**13715011400**
3,5	13715010350	14,5	13715011450
4,0	**13715010400**	15,0	**13715011500**
4,5	13715010450	15,5	13715011550
5,0	**13715010500**	16,0	**13715011600**
5,5	13715010550		
6,0	**13715010600**		
6,5	13715010650	Ø inch	Order-No.
7,0	**13715010700**	1/8"	**13715040318**
7,5	13715010750	3/16"	13715040476
8,0	**13715010800**	1/4"	**13715040635**
8,5	13715010850	5/16"	13715040794
9,0	**13715010900**	3/8"	**13715040953**
9,5	13715010950	7/16"	13715041111
10,0	**13715011000**	1/2"	**13715041270**
10,5	13715011050	9/16"	13715041429
11,0	**13715011100**	5/8"	**13715041588**
11,5	13715011150		

GERC25-**BD** Ø 3-16 mm

Sealed for Inner Coolant Supply



◪ =	5 µm
D =	26
L =	34

Ø mm	Order-No.	Ø inch	Order-No.
3,0	**13725010300**	1/8"	**13725040318**
4,0	**13725010400**	3/16"	13725040476
5,0	13725010500	1/4"	**13725040635**
6,0	**13725010600**	5/16"	13725040794
7,0	13725010700	3/8"	**13725040953**
8,0	**13725010800**	7/16"	13725041111
9,0	13725010900	1/2"	**13725041270**
10,0	**13725011000**	9/16"	13725041429
11,0	13725011100	5/8"	**13725041588**
12,0	**13725011200**		
13,0	13725011300		
14,0	**13725011400**		
15,0	13725011500		
16,0	**13725011600**		

GERC

GERC25-**B** Set

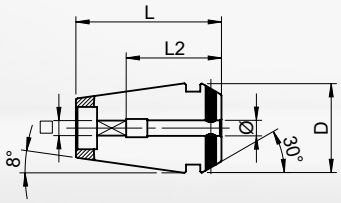
Content of set (Ø mm)	Order-No.	Set
2,0-16,0/ 1,0 Increments	1371516	15pieces

GERC25-**BD** Set

Content of set (Ø mm)	Order-No.	Set
4,0•6,0•8,0•10,0•12,0•14,0•16,0	13725160070	7pieces

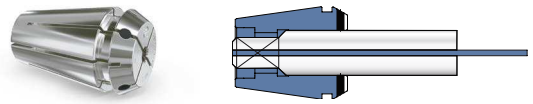
FAHRION® FAR BEYOND PRECISION

Tap Collets 10 µm



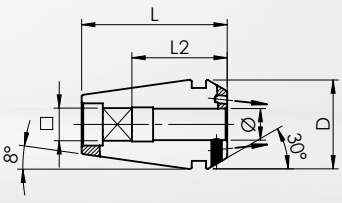
GERC25-**GBD** Ø 3,5-16 mm

Sealed for Inner Coolant Supply



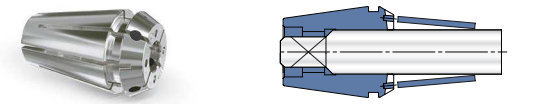
◰ =		10 µm
D =		26
L =		34

Ø / □ mm	L2	Order-No.
3,5/2,7	18	13825010350
4,0/3,2	18	13825010400
4,5/3,55	18	**13825010450**
5,0/4,0	18	13825010500
5,5/4,5	18	13825010550
6,0/5,0	18	**13825010600**
6,3/5,0	18	13825010630
7,0/5,6	18	**13825010700**
7,1/5,6	18	13825010710
8,0/6,3	22	**13825010800**
9,0/7,1	22	**13825010900**
10,0/8,0	25	**13825011000**
11,0/9,0	25	**13825011100**
11,2/9,0	25	13825011120
12,0/9,0	25	**13825011200**
12,5/10,0	25	13825011250
14,0/11,2	25	**13825011400**
16,0/12,5	25	**13825011600**



GERC25-**GBDD** Ø 4,5-16 mm

Sealed for Inner Coolant Supply and Jet Holes



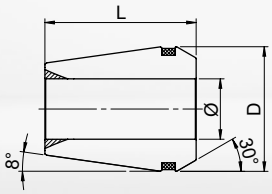
◰ =		10 µm
D =		26
L =		34

Ø / □ mm	L2	Order-No.
4,5/3,55	18	**13835010450**
6,0/5,0	18	**13835010600**
7,0/5,6	18	**13835010700**
8,0/6,3	22	**13835010800**
9,0/7,1	22	**13835010900**
10,0/8,0	25	**13835011000**
11,0/9,0	25	**13835011100**
12,0/9,0	25	**13835011200**
14,0/11,2	25	**13835011400**
16,0/12,5	25	**13835011600**

ACCESSORIES FOR CHUCKS
DPC32 | UPC32 | FPC32 | AFC32

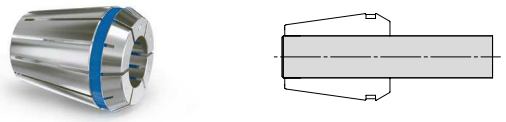
High Precison Collets 2 µm

Protect



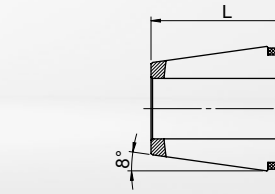
GERC32-**HP** Ø 2-20 mm

Standard



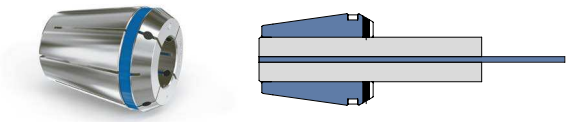
◰ =	2 µm
D =	33
L =	40

Ø mm	Order-No.	Ø mm	Order-No.
2,0	**13616010200**	15,0	**13616011500**
2,5	13616010250	15,5	13616011550
3,0	**13616010300**	16,0	**13616011600**
3,5	13616010350	16,5	13616011650
4,0	**13616010400**	17,0	**13616011700**
4,5	13616010450	17,5	13616011750
5,0	**13616010500**	18,0	**13616011800**
5,5	13616010550	18,5	13616011850
6,0	**13616010600**	19,0	**13616011900**
6,5	13616010650	19,5	13616011950
7,0	**13616010700**	20,0	**13616012000**
7,5	13616010750		
8,0	**13616010800**		
8,5	13616010850	Ø inch	Order-No.
9,0	**13616010900**	1/8"	**13616040318**
9,5	13616010950	3/16"	13616040476
10,0	**13616011000**	1/4"	**13616040635**
10,5	13616011050	5/16"	13616040794
11,0	**13616011100**	3/8"	**13616040953**
11,5	13616011150	7/16"	13616041111
12,0	**13616011200**	1/2"	**13616041270**
12,5	13616011250	9/16"	13616041429
13,0	**13616011300**	5/8"	**13616041588**
13,5	13616011350	11/16"	13616041746
14,0	**13616011400**	3/4"	**13616041905**
14,5	13616011450		



GERC32-**HPD** Ø 3-20 mm

Sealed for Inner Coolant Supply



◰ =	2 µm
D =	33
L =	40

Ø mm	Order-No.	Ø inch	Order-No.
3,0	**13626010300**	1/8"	**13626040318**
4,0	**13626010400**	3/16"	13626040476
5,0	13626010500	1/4"	**13626040635**
6,0	**13626010600**	5/16"	13626040794
7,0	13626010700	3/8"	**13626040953**
8,0	**13626010800**	7/16"	13626041111
9,0	13626010900	1/2"	**13626041270**
10,0	**13626011000**	9/16"	13626041429
11,0	13626011100	5/8"	**13626041588**
12,0	**13626011200**	11/16"	13626041746
13,0	13626011300	3/4"	**13626041905**
14,0	**13626011400**		
15,0	13626011500		
16,0	**13626011600**		
17,0	13626011700		
18,0	**13626011800**		
19,0	13626011900		
20,0	**13626012000**		

GERC32-**HP** Set

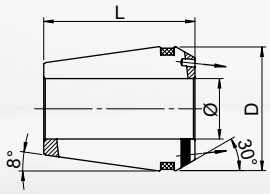
Content of set (Ø mm)	Order-No.	Set
4,0•6,0•8,0•10,0•12,0•14,0•16,0•20,0	13616160080	8pieces

GERC32-**HPD** Set

Content of set (Ø mm)	Order-No.	Set
4,0•6,0•8,0•10,0•12,0•14,0•16,0•20,0	13626160080	8pieces

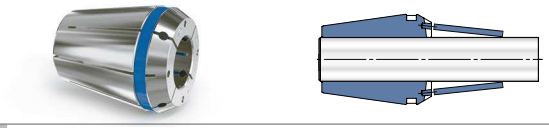
FAHRION® FAR BEYOND PRECISION

High Precison Collets 2 µm



GERC32-**HPDD** Ø 4-20 mm

Sealed for Inner Coolant Supply and Jet Holes

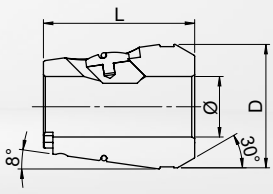


⍁ =	2 µm
D =	33
L =	40

Ø mm	Order-No.	Ø inch	Order-No.
4,0	**13636010400**	1/8"	13636040318
6,0	**13636010600**	3/16"	13636040476
8,0	**13636010800**	1/4"	13636040635
10,0	**13636011000**	5/16"	13636040794
12,0	**13636011200**	3/8"	13636040953
14,0	**13636011400**	7/16"	13636041111
16,0	**13636011600**	1/2"	13636041270
18,0	**13636011800**	9/16"	13636041429
20,0	**13636012000**	5/8"	13636041588
		11/16"	13636041746
		3/4"	13636041905

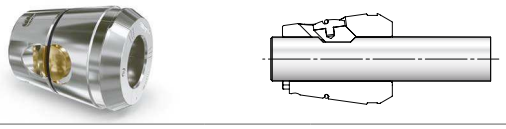
Wedge Collets 3 µm

Protect



GERC32-**W** Ø 12-20 mm

Pull-Out Protection



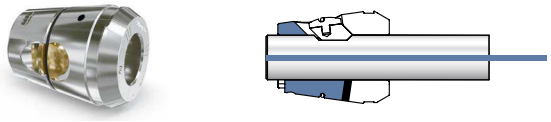
⍁ =	3 µm
D =	33
L =	40

Ø mm	Order-No.	Ø inch	Order-No.
12,0	**13916011200**	1/2"	**13916041270**
16,0	**13916011600**	5/8"	**13916041588**
20,0	**13916012000***		

* Version differs from the picture!

GERC32-**WD** Ø 12-16 mm

Sealed with Pull-Out Protection

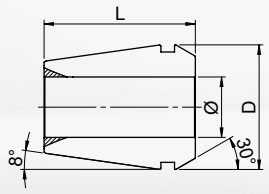


⍁ =	3 µm
D =	33
L =	40

Ø mm	Order-No.	Ø inch	Order-No.
12,0	**13926011200**	1/2"	**13926041270**
16,0	**13926011600**	5/8"	**13926041588**

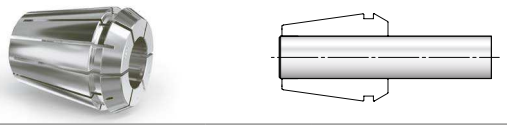
ACCESSORIES FOR CHUCKS
DPC32 | UPC32 | FPC32

Precision Collets 5 µm



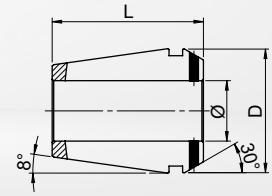
GERC32-**B** Ø 2-20 mm

Standard



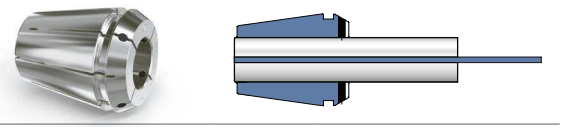
◪ =	5 µm
D =	33
L =	40

Ø mm	Order-No.	Ø mm	Order-No.
2,0	**13716010200**	15,0	**13716011500**
2,5	13716010250	15,5	13716011550
3,0	**13716010300**	16,0	**13716011600**
3,5	13716010350	16,5	13716011650
4,0	**13716010400**	17,0	**13716011700**
4,5	13716010450	17,5	13716011750
5,0	**13716010500**	18,0	**13716011800**
5,5	13716010550	18,5	13716011850
6,0	**13716010600**	19,0	**13716011900**
6,5	13716010650	19,5	13716011950
7,0	**13716010700**	20,0	**13716012000**
7,5	13716010750		
8,0	**13716010800**		
8,5	13716010850	Ø inch	Order-No.
9,0	**13716010900**	1/8"	**13716040318**
9,5	13716010950	3/16"	13716040476
10,0	**13716011000**	1/4"	**13716040635**
10,5	13716011050	5/16"	13716040794
11,0	**13716011100**	3/8"	**13716040953**
11,5	13716011150	7/16"	13716041111
12,0	**13716011200**	1/2"	**13716041270**
12,5	13716011250	9/16"	13716041429
13,0	**13716011300**	5/8"	**13716041588**
13,5	13716011350	11/16"	13716041746
14,0	**13716011400**	3/4"	**13716041905**
14,5	13716011450	13/16"	13716042064



GERC32-**BD** Ø 3-20 mm

Sealed for Inner Coolant Supply



◪ =	5 µm
D =	33
L =	40

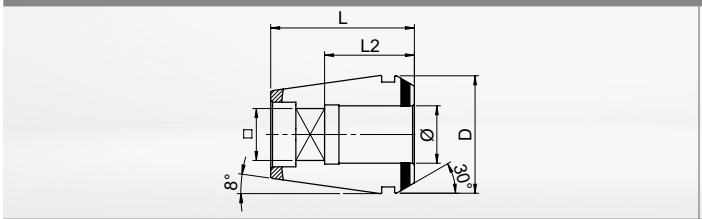
Ø mm	Order-No.	Ø inch	Order-No.
3,0	**13726010300**	1/8"	**13726040318**
4,0	**13726010400**	3/16"	13726040476
5,0	13726010500	1/4"	**13726040635**
6,0	**13726010600**	5/16"	13726040794
7,0	13726010700	3/8"	**13726040953**
8,0	**13726010800**	7/16"	13726041111
9,0	13726010900	1/2"	**13726041270**
10,0	**13726011000**	9/16"	13726041429
11,0	13726011100	5/8"	**13726041588**
12,0	**13726011200**	3/4"	**13726041905**
13,0	13726011300		
14,0	**13726011400**		
15,0	13726011500		
16,0	**13726011600**		
17,0	13726011700		
18,0	**13726011800**		
19,0	13726011900		
20,0	**13726012000**		

GERC32-**B** Set		
Content of set (Ø mm)	Order-No.	Set
3,0-20,0/ 1,0 Increments	1371616	18pieces

GERC32-**BD** Set		
Content of set (Ø mm)	Order-No.	Set
4,0•6,0•8,0•10,0•12,0•14,0•16,0•20,0	13726160080	8pieces

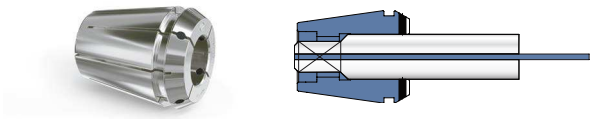
FAHRION®
FAR BEYOND PRECISION

Tap Collets 10 µm



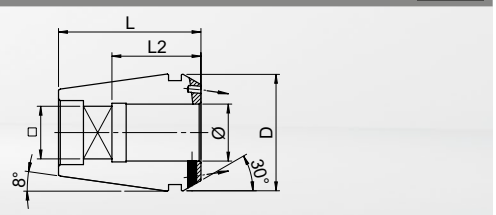
GERC32-**GBD** Ø 4-20 mm

Sealed for Inner Coolant Supply



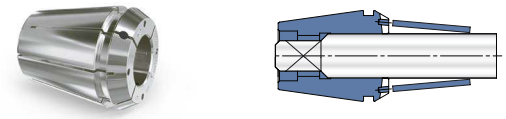
⍁ =		10 µm
D =		33
L =		40

Ø / □ mm	L2	Order-No.
4,0/3,2	18	13826010400
4,5/3,55	18	**13826010450**
5,0/4,0	18	13826010500
5,5/4,5	18	13826010550
6,0/5,0	18	**13826010600**
6,3/5,0	18	13826010630
7,0/5,6	18	**13826010700**
7,1/5,6	18	13826010710
8,0/6,3	22	**13826010800**
9,0/7,1	22	**13826010900**
10,0/8,0	25	**13826011000**
11,0/9,0	25	**13826011100**
11,2/9,0	25	13826011120
12,0/9,0	25	**13826011200**
12,5/10,0	25	13826011250
14,0/11,2	25	**13826011400**
16,0/12,5	25	**13826011600**
18,0/14,5	30	**13826011800**
20,0/16,0	30	**13826012000**



GERC32-**GBDD** Ø 4,5-20 mm

Sealed for Inner Coolant Supply and Jet Holes



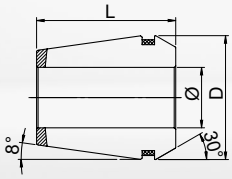
⍁ =		10 µm
D =		33
L =		40

Ø / □ mm	L2	Order-No.
4,5/3,55	18	**13836010450**
6,0/5,0	18	**13836010600**
7,0/5,6	18	**13836010700**
8,0/6,3	22	**13836010800**
9,0/7,1	22	**13836010900**
10,0/8,0	25	**13836011000**
11,0/9,0	25	**13836011100**
12,0/9,0	25	**13836011200**
14,0/11,2	25	**13836011400**
16,0/12,5	25	**13836011600**
18,0/14,5	30	**13836011800**
20,0/16,0	30	**13836012000**

ACCESSORIES FOR CHUCKS
DPC40 | UPC40 | FPC40

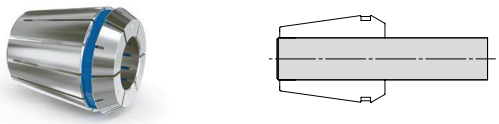
High Precison Collets 2 µm

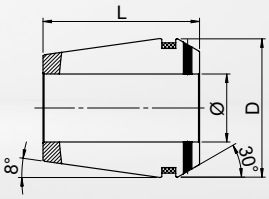
Protect



GERC40-**HP** Ø 3-26 mm

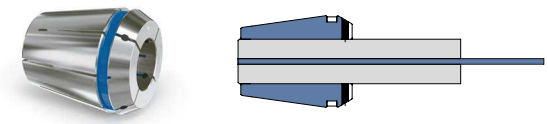
Standard





GERC40-**HPD** Ø 6-25 mm

Sealed for Inner Coolant Supply



⍁ =	2 µm
D =	41
L =	46

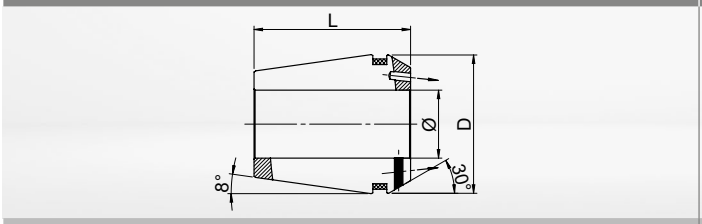
Ø mm	Order-No.	Ø mm	Order-No.
3,0	**13617010300**	19,0	**13617011900**
3,5	13617010350	19,5	13617011950
4,0	**13617010400**	20,0	**13617012000**
4,5	13617010450	20,5	13617012050
5,0	**13617010500**	21,0	**13617012100**
5,5	13617010550	21,5	13617012150
6,0	**13617010600**	22,0	**13617012200**
6,5	13617010650	22,5	13617012250
7,0	**13617010700**	23,0	**13617012300**
7,5	13617010750	23,5	13617012350
8,0	**13617010800**	24,0	**13617012400**
8,5	13617010850	24,5	13617012450
9,0	**13617010900**	25,0	**13617012500**
9,5	13617010950	25,5	13617012550
10,0	**13617011000**	26,0	**13617012600**
10,5	13617011050		
11,0	**13617011100**		
11,5	13617011150	Ø inch	Order-No.
12,0	**13617011200**	1/8"	**13617040318**
12,5	13617011250	3/16"	13617040476
13,0	**13617011300**	1/4"	**13617040635**
13,5	13617011350	5/16"	13617040794
14,0	**13617011400**	3/8"	**13617040953**
14,5	13617011450	7/16"	13617041111
15,0	**13617011500**	1/2"	**13617041270**
15,5	13617011550	9/16"	13617041429
16,0	**13617011600**	5/8"	**13617041588**
16,5	13617011650	11/16"	13617041746
17,0	**13617011700**	3/4"	**13617041905**
17,5	13617011750	13/16"	13617042064
18,0	**13617011800**	7/8"	**13617042223**
18,5	13617011850	1"	**13617042540**

⍁ =	2 µm
D =	41
L =	46

Ø mm	Order-No.	Ø inch	Order-No.
6,0	**13627010600**	1/4"	13627040635
8,0	**13627010800**	3/8"	13627040953
10,0	**13627011000**	1/2"	13627041270
12,0	**13627011200**	5/8"	13627041588
14,0	**13627011400**	3/4"	13627041905
16,0	**13627011600**	1"	13627042540
18,0	**13627011800**		
20,0	**13627012000**		
22,0	**13627012200**		
25,0	**13627012500**		

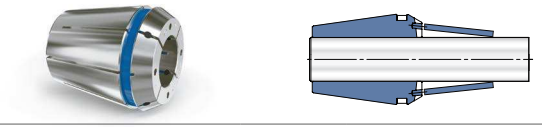
FAHRION® FAR BEYOND PRECISION

High Precison Collets 2 µm



GERC40-**HPDD** Ø 6-25 mm

Sealed for Inner Coolant Supply and Jet Holes

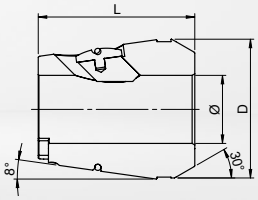


◰ =	2 µm
D =	41
L =	46

Ø mm	Order-No.	Ø inch	Order-No.
6,0	13637010600	1/4"	13637040635
8,0	13637010800	3/8"	13637040953
10,0	**13637011000**	1/2"	13637041270
12,0	**13637011200**	5/8"	13637041588
14,0	**13637011400**	3/4"	13637041905
16,0	**13637011600**	1"	13637042540
18,0	**13637011800**		
20,0	**13637012000**		
25,0	**13637012500**		

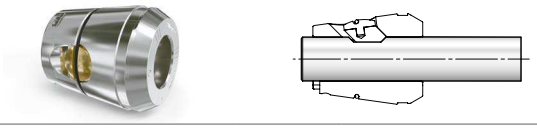
Wedge Collets 3 µm

Protect



GERC40-**W** Ø 16-25 mm

Pull-Out Protection

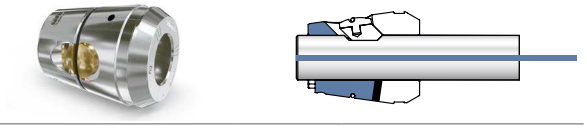


◰ =	3 µm
D =	41
L =	46

Ø mm	Order-No.	Ø inch	Order-No.
16,0	**13917011600**	5/8"	13917041588
20,0	**13917012000**	3/4"	13917041905
25,0	13917012500		

GERC40-**WD** Ø 16-20 mm

Sealed with Pull-Out Protection



◰ =	3 µm
D =	41
L =	46

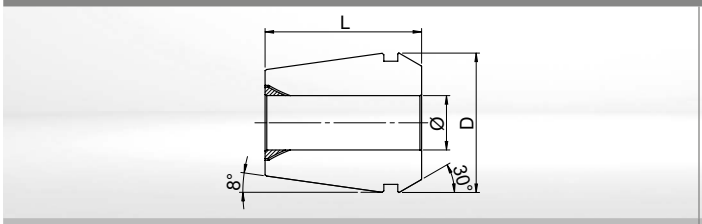
Ø mm	Order-No.	Ø inch	Order-No.
16,0	**13927011600**	5/8"	**13927041588**
20,0	**13927012000**	3/4"	**13927041905**

GERC

ACCESSORIES FOR CHUCKS
DPC40 | UPC40 | FPC40

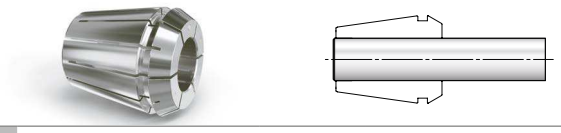
Precision Collets 5 µm

Protect



GERC40-**B** Ø 3-26 mm

Standard



⍁ =	5 µm
D =	41
L =	46

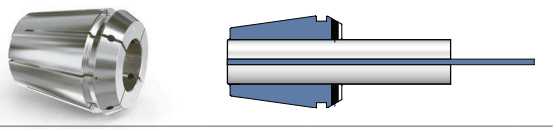
Ø mm	Order-No.	Ø mm	Order-No.
3,0	**13717010300**	19,0	**13717011900**
3,5	13717010350	19,5	13717011950
4,0	**13717010400**	20,0	**13717012000**
4,5	13717010450	20,5	13717012050
5,0	**13717010500**	21,0	**13717012100**
5,5	13717010550	21,5	13717012150
6,0	**13717010600**	22,0	**13717012200**
6,5	13717010650	22,5	13717012250
7,0	**13717010700**	23,0	**13717012300**
7,5	13717010750	23,5	13717012350
8,0	**13717010800**	24,0	**13717012400**
8,5	13717010850	24,5	13717012450
9,0	**13717010900**	25,0	**13717012500**
9,5	13717010950	25,5	13717012550
10,0	**13717011000**	26,0	**13717012600**
10,5	13717011050		
11,0	**13717011100**		
11,5	13717011150	Ø inch	Order-No.
12,0	**13717011200**	1/8"	**13717040318**
12,5	13717011250	3/16"	13717040476
13,0	**13717011300**	1/4"	**13717040635**
13,5	13717011350	5/16"	13717040794
14,0	**13717011400**	3/8"	**13717040953**
14,5	13717011450	7/16"	13717041111
15,0	**13717011500**	1/2"	**13717041270**
15,5	13717011550	9/16"	13717041429
16,0	**13717011600**	5/8"	**13717041588**
16,5	13717011650	11/16"	13717041746
17,0	**13717011700**	3/4"	**13717041905**
17,5	13717011750	13/16"	13717042064
18,0	**13717011800**	7/8"	**13717042223**
18,5	13717011850	1"	**13717042540**

GERC40-**B** Set

Content of set (Ø mm)	Order-No.	Set
4,0-26,0/ 1,0 Increments	1371716	23pieces

GERC40-**BD** Ø 6-25 mm

Sealed for Inner Coolant Supply

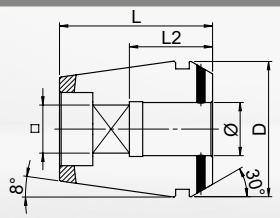


⍁ =	5 µm
D =	41
L =	46

Ø mm	Order-No.
6,0	**13727010600**
8,0	**13727010800**
10,0	**13727011000**
12,0	**13727011200**
14,0	**13727011400**
16,0	**13727011600**
18,0	**13727011800**
20,0	**13727012000**
22,0	**13727012200**
25,0	**13727012500**

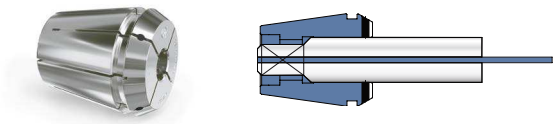
FAHRION® FAR BEYOND PRECISION

Tap Collets 10 µm



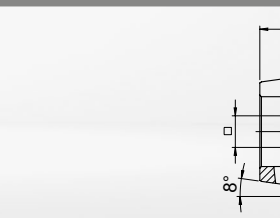
GERC40-**GBD** Ø 6-25 mm

Sealed for Inner Coolant Supply



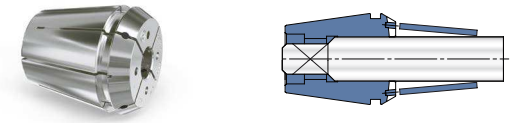
⍁ =		10 µm
D =		41
L =		46

Ø / □ mm	L2	Order-No.
6,0/5,0	18	**13827010600**
6,3/5,0	18	13827010630
7,0/5,6	18	**13827010700**
7,1/5,6	18	13827010710
8,0/6,3	22	**13827010800**
9,0/7,1	22	**13827010900**
10,0/8,0	25	**13827011000**
11,0/9,0	25	**13827011100**
11,2/9,0	25	13827011120
12,0/9,0	25	**13827011200**
12,5/10,0	25	13827011250
14,0/11,2	25	**13827011400**
16,0/12,5	25	**13827011600**
18,0/14,5	33	**13827011800**
20,0/16,0	33	**13827012000**
22,0/18,0	33	**13827012200**
25,0/20,0	33	**13827012500**



GERC40-**GBDD** Ø 6-25 mm

Sealed for Inner Coolant Supply and Jet Holes



⍁ =		10 µm
D =		41
L =		46

Ø / □ mm	L2	Order-No.
6,0/5,0	18	13837010600
7,0/5,6	18	13837010700
8,0/6,3	22	13837010800
9,0/7,1	22	13837010900
10,0/8,0	25	13837011000
11,0/9,0	25	13837011100
12,0/9,0	25	13837011200
14,0/11,2	25	13837011400
16,0/12,5	25	13837011600
18,0/14,5	33	13837011800
20,0/16,0	33	13837012000
22,0/18,0	33	13837012200
25,0/20,0	33	13837012500

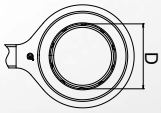
ACCESSORIES



ACCESSORIES FOR CHUCKS
MPC | DPC | UPC | FPC | AFC

Roller Bearing Wrenches with Handle

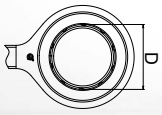




D = Wrench Ø	Description	Order-No.	for Chucks
16	RH16	**49904000500**	MPC11/MPC11C
22	RO22	**4990500**	MPC16/MPC16C
24	RO24	**4990600**	MPC16T
30	RO30	**4990900**	DPC16
32	RO32	**4991100**	DPC20
40	RO40	**4991400**	DPC25/AFC25
50	RO50	**4991800**	DPC32/FPC32/AFC32
53	RO53	**4991900**	UPC32
63	RO63	**4992000**	DPC40/FPC40/UPC40

Roller Bearing Heads for Torque Setting Wrenches





D = Wrench Ø	Description	Order-No.	Square	for Chucks
10	DRH10	**49963000100**	9x12	MPC8
16	DRH16	**49934000500**	9x12	MPC11 / MPC11C
22	DRO22	**4993500**	9x12	MPC16 / MPC16C
24	DRO24	**4993600**	9x12	MPC16T
30	DRO30	**4993900**	14x18	DPC16
32	DRO32	**4994100**	14x18	DPC20
40	DRO40	**4994400**	14x18	DPC25/AFC25
50	DRO50	**4994800**	14x18	DPC32/FPC32/AFC32
53	DRO53	**4994900**	14x18	UPC32
63	DRO63	**4995000**	14x18	DPC40/FPC40/UPC40

Torque Setting Wrenches



Description	Order-No.	Square	Torque Range
DRTW-5-30 (9x12)	**4901200**	9x12	5 - 30 Nm
DRTW-5-30 (9x12)	**4901200**	9x12	5 - 30 Nm
DRTW-10-80 (9x12)	**4901400**	9x12	10 - 80 Nm
DRTW-10-80 (9x12)	**4901400**	9x12	10 - 80 Nm
DRTW-10-80 (14x18)	**4901500**	14x18	10 - 80 Nm
DRTW-10-80 (14x18)	**4901500**	14x18	10 - 80 Nm
DRTW-20-200 (14x18)	**4901600**	14x18	20 - 200 Nm
DRTW-20-200 (14x18)	**4901600**	14x18	20 - 200 Nm
DRTW-20-200 (14x18)	**4901600**	14x18	20 - 200 Nm
DRTW-20-200 (14x18)	**4901600**	14x18	20 - 200 Nm

FAHRION® FAR BEYOND PRECISION

ACCESSORIES FOR CHUCKS
MPC | DPC | UPC | FPC | AFC

Mounting Devices



Description	Order-No.	D	for Interfaces
TBRS25	**4980200**	25	HSK25
TBRS32	**4980400**	32	HSK32
TBRS40	**4980600**	40	HSK40
TBRS46	**4980800**	46	BT30, BTP30
TBRS50	**4981000**	50	HSK50, SK30, PSC50
TBRS63	**4981200**	63	HSK63, SK40, BT40, BTP40, PSC63
TBRS80	**4981600**	80	PSC80
TBRS97	**4981800**	97,5	SK50
TBRS100	**4982000**	100	HSK100, BT50, BTP50

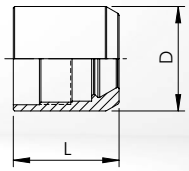


- for easy and safe clamping of the flange interface using rollers for mounting and removing cutting tools, therefore self clamping and ideal for HSK forms E and F as well polygonal shanks
- for all common interfaces such as SK (DIN 69871-1), HSK (DIN 69893 / ISO 12164 - forms A, B, C, D, E, F), polygonal shanks (ISO 26623-1) and BT (JIS B 6339)

ACCESSORIES FOR CHUCKS
MPC | DPC | UPC | FPC | AFC

Mini Clamping Nuts

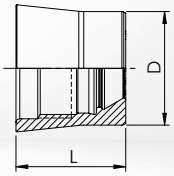




Description	Order-No.	D	L	for Collets	Clamping range
MPC8	**6184000**	10	11,1	GERC8-B/HP	1,0-5,0
MPC11	**6184100**	16	16,2	GERC11-B/HP	1,0-7,0
MPC16	**6184300**	22	20,9	GERC16-B/HP/GBD	1,0-10,0

Mini Clamping Nuts, tapered

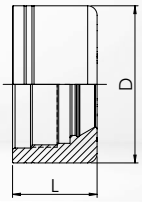




Description	Order-No.	D	L	for Collets	Clamping range
MPC16T	**6182300**	24	23,2	GERC16-B/HP/GBD	1,0-10,0

Clamping Nuts



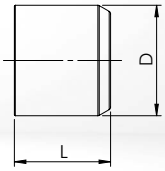


Description	Order-No.	D	L	for Collets	Clamping range
DPC16	**6380300**	30	23,4	GERC16-B/HP/GBD	1,0-10,0
DPC20	**6380400**	32	24,6	GERC20-B/HP/GBD	1,0-13,0
DPC25	**6380500**	40	25,6	GERC25-B/HP/GBD	1,0-16,0
DPC32	**6380600**	50	26,9	GERC32-B/HP/GBD	2,0-20,0
DPC40	**6380700**	63	31,5	GERC40-B/HP/GBD	3,0-26,0

FAHRION® FAR BEYOND PRECISION

Mini Clamping Nuts with collapse -0,4 mm

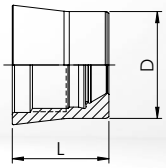




Description	Order-No.	D	L	for Collets	Clamping range
CP16M-HSS-Ø-0,4	**4183200**	22	20,9	GERC16-B/HP	1,0-10,0

Mini Clamping Nuts, tapered with collapse -0,4 mm

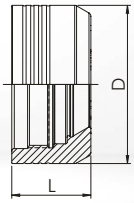




Description	Order-No.	D	L	for Collets	Clamping range
CPC16-HSS-Ø-0,4	**4184200**	24	23,2	GERC16-B/HP	1,0-10,0

Clamping Nuts with collapse -0,4 mm



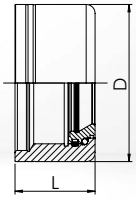


Description	Order-No.	D	L	for Collets	Clamping range
CP16-HSS-Ø-0,4	**4185200**	30	21,3	GERC16-B/HP	1,0-10,0
CP20-HSS-Ø-0,4	**4185300**	32	22,8	GERC20-B/HP	1,0-13,0
CP25-HSS-Ø-0,4	**4185400**	40	23,8	GERC25-B/HP	1,0-16,0
CP32-HSS-Ø-0,4	**4185500**	50	24,9	GERC32-B/HP	2,0-20,0

ACCESSORIES FOR CHUCKS
MPC | DPC | UPC | FPC | AFC

Clamping Nuts, multi-part

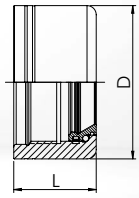




Description	Order-No.	D	L	for Collets	Clamping range
UPC32	**6790600**	53	27	GERC32-B/HP/GBD	2,0-20,0
UPC40	**6790700**	63	31,5	GERC40-B/HP/GBD	3,0-26,0

Clamping Nuts, multi-part



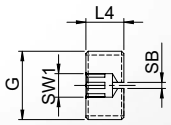


Description	Order-No.	D	L	for Collets	Clamping range
FPC32	**6390600**	50	26,9	GERC32-B/HP/GBD	2,0-20,0
FPC40	**6390700**	63	31,5	GERC40-B/HP/GBD	3,0-26,0

ACCESSORIES FOR CHUCKS
MPC | DPC | UPC | FPC | AFC

Adjustable Stop Screws, short

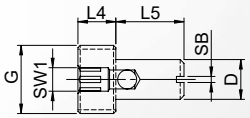




Description	Order-No.	G	SW1	SB	L4	for Chucks
AS-CP8M-U	**44980000100**	M5x0,8	2,5	1,2	5	MPC8
AS-CP11-U	**44981000100**	M8x1	4	1,6	8	MPC11
AS-CP16-U	**44982000100**	M11x1	6	1,6	8	MPC16, MPC16T, DPC16
AS-CP20-U	**44983000100**	M14x1	5	1,5	10	DPC20
AS-CP25-U	**44984000102**	M18x1,5	6	1,6	10	DPC25
AS-CP32-U	**44984000103**	M22x1,5	6	1,6	12	DPC32, UPC32
AS-CP40-U	**44985000100**	M28x1,5	6	1,8	25	DPC40, UPC40

Adjustable Stop Screws, long





Description	Order-No.	G	SW1	SB	L4	L5	D	for Chucks
AS-CP11-W	**44981000200**	M8x1	4	1,2	8	10	4,5	MPC11
AS-CP16-W	**44982000200**	M11x1	6	1,2	8	14	7	MPC16, MPC16T, DPC16
AS-CP20-W	**44983000200**	M14x1	5	1,6	10	14	8	DPC20
AS-CP25-W	**44984000202**	M18x1,5	6	1,6	10	18	10,5	DPC25
AS-CP32-W	**44984000203**	M22x1,5	6	1,6	10	18	10,5	DPC32, UPC32
AS-CP40-W	**44985000200**	M28x1,5	6	1,8	22	18	10,5	DPC40, UPC40

Coolant Supply Tubes



Description	Order-No.	for HSK	Form	G
IKR-HSK25	2490200	25	A and E	M8x1
IKR-HSK32	2490300	32	A and E	M10x1
IKR-HSK40	2490400	40	A and E	M12x1
IKR-HSK50	2490500	50	A and E	M16x1
IKR-HSK63	**2490600**	63	A and E	M18x1
IKR-HSK100	2490800	100	A and E	M24x1,5

Wrenches for Coolant Supply Tubes

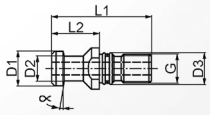


Description	Order-No.	for HSK
SCHL-IKR-HSK25	2492200	25
SCHL-IKR-HSK32	2492300	32
SCHL-IKR-HSK40	2492400	40
SCHL-IKR-HSK50	2492500	50
SCHL-IKR-HSK63	**2492600**	63
SCHL-IKR-HSK100	2492800	100

ACCESSORIES FOR CHUCKS
MPC | DPC | UPC | FPC | AFC

Pull Studs DIN 69872-A with Bore

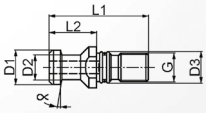




Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-DIN-A	**2910500**	54	26	19	14	17	15 °	M16	50	40
AZB50-DIN-A	**2910700**	74	34	28	21	25	15 °	M24	150	50

Pull Studs DIN 69872-B without Bore

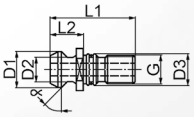




Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-DIN-B	2911500	54	26	19	14	17	15 °	M16	50	40
AZB50-DIN-B	2911700	74	34	28	21	25	15 °	M24	150	50

Pull Studs ISO 7388/II-B with Bore

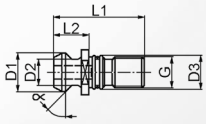




Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-ISO-A	2920500	44,5	16,4	18,95	12,95	17	45 °	M16	50	40
AZB50-ISO-A	2920700	65	25,5	29	19,6	25	45 °	M24	150	50

Pull Studs ISO 7388-B without Bore





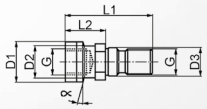
Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-ISO-B	2921500	44,5	16,4	18,95	12,95	17	45 °	M16	50	40
AZB50-ISO-B	2921700	65	25,5	29	19,6	25	45 °	M24	150	50

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ACCESSORIES FOR CHUCKS
MPC | DPC | UPC | FPC | AFC

Pull Studs DIN 2080 with Inner Thread

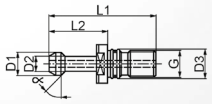




Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-DIN2080-G	2943500	54	25	25	21,6	17	15 °	M16	50	40
AZB50-DIN2080-G	2943700	65	25,1	39,3	32	25	15 °	M24	150	50

Pull Studs BT 45° (JIS B 6339) with Bore

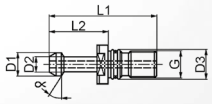




Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB30-BT-45°-A	**2930300**	43	23	11	7	12,5	45 °	M12	20	30
AZB40-BT-45°-A	**2930500**	60	35	15	10	17	45 °	M16	50	40
AZB50-BT-45°-A	2930700	85	45	23	17	25	45 °	M24	150	50

Pull Studs BT 30° (JIS B 6339) with Bore

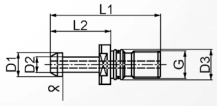




Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB30-BT-30°-A	**2931300**	43	23	11	7	12,5	30 °	M12	20	30
AZB40-BT-30°-A	**2931500**	60	35	15	10	17	30 °	M16	50	40
AZB50-BT-30°-A	2931700	85	45	23	17	25	30 °	M24	150	50

Pull Studs BT 90° (JIS B 6339) with Bore



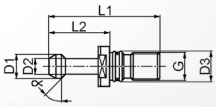


Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-BT-90°-A	2932500	60	35	15	10	17	90 °	M16	50	40
AZB50-BT-90°-A	2932700	85	45	23	17	25	90 °	M24	150	50

ACCESSORIES FOR CHUCKS
MPC | DPC | UPC | FPC | AFC

Pull Studs BT 45° (JIS B 6339) without Bore

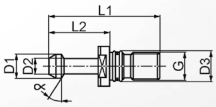




Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB30-BT-45°-B	**2933300**	43	23	11	7	12,5	45 °	M12	20	30
AZB40-BT-45°-B	**2933500**	60	35	15	10	17	45 °	M16	50	40
AZB50-BT-45°-B	2933700	85	45	23	17	25	45 °	M24	150	50

Pull Studs BT 30° (JIS B 6339) without Bore

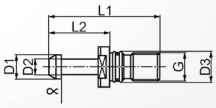




Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB30-BT-30°-B	2934300	43	23	11	7	12,5	30 °	M12	20	30
AZB40-BT-30°-B	2934500	60	35	15	10	17	30 °	M16	50	40
AZB50-BT-30°-B	2934700	85	45	23	17	23	30 °	M24	150	50

Pull Studs BT 90° (JIS B 6339) without Bore



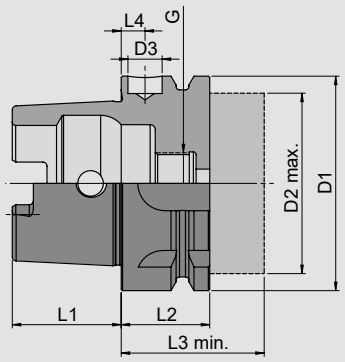


Description	Order-No.	L1	L2	D1	D2	D3	α	G	max. Nm	for Taper Shanks
AZB40-BT-90°-B	2935500	60	35	15	10	17	90 °	M16	50	40
AZB50-BT-90°-B	2935700	85	45	23	17	25	90 °	M24	150	50

FAHRION®
FAR BEYOND PRECISION

TECHNICAL SECTION

TAPER OVERVIEW



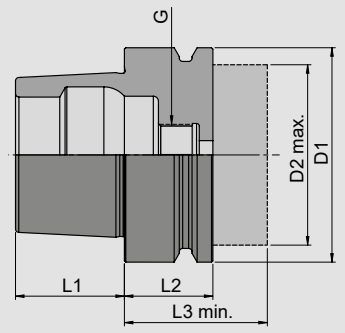
Case-hardened material, hardened and ground
Surface hardness: 58-2 HRC
Minimum core tensile strength: 1,000 N/mm²

Hollow Tapers DIN 69893-1/ISO 12164-1 – HSK-A

HSK-	D1	D2 max.	D3	L1	L2	L3 min.	L4	G
A32	32	26	10	16	20	35	7	M10x1
A40	40	34	-	20	20	35	-	M12x1
A50	50	42	-	25	26	42	-	M16x1
A63	63	53	10	32	26	42	7	M18x1
A80	80	68	10	40	26	42	7	M20x1,5
A100	100	88	10	50	29	45	7	M24x1,5
A125	125	111	10	63	29	45	7	M30x1,5
A160	160	144	10	80	31	47	7	M35x1,5

HSK-A32 to HSK-A63 and A100 in this catalogue – others on request

For **automatic** tool change with gripping and indexing groove.
Manual operation possible through an access hole in the taper, e.g. HSK-A is compatible with interface HSK-C (**manual tool change**).
Torque is transferred by drive slots and the taper.
RFID Chip Holes – standard from range HSK-A63 onwards.



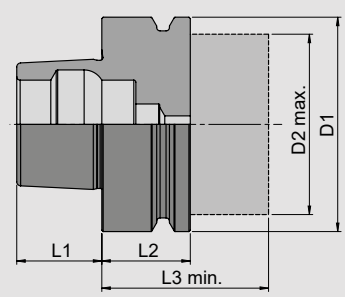
Case-hardened material, hardened and ground
Surface hardness: 58-2 HRC
Minimum core tensile strength: 1,000 N/mm²

Hollow Tapers DIN 69893-5 – HSK-E

HSK-	D1	D2 max.	L1	L2	L3 min.	G
E25	25	20	13	10	20	M8x1
E32	32	26	16	20	35	M10x1
E40	40	34	20	20	35	M12x1
E50	50	42	25	26	42	M16x1
E63	63	53	32	26	42	M18x1

HSK-E25 to E50 in this catalogue – others on request

For **automatic** tool change.
Manual confirmation is **not** possible because no access hole exists in the cone.
Torque is transferred by the taper



Case-hardened material, hardened and ground
Surface hardness: 58-2 HRC
Minimum core tensile strength: 1,000 N/mm²

Hollow Tapers DIN 69893-6 – HSK-F

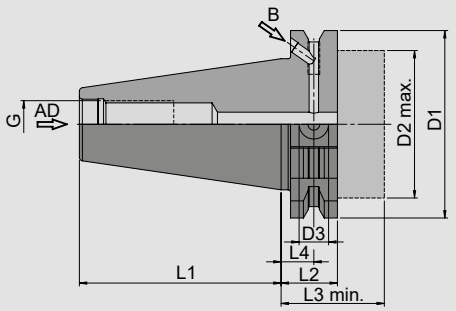
HSK-	D1	D2 max.	L1	L2	L3 min.
F50	50	42	25	26	42
F63	63	53	32	26	42

HSK-F50 to F63 in this catalogue

For **automatic** tool change.
Manual confirmation is **not** possible because no access hole exists in the cone.
Torque is transferred by the taper

HSK Form B, C and D are not common, but available on request.

FAHRION® FAR BEYOND PRECISION

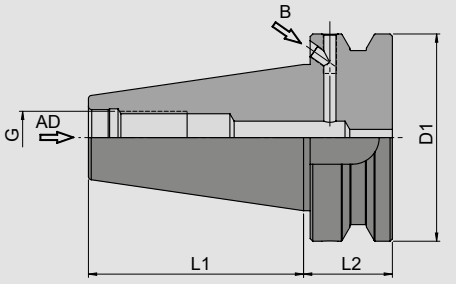


Case-hardened material, hardened and ground
Surface hardness: 60-2 HRC
Minimum core tensile strength: 950 N/mm²
Taper angle tolerance AT3

Taper Shanks DIN 69871-1 (DIN ISO 7388-1) – SK

SK	D1	D2 max.	D3	L1	L2	L3 min.	L4	G
30	50	45	10	47,8	19,1	35	11,1	M12
40	63,55	50	10	68,4	19,1	35	11,1	M16
50	97,5	80	10	101,75	19,1	35	11,1	M24
SK30 to SK50 in this catalogue								

For **automatic** tool change.
Coolant supply AD (AD) and / or AD/B (B).
RFID Chip Holes – standard with SK40 and SK50.

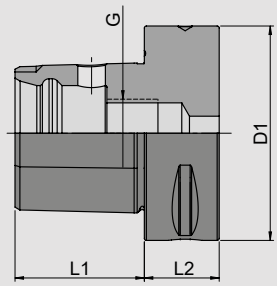


Case-hardened material, hardened and ground
Surface hardness: 60-2 HRC
Minimum core tensile strength: 950 N/mm²
Taper angle tolerance AT3

Taper Shanks JIS B 6339 (DIN ISO 7388-2) – BT/BTP

BT/BTP	D1	L1	L2	G
30	46	48,4	22	M12
40	63	65,4	27	M16
50	100	101,8	38	M24
BT/BTP30 to BT/BTP50 in this catalogue				

For **automatic** tool change.
Coolant supply AD (BT) and / or AD/B (BTB).
RFID Chip Holes – on request!



Case-hardened material, hardened and ground
Surface hardness: 60-2 HRC
Minimum core tensile strength: 950 N/mm²

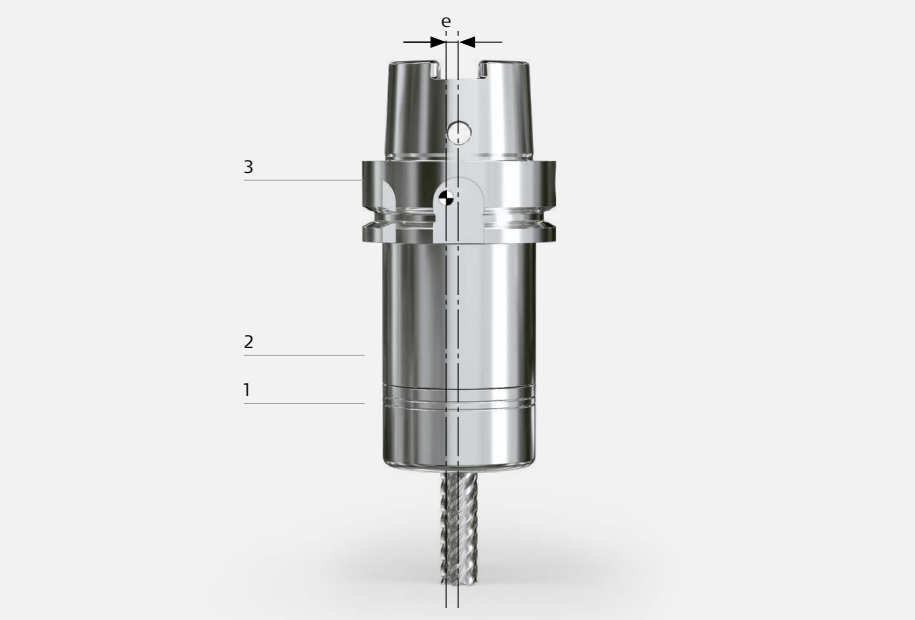
Polygonal Shank ISO 26623-1 – PSC

PSC	D1	L1	L2	G
32 (C3)	32	19	15	M12x1,5
40 (C4)	40	24	20	M14x1,5
50 (C5)	50	30	20	M16x1,5
63 (C6)	63	38	22	M20x2
80 (C8)	80	48	30	M20x2
PSC50 to PSC80 in this catalogue – others on request				

For **automatic** tool change.
RFID Chip Holes – on request!

BALANCING

Explanations to our Balancing Information



Imbalance
- Rotor centre of gravity **2** is outside its rotational axis **1** (=offset e **3**)

Causes
- Unsymmetrical bores and milling at the tool holder (e.g. bei taper shanks DIN ISO 7388-1 (so far DIN 69871) and DIN 69893/ISO 12164 HSK form A and B)
- Unsymmetrical shape of the tool (e.g. clamping surface at the milling cutter)
- Production tolerances (runout)
- Spindle runout

Consequences
Centrifugal forces cause vibrations. These cause:
- Damage to the spindle bearings
- Mediocre surface quality
- Insufficient repeatability of accuracy
- Reduction in tool life
- Noise

Requirements
Balancing is necessary whenever optimum working conditions have to be achieved e.g.:
- Surface quality
- Production accuracies
- Tool operational life
- or if prescribed by the machine tool manufacturer (warranty claims!)

However, it is only economically sensible to balance at speeds of 8,000 rpm or higher. At speeds lower than this the cutting forces are as a rule greater than the imbalance forces.

Balancing means – determining the centre of gravity axis and moving it back to the axis of rotation.

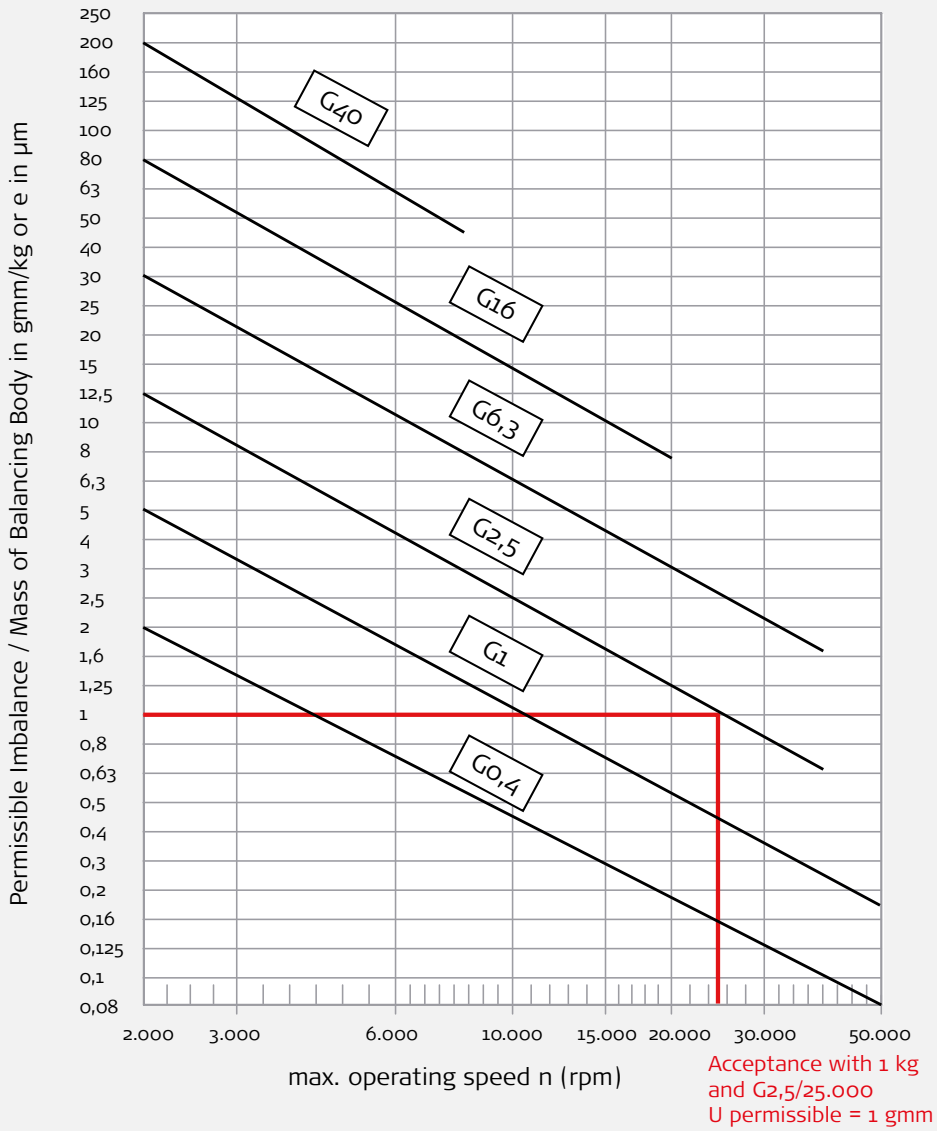
What Balance Grade
Our CENTRO|P precision collet chucks are fine balanced as standard.

Limits to Balancing Grade
According to ISO standard 1940, the balancing standard is described using G. The balancing standard G corresponds to g/mmkg or µm and is in relation to the speed.

As an explanation: At a speed of 9,500 rpm and a weight of 1 kg G2,5 means a permissible offset between the rotational axis and the centre of gravity axis of the spindle of 2.5 µm. At a speed of 19,000 rpm it would be 1.25 µm and at 38,000 rpm 0.625 µm. If the tool holder together with the tool weighs half the amount, i.e. 0.5 kg, the balance will also be halved.

Until now, so as to minimise guarantee claims the machine or spindle manufacturers demanded such excessively fine balancing that their demands could only be met by balancing the chuck and the cutter on the machine spindle.

In order to avoid the high economic costs this caused, draft standard DIN 69888 covering balancing requirements on rotating tool systems was agreed jointly by the machine, spindle, balancing machine and tool manufacturers. The standard is a sensible solution in both technical and economic terms, since in that norm all residual imbalances are indicated in „gmm“ and **not** assigned to a balance grade. Moreover, possible tool change faults are considered.



Grade steps to DIN ISO 1940-1
Permissible residual imbalances in relation to the balancing body weight for different grade steps G depending on the highest operating speed

General Formula

$$G = e \times \omega = \frac{U}{m_R} \times \frac{2 \times \pi \times n}{60} = \frac{U \times \pi \times n}{m_R \times 30}$$

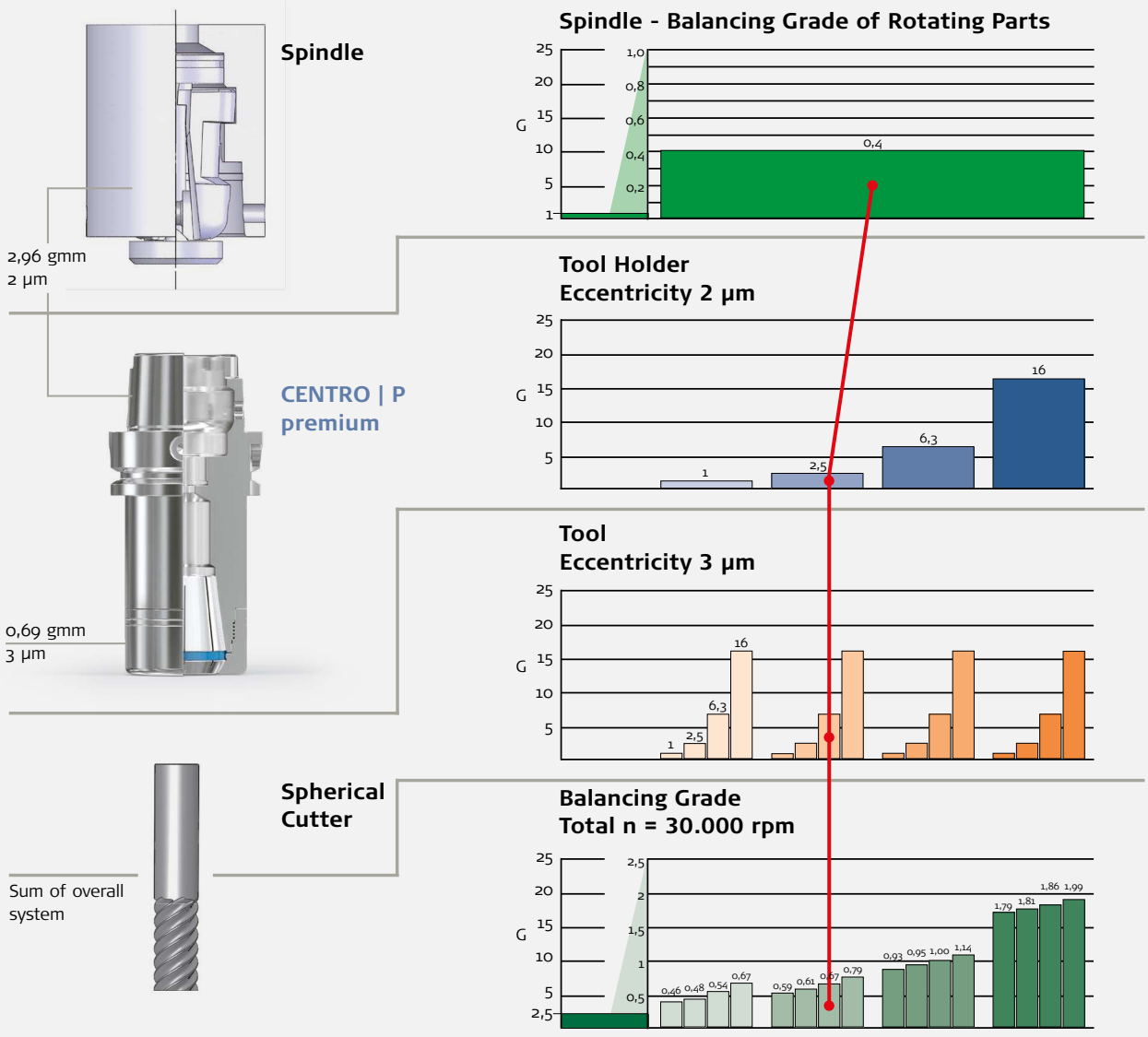
then $$U = \frac{G \times m_R \times 30}{\pi \times n}$$

G = Balancing grade step	[mm/s]
e = Centre of gravity concentricity, related imbalance	[gmm/kg or µm]
n = Speed	[rpm]
U = Imbalance	[gmm]
ω = Angular velocity	[1/sec]
m_R = Weight of the tool or the rotor	[g]

BALANCING

Explanations to our Balancing Information

Calculation of the Total Balancing Grade
of the assembled system (spindle • tool holder • tool)



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Illustration of Balancing Grade Total

$$U_{total} = U_{Spindle} + U_{Tool\ holder} + U_{Tool}$$

Example

$$U_{total} = U_{Spindle\ (G\ 0,4)} + U_{Tool\ holder\ (G2,5)} + U_{Tool\ (G6,3)}$$

Calculation of Eccentricity

$$U = \frac{G \times 60}{2 \times \pi \times n} \times m$$

m in g U in gmm

$$U_{Spindle} = \frac{0,4 \times 60}{2 \times \pi \times 30.000} \times 15.000 = 1,910$$

$$U_{Tool\ holder} = \frac{2,5 \times 60}{2 \times \pi \times 30.000} \times 1.487 = 1,176$$

$$U_{Tool} = \frac{6,3 \times 60}{2 \times \pi \times 30.000} \times 230 = 0,461$$

16.708 m_{total} in g 3,547 U_{total} in gmm

Balancing grade conversion of the total system

$$G = U_{total} \times 2 \times \pi \times \frac{n}{60 \times m_{total}}$$

Example

$$G = 3,547_{gmm} \times 2 \times \pi \times \frac{30.000 \times rpm}{60s \times 16.708g} = \mathbf{0,67}$$

Calculation scheme with kind permission of Gühring oHG, Albstadt

EXPLANATIONS

**All items with a bold item number are in stock.
All other items are available either from stock
or at short notice.**



**All products with this symbol are protected
with FAHRION|Protect**



Concentricity
Measured at 3 x D overhang

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