

ZOLLER-Tooling Solutions
HPC-High-Precision-ER-Collet-Chuck

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HAWK EYE®



ZOLLER-Tooling Solutions

Werkzeug-Spannsysteme Tool Holding Systems

HPC-Präzisions-ER-Spannzangenfutter HAWK EYE®

HPC-High-Precision-ER-Collet-Chuck HAWK EYE®



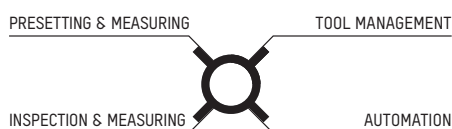
Empfohlene Anzugsmomente für HPC-Präzisions-ER-Spannzangenfutter HAWK EYE®

Recommended clamping torque for HPC-High-Precision-ER-Collet-Chuck HAWK EYE®

Durchmesser / Diameter	ER 11 «Mini»	ER 16 «Mini»	ER 16	ER 20	ER 25	ER 32	ER 40
1,00	6 Nm	8 Nm	10 Nm	15 Nm	25 Nm		
1,50	6 Nm	8 Nm	10 Nm	15 Nm	25 Nm		
2,00	8 Nm	10 Nm	15 Nm	20 Nm	25 Nm	35 Nm	
2,50	8 Nm	10 Nm	15 Nm	20 Nm	25 Nm	35 Nm	
3,00	10 Nm	15 Nm	20 Nm	25 Nm	25 Nm	35 Nm	60 Nm
3,50	10 Nm	15 Nm	20 Nm	25 Nm	35 Nm	50 Nm	60 Nm
4,00	10 Nm	20 Nm	25 Nm	30 Nm	35 Nm	50 Nm	60 Nm
4,50	10 Nm	20 Nm	25 Nm	30 Nm	35 Nm	50 Nm	60 Nm
5,00	10 Nm	20 Nm	25 Nm	30 Nm	35 Nm	60 Nm	70 Nm
5,50	10 Nm	20 Nm	25 Nm	30 Nm	35 Nm	60 Nm	70 Nm
6,00	10 Nm	30 Nm	40 Nm	50 Nm	55 Nm	60 Nm	70 Nm
6,50	10 Nm	30 Nm	40 Nm	50 Nm	55 Nm	60 Nm	70 Nm
7,00	10 Nm	30 Nm	40 Nm	50 Nm	60 Nm	90 Nm	100 Nm
8,00		30 Nm	40 Nm	50 Nm	60 Nm	90 Nm	100 Nm
9,00		30 Nm	50 Nm	70 Nm	60 Nm	90 Nm	100 Nm
10,00		30 Nm	50 Nm	70 Nm		100 Nm	110 Nm
11,00				70 Nm		100 Nm	110 Nm
12,00				70 Nm		100 Nm	120 Nm
13,00				70 Nm		100 Nm	120 Nm
14,00						100 Nm	120 Nm
15,00						110 Nm	130 Nm
16,00						110 Nm	130 Nm
17,00						140 Nm	170 Nm
18,00						140 Nm	170 Nm
19,00						140 Nm	170 Nm
20,00						140 Nm	170 Nm
21,00							190 Nm
22,00							190 Nm
23,00							190 Nm
24,00							190 Nm
25,00							190 Nm
26,00							190 Nm

Beim „Schlichten“ Anzugsmoment um 30 % reduzieren, um den Prozess zu optimieren - bessere Dämpfungseigenschaft!

To optimize the finishing process please reduce the clamping torque by 30% - for better damping!



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 Subject to technical modifications
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