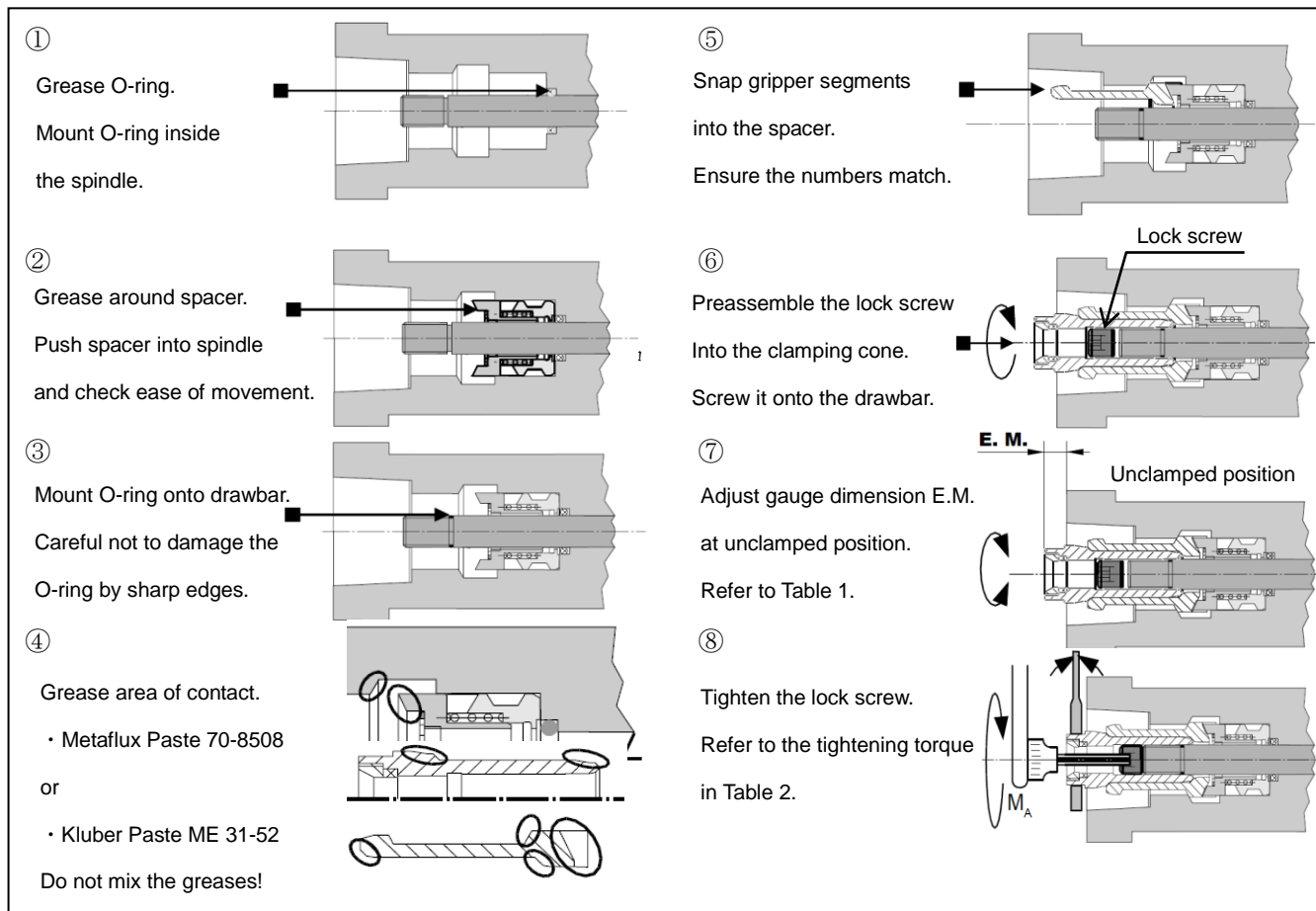


## HSK Clamping Unit Mounting Instructions

Clean spindle inside contour, make sure that edges are properly rounded.



※ Check E.M.dimension after approx. 100 tool changes. Retighten the lock screw through clamped tool.

Table.1 Gauge dimension

E25	6.5 mm
A32/B40/E32	8.5 mm
A40/B50/E40/F50	8.5 mm
A50/B63/E50/F63	10.5 mm
A63/B80/E63/F80	10.5 mm
A80/B100	13 mm
A100/B125	13 mm
A125/B160	16.5 mm

Table.2 Tightening torque

E25	7 Nm
A32/B40/E32	10 Nm
A40/B50/E40/F50	15 Nm
A50/B63/E50/F63	20 Nm
A63/B80/E63/F80	30 Nm
A80/B100	30 Nm
A100/B125	50 Nm
A125/B160	100 Nm

### Attention

- No rotation without clamped tool.
- Only use technically perfect tools.
- Refer to the operating instructions for maintenance in details.

\* Changes to this document are subject to change without notice.