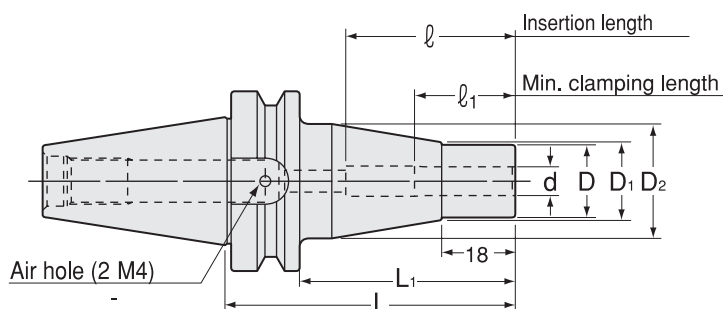
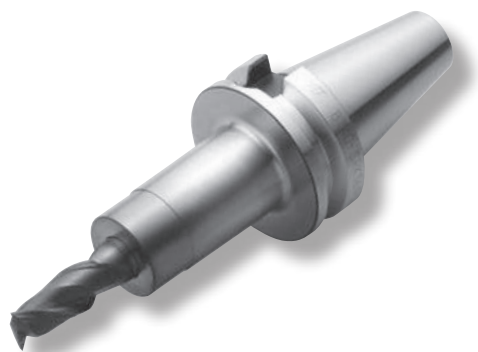


## Shrink Fit ( Heavy Type )

- Shrinkage method clamps a cutting tool firmly by heating and cooling the chuck. High precision, rigidity and strong clamping force. (Heavy Type)



## Metric Sizes

Unit : Metric

| Code          | Model             | d  | L   | L1 | D  | D1 | D2 | l1 | l        | kg  |
|---------------|-------------------|----|-----|----|----|----|----|----|----------|-----|
| 3060 01206075 | BT30 -SRK6A -75   | 6  | 75  | 53 | 16 | 17 | 30 | 26 | 26 ~ 36  | 0.8 |
| 3060 01208075 | BT30 -SRK8A -75   | 8  | 75  | 53 | 19 | 20 | 32 | 26 | 26 ~ 50  | 0.8 |
| 3060 01110075 | BT30 -SRK10A -75  | 10 | 75  | 53 | 24 | 25 | 34 | 32 | 32 ~ 50  | 0.9 |
| 3060 01112075 | BT30 -SRK12A -75  | 12 | 75  | 53 | 28 | 29 | 34 | 37 | 37 ~ 70  | 0.9 |
| 3060 01116075 | BT30 -SRK16A -75  | 16 | 75  | 53 | 32 | 33 | 34 | 40 | 40 ~ 80  | 0.9 |
| 3060 01306090 | BT40 -SRK6A -90   | 6  | 90  | 63 | 16 | 17 | 30 | 26 | 26 ~ 36  | 1.4 |
| 3060 01308090 | BT40 -SRK8A -90   | 8  | 90  | 63 | 19 | 20 | 32 | 26 | 26 ~ 50  | 1.4 |
| 3060 01310090 | BT40 -SRK10A -90  | 10 | 90  | 63 | 24 | 25 | 34 | 32 | 32 ~ 50  | 1.5 |
| 3060 01312090 | BT40 -SRK12A -90  | 12 | 90  | 63 | 28 | 29 | 34 | 37 | 37 ~ 70  | 1.5 |
| 3060 01316090 | BT40 -SRK16A -90  | 16 | 90  | 63 | 32 | 33 | 34 | 40 | 40 ~ 80  | 1.5 |
| 3060 01320090 | BT40 -SRK20A -90  | 20 | 90  | 63 | 36 | 37 | 46 | 42 | 42 ~ 100 | 1.7 |
| 3060 01325105 | BT40 -SRK25A -105 | 25 | 105 | 78 | 46 | 47 | 50 | 48 | 48 ~ 110 | 2.0 |
| 3060 01506105 | BT50 -SRK6A -105  | 6  | 105 | 67 | 16 | 17 | 30 | 26 | 26 ~ 36  | 3.7 |
| 3060 01508105 | BT50 -SRK8A -105  | 8  | 105 | 67 | 19 | 20 | 32 | 26 | 26 ~ 50  | 3.7 |
| 3060 01510105 | BT50 -SRK10A -105 | 10 | 105 | 67 | 24 | 25 | 34 | 32 | 32 ~ 50  | 3.9 |
| 3060 01512105 | BT50 -SRK12A -105 | 12 | 105 | 67 | 28 | 29 | 34 | 37 | 37 ~ 70  | 3.9 |
| 3060 01516105 | BT50 -SRK16A -105 | 16 | 105 | 67 | 32 | 33 | 34 | 40 | 40 ~ 80  | 3.9 |
| 3060 01520105 | BT50 -SRK20A -105 | 20 | 105 | 67 | 36 | 37 | 46 | 42 | 42 ~ 100 | 4.1 |
| 3060 01525120 | BT50 -SRK25A -120 | 25 | 120 | 82 | 46 | 47 | 53 | 48 | 48 ~ 110 | 4.4 |
| 3060 01532120 | BT50 -SRK32A -120 | 32 | 120 | 82 | 56 | 57 | 70 | 51 | 51 ~ 120 | 5.2 |

1. Always use carbide shank tools with h6 tolerance.

2. Use 2pcs. of M4 × 5 (S) hex. screw (included) to close air holes on the chuck when internal coolant is used.

## Heating device chart

| heating device | chuck        |               |
|----------------|--------------|---------------|
|                | SRK6A, SRK8A | SRK10A~SRK32A |
| ISG3400        | Yes          | Yes *         |
| SRK-HA1, HB2   | No           | Yes           |

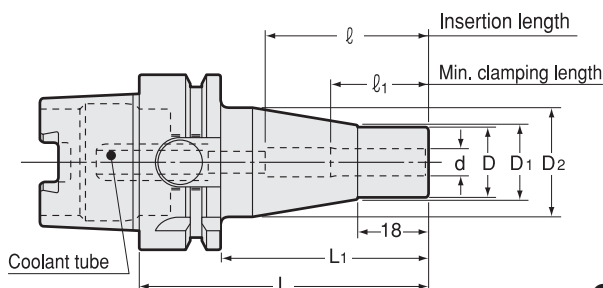
\*Special induction coil is needed. Refer to P.500-501.

## Ordering Example

**BT40 - SRK 10 A - 90**  
 Shank size I.D. (d) Projection length (L)

## Shrink Fit ( Heavy Type )

- Shrinkage method sets a cutting tool firmly by heating and cooling the chuck. High precision, rigidity and strong chucking. (Heavy Type)



- Coolant tube is included.

### Metric Sizes

Unit : Metric

| Code          | Model                | d  | L   | L <sub>1</sub> | D  | D <sub>1</sub> | D <sub>2</sub> | ℓ <sub>1</sub> | ℓ       | kg  |
|---------------|----------------------|----|-----|----------------|----|----------------|----------------|----------------|---------|-----|
| 5640 13106080 | HSK40A -SRK6A -80    | 6  | 80  | 60             | 16 | 17             | 30             | 26             | 26 ~ 36 | 0.4 |
| 5640 13108080 | HSK40A -SRK8A -80    | 8  | 80  | 60             | 19 | 20             | 32             | 26             | 26 ~ 50 | 0.4 |
| 5640 13010080 | HSK40A -SRK10A -80   | 10 | 80  | 60             | 24 | 25             | 34             | 32             | 32 ~ 50 | 0.6 |
| 5640 13012090 | HSK40A -SRK12A -90   | 12 | 90  | 70             | 28 | 29             | 34             | 37             | 37 ~ 70 | 0.6 |
| 5640 13016090 | HSK40A -SRK16A -90   | 16 | 90  | 70             | 32 | 33             | 34             | 40             | 40 ~ 70 | 0.7 |
| 5640 14106080 | HSK50A -SRK6A -80    | 6  | 80  | 54             | 16 | 17             | 30             | 26             | 26 ~ 36 | 0.7 |
| 5640 14108080 | HSK50A -SRK8A -80    | 8  | 80  | 54             | 19 | 20             | 32             | 26             | 26 ~ 50 | 0.7 |
| 5640 14010085 | HSK50A -SRK10A -85   | 10 | 85  | 59             | 24 | 25             | 34             | 32             | 32 ~ 50 | 0.8 |
| 5640 14012090 | HSK50A -SRK12A -90   | 12 | 90  | 64             | 28 | 29             | 34             | 37             | 37 ~ 65 | 0.8 |
| 5640 14016095 | HSK50A -SRK16A -95   | 16 | 95  | 69             | 32 | 33             | 34             | 40             | 40 ~ 70 | 0.8 |
| 5640 14020100 | HSK50A -SRK20A -100  | 20 | 100 | 74             | 36 | 37             | 42             | 42             | 42 ~ 75 | 1.0 |
| 5640 15106080 | HSK63A -SRK6A -80    | 6  | 80  | 54             | 16 | 17             | 30             | 26             | 26 ~ 36 | 0.9 |
| 5640 15108080 | HSK63A -SRK8A -80    | 8  | 80  | 54             | 19 | 20             | 32             | 26             | 26 ~ 50 | 0.9 |
| 5640 15010085 | HSK63A -SRK10A -85   | 10 | 85  | 59             | 24 | 25             | 34             | 32             | 32 ~ 50 | 1.0 |
| 5640 15012090 | HSK63A -SRK12A -90   | 12 | 90  | 64             | 28 | 29             | 34             | 37             | 37 ~ 63 | 1.0 |
| 5640 15016095 | HSK63A -SRK16A -95   | 16 | 95  | 69             | 32 | 33             | 34             | 40             | 40 ~ 65 | 1.1 |
| 5640 15020100 | HSK63A -SRK20A -100  | 20 | 100 | 74             | 36 | 37             | 42             | 42             | 42 ~ 72 | 1.3 |
| 5640 15025115 | HSK63A -SRK25A -115  | 25 | 115 | 89             | 46 | 47             | 53             | 48             | 48 ~ 89 | 1.8 |
| 5640 17106085 | HSK100A -SRK6A -85   | 6  | 85  | 56             | 16 | 17             | 30             | 26             | 26 ~ 36 | 1.2 |
| 5640 17108085 | HSK100A -SRK8A -85   | 8  | 85  | 56             | 19 | 20             | 32             | 26             | 26 ~ 50 | 1.2 |
| 5640 17010090 | HSK100A -SRK10A -90  | 10 | 90  | 61             | 24 | 25             | 34             | 32             | 32 ~ 50 | 1.3 |
| 5640 17012095 | HSK100A -SRK12A -95  | 12 | 95  | 66             | 28 | 29             | 34             | 37             | 37 ~ 62 | 1.3 |
| 5640 17016100 | HSK100A -SRK16A -100 | 16 | 100 | 71             | 32 | 33             | 34             | 40             | 40 ~ 65 | 1.4 |
| 5640 17020105 | HSK100A -SRK20A -105 | 20 | 105 | 76             | 36 | 37             | 42             | 42             | 42 ~ 70 | 1.7 |
| 5640 17025115 | HSK100A -SRK25A -115 | 25 | 115 | 86             | 46 | 47             | 53             | 48             | 48 ~ 80 | 2.2 |
| 5640 17032120 | HSK100A -SRK32A -120 | 32 | 120 | 91             | 56 | 57             | 70             | 51             | 51 ~ 85 | 3.0 |

Always use carbide shank tools with h6 tolerance.

### Heating device chart

| heating device | chuck        |               |
|----------------|--------------|---------------|
|                | SRK6A, SRK8A | SRK10A~SRK32A |
| ISG3400        | Yes          | Yes *         |
| SRK-HA1, HB2   | No           | Yes           |

\*Special induction coil is needed. Refer to P.500-501.

### Ordering Example

**HSK40A - SRK 12 A - 90**

Shank size

I.D. (d)

Projection length (L)