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# Tool Holder Catalog

**IT600**

**VDI 30**

**UniFlex 52**

**LR3202.30011 - 21.05.2015**

0813/Rö

## **Disclaimer**

The illustrations in this documents may deviate from the delivered product. We reserve the right to make changes due to errors or based on technical advances.

## **Abbreviations used in the catalog:**

EC	= external cooling lubricant supply
approx.	= approximately
D	= diameter
max	= maximum
min	= minimum
IC	= internal cooling lubricant supply
MT	= Morse taper
R	= radius
s	= wrench size
ST	= steep taper
SQ	= square

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For accessories for tool holders visit <http://infoshop.index-werke.de/>



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## Work area IT600

Turret and tailstock

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## Work area IT600

Turret and multifunction turret

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## Work area IT600

Turret and multifunction turret

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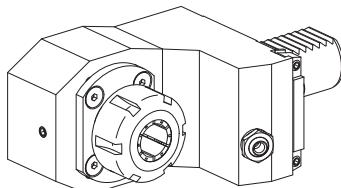
## KR2207.7002 Performance chart

Live tools

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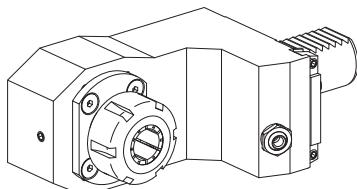
3-2



**W1310003 Drilling tool holder**

<b>Fixation</b>	Setting gauge
<b>Mounting</b>	ER 25
<b>Cooling</b>	external and internal, $p_{max}$ 80 bar
<b>X / Y / Z</b>	70 (2.76) / - / 31 (1.22) mm (")

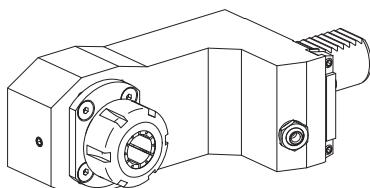
3-3



**W1310007 Drilling tool holder**

<b>Fixation</b>	Setting gauge
<b>Mounting</b>	ER 25
<b>Cooling</b>	external and internal, $p_{max}$ 80 bar
<b>X / Y / Z</b>	90 (3.54) / - / 31 (1.22) mm (")

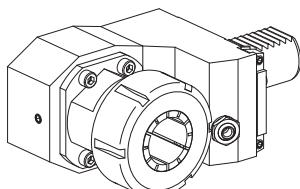
3-4



**W1310009 Drilling tool holder**

<b>Fixation</b>	Setting gauge
<b>Mounting</b>	ER 25
<b>Cooling</b>	external and internal, $p_{max}$ 80 bar
<b>X / Y / Z</b>	110 (4.33) / - / 31 (1.22) mm (")

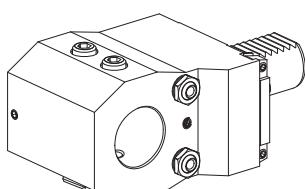
3-5



**W1310005 Drilling tool holder**

<b>Fixation</b>	Setting gauge
<b>Mounting</b>	ER 40
<b>Cooling</b>	external and internal, $p_{max}$ 80 bar
<b>X / Y / Z</b>	70 (2.76) / - / 58 (2.28) mm (")

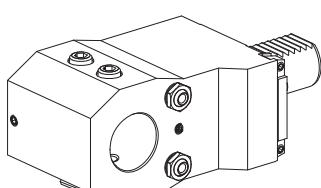
3-6



**W1310004 Drilling tool holder**

<b>Fixation</b>	Setting gauge
<b>Mounting</b>	DIN 1835 B/E D32 (1.26 ")
<b>Cooling</b>	external and internal, $p_{max}$ 80 bar
<b>X / Y / Z</b>	70 (2.76) / - / 35 (1.38) mm (")

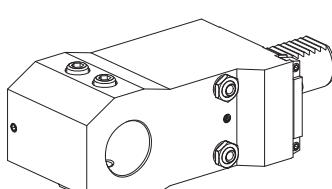
3-7



**W1310008 Drilling tool holder**

<b>Fixation</b>	Setting gauge
<b>Mounting</b>	DIN 1835 B/E D32 (1.26 ")
<b>Cooling</b>	external and internal, $p_{max}$ 80 bar
<b>X / Y / Z</b>	90 (3.54) / - / 35 (1.38) mm (")

3-8

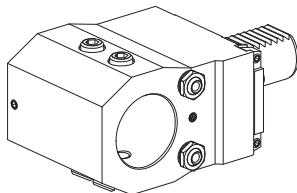


**W1310010 Drilling tool holder**

<b>Fixation</b>	Setting gauge
<b>Mounting</b>	DIN 1835 B/E D32 (1.26 ")
<b>Cooling</b>	external and internal, $p_{max}$ 80 bar
<b>X / Y / Z</b>	110 (4.33) / - / 35 (1.38) mm (")

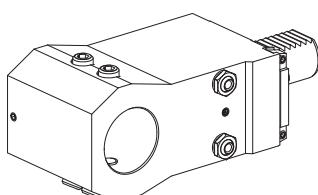
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**W1310006 Drilling tool holder**

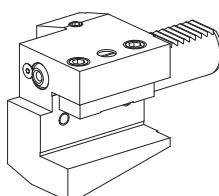
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	DIN 1835 B/E D40 (1.57 ")
<b>Cooling</b>	external and internal, $p_{max}$ 80 bar
<b>X / Y / Z</b>	70 (2.76) / - / 43 (1.69) mm (")



**W1310011 Drilling tool holder**

3-10

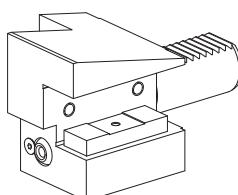
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	DIN 1835 B/E D40 (1.57 ")
<b>Cooling</b>	external and internal, $p_{max}$ 80 bar
<b>X / Y / Z</b>	110 (4.33) / - / 43 (1.69) mm (")



**W1300075 Turning tool holder, Form C1**

3-11

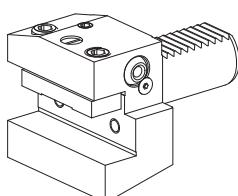
<b>Fixation</b>	-
<b>Mounting</b>	square 25x25
<b>Cooling</b>	external, $p_{max}$ 80 bar
<b>X / Y / Z</b>	70 (2.76) / - / 40 (1.57) mm (")



**W1300105 Turning tool holder, Form C3**

3-12

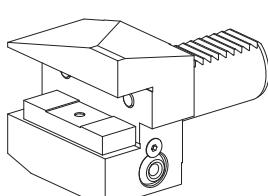
<b>Fixation</b>	-
<b>Mounting</b>	square 25x25
<b>Cooling</b>	external, $p_{max}$ 80 bar
<b>X / Y / Z</b>	70 (2.76) / - / 40 (1.57) mm (")



**W1300089 Turning tool holder, Form B1**

3-13

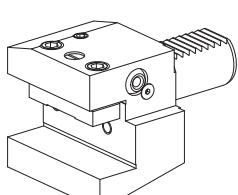
<b>Fixation</b>	-
<b>Mounting</b>	square 20x20
<b>Cooling</b>	external, $p_{max}$ 80 bar
<b>X / Y / Z</b>	35 (1.38) / - / 40 (1.57) mm (")



**W1300107 Turning tool holder, C-axis for main and counter spindles**

3-14

<b>Fixation</b>	-
<b>Mounting</b>	square 20x20
<b>Cooling</b>	external, $p_{max}$ 80 bar
<b>X / Y / Z</b>	40 (1.57) / - / 35 (1.38) mm (")

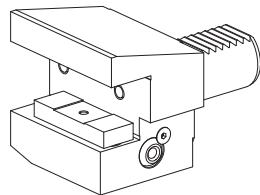


**W1300082 Turning tool holder, Form B1**

3-15

<b>Fixation</b>	-
<b>Mounting</b>	square 25x25
<b>Cooling</b>	external, $p_{max}$ 80 bar
<b>X / Y / Z</b>	55 (2.17) / - / 42.5 (1.67) mm (")

Catalog page



**W1300106 Turning tool holder, C-axis for main and counter spindles**

**3-16**

**Fixation**

—

**Mounting**

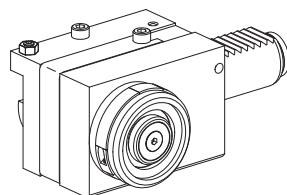
square 25x25

**Cooling**

external,  $p_{\max}$  80 bar

**X / Y / Z**

55 (2.17) / — / 42.5 (1.67) mm (")



**W1300020 Scroll holder**

**3-17**

**Fixation**

none

**Mounting**

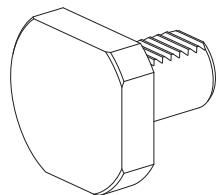
—

**Cooling**

internal,  $p_{\max}$  20 bar

**X / Y / Z**

60 (2.36) / — / 42.5 (1.67) mm (")



**W1300095 Blanking plug, Plastic**

**3-18**

**Fixation**

—

**Mounting**

—

**Cooling**

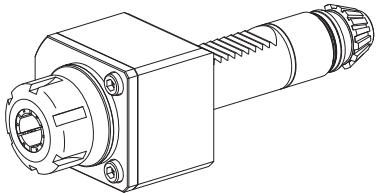
—

**X / Y / Z**

15 (0.59) / — / — mm (")

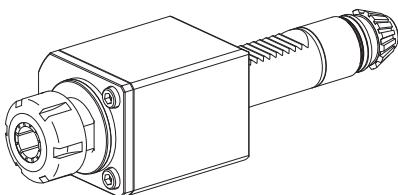
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4-2



**W1305036 Milling unit**

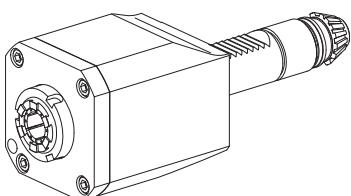
<b>Fixation</b>	–
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, $p_{\max}$ 20 bar
<b>Speed ratio</b>	1:1 (1)
<b>X / Y / Z</b>	82 (3.23) / – / – mm ("")



**W1305037 Milling unit**

4-3

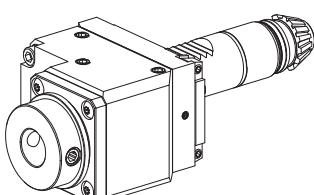
<b>Fixation</b>	–
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, $p_{\max}$ 20 bar
<b>Speed ratio</b>	1:1 (1)
<b>X / Y / Z</b>	115 (4.53) / – / 0 mm ("")



**W1305038 Milling unit**

4-4

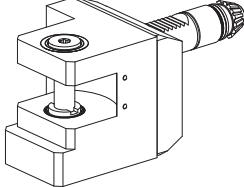
<b>Fixation</b>	–
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, $p_{\max}$ 20 bar
<b>Speed ratio</b>	4.4:1 (4.4)
<b>X / Y / Z</b>	105 (4.13) / – / 0 mm ("")



**W1315009 Milling unit**

4-5

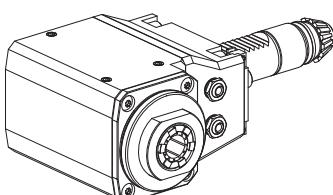
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	D20 (0.79 ")
<b>Cooling</b>	external, $p_{\max}$ 20 bar
<b>Speed ratio</b>	2:1 (2)
<b>X / Y / Z</b>	97 (3.82) / – / 31 (1.22) mm ("")



**W1315008 Circular saw unit**

4-6

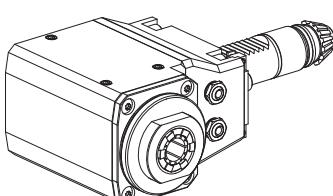
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	Milling shaft D22 (0.87 ")
<b>Cooling</b>	external, $p_{\max}$ 80 bar
<b>Speed ratio</b>	3.97:1 (3.97)
<b>X / Y / Z</b>	90 (3.54) / – / 33 (1.30) mm ("")



**W1315004 Milling unit**

4-7

<b>Fixation</b>	Setting gauge
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, internal optional, $p_{\max}$ 80 bar
<b>Speed ratio</b>	1:1 (1)
<b>X / Y / Z</b>	90 (3.54) / – / 89 (3.50) mm ("")

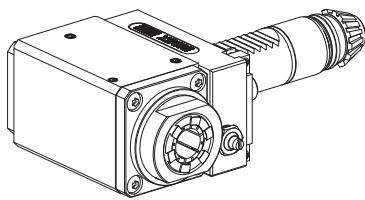


**W1315002 Milling unit**

4-8

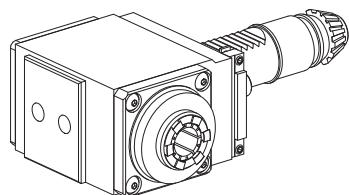
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, internal optional, $p_{\max}$ 80 bar
<b>Speed ratio</b>	2:1 (2)
<b>X / Y / Z</b>	90 (3.54) / – / 89 (3.50) mm ("")

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**4-9**



**W1315011 Milling unit**

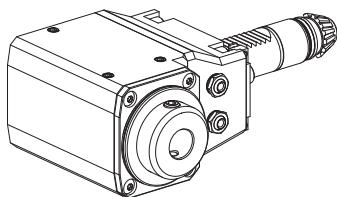
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, internal optional, $p_{max}$ 80 bar
<b>Speed ratio</b>	2:1 (2)
<b>X / Y / Z</b>	50 (1.97) / - / 64 (2.52) mm (")



**W1315000 Milling unit**

**4-10**

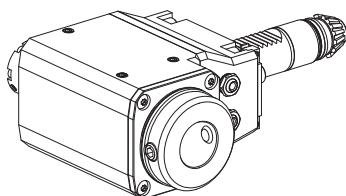
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, $p_{max}$ 20 bar
<b>Speed ratio</b>	2.27:1 (2.27)
<b>X / Y / Z</b>	50 (1.97) / - / 73 (2.87) mm (")



**W1315005 Milling unit**

**4-11**

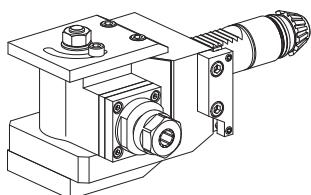
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	DIN 1835 B/E D20 (0.79 ")
<b>Cooling</b>	external, internal optional, $p_{max}$ 80 bar
<b>Speed ratio</b>	2:1 (2)
<b>X / Y / Z</b>	90 (3.54) / - / 93 (3.66) mm (")



**W1315003 Milling unit**

**4-12**

<b>Fixation</b>	Setting gauge
<b>Mounting</b>	DIN 1835 B/E D32 (1.26 ")
<b>Cooling</b>	external, internal optional, $p_{max}$ 80 bar
<b>Speed ratio</b>	2:1 (2)
<b>X / Y / Z</b>	90 (3.54) / - / 98 (3.86) mm (")



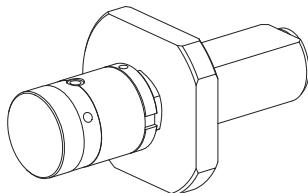
**W1315007 Drilling unit, angle-adjustable**

**4-13**

<b>Fixation</b>	Setting gauge
<b>Mounting</b>	ER 16
<b>Cooling</b>	external, $p_{max}$ 20 bar
<b>Speed ratio</b>	1:2.141 (0.467)
<b>X / Y / Z</b>	76.5 (3.01) / - / 0 mm (")

Catalog page

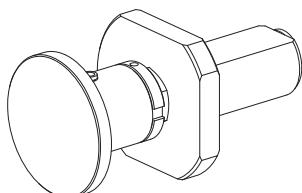
5-2



**W1300037 Bar stop, adjustable, live**

<b>Fixation</b>	none
<b>Mounting</b>	–
<b>Cooling</b>	–
<b>X / Y / Z</b>	60 - 97 (2.36 - 3.82) / – / – mm (")

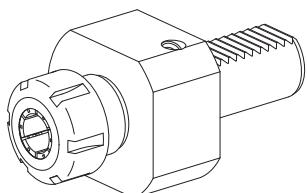
5-3



**W1300038 Bar stop, adjustable, live**

<b>Fixation</b>	none
<b>Mounting</b>	–
<b>Cooling</b>	–
<b>X / Y / Z</b>	60 - 97 (2.36 - 3.82) / – / – mm (")

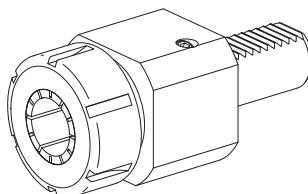
5-4



**W1300025 Drilling tool holder, Form E4**

<b>Fixation</b>	none
<b>Mounting</b>	ER 25
<b>Cooling</b>	internal, $p_{max}$ 80 bar
<b>X / Y / Z</b>	68 (2.68) / – / – mm (")

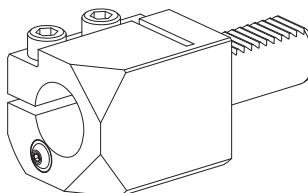
5-5



**W1300026 Drilling tool holder, Form E4**

<b>Fixation</b>	none
<b>Mounting</b>	ER 40
<b>Cooling</b>	internal, $p_{max}$ 80 bar
<b>X / Y / Z</b>	80 (3.15) / – / – mm (")

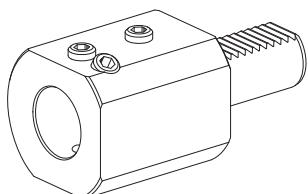
5-6



**W1300013 Drilling tool holder, Form E2**

<b>Fixation</b>	none
<b>Mounting</b>	D32
<b>Cooling</b>	external, $p_{max}$ 20 bar
<b>X / Y / Z</b>	70 (2.76) / – / – mm (")

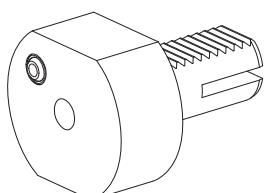
5-7



**W1300022 Drilling tool holder**

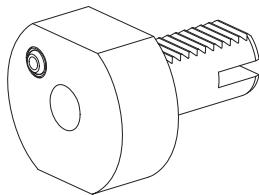
<b>Fixation</b>	none
<b>Mounting</b>	D32
<b>Cooling</b>	internal, $p_{max}$ 80 bar
<b>X / Y / Z</b>	73 (2.87) / – / – mm (")

5-8



**W1300027 Drilling tool holder**

<b>Fixation</b>	none
<b>Mounting</b>	MK1
<b>Cooling</b>	external, $p_{max}$ 20 bar
<b>X / Y / Z</b>	30 (1.18) / – / – mm (")

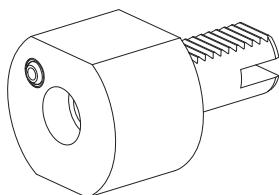


## W1300028 Drilling tool holder

Catalog page

5-9

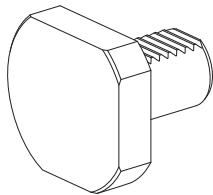
<b>Fixation</b>	none
<b>Mounting</b>	MK2
<b>Cooling</b>	external, $p_{\max}$ 20 bar
<b>X / Y / Z</b>	27 (16) / - / - mm ("")



## W1300029 Drilling tool holder

5-10

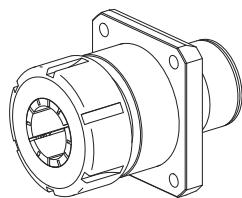
<b>Fixation</b>	none
<b>Mounting</b>	MK3
<b>Cooling</b>	external, $p_{\max}$ 20 bar
<b>X / Y / Z</b>	45 (1.77) / - / - mm ("")



## W1300095 Blanking plug, Plastic

5-11

<b>Fixation</b>	-
<b>Mounting</b>	-
<b>Cooling</b>	-
<b>X / Y / Z</b>	15 (0.59) / - / - mm ("")

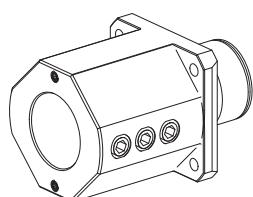


## W7590003 Drilling tool holder

Catalog page

6-2

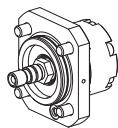
<b>Fixation</b>	none
<b>Mounting</b>	ER 40
<b>Cooling</b>	–, $p_{\max}$ 80 bar
<b>X / Y / Z</b>	65 (2.56) / – / – mm ("")



## W7590004 Drilling tool holder

6-3

<b>Fixation</b>	none
<b>Mounting</b>	D40
<b>Cooling</b>	–, $p_{\max}$ 80 bar
<b>X / Y / Z</b>	77 (33) / – / – mm ("")

**W9990284      IC attachment**

For internal cooling lubricant supply, up to 160 bar

Catalog page

7-2

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## **W9800001EN Product note**

External/internal cooling lubricant supply  
Drill holder with cylindrical shank tool mounting  
Offset set screws

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## **W9800008EN Product note**

External/internal cooling lubricant supply  
Milling unit, lid convertible to IC 80 bar / 160 bar  
Offset set screws

---

# INDEX



**Technical Information  
IT600**

## Warranty



When using tool holders that have not been set, checked and labeled accordingly by INDEXTRAUB, warranty is not applicable to the tool drive.

## Information on wear parts

Tool holders and guide bushings are wear parts requiring correct handling.

In order to ensure a long service life, compressed air or coolant must not enter the gap seals of the holders or of the guide bushings.

## Inspection of live tool holders and guide bushings



Tool holders and guide bushings must be inspected at regular intervals (at least twice a year) for smooth running and play.



The drive pinion and drive clutch of the live tool holders must be subjected to a visual inspection for damage or wear.

If one of the above-mentioned defects is detected during the inspection of the tool holders or guide bushings, they must be returned immediately for preventive maintenance or repair to the following address:

TRAUB Drehmaschinen GmbH & Co. KG  
Hauffstrasse 4  
D-73262 Reichenbach, Germany  
Phone +49 (0) 7153 502-554  
werkzeughalter@traub.de

## Tool holders with cooling lubricant supply



Tool holders marked with this symbol must be operated with cooling lubricant (no dry run permitted).

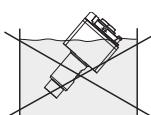


Tool holders marked with this symbol must be operated with cooling lubricant when converting from external cooling lubricant supply to internal cooling lubricant supply. Observe dry run capability of IC attachment!

## Cooling lubricant filtering

When using live tool holders with internal cooling lubricant supply, it is necessary to use a cooling lubricant filter system with a retained particle size  $\leq 50 \mu\text{m}$ .

## Cleaning live tool holders



Live tool holders must never be immersed in cleaning fluid since mixing the cleaning fluid with the bearing grease will reduce the service life of the tool holders.

## Speed ratio specifications on tool holders

The value to be programmed is specified in the documentation and on the live tool holders  
(= the input in the NC program).

$$n_{\text{prog}} = n_{\text{tool}} \times i$$

$n_{\text{tool}}$  = speed at cutting tool edge

$n_{\text{PROG}}$  = speed to be programmed

$i$  = speed ratio in the tool holder

This means: the speed increase or speed reduction is not specified as a fraction but as **a number**.

This gives speed **increase** ratios as numbers **smaller than 1**.

Example:

$i = 0.333$  (corresponds to  $i = 1:3$ )

$i = 0.676$  (corresponds to  $i = 1:1.48$ )

**Step-down** ratios result in numbers **>1**

For example:

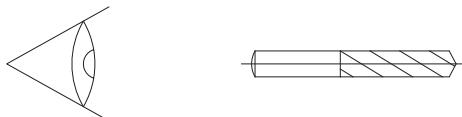
$i = 2$  (corresponds to  $i = 2:1$ )

$i = 1.333$  (corresponds to  $i = 4:3$ )

## Direction of rotation specification

Definition of the viewing direction.

Viewing direction for determining the direction of rotation is always from behind (that is, from the drive direction) toward the shaft.



On the machine side, the direction of rotation has been set by parameters such that M03 always denotes clockwise rotation and M04 counter-clockwise run at the interface of the drive pinion of the tool holder.

The direction of rotation given on the holder thus always refers to a "change in direction within a holder".

M03 and M04 are machine functions to be programmed.

The  and  arrows indicate the direction of rotation of the cutting edges.

This means:

 M03     M04

 M04     M03

### No reversal of direction of rotation

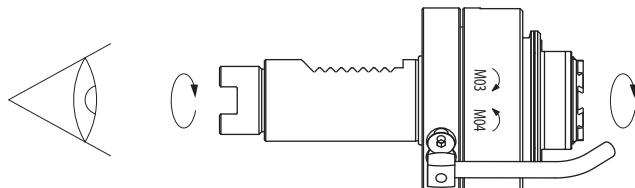
- When the holder drive shaft has the **same** direction of rotation as the tool cutting edge, the clockwise direction of run must be specified by M03 (clockwise rotation). Accordingly, counter-clockwise run must be specified by M04.

### Reversal of direction of rotation

- When the holder drive shaft has the **opposite** direction of rotation as the tool cutting edge, the clockwise direction of rotation must be specified by M04. Accordingly, counter-clockwise run must be specified by M03.

Example

### No reversal of direction of rotation



### Tightening torque

The tightening torque for the tool holder mounting depends on the shank diameter of the tool holder.

Shank	Tightening torque	
Turret 1	Clamping piece	25 Nm
Multifunction turret VDI 30	Clamping piece	25 Nm
Multifunction turret UniFlex 52	Fastening screw M6	12 Nm

### Replacement seals for tool shank

The sealing ring on the tool shank must be inspected regularly for damage.

### Sealing air port

It must be ensured on all machines with sealing air ports that the sealing air ports in the tool carrier and in the tool holders are sealed/closed with M5x6 mm set screws.

## Tool holders with fixation



Except for very few cases, all tool holders have been pre-adjusted with high precision and sealed with the INDEX V bar / TRAUB adjusting bar / W-serration. This setting must not be changed.

The INDEX V bar / TRAUB adjusting bar / W-serration ensures positional accuracy of the tool when re-inserted.

The tool holders are fixed around the shank axis by pins (DIN 69880).

DIN holders can be used.

Double serration of the tool holders allows several uses.

## High-pressure unit



The cooling lubricant up to 80 bar (e.g., for deep-hole drilling) is supplied through the standard cooling lubricant line.

## Load limits of live tools

The drive power and torques are indicated in the performance charts. These values represent the upper limit of the calculated theoretical performance values (average values). In case of interrupted cuts, e.g., for milling, the load peaks occurring when the cutting edge enters the material may be much higher than the theoretical torque according to the performance chart.



The cutter should be selected so that a cutting edge is constantly being used for cutting during the machining process.

## Weight distribution on turret head



Tool holders may have considerably different weights depending on their function and equipment. Therefore, be sure to balance the tool holders evenly around the turret head when tooling.

## Collision

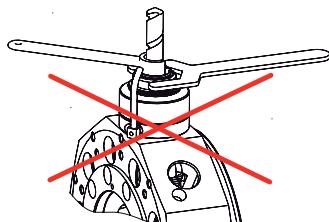


After a collision has occurred, check whether the tool carrier has been displaced. If this is the case, the tool carrier must be realigned to ensure that the drive and tool holder gears accurately engage with each other.

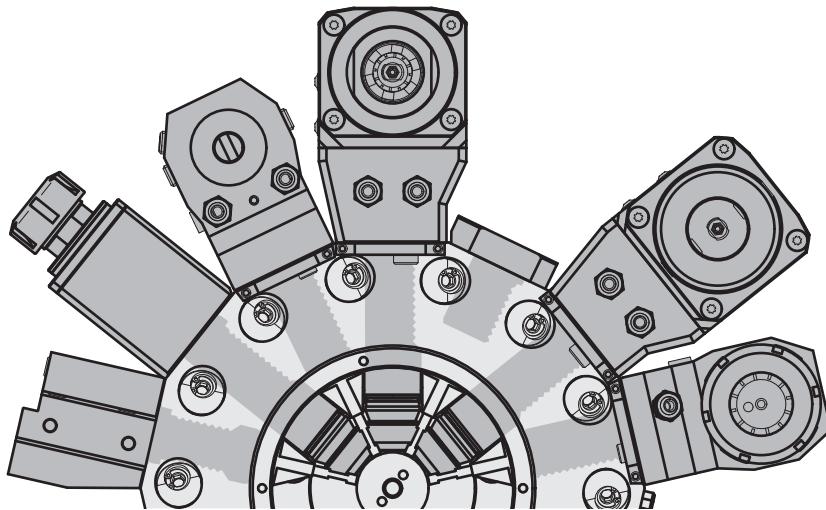
## Tool change on live tool holders

To avoid damaging or changing the adjustment of the drive train in the turret, tools must **not** be changed on the live tool holders inserted in the turret.

Tools in live tool holders must be changed outside the machine.



### Live tool holders, turret



The live tool holders are inserted into the mounting bores in the turret just like non-live tool holders.

Each second station of the turret can accept one live tool.

The motor drives all the tools.

Another motor switches the turret.



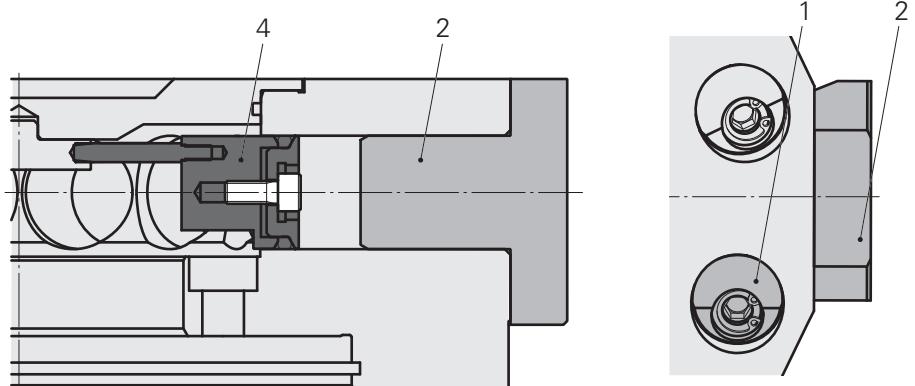
The seal set must be removed beforehand.



Before carrying out work with the machine, all mounting bores not mounted with tool holders must each be sealed with a seal set and blanking plug, and a check must be made to determine whether all tool holders are equipped with an undamaged sealing ring.

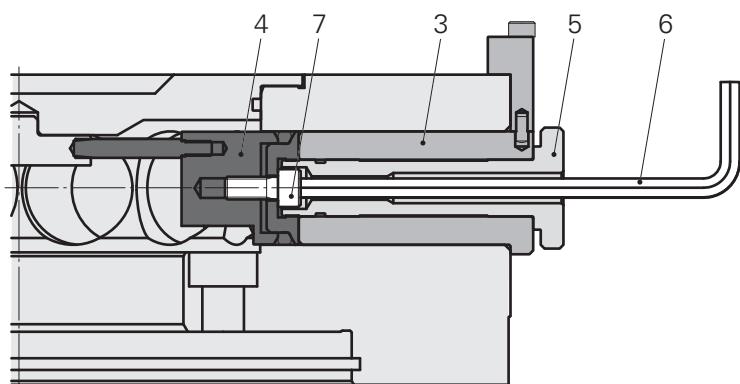
## Turret

### Delivery condition

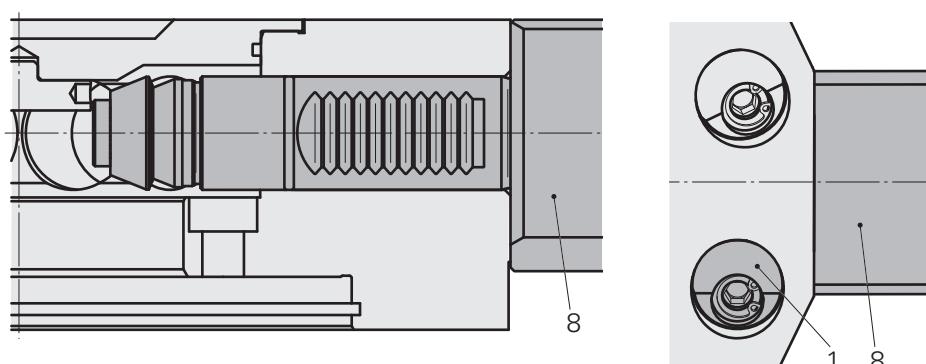


- Loosen clamping piece (1).
- Remove blanking plug (2).

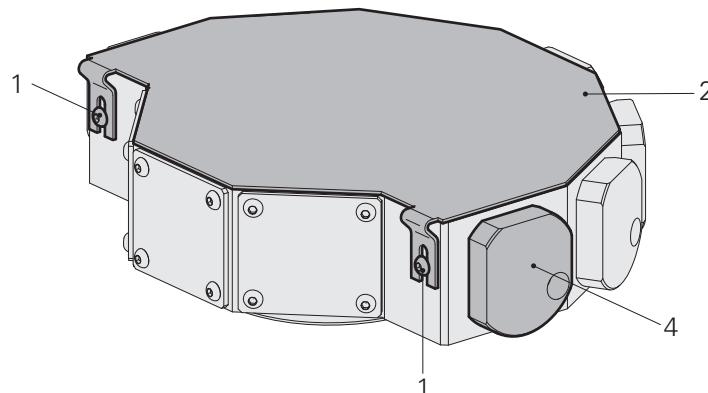
### Removing seal set



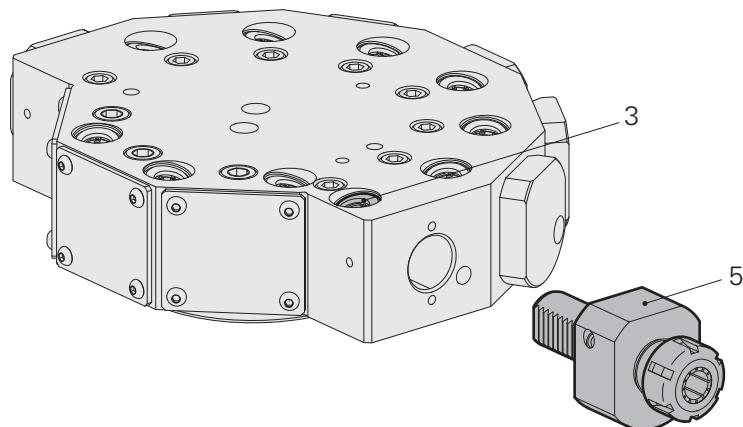
- Attach tool for installing and removing (3) the seal set (4).
- Screw in the knurled thumb screw (5).
- Use the hex key (6) to loosen the screw (7).
- Use the knurled thumb screw (5) to rotate out the seal set (4) including the tool (3).



- Insert live tool holder (8).
- Tighten clamping piece (1).

**Multifunction turret****Delivery condition****First-time mounting  
tool holder VDI30**

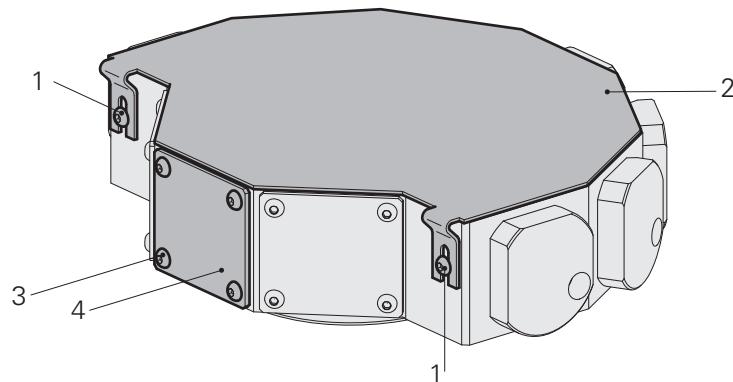
- Loosen screws (1) and remove cover sheet (2).
- Loosen clamping piece (3).
- Remove blanking plug (4).
- Insert stationary tool holder with VDI30 mounting (5).
- Tighten clamping piece (3), tightening torque 25 Nm.
- Reattach cover sheet (2), tighten screws (1).

**Tool holder change  
tool mounting VDI30**

- Loosen screws (1) and remove cover sheet (2).
- Loosen clamping piece (3)
- Change stationary tool holder with VDI30 mounting (5).
- Tighten clamping piece (3), tightening torque 25 Nm.
- Reattach cover sheet (2), tighten screws (1).

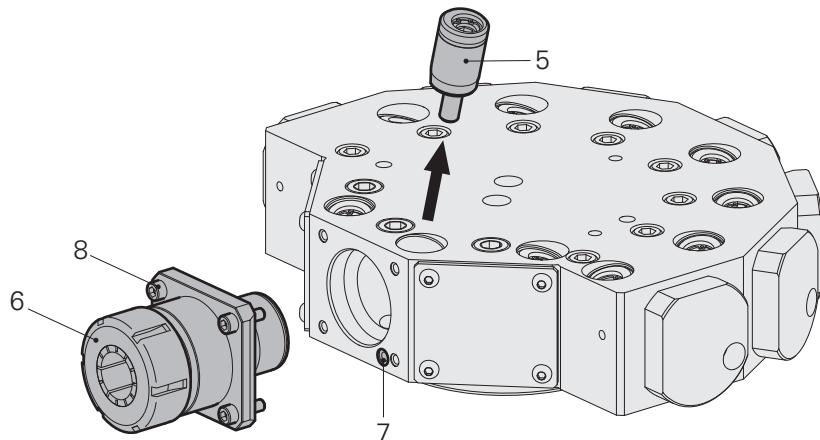
### Multifunction turret

#### Delivery condition



#### First-time mounting tool mounting UniFlex 52

- Loosen screws (1) and remove cover sheet (2).
- Loosen screws (3) and remove blanking sheet (4).
- Remove clamping piece (5).
- Insert stationary tool holder with UniFlex 52 mounting (6).
- Bore for coolant transfer (7) must be uniform.
- Tighten fastening screws (8), tightening torque 12 Nm.
- Bore of clamping piece (5) is not sealed.
- Reattach cover sheet (2), tighten screws (1).



#### Tool holder change tool mounting UniFlex 52

- Loosen the fastening screws (8).
- Change stationary tool holder with UniFlex 52 mounting (6).
- Bore for coolant transfer (7) must be uniform.
- Tighten fastening screws (8), tightening torque 12 Nm.
- Reattach cover sheet (2), tighten screws (1).

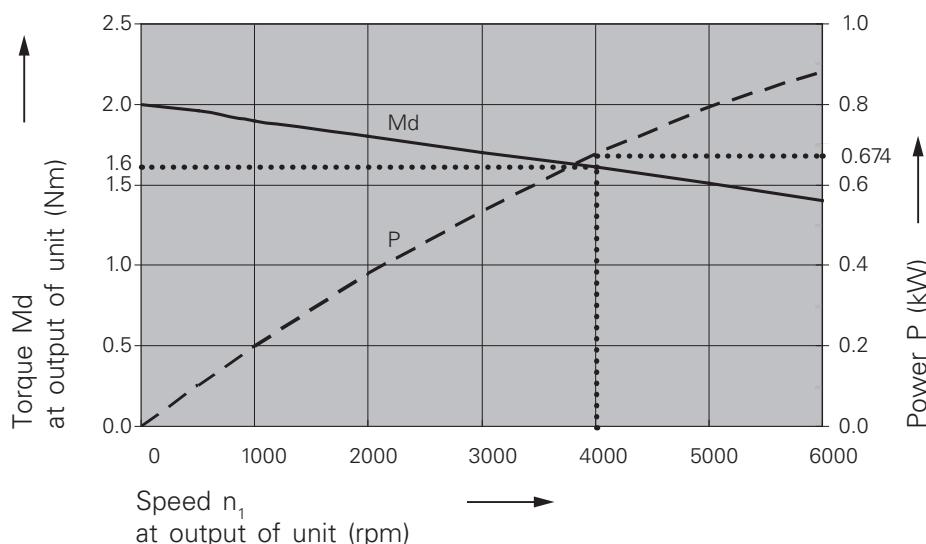
### Information on how to use the chart when using tool holders

The chart relates to the output speed  $n$  of the tool unit. The tool speed can be read directly from the chart only if the internal speed ratio  $i$  in the tool holder is 1:1.

For tool holders (e.g., VDI holders) with an internal speed ratio  $i \neq 1$ , the output speed  $n$  of the tool unit to be programmed must be calculated from the required tool speed and the speed ratio  $i$ . Afterwards, the actual powers or torques can be read off or determined.

Example (at 100% duty cycle):

<b>live tool unit, tool speed <math>n_{\text{Tool}} = 1000</math> rpm</b>	
Internal speed ratio $i$ of the tool holder	$i = 4$
Programmed speed $n_{\text{prog}}$ for the drive of the unit	$n_{\text{prog}} = n_{\text{Tool}} \times i = 1000 \text{ rpm} \times 4 = 4000 \text{ rpm}$
Torque $M_{\text{Tool}}$ at the output of the tool holder	Read-out $M_d$ at speed $n_{\text{prog}} = 4000 \text{ rpm} = 1.6 \text{ Nm}$ $M_d = M_{\text{Tool}} : i$ Formula changed: $M_{\text{Tool}} = M_d \times i = 1.6 \text{ Nm} \times 4 = 6.4 \text{ Nm}$
Power $P$ at the output of the tool holder $\approx$ Power $P$ at the output of the setup	Read-out at 4000 rpm $\rightarrow P = 0.67 \text{ kW}$ calculated: $P = 2 \times \pi \times n_{\text{prog}} \times M_d$ $P = \frac{2 \times \pi \times 4000 \times 1.6 \text{ Nm}}{60 \times 1000} = 0.67 \text{ kW}$



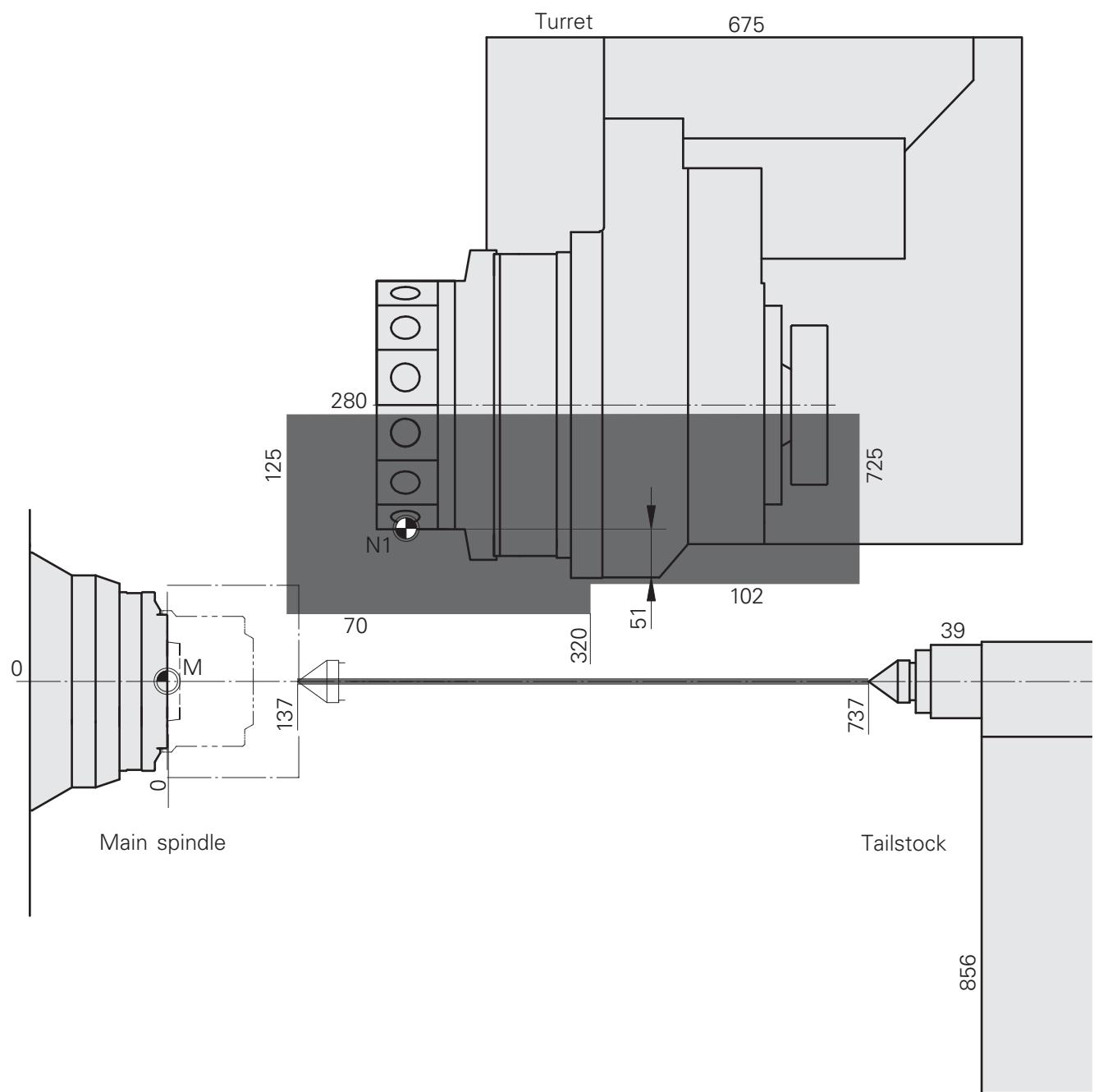
The speed ratio and the technical data of each tool holder are indicated on the next pages.

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## **Usage Information IT600**

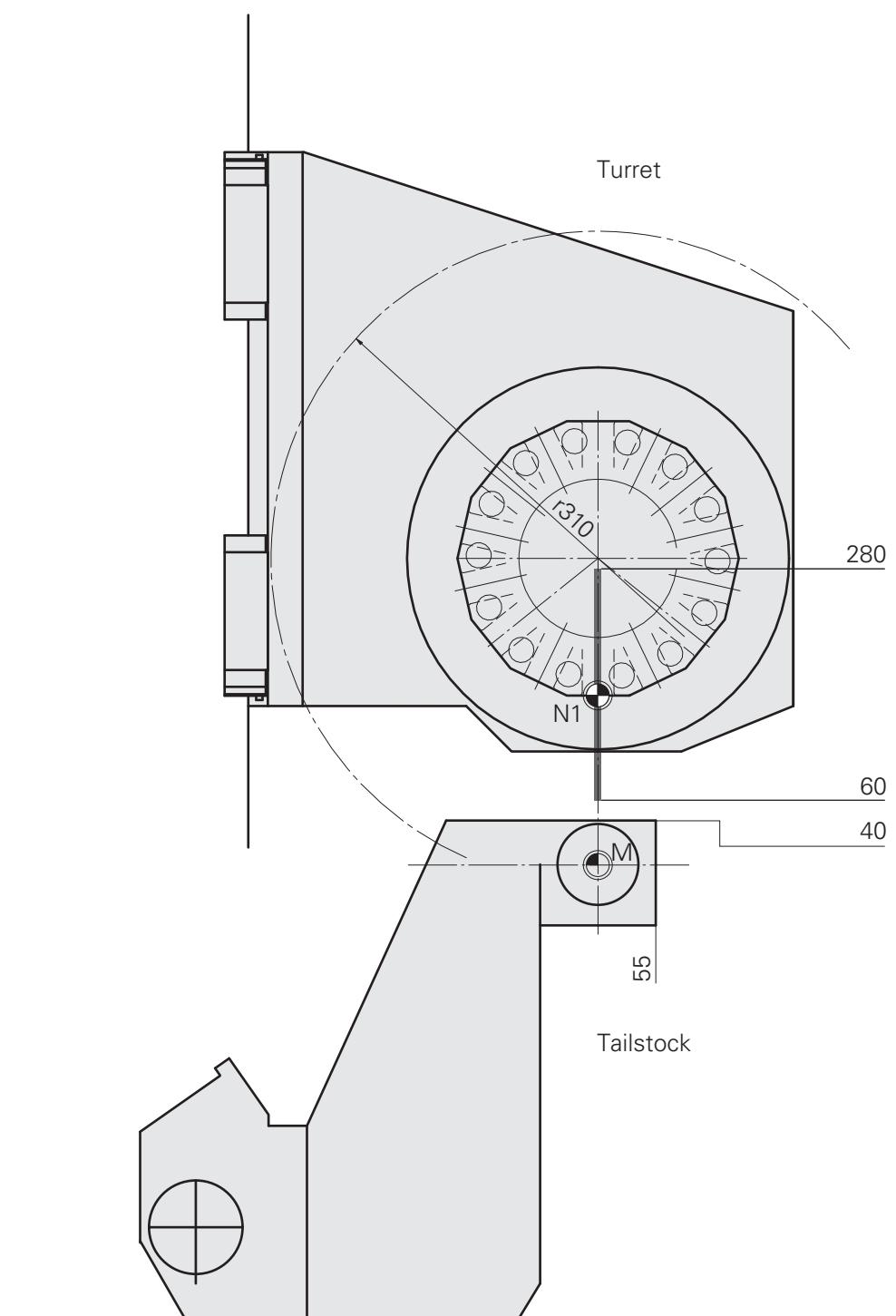
## Work area IT600

Turret and tailstock



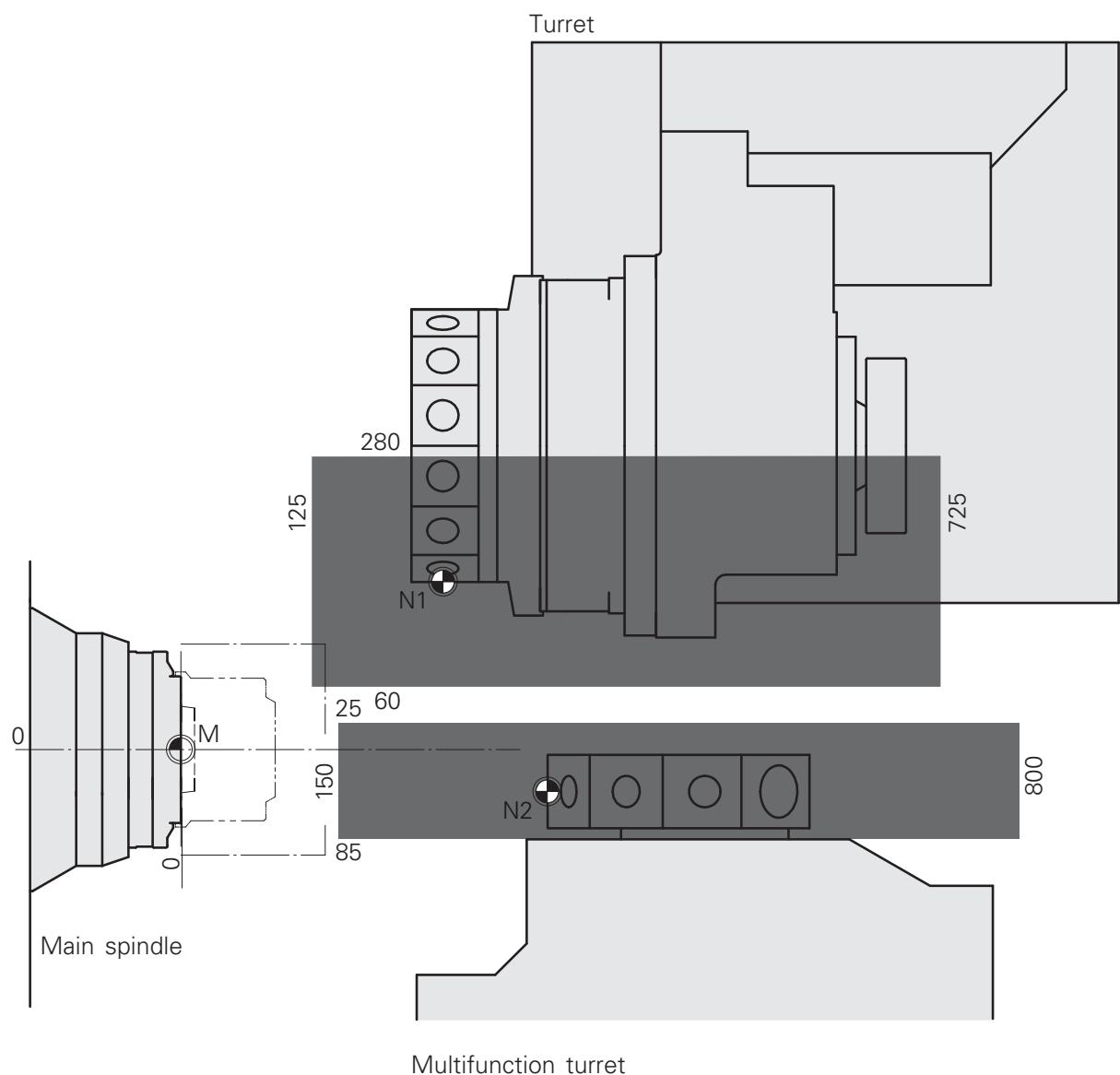
## Work area IT600

Turret and tailstock



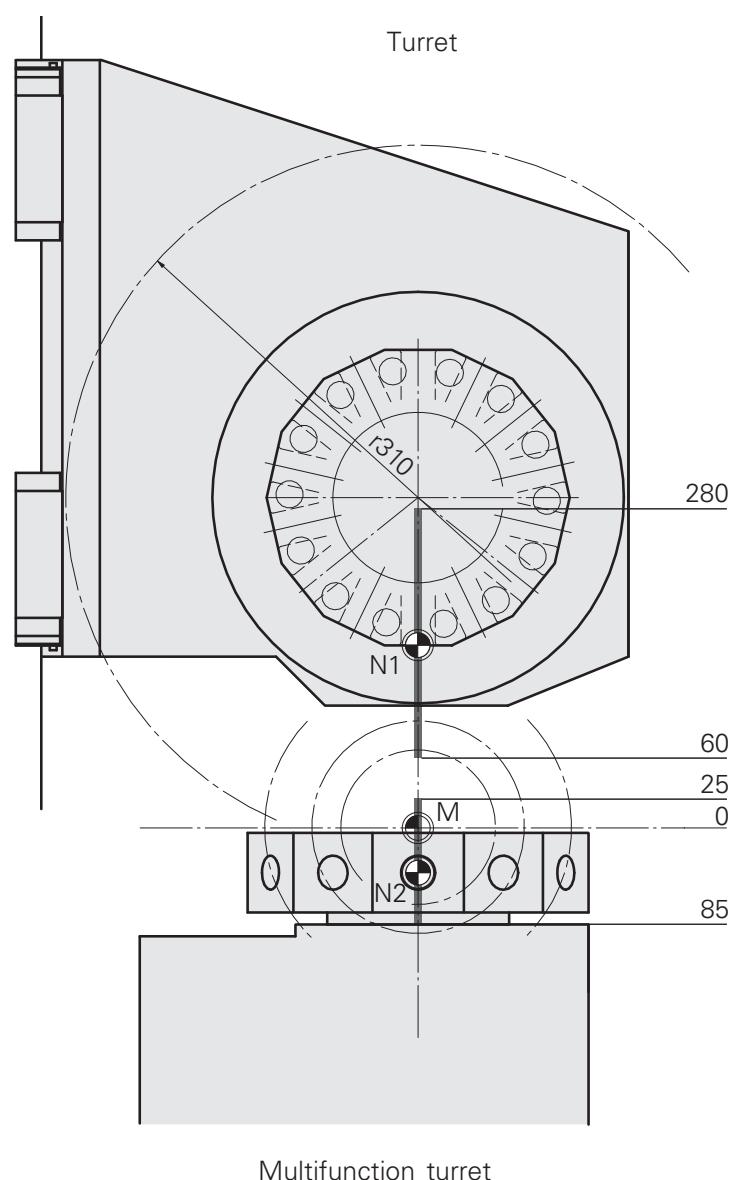
## Work area IT600

Turret and multifunction turret



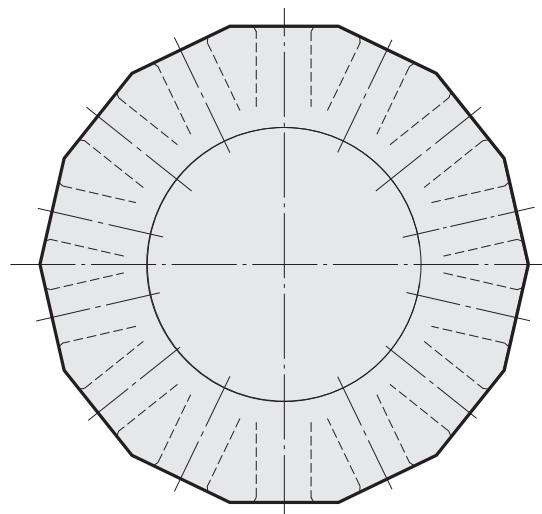
## Work area IT600

Turret and multifunction turret



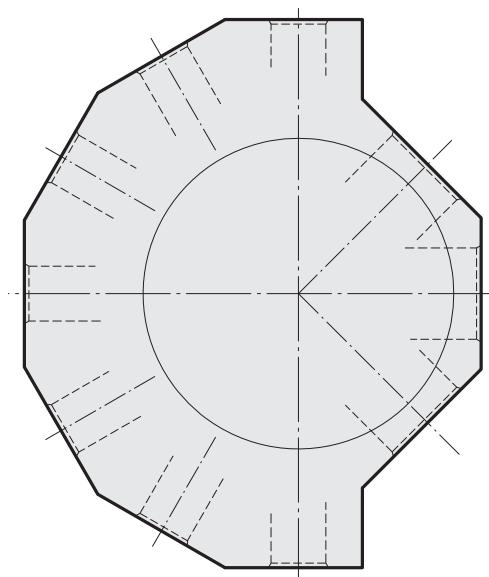
## Work area IT600

Turret and multifunction turret



### Turret

14 stations for VD130  
Stationary / live tool holders  
up to 7 of which are live



### Multifunction turret

7 stations for VD130  
Stationary tool holders  
  
3 stations for UniFlex 52  
Stationary tool holders

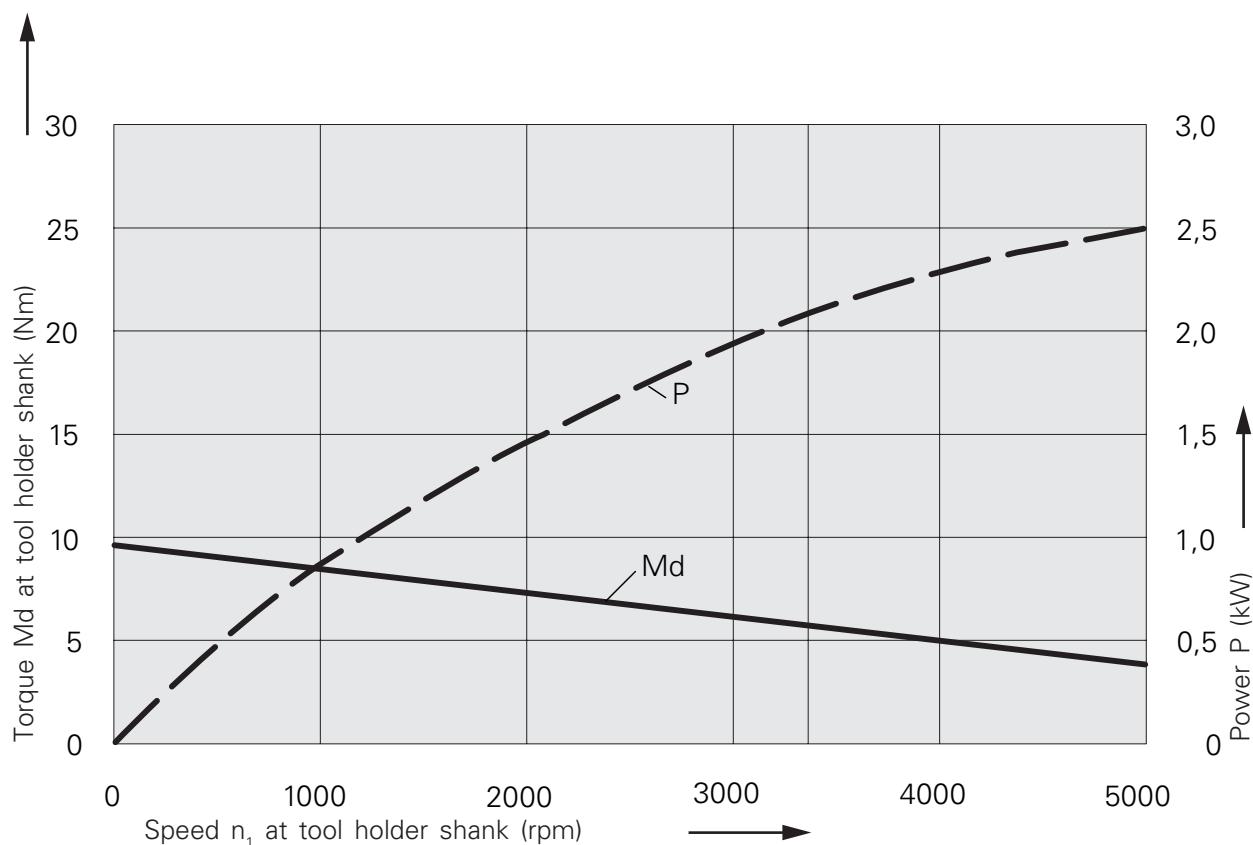
## Performance chart

Live tools



For information on how to use  
the chart, see Chapter "Techni-  
cal Information".

Speed range 0-5000 rpm





**Turret  
Stationary tool holders  
Shank VDI30**

## Drilling tool holder

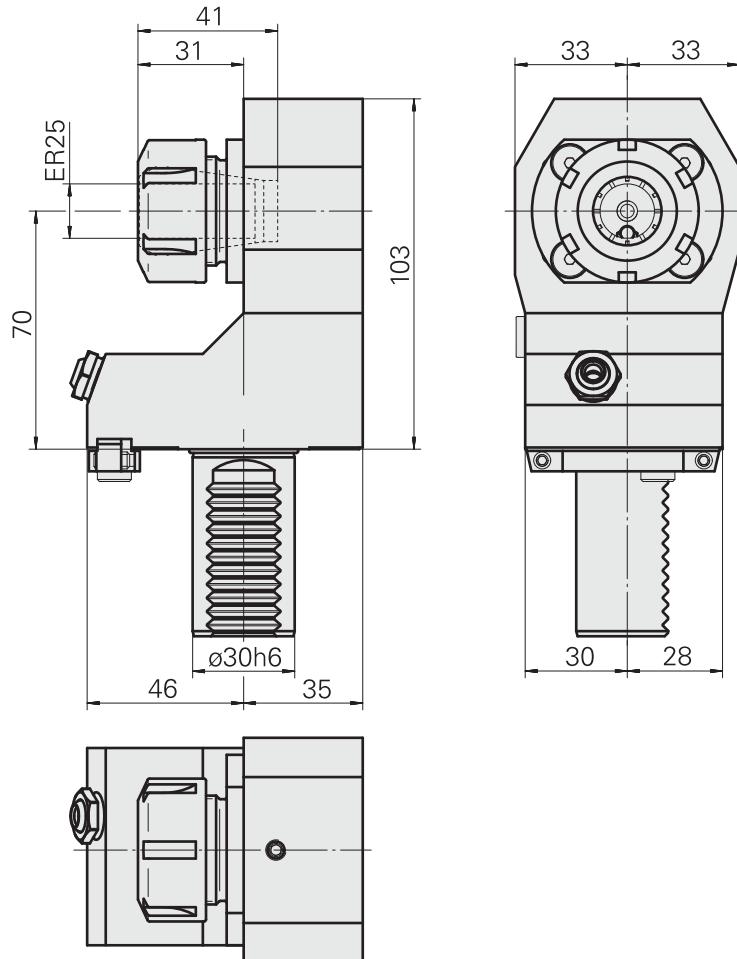
<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	ER 25
<b>Cooling</b>	external and internal, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	70 (2.76) / - / 31 (1.22) mm (")

### Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping collet, sealed	W999085-
Clamping nut <sup>1</sup>	901939.0251
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216
Spanner	490219.0251

### Other documents

Product note	W9800001EN
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<sup>1</sup> These items are included

## Drilling tool holder

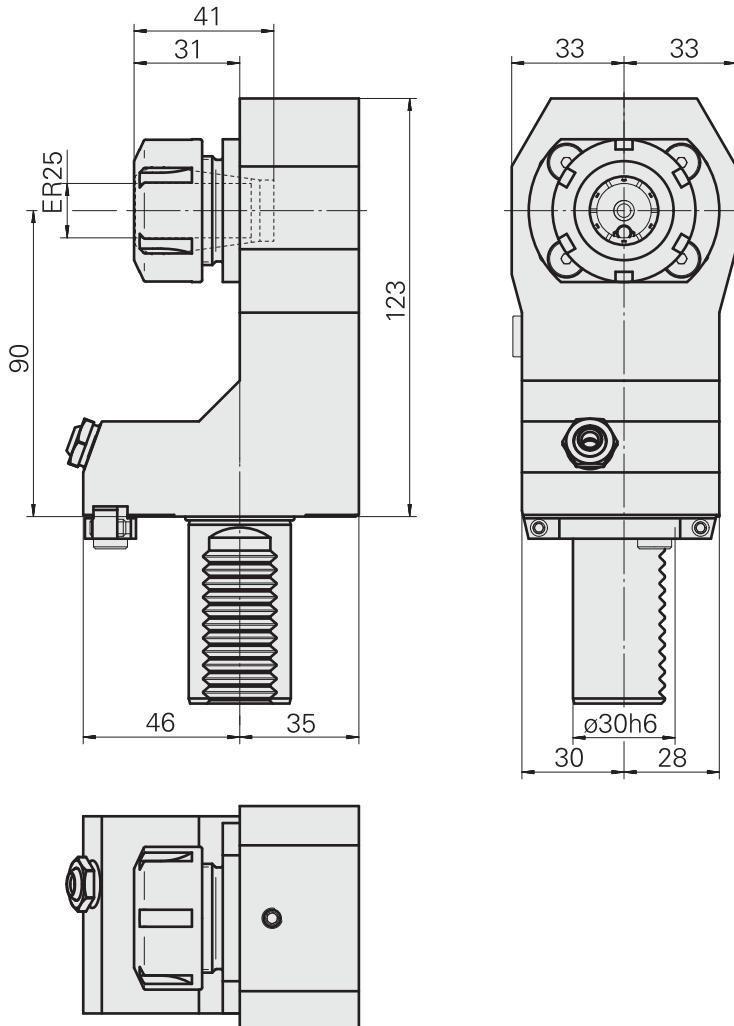
<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	ER 25
<b>Cooling</b>	external and internal, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	90 (3.54) / - / 31 (1.22) mm (")

### Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping collet, sealed	W999085-
Clamping nut <sup>1</sup>	901939.0251
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216
Spanner	490219.0251

### Other documents

Product note	W9800001EN
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<sup>1</sup> These items are included

## Drilling tool holder

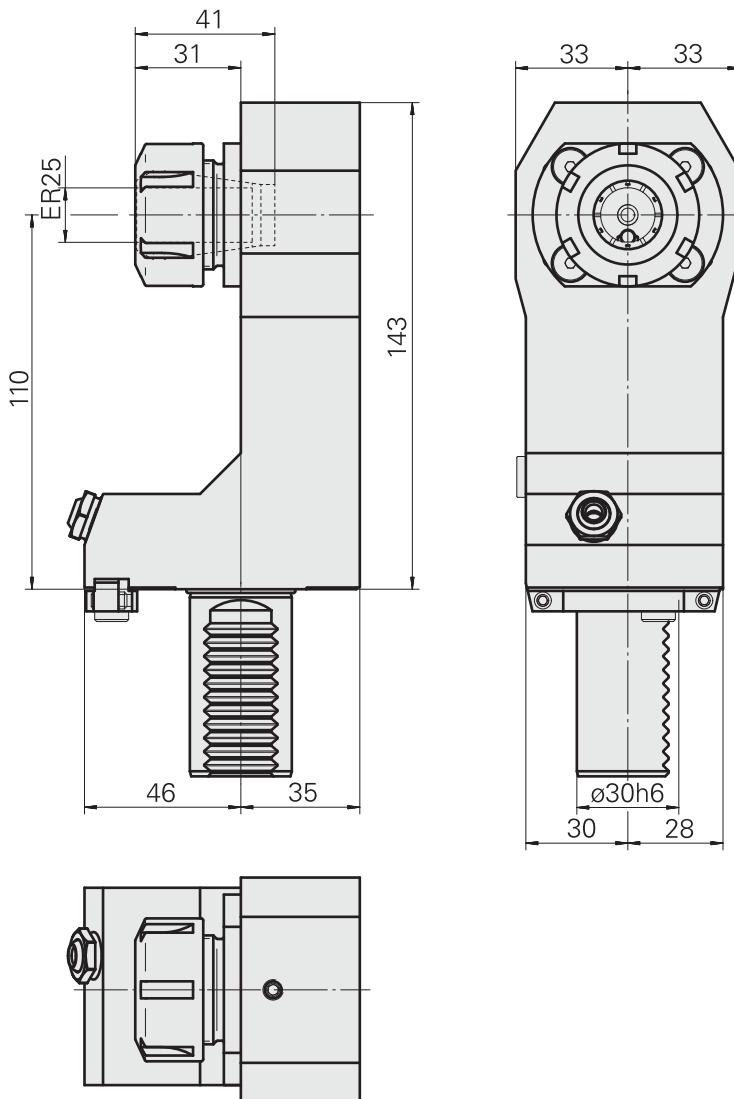
<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	ER 25
<b>Cooling</b>	external and internal, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	110 (4.33) / - / 31 (1.22) mm (")

### Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping collet, sealed	W999085-
Clamping nut <sup>1</sup>	901939.0251
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216
Spanner	490219.0251

### Other documents

Product note	W9800001EN
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<sup>1</sup> These items are included

## Drilling tool holder

<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	ER 40
<b>Cooling</b>	external and internal, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	70 (2.76) / - / 58 (2.28) mm (")

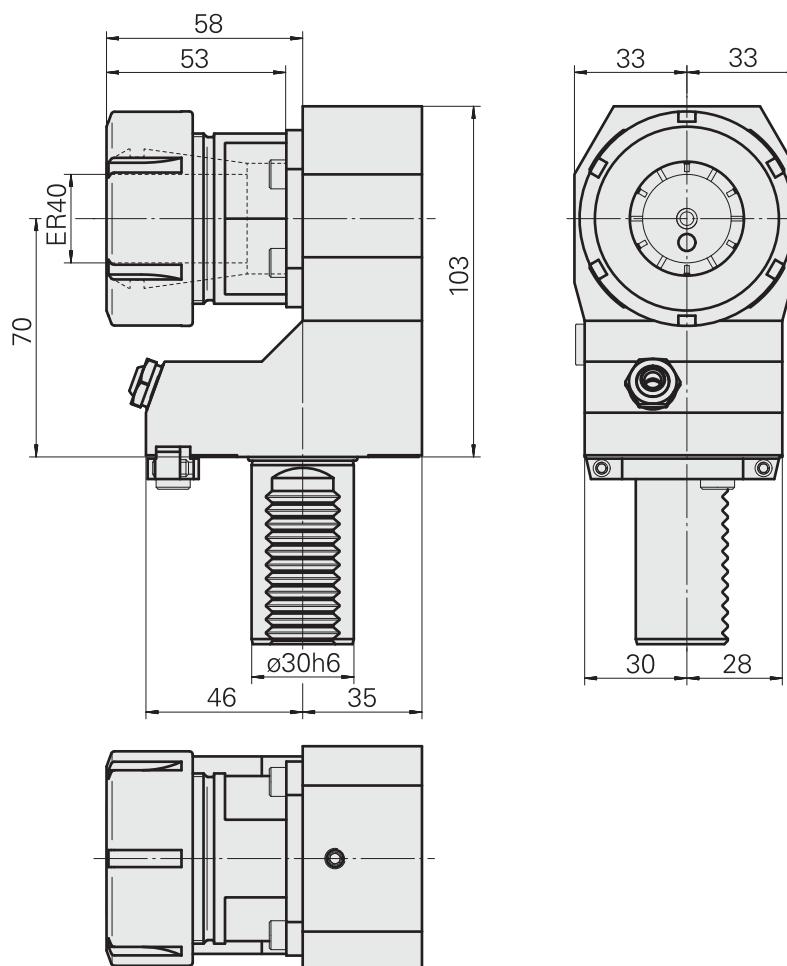
### Matching accessories

Clamping collet	901930.4---
Clamping nut <sup>1</sup>	901939.0401
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216
Spanner	490219.0401

### Other documents

Product note

[W9800001EN](#)



<sup>1</sup> These items are included

## Drilling tool holder

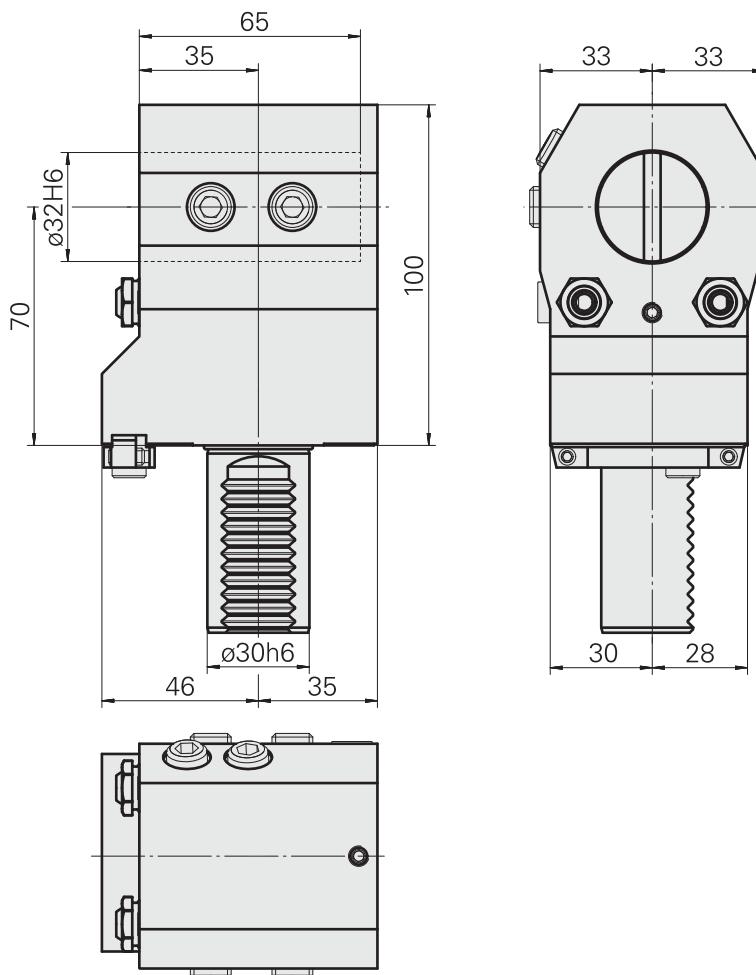
<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	DIN 1835 B/E D32 (1.26 ")
<b>Cooling</b>	external and internal, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	70 (2.76) / - / 35 (1.38) mm (")

### Matching accessories

Bush	W63221.40--
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216

### Other documents

Product note	W9800001EN
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<sup>1</sup> These items are included

## Drilling tool holder

<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	DIN 1835 B/E D32 (1.26 ")
<b>Cooling</b>	external and internal, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	90 (3.54) / - / 35 (1.38) mm (")

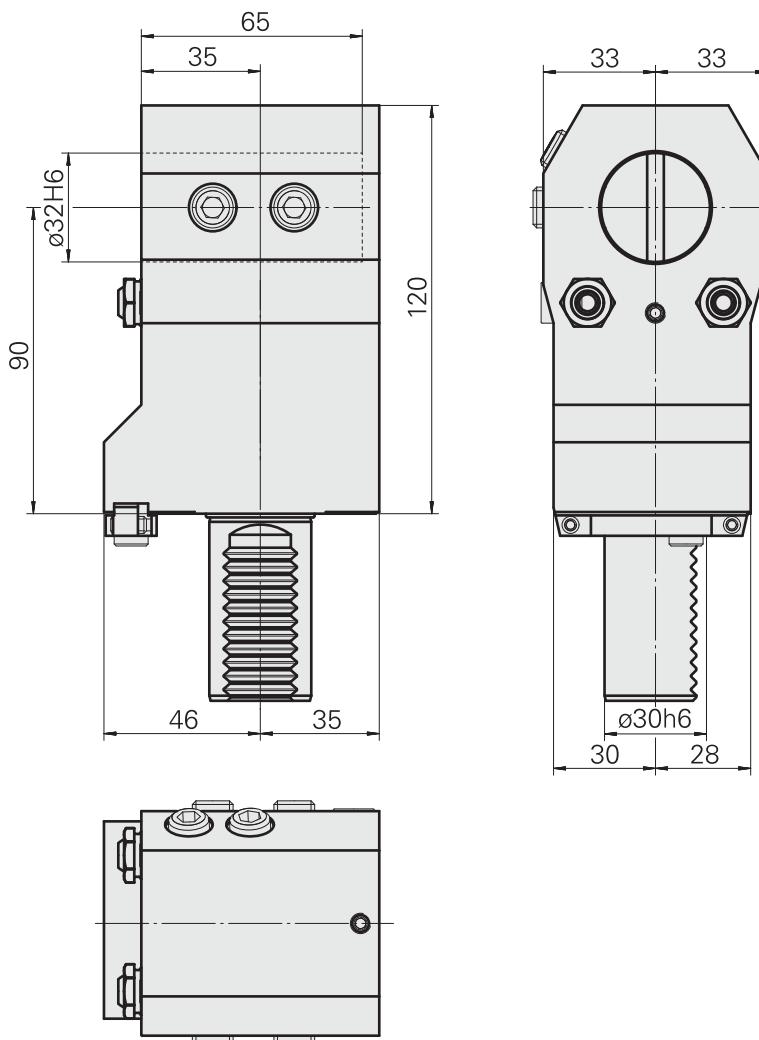
### Matching accessories

Bush	W63221.40--
Bush	W63220.02--
Bush	W63220.42--
Chuck sleeve	993132.----
Ball nozzle <sup>1</sup>	W67500.3208
Hollow screw <sup>1</sup>	W67530.0818
Bush <sup>1</sup>	W67530.0824

### Other documents

Product note

[W9800001EN](#)



<sup>1</sup> These items are included

## Drilling tool holder

<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	DIN 1835 B/E D32 (1.26 ")
<b>Cooling</b>	external and internal, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	110 (4.33) / - / 35 (1.38) mm (")

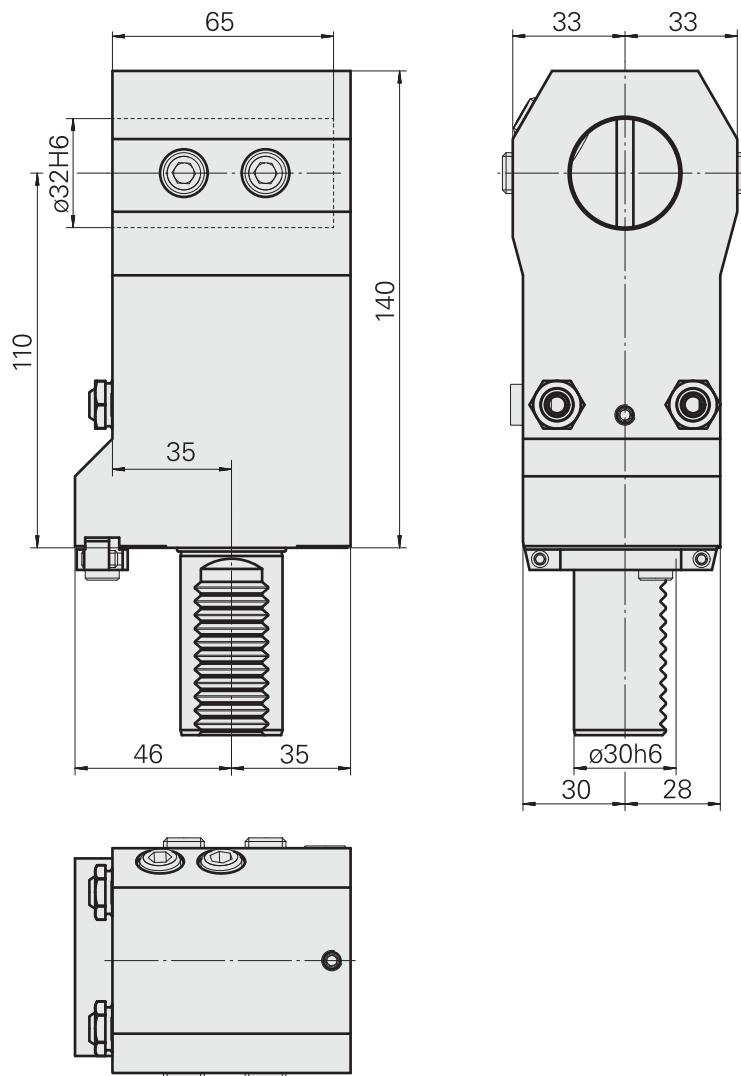
### Matching accessories

Bush	W63221.40--
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216

### Other documents

Product note

W9800001EN



<sup>1</sup> These items are included

## Drilling tool holder

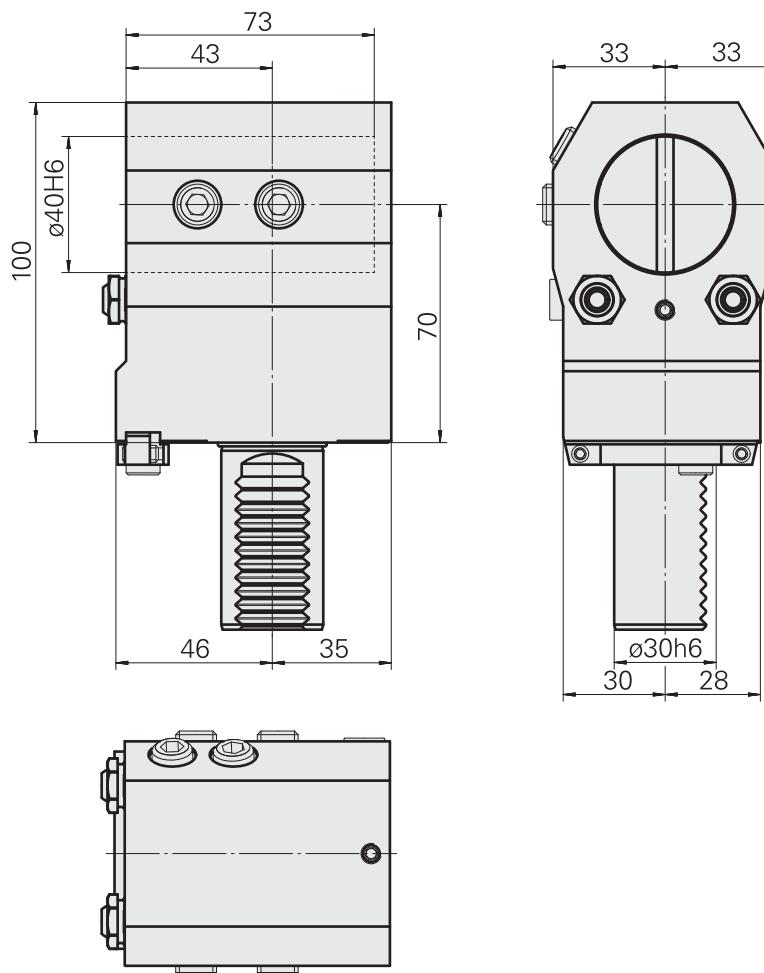
<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	DIN 1835 B/E D40 (1.57 ")
<b>Cooling</b>	external and internal, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	70 (2.76) / - / 43 (1.69) mm (")

### Matching accessories

Bush	W64222.41--
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216

### Other documents

Product note	W9800001EN
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<sup>1</sup> These items are included

## Drilling tool holder

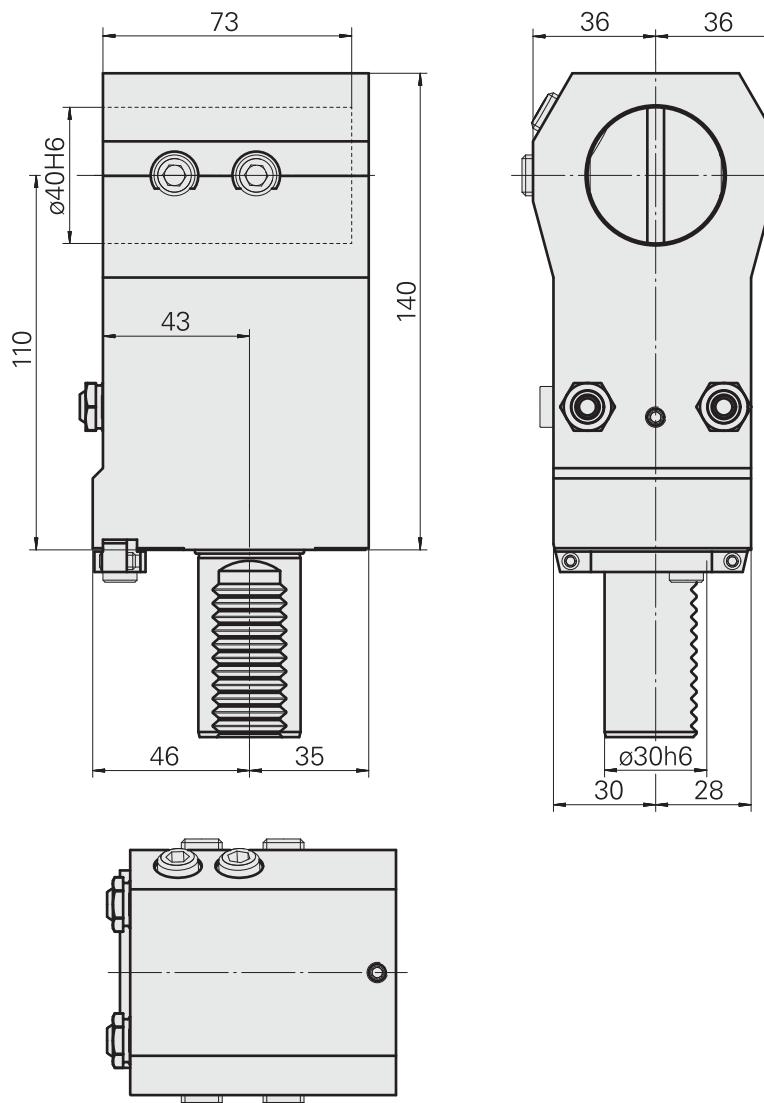
<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Mounting</b>	DIN 1835 B/E D40 (1.57 ")
<b>Cooling</b>	external and internal, $p_{max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	110 (4.33) / - / 43 (1.69) mm (")

### Matching accessories

Bush	W63221.40--
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216

### Other documents

Product note	W9800001EN
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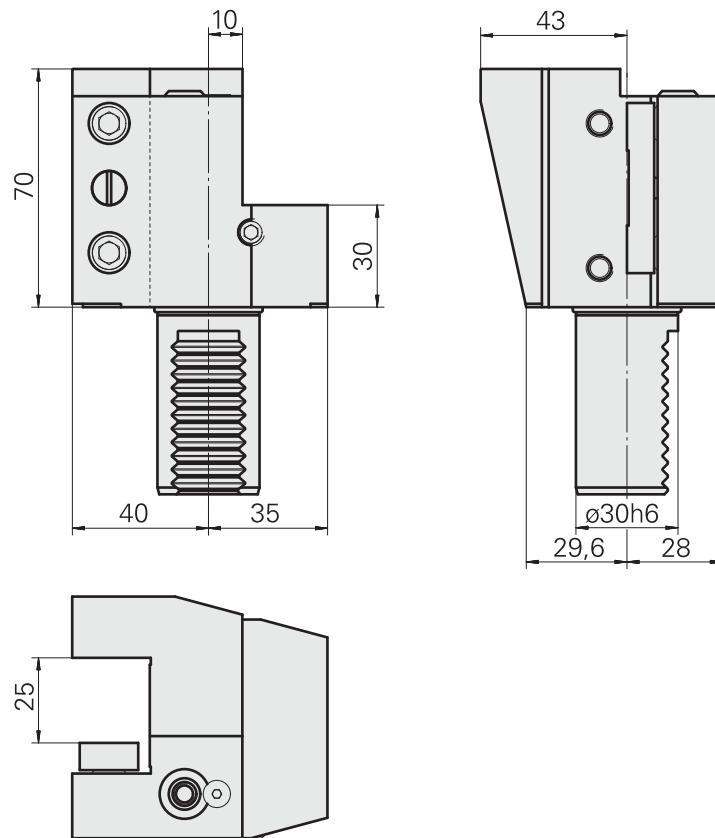
<sup>1</sup> These items are included

## Turning tool holder, Form C1

<b>Shank</b>	VDI 30
<b>Fixation</b>	—
<b>Mounting</b>	square 25x25
<b>Cooling</b>	external, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	70 (2.76) / – / 40 (1.57) mm (")

### Matching accessories

Ball nozzle <sup>1</sup>	W00019.0084
Gasket ring <sup>1</sup>	479105.1001
Shim <sup>1</sup>	317244
Countersunk screw <sup>1</sup>	410360.0408
Tool holder	W9991111



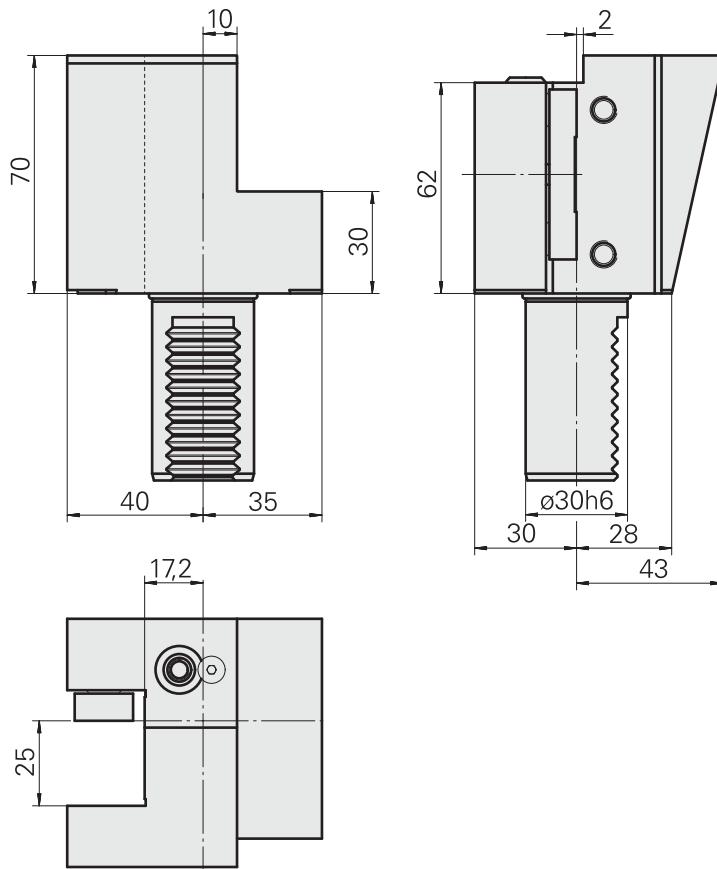
<sup>1</sup> These items are included

## Turning tool holder, Form C3

<b>Shank</b>	VDI 30
<b>Fixation</b>	—
<b>Mounting</b>	square 25x25
<b>Cooling</b>	external, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	70 (2.76) / – / 40 (1.57) mm (")

### Matching accessories

Ball nozzle	W00019.0084
Gasket ring	479105.1001
Shim	317244
Countersunk screw	410360.0408

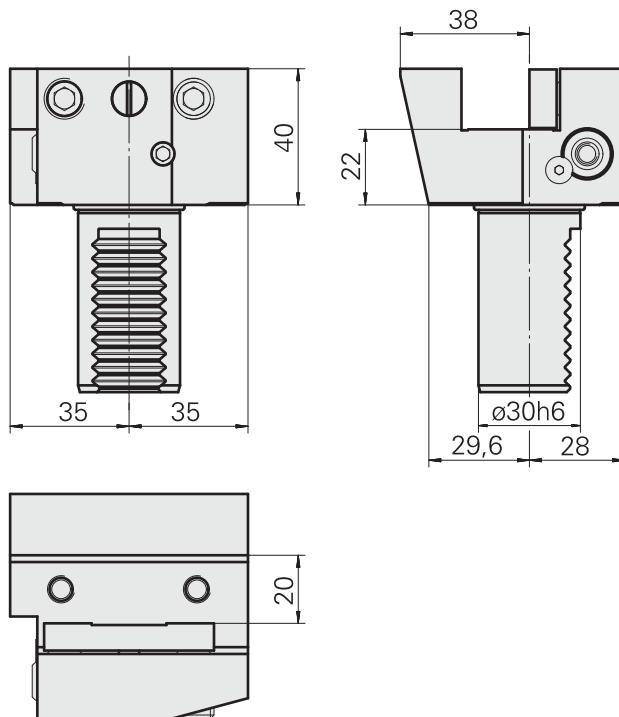


## Turning tool holder, Form B1

**Shank** VDI 30  
**Fixation** –  
**Mounting** square 20x20  
**Cooling** external,  $p_{\max}$  80 bar  
**X / Y / Z** 35 (1.38) / – / 40 (1.57) mm (")

### Matching accessories

Ball nozzle <sup>1</sup>	W00019.0084
Shim <sup>1</sup>	317244
Gasket ring <sup>1</sup>	479105.1001
Countersunk screw <sup>1</sup>	410360.0408



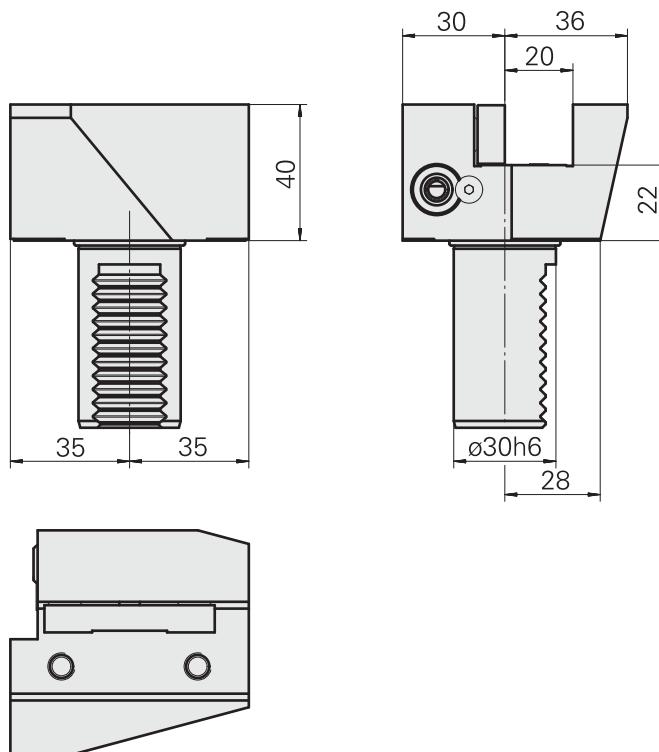
<sup>1</sup> These items are included

## Turning tool holder, C-axis for main and counter spindles

<b>Shank</b>	VDI 30
<b>Fixation</b>	—
<b>Mounting</b>	square 20x20
<b>Cooling</b>	external, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	40 (1.57) / – / 35 (1.38) mm (")

### Matching accessories

Angle	W63300.0010
Angle	W63300.0020
Ball nozzle	W00019.0084
Shim	317244
Gasket ring	479105.1001
Countersunk screw	410360.0408

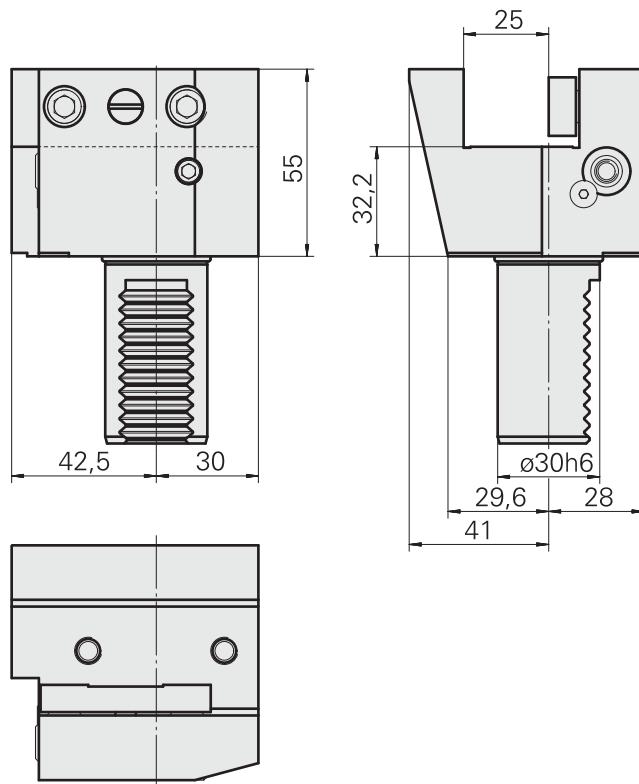


## Turning tool holder, Form B1

<b>Shank</b>	VDI 30
<b>Fixation</b>	—
<b>Mounting</b>	square 25x25
<b>Cooling</b>	external, $p_{\max}$ 80 bar
<b>X / Y / Z</b>	55 (2.17) / - / 42.5 (1.67) mm (")

### Matching accessories

Ball nozzle <sup>1</sup>	W00019.0084
Gasket ring <sup>1</sup>	479105.1001
Shim <sup>1</sup>	317244
Countersunk screw <sup>1</sup>	410360.0408
Tool holder	W9991111



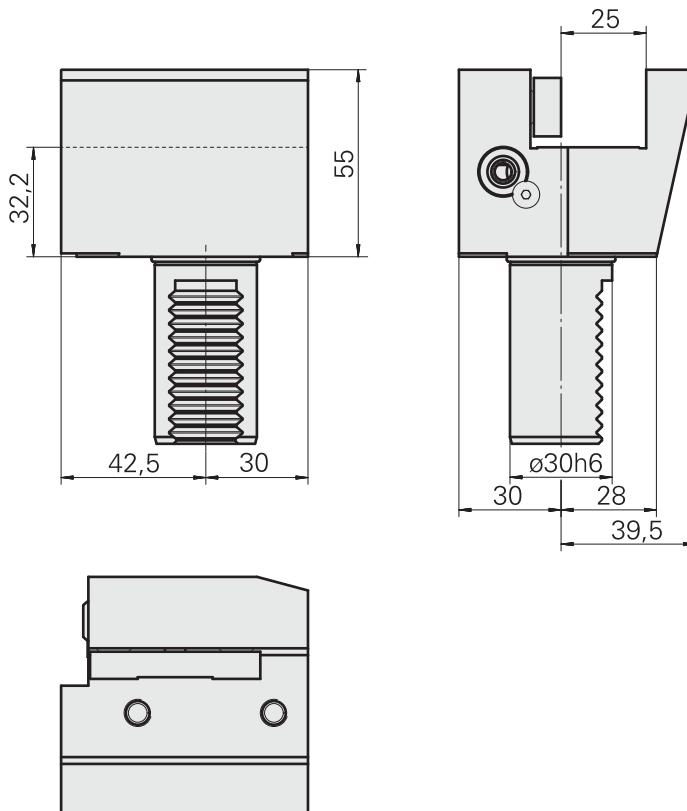
<sup>1</sup> These items are included

## Turning tool holder, C-axis for main and counter spindles

<b>Shank</b>	VDI 30
<b>Fixation</b>	—
<b>Mounting</b>	square 25x25
<b>Cooling</b>	external, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	55 (2.17) / – / 42.5 (1.67) mm (")

### Matching accessories

Ball nozzle	W00019.0084
Gasket ring	479105.1001
Shim	317244
Countersunk screw	410360.0408
Tool holder	W9991111

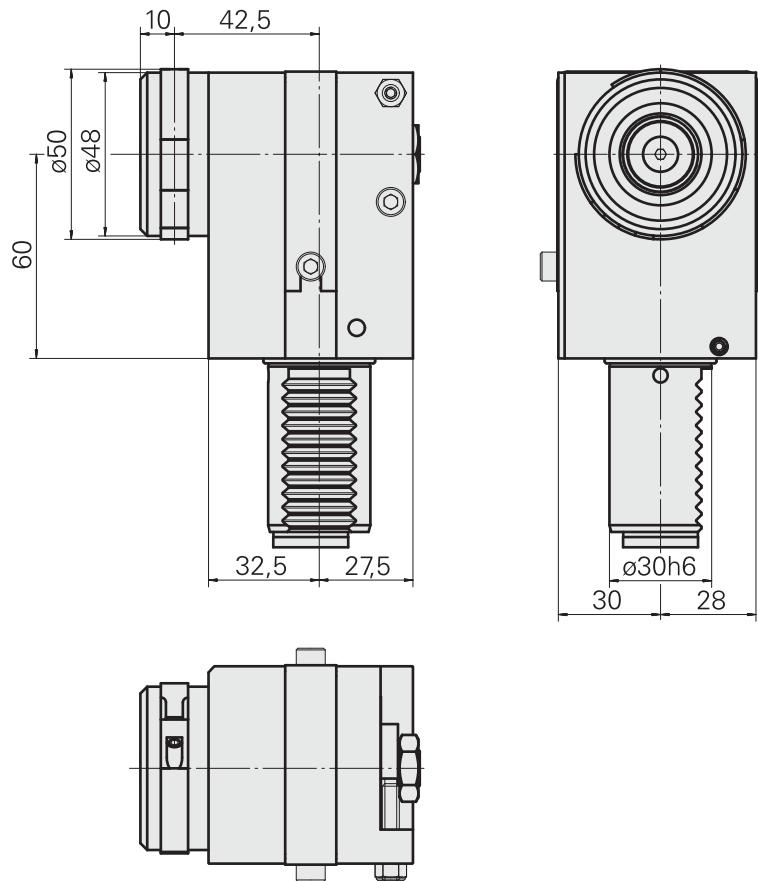


## Scroll holder

<b>Shank</b>	VDI 30
<b>Fixation</b>	none
<b>Mounting</b>	—
<b>Cooling</b>	internal, $p_{\max}$ 20 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	60 (2.36) / – / 42.5 (1.67) mm (")

### Matching accessories

<b>Cover</b>	W63380.1004
<b>Embossing roller<sup>1</sup></b>	W63380.0030
<b>Embossing roller</b>	W63380.0060

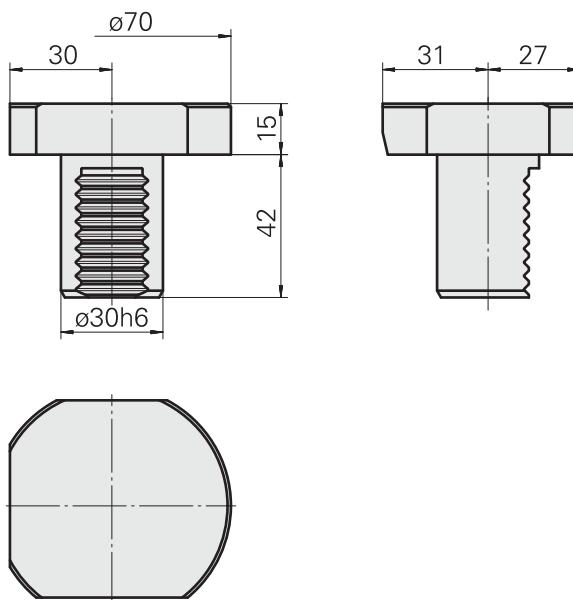


Coolant required for function

<sup>1</sup> These items are included

## Blanking plug, Plastic

Shank	VDI 30
Fixation	—
Mounting	—
Cooling	—
reversible 180°	no
X / Y / Z	15 (0.59) / – / – mm ("")



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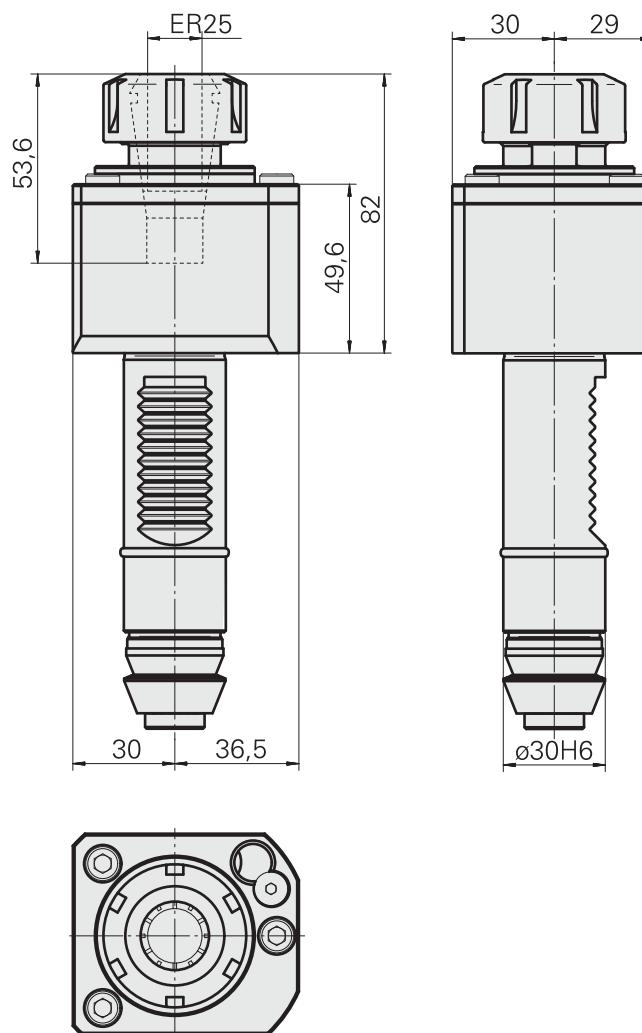
**Turret  
Live Tool Holders  
Shank VDI30**

## Milling unit

<b>Shank</b>	VDI 30
<b>Fixation</b>	—
<b>Drive</b>	Beveled wheel z18/m=1.15
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, $p_{\max}$ 20 bar
<b>Speed ratio</b>	1:1 (1)
<b>Direction</b>	same as drive direction
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	82 (3.23) / — / — mm ("")

### Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping nut <sup>1</sup>	901939.0251
Tube <sup>1</sup>	W63490.0022
Countersunk screw <sup>1</sup>	410360.0512
Spanner	490219.0251



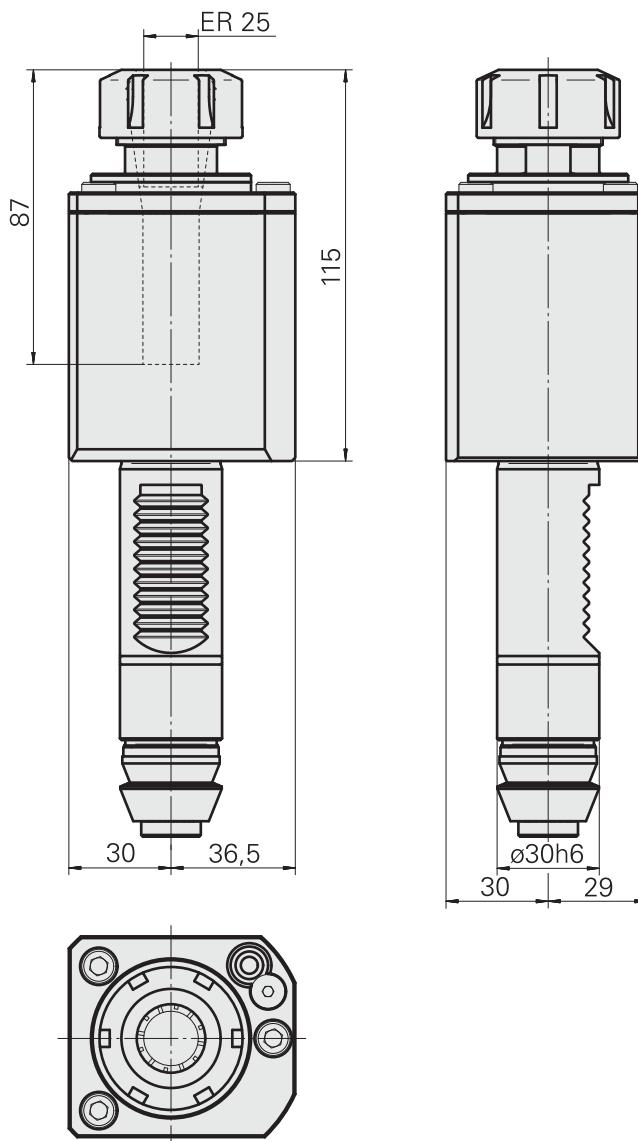
<sup>1</sup> These items are included

## Milling unit

<b>Shank</b>	VDI 30
<b>Fixation</b>	—
<b>Drive</b>	Beveled wheel z18/m=1.15
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, $p_{\max}$ 20 bar
<b>Speed ratio</b>	1:1 (1)
<b>Direction</b>	same as drive direction
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	115 (4.53) / – / 0 mm (")

### Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224-
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping nut <sup>1</sup>	901939.0251
Tube <sup>1</sup>	W63490.0022
Countersunk screw <sup>1</sup>	410360.0512
Countersunk screw <sup>1</sup>	410330.0406
Spanner	490219.0251



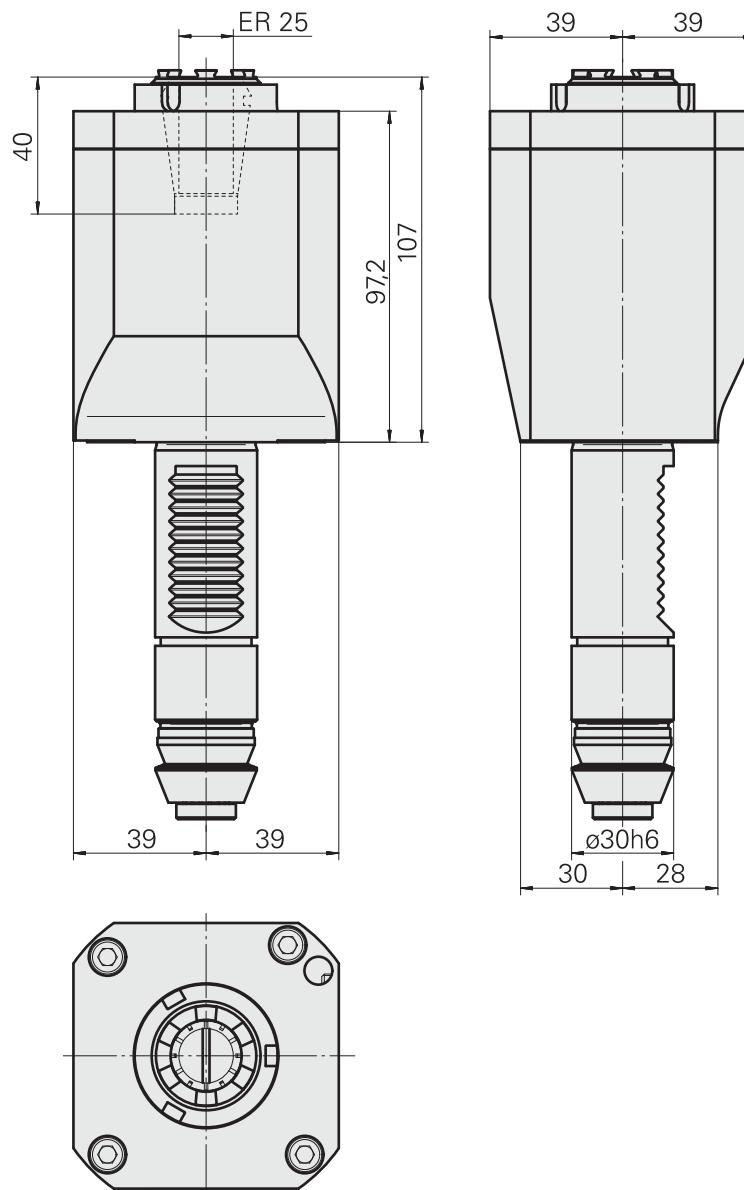
<sup>1</sup> These items are included

## Milling unit

<b>Shank</b>	VDI 30
<b>Fixation</b>	—
<b>Drive</b>	Beveled wheel z18/m=1.15
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, $p_{\max}$ 20 bar
<b>Speed ratio</b>	4.4:1 (4.4)
<b>Direction</b>	same as drive direction
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	105 (4.13) / – / 0 mm (")

### Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224-
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping nut <sup>1</sup>	901939.5251
Tube <sup>1</sup>	8W63340.0508
Spanner	490219.3251



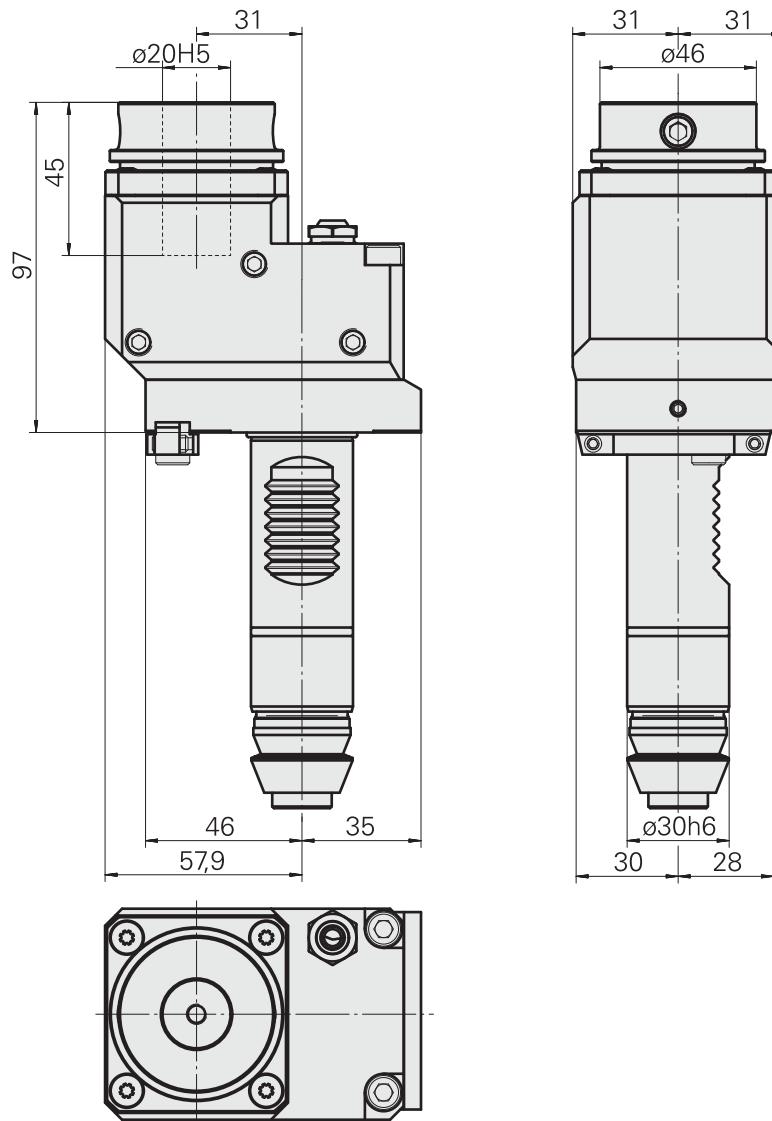
<sup>1</sup> These items are included

## Milling unit

<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Drive</b>	Beveled wheel z18/m=1.15
<b>Mounting</b>	D20 (0.79 ")
<b>Cooling</b>	external, $p_{\max}$ 20 bar
<b>Speed ratio</b>	2:1 (2)
<b>X / Y / Z</b>	97 (3.82) / - / 31 (1.22) mm (")

### Matching accessories

Bush	W68510.04--
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216



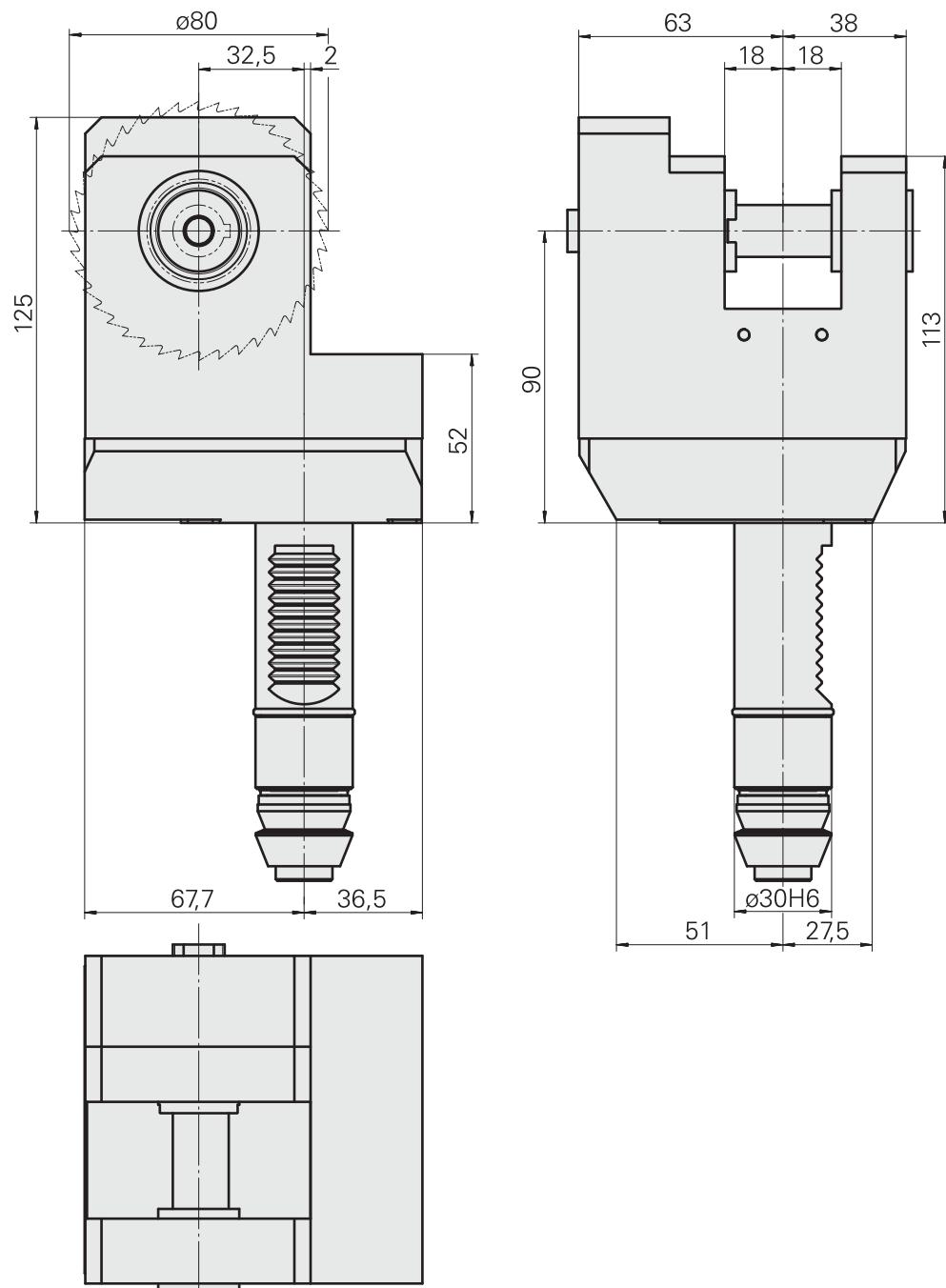
<sup>1</sup> These items are included

## Circular saw unit

<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Drive</b>	Beveled wheel z18/m=1.15
<b>Mounting</b>	Milling shaft D22 (0.87 ")
<b>Cooling</b>	external, $p_{\max}$ 80 bar
<b>Speed ratio</b>	3.97:1 (3.97)
<b>Direction</b>	same as drive direction
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	90 (3.54) / - / 33 (1.30) mm (")

### Matching accessories

Mount <sup>1</sup>	W63852.2150
Screw cap <sup>1</sup>	W63230.1004
Spindle nose cap <sup>1</sup>	471160.08
Ring <sup>1</sup>	471080.08
Tube <sup>1</sup>	W63850.2026
Bush	W63852.2160
Bush	W63852.2170
Bush	W63852.2180



<sup>1</sup> These items are included

## Milling unit

<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Drive</b>	Beveled wheel z18/m=1.15
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, internal optional, $p_{\max}$ 80 bar
<b>Speed ratio</b>	1:1 (1)
<b>Direction</b>	same as drive direction
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	90 (3.54) / - / 89 (3.50) mm (")

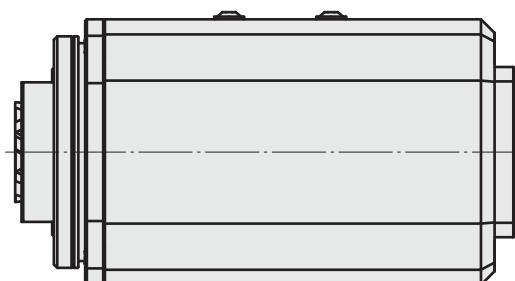
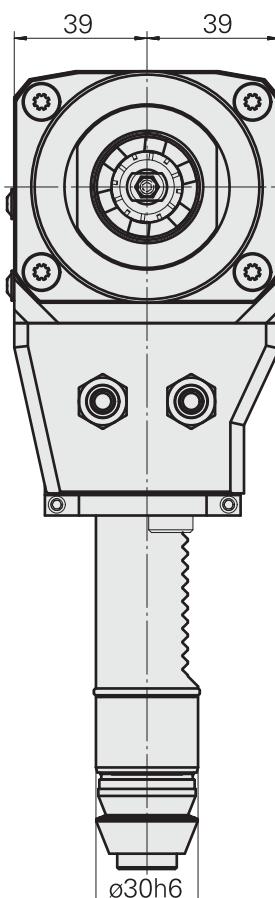
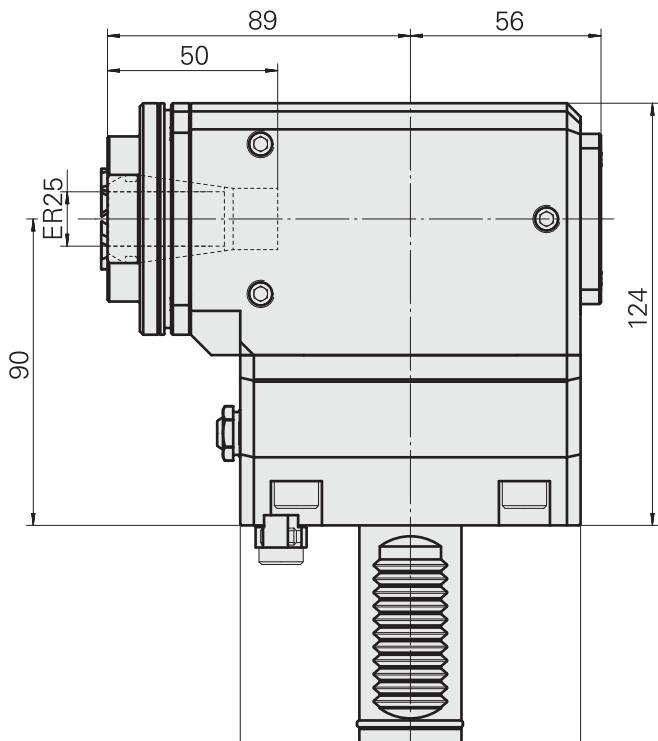
### Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping collet, sealed	W999085-
Clamping nut <sup>1</sup>	901939.5251
IC-attachment up to 160bar	W9990284
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216
Spanner	490219.3251

### Other documents

Product note

[W9800008EN](#)



<sup>1</sup> These items are included

## Milling unit

<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Drive</b>	Beveled wheel z18/m=1.15
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, internal optional, $p_{\max}$ 80 bar
<b>Speed ratio</b>	2:1 (2)
<b>Direction</b>	same as drive direction
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	90 (3.54) / - / 89 (3.50) mm (")

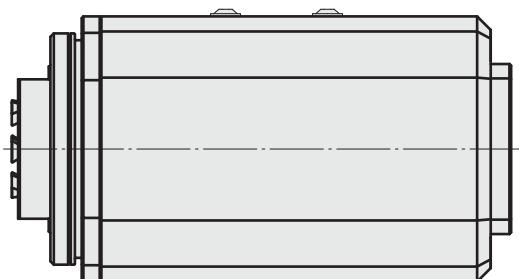
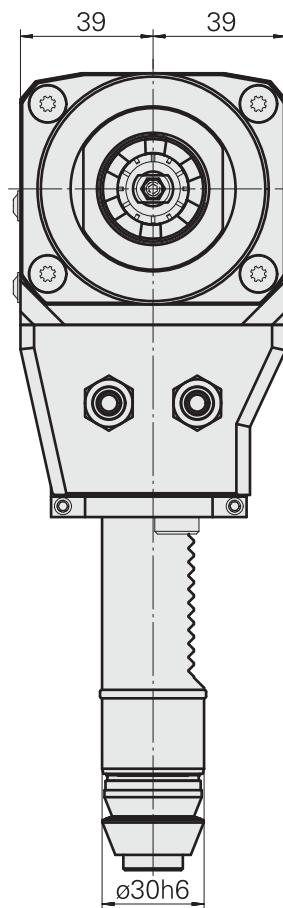
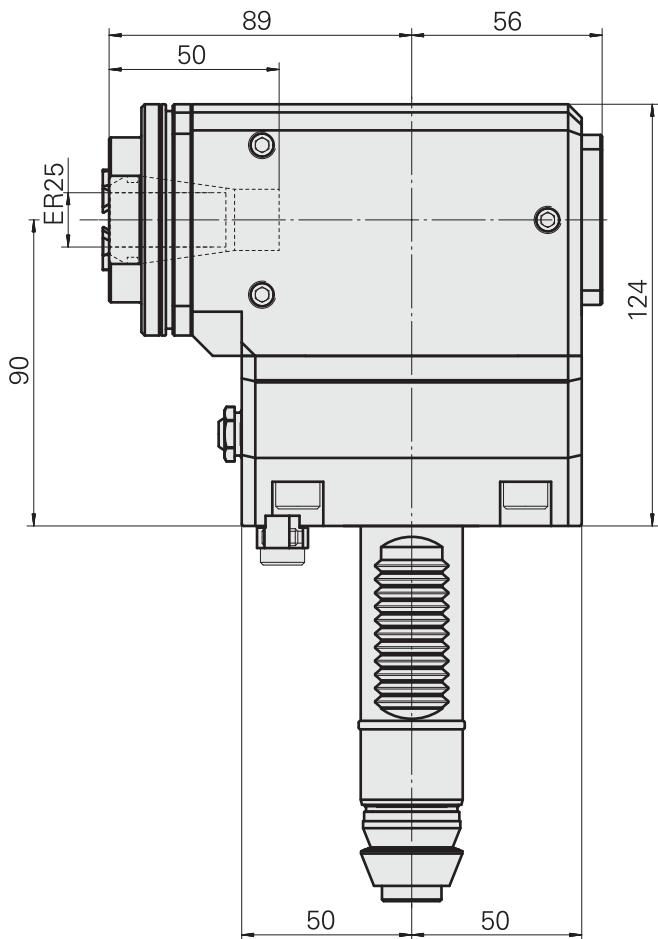
### Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping collet, sealed	W999085-
Clamping nut <sup>1</sup>	901939.5251
IC-attachment up to 160bar	W9990284
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216
Spanner	490219.3251

### Other documents

#### Product note

W9800008EN



<sup>1</sup> These items are included

## Milling unit

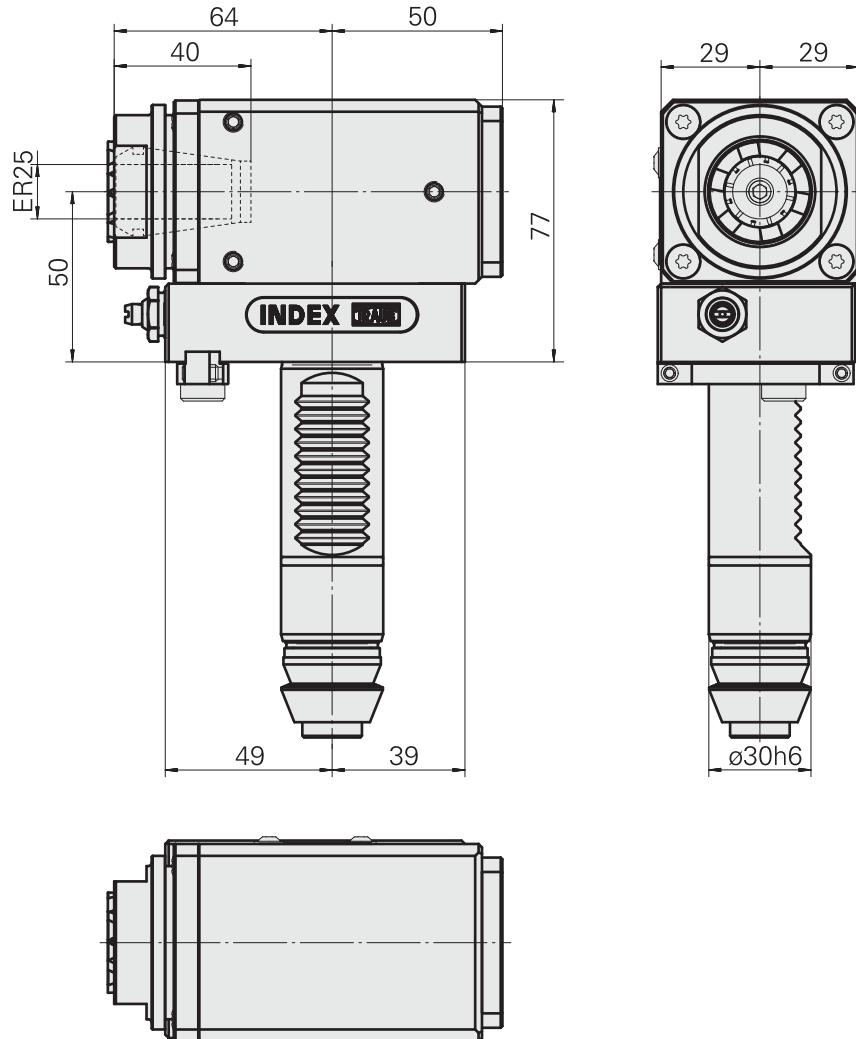
<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Drive</b>	Beveled wheel z18/m=1.15
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, internal optional, $p_{\max}$ 80 bar
<b>Speed ratio</b>	2:1 (2)
<b>Direction</b>	same as drive direction
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	50 (1.97) / - / 64 (2.52) mm (")

### Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping collet, sealed	W999085-
Clamping nut <sup>1</sup>	901939.5251
IC-attachment up to 160bar	W9990284
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216
Spanner	490219.3251

### Other documents

Product note	W9800008EN
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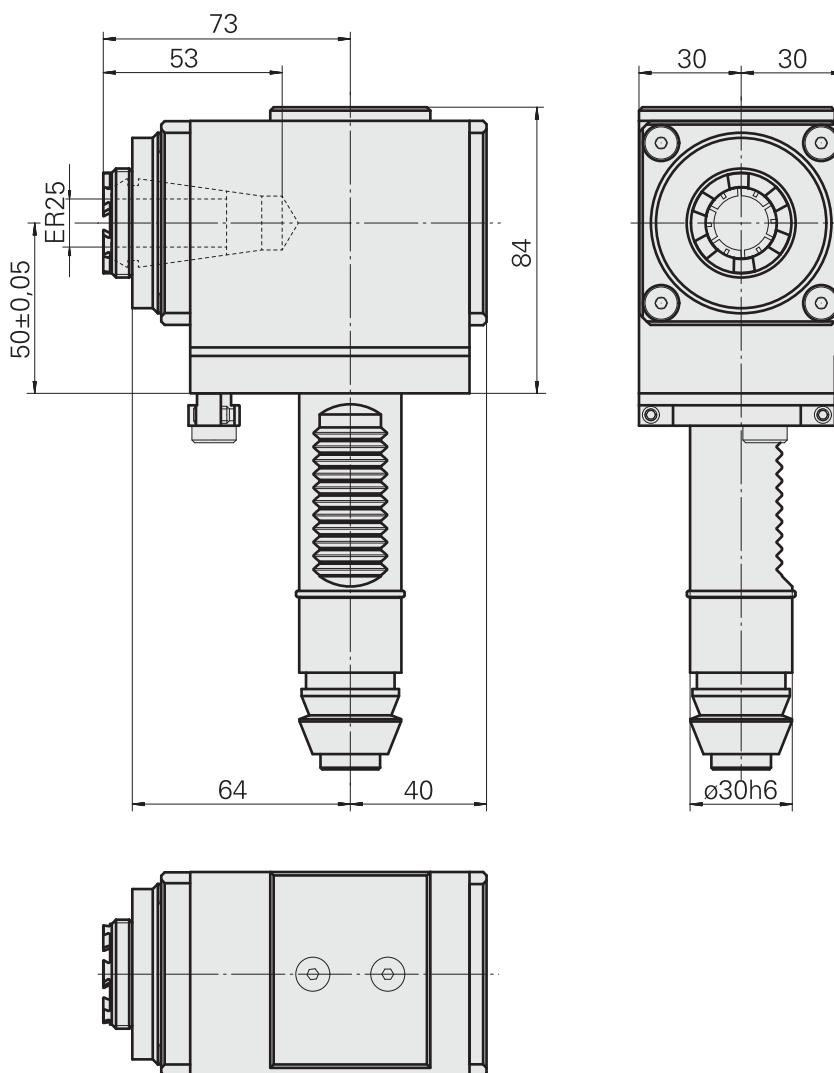
<sup>1</sup> These items are included

## Milling unit

<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Drive</b>	Beveled wheel z18/m=1.15
<b>Mounting</b>	ER 25
<b>Cooling</b>	external, $p_{\max}$ 20 bar
<b>Speed ratio</b>	2.27:1 (2.27)
<b>Direction</b>	opposite to drive direction
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	50 (1.97) / - / 73 (2.87) mm (")

## Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping nut <sup>1</sup>	901939.5251
Ball nozzle <sup>1</sup>	474550.0121
Tube <sup>1</sup>	W63501.2622
Spanner	490219.3251
Hook wrench	490340.0500



<sup>1</sup> These items are included

## Milling unit

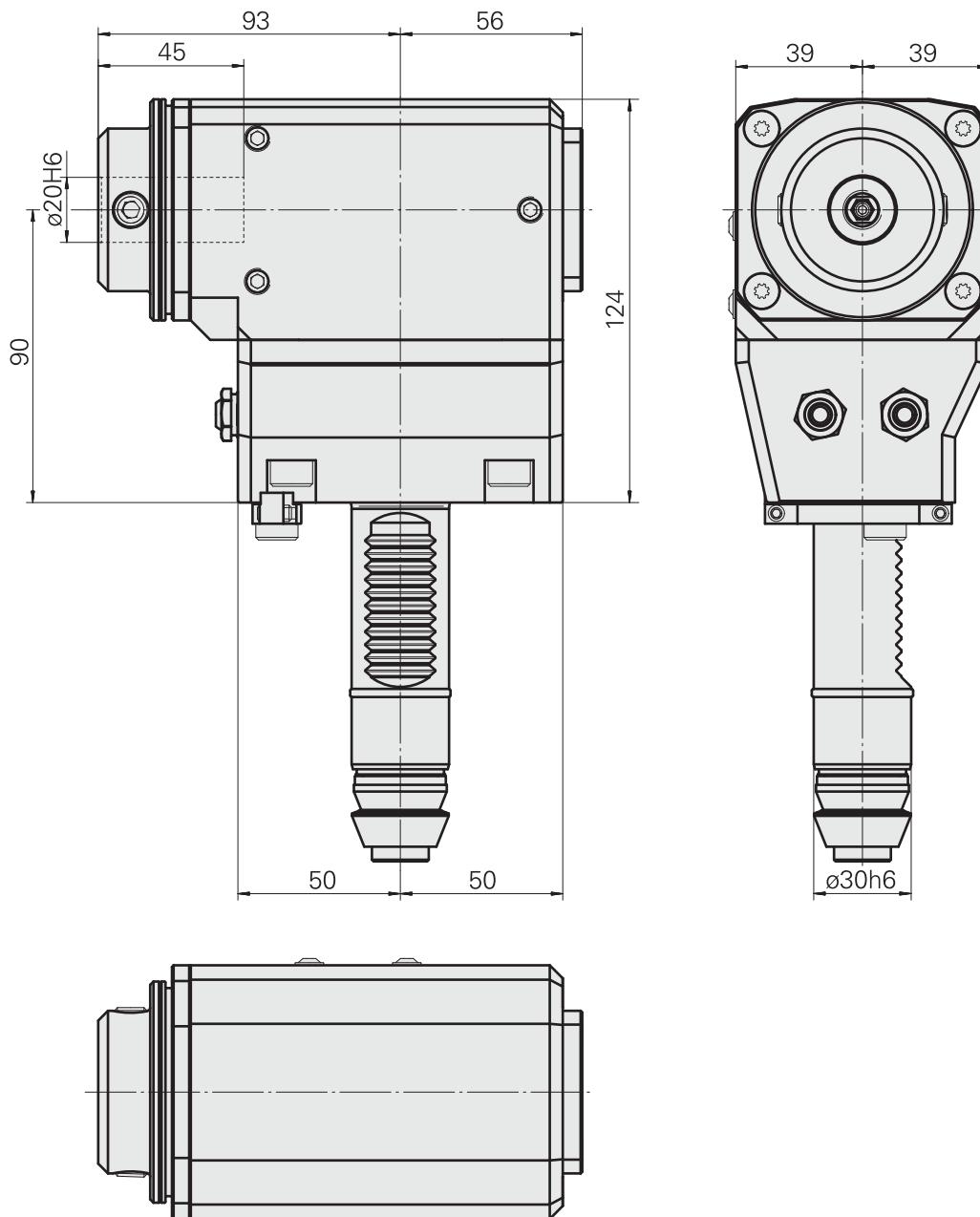
<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Drive</b>	Beveled wheel z18/m=1.15
<b>Mounting</b>	DIN 1835 B/E D20 (0.79 ")
<b>Cooling</b>	external, internal optional, $p_{\max}$ 80 bar
<b>Speed ratio</b>	2:1 (2)
<b>Direction</b>	same as drive direction
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	90 (3.54) / - / 93 (3.66) mm (")

### Matching accessories

IC-attachment up to 160bar	W9990284
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216

### Other documents

Product note	W9800008EN
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<sup>1</sup> These items are included

## Milling unit

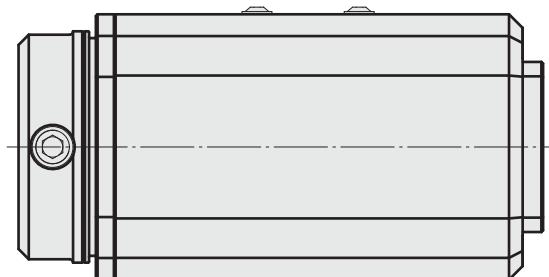
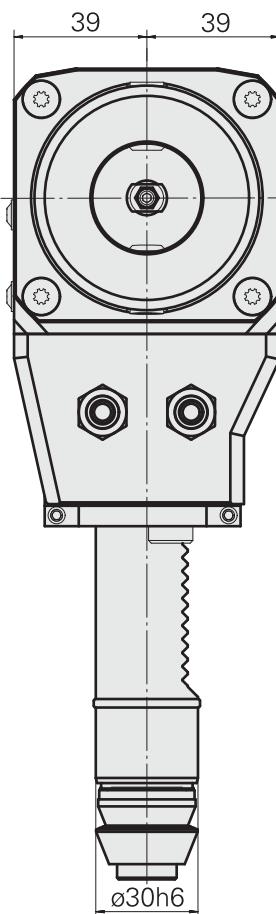
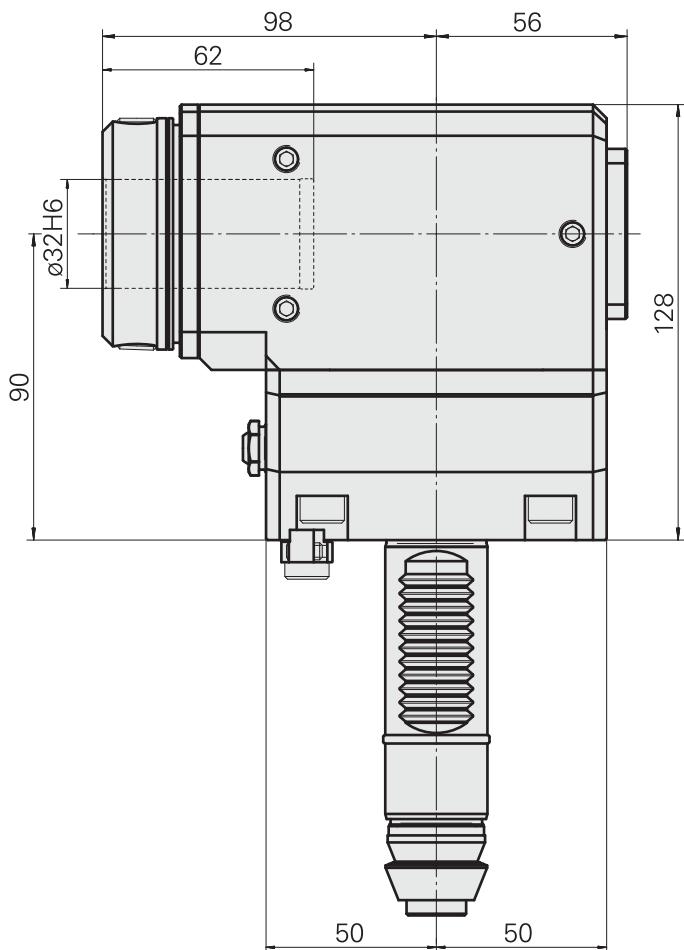
<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Drive</b>	Beveled wheel z18/m=1.15
<b>Mounting</b>	DIN 1835 B/E D32 (1.26 ")
<b>Cooling</b>	external, internal optional, $p_{\max}$ 80 bar
<b>Speed ratio</b>	2:1 (2)
<b>Direction</b>	same as drive direction
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	90 (3.54) / - / 98 (3.86) mm (")

### Matching accessories

Bush	W63220.02--
Bush	W63221.40--
IC-attachment up to 160bar	W9990284
Bush <sup>1</sup>	W67530.0824
Hollow screw <sup>1</sup>	W67530.0818
Ball nozzle <sup>1</sup>	W67500.3208
Nozzle	W00019.0216

### Other documents

Product note	<a href="#">W9800008EN</a>
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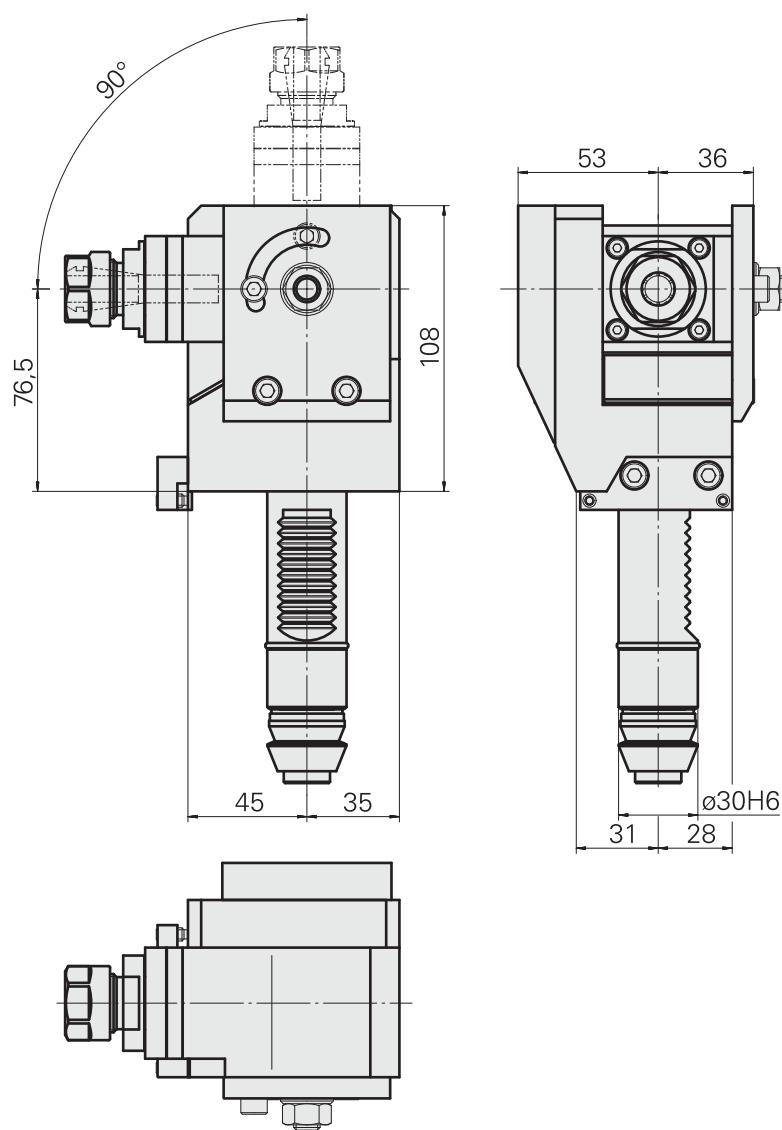
<sup>1</sup> These items are included

## Drilling unit, angle-adjustable

<b>Shank</b>	VDI 30
<b>Fixation</b>	Setting gauge
<b>Drive</b>	Beveled wheel z18/m=1.15
<b>Mounting</b>	ER 16
<b>Cooling</b>	external, $p_{\max}$ 20 bar
<b>Speed ratio</b>	1:2.141 (0.467)
<b>Direction</b>	same as drive direction
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	76.5 (3.01) / - / 0 mm (")

### Matching accessories

Clamping collet	901930.1---
Clamping collet	W99903--
tapping tool collet	3230--
tapping tool collet	WZ9990.9506F
Collet chuck	W999065-
Clamping nut <sup>1</sup>	901939.01
Screw cap <sup>1</sup>	471672.08
Spindle nose cap <sup>1</sup>	471160.08
Ring <sup>1</sup>	471080.08
Tube <sup>1</sup>	W63510.5032
Spanner	490219.0161



Drawing scale changed,  
template inapplicable!

<sup>1</sup> These items are included

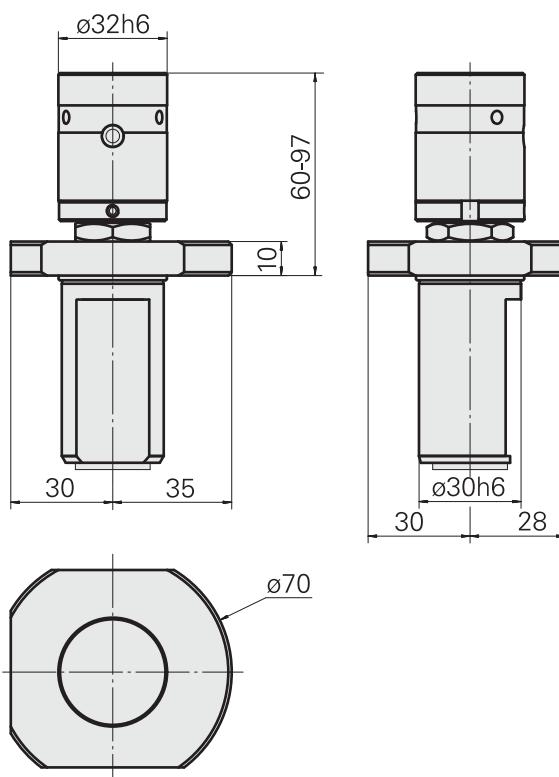


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**Multifunction turret  
Stationary tool holders  
Shank VDI30**

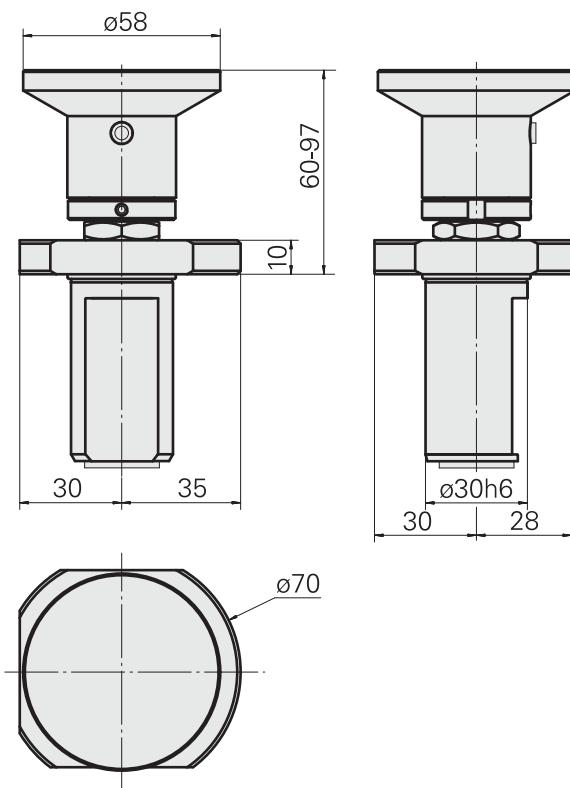
## Bar stop, adjustable, live

Shank	VDI 30
Fixation	none
Mounting	—
Cooling	—
reversible 180°	no
X / Y / Z	60 - 97 (2.36 - 3.82) / - / - mm (")



## Bar stop, adjustable, live

Shank	VDI 30
Fixation	none
Mounting	—
Cooling	—
reversible 180°	no
X / Y / Z	60 - 97 (2.36 - 3.82) / - / - mm ("")

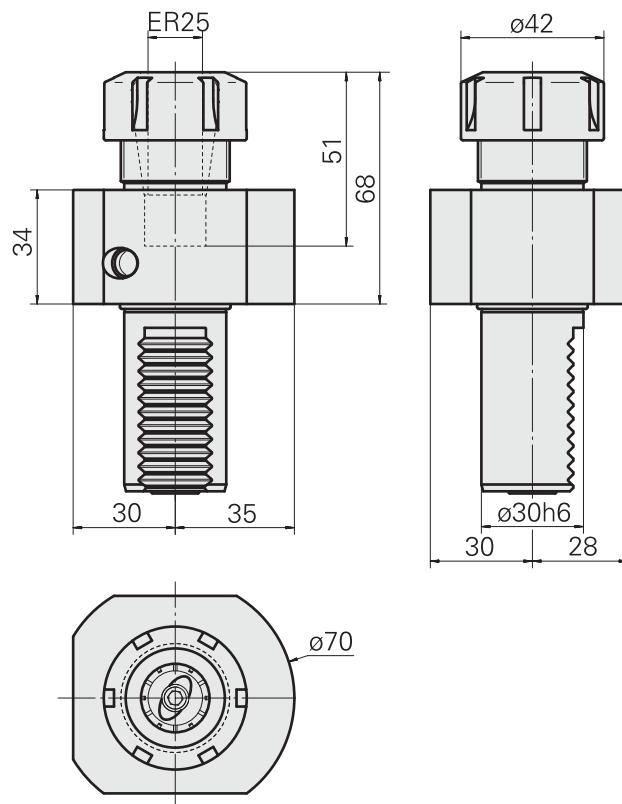


## Drilling tool holder, Form E4

<b>Shank</b>	VDI 30
<b>Fixation</b>	none
<b>Mounting</b>	ER 25
<b>Cooling</b>	internal, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	68 (2.68) / - / - mm (")

### Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping nut*	901939.0251
Spanner	490219.0251



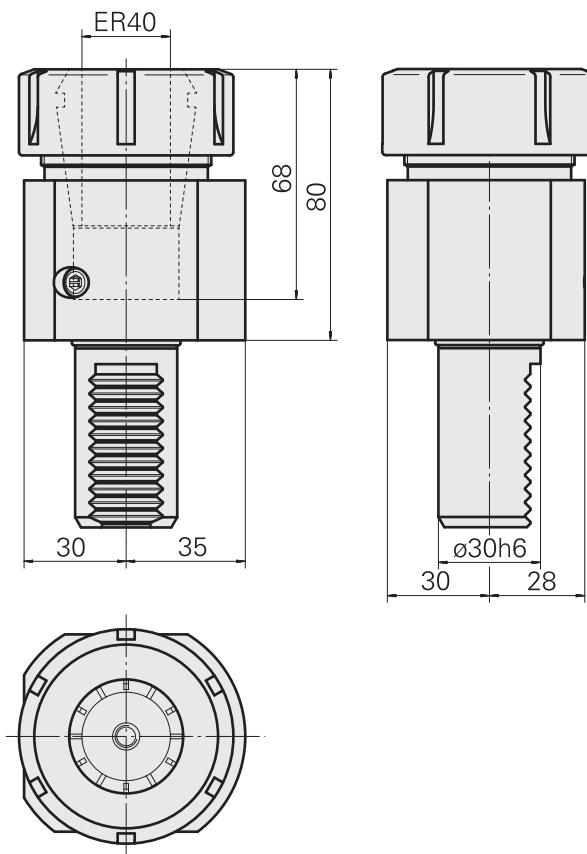
\* This article is included

## Drilling tool holder, Form E4

<b>Shank</b>	VDI 30
<b>Fixation</b>	none
<b>Mounting</b>	ER 40
<b>Cooling</b>	internal, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	80 (3.15) / - / - mm (")

### Matching accessories

Clamping collet	901930.4---
Clamping nut*	901939.0401
Spanner	490219.0401



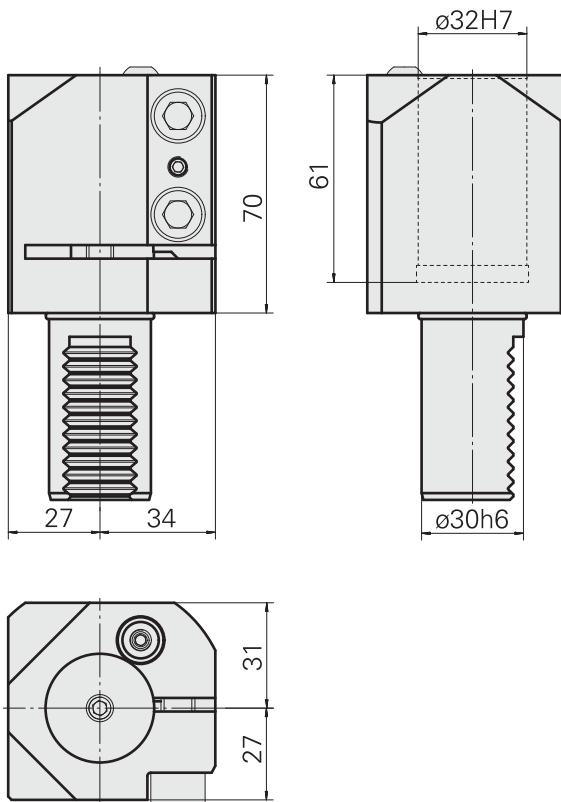
\* This article is included

## Drilling tool holder, Form E2

<b>Shank</b>	VDI 30
<b>Fixation</b>	none
<b>Mounting</b>	D32
<b>Cooling</b>	external, $p_{\max}$ 20 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	70 (2.76) / - / - mm (")

### Matching accessories

<b>Bush</b>	W63220.02--
<b>Nozzle*</b>	474550.0121



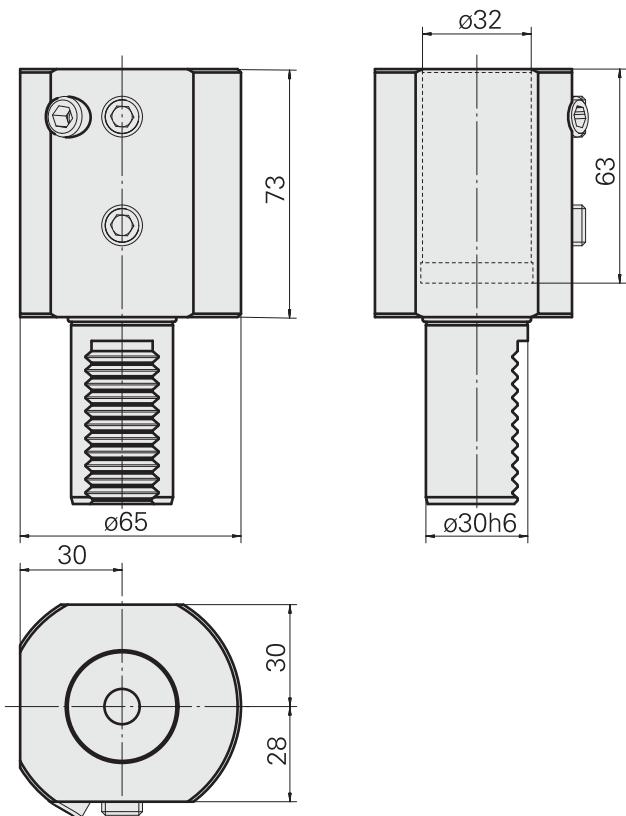
\* This article is included

## Drilling tool holder

<b>Shank</b>	VDI 30
<b>Fixation</b>	none
<b>Mounting</b>	D32
<b>Cooling</b>	internal, $p_{\max}$ 80 bar
<b>reversible 180°</b>	no
<b>X / Y / Z</b>	73 (2.87) / - / - mm (")

### Matching accessories

<b>Bush</b>	W63221.4020
<b>Bush</b>	W63221.4025

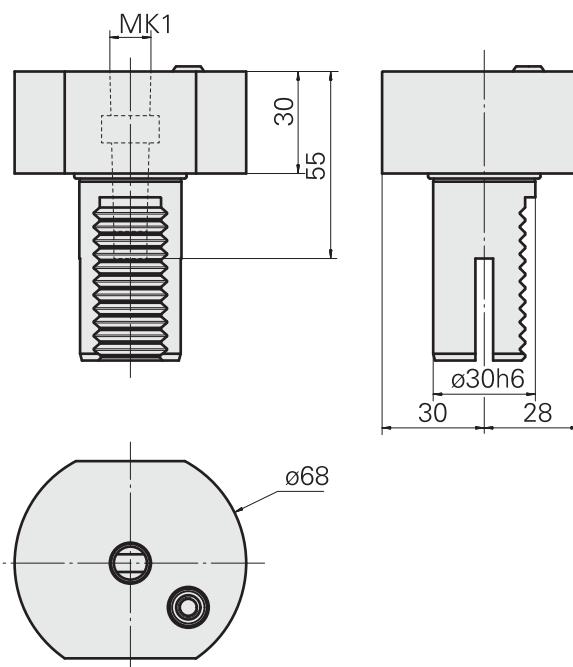


## Drilling tool holder

Shank	VDI 30
Fixation	none
Mounting	MK1
Cooling	external, $p_{\max}$ 20 bar
reversible 180°	no
X / Y / Z	30 (1.18) / - / - mm (")

### Matching accessories

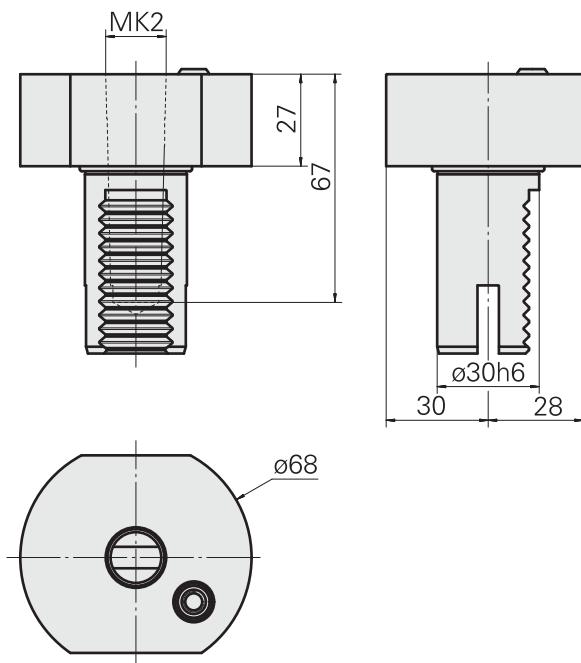
Nozzle*	474550.0121
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\* This article is included

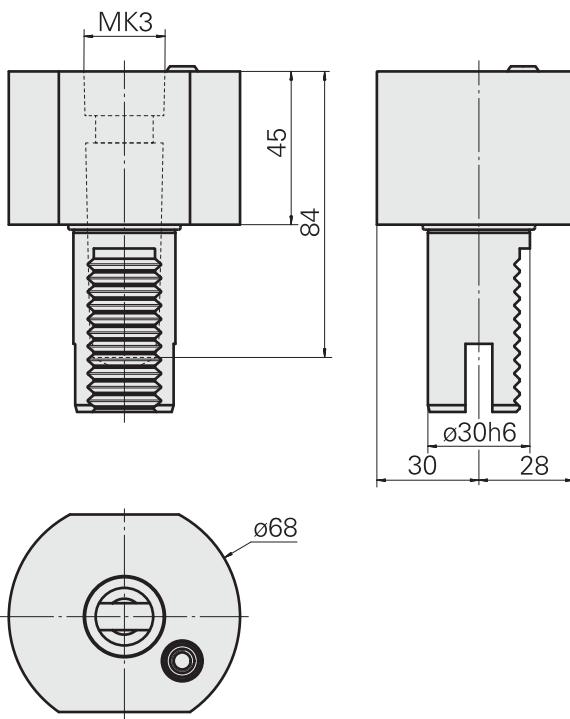
## Drilling tool holder

Shank	VDI 30
Fixation	none
Mounting	MK2
Cooling	external, $p_{\max}$ 20 bar
reversible 180°	no
X / Y / Z	27 (16) / - / - mm (")



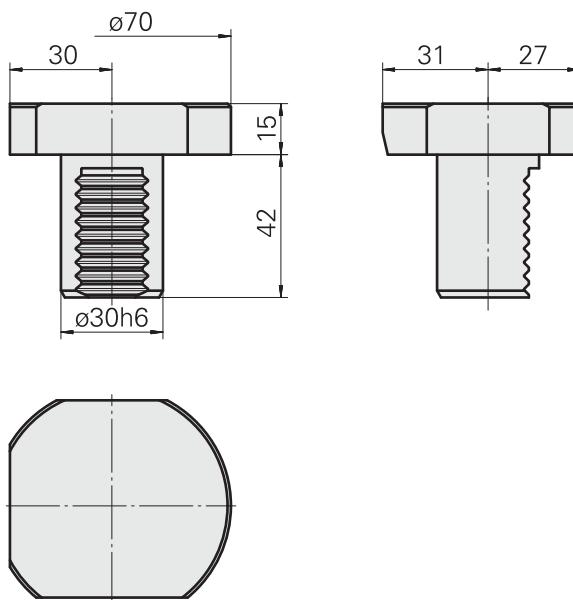
## Drilling tool holder

Shank	VDI 30
Fixation	none
Mounting	MK3
Cooling	external, $p_{\max}$ 20 bar
reversible 180°	no
X / Y / Z	45 (1.77) / - / - mm (")



## Blanking plug, Plastic

Shank	VDI 30
Fixation	—
Mounting	—
Cooling	—
reversible 180°	no
X / Y / Z	15 (0.59) / – / – mm ("")





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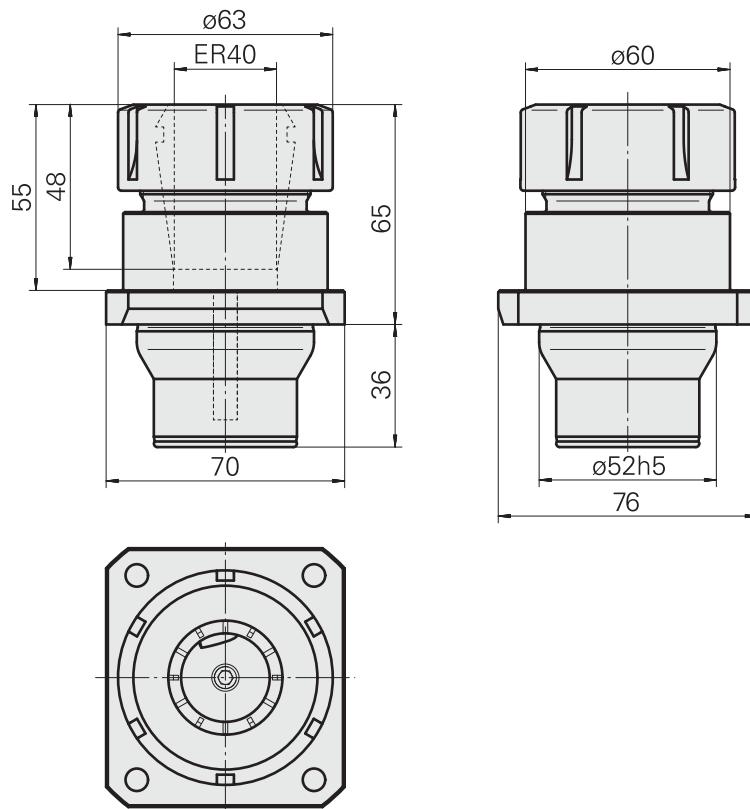
**Multifunction turret  
Stationary tool holders  
Shank UniFlex 52**

## Drilling tool holder

<b>Shank</b>	UniFlex 52
<b>Fixation</b>	none
<b>Mounting</b>	ER 40
<b>Cooling</b>	–, $p_{\max}$ 80 bar
<b>reversible 180°</b>	yes
<b>X / Y / Z</b>	65 (2.56) / – / – mm ("")

### Matching accessories

Clamping collet	901930.4---
Clamping nut*	901939.0401
Spanner	490219.0401



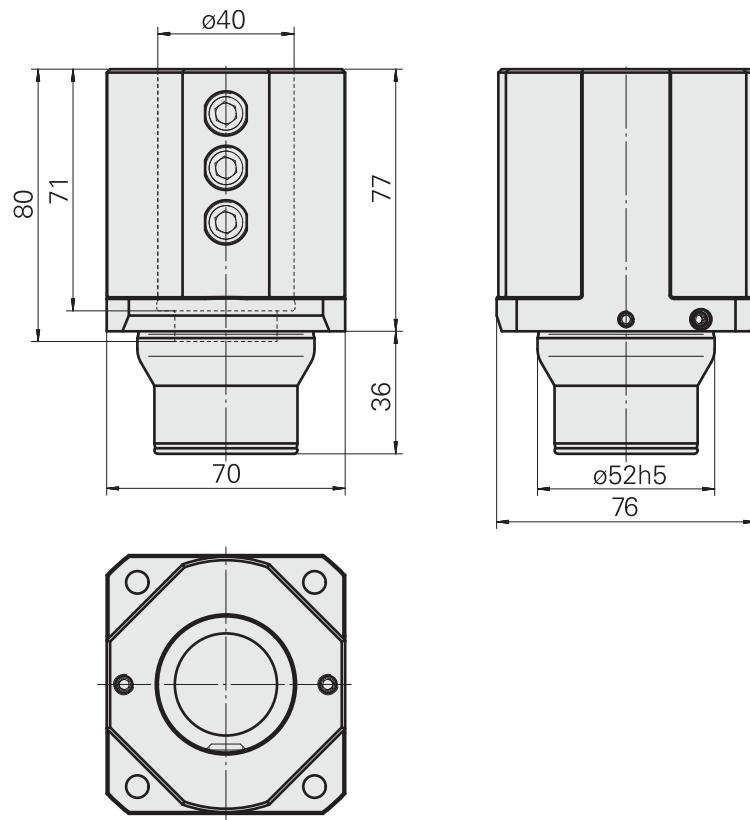
\* This article is included

## Drilling tool holder

Shank	UniFlex 52
Fixation	none
Mounting	D40
Cooling	-, $p_{\max}$ 80 bar
reversible 180°	yes
X / Y / Z	77 (33) / - / - mm (")

### Matching accessories

Bush	W64222.41--
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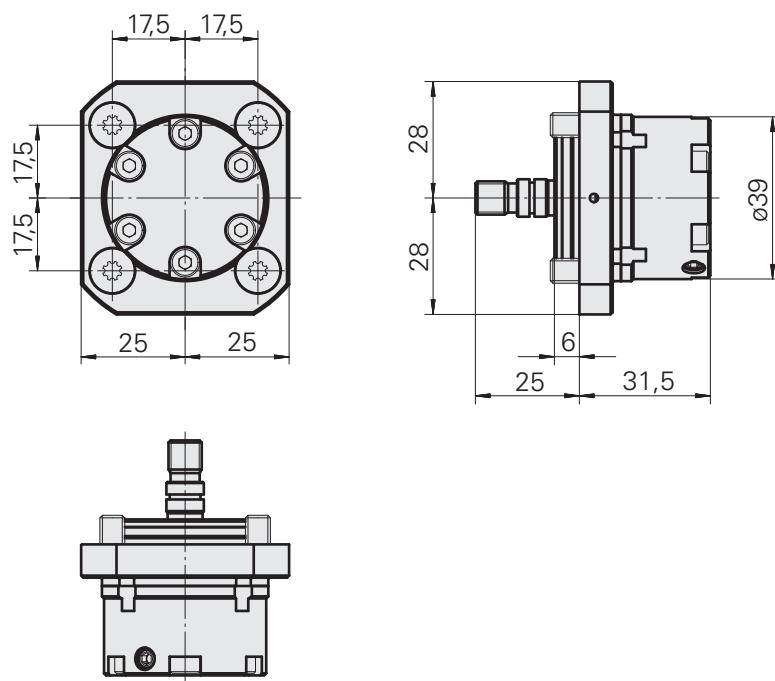
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**Accessories**  
**IT600**

## IC attachment

For internal cooling lubricant supply, up to 160 bar

Dry run-capable



**Product notes  
IT600**

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## Product note

### **External/internal cooling lubricant supply**

Drill holder with cylindrical shank tool mounting

Offset set screws

## **Disclaimer**

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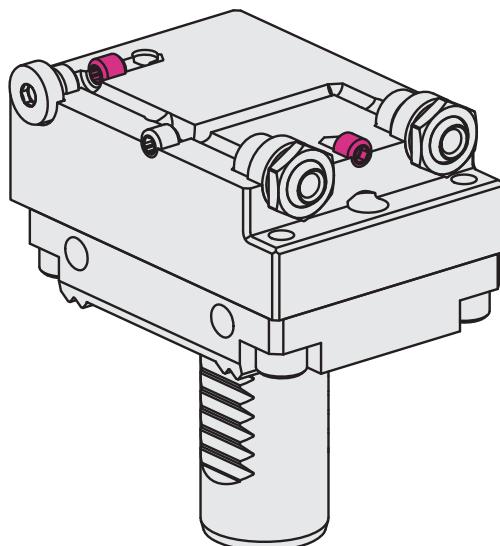
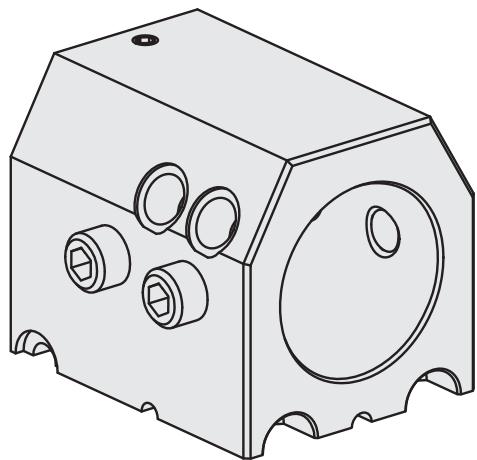
## External/internal cooling lubricant supply

Drill holder with cylindrical shank tool mounting

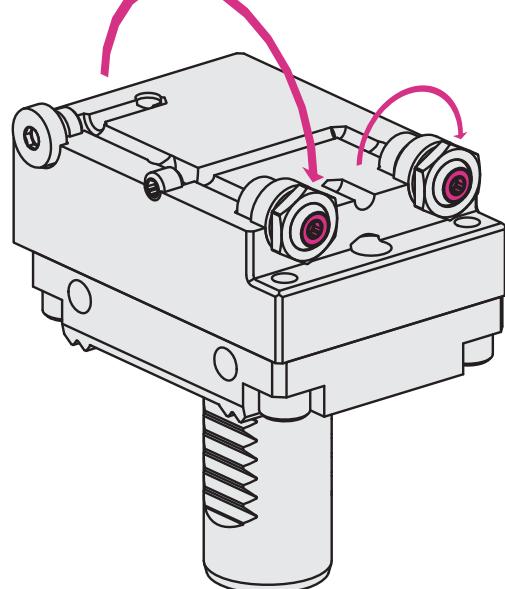
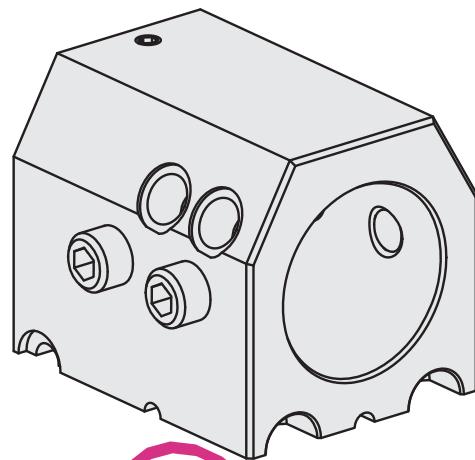
Offset set screws

### External cooling lubricant supply

Delivery condition



### Internal cooling lubricant supply



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## Product note

### External/internal cooling lubricant supply

Milling unit, lid convertible to IC 80 bar / 160 bar

Offset set screws

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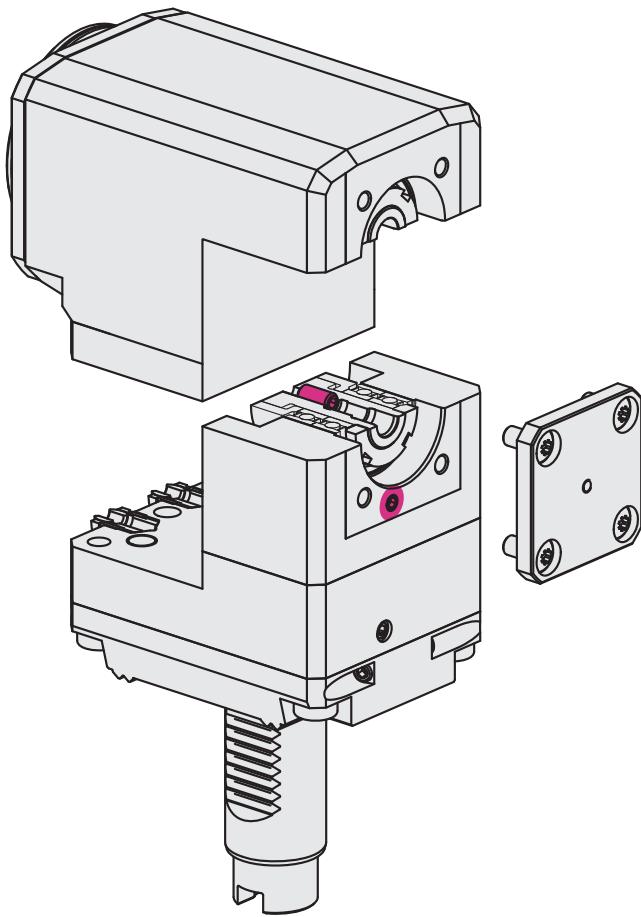
## External/internal cooling lubricant supply

Milling unit, lid convertible to IC 80 bar / 160 bar

Offset set screws

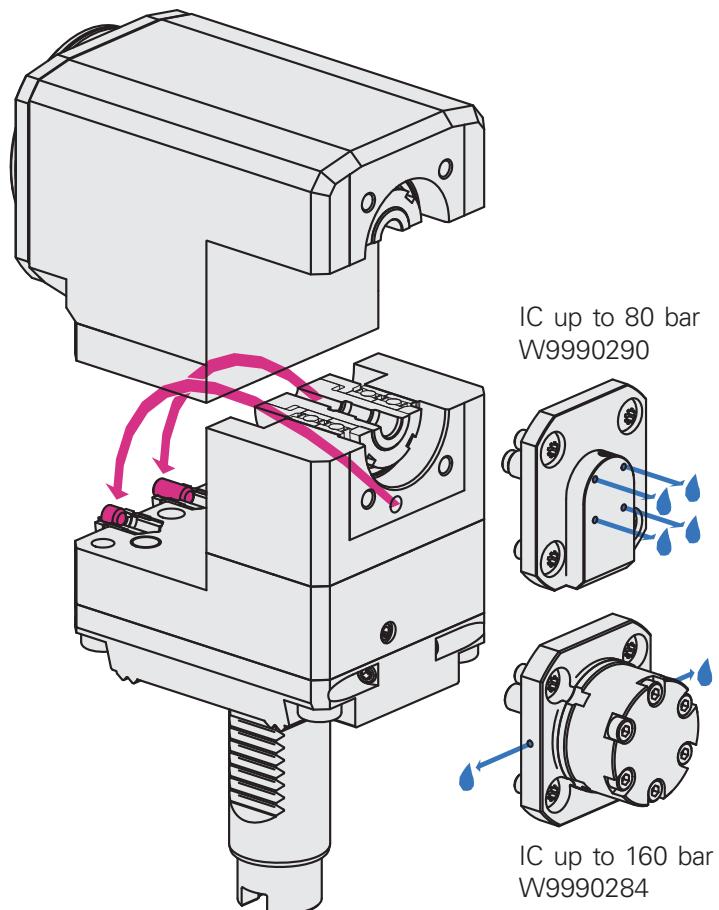
### External cooling lubricant supply

Delivery condition



### Internal cooling lubricant supply

Conversion possible with cooling lubricant attachment kit:  
max. 80 bar W9990290, max. 160 bar W9990284



**Conversion of set screws to IC 80 bar (W9990290), limited dry-running capability  
not be used for drive Bevel wheel z18/m=1.15**

- Cooling lubricant may briefly exit at 4 holes
- In case of prolonged exit, remove the cooling lubricant attachment kit (W9990290) again
- Check yellow ceramic disk; it should snugly seat against the spindle after the assembly

**Conversion of set screws to IC 160 bar (W9990284), limited dry-running capability**

- Cooling lubricant may briefly exit at 1 hole
- In case of prolonged exit, remove the tool holder from the turret disk
- Charge cooling lubricant supply briefly with compressed air; reinstall tool holder

If cooling lubricant continues to exit, please contact our tool holder advisers at +49 7153 502-9854.

#### Product note

External/internal cooling lubricant supply  
W9800008EN-22.01.2013

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