

ALPS TOOL

CNC 车床用工具

NICE MILL 系列

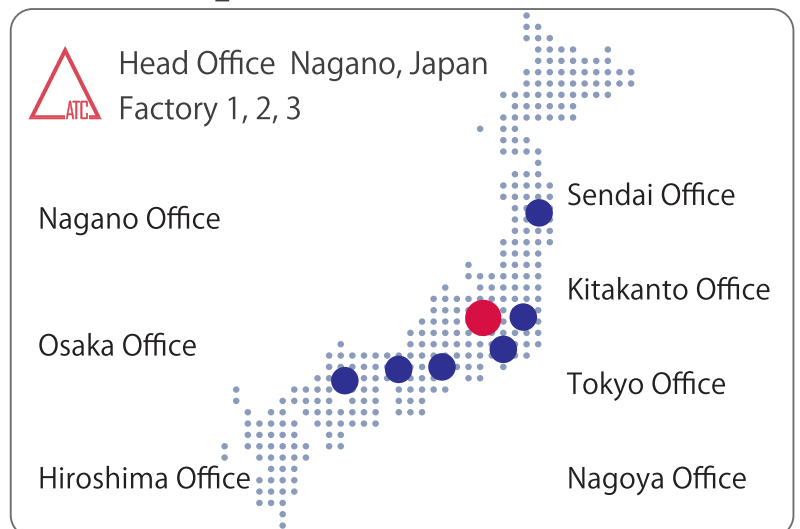
产品目录



ALPS TOOL Global Network



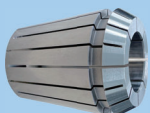
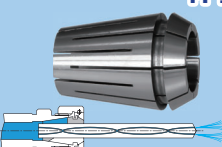
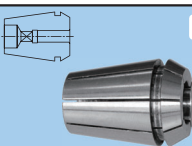
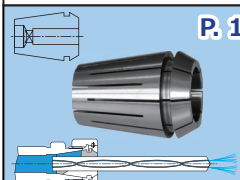
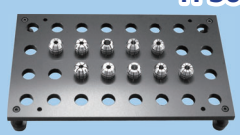
Japan



www.alpstool.com

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什么是 NICE MILL

阿尔卑斯工具 (ALPS TOOL) 的 NICE MILL 是为机床提供全面支持的产品、兼容夹头刀柄、AR 筒夹、螺母和其他工具。

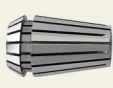
ALPS TOOL's NICE MILL are products that provide total support for machine tooling, with compatibility for collet holders, AR collets, nuts, and other tooling.

用于转塔车床

带法兰



螺帽
Nut



AR 筒夹
AR Collet



筒夹夹头刀柄
Collet Chuck Holder

用于瑞士型车床

微式



螺帽
Nut



AR 筒夹
AR Collet



筒夹夹头刀柄
Collet Chuck Holder



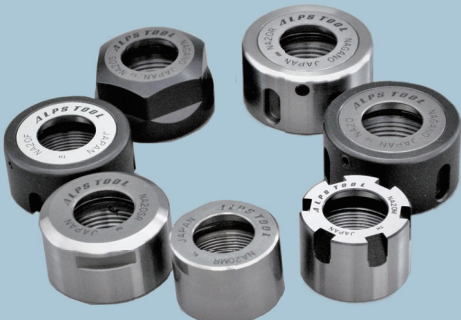
AR (ER) 筒夹

- ① 欧美标准 16°锥形筒夹。(DIN6499 / ISO15488 规格)
- ② 提供 $\varnothing 0.3$ 至 $\varnothing 34$ 范围内的各种系列尺寸
- ③ 通过 ISO9001 质量体系提供质量稳定的夹头。
- ④ 用于标准、冷却液通过、攻丝等的各种夹头
- ⑤ AAA 级 $3\mu m$ 、AA 级 $5\mu m$ 、A 级 $8\mu m$ ，满足严格的检测标准



用于 CNC 数控车床的刀柄

- ① 适用于小型自动瑞士型车床到中型和大型机器。
- ② 中心调整型、双头刀柄、带浮动功能的丝锥刀柄等多种产品阵容。
- ③ 夹头螺母作为标准配置 (随附)。
- ④ 也可支持小型镗孔刀柄。
- ⑤ 特殊尺寸请联系我们。

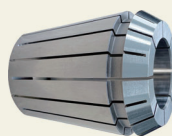


螺帽

- ① 适用于大中型机器的轴承螺母。
- ② 小型机器用六角头螺母和迷你螺母 (如瑞士型机器)
- ③ 平衡设计的 R 型螺母，非常适合刀柄的高速旋转。
- ④ 如需其他特殊形状，请随时联系我们

ER 和 AR 规格相同

5 种类 AR(ER) 筒夹



AR 筒夹 标准型

P. 8

大多数标准弹簧夹头。(一般钻孔刀用筒夹)
从 AR8 ~ AR50 到供应。

Most standard collet chucks.
AR8-AR50 are available.



AR 中心出水用筒夹 OH 型

P. 10

刀具中心出水用

特殊液密封缝隙

for Coolant thru tools.
Liquid-tight sealing slits.



AR 侧面出水用筒夹 C 型

P. 12

内孔槽的冷却液有效集中喷射到切削刃

Effective Coolant supply from the bore grooves to the cutting edge.



AR 丝锥筒夹 GB 型

P. 14

后部加工有方孔的筒夹

依据丝锥后方四方形状加工的筒夹可防止回转

Collet with a square hole machined in the rear.



AR 冷却液直通丝锥筒夹 GH 型

P. 15

适用于带冷却液通孔的丝锥

for Coolant thru Taps.

AR(ER) 筒夹的等级

Class	Grade				
	AR	AR/OH	AR/C	AR/GB	AR/GH
AAA	○ *1	-	-	-	-
AA	○	○	○	-	-
A	○	○	○	-	-

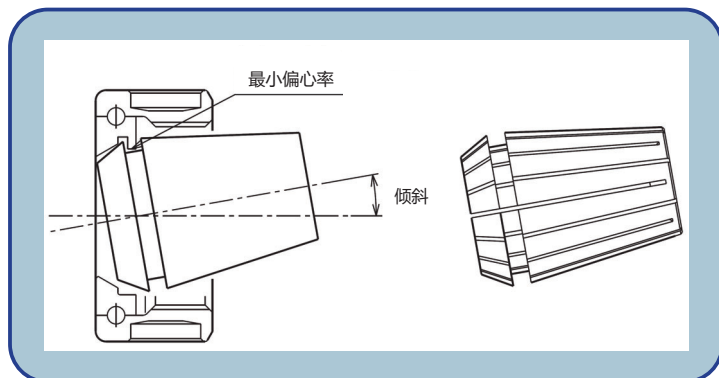
*1 AR8,AR40,AR50 未设定 AAA 等级

* 详参照第 7 页

如何在 NA 螺母中安装 AR 筒夹

How to Install AR Collet in NA Nut

轻松可靠地装上 / 取下筒夹



将筒夹的槽钩在螺母的偏心凸部上，使筒夹倾斜，即可安装和拆卸筒夹。

*Note 注

- (1) 首先，请将筒夹装入螺母，然后将其拧入机体。
- (2) 请将刀具柄插入比筒夹夹头背面端面更深的位置使用。

The Collet can be attached and detached by hooking the groove of the collet onto the eccentric convex in the nut and tilting the collet.

AR 筒夹夹持的特点

Features of AR Collet Chucks

- ER 和 AR 是相同的规格。
- 欧美标准 16°锥形筒夹。(DIN6499 / ISO15488 规格)
- 供应 $\varnothing$ 0.3 至 $\varnothing$ 34 范围内的各种系列尺寸。

- ER and AR is same specifications.
- Most standard 16 degree collet chucks. DIN6499 / ISO15488
- Various series sizes are available in the range of $\varnothing$ 0.3 to $\varnothing$ 34.

夹持范围

Gripping Range

- 详情请参阅第 8-15 页。
- 比公称直径大的尺寸无法夹持。

- See Page 8-15 for details.
- Sizes larger than the product code diameter cannot be chucked.

芯跳动精度 (TIR)

Accuracy of Runout (TIR)

AR 筒夹

尺寸	公称直径	测量位置	等级精度 (μm)		
Size	d	L	A 級	AA 級	AAA 級
AR 8	0.5 - 5	4 x d	8	5	-
AR11	1 - 7	4 x d	8	5	3
AR16	1 - 10	4 x d	8	5	3
AR20	1 - 13 (14)	4 x d	8	5	3
AR25	1 - 16	4 x d	8	5	3
AR32	2.5 - 20	4 x d	8	5	3
AR40	4 - 26	4 x d	8	5	-
AR50	6 - 10	25	8	5	-
	12 - 26	40			
	28 - 34	60	18	10	

Class	Grade				
	AR	AR/OH	AR/C	AR/GB	AR/GH
AAA	○	-	-	-	-
AA	○	○	○	-	-
A	○	○	○	-	-

* AR8,AR40,AR50 未设定 AAA 等级

* 丝锥筒夹 GB 和 GH 根据单独的标准进行检查。

*AR8, AR40 and AR50 are not set to AAA standards.

*Tap Collet GB and GH are inspected according to separately established standards.

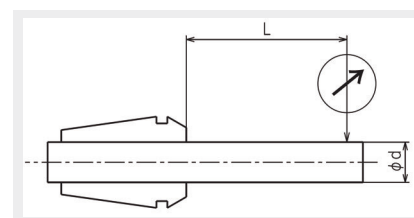
● 等级精度

AAA **3 μm**

AA **5 μm**

A **8 μm**

● 测量位置 L = 4 x d



● 精度检测

所有产品 · 3 次测量



所有 AR (ER) 筒夹都经过检查。

我们在不同阶段对所有筒夹进行了 **3 次检查**,

只有 **3 次都符合标准**的产品才会被出售。

通过严格检验标准的 AR (ER) 筒夹具备最高品质,

可供所有客户使用。

All AR (ER) collets are inspected.

We inspected **three times** at different phases for all Collets.

We only sale as a product that which pass strict inspection **three times**.

Our AR (ER) Collet has a highest quality and can be used by all customers because All Collets are overcome by strict inspection.

AR 筒夹

标准型

AR Collet Standard

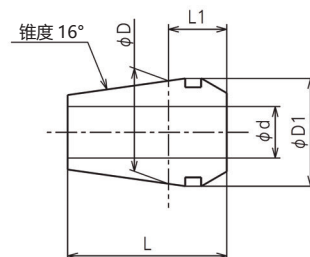
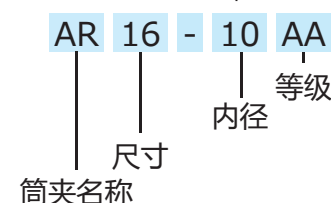
标准型



等级

AAA	3 μ m
AA	5 μ m
A	8 μ m

格式说明 Form explanation



- ER 和 AR 规格相同
- 大多数标准 16 度弹簧筒夹 **DIN6499 / ISO15488**
- 超过 50 年的筒夹制造经验
- 被主要车床制造商采用为标准
- 用于瑞士车床或多任务动力工具

- ER and AR is same specifications.
- Most standard 16 degree collet chucks. **DIN6499 / ISO15488**.
- More than 50 years of experience as a collet manufacture.
- Adopted as standard by major lathe makers.
- For tooling for Swiss Lathes or multi task livetooling.

型号 CODE	ϕ d		ϕ D	ϕ D1	L	L1	刀柄型号 Holder	详参照第 9 页
	范围 Range	收缩范围 Shrink range						
AR 8	0.5 – 5	0.2 or 0.5	8	8.5	13.5	4.5	ECH 5S	表 1
AR11	1 – 7	0.5	11	11.5	18	6.5	ECH 7	表 2
AR16	1 – 10	0.5 or 1.0	16	17	27	10	ECH10	表 3
AR20	1 – 13 (14)		20	21	31	11	ECH13	表 4
AR25	1 – 16		25	26	35	11.5	ECH16	表 5
AR32	2.5 – 20		32	33	40	12.5	ECH20	表 6
AR40	4 – 26	1.0	40	41	46	14.5	ECH26	表 7
AR50	6 – 34	1.0 or 2.0	50	52	60	21	ECH34	表 8

■备注

- (1) 可与小于 d 的刀柄刀具一起使用。
- (2) 订货时请在 CODE 末尾注明精度等级。
订购示例: AR32-5 . . . A 级 (没有 "A")
AR32-5AA . . . AA 级
AR32-5AAA . . . AAA 级
由于 A 级为标准, A 级无需注明等级。
AAA 级可用于 AR11, 16, 20, 25 和 32。
AA 级可用于 AR8, 11, 16, 20, 25, 32, 40 和 50。

■Remarks

- (1) Can be used with smaller shanktool than d.
- (2) When ordering, please indicate the precision grade at the end of the CODE.
Ordering example: AR32-5 . . . A grade (with NO "A")
AR32-5AA . . . AA grade
AR32-5AAA . . . AAA grade
Since grade A is the standard, there is no need to indicate the grade for Grade A.
AAA grade is available for AR11, 16, 20, 25, and 32.
AA grade is available for AR8, 11, 16, 20, 25, 32, 40, and 50.
- (3) The shape of AR8 collet chuck is partially different from the above drawing.
- (4) I.D. shape varies depending on ϕ d.
- (5) When using AR20-14, the tool cannot be inserted to the depth of the holder.

标准型

标准型尺寸一览

Dimensions of Standard type

图 1

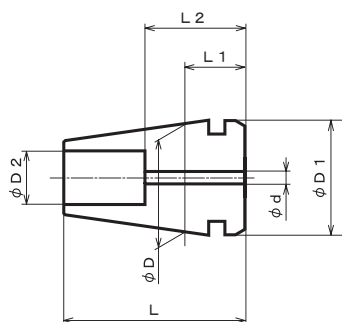


图 2

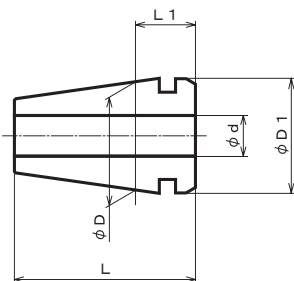


图 3

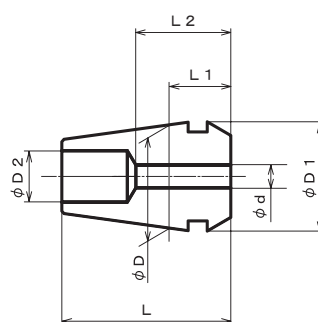


图 4

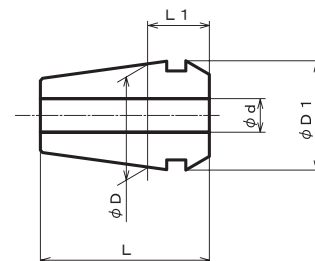


表 1

AR 8				
L1=4.6, φ D=8, φ D1=8.5, L=13.5				
CODE	O.D. range	L2	φ D2	图
AR8-0.5	0.5 - 0.3	7.5	4	1
AR8-1	1.0 - 0.5			
AR8-1.5	1.5 - 1.0			
AR8-2	2.0 - 1.5			
AR8-2.5	2.5 - 2.0			
AR8-3	3.0 - 2.5	-	-	2
AR8-3.5	3.5 - 3.0			
AR8-4	4.0 - 3.5			
AR8-4.5	4.5 - 4.0			
AR8-5	5.0 - 4.5			

表 2

AR11				
L1=6.5, φ D=11, φ D1=11.5, L=18				
CODE	O.D. range	L2	φ D2	图
AR11-1	1.0 - 0.5	10	5.5	3
AR11-1.5	1.5 - 1.0			
AR11-2	2.0 - 1.5			
AR11-2.5	2.5 - 2.0			
AR11-3	3.0 - 2.5			
AR11-3.175	3.175	-	-	4
AR11-3.5	3.5 - 3.0			
AR11-4	4.0 - 3.5			
AR11-4.5	4.5 - 4.0			
AR11-5	5.0 - 4.5			
AR11-5.5	5.5 - 5.0	-	-	4
AR11-6	6.0 - 5.5			
AR11-6.5	6.5 - 6.0			
AR11-7	7.0 - 6.5			

表 3

AR16				
L1=10, φ D=16, φ D1=17, L=27				
CODE	O.D. range	L2	φ D2	图
AR16-1	1.0 - 0.5	16	7.5	3
AR16-1.5	1.5 - 1.0			
AR16-2	2.0 - 1.5			
AR16-2.5	2.5 - 2.0			
AR16-3	3.0 - 2.5			
AR16-3.175	3.175	17	7.5	3
AR16-3.5	3.5 - 3.0			
AR16-4	4.0 - 3.5			
AR16-4.5	4.5 - 4.0			
AR16-5	5.0 - 4.5			
AR16-6	6.0 - 5.0	-	-	4
AR16-7	7.0 - 6.0			
AR16-8	8.0 - 7.0			
AR16-9	9.0 - 8.0			
AR16-10	10.0 - 9.0			

表 4

AR20				
L1=11, φ D=20, φ D1=21, L=31				
CODE	O.D. range	L2	φ D2	图
AR20-1	1.0 — 0.5	13	10	3
AR20-1.5	1.5 — 1.0	14		
AR20-2	2.0 — 1.5	18		
AR20-2.5	2.5 — 2.0			
AR20-3	3.0 — 2.5			
AR20-3.175	3.175	19		
AR20-3.5	3.5 — 3.0			
AR20-4	4.0 — 3.5			
AR20-4.5	4.5 — 4.0	20		
AR20-5	5.0 — 4.5			
AR20-6	6.0 — 5.0	-	-	4
AR20-7	7.0 — 6.0			
AR20-8	8.0 — 7.0			
AR20-9	9.0 — 8.0			
AR20-10	10.0 — 9.0			
AR20-11	11.0 — 10.0			
AR20-12	12.0 — 11.0			
AR20-13	13.0 — 12.0			
AR20-14 ※	14.0 — 13.0			

*AR20-14 不能插入很深因为内径 夹头刀柄小于 14 毫米。

表 5

AR25				
L1=11.5, φ D=25, φ D1=26, L=35				
CODE	O.D. range	L2	φ D2	图
AR25-1	1.0 - 0.5	14	20	3
AR25-1.5	1.5 - 1.0			
AR25-2	2.0 - 1.5			
AR25-2.5	2.5 - 2.0			
AR25-3	3.0 - 2.5			
AR25-3.5	3.5 - 3.0	20	13	3
AR25-4	4.0 - 3.5			
AR25-4.5	4.5 - 4.0			
AR25-5	5.0 - 4.5			
AR25-6	6.0 - 5.0			
AR25-7	7.0 - 6.0	23	21	3
AR25-8	8.0 - 7.0			
AR25-9	9.0 - 8.0			
AR25-10	10.0 - 9.0			
AR25-11	11.0 - 10.0			
AR25-12	12.0 - 11.0	-	-	4
AR25-13	13.0 - 12.0			
AR25-14	14.0 - 13.0			
AR25-15	15.0 - 14.0			
AR25-16	16.0 - 15.0			

表 6

AR32				
L1=12.5, φ D=32, φ D1=33, L=40				
CODE	O.D. range	L2	φ D2	图
AR32-2.5	2.5 - 2.0	21	16	3
AR32-3	3.0 - 2.5			
AR32-3.5	3.5 - 3.0			
AR32-4	4.0 - 3.5			
AR32-4.5	4.5 - 4.0			
AR32-5	5.0 - 4.5	22	22	3
AR32-6	6.0 - 5.0			
AR32-7	7.0 - 6.0			
AR32-8	8.0 - 7.0			
AR32-9	9.0 - 8.0			
AR32-10	10.0 - 9.0	24	24	3
AR32-11	11.0 - 10.0			
AR32-12	12.0 - 11.0			
AR32-13	13.0 - 12.0			
AR32-14	14.0 - 13.0			
AR32-15	15.0 - 14.0	-	-	4
AR32-16	16.0 - 15.0			
AR32-17	17.0 - 16.0			
AR32-18	18.0 - 17.0			
AR32-19	19.0 - 18.0			
AR32-20	20.0 - 19.0			

表 7

AR40				
L1=14.5, φ D=40, φ D1=41, L=46				
CODE	O.D. range	L2	φ D2	图
AR40-4	4.0 - 3.5	26	20	3
AR40-4.5	4.5 - 4.0	27		
AR40-5	5.0 - 4.5			
AR40-6	6.0 - 5.0			
AR40-7	7.0 - 6.0			
AR40-8	8.0 - 7.0	28	20	3
AR40-9	9.0 - 8.0			
AR40-10	10.0 - 9.0	30		
AR40-11	11.0 - 10.0			
AR40-12	12.0 - 11.0			
AR40-13	13.0 - 12.0	-	-	4
AR40-14	14.0 - 13.0			
AR40-15	15.0 - 14.0			
AR40-16	16.0 - 15.0			
AR40-17	17.0 - 16.0			
AR40-18	18.0 - 17.0			
AR40-19	19.0 - 18.0			
AR40-20	20.0 - 19.0			
AR40-21	21.0 - 20.0			
AR40-22	22.0 - 21.0			
AR40-23	23.0 - 22.0	-	-	4
AR40-24	24.0 - 23.0			
AR40-25	25.0 - 24.0			
AR40-26	26.0 - 25.0			

表 8

AR50				
L1=21, φ D=50, φ D1=52, L=60				
CODE	O.D. range	L2	φ D2	图
AR50-6	6.0 - 5.0	27	27	3
AR50-7	7.0 - 6.0			
AR50-8	8.0 - 7.0			
AR50-9	9.0 - 8.0			
AR50-10	10.0 - 9.0			
AR50-12	12.0 - 10.0	42	42	3
AR50-14	14.0 - 12.0			
AR50-16	16.0 - 14.0			
AR50-18	18.0 - 16.0			
AR50-20	20.0 - 18.0			
AR50-22	22.0 - 20.0	45	45	3
AR50-24	24.0 - 22.0			
AR50-25	25.0 - 24.0			
AR50-26	26.0 - 25.0			
AR50-28	28.0 - 26.0			
AR50-30	30.0 - 28.0	-	-	4
AR50-32	32.0 - 30.0			
AR50-34	34.0 - 32.0			

AR 筒夹

止水型筒夹 OH 型

Coolant Thru OH type

OH 型

中心出水

对应 20MPa



等级

AA **5μm**

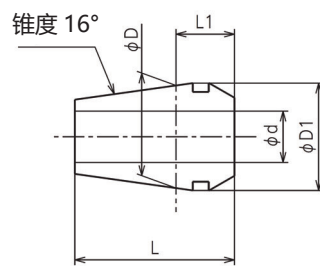
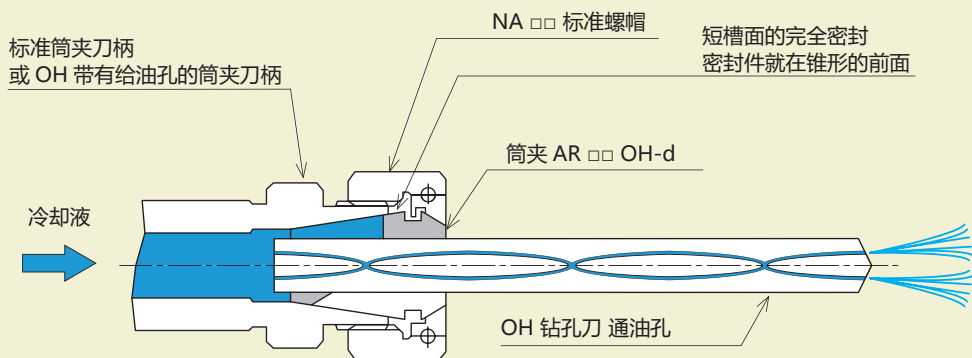
A **8μm**

格式说明 Form explanation

AR 16 OH - 10 AA

筒夹名称
尺寸 型 内径 等级

分割槽无泄漏密封筒夹



型号 CODE	φ d		φ D	φ D1	L	L1	详参照第 11 页
	范围 Range	收缩范围 Shrink range					
AR11 OH	2 — 7	0.1	11	11.5	18	6.5	表 1
AR16 OH	2 — 5.9		16	17	27	10	表 2
AR20 OH	6 — 10	0.5	20	21	31	11	表 3
	3 — 5.9	0.1					
AR25 OH	6 — 13	0.5	25	26	35	11.5	表 4
	3 — 5.9	0.1					
AR32 OH	8 — 12	0.5	32	33	40	12.5	表 5
	3 — 7.9		40	41	46	14.5	表 6
AR40 OH	10 — 26						
AR50 OH	16 — 34		50	52	60	21	表 7

■ 备注

- (1) 其他标称尺寸为定制尺寸，只有特殊指定尺寸需每种尺寸最少订购 3 件。
- (2) 用于油孔 (OH) 钻头。
- (3) 使用时，将钻头插入比夹头端面更深的位置。
- (4) 内径形状因 φd 而异。
- (5) 如果夹持公称直径以外尺寸的夹头，冷却液可能会渗出或发生少量泄漏。
- (6) 当使用平刃直柄时，夹头的密封功能不起作用。
- (7) AR50OH 为订制。

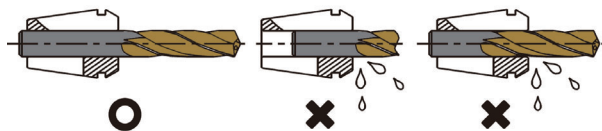
■ Remarks

- (1) Other nominal dimensions are made-to-order, and only the specified size can be used. Minimum order of 3 pieces per size.
- (2) for oil hole (OH) drills.
- (3) When using, insert the drill deeper than the collet end face.
- (4) The inside diameter shape differs depending on φd.
- (5) If a collet of a size other than the nominal diameter is gripped, coolant may seep out or a small amount of leakage may occur.
- (6) The sealing function of the collet does not work when a straight shank with a flattened edge is used.
- (7) AR50OH is made to order.

订购示例：

AR16OH-5 . . . A 级 (没有 "A")
AR16OH-5AA . . . AA 级

◆ OH 型夹头的正确使用方法 ◆



OH 型

OH 型外形尺寸

Dimensions of OH type

图 5

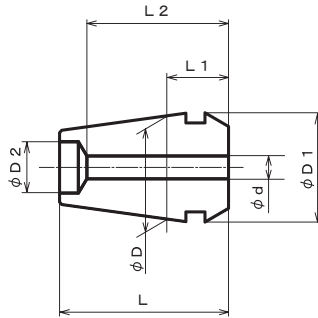


图 6

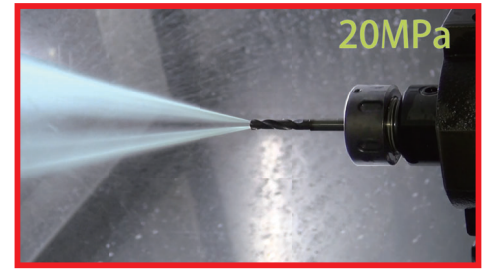
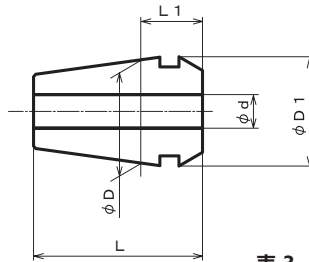


表 1

AR11 OH				
L1=6.5, $\phi D=11$, $\phi D1=11.5$, L=18				
CODE	O.D. range	L2	$\phi D2$	图
AR11OH-2	2.0 - 1.9	-	-	6
AR11OH-2.5	2.5 - 2.4			
AR11OH-3	3.0 - 2.9			
AR11OH-3.5	3.5 - 3.4			
AR11OH-4	4.0 - 3.9			
AR11OH-4.5	4.5 - 4.4			
AR11OH-5	5.0 - 4.9			
AR11OH-5.5	5.5 - 5.4			
AR11OH-6	6.0 - 5.9			
AR11OH-6.5	6.5 - 6.4			
AR11OH-7	7.0 - 6.9			

表 2

AR16 OH				
L1=10, $\phi D=16$, $\phi D1=17$, L=27				
CODE	O.D. range	L2	$\phi D2$	图
AR16OH-2	2.0 - 1.9	-	-	6
AR16OH-2.5	2.5 - 2.4			
AR16OH-3	3.0 - 2.9			
AR16OH-3.5	3.5 - 3.4			
AR16OH-4	4.0 - 3.9			
AR16OH-4.5	4.5 - 4.4			
AR16OH-5	5.0 - 4.9			
AR16OH-5.5	5.5 - 5.4			
AR16OH-6	6.0 - 5.5			
AR16OH-6.5	6.5 - 6.0			
AR16OH-7	7.0 - 6.5			
AR16OH-7.5	7.5 - 7.0			
AR16OH-8	8.0 - 7.5			
AR16OH-8.5	8.5 - 8.0			
AR16OH-9	9.0 - 8.5			
AR16OH-9.5	9.5 - 9.0			
AR16OH-10	10.0 - 9.5			

表 3

AR20 OH				
L1=11, $\phi D=20$, $\phi D1=21$, L=31				
CODE	O.D. range	L2	$\phi D2$	图
AR20OH-3	3.0 - 2.9	24	10	5
AR20OH-3.5	3.5 - 3.4			
AR20OH-4	4.0 - 3.9			
AR20OH-4.5	4.5 - 4.4			
AR20OH-5	5.0 - 4.9			
AR20OH-5.5	5.5 - 5.4	25	-	6
AR20OH-6	6.0 - 5.5			
AR20OH-6.5	6.5 - 6.0			
AR20OH-7	7.0 - 6.5			
AR20OH-7.5	7.5 - 7.0			
AR20OH-8	8.0 - 7.5			
AR20OH-8.5	8.5 - 8.0			
AR20OH-9	9.0 - 8.5			
AR20OH-9.5	9.5 - 9.0			
AR20OH-10	10.0 - 9.5			
AR20OH-10.5	10.5 - 10.0	-	-	6
AR20OH-11	11.0 - 10.5			
AR20OH-11.5	11.5 - 11.0			
AR20OH-12	12.0 - 11.5			
AR20OH-12.5	12.5 - 12.0	-	-	6
AR20OH-13	13.0 - 12.5			

表 4

AR25 OH				
L1=11.5, ϕ D=25, ϕ D1=26, L=35				
CODE	O.D. range	L2	ϕ D2	图
AR25OH-3	3.0 - 2.9	23	13	5
AR25OH-3.5	3.5 - 3.4			
AR25OH-4	4.0 - 3.9			
AR25OH-4.5	4.5 - 4.4	27		
AR25OH-5	5.0 - 4.9			
AR25OH-5.5	5.5 - 5.4			
AR25OH-6	6.0 - 5.5	28		
AR25OH-6.5	6.5 - 6.0			
AR25OH-7	7.0 - 6.5			
AR25OH-7.5	7.5 - 7.0	29		
AR25OH-8	8.0 - 7.5			
AR25OH-8.5	8.5 - 8.0			
AR25OH-9	9.0 - 8.5	29		
AR25OH-9.5	9.5 - 9.0			
AR25OH-10	10.0 - 9.5			
AR25OH-10.5	10.5 - 10.0	-	-	6
AR25OH-11	11.0 - 10.5			
AR25OH-11.5	11.5 - 11.0			
AR25OH-12	12.0 - 1.5			
AR25OH-12.5	12.5 - 12.0			
AR25OH-13	13.0 - 12.5			
AR25OH-13.5	13.5 - 13.0			
AR25OH-14	14.0 - 13.5			
AR25OH-14.5	14.5 - 14.0			
AR25OH-15	15.0 - 14.5			
AR25OH-15.5	15.5 - 15.0			
AR25OH-16	16.0 - 15.5			

表 5

AR32 OH				
L1=12.5, ϕ D=32, ϕ D1=33, L=40				
CODE	O.D. range	L2	ϕ D2	图
AR32OH-3	3.0 — 2.9	26	16	5
AR32OH-3.5	3.5 — 3.4			
AR32OH-4	4.0 — 3.9			
AR32OH-4.5	4.5 — 4.4	30		
AR32OH-5	5.0 — 4.9			
AR32OH-5.5	5.5 — 5.4			
AR32OH-6	6.0 — 5.9	31		
AR32OH-6.5	6.5 — 6.4			
AR32OH-7	7.0 — 6.9			
AR32OH-7.5	7.5 — 7.4	32		
AR32OH-8	8.0 — 7.5			
AR32OH-8.5	8.5 — 8.0			
AR32OH-9	9.0 — 8.5	33		
AR32OH-9.5	9.5 — 9.0			
AR32OH-10	10.0 — 9.5			
AR32OH-10.5	10.5 — 10.0	32		
AR32OH-11	11.0 — 10.5			
AR32OH-11.5	11.5 — 11.0			
AR32OH-12	12.0 — 11.5	31		
AR32OH-12.5	12.5 — 12.0			
AR32OH-13	13.0 — 12.5			
AR32OH-13.5	13.5 — 13.0	30		
AR32OH-14	14.0 — 13.5			
AR32OH-14.5	14.5 — 14.0			
AR32OH-15	15.0 — 14.5	26		
AR32OH-15.5	15.5 — 15.0			
AR32OH-16	16.0 — 15.5			
AR32OH-16.5	16.5 — 16.0	-		
AR32OH-17	17.0 — 16.5			
AR32OH-17.5	17.5 — 17.0			
AR32OH-18	18.0 — 17.5	-		
AR32OH-18.5	18.5 — 18.0			
AR32OH-19	19.0 — 18.5			
AR32OH-19.5	19.5 — 19.0	-		
AR32OH-20	20.0 — 19.5			

表 6

AR40 OH					
L1=14.5, φ D=40, φ D1=41, L=46					
CODE	O.D. range	L2	φ D2	图	
AR40OH-10	10.0 — 9.5	36	16	5	
AR40OH-10.5	10.5 — 10.0				
AR40OH-11	11.0 — 10.5				
AR40OH-11.5	11.5 — 11.0	37			
AR40OH-12	12.0 — 11.5				
AR40OH-12.5	12.5 — 12.0				
AR40OH-13	13.0 — 12.5	38			
AR40OH-13.5	13.5 — 13.0				
AR40OH-14	14.0 — 13.5				
AR40OH-14.5	14.5 — 14.0				
AR40OH-15	15.0 — 14.5				
AR40OH-15.5	15.5 — 15.0				
AR40OH-16	16.0 — 15.5				
AR40OH-16.5	16.5 — 16.0				
AR40OH-17	17.0 — 16.5				
AR40OH-17.5	17.5 — 17.0				
AR40OH-18	18.0 — 17.5				
AR40OH-18.5	18.5 — 18.0				
AR40OH-19	19.0 — 18.5				
AR40OH-19.5	19.5 — 19.0				
AR40OH-20	20.0 — 19.5				
AR40OH-20.5	20.5 — 20.0				
AR40OH-21	21.0 — 20.5				
AR40OH-21.5	21.5 — 21.0				
AR40OH-22	22.0 — 21.5	-			
AR40OH-22.5	22.5 — 22.0				
AR40OH-23	23.0 — 22.5				
AR40OH-23.5	23.5 — 23.0				
AR40OH-24	24.0 — 23.5				
AR40OH-24.5	24.5 — 24.0				
AR40OH-25	25.0 — 24.5				
AR40OH-25.5	25.5 — 25.0				
AR40OH-26	26.0 — 25.5				

表 7

AR50 OH				
L1=21, φ D=50, φ D1=52, L=60				
CODE	O.D. range	L2	φ D2	图
AR50OH-16	16.0 — 15.5	49	27	5
AR50OH-16.5	16.5 — 16.0			
AR50OH-17	17.0 — 16.5			
AR50OH-17.5	17.5 — 17.0	50		
AR50OH-18	18.0 — 17.5			
AR50OH-18.5	18.5 — 18.0			
AR50OH-19	19.0 — 18.5	51		
AR50OH-19.5	19.5 — 19.0			
AR50OH-20	20.0 — 19.5			
AR50OH-20.5	20.5 — 20.0	51		
AR50OH-21	21.0 — 20.5			
AR50OH-21.5	21.5 — 21.0			
AR50OH-22	22.0 — 21.5	51		
AR50OH-22.5	22.5 — 22.0			
AR50OH-23	23.0 — 22.5			
AR50OH-23.5	23.5 — 23.0	51		
AR50OH-24	24.0 — 23.5			
AR50OH-24.5	24.5 — 24.0			
AR50OH-25	25.0 — 24.5	51		
AR50OH-25.5	25.5 — 25.0			
AR50OH-26	26.0 — 25.5			
AR50OH-26.5	26.5 — 26.0	51		
AR50OH-27	27.0 — 26.5			
AR50OH-27.5	27.5 — 27.0			
AR50OH-28	28.0 — 27.5	51		
AR50OH-28.5	28.5 — 28.0			
AR50OH-29	29.0 — 28.5			
AR50OH-29.5	29.5 — 29.0	51		
AR50OH-30	30.0 — 29.5			
AR50OH-30.5	30.5 — 30.0			
AR50OH-31	31.0 — 30.5	51		
AR50OH-31.5	31.5 — 31.0			
AR50OH-32	32.0 — 31.5			
AR50OH-32.5	32.5 — 32.0	51		
AR50OH-33	33.0 — 32.5			
AR50OH-33.5	33.5 — 33.0			
AR50OH-34	34.0 — 33.5	51		

AR 筒夹

止水型筒夹 C 型

Coolant Thru C type

C 型

侧面出水

对应 20MPa



等级

AA 5μm

A 8μm

格式说明 Form explanation

AR 16 C - 10 AA

筒夹名称 尺寸 型 内径 等级

凹槽在筒夹内径中 I.D. 加工

标准夹头刀柄 or
带供应管的标准螺母筒夹刀柄

NA □□ 标准螺帽

AR/C 冷却液通过筒夹
AR□□C-d

冷却液有效的喷洒刀具前端

冷却液

标准钻孔刀

锥度 16°

φD

L1

冷却液槽

φd

φD1

L

型号 CODE	φ d		φ D	φ D1	L	L1	详参照第 13 页
	范围 Range	收缩范围 Shrink range					
AR11C	3 - 7	0.1	11	11.5	18	6.5	表1
AR16C	3 - 5.9		16	17	27	10	表2
	6 - 10	0.5					
AR20C	5 - 5.9	0.1	20	21	31	11	表3
	6 - 13						
AR25C	6 - 16	0.5	25	26	35	11.5	表4
AR32C	8 - 20		32	33	40	12.5	表5

- AR/C 筒夹是订制生产。
- 对应标准高压冷却液装置，即便 20MPa 也可完全密封使用。
- 冷却液朝切削刃方向喷射，易于减少切屑堵塞。
- 对小直径孔的深钻孔有效。
- 标准适用于水溶性冷却液。（油性冷却液也可对应使用。）

■ 备注

(1) 订购示例：

AR16C-6 . . . 水溶性冷却液 φ 6 用 A 级

AR16CY-6AA . . . 油性冷却液 φ 6 用 AA 级

(2) 钻头应插入更深的筒夹深度。

(3) 夹持直径以外尺寸的刀具时，冷却液可能会使密封出现渗出或少量泄漏。

(4) 当使用平刃直柄时，筒夹的密封功能不起作用。

(5) 内径形状因 φd 而异。

■ Remarks

(1) Ordering example:

AR16C-6 . . . Water-soluble coolant for φ 6, grade A

AR16CY-6AA . . . Oil-based coolant, for φ 6, grade AA

(2) Drill should be inserted deeper the depth of the collet.

(3) When gripping a collet of a size other than the diameter, coolant may seep out or a small amount of coolant may leak.

(4) The sealing of the collet does not work when using a straight shank with flattening.

(5) The inside diameter shape varies depending on φ d.

C 型

C 型外形尺寸

Dimensions of C type

图 5

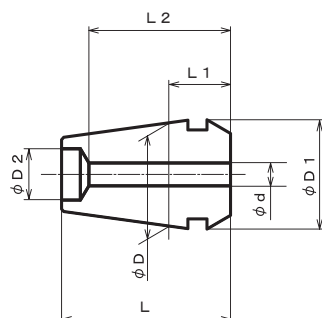


图 6

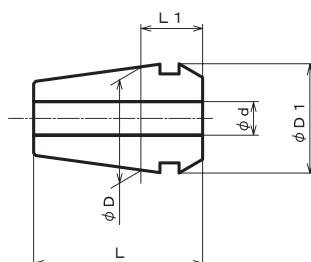


表 1

AR11C

L1=6.5, φ D=11, φ D1=11.5, L=18				
CODE	O.D. range	L2	φ D2	图
AR11C-3	3.0 - 2.9	-	-	6
AR11C-3.5	3.5 - 3.4			
AR11C-4	4.0 - 3.9			
AR11C-4.5	4.5 - 4.4			
AR11C-5	5.0 - 4.9			
AR11C-5.5	5.5 - 5.4			
AR11C-6	6.0 - 5.9			
AR11C-6.5	6.5 - 6.4			
AR11C-7	7.0 - 6.9			

表 2

AR16C

L1=10, φ D=16, φ D1=17, L=27				
CODE	O.D. range	L2	φ D2	图
AR16C-3	3.0 - 2.9	-	-	6
AR16C-3.5	3.5 - 3.4			
AR16C-4	4.0 - 3.9			
AR16C-4.5	4.5 - 4.4			
AR16C-5	5.0 - 4.9			
AR16C-5.5	5.5 - 5.4			
AR16C-6	6.0 - 5.5			
AR16C-6.5	6.5 - 6.0			
AR16C-7	7.0 - 6.5			
AR16C-7.5	7.5 - 7.0			
AR16C-8	8.0 - 7.5			
AR16C-8.5	8.5 - 8.0			
AR16C-9	9.0 - 8.5			
AR16C-9.5	9.5 - 9.0			
AR16C-10.0	10.0 - 9.5			

表 3

AR20C

L1=11, φ D=20, φ D1=21, L=31				
CODE	O.D. range	L2	φ D2	图
AR20C-5	5.0 - 4.9	25	10	5
AR20C-5.5	5.5 - 5.4			
AR20C-6	6.0 - 5.5			
AR20C-6.5	6.5 - 6.0			
AR20C-7	7.0 - 6.5			
AR20C-7.5	7.5 - 7.0			
AR20C-8	8.0 - 7.5			
AR20C-8.5	8.5 - 8.0			
AR20C-9	9.0 - 8.5	-	-	6
AR20C-9.5	9.5 - 9.0			
AR20C-10	10.0 - 9.5			
AR20C-10.5	10.5 - 10.0			
AR20C-11	11.0 - 10.5			
AR20C-11.5	11.5 - 11.0			
AR20C-12	12.0 - 11.5			
AR20C-12.5	12.5 - 12.0			
AR20C-13	13.0 - 12.5			

表 4

AR25C

L1=11.5, ϕ D=25, ϕ D1=26, L=35				
CODE	O.D. range	L2	ϕ D2	图
AR25C-6	6.0 — 5.5	28	13	5
AR25C-6.5	6.5 — 6.0			
AR25C-7	7.0 — 6.5			
AR25C-7.5	7.5 — 7.0			
AR25C-8	8.0 — 7.5	29		
AR25C-8.5	8.5 — 8.0			
AR25C-9	9.0 — 8.5			
AR25C-9.5	9.5 — 9.0			
AR25C-10	10.0 — 9.5	-	-	6
AR25C-10.5	10.5 — 10.0			
AR25C-11	11.0 — 10.5			
AR25C-11.5	11.5 — 11.0			
AR25C-12	12.0 — 11.5			
AR25C-12.5	12.5 — 12.0			
AR25C-13	13.0 — 12.5			
AR25C-13.5	13.5 — 13.0			
AR25C-14	14.0 — 13.5			
AR25C-14.5	14.5 — 14.0			
AR25C-15	15.0 — 14.5			
AR25C-15.5	15.5 — 15.0			
AR25C-16	16.0 — 15.5			

表 5

AR32C

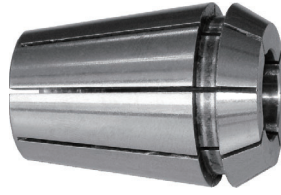
L1=12.5, ϕ D=32, ϕ D1=33, L=40				
CODE	O.D. range	L2	ϕ D2	图
AR32C-8	8.0 — 7.5	31	16	5
AR32C-8.5	8.5 — 8.0			
AR32C-9	9.0 — 8.5			
AR32C-9.5	9.5 — 9.0			
AR32C-10	10.0 — 9.5			
AR32C-10.5	10.5 — 10.0			
AR32C-11	11.0 — 10.5	32		
AR32C-11.5	11.5 — 11.0			
AR32C-12	12.0 — 11.5			
AR32C-12.5	12.5 — 12.0			
AR32C-13	13.0 — 12.5			
AR32C-13.5	13.5 — 13.0	33		
AR32C-14	14.0 — 13.5			
AR32C-14.5	14.5 — 14.0			
AR32C-15	15.0 — 14.5			
AR32C-15.5	15.5 — 15.0			
AR32C-16	16.0 — 15.5	-	-	6
AR32C-16.5	16.5 — 16.0			
AR32C-17	17.0 — 16.5			
AR32C-17.5	17.5 — 17.0			
AR32C-18	18.0 — 17.5			
AR32C-18.5	18.5 — 18.0			
AR32C-19	19.0 — 18.5			
AR32C-19.5	19.5 — 19.0			
AR32C-20	20.0 — 19.5			

AR 筒夹

丝锥筒夹 GB 型

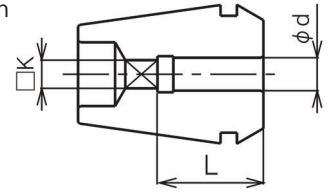
Tap Collet GB type

GB 型



格式说明 Form explanation

AR 16 GB - M4
尺寸 型 螺纹尺寸
筒夹名称



AR16GB						
型号	适用丝锥尺寸 Tap Size			d	K	L
CODE	公制螺纹	统一螺纹	管螺纹			
AR16GB-M4	M4	(No.8U)	-	5	4	15
AR16GB-M5	M5	(No10U/12U)		5.5	4.5	
AR16GB-M6	M6	(1/4U)		6		
AR16GB-5/16U	-	5/16U		6.1	5	
AR16GB-M8	M8	-	6.2	5.5		20
AR16GB-M10	M10	(3/8U)	7			
AR16GB-7/16U	(M11)	7/16U	8		6	
AR16GB-PT1/8	-	-				
AR16GB-M12	M12	-	-	8.5	6.5	

AR20GB						
型号	适用丝锥尺寸 Tap Size			d	K	L
CODE	公制螺纹	统一螺纹	管螺纹			
AR20GB-M4	M4	(No8U)	-	5	4.0	15
AR20GB-M5	M5	(No10U/12U)		5.5	4.5	
AR20GB-M6	M6	(1/4U)		6	4.5	
AR20GB-5/16U	-	5/16U		6.1	5	20
AR20GB-M8	M8	-		6.2		
AR20GB-M10	M10	(3/8U)		7	5.5	21
AR20GB-7/16U	(M11)	7/16U		8	6	
AR20GB-PT1/8	-	-	PT1/8(1/16)	8	6	20
AR20GB-M12	M12			8.5	6.5	21
AR20GB-1/2U	-	1/2U	-	9	7	

AR25GB							
型号	适用丝锥尺寸 Tap Size			d	K	L	
CODE	公制螺纹	统一螺纹	管螺纹				
AR25GB-M4	M4	(No8U)	-	5	4	15	
AR25GB-M5	M5	(No10U/12U)		5.5	4.5		
AR25GB-M6	M6	(1/4U)		6	4.5		
AR25GB-5/16U	-	5/16U		6.1	5	20	
AR25GB-M8	M8	-		6.2			
AR25GB-M10	M10	(3/8U)	PT1/8(1/16)	7	5.5		25
AR25GB-7/16U	(M11)	7/16U		8	6		
AR25GB-PT1/8	-	-		8.5	6.5	20	
AR25GB-M12	M12	-		-	9	7	25
AR25GB-1/2U	-	1/2U			10.5	8	
AR25GB-M14	M14	(9/16U)	11		9	17	
AR25GB-PT1/4	-	-	-	12	10	25	
AR25GB-5/8U	-	5/8U		12.5			
AR25GB-M16	M16	-	PT3/8	14	11	18	
AR25GB-PT3/8	-	-					

AR32GB						
型号	适用丝锥尺寸 Tap Size			d	K	L
CODE	公制螺纹	统一螺纹	管螺纹			
AR32GB-M4	M4	(No8U)	-	5	4	15
AR32GB-M5	M5	(No10U/12U)		5.5	4.5	
AR32GB-M6	M6	(1/4U)		6	4.5	
AR32GB-5/16U	-	5/16U		6.1	5	20
AR32GB-M8	M8	-	6.2			
AR32GB-M10	M10	(3/8U)	7	5.5	25	
AR32GB-7/16U	(M11)	7/16U	PT1/8(1/16)	8		
AR32GB-PT1/8	-	-		8.5		6.5
AR32GB-M12	M12	-	-	9	7	
AR32GB-1/2U	-	1/2U		10.5	8	
AR32GB-M14	M14	(9/16U)		11	9	17
AR32GB-PT1/4	-	-	PT1/4	12	25	
AR32GB-5/8U	-	5/8U	-	12.5		10
AR32GB-M16	M16	-	PT3/8	14		11
AR32GB-PT3/8	-	-		15	12	28
AR32GB-M18	M18	(3/4U)	-	17	13	
AR32GB-M20	M20	-				
AR32GB-M22	M22	-				

AR40GB						
型号	适用丝锥尺寸 Tap Size			d	K	L
CODE	公制螺纹	统一螺纹	管螺纹			
AR40GB-M10	M10	(3/8U)	-	7	5.5	25
AR40GB-7/16U	(M11)	7/16U		PT1/8(1/16)	8	
AR40GB-PT1/8	-	-	-		8.5	6.5
AR40GB-M12	M12			1/2U	-	9
AR40GB-1/2U	-	(9/16U)	-			10.5
AR40GB-M14	M14			PT1/4	11	9
AR40GB-PT1/4	-	5/8U	12			
AR40GB-5/8U	-			PT3/8	14	11
AR40GB-M16	M16	-	15			
AR40GB-PT3/8	-			PT1/2	17	13
AR40GB-M18	M18	(7/8U)	18			
AR40GB-M20	M20			-	19	15
AR40GB-M22	M22	(1U)	20			
AR40GB-PT1/2	-			-	-	-
AR40GB-M24	M24	-	-			
AR40GB-M27	M27			-	-	-

AR50GB						
型号	适用丝锥尺寸 Tap Size			d	K	L
CODE	公制螺纹	统一-螺纹	管螺纹			
AR50GB-M10	M10	(3/8U)	-	7	5.5	25
AR50GB-7/16U	(M11)	7/16U		8	6	
AR50GB-PT1/8	-	-	PT1/8(1/16)			20
AR50GB-M12	M12				8.5	6.5
AR50GB-1/2U	-	1/2U	-	9	7	
AR50GB-M14	M14	(9/16U)		10.5	8	
AR50GB-PT1/4	-	-	PT1/4	11	9	17
AR50GB-5/8U		5/8U	-	12		25
AR50GB-M16	M16	-		12.5	10	
AR50GB-PT3/8	-		PT3/8	14	11	18
AR50GB-M18	M18	(3/4U)				28
AR50GB-M20	M20	-	-	15	12	
AR50GB-M22	M22	(7/8U)		17	13	
AR50GB-PT1/2	-	-	PT1/2	18	14	21
AR50GB-M24	M24				19	35
AR50GB-M27	M27	(1U)	-	20		
AR50GB-M28	M28	-		21	17	

AR 筒夹

止水丝锥 GH 型

Coolant Tap Collet GH type

GH 型

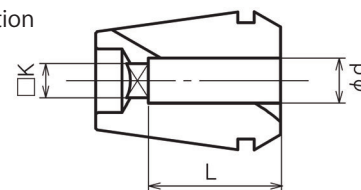
中心出水

对应 20MPa



格式说明 Form explanation

AR 16 GH - M5
 尺寸
 筒夹名称



AR16GH						
型号	适用丝锥尺寸 Tap Size			d	K	L
CODE	公制螺纹	统一螺纹	管螺纹			
AR16GH-M5	M5	—	—	5.5	4.5	22
AR16GH-M6	M6	(1/4U)		6	4.5	
AR16GH-5/16U	—	5/16U		6.1	5	
AR16GH-M8	M8	—		6.2		
AR16GH-M10	M10	(3/8U)		7	5.5	
AR16GH-7/16U	(M11)	7/16U		8	6	
AR16GH-PT1/8	—	—	PT1/8(1/16)			
AR16GH-M12	M12		—	—	8.5	6.5

AR20GH						
型号	适用丝锥尺寸 Tap Size			d	K	L
CODE	公制螺纹	统一-螺纹	管螺纹			
AR20GH-M6	M6	(1/4U)	-	6	4.5	25
AR20GH-5/16U	-	5/16U		6.1	5	
AR20GH-M8	M8	-		6.2		
AR20GH-M10	M10	(3/8U)		7	5.5	
AR20GH-7/16U	(M11)	7/16U		8	6	
AR20GH-PT1/8	-	-	PT1/8(1/16)	8.5	6.5	
AR20GH-M12	M12		-			
AR20GH-1/2U	-	1/2U				

AR25GH						
型号	适用丝锥尺寸 Tap Size			d	K	L
CODE	公制螺纹	统一螺纹	管螺纹			
AR25GH-M6	M6	(1/4U)	-	6	4.5	25
AR25GH-5/16U	-	5/16U		6.1	5	
AR25GH-M8	M8	-		6.2		
AR25GH-M10	M10	(3/8U)		7	5.5	
AR25GH-7/16U	(M11)	7/16U		8	6	
AR25GH-PT1/8	-	-	PT1/8(1/16)	8.5	6.5	30
AR25GH-M12	M12	-	-	9	7	
AR25GH-1/2U	-	1/2U	-	10.5	8	
AR25GH-M14	M14	(9/16U)	-	11	9	
AR25GH-PT1/4	-	-	PT1/4	12		
AR25GH-5/8U	-	5/8U	-	12.5	10	
AR25GH-M16	M16	-	-	14	11	
AR25GH-PT3/8	-	-	PT3/8	14	11	

AR32GH							
型号	适用丝锥尺寸 Tap Size			d	K	L	
CODE	公制螺纹	统一螺纹	管螺纹				
AR32GH-M6	M6	(1/4U)	-	6	4.5	25	
AR32GH-5/16U	-	5/16U		6.1	5		
AR32GH-M8	M8	-		6.2			
AR32GH-M10	M10	(3/8U)		7	5.5		
AR32GH-7/16U	(M11)	7/16U		PT1/8(1/16)	8	6	30
AR32GH-PT1/8	-	-	8.5		6.5		
AR32GH-M12	M12	-	-		9	7	
AR32GH-1/2U	-	1/2U	-		10.5	8	
AR32GH-M14	M14	(9/16U)	PT1/4		11	9	
AR32GH-PT1/4	-	-	-	12			
AR32GH-5/8U	-	5/8U	-	12.5	10		
AR32GH-M16	M16	-	PT3/8	14	11		
AR32GH-PT3/8	-	-	-	15	12		
AR32GH-M18	M18	(3/4U)	-	17	13	33	
AR32GH-M20	M20	-					
AR32GH-M22	M22	-					

AR40GH						
型号	适用丝锥尺寸 Tap Size			d	K	L
CODE	公制螺纹	统一螺纹	管螺纹			
AR40GH-M10	M10	(3/8U)	-	7	5.5	30
AR40GH-7/16U	(M11)	7/16U		8	6	
AR40GH-PT1/8	-	-	PT1/8(1/16)	8	6	
AR40GH-M12	M12	-	-	8.5	6.5	
AR40GH-1/2U	-	1/2U	-	9	7	
AR40GH-M14	M14	(9/16U)	-	10.5	8	
AR40GH-PT1/4	-	-	PT1/4	11	9	35
AR40GH-5/8U	-	5/8U	-	12	9	
AR40GH-M16	M16	-	-	12.5	10	
AR40GH-PT3/8	-	-	PT3/8	14	11	
AR40GH-M18	M18	(3/4U)	-	15	12	40
AR40GH-M20	M20	-		17	13	
AR40GH-M22	M22	(7/8U)		17	13	
AR40GH-PT1/2	-	-	PT1/2	18	14	
AR40GH-M24	M24	-	-	19	15	
AR40GH-M27	M27	(1U)	-	20	15	

■ 备注

(1) 以上图表基于 JIS 标准。

ANSI、DIN、ISO 柄或使用目录中未列出的丝锥尺寸时，请联系弊社“ALPS TOOL”。(请联系“阿尔卑斯工具”)。

(2) 每种丝锥尺寸都需要搭配合适的筒夹。

(3) 若使用的工具机用于同步攻牙时，可将丝锥筒夹安装到 ECH 型筒夹座上，进行攻丝。

(4) 内径形状因尺寸 d 而异。

(5) AR50GB 为订制品。

(6) 当您使用 GH 类型时，为防止冷却液泄漏，请确保将切削工具放入筒夹孔的底部。



Y 轴可调夹头刀柄

可调整

Y 高度

Y Adjustable Holder

用于转塔车床

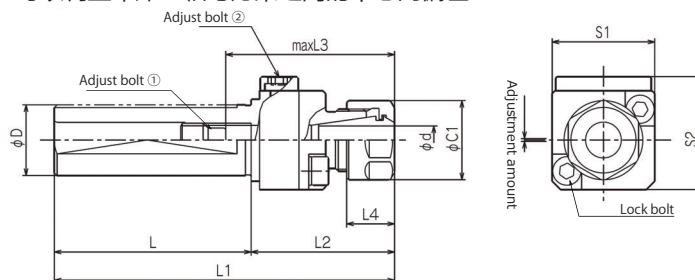
可调 Y 轴刀刀方向

调整量
 $\pm 0.3\text{mm}$



格式说明 Form explanation
SBH 20 - ECH 7 M - 70
形状 柄径 型式 机能 抓取直径 长度

* 可适用于冷却液通孔 (可适用于刀具中心出水)
可以调整车床主轴与刀架之间的中心高偏差



CODE	适用刀柄 直径 ϕd	ϕD	L	L1	L2	Max L3	S1	S2	配件螺母 Nut Size			调节螺栓 Adjust bolt ①	选配 Optional Part		锁紧螺栓 扳手 Wrench for Lock bolt *1	调节螺栓 扳手 Wrench for Adjust bolt *2
									型号 Code	L4	$\phi C1$		筒夹 Collet	扳手 Wrench		
SBH3/4-ECH7M-70	0.5 - 7	19.05	70	108	38	55	25	29	NA11M	12	16	2S06035	AR11-d	AE11M	H3	H3
SBH20-ECH7M-70	0.5 - 10	20		121	51	60	36.5	40	NA16S	17	28	2S10030	AR16-d	SP-25	H5	H5
SBH25-ECH10-70		25		125	55	70	47	49	NA25S	20	42	2S12035	AR25-d	FK-6		
SBH16-ECH70	0.5 - 16															

*1,*2 扳手为市售品, 请自备。

- 同心度在 $\pm 0.3\text{mm}$ 范围内可调。
- 可延长刀具寿命并通过偏心加工实现高精度加工, 摩擦磨损、超硬钻头和铰刀加工。
- 支架刀柄可补偿转塔精度的下降。

- 备注
- (1) AR (ER) 筒夹不包含在筒夹夹具 (刀柄) 中。如果您需要 AR 筒夹, 请单独订购。
- (2) 筒夹支架不附带扳手。如果需要扳手, 请单独订购。
- (3) 如需特殊形状, 请与我们联系。

Y-X 可调整刀柄

可调整

Y-X 轴

Y-X Adjustable Holder

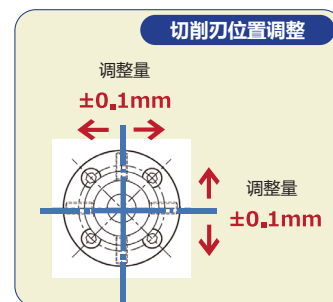
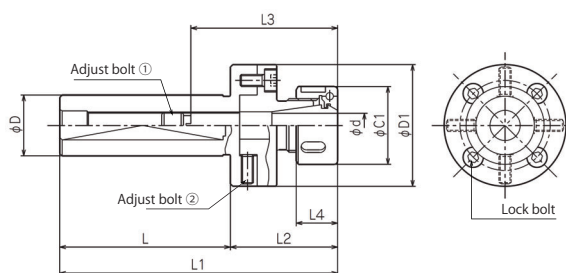


格式说明 Form explanation
SAH 20 - ECH 10 - 70
形状 柄径 型式 抓取直径 长度

切削刀位置调整

可以调整车床卡盘和转塔之间的中芯

Y-X 轴可调



CODE	适用刀柄 直径 ϕd	ϕD	L	L1	L2	Max L3	D1	配件螺母 Nut Size			调节螺栓 Adjust bolt ①	选配 Optional Part		锁紧螺栓 扳手 Wrench for Lock bolt *1	调节螺栓 扳手 Wrench for Adjust bolt *2
								型号 Code	L4	$\phi C1$		筒夹 Collet	扳手 Wrench		
SAH20-ECH7-70	0.5 - 7	20	70	105	35	55	32	NA11S	11.5	19	ECH7-05	AR11-d	SP-17A	H4	H2.5
-ECH10-70	0.5 - 10			114	44	60	50	NA16	17	32	ECH10-05	AR16-d	FK-4		
SAH25-ECH10-70	0.5 - 16	25		124	54		62	NA25	20	43	ECH16-05	AR25-d	FK-6	H5	H3
SAH32-ECH13-70	0.5 - 13	32		119	49	70	55	NA20	19	36	ECH13-05	AR20-d	FK-5		
-ECH20-70	2 - 20			126	56		72	NA32	23	51	ECH20-05	AR32-d	FK-8		

*1,*2 扳手为市售品, 请自备。

- 同心度在 ± 0.1 范围内可调。
- 可延长刀具寿命并通过偏心加工实现高精度加工, 摩擦磨损、超硬钻头和铰刀加工。
- 支架刀柄可补偿转塔精度的下降。
- Adjustable concentricity within the range of ± 0.1 .
- Extended tool life and high precision processing by eccentricity of blade edge due to frictional wear, super-hard drill and reamer processing.
- (eccentricity of blade edge minimum eccentricity of blade edge)
- Degraded of positioning accuracy of the tool post can be compensated for by the holder.

微型 夹头刀柄

公制规格

Short Nose Collet Holder

适用于瑞士型及排刀车床用的小型短式夹头刀柄

Small and short holder suitable for Swiss-type and Gang type NC lathes.

瑞士型车床

排刀车床

微型



- 尽量减少突出长度。适用于小型机器



图 1

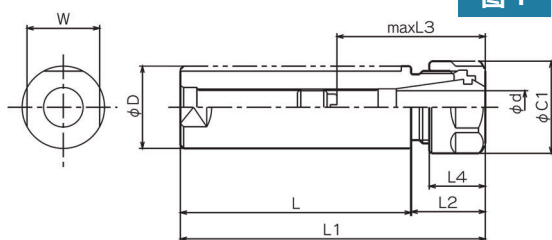


图 2

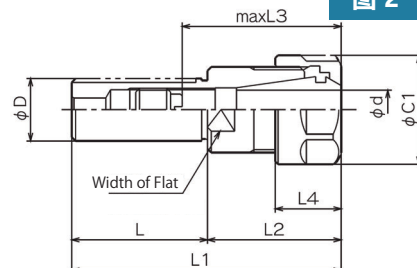


图 3

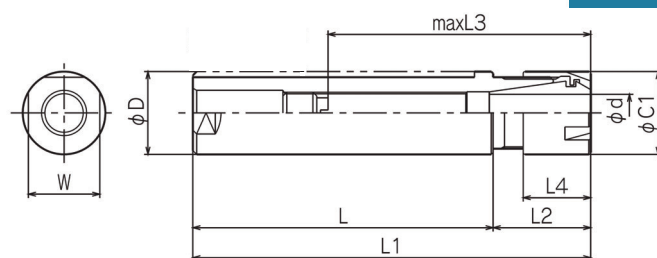
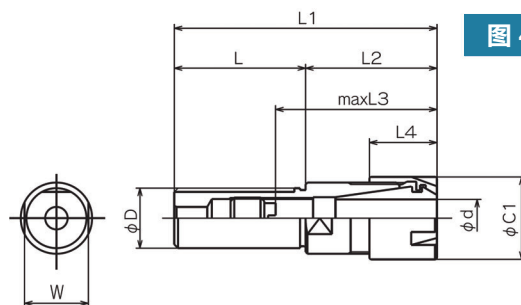


图 4



NA-M 型

迷你螺帽



NA-S 型

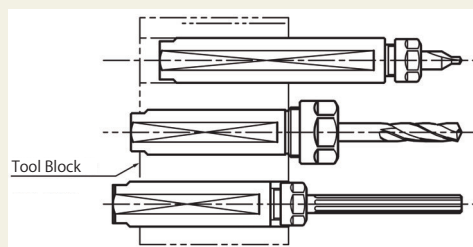
六角螺帽



M 螺帽扳手 CS 型
详情请参阅 P35

螺帽详见 P32

- 例) 微型夹头刀柄
(请在图 1, 图 2, 图 3, 图 4 中选择)



- 最小化突出长度
适用于小型机器 (如瑞士型)

尺寸表

公制规格

Dimensions

CODE	适用刀柄 直径 φ d	φ D	图	L	L1	L2	Max L3	配件螺母 Nut Size			W	调节螺栓 Adjust bolt	选配 Optional Part			
								型号 Code	φ C1	L4			筒夹 Collet	扳手 Wrench		
SSH12 -ECH 5S - 70	0.3 - 5	12	1	70	86	16	36 ※ (5)	NA8S	14.5	10.8	10	-	AR 8-d	SP-13		
SSH16 -ECH 5S - 70		0.5 - 7		16	35		51	35	NA11S	19	11.5	14	ECH 7-05	AR11-d	SP-17A	
-ECH 7S - 35	70				86		55	NA11M	16	12	AE11M					
-ECH 7S - 70	4		35		51	35	NA16S	28	17	19	ECH10-05	AR16-d			AE11M-CS	
-ECH 7MS- 35			70		86	55		NA16M	22						18	AE16M
-ECH 7MS- 70	0.5 - 10	2	35	70	35	43	NA16M	22	18	17			ECH 7-05	AR11-d	SP-25	
-ECH10S - 35			70	105											AE16M	
-ECH10S - 70			4	35			70	AE16M-CS								
-ECH10MS- 35				70			105									
-ECH10MS- 70	0.5 - 7	20	1	40	56	40	NA11S	19	11.5	17	ECH 7-05	AR16-d	SP-25			
SSH20 -ECH 7S - 40				70	86	55		70	NA16S					28	17	ECH10-05
-ECH 7S - 70				105	121	45		80								
-ECH 7S -105			0.5 - 10	2	40	62	40	55 ※ (5)	NA20S	34				19	22	-
-ECH10S - 40	70	92			70	75	ECH13-05									
-ECH10S - 70	105	127														
-ECH10S -105	0.5 - 13	22	3	40	70	30	55 ※ (5)	NA20S	34	19	22	-	AR20-d	SP-30		
-ECH13S - 40				70	100	75										
-ECH13S - 70																
SSH22 -ECH7MS - 40	0.5 - 7	22	3	40	56.5	16.5	40	NA11M	16	12	19	ECH 7-05	AR11-d	AE11M AE11M-CS		
-ECH7MS - 70				70	86.5		55									
-ECH7MS - 105				105	121.5											
-ECH7MS - 120				120	136.5											
-ECH10MS- 38	0.5 - 10	25	1	38	64	26	52	NA16M	22	18	22	ECH10-05	AR16-d	AE16M AE16M-CS		
-ECH10MS- 70				70	96		70									
-ECH10MS- 80				80	106		80									
-ECH10MS-105				105	131											
SSH25 -ECH 7S - 62	0.5 - 7	25	1	62	78	16	55	NA11S	19	11.5	22	ECH 7-05	AR11-d	SP-17A		
-ECH 7S - 70				70	86		70									
-ECH 7S - 85				85	101		45									
-ECH 7S -105				105	121		55									
-ECH10S - 40	0.5 - 10	32	1	40	63	23	45	NA16S	28	17	27	ECH10-05	AR16-d	SP-25		
-ECH10S - 50				50	73		70									
-ECH10S - 70				70	93		80									
-ECH10S -105				105	128		55									
-ECH13S - 50	0.5 - 13	32	1	50	74	24	75	NA20S	34	19	27	ECH13-05	AR20-d	SP-30		
-ECH13S - 70				70	94											
-ECH16S - 50	0.5 - 16	32	2	50	85	35	52	NA25S	42	20	27	ECH16-05	AR25-d	FK-6		
SSH32 -ECH13S - 60	0.5 - 13	32	1	60	86	26	65	NA20S	34	19	27	ECH13-05	AR20-d	SP-30		
-ECH16S - 60	0.5 - 16	32	1	60	87	27	65	NA25S	42	20	27	ECH16-05	AR25-d	FK-6		

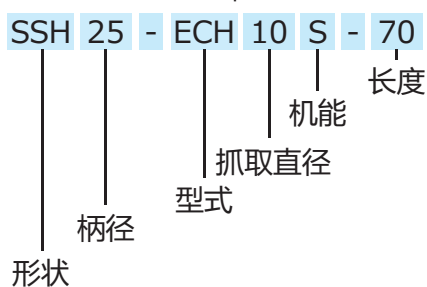
■ 备注

- (1) 与 AR 筒夹组合使用，请一并订购。
- (2) 不包括扳手，扳手请单独订购。
- (3) 可与标准螺母组合使用。如果夹持力不足，请使用替换螺母。
- (4) 可提供上述以外的特殊刀柄尺寸。
- (5) 无提供调整刀具伸出量的调节机构。
- (6) ECH16S 具有不同的螺母形状。

■ Remarks

- (1) Used in combination with AR collet. Please order together.
- (2) Spanner is not included.
- (3) Can be used in combination with standard nuts.
If the gripping force is insufficient, use a replacement nut.
- (4) Special shank dimensions other than the above are also available.
- (5) Adjusting mechanism for stick-out adjustment is not provided.
- (6) ECH16S has a different nut shape.

格式说明 Form explanation



微型 夹头刀柄

英寸规格

Short Nose Collet Holder

适用于瑞士型及排刀车床用。

Small and short holder suitable for Swiss-type and Gang type NC lathes.

瑞士型车床

排刀车床

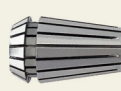
微型



- 尽量减少突出长度。适用于小型机器



螺帽



AR 筒夹



筒夹夹头刀柄

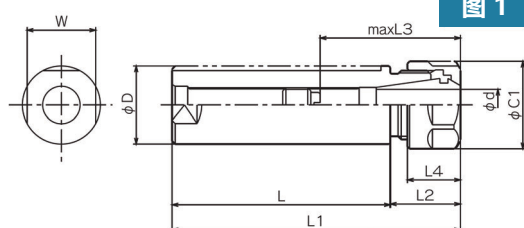


图 1

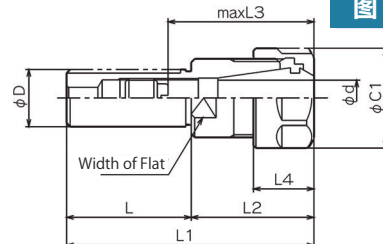


图 2

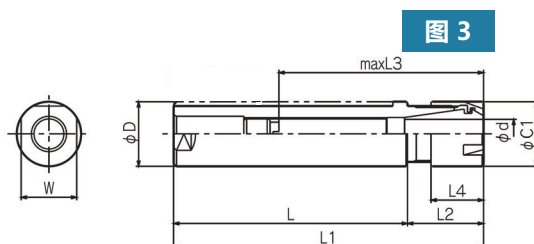


图 3



NA-M 型

迷你螺帽



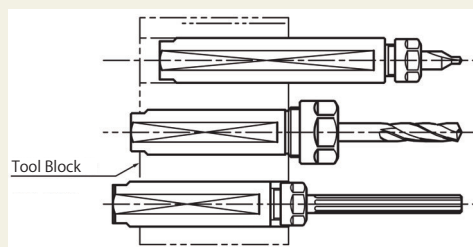
NA-S 型

六角螺帽



M 螺帽扳手 CS 型
详情请参阅 P35

- 例) 微型夹头刀柄
(请在图 1, 图 2, 图 3, 图 4 中选择)



- 最小化突出长度
适用于小型机器 (如瑞士型)

螺帽详见 P32

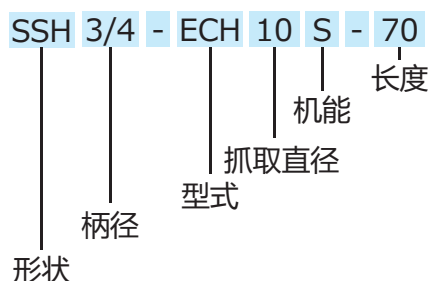
尺寸表

英寸规格

Dimensions

CODE	适用刀柄 直径 φ d	φ D	图	L	L1	L2	Max L3	配件螺母 Nut Size			W	调节螺栓 Adjust bolt	选配 Optional Part				
								型号 Code	φ C1	L4			筒夹 Collet	扳手 Wrench			
SSH5/8 -ECH 7S - 70	0.5 - 7	15.875	1	70	86	16	55	NA11S	19	11.5	14	ECH 7-05	AR11-d	SP-17A			
-ECH10S - 70	0.5 - 10		2		105	35	43	NA16S	28	17	19	ECH10-05	AR16-d	SP-25			
SSH3/4 -ECH 7S - 40	0.5 - 7	19.05	1	40	56	16	40	NA11S	19	11.5	17	ECH 7-05	AR11-d	SP-17A			
-ECH 7S - 70				70	86		55										
-ECH 7S -105				105	121		70										
-ECH 7S -120				120	136		70										
-ECH 7MS- 40			3	40	56.5	16.5	40	NA11M	16	12			AE11M AE11M-CS	SP-17A			
-ECH 7MS- 70				70	86.5		55										
-ECH 7MS- 105				105	121.5		55										
-ECH 7MS- 120				120	136.5		55										
-ECH10S - 40			0.5 - 10	1	40	62	22	45	NA16S	28		17		ECH10-05	AR16-d	SP-25	
-ECH10S - 70					70	92		70									
-ECH10S -105					105	127		80									
-ECH10S -120					120	142		80									
-ECH10MS- 40	3	40		65	25	45	NA16M	22	18			AE16M AE16M-CS	SP-25				
-ECH10MS- 70		70		95		70											
-ECH10MS-105		105		130		80											
-ECH10MS-120		120		145		80											
-ECH13S - 40	0.5 - 13	2	40	70	30	55 ※ (5)	NA20S	34	19	22	-	AR20-d	SP-30				
SSH1 -ECH 7S - 70	0.5 - 7	25.4	1	70	86	16	55	NA11S	19		11.5		ECH 7-05	AR11-d	SP-17A		
-ECH 7S -105				105	121		70										
-ECH 7MS- 70			3	70	86.5	16.5	55	NA11M	16		12			AE11M AE11M-CS	SP-25		
-ECH 7MS- 105				105	121.5		55										
-ECH10S - 50	0.5 - 10		1	50	73	23	50	NA16S	28		17		ECH10-05			AR16-d	SP-25
-ECH10S - 70				70	93		70										
-ECH10S -105				105	128		80										
-ECH10MS- 50				3	50		76							26	50		
-ECH10MS- 70			70		96	70											
-ECH10MS-105			105		131	80											
-ECH13S - 50			0.5 - 13		1	50	74	24	55		NA20S	34			19		ECH13-05
-ECH13S - 70				70		94	75										
-ECH16S - 50	0.5 - 16	2	50	85	35	52	NA25S	42	20	27	ECH16-05	AR25-d	FK-6				

格式说明 Form explanation



■ 备注

- (1) 与 AR 筒夹组合使用。请一起订购。
- (2) 不包括扳手。
- (3) 可与标准螺母组合使用。如果夹持力不足，请使用替换螺母。
- (4) 也可提供上述以外的特殊刀柄尺寸。
- (5) 无提供调整刀具伸出量的调节机构。
- (6) ECH16S 具有不同的螺母形状。

■ Remarks

- (1) Used in combination with AR collet. Please order together.
- (2) Spanner is not included.
- (3) Can be used in combination with standard nuts.
If the gripping force is insufficient, use a replacement nut.
- (4) Special shank dimensions other than the above are also available.
- (5) Adjusting mechanism for stick-out adjustment is not provided.
- (6) ECH16S has a different nut shape.

微型 夹头刀柄

双头刀柄

Two-Head Holder

公制规格

英寸规格

瑞士型车床用

格式说明 Form explanation

SSH 20 - ECH 7 WS - 33
形状 柄径 型式 抓取直径 机能 长度

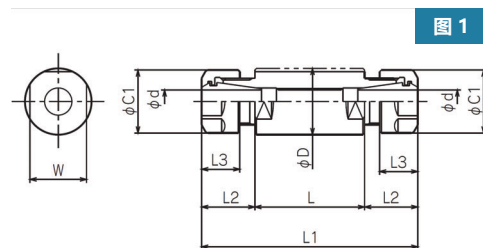


图 1

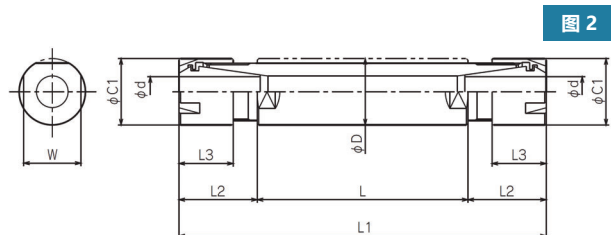


图 2

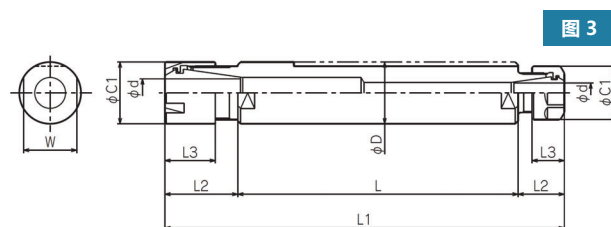


图 3

在单个工具中利用前（正面）后（背面）加工处理。

瑞士型和小型自动机器的理想选择。

支持外径公制和英制规格的尺寸。

Utilize front and back processing in a single tool.

Ideal for Swiss-type and small automatic machines.

Supports O.D. size in both Metric and Inch specifications.

CODE	适用刀柄 直径 φ d	φ D	图	L	L1	L2	配件螺母 Nut Size			W	选配 Optional Part				
							型号 Code	φ C1	L3		筒夹 Collet	扳手 Wrench			
SSH 20 -ECH 7WS -33	0.5 - 7	20	1	33	65	16	NA11S	19	11.5	17	AR11-d	SP-17A			
-ECH 7WS -53				53	85										
SSH3/4 -ECH 7WS -33		19.05			33								65		
-ECH 7WS -53					53								85		
SSH 22 -ECH10WM -38	0.5 - 10	22	2	38	90	26	NA16M	22	18	19	AR16-d	AE16M AE16M-CS			
-ECH10WM -63					63								115		
-ECH10WM -70					70								122		
-ECH10WM -85					85								137		
-ECH10/7WMS-100			0.5 - 7	3	100	142.5	16.5	NA11S	19		11.5	AR11-d	SP-17A		
			0.5 - 10				26	NA16M	22		18	AR16-d	AE16M AE16M-CS		
SSH 25 -ECH10WM -50	0.5 - 10	25	2	50	102	26	NA20M	28	19	-	AR20-d	AE20M			
-ECH13/10WM- 50	1 - 13				103	27					NA16M	22	18	AR16-d	AE16M AE16M-CS
	0.5 - 10					26					NA16M	22	18	AR16-d	AE16M AE16M-CS
SSH 1 -ECH10WM -70	0.5 - 10	25.4	2	70	122	26	NA16M	22	18	22	AR16-d	AE16M AE16M-CS			
-ECH10WM -105	0.5 - 10			105	157						27	NA20M	28	19	AR20-d
-ECH13/10WM- 70	1 - 13			70	123	26	NA16M	22	18		AR16-d	AE16M AE16M-CS			
	0.5 - 10										27	NA20M	28	19	AR20-d
-ECH13/10WM-105	0.5 - 13			105	158	27	NA20M	28	19		AR16-d	AE16M AE16M-CS			
	0.5 - 10										26	NA16M	22	18	AR16-d
SSH 32 -ECH13WM -55	0.5 - 13	32	2	55	109	27	NA20M	28	19	27	AR20-d	AE20M			
-ECH13WM -85					85						139				

■ 备注

- (1) AR (ER) 筒夹不包含在筒夹夹具中。如果您需要 AR 筒夹，请单独订购。
- (2) 夹头刀柄不附带扳手。如果您需要扳手，请单独订购。
- (3) 如需特殊形状请与我们联系。

■ Remarks

- (1) AR (ER) collet is not included with Collet holder. If you need an AR collet, please order separately.
- (2) Wrench is not included with Collet holder. If you need a wrench, please order separately.
- (3) Please contact us if you need a special shape.

冷却液通过 夹头刀柄

管螺纹 Rc 1/8 夹头刀柄

Collet Holder with Pipe Thread

公制规格

英寸规格

用于转塔车床

格式说明 Form explanation

SSH 20 - ECH 10 OH - 40
形状 柄径 型式 抓取直径 机能 长度

筒夹使用

OH 型

C 型

中心出水 / 侧面出水

20MPa 对应

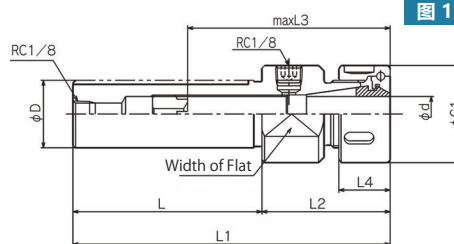


图 1

图 1

后部配管

侧面配管

CODE	适用刀柄 直径 φ d	φ D	L	L1	L2	Max L3	配件螺母 Nut Size			W	调节螺栓 Adjust bolt	选配 Optional Part			
							型号 Code	φ C1	L4			筒夹 Collet	扳手 Wrench		
SSH20 -ECH 70H- 70	1.9 - 7	20	70	106	36	55	NA11	23	11.5	27	ECH 70H-05	AR110H-d	FK-3		
-ECH100H- 40	1.9 - 10		40	85	45	45	NA16	32	17	30	ECH100H-05	AR160H-d	FK-4		
-ECH100H- 70				115		70									
-ECH130H- 70	2.9 - 13		70	117.5	47.5	75	NA20	36	19	32	ECH130H-05	AR200H-d	FK-5		
SSH25 -ECH100H- 70	1.9 - 10	25	70	115	45	70	NA16	32	17	30	ECH100H-05	AR160H-d	FK-4		
-ECH100H-105				105		150								80	
-ECH130H- 70				2.9 - 16		117.5	47.5	75	NA20	36	19	32	ECH130H-05	AR200H-d	FK-5
-ECH160H- 70															
SSH32 -ECH130H- 75	2.9 - 13	32	75	122.5	47.5	75	NA20	36	19	32	ECH130H-05	AR200H-d	FK-5		
-ECH160H- 75	2.9 - 16			126	51	80	NA25	43	20	36	ECH160H-05	AR250H-d	FK-6		
-ECH200H- 75	2.9 - 20			130	55		NA32	51	23	46	ECH200H-05	AR320H-d	FK-8		
SSH3/4 -ECH100H-105	1.9 - 10			19.05	105	150	45	80	NA16	32	17	30	ECH100H-05	AR160H-d	FK-4
SSH 1 -ECH100H-105		25.4													

瑞士型车床用

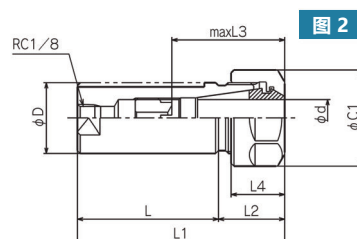
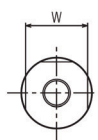


图 2

图 2

后部配管

CODE	适用刀柄 直径 φ d	φ D	L	L1	L2	Max L3	配件螺母 Nut Size			W	调节螺栓 Adjust bolt	选配 Optional Part	
							型号 Code	φ C1	L4			筒夹 Collet	扳手 Wrench
SSH20-ECH 7 S OH- 40	1.9 - 7	20	40	56	16	31	NA11S	19	11.5	17	ECH 7OH-05	AR11OH-d	SP-17A
-ECH10S OH- 40	1.9 - 10		62	22	33	NA16S	28	17	ECH100H-05		AR16OH-d	SP-25	
-ECH10S OH- 70			70	92	55								
SSH25-ECH10S OH- 40		25	40	63	23					33			22
-ECH10S OH- 50	50		73										
-ECH13S OH- 50	2.9 - 13		73.5	23.5	40	NA20S	34	19					
SSH32-ECH20S OH- 80	2.9 - 20	32	80	115	35	75	NA32S	50	23	36	ECH200H-05	AR32OH-d	FK-7

■ 备注

- (1) AR (ER) 筒夹不包含在筒夹夹具中。如果您需要 AR 筒夹, 请单独订购。
- (2) 夹头刀柄不附带扳手。如果您需要扳手, 请单独订购。
- (3) 如需特殊形状请与我们联系。
- (4) ECH20S 螺母形状不同。

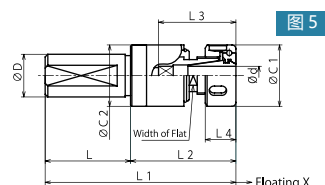
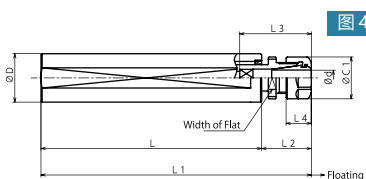
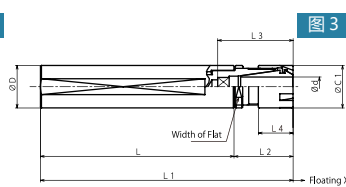
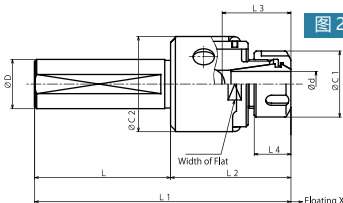
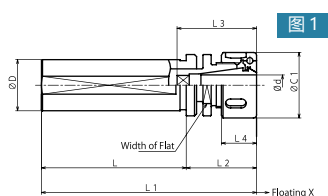
■ Remarks

- (1) AR (ER) collet is not included with Collet holder. If you need an AR collet, please order separately.
- (2) Wrench is not included with Collet holder. If you need a wrench, please order separately.
- (3) Please contact us if you need a special shape.
- (4) ECH20S is different in nut shape.

浮动轴吸收螺纹螺距误差。

Floating shaft absorbs thread pitch error.

单头



格式说明 Form explanation

SST 16 - ECH 7 - 32
形状 柄径 型式 抓取直径 长度

CODE	Tap size	φ D	图	L	L1	L2	L3	配件螺母 Nut Size			C2	W	浮动量 Floating X	选配 Optional Part	
								型号 Code	φ C1	L4				筒夹 Collet	扳手 Wrench
SST16 -ECH 7 -32	- M10	16	5	32	71.5	39.5	29	NA11	23	11.5	23	12	6	AR11-d	FK-3
SST20 -ECH 7 -40		20	1	40	66	26	29.5				NA11S				
-ECH 7 -70				4	70	97.5	27.5	32.5	18	19		10			
-ECH 7S -70		92.5	22.5			11.5	17								
SST22 -ECH10MS- 90	- M12	22	3	90	120.5	30.5	39	NA16M	22	18	-	19	10	AR16-d	AE16M
-ECH10MS-100			100	130.5	32.5										NA11S
-ECH 7S -100	- M10	4		122.5		22.5	NA11S	19	17	SP-17A					
SST25 -ECH 7 -70	- M12	25	1	70	97.5	27.5	NA11	23	11.5	-	24	17		AR16-d	FK-4
-ECH10 -70	104.5				34.5	39	NA16	32					17		
-ECT13 -70	M10 - M16		2	80	132	62	40.5	NA20S	34	19	49	32	12	AR20-d	SP-30
-ECT16 -70	M14 - M20				135	65	45	NA25S	42	20	57	38	13	AR25-d	FK-6
SST32 -ECT13 -80	M10 - M16	32	2	80	142	62	40.5	NA20S	34	19	49	32	12	AR20-d	SP-30
-ECT16 -80	M14 - M20				145	65	45	NA25S	42	20	57	38	13	AR25-d	FK-6
SST3/4-ECH 7S -46	- M10	19.05	4	46	66	20	29.5	NA11S	19	11.5	-	12	5	AR11-d	SP-17A
-ECH 7S -70				70	92.5	22.5	32.5					17	6		
-ECH 7S -105				105	127.5							17	6		
SST1 -ECH10 -70				- M12	25.4	1	70					104.5	34.5		

■ 备注

- (1) AR (ER) 简夹不包含在简夹夹具中。如果您需要 AR 简夹, 请单独订购。
- (2) 夹头刀柄不附带扳手。如果您需要扳手, 请单独订购。
- (3) ECH7 为 5.5 方孔, ECH10 为 6.5 方孔。
- (4) ECT13、ECT16 握持丝锥方柄如图 2 所示。

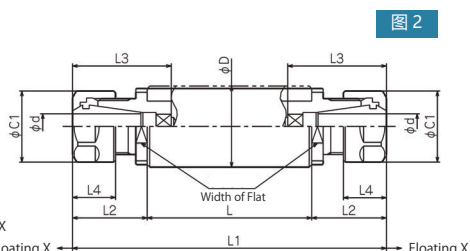
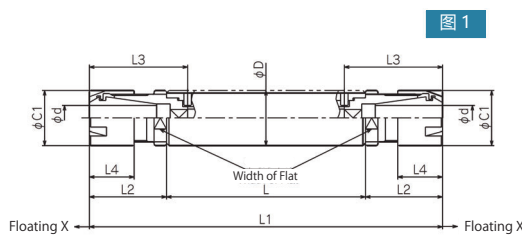
■ Remarks

- Remarks
 - (1) AR (ER) collet is not included with Collet holder. If you need an AR collet, please order separately.
 - (2) Wrench is not included with Collet holder. If you need a wrench, please order separately.
 - (3) ECH7 has 5.5 square hole and ECH10 has 6.5 square hole.
 - (4) ECT13 and ECT16 drip tap square shank as shown on Fig.2.

- (5) 使用 PF 型、PT 型丝锥时, 请使用长型丝锥。
- (6) ECH7S 的外形为微型。(衬套上没有塞子)
- (7) 丝锥刀柄不能使用内冷却液。
- (8) 使用小直径丝锥时, 轴的浮动力可能较弱。

- (5) When you use tap of PF type and PT type, please use long type tap.
- (6) The shape of ECH7S is short nose type. (It does not have a stopper to a sleeve.)
- (7) The tap holder cannot use the inner coolant.
- (8) When using a small diameter tap, the float force of the shaft may be weak.

双头



CODE	Tap size	φ D	图	L	L1	L2	L3	配件螺母 Nut Size			W	浮动量 Floating X	选配 Optional Part	
								型号 Code	φ C1	L4			简夹 Collet	扳手 Wrench
SST22-ECH10WM- 50	M5 - M12	22	1	50	111	30.5	-	NA16M	22	18	19	6	AR16-d	AE16M
SST22-ECH10WM- 80				80	142	31	38					10		AE16M-CS
SST32-ECH10WS - 65		32	2	65	124	29.5	39	NA16S	28	17	27	9		SP-25

带微型浮动丝锥刀柄 AES 型

Tap Holder AES type with Micro Float

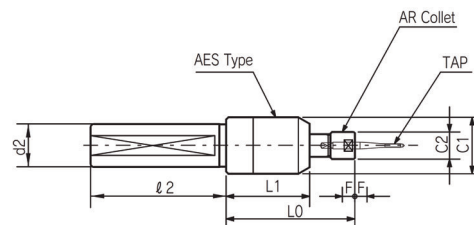
用于 NC 车床的丝锥夹具，通过稍微伸缩轴来吸收螺纹螺距误差。

Tap holder for NC lathes that absorbs thread pitch errors by slightly extending and retracting the shaft.



精密丝锥加工用

格式说明 Form explanation
STT 3/4 - AES 103 - 60
形状 柄径 型式 抓取直径 长度



- 同步控制加工
- 微型浮动攻丝机 (微膨胀 / 收缩)
- 硬质合金攻丝
- 高速攻丝
- Synchronous control machining
- Micro float tapper (with micro expansion/contraction)
- Carbide tapping
- High-speed tapping

CODE	ϕ d2	L0	L1	C1	ϕ C2	浮动量 Floating X	l 2	丝锥・铰刀尺寸 Capacity	螺母 Nut	选配 Optional Part	
						F				筒夹 Collet	扳手 Wrench
STT3/4-AES103 - 60	19.05	57	37	25	12	± 0.4	60	M1 - M3	NA8MR	AR 8	SP-11
STT 20-AES103 - 60	20										
STT 22-AES412-OHC- 60	22										
STT 25-AES412-OHC- 75	25	85	61.7	42	22	± 0.5	75	M4 - M12	NA16M	AR16 ※	AE16M AE16M-CS
STT 1-AES412-OHC- 75	25.4										
STT 32-AES412-OHC- 80	32										

■ 备注 对应筒夹
※: AR16GB-M4 — M12, AR16GH-M5 — M12

带径向浮动丝锥刀柄 ARF 型

Tap Holder ARF type with Radial Float

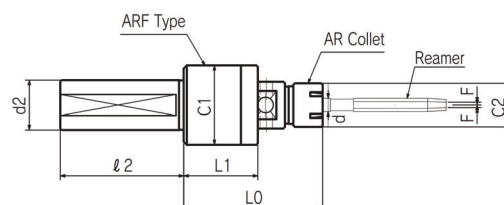
径向浮动丝锥刀柄・CNC 车床。

Radial floating Tap Holder CNC Lathes



铰刀加工用

格式说明 Form explanation
STT 16 - ARF 306 - 50
形状 柄径 型式 抓取直径 长度



- 同步控制加工
- 径向浮动丝锥
- 使用铰刀刀柄
- Synchronous control machining
- Radial float tapper
- Used as reamer holder

CODE	ϕ d2	L0	L1	C1	ϕ C2	浮动量 Floating X	l 2	丝锥・铰刀尺寸 Capacity	螺母 Nut	选配 Optional Part	
						F				筒夹 Collet	扳手 Wrench
STT 16-ARF306- 50	16	77	50	40	16	± 0.8	50	ϕ 4 - ϕ 6 (M3 - M6)	NA11M	AR11	AE11M AE11M-CS
STT3/4-ARF306- 60	19.05						60				
STT 20-ARF306- 60	20						75				
STT 22-ARF306- 60	22	67	40	40	16	± 0.8	60	ϕ 5 - ϕ 11 (M4 - M14)	NA20M	AR20	AE20M AE20M-CS
STT 25-ARF306- 75	25						75				
STT 20-ARF414- 60	20						60				
STT 25-ARF414- 75	25	90	48	51	28	± 1.0	75				
STT 1-ARF414- 75	25.4						80				
STT 32-ARF414- 80	32						80				

■ 备注
(1) L0 尺寸为标准值。
(2) 规格如有更改，恕不另行通知。

■ Remarks
(1) L0 dimension is the standard value.
(2) Specifications are subject to change without notice for improvement.

小型镗杆刀柄

Small Size Boring Bar Holder

用于 NC 车床的镗孔套筒

与使用 AR 筒夹夹紧相比，侧面锁定铣刀可以稳定切削刃位置。

Boring sleeves for NC lathes

Side-locking the boring bites stabilizes the cutting edge position compared to clamping with an AR collet.



格式说明 Form explanation

SSH 20 - BSH 10 - 70
形状 柄径 型式 抓取直径 长度

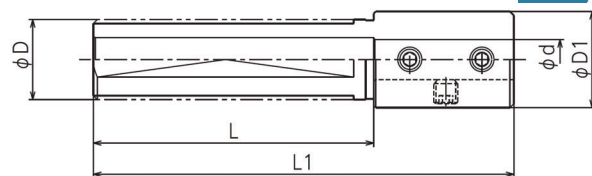


图 1

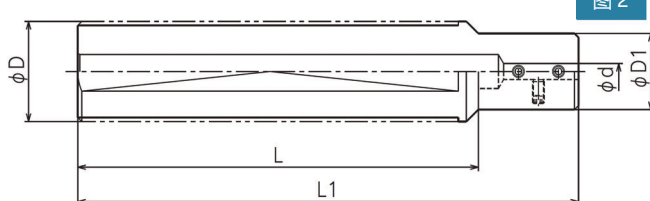
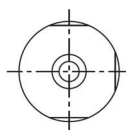


图 2

CODE	图	ϕd	ϕD	$\phi D1$	L1	L
SSH16 - BSH 4- 70	1	4	16	19	100	70
- BSH 5- 70		5				
- BSH 6- 70		6				
- BSH 7- 70		7		24	105	
- BSH 8- 70		8				
SSH20 - BSH 4- 70	2	4	20	19	100	70
- BSH 5- 70		5				
- BSH 6- 70		6				
- BSH 7- 70		7		24	105	
- BSH 8- 70		8				
- BSH10- 70	1	10	19.05			70
- BSH12- 70		12				
SSH3/4 - BSH 4- 70		4		19	100	
- BSH 5- 70		5				
- BSH 6- 70		6				
- BSH 7- 70	1	7		24	105	70
- BSH 8- 70		8				
- BSH10- 70		10				
- BSH12- 70		12				
SSH22 - BSH 4-100	2	4	22	19	125	100
- BSH 5-100		5				
- BSH 6-100		6				
- BSH 7-100		7				
- BSH 8-100		8		24	130	
- BSH10-100	1	10	25			100
- BSH12-100		12				
SSH25 - BSH 4-100		4		19	125	
- BSH 5-100		5				
- BSH 6-100		6				
- BSH 7-100	2	7		24	130	100
- BSH 8-100		8				
- BSH10-100		10				
- BSH12-100		12				

■ 备注
如果您需要特殊形状，请联系我们。

■ Remarks
Please contact us if you need a special shape.

~ 参考列表 ~ Reference Listing

混合刀柄

二头式

Hybrid Holder

二头式

One Side

镗杆刀柄

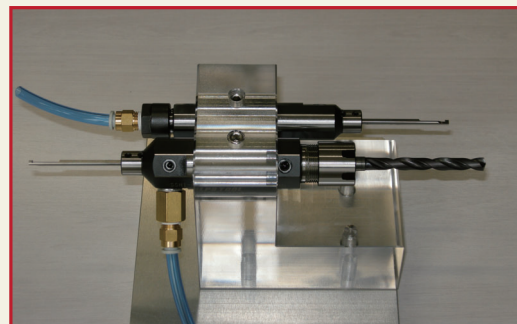
Boring Bar Holder

One Side

AR 筒夹刀柄

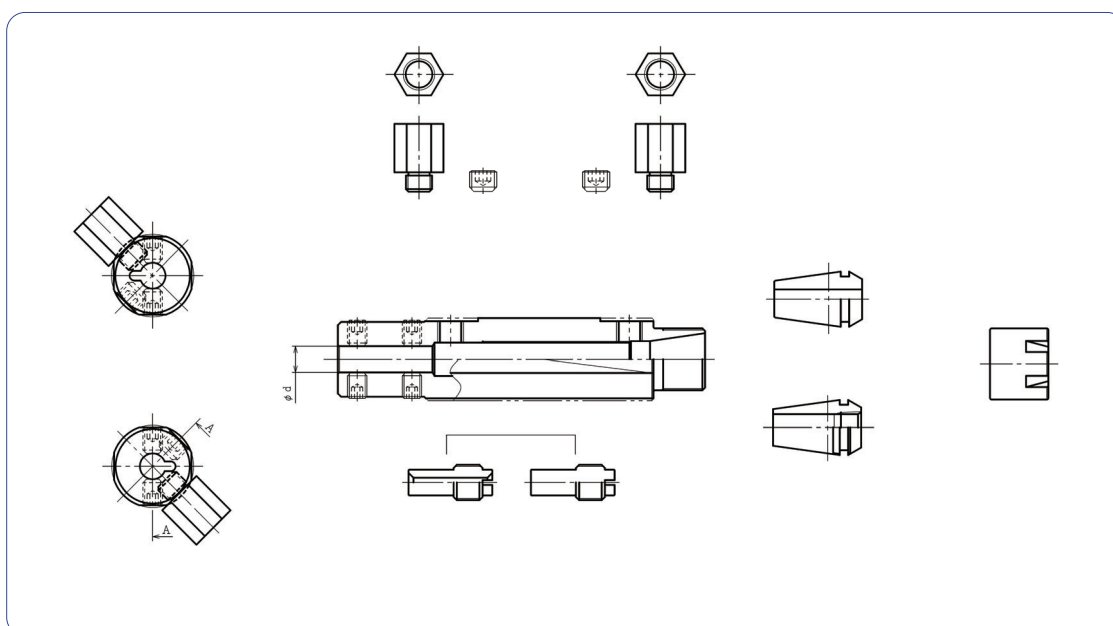
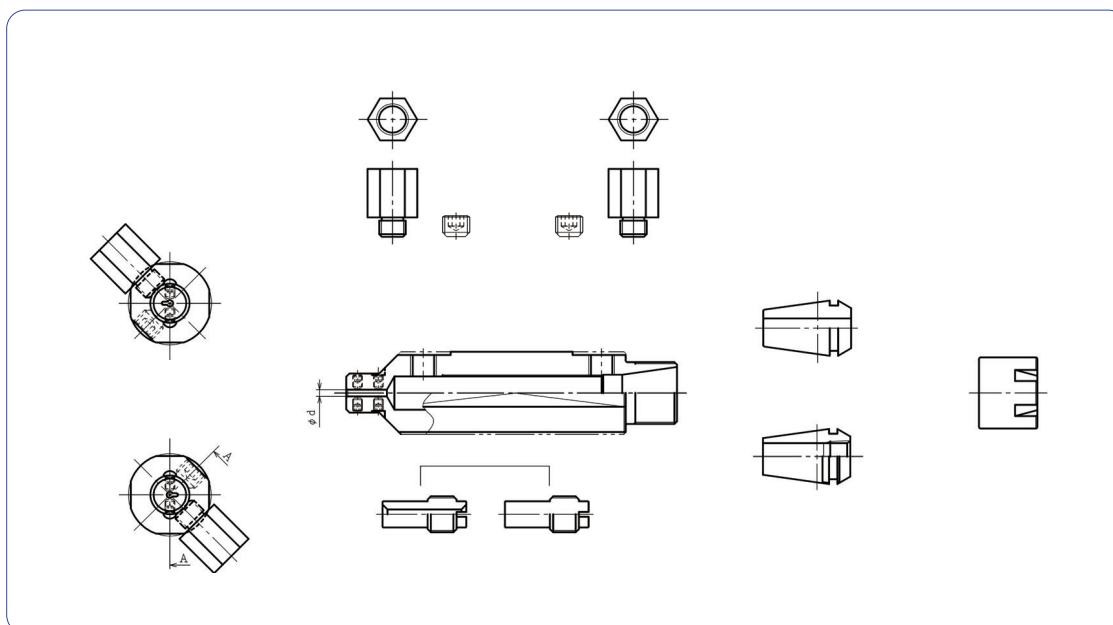
AR Collet Holder

用于数控车床



规格示例：

* 具体规格及详情请联系我们的销售部门。



刀具转换头 AR 型

Tool Change Head

只需更换现有螺母并安装。

无需更改动力工具主体，夹头刀柄等。

Simply replace the existing nut and install.

No need to change the main body of the Live tool, collet holder, etc.

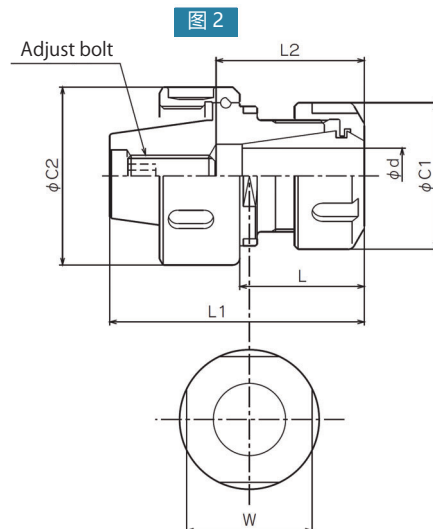
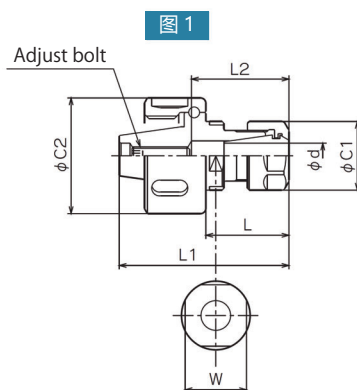
减少干扰

筒夹尺寸变更

轻松更改突出长度

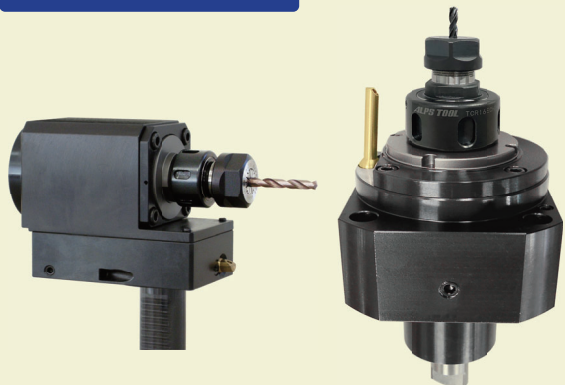


格式说明 Form explanation
TCR 20 - ECH 10 - 30
柄径 长度
形状 型式 抓取直径



CODE	图	安装侧型号 Mounting side	d	L	L1	L2	头部螺帽 Head Nut		φ C2	W	调节螺栓 Adjust bolt	筒夹 Collet	选配 Optional Part		
													扳手 Wrench		
													安装侧 Mounting side	宽度 Width	头侧 Head side
TCR11-ECH 7-22	1	ECH 7	0.5 - 7	22	38.5	22	19	NA11S	23	15	4S04012	AR11-d	FK-3	SP-15	SP-17A
TCR16-ECH 7-22		ECH10			46	25		32	17	4S05016	FK-4		SP-17A		
TCR16-ECH10- 30		ECH13	0.5 - 10	30	54	33	28	NA16S	32	22	4S06020	AR16-d	FK-5	SP-22	SP-25
TCR20-ECH10-30					60	35		36	25	FK-6				SP-25	
TCR20-ECH13- 32			2	ECH16	0.5 - 13	32	62	37	34	NA20S	36	25	4S10020	AR20-d	FK-6
TCR25-ECH13- 32	65	40					43	30		SP-30					
TCR25-ECH16- 34	ECH20	0.5 - 16		34	67	42	42	NA25S	43	32	4S12020	AR25-d	FK-8	SP-32	FK-6
TCR32-ECH16- 35					72	45		51	36	SP-32					
TCR32-ECH20- 37		ECH26		2 - 20	37	74	47	50	NA32S	51	40	4S16025	AR32-d	FK-9	SP-36
TCR40-ECH20- 37	82		50			63	46		SP-40						

动力工具的使用式列



工作效率



减少干扰



夹头刀柄

不带平边圆柄刀柄

Round Shank Holder

用于加工中心等的带圆柄的刀柄

Holders with round shanks for machining centers, etc.

作为延长刀柄用

减少干扰

格式说明 Form explanation

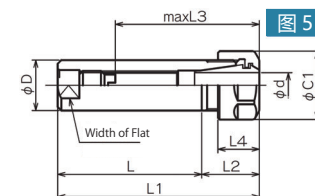
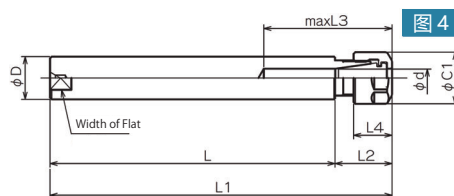
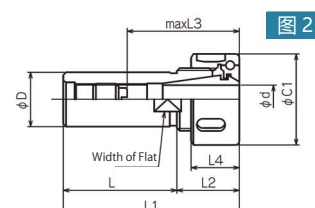
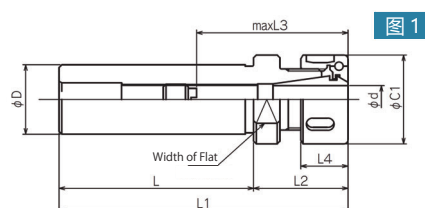
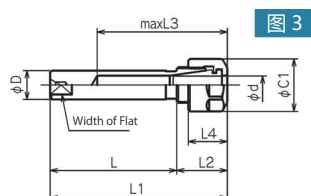
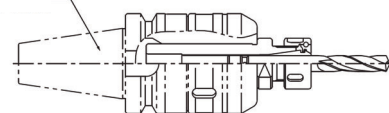
SS 25 - ECH 10 - 70

形状 柄径 型式 抓取直径 长度

● 例) 使用加工中心时

Holder, Type "R", "C" and "S"

BTO -ARHO -○
BTO -TRXO -○
BTO -ECHO -○



CODE	φ d	φ D	图	L	L1	L2	Max L3	配件螺母 Nut Size			W	调节螺栓 Adjust bolt	选配 Optional Part		
								型号 Code	φ C1	L4			筒夹 Collet	扳手 Wrench	
SS 8 -ECH 5S- 35	0.3 - 5	8	3 ※ (5)	35	49	14	36 ※ (6)	NA8S	14.5	10.8	6	-	AR 8-d	SP-13	
SS12 -ECH 5S- 80		12	4 ※ (5)	80	96	16		40	NA11S	19	11.5				10
SS14 -ECH 7S- 40	0.5 - 7	14	5 ※ (5)	40	56		16		40	NA11		23	11.5	12	ECH 7-05
SS16 -ECH 7 - 40		16	2	70	94	24		55			14			FK-3	
-ECH 7 - 70			1		70	94	24	55	19						
SS20 -ECH 7 - 45		20	2	45	61	16	45	17							
SS25 -ECH10 - 70	0.5 - 10	25	1	70	105	35	70	NA16	32	17	27	ECH10-05	AR16-d	FK-4	
-ECH10-150				150	185		55								
-ECH13 - 70	0.5 - 13			70	106	36	75	NA20	36	19	ECH13-05	AR20-d	FK-5		
-ECH13 -150				150	185										
-ECH13 -200		200		235											
-ECH16 - 70	0.5 - 16	70		110	40	80	NA25	43	20	36	ECH16-05	AR25-d	FK-6		
-ECH16 -150		150		190											
-ECH16 -200		200		240											
SS32 -ECH10 - 80	0.5 - 10	32		1	80	119	39	70	NA16	32	17	32	ECH10-05	AR16-d	FK-4
-ECH13 - 80	0.5 - 13					116	36	75	NA20	36	19		ECH13-05	AR20-d	FK-5
-ECH16 - 80	0.5 - 16					120	40	80	NA25	43	20	36	ECH16-05	AR25-d	FK-6
-ECH16 -150					150	190									
-ECH20 - 80			2 - 20		80	128	48	100							
SS40 -ECH20 -110	40				110	158									
-ECH20 -200		200			248										
-ECH20 -300		300			348										

■ 备注

- (1) AR (ER) 筒夹不包含在筒夹夹具中。
如果您需要 AR 筒夹, 请单独订购。
- (2) 夹头刀柄不附带扳手。如果您需要扳手, 请单独订购。
- (3) 发生干涉时, 可将筒夹螺母换成 "S" 型螺母。
- (4) 未显示的刀柄可按特殊订单提供制作。
- (5) 代号 5S 和 7S 随 "S" 型螺母一起提供。
- (6) 无调节机构。

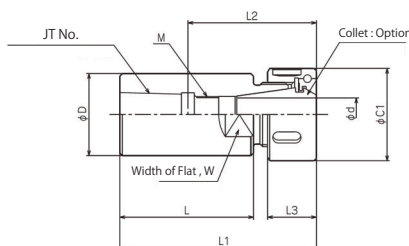
■ Remarks

- (1) AR (ER) collet is not included with Collet holder. If you need an AR collet, please order separately.
- (2) Wrench is not included with Collet holder. If you need a wrench, please order separately.
- (3) Collet nut can be replaced with type "S" Nut when interference takes place.
- (4) Shanks other than shown are available on special order.
- (5) Code No. 5S and 7S is come with type "S" Nut.
- (6) No adjustment mechanism.

雅各布斯锥度刀柄

Jacobs Taper Holder

代替无键钻夹头 (130-J6) 使用。 Use instead of keyless drill chuck (130-J6).



格式说明 Form explanation
JT 6 - ECH 13 - 80
形状 柄径 型式 抓取直径 长度

CODE	φ d	φ D	JT No.	L	L1	L2	M	配件螺母 Nut Size			W	选配 Optional Part	
								型号 Code	φ C1	L3		筒夹 Collet	扳手 Wrench
JT6-ECH13-80	0.5 - 13	32	JT6	52	77	50	M14 × 1.0	NA20	36	19	27	AR20-d	FK-5

■ 备注

- (1) 与筒夹组合使用。请一起订购。
- (2) 不包括扳手。
- (3) 可以通过外径 D 卡紧来使用。

■ Remarks

- (1) Used in combination with a collet. Please order together.
- (2) Spanner is not included.
- (3) Can be used by chucking the outer diameter D.

外径螺纹转造用园板牙夹持座

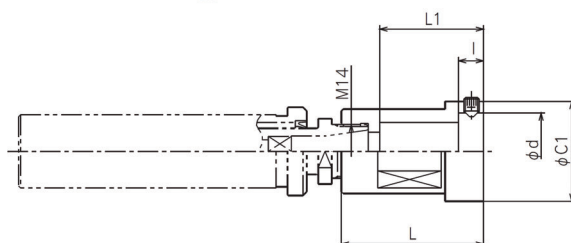
Die Holder

外径 φ 16 与 φ 20. 使用的刀柄。

与丝锥刀柄 SST □□ -ECH7 主机或配备同步功能的机器配合使用。

Die holder for die outer diameters φ 16 and φ 20.

It is used in combination with the tap holder SST □□ -ECH7 main unit or a machine equipped with the synchronizing function.



格式说明 Form explanation
ECH 7 - DH 1
型式 柄径 形状 尺寸

CODE	φ d	l	L	L1	φ C1	W	加工螺丝尺寸 (参考) Screw size
ECH 7-DH 1	16	4.8	32	22	20	9	M1 — M2.6
ECH 7-DH 2	20	6.5	27	27	26	11	M3 — M6

AR 筒夹整理台

AR Collet Arrange Stand

精巧小型的铝质筒夹排列架。

整理和管理筒夹的理想工具，可堆叠使用。

Compact aluminum arrange stand.

Best package for arrangement and manage of collet and piling up is possible.

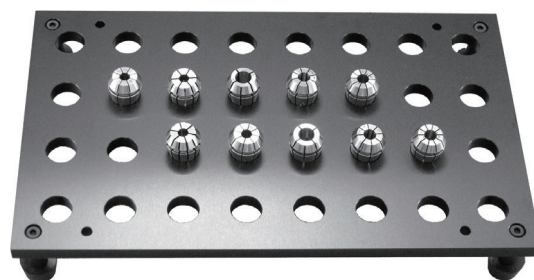
CODE	筒夹 Collet	储存容量 Storing No.	整理台尺寸 Size of Stand
CS-11	AR11-d	45	150 × 250 × 50
CS-16	AR16-d	32	
CS-20	AR20-d		
CS-25	AR25-d	18	150 × 250 × 52
CS-32	AR32-d		

■ 备注

- (1) 不含筒夹。
- (2) CS-32 不能叠置。

■ Remarks

- (1) Collet is not included.
- (2) It can not pile for CS-32



调节螺栓尺寸

Dimension of Adjust Bolt

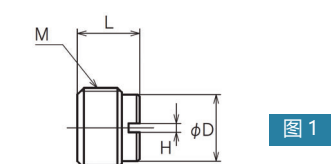


图 1

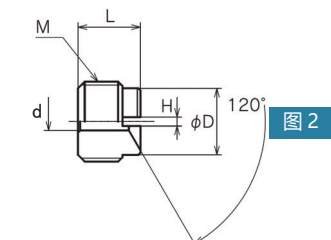


图 2

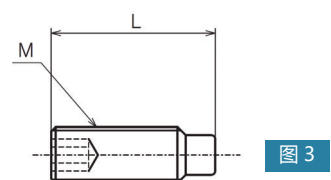


图 3

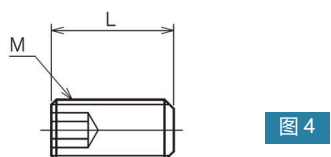


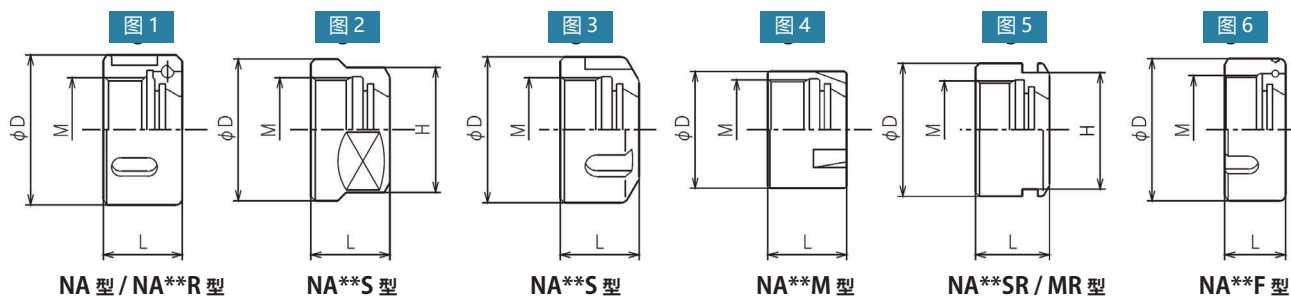
图 4

CODE	φ D	L	φ d	H	M	图	JIS
ECH 7-05	6	10	-	1.5	M 8 × 1.0	1	
ECH10-05	8	12			M11 × 1.0		
ECH13-05	11	13		2	M14 × 1.0		
ECH16-05	15	14			M18 × 1.5		
ECH20-05	20	16			M24 × 1.5		
ECH 70H-05	6	10	3	1.5	M 8 × 1.0	2	
ECH100H-05	8	12			M11 × 1.0		
ECH130H-05	11	13	4	2	M14 × 1.0		
ECH160H-05	15	14			M18 × 1.5		
ECH200H-05	20	16	5		M24 × 1.5		
2S06035	-	35	-	-	M 6 × 1.0	3	JISB1177
2S10030		30			M10 × 1.5		
2S12035		35			M12 × 1.75		
4S05016		16			M 5 × 0.8		
4S06020		20			M 6 × 1.0	4	
4S10020					M10 × 1.5		
4S12020					M12 × 1.75		
4S16025		25			M16		

- 这是刀柄附带的调整螺栓的尺寸。
- This stands for the dimensions of the adjusting bolts included with holders.

各 系列螺母

Collet Nuts



◎ NA** 型

w/ 屏蔽式轴承 w/ Bearings

屏蔽式轴承您可以获得稳定的高精度 TIR。
大约 30% 的钳位功率被与 S 型相比有所增加。适用于重切削。

◎ NA**S 型

六角头 Hex Head

尺寸比 NA 型小，因此最适合切割面积较小及干涉的情况时使用。

◎ NA**M 型

迷你螺母 Mini Nut

外部尺寸尽可能地最小化。在发生工具干涉时使用。
注：M 螺纹尺寸不同，需要专用刀柄。

◎ NA**F 型

薄螺母 Thin Nut

厚度比 NA 型更薄。注：M 螺纹尺寸不同。

◎ R 型

高速用 for High Speed
(选配) (option)

NA-R/SR** 适用于高速
高平衡设计、高平衡加工。用于高速旋转。

请指定代码, NA**R, NA**SR, NA**MR.

例) NA16R NA16SR NA16MR



CODE	图	D	L	M	H	筒夹 Collet	刀柄 Holder	扳手 Nut Wrench
NA 11	1	23	11.5	M14 × 0.75	-	AR11-d	-ECH 7	FK-3
11R		32	17	M22 × 1.5		AR16-d	-ECH10	FK-4
16								
16R		36	19	M25 × 1.5		AR20-d	-ECH13	FK-5
20								
20R		43	20	M32 × 1.5		AR25-d	-ECH16	FK-6
25								
25R		51	23	M40 × 1.5		AR32-d	-ECH20	FK-8
32								
32R		63	25	M50 × 1.5		AR40-d	-ECH26	FK-9
40								
50	80	35	M64 × 2.0	AR50-d	-ECH34	FK-11		
NA 8S	2	14.5	10.8	M10 × 0.75	13	AR 8-d	-ECH5S	SP-13
11S		19	11.5	M14 × 0.75	17	AR11-d	-ECH 7	SP-17A
11SR	5							
16S	2	28	17	M22 × 1.5	25	AR16-d	-ECH10	SP-25
16SR	5							
20S	2	34	19	M25 × 1.5	30	AR20-d	-ECH13	SP-30
20SR	5							
25S	3	42	20	M32 × 1.5	-	AR25-d	-ECH16	FK-6
32S		50	23	M40 × 1.5		AR32-d	-ECH20	FK-7
NA 8M	4	12	10.8	M10 × 0.75	-	AR 8-d	-ECH5S	AE8M
11M		16	12	M13 × 0.75		AR11-d	-	AE11M
16M		22	18	M19 × 1.0		AR16-d		AE16M
20M		28	19	M24 × 1.0		AR20-d		AE20M
NA 8MR	5	12	10.8	M10 × 0.75	11	AR 8-d	-	SP-11
11MR		16	12	M13 × 0.75	15	AR11-d		SP-15
16MR		22	18	M19 × 1.0	20	AR16-d		SP-20
NA 11F	6	23	11	M15 × 1.0	-	AR11-d	-	FK-3
16F		30	15	M22 × 1.0		AR16-d		FK-4
20F		35	17	M25 × 1.0		AR20-d		FK-5
25F		42	18	M32 × 1.0		AR25-d		FK-6
32F		50	19	M40 × 1.0		AR32-d		FK-8

■ 备注 (1) NA-R/SR/MR 为订购产品。
(2) 也可根据要求设计制造特殊螺母。

■ Remarks (1) NA-R/SR/MR are made to order.
(2) Special nuts are also designed and manufactured upon request.

建议螺母拧紧扭矩

Recomended Torque

尺寸 Dimension	大小 Size	扭矩 N · m Torque	刀柄尺寸 Holder size
AR 8	$\varnothing 0.5 - ^*\varnothing 3.5$	7	ECH 5
	$\varnothing 3.5 - \varnothing 5.0$	10	
AR11	$\varnothing 1.0 - < \varnothing 3.5$	15	ECH 7
	$\varnothing 3.5 - \varnothing 7.0$	20	
AR16	$\varnothing 1.0 - < \varnothing 3.5$	30	ECH10
	$\varnothing 3.5 - \varnothing 10.0$	40	
AR20	$\varnothing 1.0 - < \varnothing 3.5$	40	ECH13
	$\varnothing 3.5 - \varnothing 14.0$	60	
AR25	$\varnothing 1.0 - < \varnothing 3.5$	40	ECH16
	$\varnothing 3.5 - \varnothing 16.0$	60	
AR32	$\varnothing 3.0 - \varnothing 20.0$	70	ECH20
AR40	$\varnothing 4.0 - \varnothing 26.0$	80	ECH26
AR50	$\varnothing 6.0 - \varnothing 34.0$	140	ECH34

■ 注意事项

- (1) 过度拧紧可能会损坏刀柄主体、螺母或夹头。
- (2) 上表所列推荐扭矩仅供参考，不保证加工精度。
- (3) 拧紧螺母时建议使用扭力扳手。

* < =不到
大于 $\varnothing 0.5$ 小于 $\varnothing 3.5$

■ Caution

- (1) Excessive tightening may cause damage to the holder body, nut, or collet.
- (2) The recommended torques listed in the table above are only for reference. They do not guarantee machining accuracy.
- (3) Use of a torque wrench is recommended for tightening nuts.

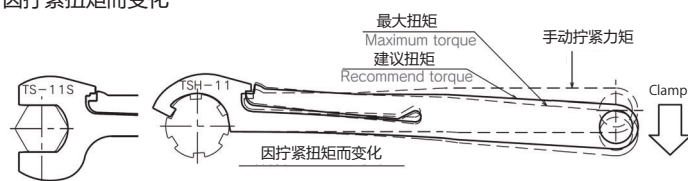
扭力扳手 PAT

在螺母的拧紧扭矩控制下可使精度稳定。
Stable accuracy with torque control for nut tightening



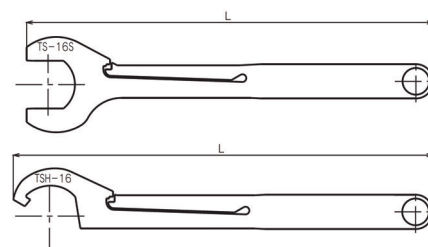
NA 螺母专用

因拧紧扭矩而变化

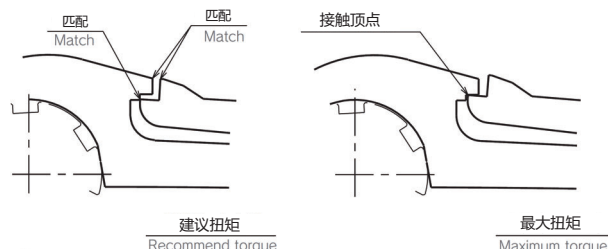


型号 CODE	螺母型号 Nut Code	建议扭矩 Recommend Torque	L(mm)	辅助管型号 Auxiliary pipe Code
TSH-11	NA11	20 (15)	180	
	NA11R			
	NA11F			
TS-11S	NA11S		170	
	NA11SR			
TS-11MR	NA11MR			
TSH-16	NA16	40 (30)	222	TSP-16
	NA16R			
	NA16F			
TS-16S	NA16S		215	
	NA16SR			
TS-16MR	NA16MR			

Torque Spanner



可通过目视确认建议的扭矩，并防止过度拧紧。



■ 备注

- (1) 请在建议扭矩和最大扭矩之间使用。
- (2) 筒夹尺寸小于 3.5mm 时，请使用 () 表示的扭矩。
- (3) 使用辅助管时，拧紧扭矩会减小，使用前请查看使用说明书。

■ Remarks

- (1) Please use between the recommend torque and maximum torque.
- (2) When the collet size is 3.5mm smaller, please use a torque that was represented to ().
- (3) When use the auxiliary pipe, tightening torque decreases, please check the instruction manual before use.

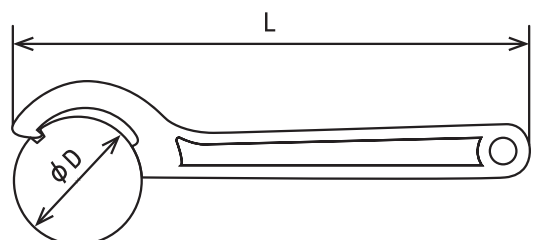
各 系列扳手

Wrenches

钩形扳手

Hook Wrench

NA** 型 用

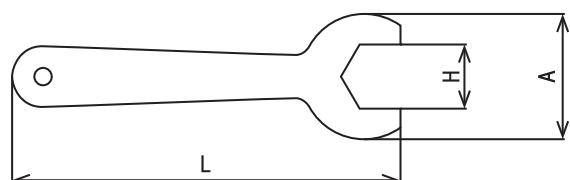


型号 CODE	螺母型号 Nut Code	φ D	L
FK-3	NA11	23	108
	NA11R		
	NA11F		
FK-4	NA16	32	136
	NA16R	30	
	NA16F		
FK-5	NA20	36	160
	NA20R	35	
	NA20F		
FK-6	NA25	43	173
	NA25R		
	NA25F	42	
	NA25S		
FK-8	NA32	51	208
	NA32R	50	
	NA32F		
	NA32S		
FK-9	NA40	63	232
FK-11	NA50	80	271

单头扳手

Spanner

NA**S 型 用

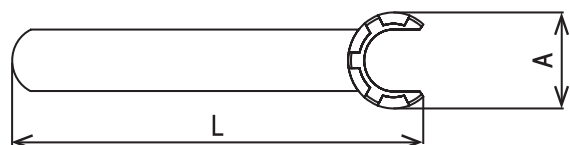


型号 CODE	螺母型号 Nut Code	H	A	L
SP-13	NA8S	13	40	140
SP-17A	NA11S	17	44	100
	NA11SR			
SP-25	NA16S	25	50	180
	NA16SR			
SP-30	NA20S	30	58	
	NA20SR			
SP-11	NA8MR	11	35	90
SP-15	NA11MR	15	50	150
SP-20	NA16MR	20	50	150

NA-M 扳手

NA-M Wrench

NA**M 型 用



型号 CODE	螺母型号 Nut Code	L	A
AE8M	NA 8 M	74	12.2
AE11M	NA11M	95	16.5
AE16M	NA16M	117	22.5
AE20M	NA20M	129	28.2

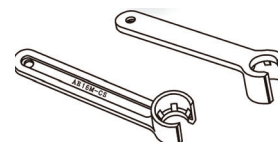
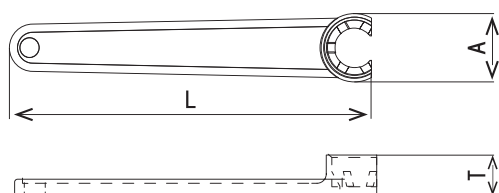
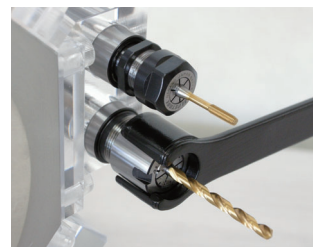


NA-M 扳手 CS 型

NA-M Wrench CS type

**牢牢抓住螺母，不会产生任何间隙。
可以放置在螺母的外圆周上。**

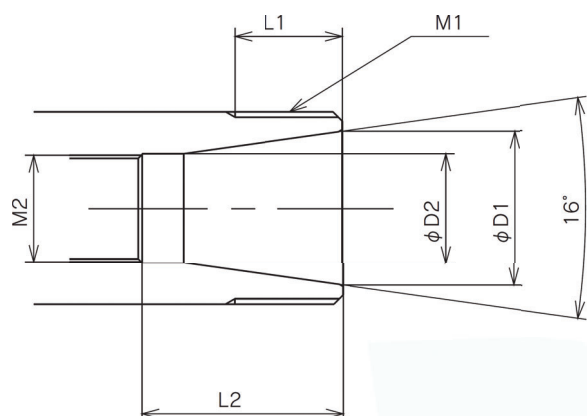
Grips nut securely and without rattle.
Can be placed over the outer circumference of the nut.



型号 CODE	螺母型号 Nut Code	L	A	T
AE11M-CS	NA11M	110	20	12.5
AE16M-CS	NA16M	126	28	21.5
AE20M-CS	NA20M	138	35	20

锥度尺寸

Dimensions of Taper



■ 备注

- (1) 这是设计主轴等时的参考标准。
详细尺寸请联系我们。
- (2) 也可提供锥度规。
- (3) 使用 M 螺母时，其数值与表中所示不同。

■ Remarks

- (1) This is a reference standard when designing spindles, etc.
Please contact us for detailed dimensions.
- (2) Taper gauge is also available.
- (3) The values are different from those shown in the table when M nuts are used.

CODE	D1	D2	M1	M2	min L1	min L2	适用筒夹 Collet to be used
☐ -ECH 5S- ☐	8	5.2	M10 × 0.75	-	7.5	-	AR 8
☐ -ECH 7 - ☐	11	8.2	M14 × 0.75	M 8 × 1.0	8	15	AR11
☐ -ECH10 - ☐	16	11.2	M22 × 1.5	M11 × 1.0	13	23	AR16
☐ -ECH13 - ☐	20	14.2	M25 × 1.5	M14 × 1.0	14	26	AR20
☐ -ECH16 - ☐	25	18.3	M32 × 1.5	M18 × 1.5	15	30	AR25
☐ -ECH20 - ☐	32	24.3	M40 × 1.5	M24 × 1.5	16	34	AR32
☐ -ECH26 - ☐	40	30.5	M50 × 1.5	M28 × 1.5	16	38	AR40
☐ -ECH34 - ☐	50	38	M64 × 2.0	-	24	-	AR50



That's the way!

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