Overview

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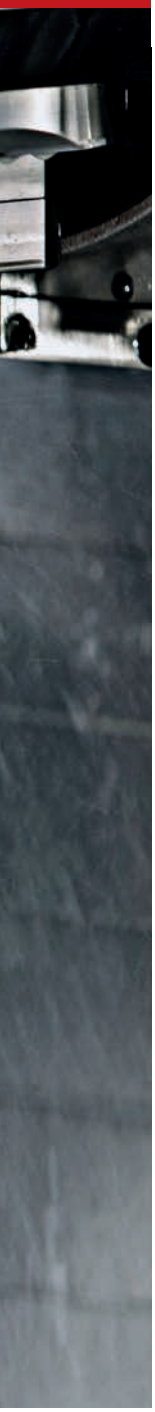

Chucks

Standard chucks in overview

	TOPlus mini	**TOPlus premium**	**TOPlus**
			
Description	Chuck with hexagonal clamping geometry and minimal interference contour	Chuck with hexagonal clamping geometry, minimal interference contour and high-precision run-out	Chuck with hexagonal clamping geometry
Sizes	26, 40, 52, 65, 80, 100	26, 40, 52, 65, 80, 100	52, 65, 100
Clamping range of all sizes [mm]	3 – 100	3 – 100	3 – 100
Variant	SE [hexagonal]	SE [hexagonal]	SE [hexagonal]
Advantages	■ 25 % higher holding power than SPANNTOP ■ Significantly reduced interference contour ■ Improved tool accessibility	■ Run-out accuracy ≤ 5 µm with premium clamping heads, otherwise ≤ 10 µm [requires clamping against the workpiece end-stop] ■ For precise and powerful clamping ■ Less expensive than hydro-expansion and diaphragm clamping devices	■ 25 % higher holding power than SPANNTOP ■ Unequalled rigidity due to full-surface contact of the clamping segments ■ Superior resistance to contami-nation because of the clamping head geometry ■ Absorbs vibration
Clamping elements	 Clamping head SE	 Clamping head SE	 Clamping head SE
Adaptations	 MANDO Adapt T211 SE [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE [Adaptation for jaw clamping]  Face driver SE / Morse taper adapter SE [Adaptation for clamping between centers]  Magnet module SE [Adaptation for magnetic clamping]	 MANDO Adapt T211 SE [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE [Adaptation for jaw clamping]  Face driver SE / Morse taper adapter SE [Adaptation for clamping between centers]  Magnet module SE [Adaptation for magnetic clamping]	 MANDO Adapt T211 SE [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE [Adaptation for jaw clamping]  Face driver SE / Morse taper adapter SE [Adaptation for clamping between centers]  Magnet module SE [Adaptation for magnetic clamping
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SPANNTOP mini	SPANNTOP nova	TOROK	InoFlex
			
Chuck with round clamping geometry and minimal interference contour	Chuck with round clamping geometry	Manually actuated chuck	Compensating 4-jaw chuck
32, 42, 52, 65, 80, 100	32, 42, 52, 65, 80, 100, 125, 160	52, 65, 80, 100	165, 215, 260, 315
3 – 100	3 – 160	3 – 100	8 - 315
RD [round]	RD [round]	SE [hexagonal] / RD [round]	
■ Significantly reduced interference contour ■ Improved tool accessibility ■ Ideal for limited installation space	■ Ideal for customers with existing RD clamping heads ■ Typical features of all HAINBUCH power chucks, such as high holding power, parallel clamping with high accuracy and easy set-up ■ Minimal inertia loss compared to 3-jaw chucks	■ Also available in a CFRP light-weight design ■ Manual actuation – a clamping cylinder is not required ■ Sensitive clamping possible ■ Workpiece stabilization through axial draw force applied against the workpiece end-stop	■ 4-sided clamping [2x2] with compensation of the opposing jaws ■ Ideal for clamping workpieces that are susceptible to deformation ■ For I.D. and O.D. clamping ■ High repeatability and run-out accuracy
 Clamping head RD	 Clamping head RD	 Clamping head SE  Clamping head RD	 Jaws
 MANDO Adapt T211 RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 RD [Mandrel-in-clamping-device, without draw bolt]  MANDO Adapt T812 RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module RD [Adaptation for jaw clamping]  Face driver RD / Morse taper adapter RD [Adaptation for clamping between centers]  Magnet module RD [Adaptation for magnetic clamping]	 MANDO Adapt T211 RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 RD [Mandrel-in-clamping-device, without draw bolt]  MANDO Adapt T812 RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module RD [Adaptation for jaw clamping]  Face driver RD / Morse taper adapter RD [Adaptation for clamping between centers]  Magnet module RD [Adaptation for magnetic clamping]	 MANDO Adapt T211 SE / RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE / RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE / RD [Adaptation for jaw clamping]  Face driver Morse taper adapter SE / RD [Adaptation for clamping between centers]  Magnet module SE / RD [Adaptation for magnetic clamping]	 InoZet pendulum bridge  InoTop hybrid chuck jaw
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Standard chucks in overview

	B-Top	B-Top3	Eccentric chuck	Machine specific chucks
				
Description	3-jaw chuck	3-jaw chuck with CENTREX interface	Eccentric chuck adjustable via c-axis	Chuck especially for your machine
Sizes	165, 215, 260, 315	215	65	SE 52, 65, 100 / RD 32, 42, 52, 65, 80, 100
Clamping range of all sizes [mm]	12 – 300	12 – 300	3 – 65	3 – 100
			RD [round]	SE [hexagonal] / RD [round]
Advantages	■ Fast jaw change with individual unlocking ■ Large through-bore with bushing inserts that can be changed from the front ■ Proven wedge rod mechanism	■ Jaw chuck with quick conversion to a segmented clamping bushing [I.D. clamping] and a clamping head [O.D. clamping] ■ Fast jaw change with individual unlocking ■ Large through-bore with bushing inserts that can be changed from the front ■ Proven wedge rod mechanism	■ Infinite eccentric adjustment via the c-axis ■ Concentric and eccentric machining in a single clamping set-up ■ Different eccentric dimensions are possible with the same chuck and clamping head	
Clamping elements	 Jaws	 Jaws	 Clamping head RD	 Clamping head SE  Clamping head RD
Adaptations		 MANDO Adapt [Mandrel-in-jaw-chuck]  SPANNTOP Adapt [End-stop-chuck-in-jaw-chuck]  SPANNTOP Adapt M [Through-bore-chuck-in-jaw-chuck]		
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TOPlus mini

HAINBUCH SYSTEM

The »mini« series really shines with a mass reduced by as much as 30 %, and a chuck diameter that is reduced by 1/3. This means reduced energy consumption and better tool accessibility. Naturally, adaptation devices can also be used with the TOPlus mini chuck. To maintain the minimal interference contour, the TOPlus mini chuck has its own adaptation devices with a smaller bolt hole circle.

Thanks to the reduced interference contour, it is easier to choose the tool that you need. Now it can also be shorter and more stable – on the main and sub spindles. Particularly in the case of limited installation space and in series operation, the TOPlus mini chuck is ideal: Lower energy consumption, dynamic spindle acceleration, and shorter cycle times reduce the costs per workpiece.

Minimalism that pays off!

Key advantages

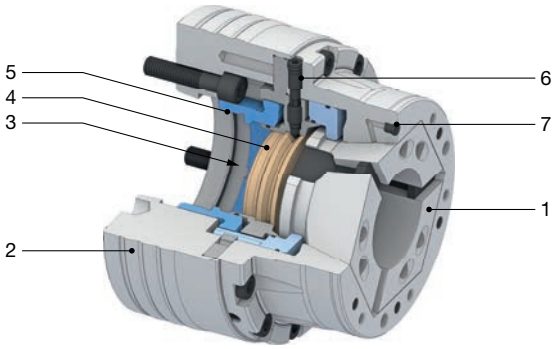
- Adaptation devices possible [HAINBUCH SYSTEM]
- 25 % higher holding power than SPANNTOP
- Significantly reduced interference contour
- Improved tool accessibility
- Ideal for limited installation space
- Lower mass
- Minimal inertia loss compared to 3-jaw chucks

TOPlus mini pull-back in use

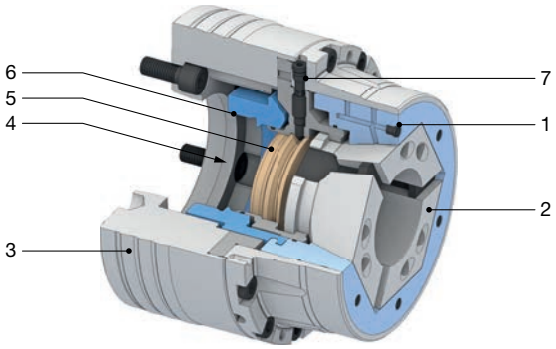
TOPlus mini chuck types

	TOPlus mini pull-back	TOPlus mini deadlength
		
Description	Workpiece clamping with pull-back effect. Chuck with dismountable end-stop plate.	Workpiece clamping without pull-back effect. Chuck with dismountable end-stop plate.
Advantages	■ Workpiece stabilization through axial draw force applied against the workpiece end-stop ■ Prepared for inside and front end-stop ■ Converts to a fully functional »bar chuck« when the end-stop plate is removed	■ Workpiece clamping without axial movement of the clamping head ■ Clamps workpieces with a short collar or shoulder ■ Suitable for pick-off without pull-back effect ■ Prepared for inside and front end-stop ■ Converts to a fully functional »bar chuck« when the end-stop plate is removed
Clamping elements	 Clamping head SE	 Clamping head SE
Adaptations	 MANDO Adapt T211 SE [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE [Adaptation for jaw clamping]  Face driver SE / Morse taper adapter SE [Adaptation for clamping between centers]  Magnet module SE [Adaptation for magnetic clamping]	

TOPlus mini pull-back in detail

Designation	
1 Vulcanized clamping head with pull-back and hexagonal geometry for optimum chuck sealing and improved clamping force 2 Spindle flange 3 Chuck through-bore for bar work after disassembling the base end-stop 4 Fixed base end-stop for clamping with pull-back effect, central mounting thread for workpiece specific end-stop 5 Mounting thread for drawtube connection 6 Clamping screw for base end-stop, easy mounting through external actuation 7 Grease nipple, optimal holding power due to efficient lubrication	

TOPlus mini deadlength in detail

Designation	
1 Grease nipple, optimal holding power due to efficient lubrication 2 Vulcanized standing clamping head with hexagonal geometry for improved chuck seal and greater clamping force 3 Spindle flange 4 Chuck through-bore for bar work after disassembling the base end-stop 5 Fixed base end-stop with central mounting thread for workpiece specific end-stop 6 Mounting thread for drawtube connection 7 Clamping screw for base end-stop, easy mounting through external actuation	

Order overview. TOPlus mini chuck

						Clamping elements and adaptations					
											
Size	Variant	Spindle nose	Total length [mm]	Material no.	In stock	Clamping head SE	MANDO Adapt T211 SE for TOPlus mini / premium	MANDO Adapt T212 SE for TOPlus mini / premium	Jaw module SE	Face driver / morse taper adapter SE for TOPlus mini / premium	Magnet module SE
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26	Pull-back	A2-4	102	10000752	✔	✔					
		A2-5		10000753	✔						
			125	10000754	✔						
	Deadlength	A2-4	99	10000797	✔	✔					
			110	10000798	✔						
		A2-5	101	10000799	✔						
			110	10000800	✔						
			130	10000801	✔						
40	Pull-back	A2-4	125	10000755	✔	✔					
		A2-5	117	10000756	✔						
			125	10000757	✔						
			143	10000758	✔						
		A2-6	124	10000759	✔						
			142	10000760	✔						
		AP120	106	10000761	✔						
			118	10000762	✔						
		AP140	106	10000786	✔						
	Deadlength	A2-4	123	10000802	✔	✔					
		A2-5	115	10000803	✔						
			123	10000804	✔						
			140	10000805	✔						
		A2-6	122	10000806	✔						
			139	10000807	✔						
52	Pull-back	A2-5	122	10000764	✔	✔	✔	✔		✔	✔
			145	10000765	✔						
		A2-6	122	10000766	✔						
			145	10000767	✔						
		A2-8	120	10000784	✔						
			145	10000785	✔						
		AP110	120	10000782	✔						
		AP120	105	10000768	✔						
			115	10000769	✔						
		AP140	105	10000770	✔						
			115	10000771	✔						

Detailed technical data follows.
TOPlus mini and TOPlus premium chucks require adaptations [MANDO Adapt, face driver and morse taper adapter] of the mini series.
Machine spindle standard DIN ISO 702-1. For spindle connection data please visit www.hainbuch.com.

Order overview. TOPlus mini chuck

						Clamping elements and adaptations					
											
Size	Variant	Spindle nose	Total length [mm]	Material no.	In stock	Clamping head SE	MANDO Adapt T211 SE for TOPlus mini / premium	MANDO Adapt T212 SE for TOPlus mini / premium	Jaw module SE	Face driver / morse taper adapter SE for TOPlus mini / premium	Magnet module SE
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52	Deadlength	A2-5	122	10000811	✔	✔					
		A2-5	147	10000812	✔						
		A2-6	122	10000813	✔						
			147	10000814	✔						
		A2-8	120	10000834	✔						
		AP110	100	10000831	✔						
			115	10000833	✔						
		AP120	105	10000815	✔						
			115	10000816	✔						
		AP140	107	10000817	✔						
65	Pull-back	A2-5	124	10000787	✔	✔	✔	✔	✔	✔	✔
			130	10000740	✔						
			150	10000741	✔						
		A2-6	126	10000742	✔						
			130	10000743	✔						
			155	10000744	✔						
		A2-8	130	10000745	✔						
			155	10000746	✔						
		AP120	111	10000749	✔						
			120	10000750	✔						
		AP140	111	10000747	✔						
			120	10000748	✔						
		AP170	115	10000751	✔						
	Deadlength	A2-5	128	10000788	✔	✔					
			138	10000789	✔						
		A2-6	124	10000790	✔						
			138	10000791	✔						
			163	10000792	✔						
		A2-8	133	10000793	✔						
			163	10000794	✔						
		AP120	129	10000840	✔						
		AP140	138	10000795	✔						
		AP170	110	10000836	✔						
			128	10000796	✔						
80	Pull-back	A2-5	132	10017026	✔	✔	✔	✔			
		A2-6	128	10017030	✔						

Detailed technical data follows.
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Machine spindle standard DIN ISO 702-1. For spindle connection data please visit www.hainbuch.com.

Order overview. TOPlus mini chuck

						Clamping elements and adaptations					
											
Size	Variant	Spindle nose	Total length [mm]	Material no.	In stock	Clamping head SE	MANDO Adapt T211 SE for TOPlus mini / premium	MANDO Adapt T212 SE for TOPlus mini / premium	Jaw module SE	Face driver / morse taper adapter SE for TOPlus mini / premium	Magnet module SE
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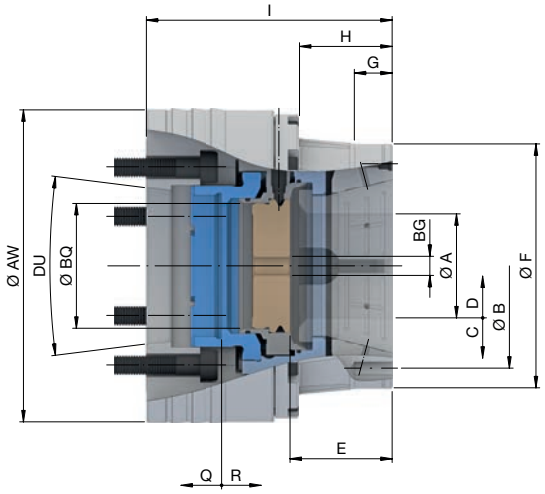
80	Pull-back	A2-6	135	10017031	✔	✔	✔	✔			
			155	10017032	✔						
		A2-8	132	10017034	✔						
			150	10017038	✔						
			180	10017039	✔						
		AP140	132	10017040	✔						
		AP170	115	10017041	✔						
		AP220		10018166	✔						
	Deadlength	A2-5	136	10017043	✔	✔					
		A2-6	130	10017044	✔						
			137	10017045	✔						
			157	10017046	✔						
		A2-8	132	10017048	✔						
			152	10017049	✔						
			182	10017050	✔						
		AP140	134	10017051	✔						
		AP170	115	10017053	✔						
100	Pull-back	A2-5	160	10000772	✔	✔	✔	✔	✔	✔	✔
		A2-6	164	10000773	✔						
			170	10000774	✔						
		A2-8	162	10000775	✔						
			180	10000776	✔						
		A2-11		10000777	✔						
			195	10000778	✔						
		AP170	164	10000779	✔						
		AP220	150	10000780	✔						
	Deadlength	A2-5	171	10000818	✔	✔					
		A2-6	175	10000819	✔						
			182	10000820	✔						
		A2-8	169	10000821	✔						
			192	10000822	✔						
		A2-11	185	10000823	✔						
			200	10000824	✔						
		AP140	171	10000828	✔						
		AP170	175	10000825	✔						

Detailed technical data follows.
TOPlus mini and TOPlus premium chucks require adaptations [MANDO Adapt, face driver and morse taper adapter] of the mini series.
Machine spindle standard DIN ISO 702-1.
For spindle connection data please visit www.hainbuch.com.

Scope of delivery

- Chuck
- Base end-stop
- Socket wrench insert 1/2"

TOPlus mini pull-back size 26. Technical data



Size		26
Variant		**Pull-back**
Run-out ≤ [mm]		0,010
Max. radial clamping force [kN]		35
Max. axial drawtube force [pull / push] [kN]		16
RPM n max. [1/min.]		10000
Clamping range [mm]	A	3 – 26
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	0,6
Range / recommended workpiece tolerance [mm]		± 0,3
End-stop depth [mm]	E	33,8
Ø Capacity [mm]	BQ	37
End-stop thread size [M]	BG	8
Location front end-stop	F	Ø 67 f7
Centering length [mm]	G	15
Bolt hole circle end-stop	B	LK Ø 58 [3 x M6]
Length [mm]	H	43
Reserve stroke axial [mm]	Q	1
Release stroke axial [mm]	R	2

Spindle nose	DU	**A2-4**	**A2-5**	
Total length [mm]	I	**102**		**125**
Outer Ø [mm]	AW	114	128	
Weight [kg]		4,8	5,3	6,3
In stock		✔	✔	✔
Material no.		10000752	10000753	10000754

Clamping heads

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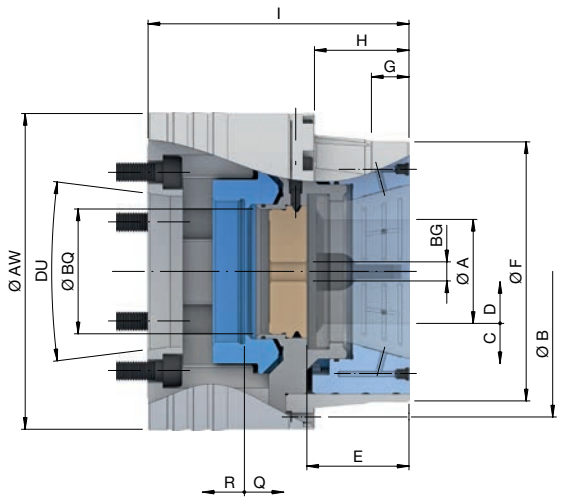
TOPlus mini deadlength size 26. Technical data



Size		26
Variant		**Deadlength**
Run-out ≤ [mm]		0,020
Max. radial clamping force [kN]		35
Max. axial compression force [kN]		16
RPM n max. [1/min.]		10000
Clamping range [mm]	A	3 – 26
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	0,6
Range / recommended workpiece tolerance [mm]		± 0,3
End-stop depth [mm]	E	34,5
Ø Capacity [mm]	BQ	27
End-stop thread size [M]	BG	8
Location front end-stop	F	Ø 74 f7
Centering length [mm]	G	20
Bolt hole circle end-stop	B	LK Ø 88 [3 x M4]
Length [mm]	H	33
Reserve stroke axial [mm]	Q	1
Release stroke axial [mm]	R	2

Spindle nose	DU	A2-4		A2-5		
Total length [mm]	I	**99**	**110**	**101**	**110**	**130**
Outer Ø [mm]	AW	114		128		
Weight [kg]		4,8	5,3	5,4	5,9	6,8
In stock		✔	✔	✔	✔	✔
Material no.		10000797	10000798	10000799	10000800	10000801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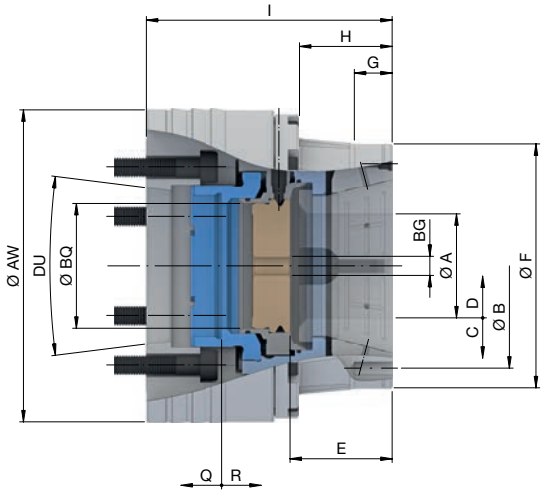
TOPlus mini pull-back size 40. Technical data



Size		40
Variant		**Pull-back**
Run-out ≤ [mm]		0,010
Max. radial clamping force [kN]		103
Max. axial drawtube force [pull / push] [kN]		33
RPM n max. [1/min.]		7000
Clamping range [mm]	A	3 – 40
Release stroke in Ø [mm]	C	0,5
Reserve stroke in Ø [mm]	D	0,8
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	47
Ø Capacity [mm]	BQ	44
End-stop thread size [M]	BG	10
Location front end-stop	F	Ø 91 f7
Centering length [mm]	G	20
Bolt hole circle end-stop	B	LK Ø 105 [3 x M6]
Length [mm]	H	47
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2

Spindle nose	DU	A2-4	A2-5			A2-6	
Total length [mm]	I	125	117	125	143	124	142
Outer Ø [mm]	AW	132				163	
Weight [kg]		7,7	6,9	7,3	8,2	9,7	11,1
In stock		✔	✔	✔	✔	✔	✔
Material no.		10000755	10000756	10000757	10000758	10000759	10000760

Spindle nose	DU	AP120		AP140
Total length [mm]	I	106	118	106
Outer Ø [mm]	AW	132		150
Weight [kg]		6,4	7	7,9
In stock		✔	✔	✔
Material no.		10000761	10000762	10000786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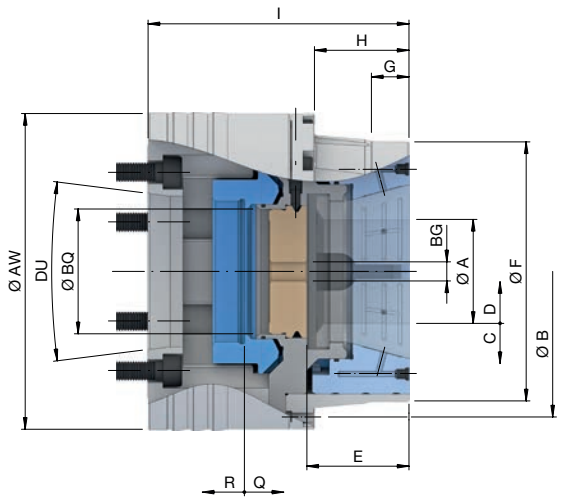
TOPlus mini deadlength size 40. Technical data



Size		40
Variant		**Deadlength**
Run-out ≤ [mm]		0,020
Max. radial clamping force [kN]		103
Max. axial compression force [kN]		33
RPM n max. [1/min.]		7000
Clamping range [mm]	A	3 – 40
Release stroke in Ø [mm]	C	0,5
Reserve stroke in Ø [mm]	D	0,8
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	47,7
Ø Capacity [mm]	BQ	44
End-stop thread size [M]	BG	10
Location front end-stop	F	Ø 99 f7
Centering length [mm]	G	20
Bolt hole circle end-stop	B	LK Ø 115 [3 x M4]
Length [mm]	H	47
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2

Spindle nose	DU	A2-4	A2-5			A2-6	
Total length [mm]	l	**123**	**115**	**123**	**140**	**122**	**139**
Outer Ø [mm]	AW	134				160	
Weight [kg]		8,2	7,5	8	8,9	10	11,3
In stock		✔	✔	✔	✔	✔	✔
Material no.		10000802	10000803	10000804	10000805	10000806	10000807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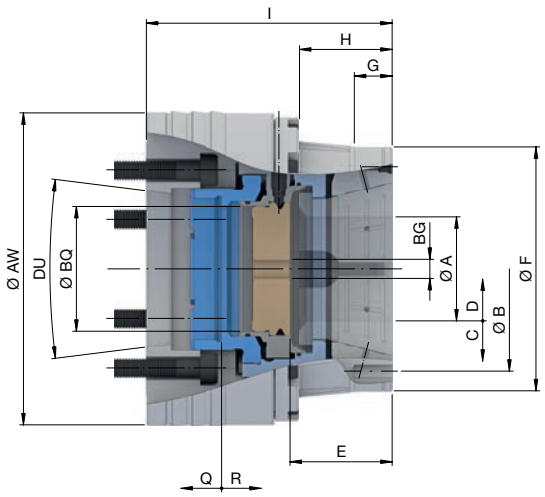
TOPlus mini pull-back size 52. Technical data



Size		52
Variant		**Pull-back**
Run-out ≤ [mm]		0,010
Max. radial clamping force [kN]		108
Max. axial drawtube force [pull / push] [kN]		40
RPM n max. [1/min.]		7000
Clamping range [mm]	A	3 – 52
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	46
Ø Capacity [mm]	BQ	53
End-stop thread size [M]	BG	10
Location front end-stop	F	Ø 119 f7
Centering length [mm]	G	15
Bolt hole circle end-stop	B	LK Ø 105 [3 x M8]
Length [mm]	H	42
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	**A2-5**		**A2-6**		**A2-8**	
Total length [mm]	I	**122**	**145**	**122**	**145**	**120**	**145**
Outer Ø [mm]	AW	149		159		204	
Weight [kg]		10,5	12,4	10,7	12,4	15,7	18,6
In stock		✔	✔	✔	✔	✔	✔
Material no.		10000764	10000765	10000766	10000767	10000784	10000785

Spindle nose	DU	**AP110**	**AP120**		**AP140**	
Total length [mm]	I	**120**	**105**	**115**	**105**	**115**
Outer Ø [mm]	AW	149			150	
Weight [kg]		10,7	9,3	10,1	9,2	10,1
In stock		✔	✔	✔	✔	✔
Material no.		10000782	10000768	10000769	10000770	10000771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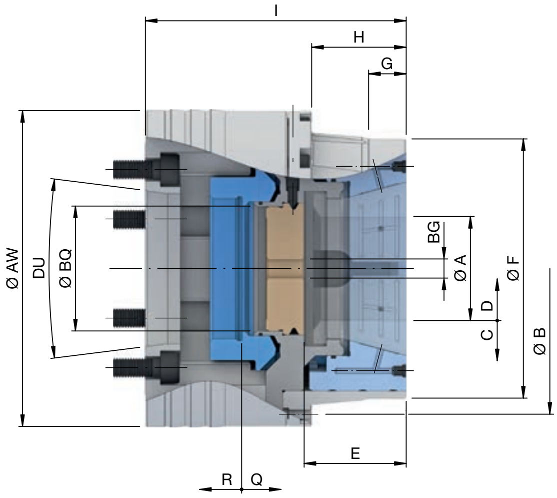
TOPlus mini deadlength size 52. Technical data



Size		52
Variant		**Deadlength**
Run-out ≤ [mm]		0,020
Max. radial clamping force [kN]		108
Max. axial compression force [kN]		40
RPM n max. [1/min.]		7000
Clamping range [mm]	A	3 – 52
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	45,8
Ø Capacity [mm]	BQ	53
End-stop thread size [M]	BG	10
Location front end-stop	F	Ø 119 f7
Centering length [mm]	G	15
Bolt hole circle end-stop	B	LK Ø 136 [3 x M6]
Length [mm]	H	44
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	A2-5		A2-6		A2-8
Total length [mm]	I	**122**	**147**	**122**	**147**	**120**
Outer Ø [mm]	AW	149		163		202
Weight [kg]		10,5	12,4	11,5	13,5	15,4
In stock		✔	✔	✔	✔	✔
Material no.		10000811	10000812	10000813	10000814	10000834

Spindle nose	DU	AP110		AP120		AP140
Total length [mm]	I	**100**	**115**	**105**	**115**	**107**
Outer Ø [mm]	AW			149		
Weight [kg]		8,9	10,2	9,3	10	9,1
In stock		✔	✔	✔	✔	✔
Material no.		10000831	10000833	10000815	10000816	10000817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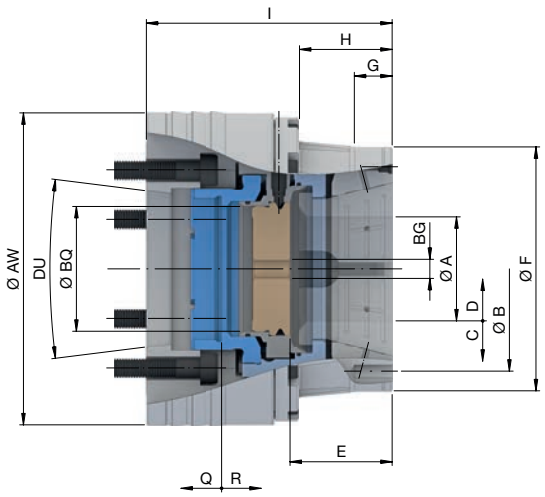
TOPlus mini pull-back size 65. Technical data



Size		65
Variant		**Pull-back**
Run-out ≤ [mm]		0,010
Max. radial clamping force [kN]		120
Max. axial drawtube force [pull / push] [kN]		45
RPM n max. [1/min.]		6000
Clamping range [mm]	A	3 – 65
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	54
Ø Capacity [mm]	BQ	66
End-stop thread size [M]	BG	12
Location front end-stop	F	Ø 129 f7
Centering length [mm]	G	20
Bolt hole circle end-stop	B	LK Ø 112 [3 x M8]
Length [mm]	H	49
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	A2-5			A2-6			A2-8	
Total length [mm]	I	**124**	**130**	**150**	**126**	**130**	**155**	**130**	**155**
Outer Ø [mm]	AW	165						204	
Weight [kg]		12,4	13	15,2	11,4	11,7	13,5	15,9	19
In stock		✔	✔	✔	✔	✔	✔	✔	✔
Material no.		10000787	10000740	10000741	10000742	10000743	10000744	10000745	10000746

Spindle nose	DU	AP120		AP140		AP170
Total length [mm]	I	**111**	**120**	**111**	**120**	**115**
Outer Ø [mm]	AW	165				180
Weight [kg]		11,3	12,3	10,9	11,7	12,3
In stock		✔	✔	✔	✔	✔
Material no.		10000749	10000750	10000747	10000748	10000751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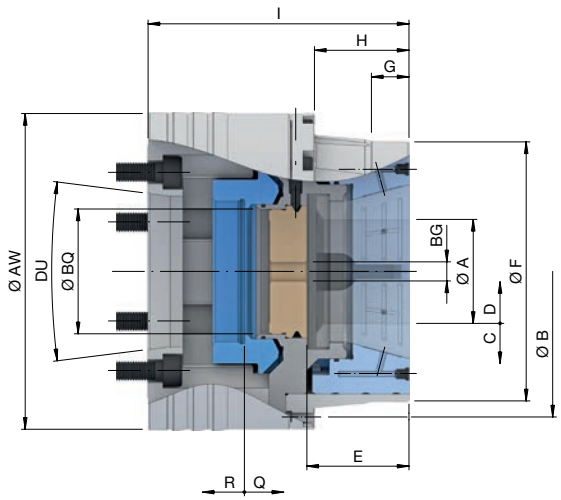
TOPlus mini deadlength size 65. Technical data



Size		65
Variant		**Deadlength**
Run-out ≤ [mm]		0,020
Max. radial clamping force [kN]		120
Max. axial compression force [kN]		45
RPM n max. [1/min.]		6000
Clamping range [mm]	A	3 – 65
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	54
Ø Capacity [mm]	BQ	66
End-stop thread size [M]	BG	12
Location front end-stop	F	Ø 137 f7
Centering length [mm]	G	20
Bolt hole circle end-stop	B	LK Ø 154 [3 x M6]
Length [mm]	H	50
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	A2-5		A2-6			A2-8	
Total length [mm]	l	**128**	**138**	**124**	**138**	**163**	**133**	**163**
Outer Ø [mm]	AW	167		165			202	
Weight [kg]		13,7	14,7	12,6	13,9	16,2	17,2	20,5
In stock		✔	✔	✔	✔	✔	✔	✔
Material no.		10000788	10000789	10000790	10000791	10000792	10000793	10000794

Spindle nose	DU	AP120	AP140	AP170	
Total length [mm]	l	**129**	**138**	**110**	**128**
Outer Ø [mm]	AW	167		180	
Weight [kg]		14	14,6	12,8	14,9
In stock		✔	✔	✔	✔
Material no.		10000840	10000795	10000836	10000796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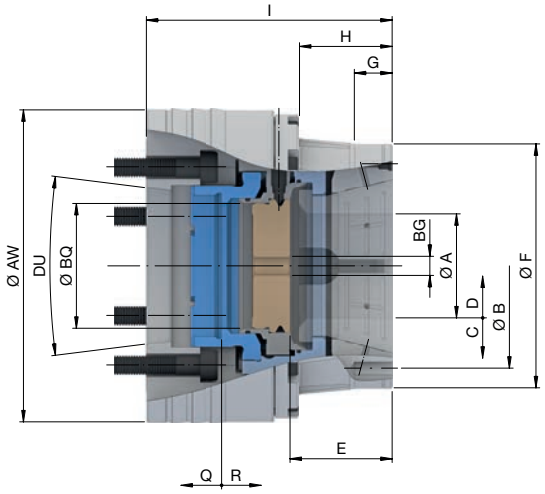
TOPlus mini pull-back size 80. Technical data



Size		80
Variant		**Pull-back**
Run-out ≤ [mm]		0,010
Max. radial clamping force [kN]		132
Max. axial drawtube force [pull / push] [kN]		50
RPM n max. [1/min.]		5500
Clamping range [mm]	A	4 – 80
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	54
Ø Capacity [mm]	BQ	82
End-stop thread size [M]	BG	12
Location front end-stop	F	Ø 150 f7
Centering length [mm]	G	20
Bolt hole circle end-stop	B	LK Ø 130 [3 x M8]
Length [mm]	H	49
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	A2-5	A2-6			A2-8		
Total length [mm]	I	**132**	**128**	**135**	**155**	**132**	**150**	**180**
Outer Ø [mm]	AW	176				204		
Weight [kg]		15,2	13,9	14,6	16,6	17	19,1	22,6
In stock		✔	✔	✔	✔	✔	✔	✔
Material no.		10017026	10017030	10017031	10017032	10017034	10017038	10017039

Spindle nose	DU	AP140	AP170	AP220
Total length [mm]	I	**132**	**115**	
Outer Ø [mm]	AW	176	180	230
Weight [kg]		15,3	13	18,7
In stock		✔	✔	✔
Material no.		10017040	10017041	10018166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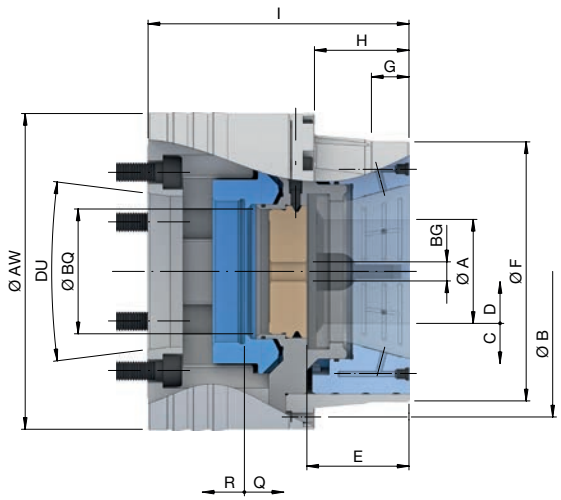
TOPlus mini deadlength size 80. Technical data



Size		80
Variant		**Deadlength**
Run-out ≤ [mm]		0,020
Max. radial clamping force [kN]		132
Max. axial compression force [kN]		50
RPM n max. [1/min.]		5500
Clamping range [mm]	A	4 – 80
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	55
Ø Capacity [mm]	BQ	82
End-stop thread size [M]	BG	12
Location front end-stop	F	Ø 160 f7
Centering length [mm]	G	25
Bolt hole circle end-stop	B	LK Ø 175 [9 x M6]
Length [mm]	H	51
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	A2-5	A2-6			A2-8		
Total length [mm]	I	**136**	**130**	**137**	**157**	**132**	**152**	**182**
Outer Ø [mm]	AW	194	193			205		
Weight [kg]		20	18,2	19,1	21,8	19,3	21,6	24,7
In stock		✔	✔	✔	✔	✔	✔	✔
Material no.		10017043	10017044	10017045	10017046	10017048	10017049	10017050

Spindle nose	DU	AP140	AP170
Total length [mm]	I	**134**	**115**
Outer Ø [mm]	AW	193	
Weight [kg]		20	16,2
In stock		✔	✔
Material no.		10017051	10017053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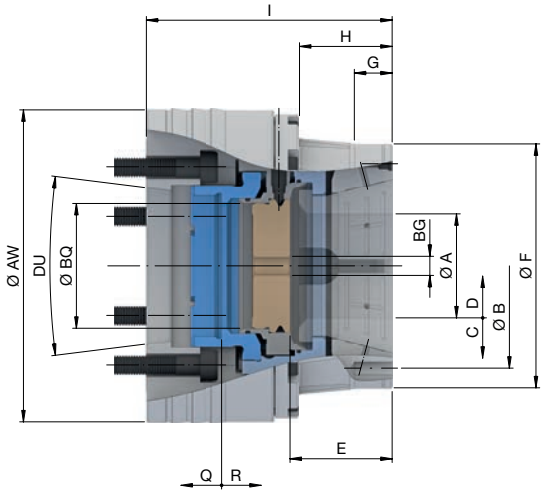
TOPlus mini pull-back size 100. Technical data



Size		100
Variant		**Pull-back**
Run-out ≤ [mm]		0,015
Max. radial clamping force [kN]		172
Max. axial drawtube force [pull / push] [kN]		65
RPM n max. [1/min.]		4650
Clamping range [mm]	A	15 – 100
Release stroke in Ø [mm]	C	1,6
Reserve stroke in Ø [mm]	D	1,5
Range / recommended workpiece tolerance [mm]		± 1,0
End-stop depth [mm]	E	72
Ø Capacity [mm]	BQ	102
End-stop thread size [M]	BG	12
Location front end-stop	F	Ø 183 f7
Centering length [mm]	G	20
Bolt hole circle end-stop	B	LK Ø 160 [3 x M8]
Length [mm]	H	64
Reserve stroke axial [mm]	Q	3
Release stroke axial [mm]	R	5

Spindle nose	DU	A2-5	A2-6		A2-8		A2-11	
Total length [mm]	I	**160**	**164**	**170**	**162**	**180**		**195**
Outer Ø [mm]	AW	221					281	
Weight [kg]		27,4	27,9	28,8	25,7	27,9	43,3	47,5
In stock		✔	✔	✔	✔	✔	✔	✔
Material no.		10000772	10000773	10000774	10000775	10000776	10000777	10000778

Spindle nose	DU	AP170	AP220
Total length [mm]	I	**164**	**150**
Outer Ø [mm]	AW	221	230
Weight [kg]		28,2	26,3
In stock		✔	✔
Material no.		10000779	10000780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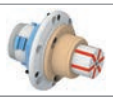
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Adaptations jaw clamping
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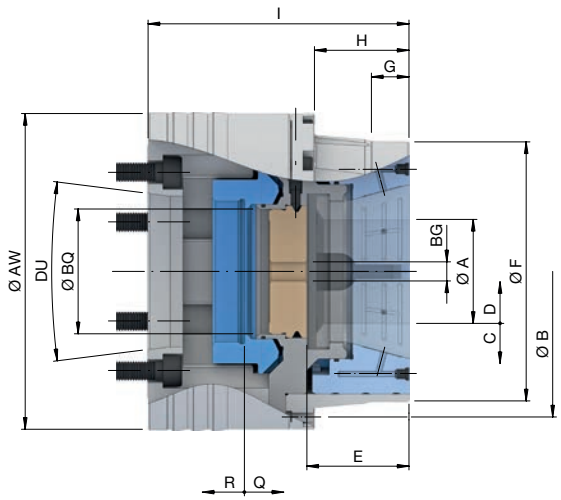
TOPlus mini deadlength size 100. Technical data



Size		100
Variant		**Deadlength**
Run-out ≤ [mm]		0,025
Max. radial clamping force [kN]		172
Max. axial compression force [kN]		65
RPM n max. [1/min.]		4650
Clamping range [mm]	A	15 – 100
Release stroke in Ø [mm]	C	1,6
Reserve stroke in Ø [mm]	D	1,5
Range / recommended workpiece tolerance [mm]		± 1,0
End-stop depth [mm]	E	74
Ø Capacity [mm]	BQ	102
End-stop thread size [M]	BG	12
Location front end-stop	F	Ø 191 f7
Centering length [mm]	G	30
Bolt hole circle end-stop	B	LK Ø 208 [3 x M6]
Length [mm]	H	64
Reserve stroke axial [mm]	Q	3
Release stroke axial [mm]	R	5

Spindle nose	DU	A2-5	A2-6		A2-8		A2-11	
Total length [mm]	I	171	175	182	169	192	185	200
Outer Ø [mm]	AW	221					276	
Weight [kg]		31,5	31,9	33	29,2	32,6	42,5	45,5
In stock		✔	✔	✔	✔	✔	✔	✔
Material no.		10000818	10000819	10000820	10000821	10000822	10000823	10000824

Spindle nose	DU	AP140	AP170	AP220
Total length [mm]	I	171	175	162
Outer Ø [mm]	AW	221		230
Weight [kg]		32,5	32,3	29,9
In stock		✔	✔	✔
Material no.		10000828	10000825	10000826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TOPlus mini chuck

TOPlus premium

Maximum precision in a mini format

TOPlus premium chuck

The TOPlus premium chuck is ideal for high-precision clamping of delicate and thin-walled parts, as well as solid and massive parts. In combination with premium clamping heads and when clamping against the end-stop, you benefit from incredible run-out accuracy of ≤ 5 µm.

That makes the standard TOPlus premium chuck a better and less expensive alternative to hydraulic and diaphragm clamping devices. In addition to high precision, the large opening stroke also facilitates automated loading of the machine – even if the robot is somewhat inaccurate. By the way, slight contact with the workpiece during loading has no negative effect on the TOPlus premium. Despite its high precision it remains »robust« and your process remains stable.

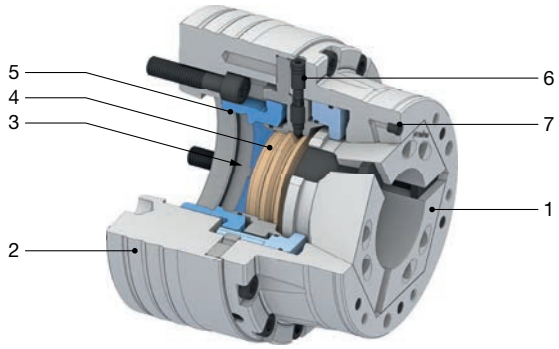
For machining in which »standard« accuracy is sufficient, you can simply use conventional standard clamping heads. As with the conventional TOPlus mini, the run-out accuracy when clamping against the workpiece end-stop is then 10 µm. Of course, all compatible HAINBUCH adaptations can also be used. Change-over from O.D. to I.D. clamping or jaw clamping in less than two minutes is therefore assured.

The most accurate of all HAINBUCH chucks!

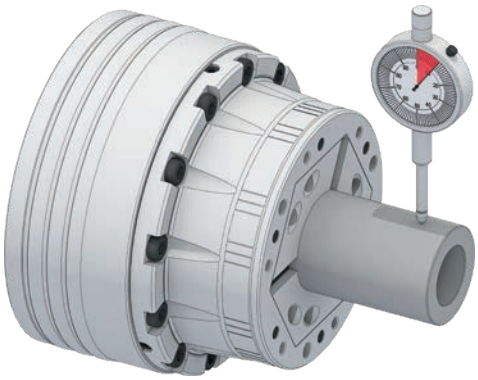
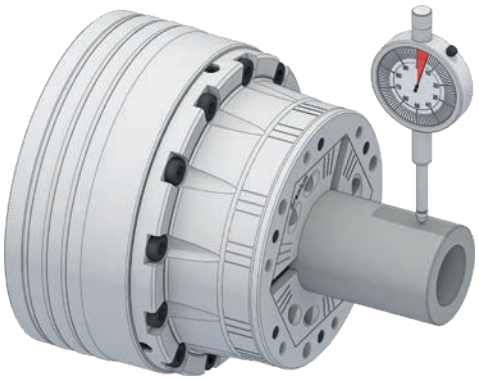
Key advantages

- Run-out accuracy ≤ 5 µm with premium clamping heads, otherwise ≤ 10 µm [requires clamping against the workpiece end-stop]
- For precise and powerful clamping
- Changeable to I.D., or jaw clamping [HAINBUCH SYSTEM]
- Less expensive than hydro-expansion and diaphragm clamping devices

TOPlus premium pull-back in detail

Designation	
1 Standard or premium clamping head with pull-back and hexagonal geometry for optimum chuck sealing and improved clamping force 2 Spindle flange 3 Chuck through-bore for bar work after disassembling the base end-stop 4 Fixed base end-stop for clamping with pull-back effect, central mounting thread for workpiece specific end-stop 5 Mounting thread for drawtube connection 6 Clamping screw for base end-stop, easy mounting through external actuation 7 Grease nipple, optimal holding power due to efficient lubrication	

Max. run-out accuracy of chuck

		
Variant	**premium chuck with standard clamping head**	**premium chuck with premium clamping head**
Run-out	≤ 10 µm	≤ 5 µm
Description	Measured on a ground test shaft according to HAINBUCH standard [Alignment set], clamped against a workpiece end-stop	
Clamping head	■ Standard sizes are in stock ■ Inexpensive clamping head ■ Round, other profile clamping also available [standard clamping range]	■ Custom clamping diameter ■ High-precision run-out ■ Round clamping possible [clamping range starting at 10 mm]

Order overview. TOPlus premium chuck

Size	Variant	Spindle nose	Total length [mm]	Material no.	In stock	Clamping elements and adaptations: Clamping head SE Page 422	MANDO Adapt T211 SE for TOPlus mini / premium Page 274	MANDO Adapt T212 SE for TOPlus mini / premium Page 280	Jaw module SE Page 316	Face driver / morse taper adapter SE for TOPlus mini / premium Page 324	Magnet module SE Page 332
26	Pull-back	A2-4	102	10017416	✔	✔					
		A2-5		10017418	✔						
			125	10017419	✔						
40	Pull-back	A2-4	125	10017420	✔	✔					
		A2-5	117	10017421	✔						
			125	10017422	✔						
			143	10017423	✔						
		A2-6	124	10017424	✔						
			142	10017425	✔						
		AP120	106	10017426	✔						
			118	10017427	✔						
		AP140	106	10017428	✔						
52	Pull-back	A2-5	122	10017430	✔	✔	✔	✔		✔	✔
			145	10017432	✔						
		A2-6	122	10017433	✔						
			145	10017434	✔						
		A2-8	120	10017435	✔						
			145	10017436	✔						
		AP110	120	10017437	✔						
		AP120	105	10017438	✔						
			115	10017439	✔						
		AP140	105	10017440	✔						
			115	10017441	✔						
65	Pull-back	A2-5	124	10017442	✔	✔	✔	✔	✔	✔	✔
			130	10017443	✔						
			150	10017444	✔						
		A2-6	126	10017445	✔						
			130	10017446	✔						
			155	10017447	✔						
		A2-8	130	10017448	✔						
			155	10017450	✔						
		AP120	111	10017451	✔						
			120	10017452	✔						
		AP140	111	10017453	✔						
			120	10017454	✔						
		AP170	115	10017455	✔						

Order overview. TOPlus premium chuck

						Clamping elements and adaptations					
											
Size	Variant	Spindle nose	Total length [mm]	Material no.	In stock	Clamping head SE Page 422	MANDO Adapt T211 SE for TOPlus mini / premium Page 274	MANDO Adapt T212 SE for TOPlus mini / premium Page 280	Jaw module SE Page 316	Face driver / morse taper adapter SE for TOPlus mini / premium Page 324	Magnet module SE Page 332
80	Pull-back	A2-5	132	10017456	✔	✔	✔	✔			
		A2-6	128	10017457	✔						
			135	10017458	✔						
			155	10017459	✔						
		A2-8	132	10017460	✔						
			150	10017461	✔						
			180	10017462	✔						
		AP140	132	10017463	✔						
		AP170	115	10017464	✔						
		AP220		10018433	✔						
100	Pull-back	A2-5	160	10017465	✔	✔	✔	✔	✔	✔	✔
		A2-6	164	10017466	✔						
			170	10017467	✔						
		A2-8	162	10017468	✔						
			180	10017469	✔						
		A2-11		10017470	✔						
			195	10017471	✔						
		AP170	164	10017472	✔						
		AP220	150	10017473	✔						

The specified accuracy is achieved with the compatible premium clamping head when clamping against a workpiece end-stop.

TOPlus premium and TOPlus mini chucks require adaptations [MANDO Adapt, face driver and morse taper adapter] of the mini series.

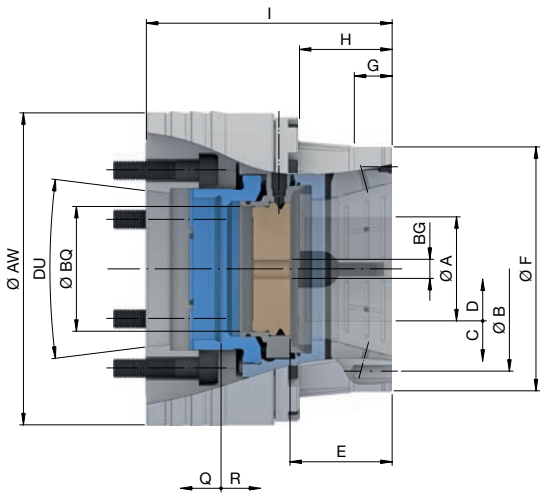
Machine spindle standard DIN ISO 702-1.

For more connection data please visit www.hainbuch.com

Scope of delivery

- Chuck
- Base end-stop
- Socket wrench insert 1/2"

TOPlus premium pull-back size 26. Technical data



Size		26
Variant		**Pull-back**
Run-out with standard clamping head ≤ [mm]		0,010
Run-out with premium clamping head ≤ [mm]		0,005
Max. radial clamping force [kN]		35
Max. axial drawtube force [pull / push] [kN]		16
RPM n max. [1/min.]		10000
Clamping range with standard clamping head [mm]	A	3 – 26
Clamping range with premium clamping head [mm]	A	10 – 26
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	0,6
Range / recommended workpiece tolerance [mm]		± 0,3
End-stop depth [mm]	E	33,8
Ø Capacity [mm]	BQ	37
End-stop thread size [M]	BG	8
Location front end-stop	F	Ø 67 f7
Centering length [mm]	G	15
Bolt hole circle end-stop	B	LK Ø 58 [3 x M6]
Length [mm]	H	43
Reserve stroke axial [mm]	Q	1
Release stroke axial [mm]	R	2

Spindle nose	DU	A2-4	A2-5	
Total length [mm]	I	**102**		**125**
Outer Ø [mm]	AW	114	128	
Weight [kg]		4,9	6,3	6,9
In stock		✔	✔	✔
Material no.		10017416	10017418	10017419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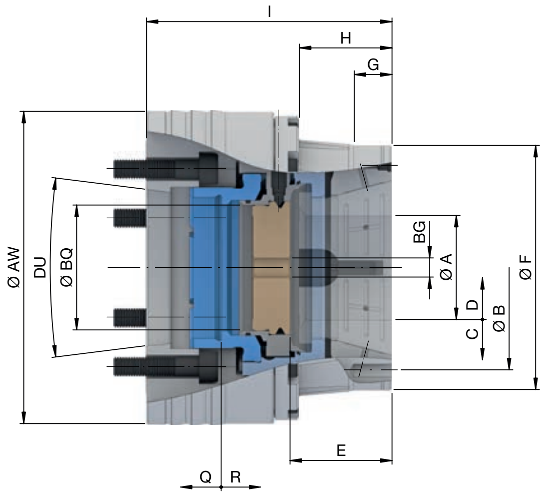
TOPlus premium pull-back size 40. Technical data



Size		**40**
Variant		**Pull-back**
Run-out with standard clamping head ≤ [mm]		0,010
Run-out with premium clamping head ≤ [mm]		0,005
Max. radial clamping force [kN]		103
Max. axial drawtube force [pull / push] [kN]		33
RPM n max. [1/min.]		7000
Clamping range with standard clamping head [mm]	A	3 – 40
Clamping range with premium clamping head [mm]	A	10 – 40
Release stroke in Ø [mm]	C	0,5
Reserve stroke in Ø [mm]	D	0,8
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	47
Ø Capacity [mm]	BQ	44
End-stop thread size [M]	BG	10
Location front end-stop	F	Ø 91 f7
Centering length [mm]	G	20
Bolt hole circle end-stop	B	LK Ø 105 [3 x M6]
Length [mm]	H	47
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2

Spindle nose	DU	**A2-4**	**A2-5**			**A2-6**	
Total length [mm]	I	**125**	**117**	**125**	**143**	**124**	**142**
Outer Ø [mm]	AW	132				163	
Weight [kg]		7,7	7		7,5	9,5	10
In stock		✔	✔	✔	✔	✔	✔
Material no.		10017420	10017421	10017422	10017423	10017424	10017425

Spindle nose	DU	**AP120**		**AP140**
Total length [mm]	I	**106**	**118**	**106**
Outer Ø [mm]	AW	132		150
Weight [kg]		6,5		8
In stock		✔	✔	✔
Material no.		10017426	10017427	10017428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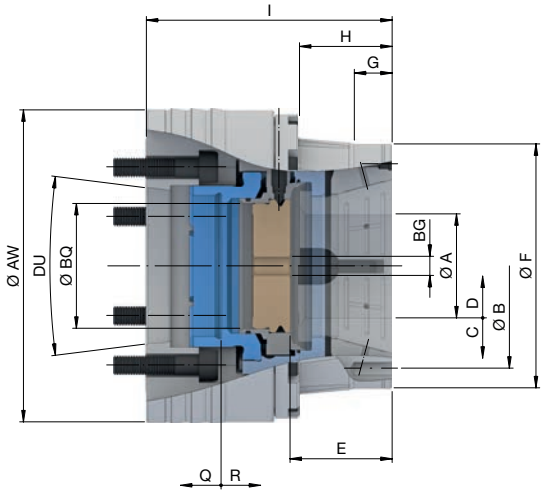
TOPlus premium pull-back size 52. Technical data



Size		52					
Variant		**Pull-back**					
Run-out with standard clamping head ≤ [mm]		0,010					
Run-out with premium clamping head ≤ [mm]		0,005					
Max. radial clamping force [kN]		108					
Max. axial drawtube force [pull / push] [kN]		40					
RPM n max. [1/min.]		7000					
Clamping range with standard clamping head [mm]	A	3 – 52					
Clamping range with premium clamping head [mm]	A	10 – 52					
Release stroke in Ø [mm]	C	0,6					
Reserve stroke in Ø [mm]	D	1					
Range / recommended workpiece tolerance [mm]		± 0,5					
End-stop depth [mm]	E	46					
Ø Capacity [mm]	BQ	53					
End-stop thread size [M]	BG	10					
Location front end-stop	F	Ø 119 f7					
Centering length [mm]	G	15					
Bolt hole circle end-stop	B	LK Ø 105 [3 x M8]					
Length [mm]	H	42					
Reserve stroke axial [mm]	Q	2					
Release stroke axial [mm]	R	2,5					
Spindle nose	DU	**A2-5**		**A2-6**		**A2-8**	
Total length [mm]	I	**122**	**145**	**122**	**145**	**120**	**145**
Outer Ø [mm]	AW	149		159		204	
Weight [kg]		10	10,5		11	15,7	16
In stock		✔	✔	✔	✔	✔	✔
Material no.		10017430	10017432	10017433	10017434	10017435	10017436
Spindle nose	DU	**AP110**	**AP120**			**AP140**	
Total length [mm]	I	**120**	**105**	**115**		**105**	**115**
Outer Ø [mm]	AW	149				150	
Weight [kg]		10,7	10			9,5	
In stock		✔	✔	✔		✔	✔
Material no.		10017437	10017438	10017439		10017440	10017441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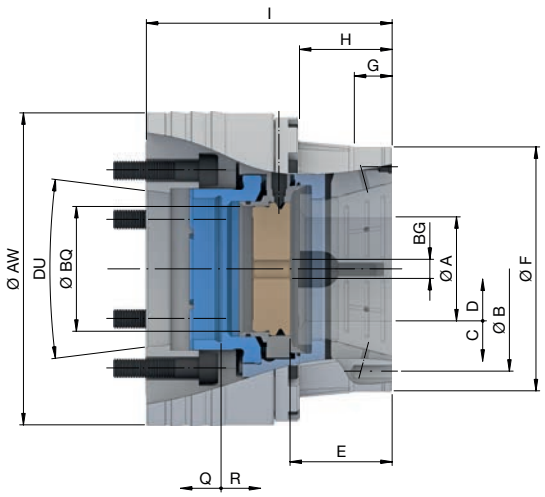
TOPlus premium pull-back size 65. Technical data



Size		65							
Variant		**Pull-back**							
Run-out with standard clamping head ≤ [mm]		0,010							
Run-out with premium clamping head ≤ [mm]		0,005							
Max. radial clamping force [kN]		120							
Max. axial drawtube force [pull / push] [kN]		45							
RPM n max. [1/min.]		6000							
Clamping range with standard clamping head [mm]	A	3 – 65							
Clamping range with premium clamping head [mm]	A	10 – 65							
Release stroke in Ø [mm]	C	0,6							
Reserve stroke in Ø [mm]	D	1							
Range / recommended workpiece tolerance [mm]		± 0,5							
End-stop depth [mm]	E	54							
Ø Capacity [mm]	BQ	66							
End-stop thread size [M]	BG	12							
Location front end-stop	F	Ø 129 f7							
Centering length [mm]	G	20							
Bolt hole circle end-stop	B	LK Ø 112 [3 x M8]							
Length [mm]	H	49							
Reserve stroke axial [mm]	Q	2							
Release stroke axial [mm]	R	2,5							
Spindle nose	DU	**A2-5**			**A2-6**			**A2-8**	
Total length [mm]	I	**124**	**130**	**150**	**126**	**130**	**155**	**130**	**155**
Outer Ø [mm]	AW	165						204	
Weight [kg]		11,5	13		11			16	
In stock		✔	✔	✔	✔	✔	✔	✔	✔
Material no.		10017442	10017443	10017444	10017445	10017446	10017447	10017448	10017450
Spindle nose	DU	**AP120**			**AP140**			**AP170**	
Total length [mm]	I	**111**		**120**	**111**		**120**	**115**	
Outer Ø [mm]	AW	165						180	
Weight [kg]		12,5			11,8			12,5	
In stock		✔		✔	✔		✔	✔	
Material no.		10017451		10017452	10017453		10017454	10017455	

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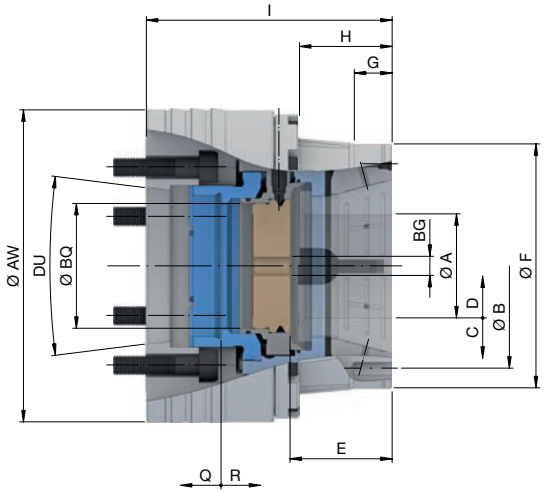
TOPlus premium pull-back size 80. Technical data



Size		80						
Variant		**Pull-back**						
Run-out with standard clamping head ≤ [mm]		0,010						
Run-out with premium clamping head ≤ [mm]		0,005						
Max. radial clamping force [kN]		132						
Max. axial drawtube force [pull / push] [kN]		50						
RPM n max. [1/min.]		5500						
Clamping range with standard clamping head [mm]	A	4 – 80						
Clamping range with premium clamping head [mm]	A	10 – 80						
Release stroke in Ø [mm]	C	0,6						
Reserve stroke in Ø [mm]	D	1						
Range / recommended workpiece tolerance [mm]		± 0,5						
End-stop depth [mm]	E	54						
Ø Capacity [mm]	BQ	82						
End-stop thread size [M]	BG	12						
Location front end-stop	F	Ø 150 f7						
Centering length [mm]	G	20						
Bolt hole circle end-stop	B	LK Ø 130 [3 x M8]						
Length [mm]	H	49						
Reserve stroke axial [mm]	Q	2						
Release stroke axial [mm]	R	2,5						
Spindle nose	DU	**A2-5**	**A2-6**			**A2-8**		
Total length [mm]	I	**132**	**128**	**135**	**155**	**132**	**150**	**180**
Outer Ø [mm]	AW	176				204		
Weight [kg]		15,2	14,8			19,3		
In stock		✔	✔	✔	✔	✔	✔	✔
Material no.		10017456	10017457	10017458	10017459	10017460	10017461	10017462

Spindle nose	DU	**AP140**	**AP170**	**AP220**
Total length [mm]	I	**132**	**115**	
Outer Ø [mm]	AW	176	180	230
Weight [kg]		15,4	13,2	18,9
In stock		✔	✔	✔
Material no.		10017463	10017464	10018433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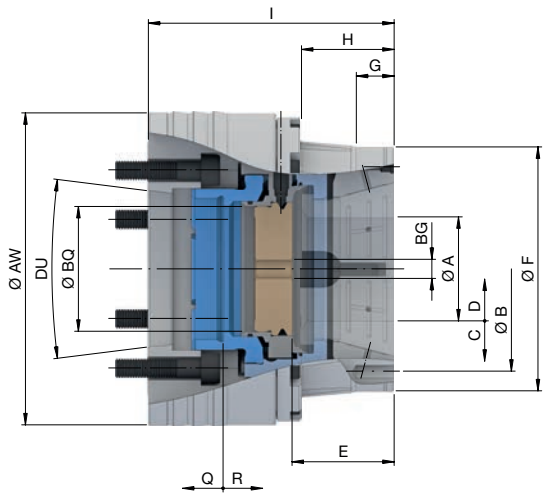
TOPlus premium pull-back size 100. Technical data



Size		**100**						
Variant		**Pull-back**						
Run-out with standard clamping head ≤ [mm]		0,010						
Run-out with premium clamping head ≤ [mm]		0,005						
Max. radial clamping force [kN]		172						
Max. axial drawtube force [pull / push] [kN]		65						
RPM n max. [1/min.]		4650						
Clamping range with standard clamping head [mm]	A	15 – 100						
Clamping range with premium clamping head [mm]	A	15 – 100						
Release stroke in Ø [mm]	C	1,6						
Reserve stroke in Ø [mm]	D	1,5						
Range / recommended workpiece tolerance [mm]		± 1,0						
End-stop depth [mm]	E	72						
Ø Capacity [mm]	BQ	102						
End-stop thread size [M]	BG	12						
Location front end-stop	F	Ø 183 f7						
Centering length [mm]	G	20						
Bolt hole circle end-stop	B	LK Ø 160 [3 x M8]						
Length [mm]	H	64						
Reserve stroke axial [mm]	Q	3						
Release stroke axial [mm]	R	5						
Spindle nose	DU	**A2-5**	**A2-6**		**A2-8**		**A2-11**	
Total length [mm]	I	**160**	**164**	**170**	**162**	**180**		**195**
Outer Ø [mm]	AW	221					281	
Weight [kg]		27	31		31,5		43	
In stock		✔	✔	✔	✔	✔	✔	✔
Material no.		10017465	10017466	10017467	10017468	10017469	10017470	10017471

Spindle nose	DU	**AP170**	**AP220**
Total length [mm]	I	**164**	**150**
Outer Ø [mm]	AW	221	230
Weight [kg]		28	26
In stock		✔	✔
Material no.		10017472	10017473

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TOPlus premium chuck

TOPlus

Six to win

Up to 25 % more clamping force and higher output – with the same draw force of the clamping cylinder that is used to actuate our SPANNTOP chucks. The pyramid arrangement of glide surfaces is what makes it possible. The clamping head rests with full-surface contact in the TOPlus chuck body – even with large workpiece tolerances. In addition this geometry ensures that TOPlus is significantly less sensitive to contamination than previous chuck/clamping head solutions, and it offers a concentric precision of approx. 0.015 mm [for chuck size 65]! Thus TOPlus is even better suited for raw material, cast and forged parts, as well as fine-particle non-ferrous metals such as brass. Therefore, the optimized values make the chuck an ideal partner for modern manufacturing strategies and state-of-the-art machine tools.

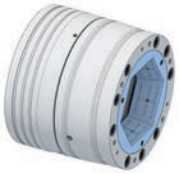
TOPlus – simply revolutionary!

Key advantages

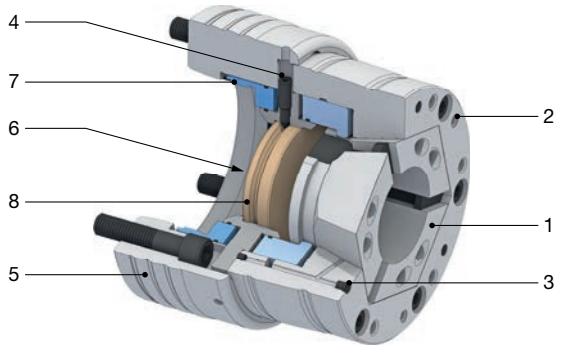
- 25 % higher holding power than SPANNTOP
- Unequalled rigidity due to full-surface contact of the clamping segments
- Superior resistance to contamination because of the clamping head geometry
- Absorbs vibration
- Optimal lubrication thanks to lubricating grooves in the clamping head reception
- Minimal inertia loss compared to 3-jaw chucks

TOPlus combi pull-back chuck in use

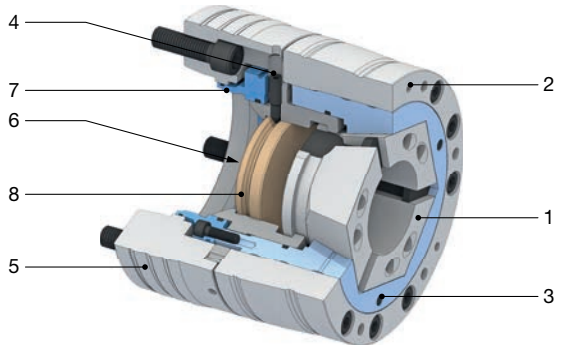
TOPlus chuck types

	TOPlus combi pull-back	TOPlus combi deadlength	TOPlus modular
			
Description	Workpiece clamping with pull-back effect. Chuck with dismountable end-stop plate. Without end-stop plate ideal for machining pipes and bars.	Workpiece clamping without pull-back effect. Chuck with dismountable end-stop plate. It is also frequently used on the sub spindle.	Through-bore chuck only – ideal for machining pipes and bars.
Advantages	■ Workpiece stabilization through axial draw force applied against the workpiece end-stop ■ Prepared for inside and front end-stop ■ Converts to a fully functional »bar chuck« when the end-stop plate is removed	■ Workpiece clamping without axial movement of the clamping head ■ Clamps workpieces with a short collar or shoulder ■ Suitable for pick-off without pull-back effect ■ Prepared for inside and front end-stop ■ Converts to a fully functional »bar chuck« when the end-stop plate is removed	■ Fully-functional bar chuck ■ Due to pull-back effect significantly more rigid clamping is achieved than by conventional collets ■ Higher RPM and metal removal rates for bar work
Clamping elements	 Clamping head SE	 Clamping head SE	 Clamping head SE
Adaptations	 MANDO Adapt T211 SE [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE [Adaptation for jaw clamping]  Face driver SE / Morse taper adapter SE [Adaptation for clamping between centers]  Magnet module SE [Adaptation for magnetic clamping]		 MANDO Adapt T211 SE [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE [Adaptation for jaw clamping]  Face driver SE / Morse taper adapter SE [Adaptation for clamping between centers]  Magnet module SE [Adaptation for magnetic clamping]

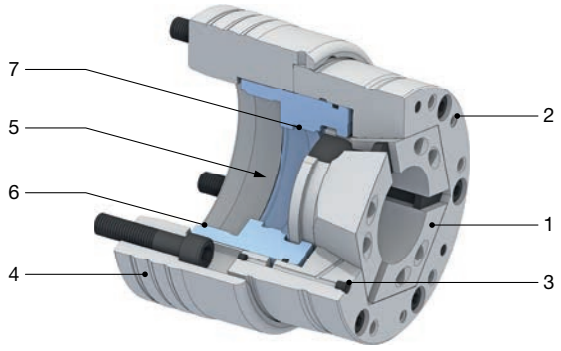
TOPlus combi pull-back in detail

Designation	
1 Vulcanized clamping head with pull-back and hexagonal geometry for optimum chuck sealing and improved clamping force 2 Mounting threads for front end-stop 3 Grease nipple, optimal holding power due to efficient lubrication 4 Clamping screw for base end-stop, easy mounting through external actuation 5 Spindle flange 6 Full chuck through-bore for bar work after disassembling the base end-stop 7 Mounting thread for drawtube connection 8 Fixed base end-stop for clamping with pull-back effect, central mounting thread for workpiece specific end-stop	

TOPlus combi deadlength in detail

Designation	
1 Vulcanized standing clamping head with hexagonal geometry for improved chuck sealant and higher clamping force 2 Mounting threads for front end-stop 3 Grease nipple, optimal holding power due to efficient lubrication 4 Clamping screw for base end-stop, easy mounting through external actuation 5 Spindle flange 6 Full chuck through-bore for bar work after disassembling the base end-stop 7 Mounting thread for drawtube connection 8 Fixed base end-stop with central mounting thread for workpiece specific end-stop	

TOPlus modular in detail

Designation	
1 Vulcanized clamping head with pull-back and hexagonal geometry for optimum chuck sealing and improved clamping force 2 Mounting threads for front end-stop 3 Grease nipple, optimal holding power due to efficient lubrication 4 Spindle flange 5 Full chuck passage for bar work 6 Mounting thread for drawtube connection 7 Mounting thread for guide rings, introduction, spring ejectors, etc.	

Order overview. TOPlus chuck

Size	Variant	Spindle nose	Material no.	In stock	Clamping elements and adaptations					
										
					Clamping head SE Page 422	MANDO Adapt T211 SE Page 274	MANDO Adapt T212 SE Page 280	Jaw module SE Page 316	Face driver / morse taper adapter SE Page 324	Magnet module SE Page 332
52	Combi pull-back	A2-5	10001926	-	✔	✔	✔		✔	✔
		A2-6	10001927	-						
		AP120	10001928	-						
		AP140	10001929	-						
	Combi deadlength	A2-5	10001945	-	✔					
		A2-6	10001946	-						
		AP120	10001947	-						
		AP140	10001948	-						
	Modular	A2-5	10001913	-	✔	✔	✔		✔	✔
		A2-6	10001914	-						
		AP120	10001915	-						
		AP140	10001916	-						
65	Combi pull-back	A2-5	10001920	-	✔	✔	✔	✔	✔	✔
		A2-6	10001921	-						
		A2-8	10001922	-						
		AP120	10001923	-						
		AP140	10001924	-						
		AP170	10001925	-						
	Combi deadlength	A2-5	10001936	-	✔					
		A2-6	10001937	-						
		A2-8	10001938	-						
		AP140	10001939	-						
		AP170	10001940	-						
	Modular	A2-5	10001907	-	✔	✔	✔	✔	✔	✔
		A2-6	10001908	-						
		A2-8	10001909	-						
		AP120	10001910	-						
		AP140	10001911	-						
		AP170	10001912	-						
100	Combi pull-back	A2-6	10001930	-	✔	✔	✔	✔	✔	✔
		A2-8	10001931	-						
		A2-11	10001935	-						
		AP170	10001932	-						
		AP220	10001933	-						
	Combi deadlength	A2-6	10001941	-	✔					
		A2-8	10001942	-						
		AP170	10001943	-						
		AP220	10001944	-						
	Modular	A2-8	10001917	-	✔	✔	✔	✔	✔	✔
		AP170	10001918	-						
		AP220	10001919	-						

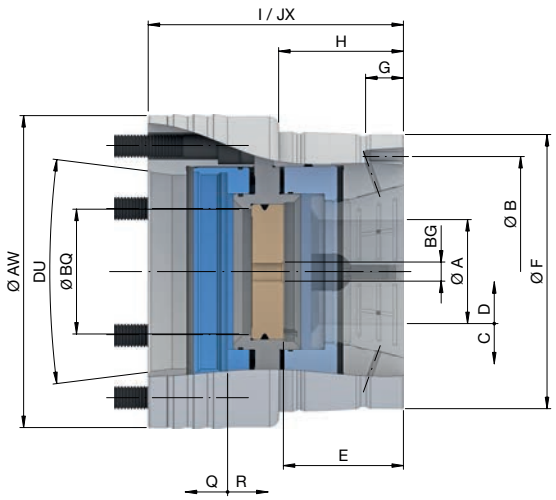
Detailed technical data follows.

For more connection data please visit www.hainbuch.com

Scope of delivery

- Chuck
- Base end-stop [depending on the variant]
- Chip protection cover

TOPlus combi pull-back size 52. Technical data



Size		52			
Variant		Combi pull-back			
Spindle nose	DU	A2-5	A2-6	AP120	AP140
Run-out ≤ [mm]		0,010			
Max. radial clamping force [kN]		108			
Max. axial drawtube force [pull / push] [kN]		40			
RPM n max. [1/min.]		7000			
Clamping range [mm]	A	3 – 52			
Release stroke in Ø [mm]	C	0,6			
Reserve stroke in Ø [mm]	D	1			
Range / recommended workpiece tolerance [mm]		± 0,5			
End-stop depth [mm]	E	56,5			
Ø Capacity [mm]	BQ	53			
End-stop thread size [M]	BG	10			
Location front end-stop	F	Ø 125 f7			
Centering length [mm]	G	17			
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]			
Length [mm]	H	59			
Total length [mm]	I	122		115	
Total length with guard plate [mm]	JX	125		118	
Reserve stroke axial [mm]	Q	2			
Release stroke axial [mm]	R	2,5			
Outer Ø [mm]	AW	144	165	144	150
Weight [kg]		10	12	9	10
In stock		-	-	-	-
Material no.		10001926	10001927	10001928	10001929

Machine spindle standard DIN 55026.
Total length can be extended via flange.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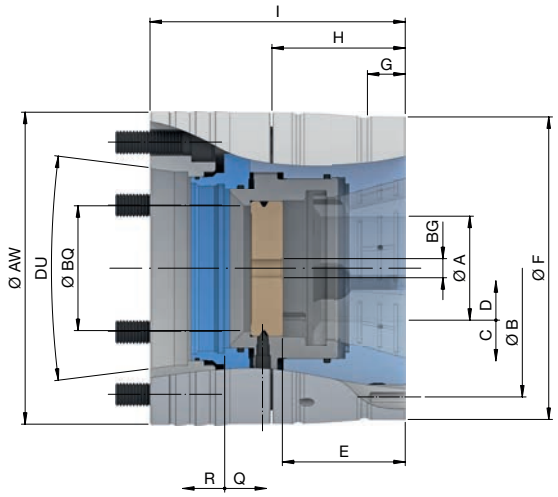
TOPlus combi deadlength size 52. Technical data



Size		52			
Variant		**Combi deadlength**			
Spindle nose	DU	A2-5	A2-6	AP120	AP140
Run-out ≤ [mm]		0,020			
Max. radial clamping force [kN]		108			
Max. axial compression force [kN]		40			
RPM n max. [1/min.]		7000			
Clamping range [mm]	A	3 – 52			
Release stroke in Ø [mm]	C	0,6			
Reserve stroke in Ø [mm]	D	1			
Range / recommended workpiece tolerance [mm]		± 0,5			
End-stop depth [mm]	E	54,8			
Ø Capacity [mm]	BQ	53			
End-stop thread size [M]	BG	10			
Location front end-stop	F	Ø 140 f7			
Centering length [mm]	G	17			
Bolt hole circle end-stop	B	LK Ø 122 [3 x M6]			
Length [mm]	H	61,5			
Total length [mm]	I	120		110	
Reserve stroke axial [mm]	Q	2			
Release stroke axial [mm]	R	2,5			
Outer Ø [mm]	AW	145	162	145	150
Weight [kg]		11	12	10	11
In stock		-	-	-	-
Material no.		10001945	10001946	10001947	10001948

Machine spindle standard DIN 55026.
Total length can be extended via flange.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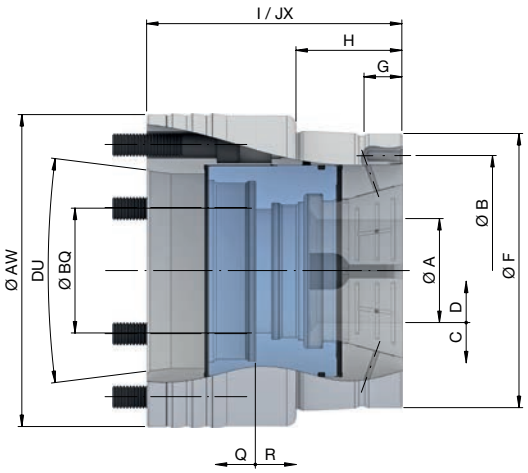
TOPlus modular size 52. Technical data



Size		52			
Variant		**Modular**			
Spindle nose	DU	A2-5	A2-6	AP120	AP140
Run-out ≤ [mm]		0,010			
Max. radial clamping force [kN]		108			
Max. axial drawtube force [pull / push] [kN]		40			
RPM n max. [1/min.]		7000			
Clamping range [mm]	A	3 – 52			
Release stroke in Ø [mm]	C	0,6			
Reserve stroke in Ø [mm]	D	1			
Range / recommended workpiece tolerance [mm]		± 0,5			
Ø Capacity [mm]	BQ	53			
Location front end-stop	F	Ø 125 f7			
Centering length [mm]	G	17			
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]			
Length [mm]	H	49			
Total length [mm]	l	112		105	
Total length with guard plate [mm]	JX	115		108	
Reserve stroke axial [mm]	Q	2			
Release stroke axial [mm]	R	2,5			
Outer Ø [mm]	AW	144	165	144	150
Weight [kg]		9	11	9	
In stock		-	-	-	-
Material no.		10001913	10001914	10001915	10001916

Machine spindle standard DIN 55026.
Total length can be extended via flange.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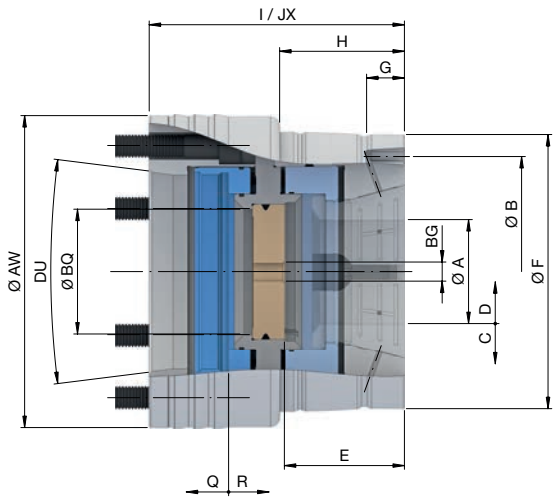
TOPlus combi pull-back size 65. Technical data



Size		65					
Variant		Combi pull-back					
Spindle nose	DU	A2-5	A2-6	A2-8	AP120	AP140	AP170
Run-out ≤ [mm]		0,010					
Max. radial clamping force [kN]		120					
Max. axial drawtube force [pull / push] [kN]		45					
RPM n max. [1/min.]		6000					
Clamping range [mm]	A	3 – 65					
Release stroke in Ø [mm]	C	0,6					
Reserve stroke in Ø [mm]	D	1					
Range / recommended workpiece tolerance [mm]		± 0,5					
End-stop depth [mm]	E	63,5					
Ø Capacity [mm]	BQ	66					
End-stop thread size [M]	BG	12					
Location front end-stop	F	Ø 145 f7					
Centering length [mm]	G	20					
Bolt hole circle end-stop	B	LK Ø 126 [3 x M6]					
Length [mm]	H	66					
Total length [mm]	l	131	130	131	120		115
Total length with guard plate [mm]	JX	134	133	134	123		118
Reserve stroke axial [mm]	Q	2					
Release stroke axial [mm]	R	2,5					
Outer Ø [mm]	AW	160	165	210	160		184
Weight [kg]		14	12	18	12	13	12
In stock		-	-	-	-	-	-
Material no.		10001920	10001921	10001922	10001923	10001924	10001925

Machine spindle standard DIN 55026.
Total length can be extended via flange.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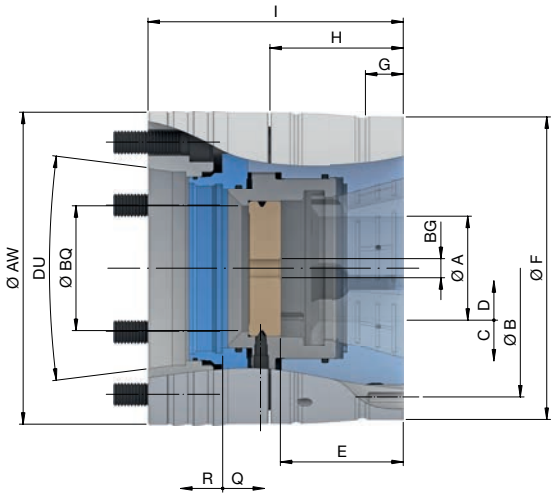
TOPlus combi deadlength size 65. Technical data



Size		65				
Variant		Combi deadlength				
Spindle nose	DU	A2-5	A2-6	A2-8	AP140	AP170
Run-out ≤ [mm]		0,020				
Max. radial clamping force [kN]		120				
Max. axial compression force [kN]		45				
RPM n max. [1/min.]		6000				
Clamping range [mm]	A	3 – 65				
Release stroke in Ø [mm]	C	0,6				
Reserve stroke in Ø [mm]	D	1				
Range / recommended workpiece tolerance [mm]		± 0,5				
End-stop depth [mm]	E	65				
Ø Capacity [mm]	BQ	66				
End-stop thread size [M]	BG	12				
Location front end-stop	F	Ø 160 f7				
Centering length [mm]	G	17				
Bolt hole circle end-stop	B	LK Ø 141 [3 x M6]				
Length [mm]	H	71,5				
Total length [mm]	I	135				125
Reserve stroke axial [mm]	Q	2				
Release stroke axial [mm]	R	2,5				
Outer Ø [mm]	AW	165		210	165	180
Weight [kg]		16		21	16	
In stock		-	-	-	-	-
Material no.		10001936	10001937	10001938	10001939	10001940

Machine spindle standard DIN 55026.
Total length can be extended via flange.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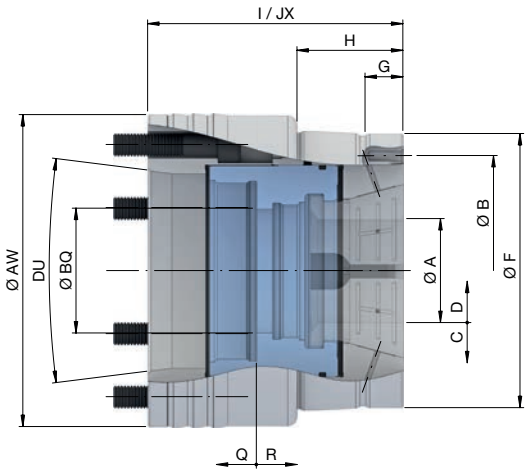
TOPlus modular size 65. Technical data



Size		65					
Variant		Modular					
Spindle nose	DU	A2-5	A2-6	A2-8	AP120	AP140	AP170
Run-out ≤ [mm]		0,010					
Max. radial clamping force [kN]		120					
Max. axial drawtube force [pull / push] [kN]		45					
RPM n max. [1/min.]		6000					
Clamping range [mm]	A	3 – 65					
Release stroke in Ø [mm]	C	0,6					
Reserve stroke in Ø [mm]	D	1					
Range / recommended workpiece tolerance [mm]		± 0,5					
Ø Capacity [mm]	BQ	66					
Location front end-stop	F	Ø 145 f7					
Centering length [mm]	G	20					
Bolt hole circle end-stop	B	LK Ø 126 [3 x M6]					
Length [mm]	H	56					
Total length [mm]	l	121	120	121	110		105
Total length with guard plate [mm]	JX	124	123	124	113		108
Reserve stroke axial [mm]	Q	2					
Release stroke axial [mm]	R	2,5					
Outer Ø [mm]	AW	160	165	210	160		184
Weight [kg]		12		17	11		12
In stock		-	-	-	-	-	-
Material no.		10001907	10001908	10001909	10001910	10001911	10001912

Machine spindle standard DIN 55026.
Total length can be extended via flange.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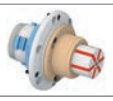
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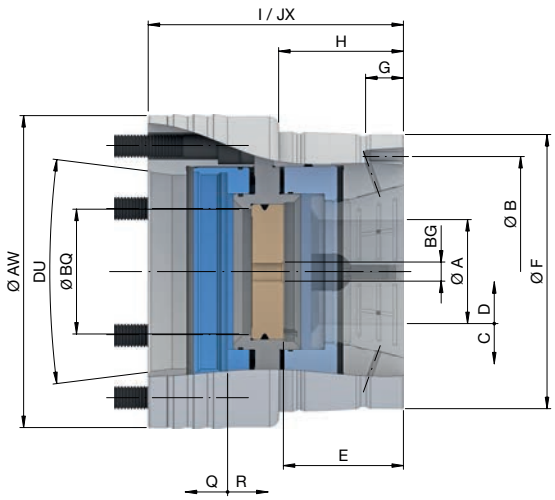
TOPlus combi pull-back size 100. Technical data



Size		100				
Variant		Combi pull-back				
Spindle nose	DU	A2-6	A2-8	A2-11	AP170	AP220
Run-out ≤ [mm]		0,015				
Max. radial clamping force [kN]		172				
Max. axial drawtube force [pull / push] [kN]		65				
RPM n max. [1/min.]		5000				
Clamping range [mm]	A	15 – 100				
Release stroke in Ø [mm]	C	1,6		2	1,6	
Reserve stroke in Ø [mm]	D	1,5				
Range / recommended workpiece tolerance [mm]		± 1,0				
End-stop depth [mm]	E	73				
Ø Capacity [mm]	BQ	101				
End-stop thread size [M]	BG	12				
Location front end-stop	F	Ø 215 f7				
Centering length [mm]	G	23				
Bolt hole circle end-stop	B	LK Ø 180 [3 x M8]				
Length [mm]	H	78,5				
Total length [mm]	I	155	159	165	159	
Total length with guard plate [mm]	JX	159	163	169	163	
Reserve stroke axial [mm]	Q	3				
Release stroke axial [mm]	R	5				
Outer Ø [mm]	AW	235		280	235	240
Weight [kg]		33	32	42	32	35
In stock		-	-	-	-	-
Material no.		10001930	10001931	10001935	10001932	10001933

Machine spindle standard DIN 55026.
Total length can be extended via flange.

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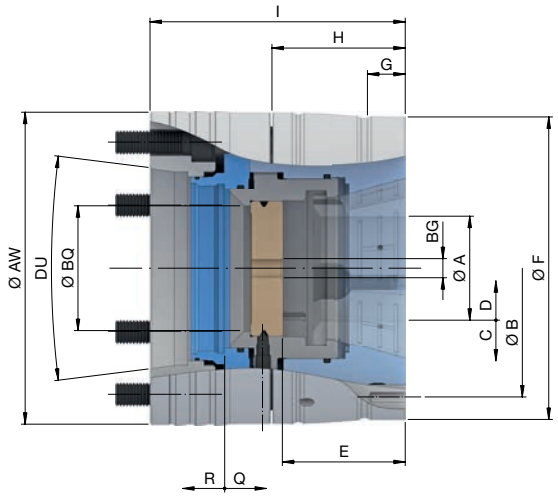
TOPlus combi deadlength size 100. Technical data



Size		100			
Variant		**Combi deadlength**			
Spindle nose	DU	A2-6	A2-8	AP170	AP220
Run-out ≤ [mm]		0,025			
Max. radial clamping force [kN]		172			
Max. axial compression force [kN]		65			
RPM n max. [1/min.]		5000			
Clamping range [mm]	A	15 – 100			
Release stroke in Ø [mm]	C	1,6			
Reserve stroke in Ø [mm]	D	1,5			
Range / recommended workpiece tolerance [mm]		± 1,0			
End-stop depth [mm]	E	85,5			
Ø Capacity [mm]	BQ	84	101		
End-stop thread size [M]	BG	12			
Location front end-stop	F	Ø 215 f7			
Centering length [mm]	G	23			
Bolt hole circle end-stop	B	LK Ø 192 [3 x M8]			
Length [mm]	H	94			
Total length [mm]	I	175		180	170
Reserve stroke axial [mm]	Q	3			
Release stroke axial [mm]	R	5			
Outer Ø [mm]	AW	220			240
Weight [kg]		36	34	37	38
In stock		-	-	-	-
Material no.		10001941	10001942	10001943	10001944

Machine spindle standard DIN 55026.
Total length can be extended via flange.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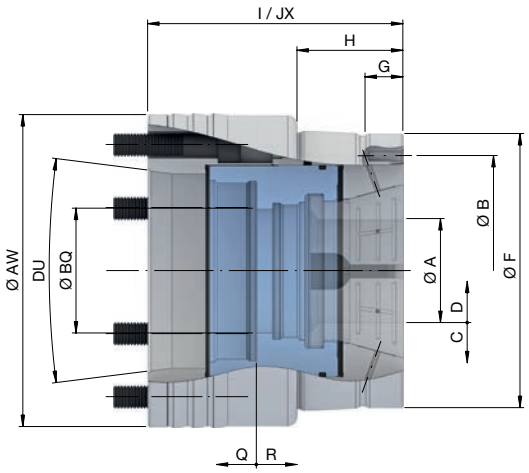
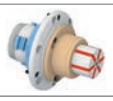
TOPlus modular size 100. Technical data



Size		100		
Variant		**Modular**		
Spindle nose	DU	A2-8	AP170	AP220
Run-out ≤ [mm]		0,015		
Max. radial clamping force [kN]		172		
Max. axial drawtube force [pull / push] [kN]		65		
RPM n max. [1/min.]		5000		
Clamping range [mm]	A	15 – 100		
Release stroke in Ø [mm]	C	2		
Reserve stroke in Ø [mm]	D	1,5		
Range / recommended workpiece tolerance [mm]		± 1,0		
Ø Capacity [mm]	BQ	104,5		
Location front end-stop	F	Ø 215 f7		
Centering length [mm]	G	23		
Bolt hole circle end-stop	B	LK Ø 180 [3 x M8]		
Length [mm]	H	68,5		
Total length [mm]	I	149		
Total length with guard plate [mm]	JX	153		
Reserve stroke axial [mm]	Q	3		
Release stroke axial [mm]	R	5		
Outer Ø [mm]	AW	235		240
Weight [kg]		28	31	30
In stock		-	-	-
Material no.		10001917	10001918	10001919

Machine spindle standard DIN 55026.
Total length can be extended via flange.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SPANNTOP mini

HAINBUCH SYSTEM

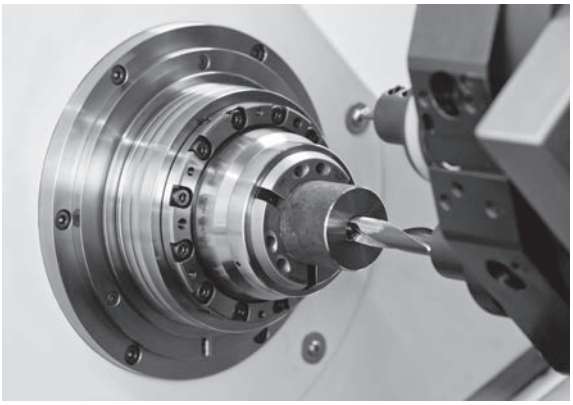
The »mini« series really shines with a mass reduced by as much as 30 %, and a chuck diameter that is reduced by 1/3. This means reduced energy consumption and better tool accessibility. Naturally, adaptation devices may also be used with the SPANNTOP mini. An additional ring enables use of the adaptation devices that are also used with the SPANNTOP nova.

Thanks to the reduced interference contour, it is easier to choose the tool that you need. Now it can also be shorter and more stable – on the main and sub spindles. Particularly in the case of limited installation space and in series operation, SPANNTOP mini is ideal: Lower energy consumption, dynamic spindle acceleration, and shorter cycle times reduce the costs per workpiece.

Minimalism that pays off!

Key advantages

- Adaptation devices possible [HAINBUCH SYSTEM]
- Significantly reduced interference contour
- Improved tool accessibility
- Ideal for limited installation space
- Lower mass
- Minimal inertia loss compared to 3-jaw chucks



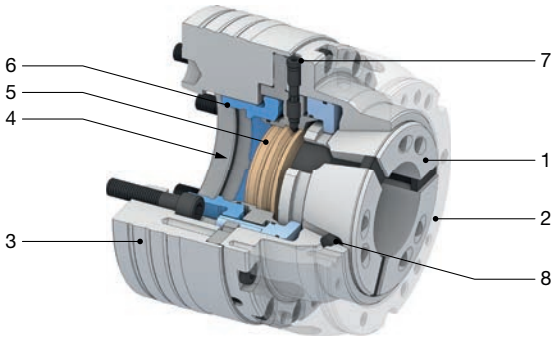
SPANNTOP mini pull-back in use

SPANNTOP mini chuck types

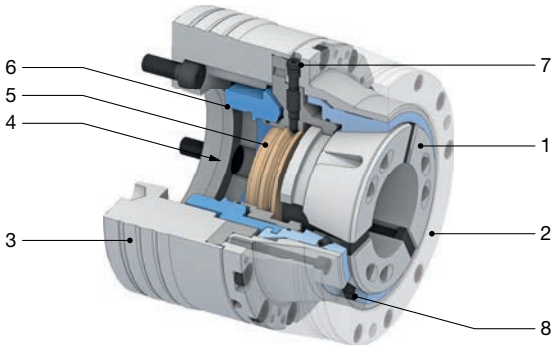
	SPANNTOP mini pull-back	SPANNTOP mini deadlength
		
Description	Workpiece clamping with pull-back effect. Chuck with dismountable end-stop plate.	Workpiece clamping without pull-back effect. Chuck with dismountable end-stop plate.
Advantages	■ Workpiece stabilization through axial draw force applied against the workpiece end-stop ■ Prepared for inside and front end-stop ■ Converts to a fully functional »bar chuck« when the end-stop plate is removed	■ Workpiece clamping without axial movement of the clamping head ■ Clamps workpieces with a short collar or shoulder ■ Suitable for pick-off without pull-back effect ■ Prepared for inside and front end-stop ■ Converts to a fully functional »bar chuck« when the end-stop plate is removed
Clamping elements	 Clamping head RD	 Clamping head RD
Adaptations	 MANDO Adapt T211 RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module RD [Adaptation for jaw clamping]  Face driver RD / Morse taper adapter RD [Adaptation for clamping between centers]  Magnet module RD [Adaptation for magnetic clamping]	 MANDO Adapt T812 RD [Mandrel-in-clamping-device, without draw bolt]

An adaptation ring, which is available as an option, is required for use of clamping adaptation devices.

SPANNTOP mini pull-back in detail

Designation	
1 Vulcanized clamping head with hardened steel segments and pull-back 2 Adaptation ring [required for the adaptation elements] 3 Spindle flange 4 Chuck through-bore for bar work after disassembling the base end-stop 5 Fixed base end-stop with central mounting thread for workpiece specific end-stop 6 Mounting thread for drawtube connection 7 Clamping screw for base end-stop, easy mounting through external actuation 8 Torsional safety lock of the clamping head	

SPANNTOP mini deadlength in detail

Designation	
1 Vulcanized standing clamping head with hardened steel segments 2 Adaptation ring [required for the adaptation elements] 3 Spindle flange 4 Chuck through-bore for bar work after disassembling the base end-stop 5 Fixed base end-stop with central mounting thread for workpiece specific end-stop 6 Mounting thread for drawtube connection 7 Clamping screw for base end-stop, easy mounting through external actuation 8 Torsional safety lock of the clamping head	

Order overview. SPANNTOP mini chuck

						Clamping elements and adaptations						
												
Size	Variant	Spindle nose	Total length [mm]	Material no.	In stock	Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	MANDO Adapt T812 RD Page 308	Jaw module RD Page 316	Face driver / morse taper adapter RD Page 324	Magnet module RD Page 332
32	Pull-back	A2-4	117	10000850	✔	✔						
		A2-5		10000851	✔							
			140	10000852	✔							
		A2-6	117	10000897	✔							
	Deadlength	A2-4	112	10000910	✔	✔						
			122	10000911	✔							
		A2-5	114	10000912	✔							
			122	10000913	✔							
			142	10000914	✔							
		A2-6	115	10000967	✔							
		AP140	101	10000968	✔							
42	Pull-back	A2-4	122	10000853	✔	✔	✔	✔			✔	
		A2-5	114	10000854	✔							
			122	10000855	✔							
			140	10000856	✔							
		A2-6	122	10000857	✔							
			140	10000858	✔							
		AP120	102	10000859	✔							
			115	10000860	✔							
		AP140	102	10000861	✔							
			115	10000862	✔							
		AP170	102	10000901	✔							
	Deadlength	A2-4	125	10000951	✔	✔			✔			
		A2-5	118	10000915	✔							
			125	10000916	✔							
			142	10000917	✔							
		A2-6	124	10000918	✔							
			142	10000919	✔							
		AP110	105	10000952	✔							
		AP120		10000966	✔							
		AP140		10000920	✔							
			117	10000921	✔							

Detailed technical data follows.
An adaptation ring, which is available as an option, is required for use of clamping adaptation devices.

Machine spindle standard DIN ISO 702-1. For more connection data please visit www.hainbuch.com

Order overview. SPANNTOP mini chuck

Size	Variant	Spindle nose	Total length [mm]	Material no.	In stock	Clamping elements and adaptations: Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	MANDO Adapt T812 RD Page 308	Jaw module RD Page 316	Face driver / morse taper adapter RD Page 324	Magnet module RD Page 332
52	Pull-back	A2-5	122	10000864	✔	✔	✔	✔			✔	✔
			145	10000865	✔							
		A2-6	122	10000866	✔							
		A2-6	145	10000867	✔							
		A2-8	120	10000894	✔							
			145	10000895	✔							
		AP110	120	10000891	✔							
		AP120	105	10000887	✔							
			115	10000888	✔							
		AP140	105	10000889	✔							
			115	10000890	✔							
	Deadlength	A2-4	122	10000922	✔	✔			✔			
		A2-5		10000923	✔							
			147	10000924	✔							
		A2-6	122	10000925	✔							
			147	10000926	✔							
		A2-8	120	10000950	✔							
		AP110	100	10000944	✔							
			115	10000953	✔							
		AP120	105	10000927	✔							
			115	10000928	✔							
		AP140	107	10000929	✔							
65	Pull-back	A2-5	124	10000898	✔	✔	✔	✔		✔	✔	✔
			130	10000841	✔							
			150	10000842	✔							
		A2-6	126	10000843	✔							
			130	10000844	✔							
			155	10000845	✔							
		A2-8	130	10000846	✔							
			155	10000847	✔							
		AP120	111	10000868	✔							
			120	10000869	✔							
		AP140	111	10000848	✔							
			120	10000849	✔							
		AP170	115	10000870	✔							
		AP220	112	10000896	✔							

Detailed technical data follows.
An adaptation ring, which is available as an option, is required for use of clamping adaptation devices.

Machine spindle standard DIN ISO 702-1. For more connection data please visit www.hainbuch.com

Order overview. SPANNTOP mini chuck

						Clamping elements and adaptations						
												
Size	Variant	Spindle nose	Total length [mm]	Material no.	In stock	Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	MANDO Adapt T812 RD Page 308	Jaw module RD Page 316	Face driver / morse taper adapter RD Page 324	Magnet module RD Page 332
65	Deadlength	A2-4	128	10000965	✔	✔			✔			
		A2-5		10000902	✔							
		A2-5	138	10000903	✔							
		A2-6	124	10000904	✔							
			138	10000905	✔							
			163	10000906	✔							
		A2-8	133	10000907	✔							
			163	10000908	✔							
		AP110	125	10000949	✔							
		AP120	129	10000963	✔							
		AP140	138	10000909	✔							
		AP170	110	10000954	✔							
			128	10000930	✔							
		AP220	111	10000964	✔							
80	Pull-back	A2-5	132	10000892	✔	✔	✔	✔		✔	✔	✔
		A2-6	128	10000871	✔							
			135	10000872	✔							
			155	10000873	✔							
		A2-8	132	10000874	✔							
			150	10000875	✔							
			180	10000876	✔							
		AP140	132	10000900	✔							
		AP170	115	10000877	✔							
	Deadlength	A2-5	136	10000945	✔	✔			✔			
		A2-6	130	10000931	✔							
			137	10000932	✔							
			157	10000933	✔							
		A2-8	132	10000934	✔							
			152	10000935	✔							
			182	10000936	✔							
		AP140	134	10000937	✔							
		AP170	115	10000946	✔							

Detailed technical data follows.
An adaptation ring, which is available as an option, is required for use of clamping adaptation devices.

Machine spindle standard DIN ISO 702-1. For more connection data please visit www.hainbuch.com

Order overview. SPANNTOP mini chuck

Size	Variant	Spindle nose	Total length [mm]	Material no.	In stock	Clamping elements and adaptations: Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	MANDO Adapt T812 RD Page 308	Jaw module RD Page 316	Face driver / morse taper adapter RD Page 324	Magnet module RD Page 332
100	Pull-back	A2-5	160	10000893	✔	✔	✔	✔		✔	✔	✔
		A2-6	164	10000879	✔							
			170	10000880	✔							
		A2-8	162	10000881	✔							
			180	10000882	✔							
		A2-11	180	10000883	✔							
			195	10000884	✔							
		AP140	161	10000899	✔							
		AP170	164	10000885	✔							
		AP220	150	10000886	✔							
	Deadlength	A2-5	171	10000959	✔	✔						
		A2-6	175	10000938	✔							
			182	10000939	✔							
		A2-8	169	10000940	✔							
			192	10000941	✔							
		A2-11	185	10000960	✔							
			200	10000961	✔							
		AP140	171	10000962	✔							
		AP170	175	10000942	✔							
		AP220	162	10000943	✔							

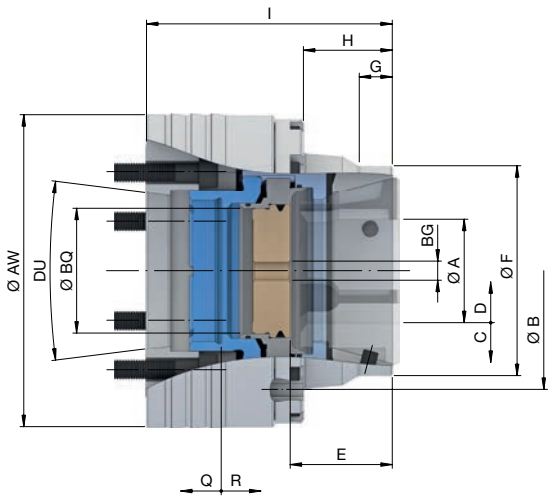
Detailed technical data follows.
An adaptation ring, which is available as an option, is required for use of clamping adaptation devices.

For more connection data please visit www.hainbuch.com

Scope of delivery

- Chuck
- Base end-stop
- Socket wrench insert 1/2"

SPANNTOP mini pull-back size 32. Technical data



Size		32
Variant		**Pull-back**
Run-out ≤ [mm]		0,010
Max. radial clamping force [kN]		70
Max. axial drawtube force pull / push] [kN]		25
RPM n max. [1/min.]		8000
Clamping range [mm]	A	3 – 32
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	0,8
Range / recommended workpiece tolerance [mm]		± 0,3
End-stop depth [mm]	E	45
Ø Capacity [mm]	BQ	33
End-stop thread size [M]	BG	10
Location front end-stop	F	Ø 66 f7
Centering length [mm]	G	17
Bolt hole circle end-stop	B	LK Ø 110 [3 x M6]
Length [mm]	H	43
Reserve stroke axial [mm]	Q	2,5
Release stroke axial [mm]	R	3

Spindle nose	DU	A2-4	A2-5		A2-6
Total length [mm]	I	**117**		**140**	**117**
Outer Ø [mm]	AW	132			159
Weight [kg]		7,1	6,6	7,8	8,8
In stock		✔	✔	✔	✔
Material no.		10000850	10000851	10000852	10000897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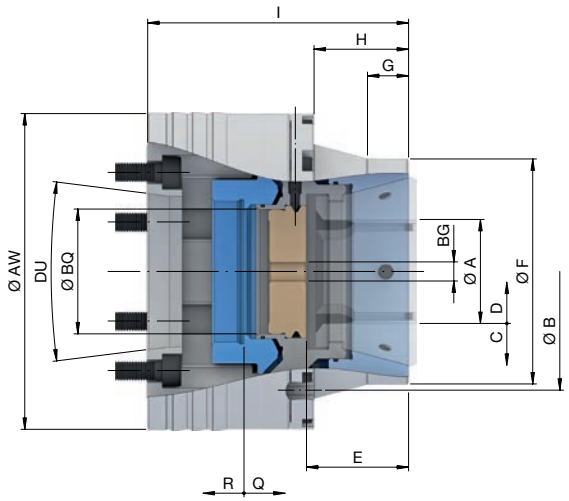
SPANNTOP mini deadlength size 32. Technical data



Size		32
Variant		**Deadlength**
Run-out ≤ [mm]		0,020
Max. radial clamping force [kN]		70
Max. axial compression force [kN]		25
RPM n max. [1/min.]		8000
Clamping range [mm]	A	3 – 32
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,3
End-stop depth [mm]	E	45,5
Ø Capacity [mm]	BQ	33
End-stop thread size [M]	BG	10
Location front end-stop	F	Ø 74 f7
Centering length [mm]	G	15
Bolt hole circle end-stop	B	LK Ø 115 [3 x M6]
Length [mm]	H	44
Reserve stroke axial [mm]	Q	2,5
Release stroke axial [mm]	R	3

Spindle nose	DU	A2-4		A2-5			A2-6
Total length [mm]	I	112	122	114	122	142	115
Outer Ø [mm]	AW			130			159
Weight [kg]		6,6	7,2	6,4	6,8	7,8	8,6
In stock		✔	✔	✔	✔	✔	✔
Material no.		10000910	10000911	10000912	10000913	10000914	10000967

Spindle nose	DU	AP140
Total length [mm]	I	101
Outer Ø [mm]	AW	149
Weight [kg]		7,2
In stock		✔
Material no.		10000968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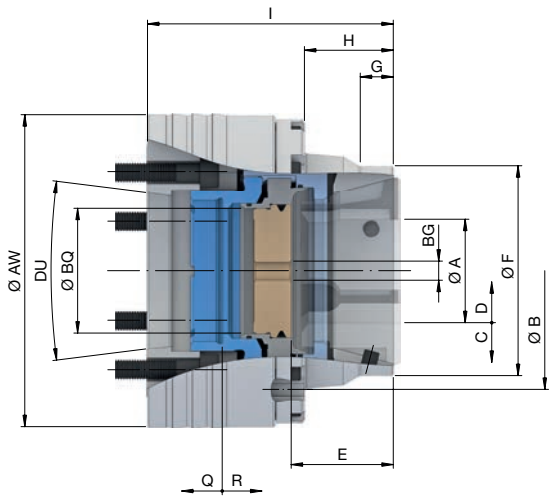
SPANNTOP mini pull-back size 42. Technical data



Size		42
Variant		**Pull-back**
Run-out ≤ [mm]		0,010
Max. radial clamping force [kN]		80
Max. axial drawtube force [pull / push] [kN]		35
RPM n max. [1/min.]		7000
Clamping range [mm]	A	3 – 42
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	42
Ø Capacity [mm]	BQ	44
End-stop thread size [M]	BG	10
Location front end-stop	F	Ø 90 f7
Centering length [mm]	G	15
Bolt hole circle end-stop	B	LK Ø 117 [3 x M6]
Length [mm]	H	42
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	A2-4	A2-5			A2-6	
Total length [mm]	l	**122**	**114**	**122**	**140**	**122**	**140**
Outer Ø [mm]	AW	134				159	
Weight [kg]		7,6	6,8	7,3	8,3	9,1	10,4
In stock		✔	✔	✔	✔	✔	✔
Material no.		10000853	10000854	10000855	10000856	10000857	10000858

Spindle nose	DU	AP120		AP140		AP170
Total length [mm]	l	**102**	**115**	**102**	**115**	**102**
Outer Ø [mm]	AW	134		150		180
Weight [kg]		6,2	6,9	7,5	8,5	10,4
In stock		✔	✔	✔	✔	✔
Material no.		10000859	10000860	10000861	10000862	10000901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Face driver / morse taper
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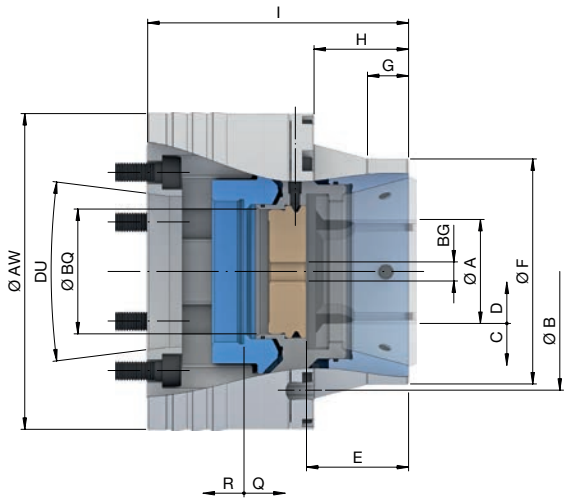
SPANNTOP mini deadlength size 42. Technical data



Size		42
Variant		**Deadlength**
Run-out ≤ [mm]		0,020
Max. radial clamping force [kN]		80
Max. axial compression force [kN]		35
RPM n max. [1/min.]		7000
Clamping range [mm]	A	3 – 42
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	45,8
Ø Capacity [mm]	BQ	44
End-stop thread size [M]	BG	10
Location front end-stop	F	Ø 98 f7
Centering length [mm]	G	25
Bolt hole circle end-stop	B	LK Ø 113 [9 x M6]
Length [mm]	H	44
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	A2-4	A2-5			A2-6	
Total length [mm]	l	125	118	125	142	124	142
Outer Ø [mm]	AW	139				159	
Weight [kg]		8,5	7,9	8,4	9,5	10	11,3
In stock		✔	✔	✔	✔	✔	✔
Material no.		10000951	10000915	10000916	10000917	10000918	10000919

Spindle nose	DU	AP110	AP120	AP140	
Total length [mm]	l	105			117
Outer Ø [mm]	AW	149			
Weight [kg]		8,2	8,1	8	9
In stock		✔	✔	✔	✔
Material no.		10000952	10000966	10000920	10000921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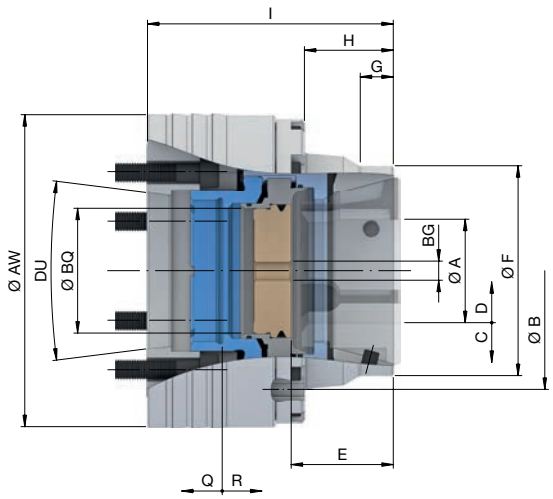
SPANNTOP mini pull-back size 52. Technical data



Size		52
Variant		**Pull-back**
Run-out ≤ [mm]		0,010
Max. radial clamping force [kN]		94
Max. axial drawtube force [pull / push] [kN]		40
RPM n max. [1/min.]		7000
Clamping range [mm]	A	3 – 52
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	46
Ø Capacity [mm]	BQ	53
End-stop thread size [M]	BG	10
Location front end-stop	F	Ø 90 f7
Centering length [mm]	G	15
Bolt hole circle end-stop	B	LK Ø 133 [3 x M8]
Length [mm]	H	45
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	A2-5		A2-6		A2-8	
Total length [mm]	I	122	145	122	145	120	145
Outer Ø [mm]	AW	149		159		204	
Weight [kg]		9,3	11,1	9,5	11,1	14,4	17,3
In stock		✔	✔	✔	✔	✔	✔
Material no.		10000864	10000865	10000866	10000867	10000894	10000895

Spindle nose	DU	AP110	AP120		AP140	
Total length [mm]	I	120	105	115	105	115
Outer Ø [mm]	AW	149			150	
Weight [kg]		9,5	8	8,8	7,9	8,8
In stock		✔	✔	✔	✔	✔
Material no.		10000891	10000887	10000888	10000889	10000890

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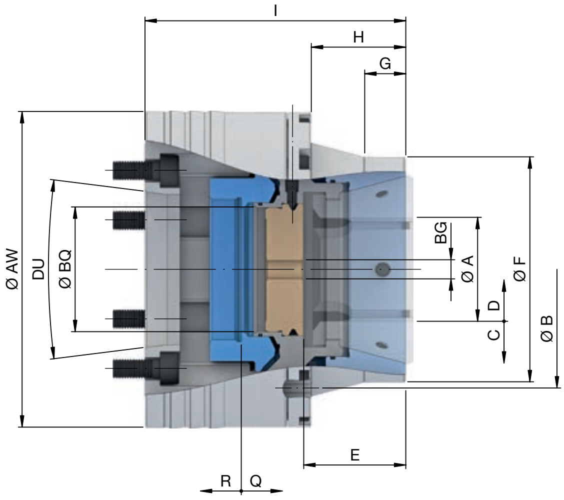
SPANNTOP mini deadlength size 52. Technical data



Size		**52**
Variant		**Deadlength**
Run-out ≤ [mm]		0,020
Max. radial clamping force [kN]		94
Max. axial compression force [kN]		40
RPM n max. [1/min.]		7000
Clamping range [mm]	A	3 – 52
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	45,8
Ø Capacity [mm]	BQ	53
End-stop thread size [M]	BG	10
Location front end-stop	F	Ø 98 f7
Centering length [mm]	G	23
Bolt hole circle end-stop	B	LK Ø 125 [9 x M6]
Length [mm]	H	44
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	**A2-4**	**A2-5**		**A2-6**		**A2-8**
Total length [mm]	I	**122**		**147**	**122**	**147**	**120**
Outer Ø [mm]	AW	149			163		202
Weight [kg]		9,7	9,4	11,3	10,4	12,4	14,3
In stock		✔	✔	✔	✔	✔	✔
Material no.		10000922	10000923	10000924	10000925	10000926	10000950

Spindle nose	DU	**AP110**		**AP120**		**AP140**
Total length [mm]	I	**100**	**115**	**105**	**115**	**107**
Outer Ø [mm]	AW	149				
Weight [kg]		7,8	9,1	8,2	8,9	8,1
In stock		✔	✔	✔	✔	✔
Material no.		10000944	10000953	10000927	10000928	10000929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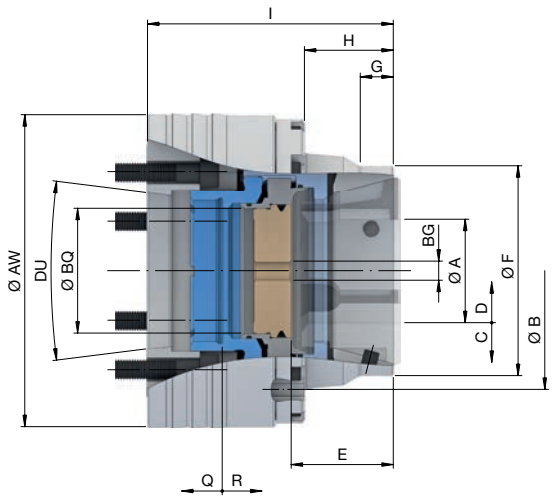
SPANNTOP mini pull-back size 65. Technical data



Size		65
Variant		**Pull-back**
Run-out ≤ [mm]		0,010
Max. radial clamping force [kN]		105
Max. axial drawtube force [pull / push] [kN]		45
RPM n max. [1/min.]		6000
Clamping range [mm]	A	3 – 65
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	54
Ø Capacity [mm]	BQ	66
End-stop thread size [M]	BG	12
Location front end-stop	F	Ø 111 f7
Centering length [mm]	G	18
Bolt hole circle end-stop	B	LK Ø 145 [3 x M8]
Length [mm]	H	47
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	A2-5			A2-6			A2-8	
Total length [mm]	I	**124**	**130**	**150**	**126**	**130**	**155**	**130**	**155**
Outer Ø [mm]	AW	165						204	
Weight [kg]		11,4	12,1	14,2	10,5	10,7	12,5	14,9	18,1
In stock		✔	✔	✔	✔	✔	✔	✔	✔
Material no.		10000898	10000841	10000842	10000843	10000844	10000845	10000846	10000847

Spindle nose	DU	AP120		AP140		AP170	AP220
Total length [mm]	I	**111**	**120**	**111**	**120**	**115**	**112**
Outer Ø [mm]	AW	165				180	230
Weight [kg]		10,4	11,3	10	10,7	11,3	16,6
In stock		✔	✔	✔	✔	✔	✔
Material no.		10000868	10000869	10000848	10000849	10000870	10000896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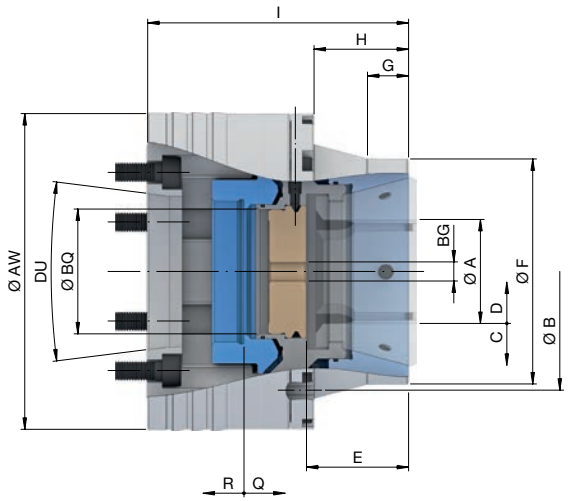
SPANNTOP mini deadlength size 65. Technical data



Size		65
Variant		**Deadlength**
Run-out ≤ [mm]		0,020
Max. radial clamping force [kN]		105
Max. axial compression force [kN]		45
RPM n max. [1/min.]		6000
Clamping range [mm]	A	3 – 65
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	54
Ø Capacity [mm]	BQ	66
End-stop thread size [M]	BG	12
Location front end-stop	F	Ø 119 f7
Centering length [mm]	G	22
Bolt hole circle end-stop	B	LK Ø 145 [9 x M6]
Length [mm]	H	50
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	A2-4	A2-5		A2-6			A2-8	
Total length [mm]	l	128		138	124	138	163	133	163
Outer Ø [mm]	AW	167						202	
Weight [kg]		12,9	12,3	13,3	11,3	12,5	14,8	15,8	19,1
In stock		✔	✔	✔	✔	✔	✔	✔	✔
Material no.		10000965	10000902	10000903	10000904	10000905	10000906	10000907	10000908

Spindle nose	DU	AP110	AP120	AP140	AP170		AP220
Total length [mm]	l	125	129	138	110	128	111
Outer Ø [mm]	AW	167			180		230
Weight [kg]		12,6		13,3	11,4	13,5	17
In stock		✔	✔	✔	✔	✔	✔
Material no.		10000949	10000963	10000909	10000954	10000930	10000964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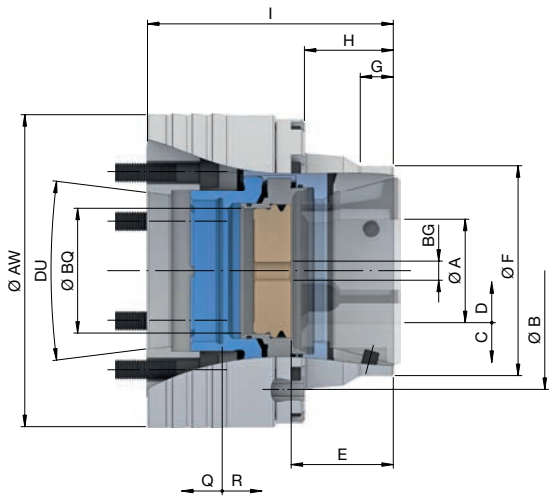
SPANNTOP mini pull-back size 80. Technical data



Size		80
Variant		**Pull-back**
Run-out ≤ [mm]		0,010
Max. radial clamping force [kN]		115
Max. axial drawtube force [pull / push] [kN]		50
RPM n max. [1/min.]		5500
Clamping range [mm]	A	4 – 80
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	54
Ø Capacity [mm]	BQ	82
End-stop thread size [M]	BG	12
Location front end-stop	F	Ø 126 f7
Centering length [mm]	G	18
Bolt hole circle end-stop	B	LK Ø 156 [3 x M8]
Length [mm]	H	47
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	A2-5	A2-6			A2-8		
Total length [mm]	I	**132**	**128**	**135**	**155**	**132**	**150**	**180**
Outer Ø [mm]	AW	171				204		
Weight [kg]		12,8	11,8	12,4	14,2	15,4	17,6	21,1
In stock		✔	✔	✔	✔	✔	✔	✔
Material no.		10000892	10000871	10000872	10000873	10000874	10000875	10000876

Spindle nose	DU	AP140	AP170
Total length [mm]	I	**132**	**115**
Outer Ø [mm]	AW	171	180
Weight [kg]		13	11,5
In stock		✔	✔
Material no.		10000900	10000877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Adaptations jaw clamping
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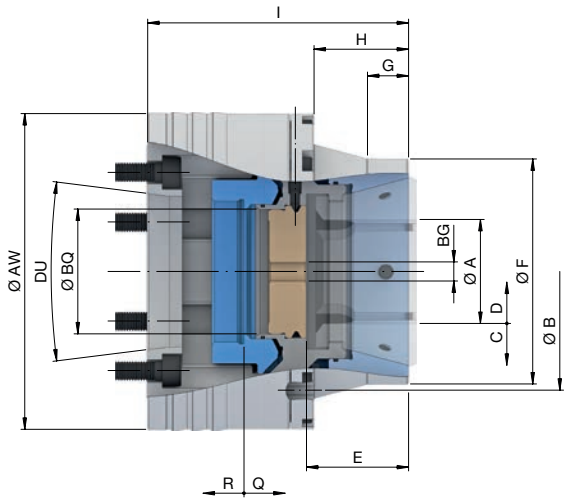
SPANNTOP mini deadlength size 80. Technical data



Size		80
Variant		**Deadlength**
Run-out ≤ [mm]		0,020
Max. radial clamping force [kN]		115
Max. axial compression force [kN]		50
RPM n max. [1/min.]		5500
Clamping range [mm]	A	4 – 80
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	1
Range / recommended workpiece tolerance [mm]		± 0,5
End-stop depth [mm]	E	55
Ø Capacity [mm]	BQ	82
End-stop thread size [M]	BG	12
Location front end-stop	F	Ø 136 f7
Centering length [mm]	G	22
Bolt hole circle end-stop	B	LK Ø 160,5 [9 x M6]
Length [mm]	H	51
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5

Spindle nose	DU	A2-5	A2-6			A2-8		
Total length [mm]	I	136	130	137	157	132	152	182
Outer Ø [mm]	AW	180				205		
Weight [kg]		15,4	13,9	14,6	16,7	16,9	19,2	22,8
In stock		✔	✔	✔	✔	✔	✔	✔
Material no.		10000945	10000931	10000932	10000933	10000934	10000935	10000936

Spindle nose	DU	AP140	AP170
Total length [mm]	I	134	115
Outer Ø [mm]	AW	180	
Weight [kg]		15,4	12,2
In stock		✔	✔
Material no.		10000937	10000946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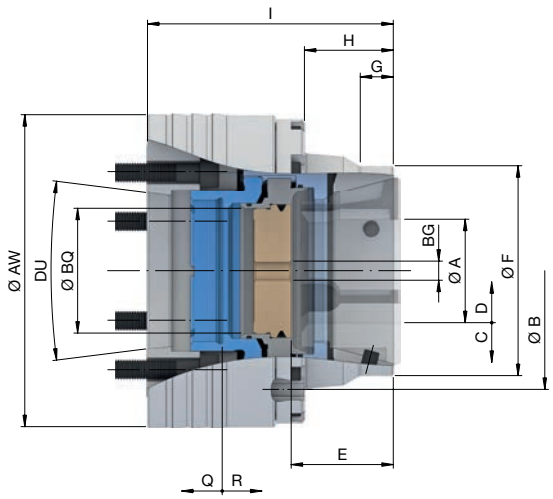
SPANNTOP mini pull-back size 100. Technical data



Size		100
Variant		**Pull-back**
Run-out ≤ [mm]		0,015
Max. radial clamping force [kN]		150
Max. axial drawtube force [pull / push] [kN]		65
RPM n max. [1/min.]		5000
Clamping range [mm]	A	15 – 100
Release stroke in Ø [mm]	C	2
Reserve stroke in Ø [mm]	D	1,5
Range / recommended workpiece tolerance [mm]		± 1,0
End-stop depth [mm]	E	72
Ø Capacity [mm]	BQ	102
End-stop thread size [M]	BG	12
Location front end-stop	F	Ø 160 f7
Centering length [mm]	G	20
Bolt hole circle end-stop	B	LK Ø 198 [3 x M8]
Length [mm]	H	64
Reserve stroke axial [mm]	Q	3
Release stroke axial [mm]	R	5

Spindle nose	DU	A2-5	A2-6		A2-8		A2-11	
Total length [mm]	I	**160**	**164**	**170**	**162**	**180**		**195**
Outer Ø [mm]	AW	221					280	
Weight [kg]		24,8	25,3	26,2	23,1	25,3	40,7	44,9
In stock		✔	✔	✔	✔	✔	✔	✔
Material no.		10000893	10000879	10000880	10000881	10000882	10000883	10000884

Spindle nose	DU	AP140	AP170	AP220
Total length [mm]	I	**161**	**164**	**150**
Outer Ø [mm]	AW	221		230
Weight [kg]		26	25,6	23,7
In stock		✔	✔	✔
Material no.		10000899	10000885	10000886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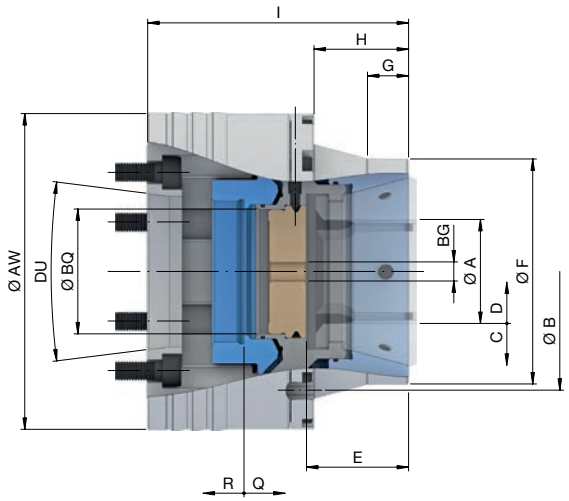
SPANNTOP mini deadlength size 100. Technical data



Size		100
Variant		**Deadlength**
Run-out ≤ [mm]		0,025
Max. radial clamping force [kN]		150
Max. axial compression force [kN]		65
RPM n max. [1/min.]		5000
Clamping range [mm]	A	15 – 100
Release stroke in Ø [mm]	C	2
Reserve stroke in Ø [mm]	D	1,5
Range / recommended workpiece tolerance [mm]		± 1,0
End-stop depth [mm]	E	74
Ø Capacity [mm]	BQ	102
End-stop thread size [M]	BG	12
Location front end-stop	F	Ø 168 f7
Centering length [mm]	G	22
Bolt hole circle end-stop	B	LK Ø 208 [3 x M6]
Length [mm]	H	64
Reserve stroke axial [mm]	Q	3
Release stroke axial [mm]	R	5

Spindle nose	DU	A2-5	A2-6		A2-8		A2-11	
Total length [mm]	I	171	175	182	169	192	185	200
Outer Ø [mm]	AW	221						276
Weight [kg]		28,6	29	30,2	26,4	29,8	39,6	42,6
In stock		✔	✔	✔	✔	✔	✔	✔
Material no.		10000959	10000938	10000939	10000940	10000941	10000960	10000961

Spindle nose	DU	AP140	AP170	AP220
Total length [mm]	I	171	175	162
Outer Ø [mm]	AW	221		230
Weight [kg]		29,6	29,4	27,1
In stock		✔	✔	✔
Material no.		10000962	10000942	10000943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SPANNTOP

The original, that wrote workholding history

HAINBUCH SYSTEM

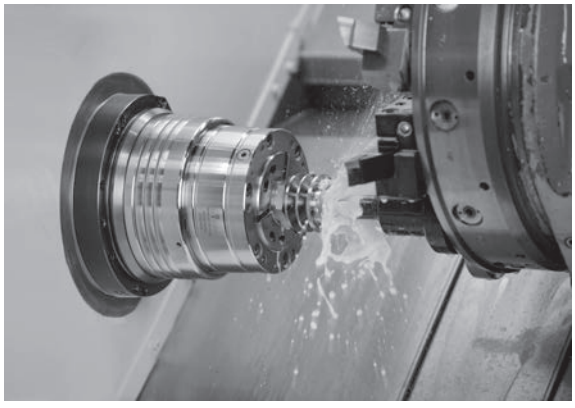
SPANNTOP nova – this development represents more than 30 years of SPANNTOP experience. It exploits all the advantages of the latest machine tools. The components are optimized for balance quality, and have an extended guide length. The clamping length of the workpieces is also significantly greater. This chuck is designed for maximum RPM and holding power at ideal run-out accuracy. It is extremely rigid, precise, and has an extremely long life.

The position-oriented base end-stop of the »combi pull-back« and »combi deadlength« variants can be conveniently changed from the outside via three clamping screws countersunk in the chuck, and for standard chucks, provides excellent accuracy for face location combined with through-bore capacity.

SPANNTOP nova: reliable and solid. The product is the result of more than 30 years of experience!

Key advantages

- Ideal for customers with existing RD clamping heads
- Typical features of all HAINBUCH power chucks, such as high holding power, parallel clamping with high accuracy and easy set-up
- Minimal inertia loss compared to 3-jaw chucks

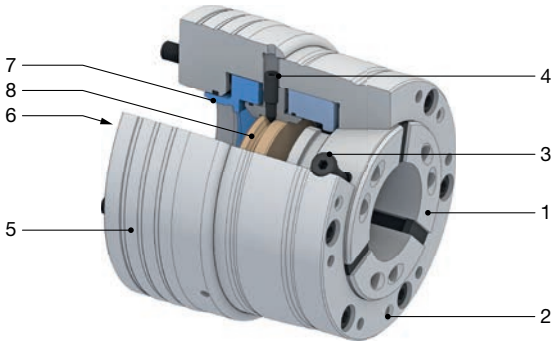


SPANNTOP nova combi pull-back chuck in use

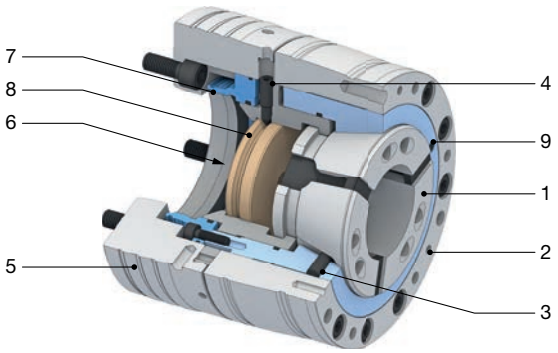
SPANNTOP nova chuck types

	SPANNTOP nova combi pull-back	SPANNTOP nova combi deadlength	SPANNTOP nova modular
			
Description	Workpiece clamping with pull-back effect. Chuck with dismountable end-stop plate. Without end-stop plate ideal for machining pipes and bars.	Workpiece clamping without pull-back effect. Chuck with dismountable end-stop plate. It is also frequently used on the sub spindle.	Through-bore chuck only – ideal for machining pipes and bars.
Advantages	■ Workpiece stabilization through axial draw force applied against the workpiece end-stop ■ Prepared for inside and front end-stop ■ Converts to a fully functional »bar chuck« when the end-stop plate is removed	■ Workpiece clamping without axial movement of the clamping head ■ Clamps workpieces with a short collar or shoulder ■ Suitable for pick-off without pull-back effect ■ Prepared for inside and front end-stop ■ Converts to a fully functional »bar chuck« when the end-stop plate is removed	■ Fully-functional bar chuck ■ Due to pull-back effect signi-ficantly more rigid clamping is achieved than by conventional collets ■ Higher RPM and metal removal rates for bar work
Clamping elements	 Clamping head RD	 Clamping head RD	 Clamping head RD
Adaptations	 MANDO Adapt T211 RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module RD [Adaptation for jaw clamping]  Face driver RD / Morse taper adapter RD [Adaptation for clamping between centers]  Magnet module RD [Adaptation for magnetic clamping]	 MANDO Adapt T812 RD [Mandrel-in-clamping-device, without draw bolt]	 MANDO Adapt T211 RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module RD [Adaptation for jaw clamping]  Face driver RD / Morse taper adapter RD [Adaptation for clamping between centers]  Magnet module RD [Adaptation for magnetic clamping]

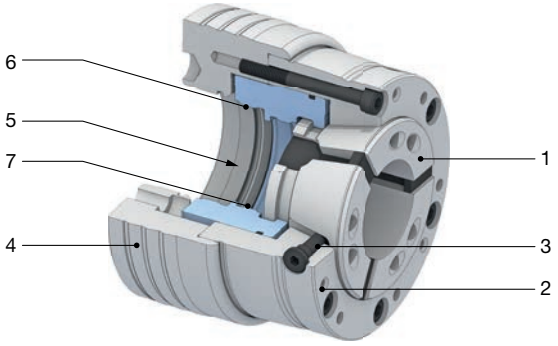
SPANNTOP nova combi pull-back in detail

Designation	
1 Vulcanized clamping head with hardened steel segments and pull-back 2 Mounting threads for front end-stop 3 Torsional safety lock of the clamping head 4 Clamping screw for base end-stop, easy mounting through external actuation 5 Spindle flange 6 Full through-bore after removing the base end-stop plate 7 Mounting thread for drawtube connection 8 Fixed base end-stop for clamping with pull-back effect, central mounting thread for workpiece specific end-stop	

SPANNTOP nova combi deadlength in detail

Designation	
1 Vulcanized clamping head with hardened steel segments 2 Mounting threads for front end-stop 3 Torsional safety lock of the clamping head 4 Clamping screw for base end-stop, easy mounting through external actuation 5 Spindle flange 6 Full through-bore after removing the base end-stop plate 7 Mounting thread for drawtube connection 8 Fixed base end-stop with central mounting thread for workpiece specific end-stop 9 Central grease nipple, optimum tool life and holding power due to perfect lubrication	

SPANNTOP nova modular in detail

Designation	
1 Vulcanized clamping head with hardened steel segments and pull-back 2 Mounting threads for front end-stop 3 Torsional safety lock of the clamping head 4 Spindle flange 5 Full chuck passage for bar work 6 Mounting thread for drawtube connection 7 Mounting thread for guide rings, introduction, spring ejectors, etc.	

Order overview. SPANNTOP nova chuck

Size	Variant	Spindle nose	Material no.	In stock	Clamping elements and adaptations						
											
					Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	MANDO Adapt T812 RD Page 308	Jaw module RD Page 316	Face driver / morse taper adapter RD Page 324	Magnet module RD Page 332
32	Combi pull-back	A2-4	10001768	-	✔						
		A2-5	10001769	-							
	Combi deadlength	A2-4	10001810	-							
		A2-5	10001811	-							
	Modular	A2-4	10001739	-							
		A2-5	10001740	-							
42	Combi pull-back	A2-4	10001792	-	✔	✔	✔			✔	
		A2-5	10001770	-							
		A2-6	10001771	-							
		AP120	10001781	-							
		AP140	10001782	-							
	Combi deadlength	A2-5	10001812	-	✔			✔			
		A2-6	10001813	-							
		AP140	10001823	-							
	Modular	A2-5	10001741	-	✔	✔	✔			✔	
		A2-6	10001742	-							
		AP120	10001751	-							
		AP140	10001752	-							
52	Combi pull-back	A2-5	10001772	-	✔	✔	✔			✔	✔
		A2-6	10001773	-							
		AP120	10001783	-							
		AP140	10001784	-							
	Combi deadlength	A2-5	10001814	-	✔			✔			
		A2-6	10001815	-							
		AP120	10001830	-							
		AP140	10001824	-							
	Modular	A2-5	10001743	-	✔	✔	✔			✔	✔
		A2-6	10001744	-							
		AP120	10001753	-							
		AP140	10001754	-							
65	Combi pull-back	A2-5	10001774	-	✔	✔	✔		✔	✔	✔
		A2-6	10001775	-							
		A2-8	10001776	-							
		AP120	10001785	-							
		AP140	10001786	-							
		AP170	10001787	-							

Detailed technical data follows.

For more connection data please visit www.hainbuch.com

Order overview. SPANNTOP nova chuck

Size	Variant	Spindle nose	Material no.	In stock	Clamping elements and adaptations						
											
					Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	MANDO Adapt T812 RD Page 308	Jaw module RD Page 316	Face driver / morse taper adapter RD Page 324	Magnet module RD Page 332
65	Combi deadlength	A2-5	10001816	-	✔			✔			
		A2-6	10001817	-							
		A2-8	10001818	-							
		AP140	10001825	-							
		AP170	10001826	-							
	Modular	A2-5	10001745	-	✔	✔	✔		✔	✔	✔
		A2-6	10001746	-							
		A2-8	10001747	-							
		AP120	10001755	-							
		AP140	10001756	-							
		AP170	10001757	-							
80	Combi pull-back	A2-5	10001803	-	✔	✔	✔		✔	✔	✔
		A2-6	10001777	-							
		A2-8	10001778	-							
		AP170	10001788	-							
		AP220	10001789	-							
	Combi deadlength	A2-6	10001819	-	✔			✔			
		A2-8	10001820	-							
		AP140	10001827	-							
	Modular	A2-6	10001748	-	✔	✔	✔		✔	✔	✔
		A2-8	10001749	-							
		AP220	10001758	-							
100	Combi pull-back	A2-6	10001779	-	✔	✔	✔		✔	✔	✔
		A2-8	10001780	-							
		A2-11	10001793	-							
		AP170	10001790	-							
		AP220	10001791	-							
	Combi deadlength	A2-6	10001821	-	✔						
		A2-8	10001822	-							
		A2-11	10001837	-							
		AP170	10001828	-							
		AP220	10001829	-							
	Modular	A2-8	10001750	-	✔	✔	✔		✔	✔	✔
		A2-11	10001761	-							
		AP170	10001759	-							
		AP220	10001760	-							

Detailed technical data follows.

For more connection data please visit www.hainbuch.com

Order overview. SPANNTOP nova chuck

Size	Variant	Spindle nose	Material no.	In stock	Clamping elements and adaptations						
											
					Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	MANDO Adapt T812 RD Page 308	Jaw module RD Page 316	Face driver / morse taper adapter RD Page 324	Magnet module RD Page 332
125	Combi pull-back	A2-6	10001804	✔	✔		✔				
		A2-8	10001805	✔							
		A2-11	10001806	✔							
		AP170	10001807	✔							
		AP220	10001808	✔							
	Combi deadlength	A2-6	10001832	✔	✔						
		A2-8	10001833	✔							
		A2-11	10001834	✔							
		AP170	10001835	✔							
		AP220	10001836	✔							
	Modular	A2-6	10001763	✔	✔		✔				
		A2-8	10001764	✔							
		A2-11	10001765	✔							
		AP170	10001766	✔							
		AP220	10001767	✔							
160	Combi pull-back	A2-6	10014974	✔	✔						
		A2-8	10014977	✔							
		A2-11	10014978	✔							
		AP170	10014979	✔							
		AP220	10014980	✔							

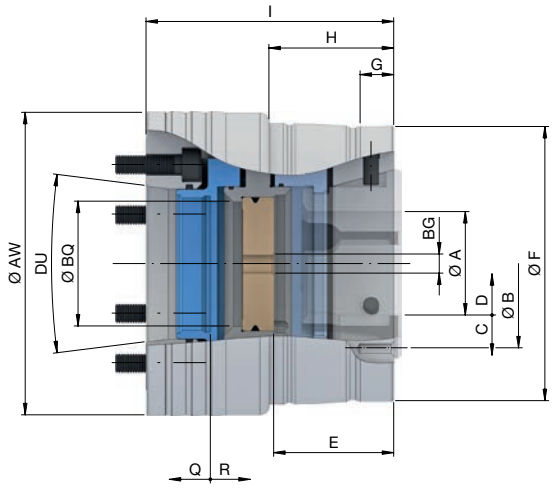
Detailed technical data follows.

For more connection data please visit www.hainbuch.com

Scope of delivery

- Chuck
- Base end-stop [depending on the variant]

SPANNTOP nova combi pull-back size 32. Technical data



Size		**32**	
Variant		**Combi pull-back**	
Spindle nose	DU	A2-4	A2-5
Run-out ≤ [mm]		0,010	
Max. radial clamping force [kN]		70	
Max. axial drawtube force [pull / push] [kN]		25	
RPM n max. [1/min.]		8000	
Clamping range [mm]	A	3 – 32	
Release stroke in Ø [mm]	C	0,6	
Reserve stroke in Ø [mm]	D	1	
Range / recommended workpiece tolerance [mm]		± 0,3	
End-stop depth [mm]	E	52,5	
Ø Capacity [mm]	BQ	33	
End-stop thread size [M]	BG	10	
Location front end-stop	F	Ø 75 f7	
Centering length [mm]	G	14	
Bolt hole circle end-stop	B	LK Ø 67 [3 x M4]	
Length [mm]	H	55	
Total length [mm]	I	117	
Reserve stroke axial [mm]	Q	2,5	
Release stroke axial [mm]	R	3	
Outer Ø [mm]	AW	115	135
Weight [kg]		6	7
In stock		-	-
Material no.		10001768	10001769

Machine spindle standard DIN 55026.
Total length can be extended via flange.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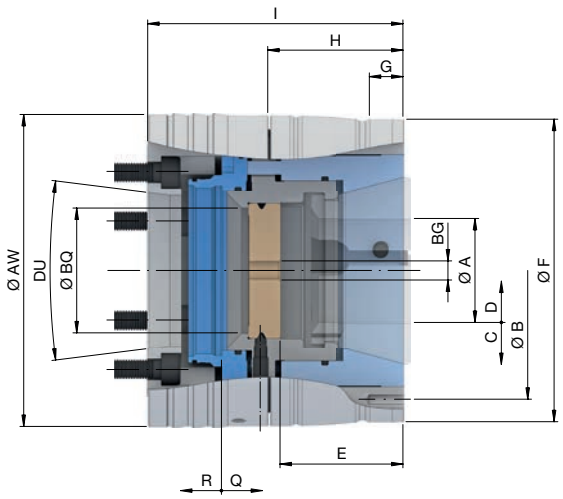
SPANNTOP nova combi deadlength size 32. Technical data



Size		32	
Variant		**Combi deadlength**	
Spindle nose	DU	A2-4	A2-5
Run-out ≤ [mm]		0,020	
Max. radial clamping force [kN]		70	
Max. axial compression force [kN]		25	
RPM n max. [1/min.]		8000	
Clamping range [mm]	A	3 – 32	
Release stroke in Ø [mm]	C	0,6	
Reserve stroke in Ø [mm]	D	1	
Range / recommended workpiece tolerance [mm]		± 0,3	
End-stop depth [mm]	E	53,5	
Ø Capacity [mm]	BQ	33	
End-stop thread size [M]	BG	10	
Location front end-stop	F	Ø 100 f7	
Centering length [mm]	G	10	
Bolt hole circle end-stop	B	LK Ø 92,5 [3 x M4]	
Length [mm]	H	60	
Total length [mm]	I	120	
Reserve stroke axial [mm]	Q	2,5	
Release stroke axial [mm]	R	3	
Outer Ø [mm]	AW	145	
Weight [kg]		10	
In stock		-	-
Material no.		10001810	10001811

Machine spindle standard DIN 55026.
Total length can be extended via flange.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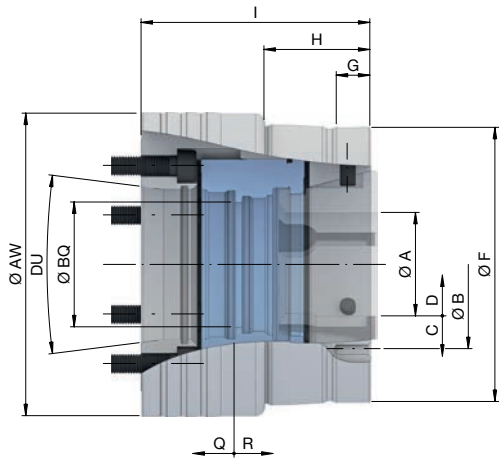
SPANNTOP nova modular size 32. Technical data



Size		**32**	
Variant		**Modular**	
Spindle nose	DU	A2-4	A2-5
Run-out ≤ [mm]		0,010	
Max. radial clamping force [kN]		70	
Max. axial drawtube force [pull / push] [kN]		25	
RPM n max. [1/min.]		8000	
Clamping range [mm]	A	3 – 32	
Release stroke in Ø [mm]	C	0,6	
Reserve stroke in Ø [mm]	D	1	
Range / recommended workpiece tolerance [mm]		± 0,3	
Ø Capacity [mm]	BQ	34	
Location front end-stop	F	Ø 75 f7	
Centering length [mm]	G	14	
Bolt hole circle end-stop	B	LK Ø 67 [3 x M4]	
Length [mm]	H	45	
Total length [mm]	I	107	
Reserve stroke axial [mm]	Q	2,5	
Release stroke axial [mm]	R	3	
Outer Ø [mm]	AW	115	135
Weight [kg]		5	6
In stock		-	-
Material no.		10001739	10001740

Machine spindle standard DIN 55026.
Total length can be extended via flange.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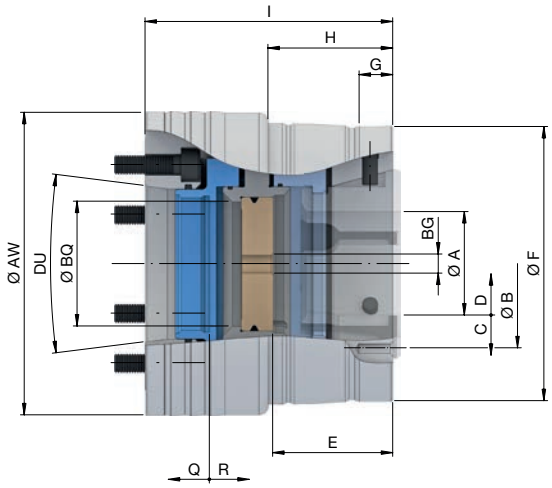
SPANNTOP nova combi pull-back size 42. Technical data



Size		42				
Variant		**Combi pull-back**				
Spindle nose	DU	A2-4	A2-5	A2-6	AP120	AP140
Run-out ≤ [mm]		0,010				
Max. radial clamping force [kN]		80				
Max. axial drawtube force [pull / push] [kN]		35				
RPM n max. [1/min.]		7000				
Clamping range [mm]	A	3 – 42				
Release stroke in Ø [mm]	C	0,6				
Reserve stroke in Ø [mm]	D	1				
Range / recommended workpiece tolerance [mm]		± 0,5				
End-stop depth [mm]	E	56,5				
Ø Capacity [mm]	BQ	43				
End-stop thread size [M]	BG	10				
Location front end-stop	F	Ø 125 f7				
Centering length [mm]	G	17				
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]				
Length [mm]	H	59				
Total length [mm]	I	122			115	
Reserve stroke axial [mm]	Q	2				
Release stroke axial [mm]	R	2,5				
Outer Ø [mm]	AW	144		165	144	150
Weight [kg]		11	10	12	10	11
In stock		-	-	-	-	-
Material no.		10001792	10001770	10001771	10001781	10001782

Machine spindle standard DIN 55026.
Total length can be extended via flange.

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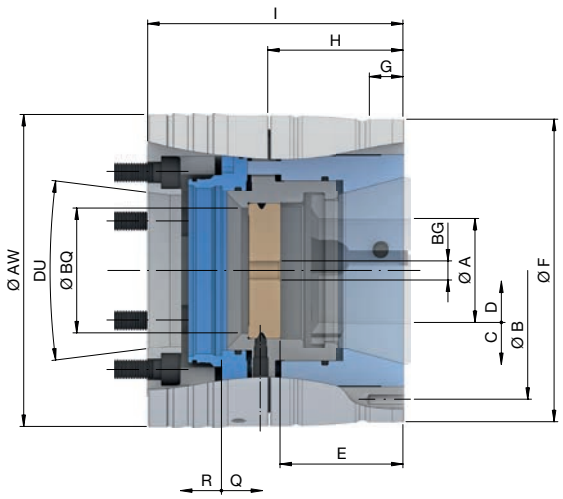
SPANNTOP nova combi deadlength size 42. Technical data



Size		42		
Variant		**Combi deadlength**		
Spindle nose	DU	A2-5	A2-6	AP140
Run-out ≤ [mm]		0,020		
Max. radial clamping force [kN]		80		
Max. axial compression force [kN]		35		
RPM n max. [1/min.]		7000		
Clamping range [mm]	A	3 – 42		
Release stroke in Ø [mm]	C	0,6		
Reserve stroke in Ø [mm]	D	1		
Range / recommended workpiece tolerance [mm]		± 0,5		
End-stop depth [mm]	E	54,8		
Ø Capacity [mm]	BQ	43		
End-stop thread size [M]	BG	10		
Location front end-stop	F	Ø 140 f7		
Centering length [mm]	G	17		
Bolt hole circle end-stop	B	LK Ø 122 [3 x M6]		
Length [mm]	H	61,5		
Total length [mm]	I	120		110
Reserve stroke axial [mm]	Q	2		
Release stroke axial [mm]	R	2,5		
Outer Ø [mm]	AW	145	162	150
Weight [kg]		13,5		14
In stock		-	-	-
Material no.		10001812	10001813	10001823

Machine spindle standard DIN 55026.
Total length can be extended via flange.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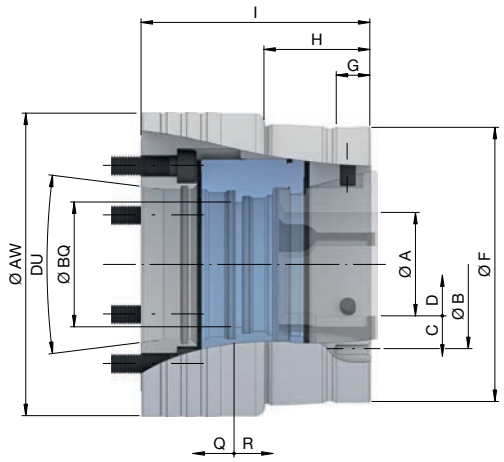
SPANNTOP nova modular size 42. Technical data



Size		42			
Variant		**Modular**			
Spindle nose	DU	A2-5	A2-6	AP120	AP140
Run-out ≤ [mm]		0,010			
Max. radial clamping force [kN]		80			
Max. axial drawtube force [pull / push] [kN]		35			
RPM n max. [1/min.]		7000			
Clamping range [mm]	A	3 – 42			
Release stroke in Ø [mm]	C	0,6			
Reserve stroke in Ø [mm]	D	1			
Range / recommended workpiece tolerance [mm]		± 0,5			
Ø Capacity [mm]	BQ	45			
Location front end-stop	F	Ø 125 f7			
Centering length [mm]	G	17			
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]			
Length [mm]	H	49			
Total length [mm]	I	112		105	
Reserve stroke axial [mm]	Q	2			
Release stroke axial [mm]	R	2,5			
Outer Ø [mm]	AW	144	165	144	150
Weight [kg]		9	11	9	
In stock		-	-	-	-
Material no.		10001741	10001742	10001751	10001752

Machine spindle standard DIN 55026.
Total length can be extended via flange.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Face driver / morse taper
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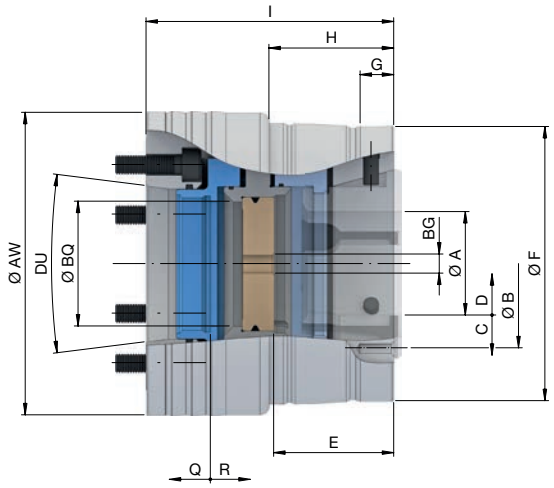
SPANNTOP nova combi pull-back size 52. Technical data



Size		52			
Variant		**Combi pull-back**			
Spindle nose	DU	A2-5	A2-6	AP120	AP140
Run-out ≤ [mm]		0,010			
Max. radial clamping force [kN]		94			
Max. axial drawtube force [pull / push] [kN]		40			
RPM n max. [1/min.]		7000			
Clamping range [mm]	A	3 – 52			
Release stroke in Ø [mm]	C	0,6			
Reserve stroke in Ø [mm]	D	1			
Range / recommended workpiece tolerance [mm]		± 0,5			
End-stop depth [mm]	E	56,5			
Ø Capacity [mm]	BQ	53			
End-stop thread size [M]	BG	10			
Location front end-stop	F	Ø 125 f7			
Centering length [mm]	G	17			
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]			
Length [mm]	H	59			
Total length [mm]	I	122		115	
Reserve stroke axial [mm]	Q	2			
Release stroke axial [mm]	R	2,5			
Outer Ø [mm]	AW	144	165	144	150
Weight [kg]		10	12	10	
In stock		-	-	-	-
Material no.		10001772	10001773	10001783	10001784

Machine spindle standard DIN 55026.
Total length can be extended via flange.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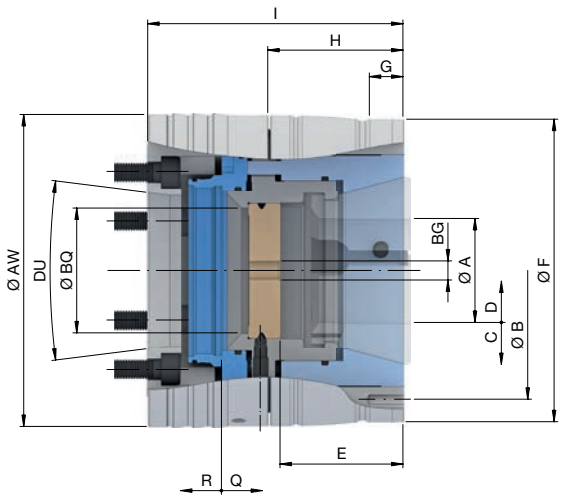
SPANNTOP nova combi deadlength size 52. Technical data



Size		52			
Variant		**Combi deadlength**			
Spindle nose	DU	A2-5	A2-6	AP120	AP140
Run-out ≤ [mm]		0,020			
Max. radial clamping force [kN]		94			
Max. axial compression force [kN]		40			
RPM n max. [1/min.]		7000			
Clamping range [mm]	A	3 – 52			
Release stroke in Ø [mm]	C	0,6			
Reserve stroke in Ø [mm]	D	1			
Range / recommended workpiece tolerance [mm]		± 0,5			
End-stop depth [mm]	E	54,8			
Ø Capacity [mm]	BQ	53			
End-stop thread size [M]	BG	10			
Location front end-stop	F	Ø 140 f7			
Centering length [mm]	G	17	13	20	
Bolt hole circle end-stop	B	LK Ø 122 [3 x M6]			
Length [mm]	H	61,5			
Total length [mm]	I	120		110	
Reserve stroke axial [mm]	Q	2			
Release stroke axial [mm]	R	2,5			
Outer Ø [mm]	AW	145	162	145	150
Weight [kg]		13		13,5	
In stock		-	-	-	-
Material no.		10001814	10001815	10001830	10001824

Machine spindle standard DIN 55026.
Total length can be extended via flange.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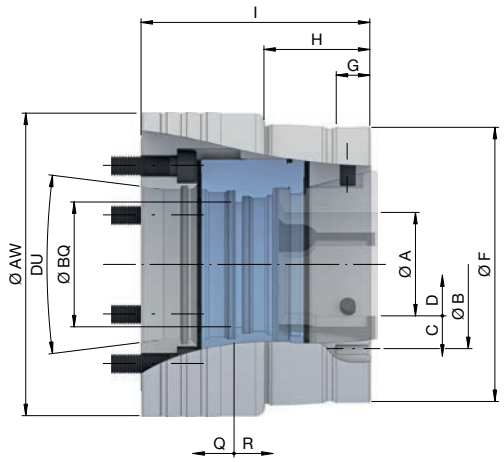
SPANNTOP nova modular size 52. Technical data



Size		52			
Variant		**Modular**			
Spindle nose	DU	A2-5	A2-6	AP120	AP140
Run-out ≤ [mm]		0,010			
Max. radial clamping force [kN]		94			
Max. axial drawtube force [pull / push] [kN]		40			
RPM n max. [1/min.]		7000			
Clamping range [mm]	A	3 – 52			
Release stroke in Ø [mm]	C	0,6			
Reserve stroke in Ø [mm]	D	1			
Range / recommended workpiece tolerance [mm]		± 0,5			
Ø Capacity [mm]	BQ	53			
Location front end-stop	F	Ø 125 f7			
Centering length [mm]	G	17			
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]			
Length [mm]	H	49			
Total length [mm]	I	112		105	
Reserve stroke axial [mm]	Q	2			
Release stroke axial [mm]	R	2,5			
Outer Ø [mm]	AW	144	165	144	150
Weight [kg]		9	11	9	
In stock		-	-	-	-
Material no.		10001743	10001744	10001753	10001754

Machine spindle standard DIN 55026.
Total length can be extended via flange.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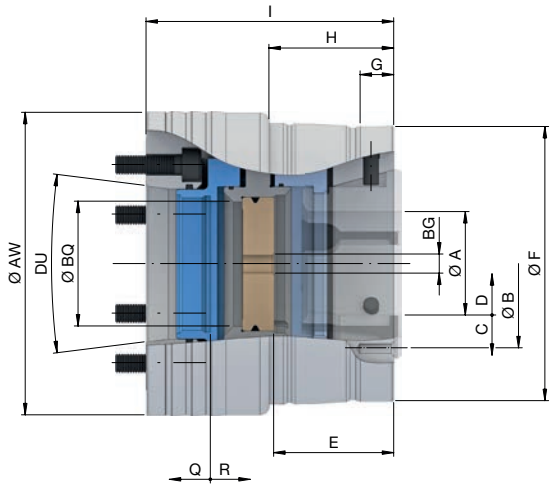
SPANNTOP nova combi pull-back size 65. Technical data



Size		65					
Variant		**Combi pull-back**					
Spindle nose	DU	A2-5	A2-6	A2-8	AP120	AP140	AP170
Run-out ≤ [mm]		0,010					
Max. radial clamping force [kN]		105					
Max. axial drawtube force [pull / push] [kN]		45					
RPM n max. [1/min.]		6000					
Clamping range [mm]	A	3 – 65					
Release stroke in Ø [mm]	C	0,6					
Reserve stroke in Ø [mm]	D	1					
Range / recommended workpiece tolerance [mm]		± 0,5					
End-stop depth [mm]	E	63,5					
Ø Capacity [mm]	BQ	66					
End-stop thread size [M]	BG	12					
Location front end-stop	F	Ø 145 f7					
Centering length [mm]	G	17					
Bolt hole circle end-stop	B	LK Ø 126 [3 x M6]					
Length [mm]	H	66					
Total length [mm]	I	131	130	131	120		115
Reserve stroke axial [mm]	Q	2					
Release stroke axial [mm]	R	2,5					
Outer Ø [mm]	AW	160	165	210	160		184
Weight [kg]		13,5	13	18,5	12,5		14
In stock		-	-	-	-	-	-
Material no.		10001774	10001775	10001776	10001785	10001786	10001787

Machine spindle standard DIN 55026.
Total length can be extended via flange.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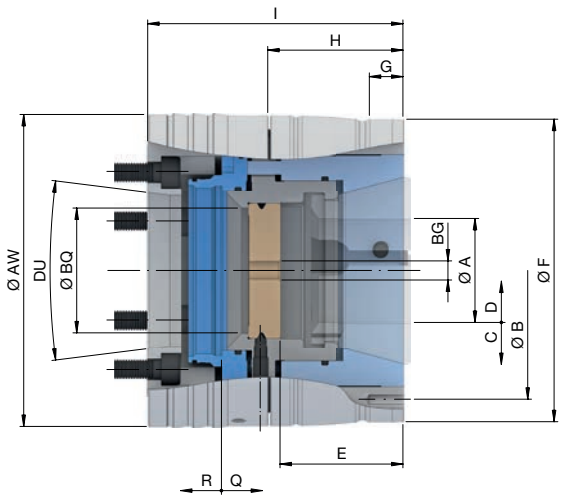
SPANNTOP nova combi deadlength size 65. Technical data



Size		65				
Variant		**Combi deadlength**				
Spindle nose	DU	A2-5	A2-6	A2-8	AP140	AP170
Run-out ≤ [mm]		0,020				
Max. radial clamping force [kN]		105				
Max. axial compression force [kN]		45				
RPM n max. [1/min.]		6000				
Clamping range [mm]	A	3 – 65				
Release stroke in Ø [mm]	C	0,6				
Reserve stroke in Ø [mm]	D	1				
Range / recommended workpiece tolerance [mm]		± 0,5				
End-stop depth [mm]	E	65				
Ø Capacity [mm]	BQ	66				
End-stop thread size [M]	BG	12				
Location front end-stop	F	Ø 160 f7				
Centering length [mm]	G	17				
Bolt hole circle end-stop	B	LK Ø 141 [3 x M6]				
Length [mm]	H	71,5				
Total length [mm]	I	135				125
Reserve stroke axial [mm]	Q	2				
Release stroke axial [mm]	R	2,5				
Outer Ø [mm]	AW	165		210	165	180
Weight [kg]		15,5	15	20	16	20
In stock		-	-	-	-	-
Material no.		10001816	10001817	10001818	10001825	10001826

Machine spindle standard DIN 55026.
Total length can be extended via flange.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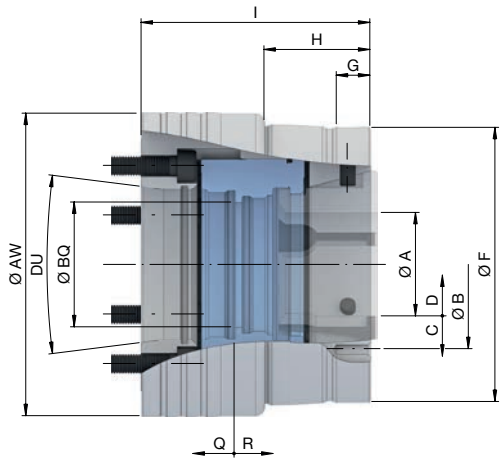
SPANNTOP nova modular size 65. Technical data



Size		65					
Variant		**Modular**					
Spindle nose	DU	A2-5	A2-6	A2-8	AP120	AP140	AP170
Run-out ≤ [mm]		0,010					
Max. radial clamping force [kN]		105					
Max. axial drawtube force [pull / push] [kN]		45					
RPM n max. [1/min.]		6000					
Clamping range [mm]	A	3 – 65					
Release stroke in Ø [mm]	C	0,6					
Reserve stroke in Ø [mm]	D	1					
Range / recommended workpiece tolerance [mm]		± 0,5					
Ø Capacity [mm]	BQ	66					
Location front end-stop	F	Ø 145 f7					
Centering length [mm]	G	17					
Bolt hole circle end-stop	B	LK Ø 126 [3 x M6]					
Length [mm]	H	56					
Total length [mm]	I	121	120	121	110		105
Reserve stroke axial [mm]	Q	2					
Release stroke axial [mm]	R	2,5					
Outer Ø [mm]	AW	160	165	210	160		184
Weight [kg]		12	17		11		12,5
In stock		-	-	-	-	-	-
Material no.		10001745	10001746	10001747	10001755	10001756	10001757

Machine spindle standard DIN 55026.
Total length can be extended via flange.

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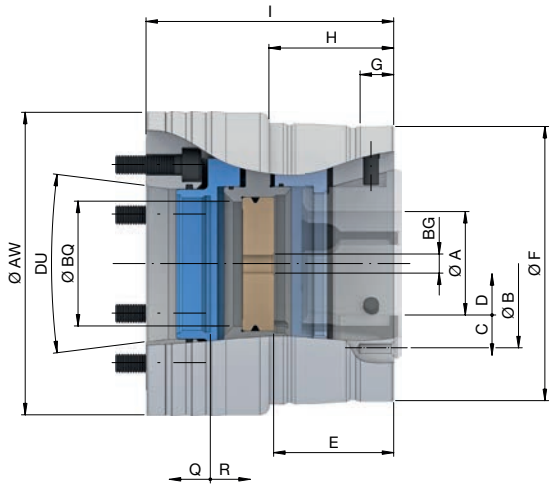
SPANNTOP nova combi pull-back size 80. Technical data



Size		80				
Variant		**Combi pull-back**				
Spindle nose	DU	A2-5	A2-6	A2-8	AP170	AP220
Run-out ≤ [mm]		0,010				
Max. radial clamping force [kN]		115				
Max. axial drawtube force [pull / push] [kN]		50				
RPM n max. [1/min.]		5500				
Clamping range [mm]	A	4 – 80				
Release stroke in Ø [mm]	C	0,6				
Reserve stroke in Ø [mm]	D	1				
Range / recommended workpiece tolerance [mm]		± 0,5				
End-stop depth [mm]	E	63,5				
Ø Capacity [mm]	BQ	81				
End-stop thread size [M]	BG	12				
Location front end-stop	F	Ø 160 f7				
Centering length [mm]	G	17				
Bolt hole circle end-stop	B	LK Ø 139 [3 x M6]				
Length [mm]	H	66				
Total length [mm]	I	134	135	140	135	148
Reserve stroke axial [mm]	Q	2				
Release stroke axial [mm]	R	2,5				
Outer Ø [mm]	AW	180		210	180	235
Weight [kg]		17	16	21	17	
In stock		-	-	-	-	-
Material no.		10001803	10001777	10001778	10001788	10001789

Machine spindle standard DIN 55026.
Total length can be extended via flange.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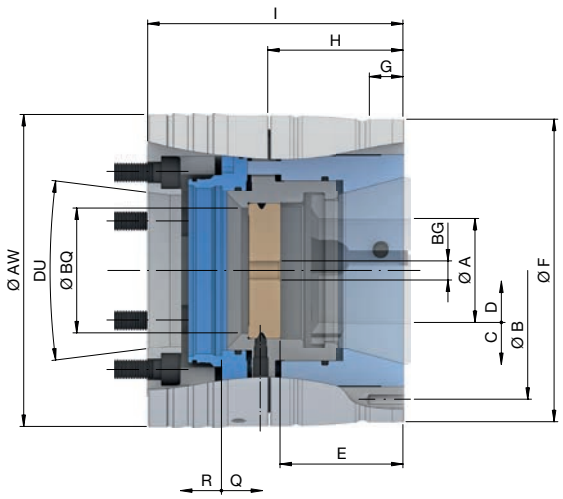
SPANNTOP nova combi deadlength size 80. Technical data



Size		80		
Variant		**Combi deadlength**		
Spindle nose	DU	A2-6	A2-8	AP140
Run-out ≤ [mm]		0,020		
Max. radial clamping force [kN]		115		
Max. axial compression force [kN]		50		
RPM n max. [1/min.]		5500		
Clamping range [mm]	A	4 – 80		
Release stroke in Ø [mm]	C	0,6		
Reserve stroke in Ø [mm]	D	1		
Range / recommended workpiece tolerance [mm]		± 0,5		
End-stop depth [mm]	E	65		
Ø Capacity [mm]	BQ	81		
End-stop thread size [M]	BG	12		
Location front end-stop	F	Ø 175 f7		
Centering length [mm]	G	17		
Bolt hole circle end-stop	B	LK Ø 156 [3 x M6]		
Length [mm]	H	71,5		
Total length [mm]	I	145		
Reserve stroke axial [mm]	Q	2		
Release stroke axial [mm]	R	2,5		
Outer Ø [mm]	AW	179	210	179
Weight [kg]		19	23	20
In stock		-	-	-
Material no.		10001819	10001820	10001827

Machine spindle standard DIN 55026.
Total length can be extended via flange.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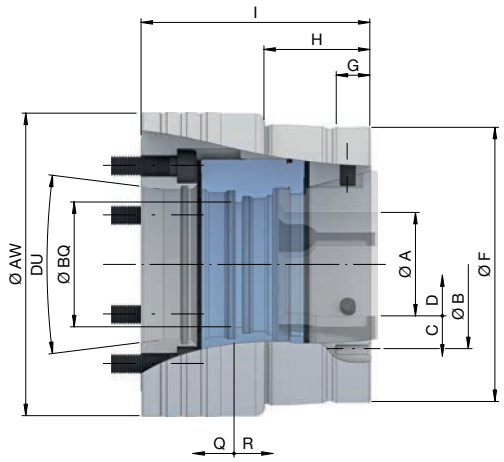
SPANNTOP nova modular size 80. Technical data



Size		**80**		
Variant		**Modular**		
Spindle nose	DU	A2-6	A2-8	AP220
Run-out ≤ [mm]		0,010		
Max. radial clamping force [kN]		115		
Max. axial drawtube force [pull / push] [kN]		50		
RPM n max. [1/min.]		5500		
Clamping range [mm]	A	4 – 80		
Release stroke in Ø [mm]	C	0,6		
Reserve stroke in Ø [mm]	D	1		
Range / recommended workpiece tolerance [mm]		± 0,5		
Ø Capacity [mm]	BQ	81		
Location front end-stop	F	Ø 160 f7		
Centering length [mm]	G	17		
Bolt hole circle end-stop	B	LK Ø 139 [3 x M6]		
Length [mm]	H	56		
Total length [mm]	I	125	130	138
Reserve stroke axial [mm]	Q	2		
Release stroke axial [mm]	R	2,5		
Outer Ø [mm]	AW	180	210	235
Weight [kg]		14	19	27
In stock		-	-	-
Material no.		10001748	10001749	10001758

Machine spindle standard DIN 55026.
Total length can be extended via flange.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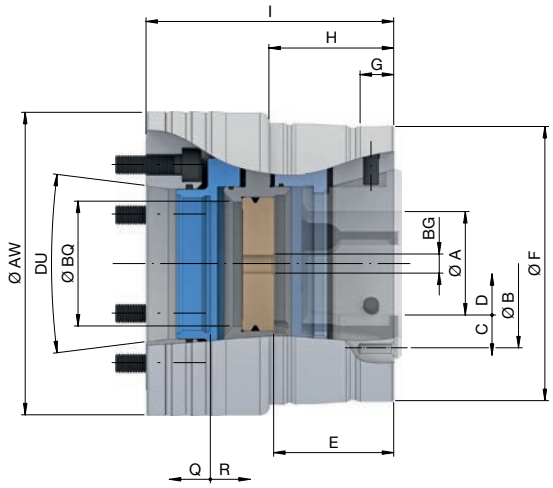
SPANNTOP nova combi pull-back size 100. Technical data



Size		100				
Variant		**Combi pull-back**				
Spindle nose	DU	A2-6	A2-8	A2-11	AP170	AP220
Run-out ≤ [mm]		0,015				
Max. radial clamping force [kN]		150				
Max. axial drawtube force [pull / push] [kN]		65				
RPM n max. [1/min.]		5000				
Clamping range [mm]	A	15 – 100				
Release stroke in Ø [mm]	C	2				
Reserve stroke in Ø [mm]	D	1,5				
Range / recommended workpiece tolerance [mm]		± 1,0				
End-stop depth [mm]	E	73				
Ø Capacity [mm]	BQ	101				
End-stop thread size [M]	BG	12				
Location front end-stop	F	Ø 215 f7				
Centering length [mm]	G	20				
Bolt hole circle end-stop	B	LK Ø 180 [3 x M8]				
Length [mm]	H	78,5				
Total length [mm]	I	155	159	165	159	
Reserve stroke axial [mm]	Q	3				
Release stroke axial [mm]	R	5				
Outer Ø [mm]	AW	235		280	235	240
Weight [kg]		33,5	33	43	35	
In stock		-	-	-	-	-
Material no.		10001779	10001780	10001793	10001790	10001791

Machine spindle standard DIN 55026.
Total length can be extended via flange.

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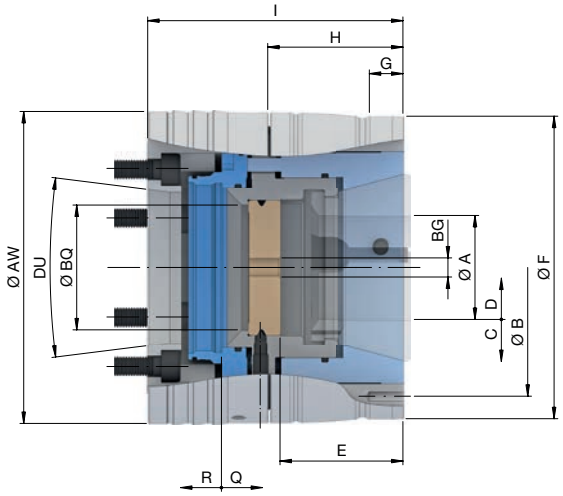
SPANNTOP nova combi deadlength size 100. Technical data



Size		100				
Variant		Combi deadlength				
Spindle nose	DU	A2-6	A2-8	A2-11	AP170	AP220
Run-out ≤ [mm]		0,025				
Max. radial clamping force [kN]		150				
Max. axial compression force [kN]		65				
RPM n max. [1/min.]		5000				
Clamping range [mm]	A	15 – 100				
Release stroke in Ø [mm]	C	2				
Reserve stroke in Ø [mm]	D	1,5				
Range / recommended workpiece tolerance [mm]		± 1,0				
End-stop depth [mm]	E	85,5				
Ø Capacity [mm]	BQ	84	101			
End-stop thread size [M]	BG	12				
Location front end-stop	F	Ø 215 f7				
Centering length [mm]	G	20		22	20	
Bolt hole circle end-stop	B	LK Ø 192 [3 x M8]				
Length [mm]	H	94				
Total length [mm]	I	175			180	170
Reserve stroke axial [mm]	Q	3				
Release stroke axial [mm]	R	5				
Outer Ø [mm]	AW	220		280	220	240
Weight [kg]		35	34	46	37	38
In stock		-	-	-	-	-
Material no.		10001821	10001822	10001837	10001828	10001829

Machine spindle standard DIN 55026.
Total length can be extended via flange.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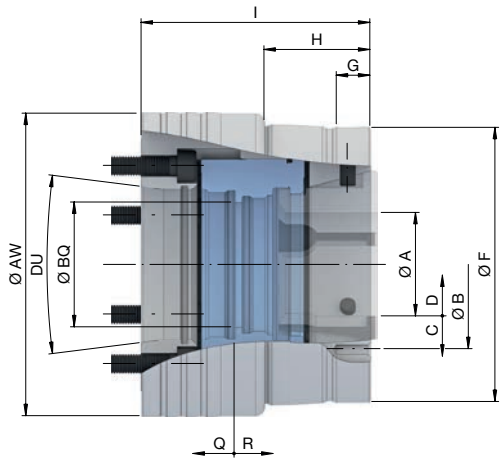
SPANNTOP nova modular size 100. Technical data



Size		100			
Variant		**Modular**			
Spindle nose	DU	A2-8	A2-11	AP170	AP220
Run-out ≤ [mm]		0,015			
Max. radial clamping force [kN]		150			
Max. axial drawtube force [pull / push] [kN]		65			
RPM n max. [1/min.]		5000			
Clamping range [mm]	A	15 – 100			
Release stroke in Ø [mm]	C	2			
Reserve stroke in Ø [mm]	D	1,5			
Range / recommended workpiece tolerance [mm]		± 1,0			
Ø Capacity [mm]	BQ	104,5			
Location front end-stop	F	Ø 215 f7			
Centering length [mm]	G	20			
Bolt hole circle end-stop	B	LK Ø 180 [3 x M8]			
Length [mm]	H	68,5			
Total length [mm]	I	149	155	149	
Reserve stroke axial [mm]	Q	3			
Release stroke axial [mm]	R	5			
Outer Ø [mm]	AW	235	280	235	240
Weight [kg]		29	39	32	31
In stock		-	-	-	-
Material no.		10001750	10001761	10001759	10001760

Machine spindle standard DIN 55026.
Total length can be extended via flange.

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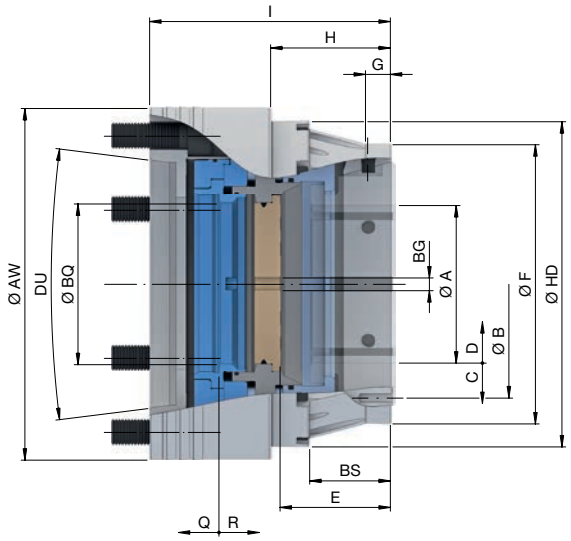
SPANNTOP nova combi pull-back size 125. Technical data



Size		125				
Variant		**Combi pull-back**				
Spindle nose	DU	A2-6	A2-8	A2-11	AP170	AP220
Run-out ≤ [mm]		0,020				
Max. radial clamping force [kN]		165				
Max. axial drawtube force [pull / push] [kN]		70				
RPM n max. [1/min.]		3200				
Clamping range [mm]	A	25 – 125				
Release stroke in Ø [mm]	C	2,5				
Reserve stroke in Ø [mm]	D	2,5				
Range / recommended workpiece tolerance [mm]		± 1,0				
End-stop depth [mm]	E	87,5				
Ø Capacity [mm]	BQ	127,5				
End-stop thread size [M]	BG	12				
Location front end-stop	F	Ø 221,5 f7				
Centering length [mm]	G	20				
Bolt hole circle end-stop	B	LK Ø 208,5 [6 x M8]				
Length [mm]	H	95				
Length 2 [mm]	BS	64				
Total length [mm]	I		191		185	190
Reserve stroke axial [mm]	Q	5				
Release stroke axial [mm]	R	6				
Outer Ø [mm]	AW	270		280	270	
Outer Ø 2 [mm]	HD	258				
Weight [kg]		50	48	46	49	47
In stock		✔	✔	✔	✔	✔
Material no.		10001804	10001805	10001806	10001807	10001808

Machine spindle standard DIN 55026.
Total length can be extended via flange.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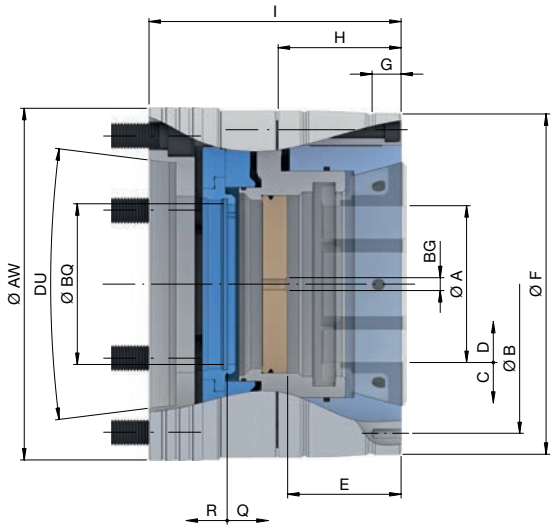
SPANNTOP nova combi deadlength size 125. Technical data



Size		125				
Variant		Combi deadlength				
Spindle nose	DU	A2-6	A2-8	A2-11	AP170	AP220
Run-out ≤ [mm]		0,030				
Max. radial clamping force [kN]		165				
Max. axial compression force [kN]		70				
RPM n max. [1/min.]		3200				
Clamping range [mm]	A	25 – 125				
Release stroke in Ø [mm]	C	2,5				
Reserve stroke in Ø [mm]	D	2,5				
Range / recommended workpiece tolerance [mm]		± 1,0				
End-stop depth [mm]	E	90				
Ø Capacity [mm]	BQ	127,5				
End-stop thread size [M]	BG	12				
Location front end-stop	F	Ø 270 f7				
Centering length [mm]	G	22				
Bolt hole circle end-stop	B	LK Ø 245 [3 x M8]				
Length [mm]	H	97,5				
Total length [mm]	I	190	200		185	190
Reserve stroke axial [mm]	Q	5				
Release stroke axial [mm]	R	6				
Outer Ø [mm]	AW	275				
Weight [kg]		61	63	61	62	
In stock		✔	✔	✔	✔	✔
Material no.		10001832	10001833	10001834	10001835	10001836

Machine spindle standard DIN 55026.
Total length can be extended via flange.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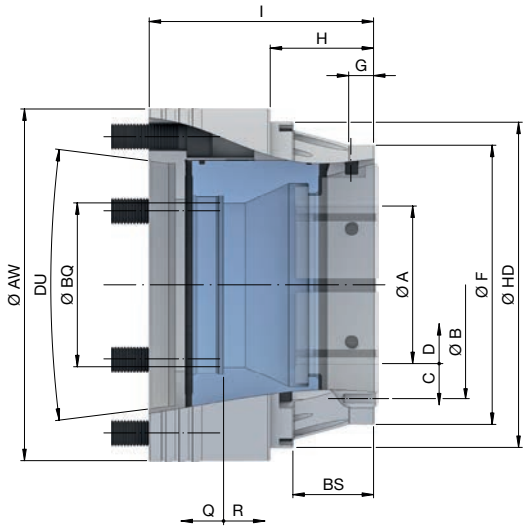
SPANNTOP nova modular size 125. Technical data



Size		125				
Variant		**Modular**				
Spindle nose	DU	A2-6	A2-8	A2-11	AP170	AP220
Run-out ≤ [mm]		0,020				
Max. radial clamping force [kN]		165				
Max. axial drawtube force [pull / push] [kN]		70				
RPM n max. [1/min.]		3200				
Clamping range [mm]	A	25 – 125				
Release stroke in Ø [mm]	C	2,5				
Reserve stroke in Ø [mm]	D	2,5				
Range / recommended workpiece tolerance [mm]		± 1,0				
Ø Capacity [mm]	BQ	130				
Location front end-stop	F	Ø 221,5 f7				
Centering length [mm]	G	20				
Bolt hole circle end-stop	B	LK Ø 208,5 [6 x M8]				
Length [mm]	H	82				
Length 2 [mm]	BS	64				
Total length [mm]	I	178				177
Reserve stroke axial [mm]	Q	5				
Release stroke axial [mm]	R	6				
Outer Ø [mm]	AW	270		280	270	
Outer Ø 2 [mm]	HD	258				
Weight [kg]		44	43		44	43
In stock		✔	✔	✔	✔	✔
Material no.		10001763	10001764	10001765	10001766	10001767

Machine spindle standard DIN 55026.
Total length can be extended via flange.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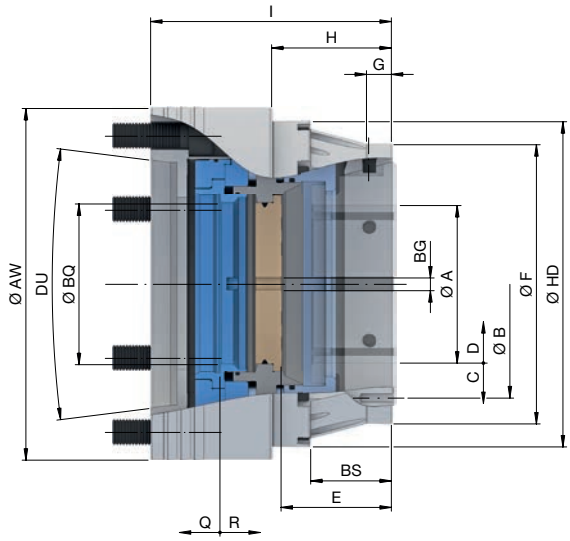
SPANNTOP nova combi pull-back size 160. Technical data



Size		160				
Variant		**Combi pull-back**				
Spindle nose	DU	A2-6	A2-8	A2-11	AP170	AP220
Run-out ≤ [mm]		0,025				
Max. radial clamping force [kN]		235				
Max. axial drawtube force [pull / push] [kN]		100				
RPM n max. [1/min.]		3200				
Clamping range [mm]	A	27 – 160				
Release stroke in Ø [mm]	C	1,3				
Reserve stroke in Ø [mm]	D	1,5				
Range / recommended workpiece tolerance [mm]		± 1,0				
End-stop depth [mm]	E	89,5				
Ø Capacity [mm]	BQ	162				
End-stop thread size [M]	BG	12				
Location front end-stop	F	Ø 254 f7				
Centering length [mm]	G	20				
Bolt hole circle end-stop	B	LK Ø 240,5 [3 x M8]				
Length [mm]	H	95				
Length 2 [mm]	BS	64				
Total length [mm]	I	190	195	200	189	194
Reserve stroke axial [mm]	Q	3				
Release stroke axial [mm]	R	3				
Outer Ø [mm]	AW	302				
Outer Ø 2 [mm]	HD	290				
Weight [kg]		60	60,8	59	62	
In stock		✔	✔	✔	✔	✔
Material no.		10014974	10014977	10014978	10014979	10014980

Machine spindle standard DIN 55026.
Total length can be extended via flange.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SPANNTOP nova chuck

TOROK

Clamps gently or forcefully

HAINBUCH SYSTEM

The TOROK manual chuck is primarily used in tool prototyping on machines without a clamping cylinder. For example, thanks to its easy manual actuation, when used on grinding machines you can safely and delicately clamp. In combination with our clamping device adaptations, such as the MANDO Adapt mandrel-in-chuck or the jaw module, many more clamping options are possible.

And most recent: Thanks to the optional lightweight CFRP design, with the TOROK CFK you save one-third the weight. This is particularly set-up friendly and it offloads the machine spindle bearings.

Key advantages

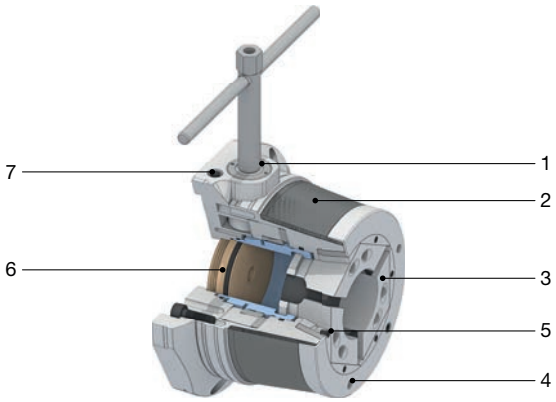
- Also available in a CFRP lightweight design
- Manual actuation – a clamping cylinder is not required
- Sensitive clamping possible
- Workpiece stabilization through axial draw force applied against the workpiece end-stop
- Mandrels, jaw modules, face drivers, and morse taper adaptable

TOROK in use

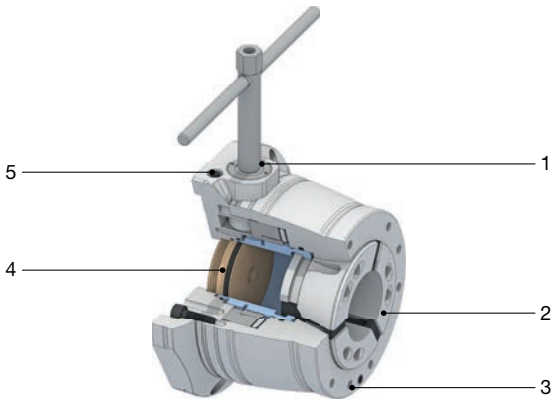
TOROK manually actuated chuck types

	TOROK CFK	TOROK
		
Description	Manually actuated lightweight chuck	Manually actuated chuck
Sizes	52, 65	52, 65, 80, 100
Clamping range of all sizes [mm]	3 – 65	3 – 100
Variant	SE [hexagonal] / RD [round]	SE [hexagonal] / RD [round]
Advantages	■ Made of carbon fiber ■ 1/3 lighter than the standard model	
Clamping elements	 Clamping head SE  Clamping head RD	 Clamping head SE  Clamping head RD
Adaptations	 MANDO Adapt T211 SE / RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE / RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE / RD [Adaptation for jaw clamping]  Face driver / Morse taper adapter SE / RD [Adaptation for clamping between centers]  Magnet module SE / RD [Adaptation for magnetic clamping]	 MANDO Adapt T211 SE / RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE / RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE / RD [Adaptation for jaw clamping]  Face driver SE / Morse taper adapter SE / RD [Adaptation for clamping between centers]  Magnet module SE / RD [Adaptation for magnetic clamping]

TOROK CFK SE in detail

Designation	
1 Manual actuation via socket wrench 2 Chuck body made of carbon fiber 3 Clamping head with pull-back and hexagon geometry for optimum chuck sealing and improved clamping force 4 Mounting threads for front end-stop 5 Grease nipple, optimal holding power due to efficient lubrication 6 Fixed base end-stop for clamping with pull-back effect, central mounting thread for workpiece specific end-stop 7 Clamping screw for base end-stop, easy mounting through external actuation	

TOROK RD in detail

Designation	
1 Manual actuation via socket wrench 2 Vulcanized clamping head with hardened steel segments and pull-back 3 Mounting threads for front end-stop 4 Fixed base end-stop for clamping with pull-back effect, central mounting thread for workpiece specific end-stop 5 Clamping screw for base end-stop, easy mounting through external actuation	

Order overview. TOROK CFK SE / RD

Product line	Size	Material no.	In stock	Clamping elements and adaptations					
									
				Clamping head SE Page 422	MANDO Adapt T211 SE Page 274	MANDO Adapt T212 SE Page 280	Jaw module SE Page 316	Face driver / morse taper adapter SE Page 324	Magnet module SE Page 332
SE	52	10000486	-	✔	✔	✔		✔	✔
	65	10000487	-	✔	✔	✔	✔	✔	✔
Product line	Size	Material no.	In stock	Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	Jaw module RD Page 316	Face driver / morse taper adapter RD Page 324	Magnet module RD Page 332
RD	52	10000488	-	✔	✔	✔		✔	✔
	65	10000489	-	✔	✔	✔	✔	✔	✔

Detailed technical data follows.

Order overview. TOROK SE / RD

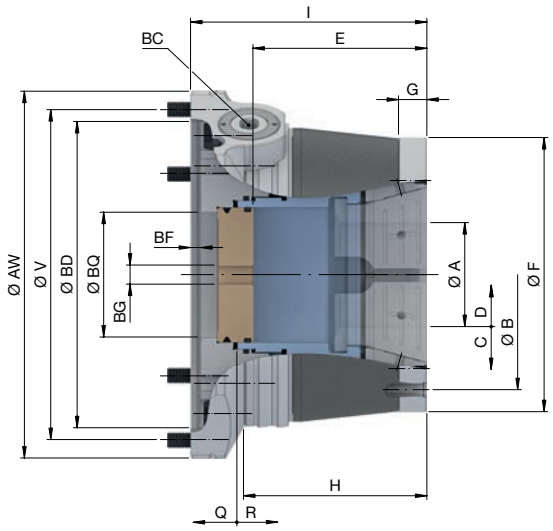
Product line	Size	Material no.	In stock	Clamping elements and adaptations					
									
				Clamping head SE Page 422	MANDO Adapt T211 SE Page 274	MANDO Adapt T212 SE Page 280	Jaw module SE Page 316	Face driver / morse taper adapter SE Page 324	Magnet module SE Page 332
SE	52	10000174	✔	✔	✔	✔		✔	✔
	65	10000175	✔	✔	✔	✔	✔	✔	✔
	100	10015275	✔	✔	✔	✔	✔	✔	✔
Product line	Size	Material no.	In stock	Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	Jaw module RD Page 316	Face driver / morse taper adapter RD Page 324	Magnet module RD Page 332
RD	52	10000172	✔	✔	✔	✔		✔	✔
	65	10000173	✔	✔	✔	✔	✔	✔	✔
	80	10015262	✔	✔	✔	✔	✔	✔	✔
	100	10015263	✔	✔	✔	✔	✔	✔	✔

Detailed technical data follows.

Scope of delivery

- Chuck without spindle flange
- Base end-stop
- Actuation tool

TOROK CFK SE. Technical data



Product line		SE	
Size		**52**	**65**
Run-out ≤ [mm]		0,015	
Max. radial clamping force [kN]		108	120
Max. axial drawtube force [pull / push] [kN]		40	45
Flange location	BD	Ø 145 H7	Ø 162 H7
Flange fit length [mm]	BF	5,1	
Max. actuating torque [Nm]	BC	75	90
RPM n max. [1/min.]		7000	
Clamping range [mm]	A	3 – 52	3 – 65
Release stroke in Ø [mm]	C	0,6	
Reserve stroke in Ø [mm]	D	1	
Range / recommended workpiece tolerance [mm]		± 0,5	
End-stop depth [mm]	E	90	92
Ø Capacity [mm]	BQ	53	66
End-stop thread size [M]	BG	10	12
Location front end-stop	F	Ø 125 f7	Ø 145 f7
Length [mm]	H	92	97
Centering length [mm]	G	15	
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]
Total length [mm]	I	120	125
Reserve stroke axial [mm]	Q	2	
Release stroke axial [mm]	R	2,5	
Bolt hole circle	V	LK Ø 156 [6 x M8]	LK Ø 176 [6 x M8]
Outer Ø [mm]	AW	174	194
Weight [kg]		7	10,3
In stock		-	-
Material no.		10000486	10000487

Clamping heads	Adaptations I.D. clamping	Adaptations jaw clamping	Face driver / morse taper	Magnet module	Flanges	Accessory overview
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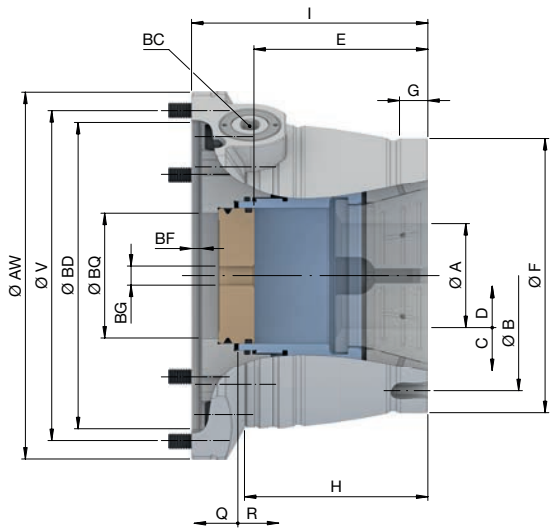
TOROK SE. Technical data



Product line		SE		
Size		**52**	**65**	**100**
Run-out ≤ [mm]		0,015		
Max. radial clamping force [kN]		108	120	150
Max. axial drawtube force [pull / push] [kN]		40	45	65
Flange location	BD	Ø 145 H7	Ø 162 H7	Ø 240 H6
Flange fit length [mm]	BF	5,1		5
Max. actuating torque [Nm]	BC	75	90	
RPM n max. [1/min.]		7000	6000	5000
Clamping range [mm]	A	3 – 52	3 – 65	15 – 100
Release stroke in Ø [mm]	C	0,6		2
Reserve stroke in Ø [mm]	D	2		1,5
Range / recommended workpiece tolerance [mm]		± 0,5		± 1,0
End-stop depth [mm]	E	90	92	
Ø Capacity [mm]	BQ	53	66	100
End-stop thread size [M]	BG	10	12	
Location front end-stop	F	Ø 125 f7	Ø 145 f7	Ø 195 f7
Length [mm]	H	92	97	67
Centering length [mm]	G	17	14	15
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]	LK Ø 180 [3 x M8]
Total length [mm]	I	120	125	130
Reserve stroke axial [mm]	Q	2		3,1
Release stroke axial [mm]	R	2,5		5
Bolt hole circle	V	LK Ø 156 [6 x M8]	LK Ø 176 [6 x M8]	LK Ø 235 [6 x M10]
Outer Ø [mm]	AW	174	194	260
Weight [kg]		12,6	15,2	32
In stock		✔	✔	✔
Material no.		10000174	10000175	10015275

The bolt hole circle does not have equal division.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Adaptations I.D. clamping
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Adaptations jaw clamping
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Face driver / morse taper
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Magnet module
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Clamping head adapter
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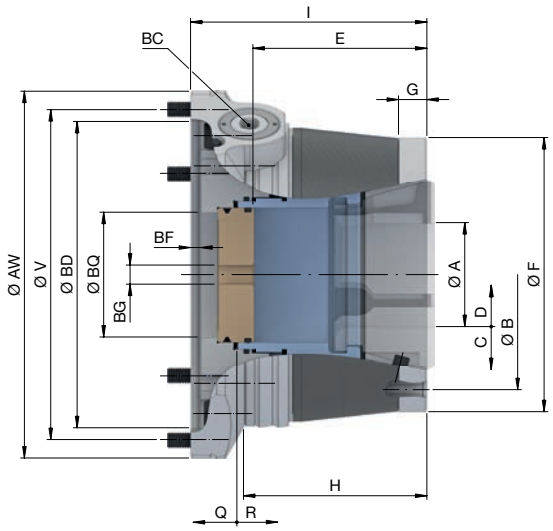
TOROK CFK RD. Technical data



Product line		RD	
Size		**52**	**65**
Run-out ≤ [mm]		0,010	
Max. radial clamping force [kN]		94	105
Max. axial drawtube force [pull / push] [kN]		40	45
Flange location	BD	Ø 145 H7	Ø 162 H7
Flange fit length [mm]	BF	5,1	
Max. actuating torque [Nm]	BC	75	90
RPM n max. [1/min.]		7000	
Clamping range [mm]	A	3 – 52	3 – 65
Release stroke in Ø [mm]	C	0,6	
Reserve stroke in Ø [mm]	D	1	
Range / recommended workpiece tolerance [mm]		± 0,5	
End-stop depth [mm]	E	90	92
Ø Capacity [mm]	BQ	53	66
End-stop thread size [M]	BG	10	12
Location front end-stop	F	Ø 125 f7	Ø 145 f7
Length [mm]	H	92	97
Centering length [mm]	G	15	
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]
Total length [mm]	I	120	125
Reserve stroke axial [mm]	Q	2	
Release stroke axial [mm]	R	2,5	
Bolt hole circle	V	LK Ø 156 [6 x M8]	LK Ø 176 [6 x M8]
Outer Ø [mm]	AW	174	194
Weight [kg]		7,3	10,4
In stock		-	-
Material no.		10000488	10000489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Adaptations I.D. clamping
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Adaptations jaw clamping
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Face driver / morse taper
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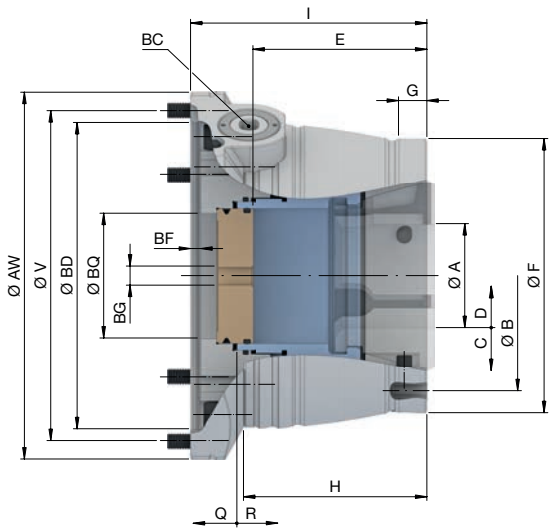
Manual chuck TOROK

TOROK RD. Technical data

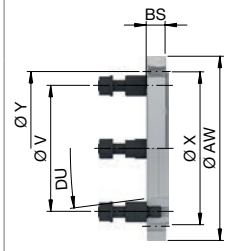


Product line		RD			
Size		**52**	**65**	**80**	**100**
Run-out ≤ [mm]		0,010		0,015	
Max. radial clamping force [kN]		94	105	115	150
Max. axial drawtube force [pull / push] [kN]		40	45	50	65
Flange location	BD	Ø 145 H7	Ø 162 H7	Ø 240 H6	
Flange fit length [mm]	BF	5,1		5	
Max. actuating torque [Nm]	BC	75	90	70	90
RPM n max. [1/min.]		7000	6000	5500	5000
Clamping range [mm]	A	3 – 52	3 – 65	4 – 80	15 – 100
Release stroke in Ø [mm]	C	0,6			2
Reserve stroke in Ø [mm]	D	1			1,5
Range / recommended workpiece tolerance [mm]		± 0,5			± 1,0
End-stop depth [mm]	E	90	92	90	92
Ø Capacity [mm]	BQ	53	66	80	100
End-stop thread size [M]	BG	10	12		
Location front end-stop	F	Ø 125 f7	Ø 145 f7	Ø 160 f7	Ø 195 f7
Length [mm]	H	92	97	57	67
Centering length [mm]	G	17	14	15	
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Total length [mm]	I	120	125		130
Reserve stroke axial [mm]	Q	2		2,1	3,1
Release stroke axial [mm]	R	2,5			5
Bolt hole circle	V	LK Ø 156 [6 x M8]	LK Ø 176 [6 x M8]	LK Ø 235 [6 x M10]	
Outer Ø [mm]	AW	174	194	260	
Weight [kg]		12,6	15,2	32	
In stock		✔	✔	✔	✔
Material no.		10000172	10000173	10015262	10015263

The bolt hole circle does not have equal division.

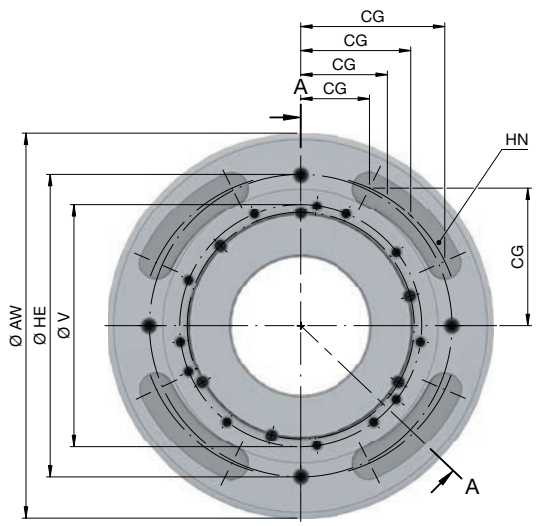
 Clamping heads Page 430	 Adaptations I.D. clamping Page 270	 Adaptations jaw clamping Page 316	 Face driver / morse taper Page 324	 Magnet module Page 332	 Flanges Page 131	 Clamping head adapter Page 513	 Accessory overview Page 478

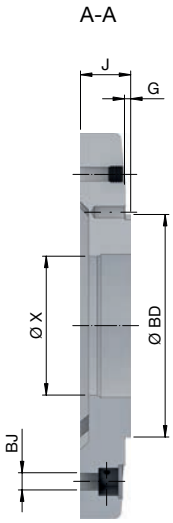
Flanges. For TOROK and TOROK CFK

Size	Figure	Spindle nose DU	Length 2 [mm] BS	Interface X	Interface hole circle Y	Outer Ø [mm] AW	Bolt hole circle V	Variant	In stock	Material no.
52		A2-5	20	Ø 145 g5	LK Ø 156 [6 x M8]	195	LK Ø 104,8 [4 x M10]	Adjustable bolt DIN ISO 702-3 M10x43	✔	10000220
		A2-6					LK Ø 133,4 [4 x M12]	Adjustable bolt DIN ISO 702-3 M12x50	✔	10000221
		A2-8				210	LK Ø 171,4 [4 x M16]	Adjustable bolt DIN ISO 702-3 M16x60	✔	10000222
65		A2-5	20	Ø 162 g5	LK Ø 176 [6 x M8]	195	LK Ø 104,8 [4 x M10]	Adjustable bolt DIN ISO 702-3 M10x43	✔	10000223
		A2-6					LK Ø 133,4 [4 x M12]	Adjustable bolt DIN ISO 702-3 M12x50	✔	10000224
		A2-8				210	LK Ø 171,4 [4 x M16]	Adjustable bolt DIN ISO 702-3 M16x60	✔	10000225
80/100		A2-5	26,5	Ø 240 g5	LK Ø 235 [6 x M10]	260	LK Ø 104,8 [4 x M10]	Adjustable bolt DIN ISO 702-3 M10x43	✔	10015276
		A2-6	20				LK Ø 133,4 [4 x M12]	Adjustable bolt DIN ISO 702-3 M12x50	✔	10015277
		A2-8	26,5				LK Ø 171,4 [4 x M16]	Adjustable bolt DIN ISO 702-3 M16x60	✔	10015278

Camlock flange [DIN 55029] on request.

TOROK base plate for stationary use e.g. on a machining center. Technical data





Size		52 SE / RD	65 SE / RD	80/100 SE / RD
Bolt hole circle	V	**LK Ø 156 [6 x M8]**	**LK Ø 176 [6 x M8]**	**LK Ø 234 [6 x M10]**
Flange location	BD	Ø 145 g5	Ø 162 g5	Ø 240 f7
Interface	X	Ø 101 H7		Ø 140 H7
Outer Ø [mm]	AW	280		350
Height [mm]	J	36	36,5	35
Centering length [mm]	G	4	4,5	3,5
Mounting slots for T-groove table with groove spacing [mm]	CG	50, 63, 80, 100		
Groove width [mm]	BJ	12,5		13,5
Protective cover	HN	4x		
Torsional safety	HE	220 [4 x M10]		300 [4 x M10]
Weight [kg]		10,5	10,7	17
In stock		✔	✔	✔
Material no.		10001437	10001436	10001434

Manual chuck TOROK

InoFlex

Compensating 4-jaw clamping device

The new InoFlex VT-S and VD 4-jaw compensating chucks enable optimal clamping of round, rectangular, and geometrically irregular workpieces or workpieces that are susceptible to deformation during turning operations.

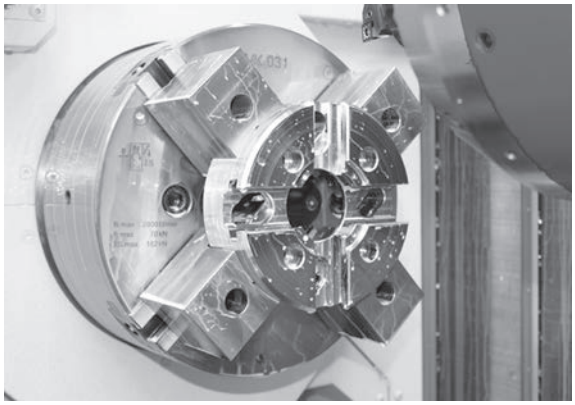
Thanks to the 4-jaw workholding technology, with which the jaw pairs enclose the center in a manner that provides compensation, the workpiece is always clamped centered – no matter how asymmetric it is. Compensation is achieved by connecting the sliding carriages located in the circle by means of levers.

This ensures substantially safer and more stable clamping than with conventional 3-jaw chucks or non-compensating concentric clamping vises. You can therefore switch between workpieces with different geometries and clamping diameters, without the need for additional clamping devices.

They are suitable for clamping of blanks and finished parts; they compensate in the case of blanks and provide for excellent repeatability in the case of finished parts.

Key advantages

- 4-sided clamping [2x2] with compensation of the opposing jaws
- Ideal for clamping workpieces that are susceptible to deformation
- For I.D. and O.D. clamping
- High repeatability and run-out accuracy



InoFlex in use

InoFlex manual / power chuck

InoFlex chuck types

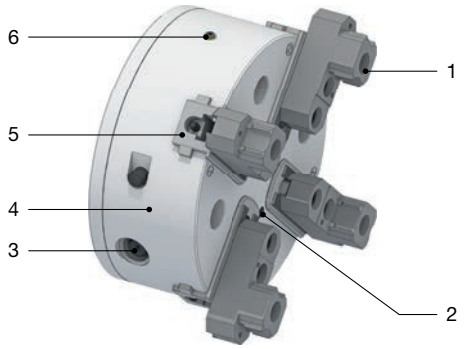
	InoFlex VD	InoFlex VT-S
		
Applications	Turning	Turning
Actuation	Manually actuated	Power-operated
Sizes	165, 215, 260, 315	165, 215, 260, 315
RPM n max.	3500	5000
Clamping range of all sizes [mm]	8 – 315	10 – 315
Advantages	■ Manual actuation – a clamping cylinder is not required ■ Sensitive clamping possible ■ 4-jaw or 2-jaw clamping possible ■ Clamping against fixed end-stop ■ Drilling area for front end-stop ■ Stationary implementation in the machining center	■ Large through-bore ■ Sensitive clamping possible ■ 4-jaw or 2-jaw clamping possible ■ Drilling area for front end-stop
Clamping elements	 Jaws	 Jaws
Adaptations	 InoZet pendulum bridge  InoTop hybrid chuck jaw	 InoZet pendulum bridge  InoTop hybrid chuck jaw

Applications

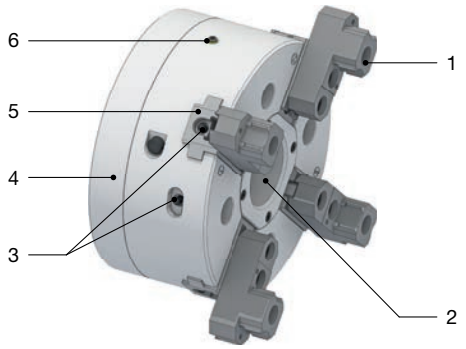
Technical suitability	Vise	3-jaw chuck	InoFlex
Clamping of asymmetrical workpieces	✘	✘	✔
Clamping of round workpieces	✘	✔	✔
Clamping of cubic workpieces	✔	✘	✔
Clamping workpieces that are susceptible to deformation	✘	✘	✔
I.D. clamping	✘	✔	✔
Centric compensating clamping	✘	✘	✔

✔ = suitable ✘ = unsuitable

InoFlex VD [manual chuck without capacity] in detail

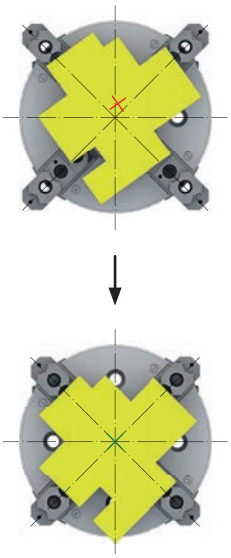
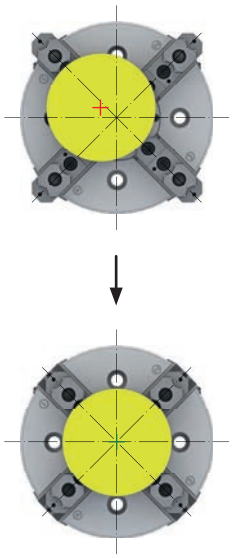
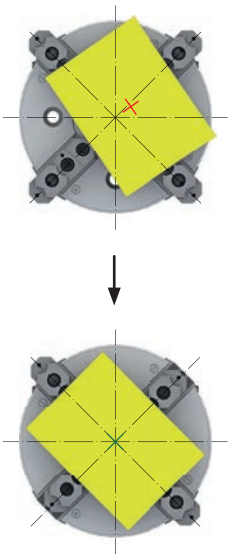
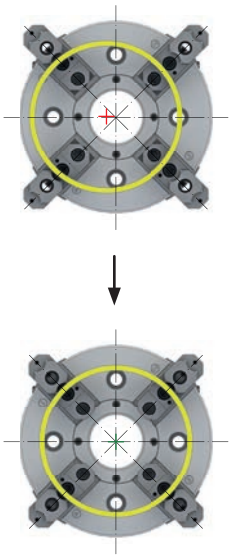
Designation	
1 Adjustable top jaws with fine serration 2 Innovative lubricating system with grease nipple in the chuck body and for each jaw guide 3 Manual actuation via socket wrench 4 Stable base body 5 Base jaw with serration for use with different top jaws 6 Clamping reserve indicator [shows whether safe or unsafe clamping is present in the stroke range]	

InoFlex VT-S [power chuck with capacity] in detail

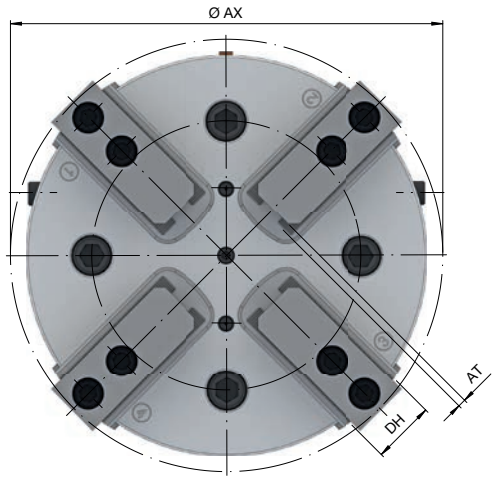
Designation	
1 Adjustable top jaws with fine serration 2 Large capacity for bar material or chuck parts 3 Innovative lubricating system with grease nipple in the chuck body and for each jaw guide 4 Stable base body 5 Base jaw with serration for use with different top jaws 6 Clamping reserve indicator [shows whether safe or unsafe clamping is present in the stroke range]	

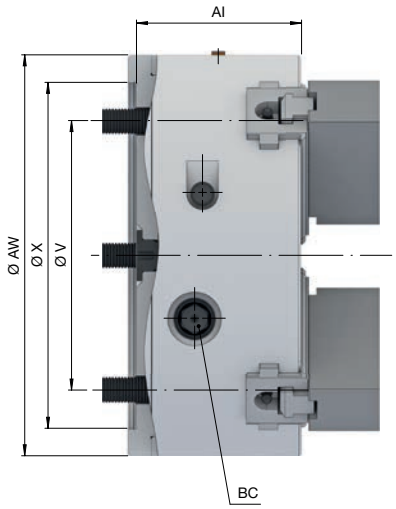
InoFlex manual / power chuck

Centric compensating clamping possibilities

Workpiece type	Asymmetric	Round	Cubic	Susceptible to deformation
Workpiece example	 Flame cutout 200 x 200 mm	 Saw cut Ø 150 mm	 Rectangular 150 x 200 mm	 Ring Ø 210 mm
Advantages	■ Simple centric clamping through jaw adjustment	■ Compensation of the roundness error on the raw material	■ Simple centric clamping through jaw adjustment	■ Uniform clamping force distribution on four jaws ■ Precision compensation
Clamping situation				

InoFlex VD manual chuck. Technical data





Size		165	215	260	315
Variant		VD			
Run-out ≤ [mm]		0,020			
Max. clamping force [kN]		70	85	100	125
Max. actuating torque [Nm]	BC	70	120	160	200
RPM n max. [1/min.]		3500	3000	2700	2200
Stroke per jaw [mm]	AT	4,3	5,2		6,1
Compensating stroke for each jaw [mm]		2,5	3,5		4
Length without jaws [mm]	AI	76	85	105	130
Jaw width [mm]	DH	31	36	40	
Bolt hole circle	V	LK Ø 104,8 [4 x M10]	LK Ø 133,4 [4 x M12]	LK Ø 171,4 [4 x M16]	
Outer Ø [mm]	AW	165	210	255	315
Swing Ø	AX	185	230	275	330
Interface	X	Ø 140	Ø 170	Ø 220	
Weight [kg]		12	22	39	75
In stock		✔	✔	✔	✔
Material no.		10001155	10001156	10001157	10001158

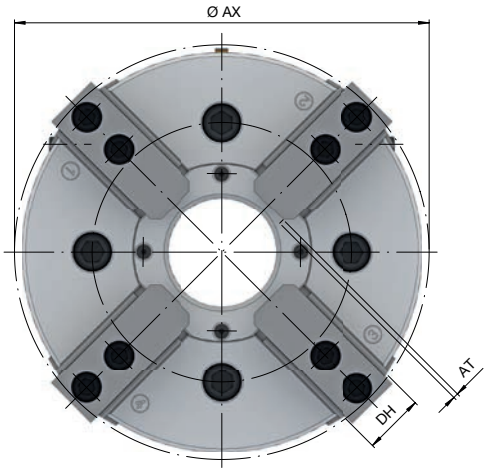
The run-out is related to the already machined top jaws.

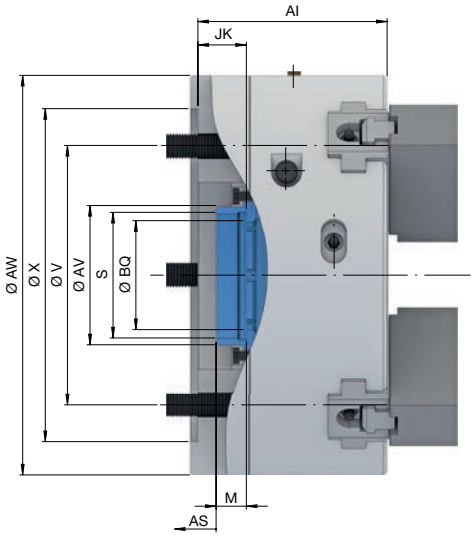
		
Jaws Page 458	Flanges Page 141	Accessory overview Page 478

Scope of delivery

- Chuck without spindle flange
- Top jaws, soft
- T-slot nuts
- Grease cartridge
- Fit-on wrench socket for actuation tool

InoFlex VT-S power chuck. Technical data





Size		165	215	260	315
Variant		VT-S			
Run-out ≤ [mm]		0,020			
Max. clamping force [kN]		52	100	125	150
Max. axial drawtube force [pull / push] [kN]		20	40	50	60
RPM n max. [1/min.]		5000	3900	3500	3000
Stroke per jaw [mm]	AT	3,4	4,3	5	5,5
Compensating stroke for each jaw [mm]		2,3	3,3	4,0	4,4
Ø Capacity [mm]	BQ	46	52	72	91
Length without jaws [mm]	AI	88	109,2	125	134
Jaw width [mm]	DH	32	34	42	46
Connecting thread inside	S	M56 x 1,5	M60 x 2	M85 x 2	M100 x 2
Piston stroke [mm]	AS	15	19	22	24
Bolt hole circle	V	LK Ø 104,8 [4 x M10]	LK Ø 133,4 [4 x M12]	LK Ø 171,4 [4 x M16]	LK Ø 235 [4 x M22]
Outer Ø [mm]	AW	168	218	264	315
Inner Ø [mm]	AV		67	92	112
Swing Ø	AX	178	222	274	326
Interface	X	Ø 140	Ø 170	Ø 220	Ø 300
Depth of thread [mm]	M	18	20		24
Thread position in unclamped position [mm]	JK	33	36	32	40
Weight [kg]		12	26	42	64
In stock		✔	✔	✔	✔
Material no.		10015194	10015199	10015201	10015202

The run-out is based on soft, bored top jaws.

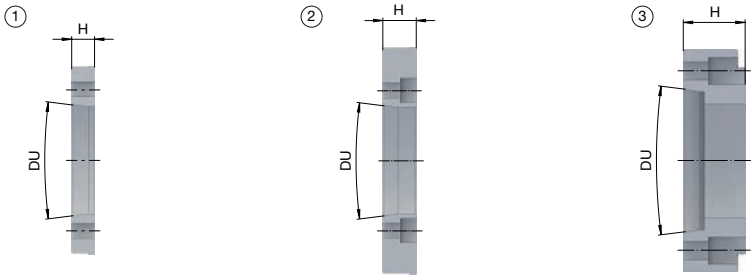
The InoFlex VT-S replaces the InoFlex VT with better technology. This offers a higher repeatability [≤ 0.006 mm] and easier in-house machining of the soft top jaws.


Jaws Page 458 | Flanges Page 141 | Accessory overview Page 478

Scope of delivery

- Chuck without spindle flange
- Top jaws, soft
- T-slot nuts
- Grease cartridge
- Assembly wrench for revolving threaded ring

Flanges for InoFlex short taper. Technical data



Size	Suitable for	Spindle nose DU	Designation	Flange type	Length [mm] H	In stock	Material no.
165	VD / VT-S	A2-5	VZ165	1	17	✔	10014728
		A2-6	VZ166	3	46	✔	10014729
		A2-8	VZ168		35	✔	10014730
215	VD / VT-S	A2-5	VZ265	2	25	✔	10014736
		A2-6	VZ266	1	17	✔	10014737
		A2-8	VZ268	3	44	✔	10014738
260/315	VD [size 260/315] / VT-S [size 260]	A2-6	VZ366	2	28	✔	10014744
		A2-8	VZ368	1	19	✔	10014745
		A2-11	VZ3611	3	47	✔	10014746
315	VT-S	A2-8	VZ468	2	30	✔	10014751
		A2-11	VZ4611	1		✔	10014752

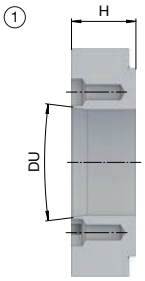
Machine spindle standard DIN DIN 55026 / ISO 702-1.

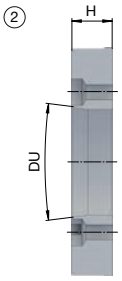
Flanges for InoFlex short taper with bayonet. Technical data

Size	Suitable for	Spindle nose DU	Designation	Flange type	Length [mm] H	In stock	Material no.
165	VD / VT-S	A2-5	VZ175	1	17	✔	10014731
		A2-6	VZ176	2	46	✔	10014732
		A2-8	VZ178		34	✔	10014733
215	VD / VT-S	A2-5	VZ275	1	19	✔	10014739
		A2-6	VZ276			✔	10014740
		A2-8	VZ278	2	40	✔	10014741
260/315	VD [size 260/315] / VT-S [size 260]	A2-6	VZ376	1	28	✔	10014747
		A2-8	VZ378			✔	10014748
315	VT-S	A2-8	VZ478	1	36	✔	10014753
		A2-11	VZ4711			✔	10014754

Machine spindle standard DIN 55027 / ISO 702-3.

Flanges for InoFlex short taper with camlock. Technical data





Size	Suitable for	Spindle nose DU	Designation	Flange type	Length [mm] H	In stock	Material no.
165	VD / VT-S	A2-5	VZ195	2	48	✔	10014734
		A2-6	VZ196		52,5	✔	10014735
215	VD / VT-S	A2-5	VZ295	1	30	✔	10014742
		A2-6	VZ296	2	55	✔	10014743
260/315	VD [size 260/315] / VT-S [size 260]	A2-6	VZ396	1	34	✔	10014749
		A2-8	VZ398		56	✔	10014750
315	VT-S	A2-8	VZ498	1	38	✔	10014755
		A2-11	VZ4911		52	✔	10014756

Machine spindle standard DIN DIN 55029 / ISO 702-2.

InoFlex manual / power chuck

B-Top

A large through-bore, for a reason

Jaw chuck B-Top

Fast jaw change with quick change design and high repeatability – that is what makes the B-Top jaw chuck product line so flexible. Particularly for small lot sizes. Thus in most cases machining the chuck jaw to size is unnecessary. Also the insert bushing system is configured for small lot sizes and maximum flexibility. It enables clamping devices to be conveniently adapted to your requirement: Closed with ejector, spray nozzles, or with variable end-stop. Just the way you need it. And the innovative lubricating system ensures improved clamping force behavior of the wedge bar principle.

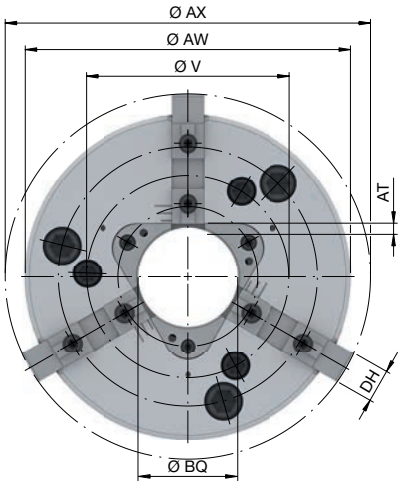
Key advantages

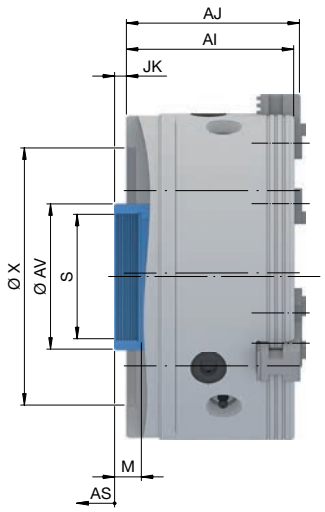
- Fast jaw change with individual unlocking
- Large through-bore with bushing inserts that can be changed from the front
- Proven wedge rod mechanism

B-Top jaw chuck in use

Jaw chuck B-Top

Jaw chuck B-Top. Technical data and order overview





Size		165	215	260	315
Variant		B-Top			
Run-out ≤ [mm]		0,020		0,025	0,030
Max. clamping force [kN]		41	74	115	160
Max. axial drawtube force [pull / push] [kN]		30	46	65	90
RPM n max. [1/min.]		6000	5400	4000	3600
Stroke per jaw [mm]	AT	5,9	7,4	8,2	8,6
Ø Capacity [mm]	BQ	43	66	81	104
Length without jaws [mm]	AI	89	104,6	123,3	132,1
Length with jaws [mm]	AJ	94,4	109,4	129,5	139,8
Jaw width [mm]	DH	20	22	26	32
Connecting thread inside	S	M54 x 1,5	M78 x 1,5	M90 x 2	M115 x 2
Piston stroke [mm]	AS	20	25	28	
Bolt hole circle	V	LK Ø 104,8 [3 x M10]	LK Ø 133,4 [3 x M12]	LK Ø 171,4 [3 x M16]	
Outer Ø [mm]	AW	165	215	260	315
Inner Ø [mm]	AV	68	96	118	148
Swing Ø	AX	191.4	265.8	315	375.4
Interface	X	Ø 140	Ø 170	Ø 220	
Depth of thread [mm]	M	15	17	20,3	22,7
Thread position in unclamped position [mm]	JK	35,2	42,2	48,5	51,2
Weight [kg]		13	24	42	66
In stock		✔	✔	✔	✔
Material no.		10002027	10002028	10002029	10002030

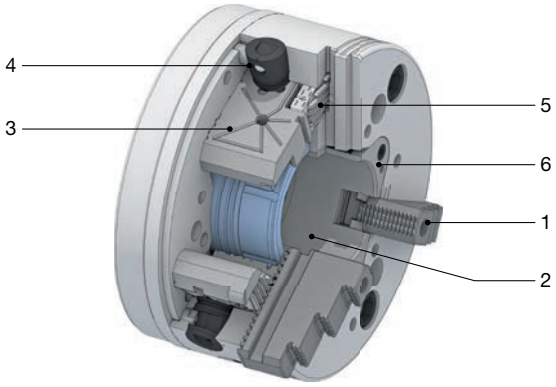
The full functional range is guaranteed only in combination with HAINBUCH universal grease Material no. 10001489 and high-pressure grease gun Material no. 10001493.
The run-out refers to soft, milled top jaws.
The clamping range depends on the jaws that are used.

		
Jaws Page 454	Flanges Page 147	Accessory overview Page 478

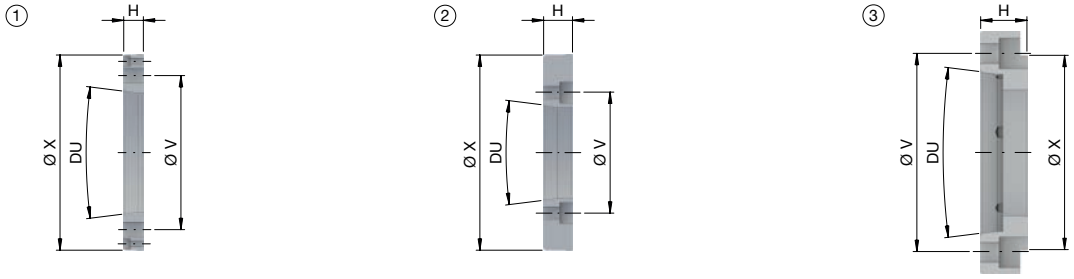
Scope of delivery

- Jaw chuck
- Master jaws
- Actuation tool
- Assembly wrench for revolving threaded ring [size 260/315]

Jaw chuck B-Top in detail

Designation	
1 Jaws with cross offset 2 Large chuck through-bore 3 Innovative lubricating system, consequently longer lubricating intervals and improved clamping force behavior 4 Operational safety when changing jaws due to ball mechanism: The actuating wrench can only be pulled off if the wedge bar is properly engaged in the master jaw 5 Locking mechanism in the wedge bar enables a secure master jaw position and thus guarantees secure mesh of the master jaw gearing in the wedge bar 6 Different insert bushings for fast adaptation to the machining requirements	

Flanges for jaw chuck B-Top

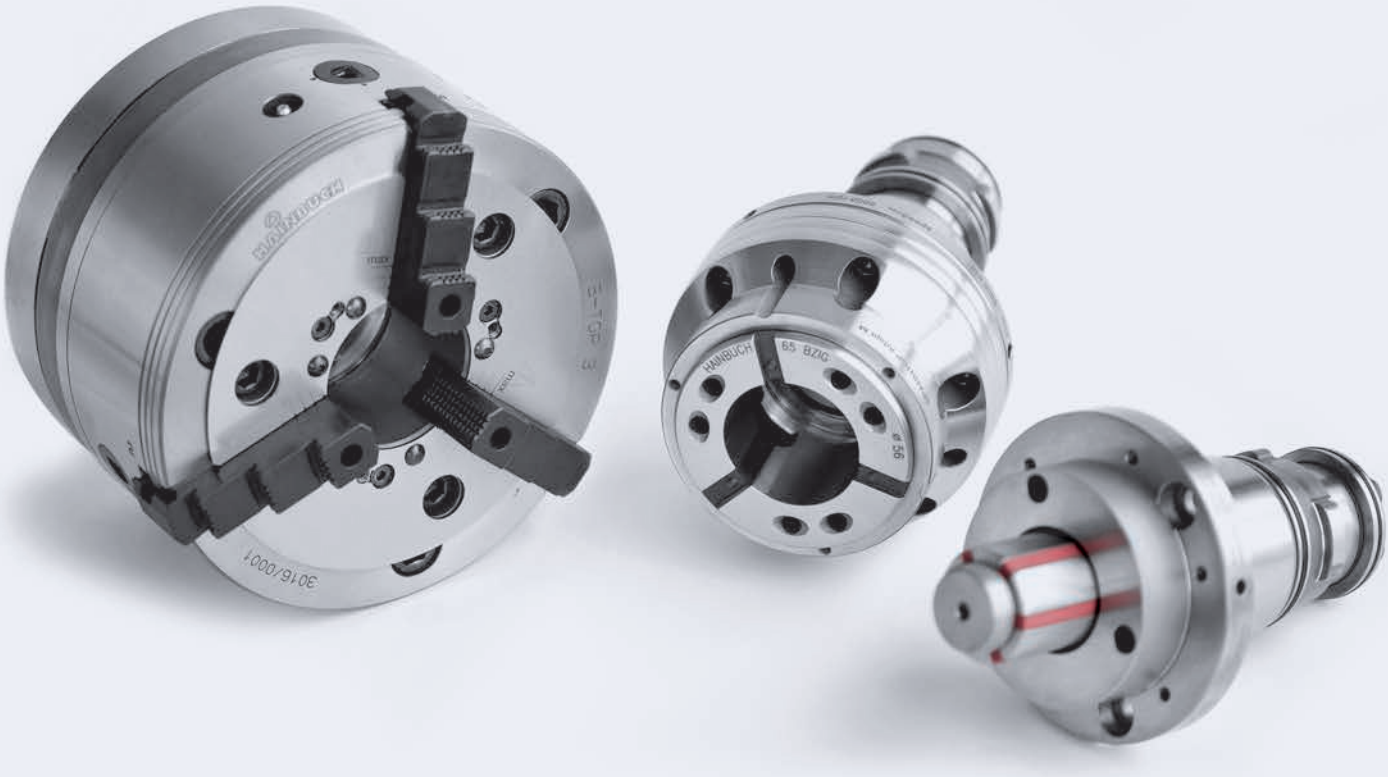


Size	Spindle nose DU	Flange type	Interface X	Length [mm] H	Bolt hole circle V	In stock	Material no.
165	A2-4	2	Ø 140	21	LK Ø 82,6 [6 x M10]	✔	10014760
	A2-5	1		16	LK Ø 104,8 [6 x M10]	✔	10014761
	A2-6	3		34	LK Ø 133,4 [6 x M12]	✔	10014762
215	A2-5	2	Ø 170	25	LK Ø 104,8 [6 x M10]	✔	10014763
	A2-6	1		17	LK Ø 133,4 [6 x M12]	✔	10014764
	A2-8	3		40	LK Ø 171,4 [6 x M16]	✔	10014765
260/315	A2-5	2	Ø 220	28	LK Ø 104,8 [6 x M10]	✔	10014766
	A2-6				LK Ø 133,4 [6 x M12]	✔	10014767
	A2-8	1		19	LK Ø 171,4 [6 x M16]	✔	10014768
	A2-11	3		50	LK Ø 235 [6 x M16]	✔	10014769

Machine spindle standard DIN 55026.

B-Top3

All fits in one another



I.D., O.D. or jaw clamping – it's easy with the B-Top3 system. Everything fits together. With the MANDO Adapt segmented mandrel, you can change to perfect I.D. clamping in less than 2 minutes. The SPANNTOP adaptation is the right partner if you have reached your holding power and accuracy limits for O.D clamping. And all without disassembling the jaw chuck!

However, the B-Top3 basic clamping device also has its advantages: The fast change of jaws with a single-jaw unlocking mechanism and high repeatability is ideal especially for small lot sizes. Machining the chuck jaw to size is therefore unnecessary in most cases. Also, the insert bushing system is configured for small lot sizes and maximum flexibility. It enables clamping devices to be conveniently adapted to your requirements: closed, with ejector, spray nozzles or variable end-stop. Just the way you need it. And the innovative lubricating system improves clamping force behavior with the wedge bar principle.

You have never turned like this before.

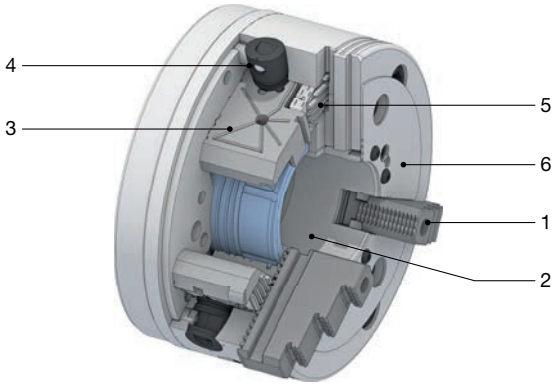
Key advantages

- Jaw chuck with quick conversion to a segmented clamping bushing [I.D. clamping] and a clamping head [O.D. clamping]
- Fast jaw change with individual unlocking
- Large through-bore with bushing inserts that can be changed from the front
- Proven wedge rod mechanism

B-Top3 in use

Jaw chuck B-Top3

Jaw chuck B-Top3 in detail

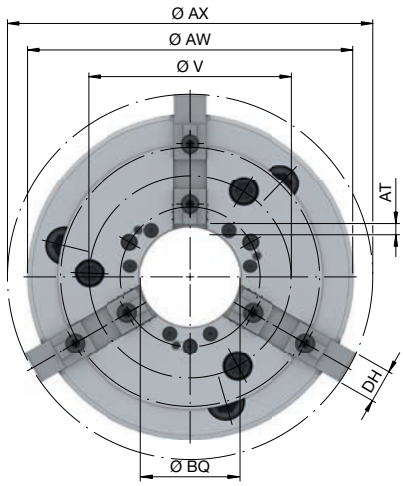
Designation	
1 Jaws with cross offset 2 Large chuck bore with CENTREX interface for ultra-precise change-over without adjustment 3 Innovative lubricating system, consequently longer lubricating intervals and improved clamping force behavior 4 Operational safety when changing jaws due to ball mechanism: The actuating wrench can only be pulled off if the wedge bar is properly engaged in the master jaw 5 Locking mechanism in the wedge bar enables a secure master jaw position and thus guarantees secure mesh of the master jaw gearing in the wedge bar 6 Different insert bushings for fast adaptation to the machining requirements	

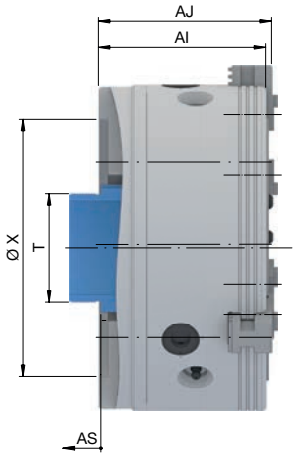
Order overview. Jaw chuck B-Top3

			Clamping elements and adaptations			
						
Size	Material no.	In stock	Jaws for jaw chuck B-Top Page 454	MANDO Adapt for jaw chuck Page 154	SPANNTOP Adapt Page 155	SPANNTOP Adapt M Page 155
215	10002031	✔	✔	✔	✔	✔

Detailed technical data follows.
The full functional range is only guaranteed if HAINBUCH universal grease, material no. 10001489, and high-pressure grease gun, material no. 10001493 are used.

Jaw chuck B-Top3. Technical data





Size		215
Variant		**B-Top3**
Run-out ≤ [mm]		0,020
Max. clamping force [kN]		74
Max. axial drawtube force [pull / push] [kN]		46
RPM n max. [1/min.]		5400
Stroke per jaw [mm]	AT	7,4
Ø Capacity [mm]	BQ	62
Length without jaws [mm]	AI	104,6
Length with jaws [mm]	AJ	109,4
Jaw width [mm]	DH	22
Connecting thread outside	T	M72 x 1,5
Piston stroke [mm]	AS	25
Bolt hole circle	V	LK Ø 133,4 [3 x M12]
Outer Ø [mm]	AW	215
Swing Ø	AX	265.8
Interface	X	Ø 170
Weight [kg]		29,5
In stock		✔
Material no.		10002031

The run-out refers to soft, milled top jaws.
The clamping range depends on the jaws that are used.

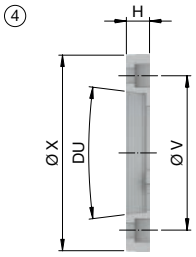
				
Jaws Page 454	Flanges Page 152	Adaptations I.D. clamping Page 154	Adaptations O.D. clamping Page 155	Accessory overview Page 478

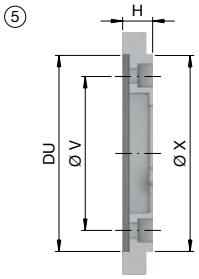
Scope of delivery

- Jaw chuck without spindle flange
- Master jaws
- Protection jaws
- Guard bushing for 22 mm wide top jaws
- Actuation tool

Jaw chuck B-Top3

Flanges for jaw chuck B-Top3

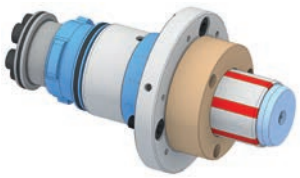




Size	Spindle nose DU	Flange type	Interface X	Length [mm] H	Bolt hole circle V	In stock	Material no.
215	A2-6	4	Ø 170	20	LK Ø 133,4 [6 x M12]	✔	10014757
	A2-8			37	LK Ø 171,4 [6 x M16]	✔	10014758
	AP170	5		20	LK Ø 133,4 [6 x M12]	✔	10014759

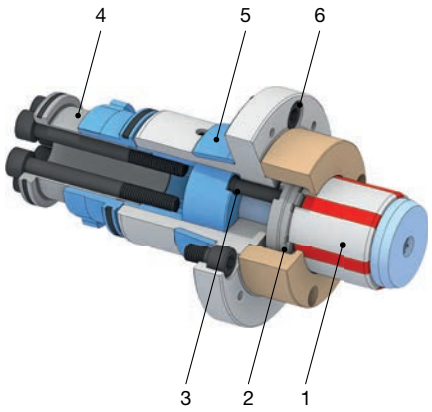
Machine spindle standard DIN 55026.

All adaptation variants at a glance

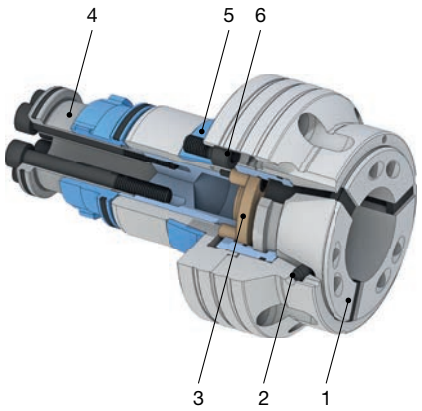
	MANDO Adapt for jaw chuck	SPANNTOP Adapt	SPANNTOP Adapt M
			
Description	Mandrel-in-jaw-chuck with draw bolt	Clamping head end-stop chuck	Clamping head through-bore chuck
Sizes	0, 1, 2, 3	65, 80, 100	65
Clamping range of all sizes [mm]	20 – 80	3 – 100	3 – 65
Ø Capacity			51,3

Attention: These adaptations are configured for a cylinder stroke of 25 mm. For shorter strokes a specially configured adaptation is required.

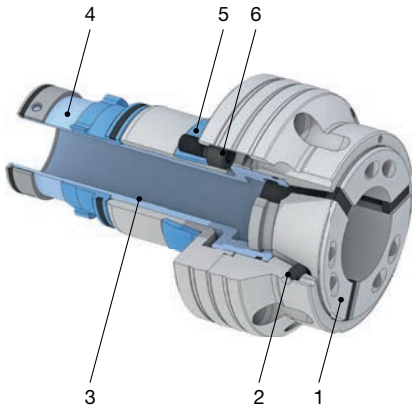
MANDO Adapt in detail

Designation	
1 Segmented clamping bushing with pull-back and hardened steel segments, joined in a vulcanization process 2 Torsional safety lock of segmented clamping bushing 3 Push-off pin 4 Integrated empty stroke. This means it is not necessary to adjust the limit switch on the clamping cylinder 5 CENTREX system for µm-precise use without adjustment 6 Mounting screws	

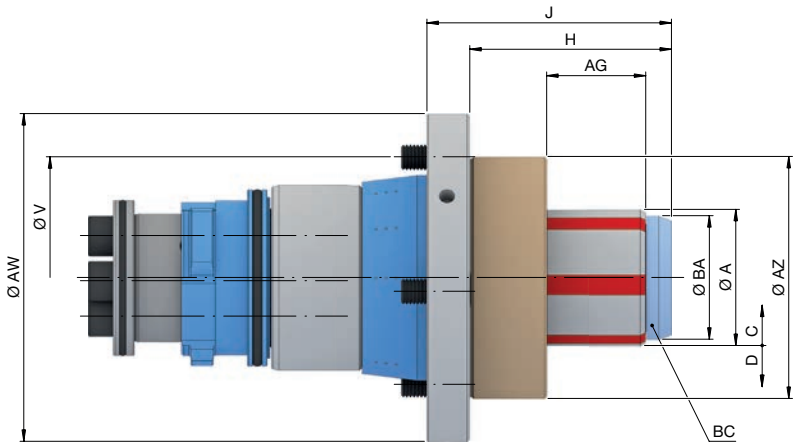
SPANNTOP Adapt in detail [end-stop chuck]

Designation	
1 Clamping head with pull-back and hardened steel segments, joined in a vulcanization process 2 Torsional safety lock of the clamping head 3 Fixed base end-stop for clamping with pull-back effect, central mounting thread for workpiece specific end-stop 4 Integrated empty stroke. This means it is not necessary to adjust the limit switch on the clamping cylinder 5 CENTREX system for µm-precise use without adjustment 6 Mounting screws	

SPANNTOP Adapt M in detail [through-bore chuck]

Designation	
1 Clamping head with pull-back and hardened steel segments, joined in a vulcanization process 2 Torsional safety lock of the clamping head 3 Through-bore Ø 51.3 mm 4 Integrated empty stroke. This means it is not necessary to adjust the limit switch on the clamping cylinder 5 CENTREX system for µm-precise use without adjustment 6 Mounting screws	

MANDO Adapt T211. Technical data and order overview



Size		0	1	2	3
Adaptation size			**215**		
Run-out ≤ [mm]			0,010		
Max. clamping length [mm]	AG	22	26	43	49
Clamping range [mm]	A	20 – 28	26 – 38	36 – 54	50 – 80
Release stroke in Ø [mm]	C		0,3		0,4
Reserve stroke in Ø [mm]	D	0,4		0,5	
Range / recommended workpiece tolerance [mm]			± 0,25		± 0,35
Max. axial drawtube force [pull / push] [kN]		10		20	25
Max. radial clamping force [kN]		42		85	105
RPM n max. [1/min.]			6000		
Length [mm]	H	40	51	71	80
Height [mm]	J	60	71	90	97
Bolt hole circle	V		LK Ø 104,8 [3 x M10]		
Outer Ø [mm]	AW		130		
Draw bolt Ø [mm]	BA	19		35	49
Max. actuating torque [Nm]	BC	10	20	25	55
End-stop outer Ø [mm]	AZ	65	69	93	96
Weight [kg]		4		5	
In stock		✔	✔	✔	✔
Material no.		10001564	10001565	10001566	10001567

In addition to the run-out of the MANDO Adapt, the run-out of the jaw chuck must also be taken into account.
Attention: These adaptations are configured for a cylinder stroke of 25 mm. For shorter strokes a specially configured adaptation is required.


Segmented clamping bushings
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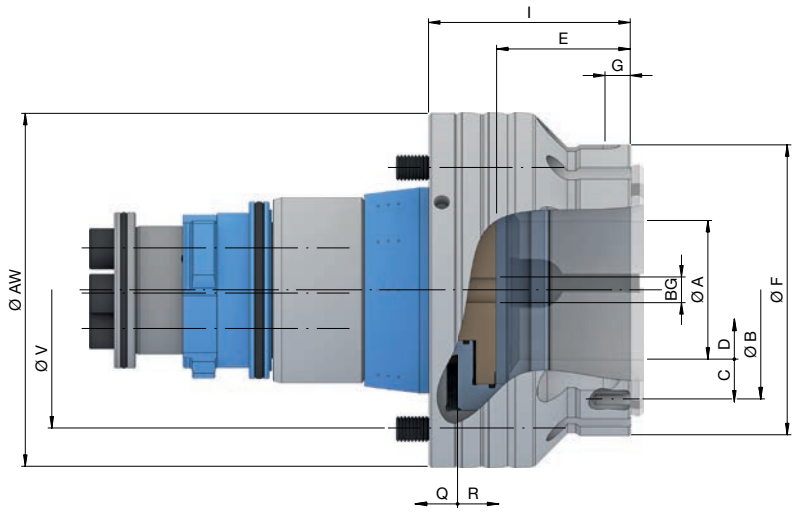
Scope of delivery

- Mandrel adaptation
- Draw bolt

SPANNTOP Adapt. Technical data and order overview



Size		65	80	100
Clamping range [mm]	A	**3 – 65**	**4 – 80**	**15 – 100**
Run-out ≤ [mm]		0,010		
Max. radial clamping force [kN]		105	115	150
Max. axial drawtube force [pull / push] [kN]		45	50	65
Reserve stroke in Ø [mm]	D	1		1,5
Release stroke in Ø [mm]	C	0,6		2
RPM n max. [1/min.]		6000	5500	5000
Reserve stroke axial [mm]	Q	2		3
Release stroke axial [mm]	R	2,5		5
Location front end-stop	F	Ø 115 f7	Ø 145 f7	Ø 191 f7
Bolt hole circle end-stop	B	LK Ø 107 [3 x M5]	LK Ø 130 [3 x M6]	LK Ø 168 [3 x M8]
Centering length [mm]	G	10		
End-stop depth [mm]	E	53	52	63,5
End-stop thread size [M]	BG	12		
Total length [mm]	I	80	85	110
Outer Ø [mm]	AW	140	182	194
Bolt hole circle	V	LK Ø 120 [3 x M10]	LK Ø 160 [3 x M10]	
Weight [kg]		8	14	20
In stock		✔	✔	✔
Material no.		10001670	10001671	10001672

In addition to the run-out of the SPANNTOP Adapt, the run-out of the jaw chuck must also be taken into consideration.
Attention: These adaptations are configured for a cylinder stroke of 25 mm. For shorter strokes a specially configured adaptation is required.


Clamping heads
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Accessory overview
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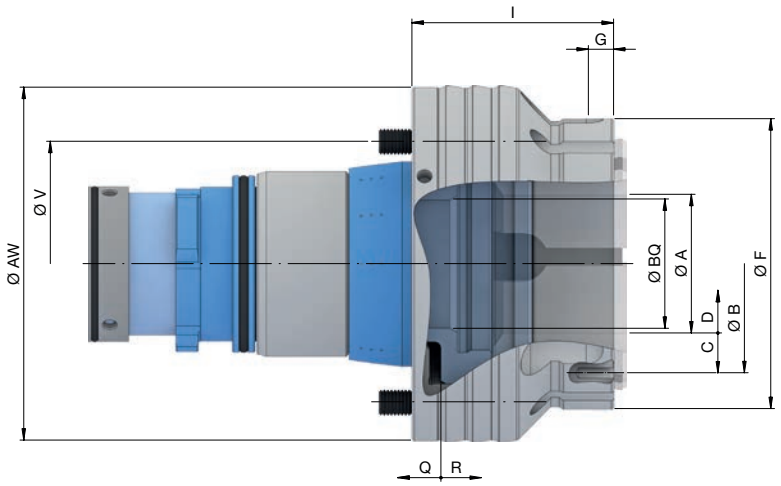
SPANNTOP Adapt M. Technical data and order overview



Size		65
Clamping range [mm]	A	**3 – 65**
Run-out ≤ [mm]		0,010
Max. radial clamping force [kN]		105
Max. axial drawtube force [pull / push] [kN]		45
Reserve stroke in Ø [mm]	D	1
Release stroke in Ø [mm]	C	0,6
RPM n max. [1/min.]		6000
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5
Location front end-stop	F	Ø 115 f7
Bolt hole circle end-stop	B	LK Ø 107 [3 x M5]
Centering length [mm]	G	10
Ø Capacity [mm]	BQ	51,3
Total length [mm]	I	80
Outer Ø [mm]	AW	140
Bolt hole circle	V	LK Ø 120 [3 x M10]
Weight [kg]		8
In stock		✔
Material no.		10001673

In addition to run-out of the SPANNTOP Adapt M, run-out of the jaw chuck must also be taken into consideration.
Attention: These adaptations are configured for a cylinder stroke of 25 mm. For shorter strokes a specially configured adaptation is required.


Clamping heads
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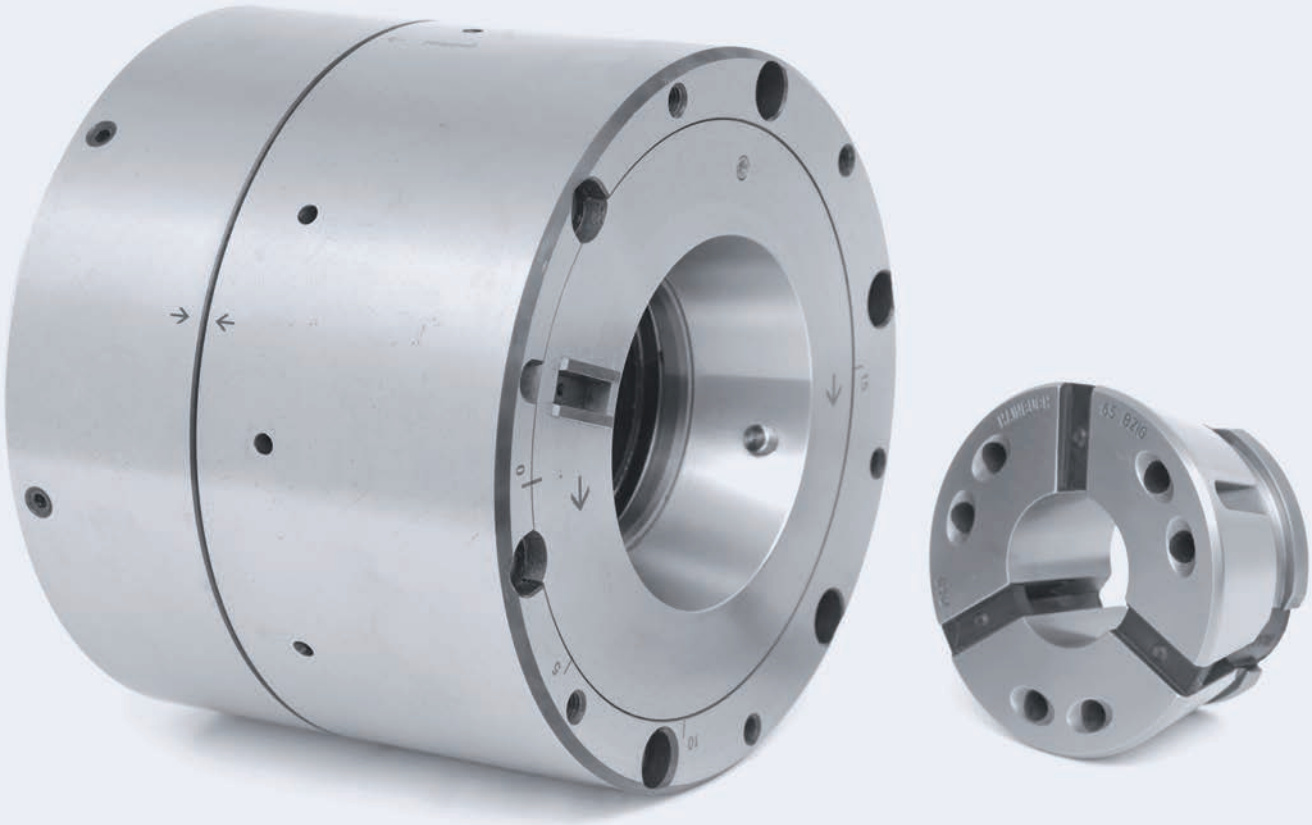
Jaw chuck B-Top3

Eccentric chuck

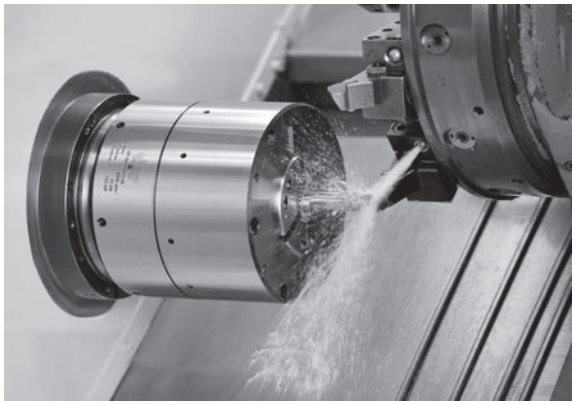
Concentric and eccentric machining in a single clamping set-up



Concentric and eccentric complete machining in a single clamping set-up? That's right! With our compact chuck you can turn an eccentric position on the workpiece – in a single set-up without having to re-chuck it! Thus you save time and money. Change-over from concentric to eccentric takes just a few seconds – it is automatic and convenient due to the setting tool in the turret and the c-axis of the machine spindle. Minimum set-up times and no machine changes whatsoever. And first and foremost: You can use your normal clamping cylinder.

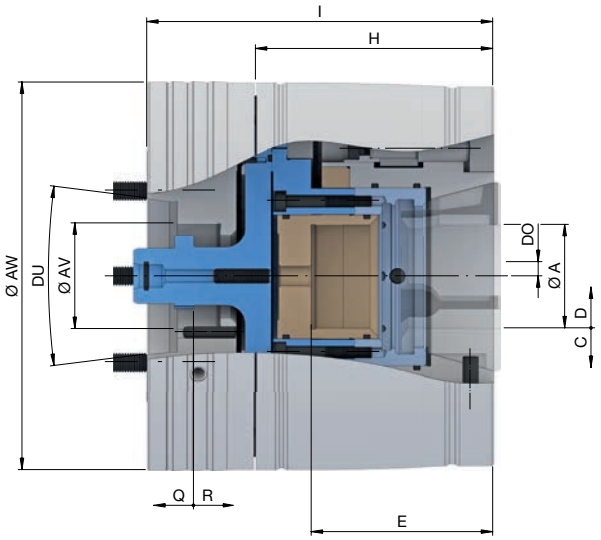
Key advantages

- Infinite eccentric adjustment via the c-axis
- Concentric and eccentric machining in a single clamping set-up
- Different eccentric dimensions are possible with the same chuck and clamping head
- Minimal inertia loss compared to 3-jaw chucks
- Workpiece stabilization through axial draw force applied against the workpiece end-stop
- Standard clamping heads can be used



Eccentric chuck in use

Eccentric chuck. Technical data and order overview



Size		65		
Spindle nose	DU	**A2-5**	**A2-6**	**A2-8**
Run-out ≤ [mm]		0,020		
Max. radial clamping force [kN]		105		
Max. axial drawtube force [pull / push] [kN]		45		
RPM n max. [1/min.]		6000		
Max. eccentricity [mm]	DO	15		
Clamping range [mm]	A	3 – 65		
Release stroke in Ø [mm]	C	0,6		
Reserve stroke in Ø [mm]	D	1		
End-stop depth [mm]	E	96		
Length [mm]	H	125,5		
Total length [mm]	I	183		
Reserve stroke axial [mm]	Q	2		
Release stroke axial [mm]	R	2,5		
Outer Ø [mm]	AW	205		
Inner Ø [mm]	AV	56		
Weight [kg]		40	39,5	38,6
In stock		-	-	-
Material no.		10002123	10002124	10002125

Please note: RPM depends upon the chuck position and workpiece.
Machine spindle standard DIN ISO 702-1.


Clamping heads
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Scope of delivery

- Eccentric chuck
- Adjustment tool

Eccentric chuck

Machine specific chucks

Photo: INDEX-Werke GmbH & Co. KG

Machine specific chucks

Standard or machine specific, which chuck fits?

In 90 % of all cases, you will find what you are looking for with our standard chucks, that fit for the following brands, such as:

- Biglia
- Daewoo
- Doosan
- Emco
- Gildemeister
- MAG Boehringer
- MAG Hessapp
- Mazak
- Miyano
- Monforts
- Mori Seiki
- Nakamura
- Okuma
- Scherer
- Spinner
- Takamaz
- Weiler
- Weisser
- and other machine tool manufacturers.

For certain lathes we have designed special chucks that take the connection or other equipment features of the respective machine into account. You will find a selection to the right, such as

- EMAG
- INDEX
- TRAUB
- LEHMANN rotary indexing tables

Of course, we still have much more in the product line. Simply ask us about it.

EMAG

SPANNTOP nova chuck for EMAG

Size	Variant	Machine type	Spindle nose	Connecting thread outside	In stock	Material no.
80	Combi pull-back	VSC 200 / VL	A2-5	M20 x 2,5	✔	10001846
100	Combi pull-back	VSC 250 / VL 5	A2-6	M20 x 2,5	✔	10001847

Machine spindle standard DIN 55026.

INDEX

TOPlus mini chuck für INDEX

Size	Variant	Machine type	Ø Capacity [mm]	Spindle nose	Connecting thread inside	In stock	Material no.
65	Deadlength	G160-D65 / C65 / C200-D65 / ABC65 HSP / R200 D65 / G220-D65	66	AP140	M76 x 1,5	✔	10000599

SPANNTOP nova chuck for INDEX

Size	Variant	Machine type	Ø Capacity [mm]	Spindle nose	Connecting thread inside	In stock	Material no.
42	Combi pull-back	C100-D42 / A100-D42	43	A2-5	M52 x 1,5	✔	10001845
	Combi deadlength	A100-D42 / C100	42,5			-	10001859
65	Combi pull-back	G160-D65 / C65 / C200-D65 / ABC65 / G220-D65	66	AP140	M76 x 1,5	✔	10001857
	Combi deadlength	C200 / G160 / R200-D65	67			✔	10001860
	Modular	G220-D65				✔	10001843
100	Modular	C200-D100	91	A2-8	M100 x 1,5	✔	10001841

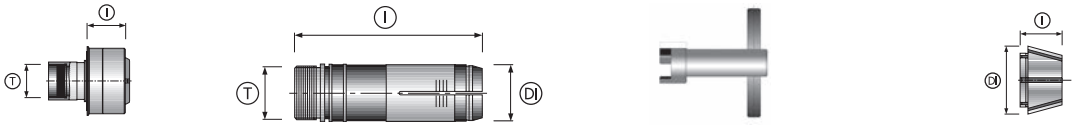
Machine spindle standard DIN 55026.

SPANNTOP chuck for INDEX

Size	Variant	Machine type	Ø Capacity [mm]	Spindle nose	Connecting thread outside	Connecting thread inside	In stock	Material no.
42	Combi deadlength	G200-42 / G160-42	43	A2-5		M52 x 1,5	✔	10001712
	Modular	ABC36/42 / G160-D42 / G200-D42	44,1		M52 x 1,5		✔	10001690
		C100-D42	44			M52 x 1,5	✔	10001693
65	Combi pull-back	G200-D60	61,5	AP85		M69 x 1,5	-	10001696
	Combi deadlength		62				-	10001669
	Modular	C200-D65 / G160-D65 / R200-D65	65,5	AP140		M76 x 1,5	✔	10001688
		ABC52/60 / G200-D60	61		M69 x 1,5		✔	10001689
		ABC / G200-D65	68			M74 x 1,5	✔	10001691
100	Modular	G300-D90	91	A2-8		M100 x 1,5	✔	10001685
		G300-D102	103			M112 x 1,5	✔	10001694

Machine spindle standard DIN 55026.

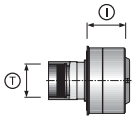
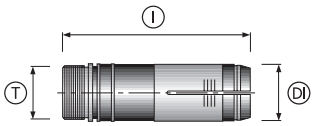
INDEX ABC 36 / 42. Machine specific chucks incl. accessories

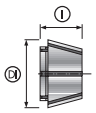


Product variants	Product	Profile	Clamping range [mm]	Type of serration	Base bore Ø [mm]	Head Ø [mm] DI	Connecting thread outside T	Total length [mm] l	In stock	Material no.
	Machine specific SPANNTOP chucks						M52 x 1,5	81	✔	10001690
	Manual changing fixture								✔	10006986
SPANNTOP BZI	Clamping head RD	●	4,0 - 7,5	Smooth		80		47	✔	sk42bzir4,0-7,5
			8	Radial grooves					✔	sk42bzir8,0
			8,5 - 10,5						✔	sk42bzir8,5-10,5
			11 - 42	Radial and axial grooves					✔	sk42bzir11,0-42,0
		■	7	Smooth					✔	sk42bziv7,0
			8 - 10	Radial grooves					✔	sk42bziv8,0-10,0
			11 - 28						✔	sk42bziv11,0-28,0
		⬢	7	Smooth					✔	sk42bzis7,0
			8 - 10	Radial grooves					✔	sk42bzis8,0-10,0
			11 - 37						✔	sk42bzis11,0-37,0

Product variants	Product	Profile	Clamping range [mm]	Type of serration	Base bore Ø [mm]	Head Ø [mm] DI	Connecting thread outside T	Total length [mm] l	In stock	Material no.
RS system	Outer sleeve					39,6	M40 x 1 - LH	116	✔	254e/rs
	Inner collet steel	●	4,0 - 32,0						✔	rs32/st/r4,0-32,0
		■	7,0 - 9,0						-	rs32/st/v7,0-9,0
			10,0 -21,0						-	rs32/st/v10,0-21,0
		⬢	7,0 - 9,0						-	rs32/st/s7,0-9,0
			10,0 - 27,0						-	rs32/st/s10,0-27,0
	Inner collet steel brass	●	4,0 - 32,0						-	rs32/sb/r4,0-32,0
		■	7,0 - 9,0						-	rs32/sb/v7,0-9,0
			10,0 - 22,0						-	rs32/sb/v10,0-22,0
		⬢	7,0 - 9,0						-	rs32/sb/s7,0-9,0
			10,0 - 27,0						-	rs32/sb/s10,0-27,0
	Inner collet SPH	●	4,0 - 32,0						-	rs32/sph/r4,0-32,0
		■	7,0 - 9,0						-	rs32/sph/v7,0-9,0
			10,0 - 22,0						-	rs32/sph/v10,0-22,0
		⬢	7,0 - 9,0						-	rs32/sph/s7,0-9,0
			10,0 - 27,0						-	rs32/sph/s10,0-27,0
	Inner collet KSB	●	4,0 - 29,5						-	rs32/ksb/r4,0-29,5
		■	8,0 - 9,0						-	rs32/ksb/v8,0-9,0
			10,0 - 22,0						-	rs32/ksb/v10,0-22,0
		⬢	8,0 - 9,0						-	rs32/ksb/s8,0-9,0
			10,0 - 27,0						-	rs32/ksb/s10,0-27,0
	Inner collet OXK	●	8,0 - 9,0						-	rs32/ksb/s8,0-9,0
			10,0 - 27,0						-	rs32/ksb/s10,0-27,0
	Wrench								✔	10008171
	Guide ring for feed tube	●							-	254e/f-c
	Segmented collet		4,0 - 42,0	Smooth		59,57		39	✔	sz42r4,0-42,0
			7,0 - 9,0						-	sz42v7,0-9,0
			10,0 - 29,0						-	sz42v10,0-29,0
			7,0 - 9,0						✔	sz42s7,0-9,0
			10,0 - 36,0						✔	sz42s10,0-36,0
	Segmented collet for machining to size				8				✔	10013417
					15				✔	10013415
					30				✔	10013416
	Spindle head adapter plate								✔	10001419

INDEX ABC 52 / 60. Machine specific chucks incl. accessories



Product variants	Product	Profile	Clamping range [mm]	Type of serration	Base bore Ø [mm]	Head Ø [mm] DI	Connecting thread outside T	Total length [mm] l	In stock	Material no.
	Machine specific SPANNTOP chucks					99,5	M69 x 1,5	81	✔	10001689
	Manual changing fixture								✔	10006991
SPANNTOP BZI	Clamping head RD	●	4,0 - 7,5	Smooth		99,5		58	✔	sk65bzir4,0-7,5
			8	Radial grooves					✔	sk65bzir8,0
			8,5 - 10,5						✔	sk65bzir8,5-10,5
			11 - 65	Radial and axial grooves					✔	sk65bzir11,0-65,0
		■	8 - 10	Radial grooves					✔	sk65bziv8,0-10,0
			11 - 45						✔	sk65bziv11,0-45,0
		⬢	7	Smooth					✔	sk65bzis7,0
			8 - 10	Radial grooves					✔	sk65bzis8,0-10,0
			11 - 55						✔	sk65bzis11,0-55,0
RS system	Outer sleeve					57,6	M58 x 1 - LH	140	✔	10001868
	Inner collet steel	●	6,0 - 48,0						✔	rs50/st/r6,0-48,0
		■	12,0 - 34,0						-	rs50/st/v12,0-34,0
		⬢	6,0 - 9,0						-	rs50/st/s6,0-9,0
			10,0 - 41,0						-	rs50/st/s10,0-41,0
	Inner collet steel brass	●	6,0 - 48,0						-	rs50/sb/r6,0-48,0
		■	12,0 - 34,0						-	rs50/sb/v12,0-34,0
		⬢	6,0 - 9,0						-	rs50/sb/s6,0-9,0
			10,0 - 41,0						-	rs50/sb/s10,0-41,0
	Inner collet SPH	●	6,0 - 48,0						-	rs50/sph/r6,0-48,0
		■	12,0 - 34,0						-	rs50/sph/v12,0-34,0
		⬢	6,0 - 9,0						-	rs50/sph/s6,0-9,0
			10,0 - 41,0						-	rs50/sph/s10,0-41,0
	Inner collet KSB	●	12,0 - 44,5						-	rs50/ksb/r12,0-44,5
		■	12,0 - 31,0						-	rs50/ksb/v12,0-31,0
		⬢	12,0 - 41,0						-	rs50/ksb/s12,0-41,0

Product variants	Product	Profile	Clamping range [mm]	Type of serration	Base bore Ø [mm]	Head Ø [mm] DI	Connecting thread outside T	Total length [mm] l	In stock	Material no.
RS system	Inner collet OXK	●	12,0 - 20,0						-	rs50/oxk/r12,0-20,0
			20,1 - 40,0						-	rs50/oxk/r20,1-40,0
			40,1 - 46,0						-	rs50/oxk/r40,1-46,0
	Wrench								✔	10008179
	Guide ring for feed tube	●							-	273e/f-c
	Segmented collet		4,0 - 42,0	Smooth		59,57		39	✔	sz42r4,0-42,0
			7,0 - 9,0						-	sz42v7,0-9,0
			10,0 - 29,0						-	sz42v10,0-29,0
			7,0 - 9,0						✔	sz42s7,0-9,0
			10,0 - 36,0						✔	sz42s10,0-36,0
	Segmented collet for machining to size				8				✔	10013417
					15				✔	10013415
					30				✔	10013416
	Spindle head adapter plate								✔	10001419

SPH = special cast coating; KSB = plastic coating; OXK = oxidized ceramic coating

TRAUB

TOPlus mini chuck for TRAUB

Size	Variant	Machine type	Ø Capacity [mm]	Spindle nose	Connecting thread outside	In stock	Material no.
40	Deadlength	TNL32 GSP	33	A2-4	M42 x 1,5 - LH	✔	10000600

Machine spindle standard DIN ISO 702-1.

SPANNTOP nova chuck for TRAUB

Size	Variant	Machine type	Ø Capacity [mm]	Spindle nose	Connecting thread inside	In stock	Material no.
65	Modular	TNX 65/42	67	A2-6	M75 x 1,5	-	10001839

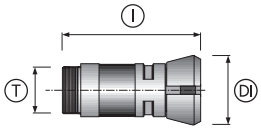
Machine spindle standard DIN 55026.

SPANNTOP chuck for TRAUB

Size	Variant	Machine type	Ø Capacity [mm]	Spindle nose	Connecting thread outside	Connecting thread inside	In stock	Material no.
36	Combi deadlength	TNK36 GS	36	A2-4	M42 x 1,5		-	10001717
42	Combi deadlength	TNC 42	46	A2-5		M54 x 1,5	-	10001709
65	Combi deadlength	TNC 65 / TNX 65-D65	67	A2-6	M74 x 1,5		✔	10001710
	Modular	TNA 300/400-65 / TND350/G / TND 400 / TNS 65				M74 x 1,5	-	10001683

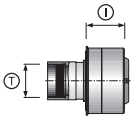
Machine spindle standard DIN 55026.

TRAUB TNK26/32. Machine specific chucks incl. accessories - main spindle



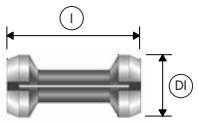
Product	Profile	Clamping range [mm] A	Head Ø [mm] DI	Connecting thread outside T	Total length [mm] l	In stock	Material no.
Basic body			69,7	M42 x 1,5 - LH	132,3	✔	1105/0005
Clamping head ZW	●	4 – 36	69,7			✔	sk6970zwr4,0-36,0
	■	7 – 9				-	sk6970zwv7,0-9,0
		10 – 24				-	sk6970zwv10,0-24,0
	⬢	7 – 9				✔	SK6970ZWS7,0-9,0
		10 – 30				✔	sk6970zws10,0-30,0
Manual changing fixture						✔	10006985
Assembling aid						✔	10006685

TRAUB TNK26/32. Machine specific chucks incl. accessories - sub spindle



Product	Profile	Clamping range [mm] A	Head Ø [mm] DI	Connecting thread outside T	Total length [mm] l	In stock	Material no.
Machine specific SPANNTOP chucks				M42 x 1,5	90	-	10001717
Clamping head ZWG	●	4 – 36	69,7			✔	sk6970zwgr4,0-36,0
	■	7 – 9				-	sk6970zwgv7,0-9,0
		10 – 24				-	sk6970zwgv10,0-24,0
	⬢	7 – 9				-	sk6970zwgs7,0-9,0
		10 – 30				-	sk6970zwgs10,0-30,0

TRAUB TNK26/32



Product	Profile	Clamping range [mm] A	Head Ø [mm] DI	Total length [mm] l	In stock	Material no.
Segmented collet	●	5 – 32	42	90	✔	sb.d/0001r5,0-32,0
	■	8 – 22			-	sb.d/0001v8,0-22,0
	⬢	8 – 27			-	sb.d/0001s8,0-27,0

LEHMANN

TOPlus mini chuck for pl Lehmann rotary indexing tables

Size	Variant	Type	Spindle nose	In stock	Material no.
26	Pull-back	507	HSK-A63	-	10001281
	Deadlength	91x	A2-5	-	10018251
		507	HSK-A63	-	10001285
40	Pull-back	91x	A2-5	-	10018230
	Deadlength			-	10018252
52	Pull-back	510	HSK-A63	-	10001282
		520		-	10001283
	Deadlength		A2-5	-	10001287
		91x		-	10018708
		510	HSK-A63	-	10001286
65	Pull-back	530	A2-8	-	10001284
	Deadlength			-	10001288

Incl. drawtube adapter for direct assembly on the rotary indexing table.

SPANNTOP mini chuck for pl Lehmann rotary indexing tables

Size	Variant	Type	Spindle nose	In stock	Material no.
32	Pull-back	507	HSK-A63	-	10001289
	Deadlength			-	10001293
52	Pull-back	520	A2-5	-	10001291
		510	HSK-A63	-	10001290
	Deadlength	520	A2-5	-	10001295
		510	HSK-A63	-	10001294
65	Pull-back	530	A2-8	-	10001292
	Deadlength			-	10001296

Incl. drawtube adapter for direct assembly on the rotary indexing table.

TOROK manual chuck for pl Lehmann rotary indexing tables

Product line	Size	Type	Spindle nose	In stock	Material no.
SE	52	520	A2-5	-	10001301
		510	HSK-A63	-	10001300
	65	530	A2-8	-	10001302
RD	52	520	A2-5	-	10001298
		510	HSK-A63	-	10001297
	65	530	A2-8	-	10001299

Machine specific chucks