

TOOLING SYSTEMS

HSK63A MQL

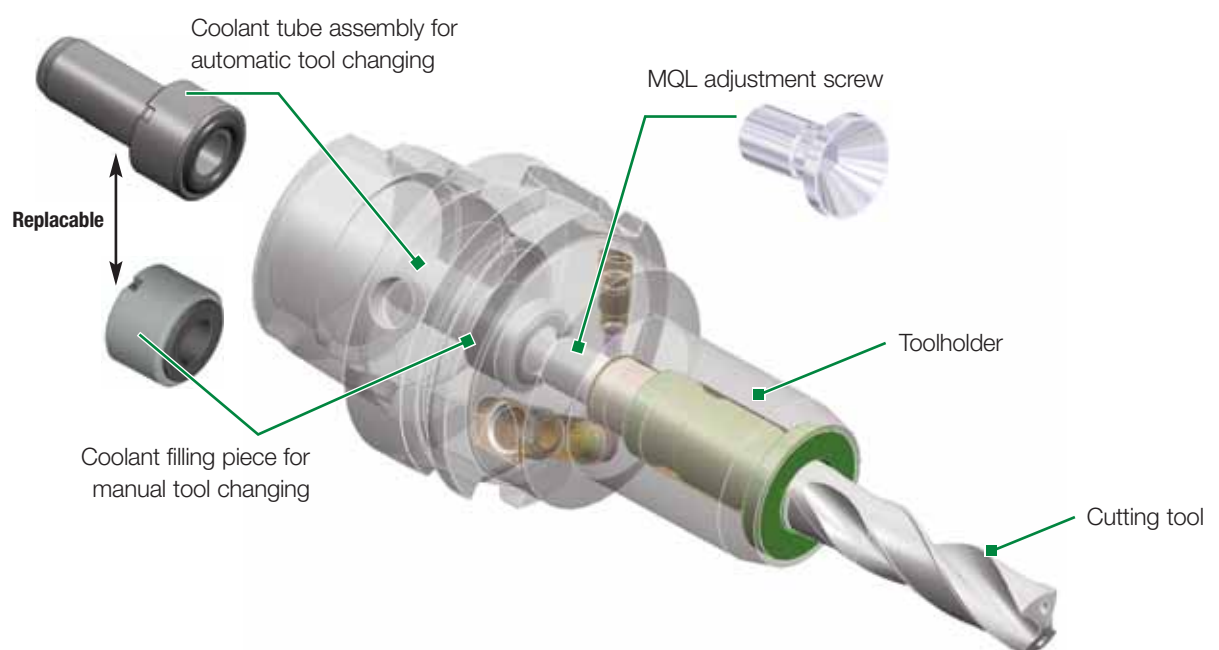
(MINIMUM QUANTITY LUBRICATION)

Erickson™ HSK Shank Tooling System • **HSK63A Series**

WIDIA™ has further developed their successful products, hydraulic chucks and Shrink Fit toolholders, by replacing the individual components for use in wet, dry, and MQL (Minimum Quantity Lubrication) machining applications. The HSK63A Series, well known in the automotive industry, is mainly used for holmaking applications. In dry/MQL machining, more than 70% of the heat is dissipated by the chips creating less abrasive wear.

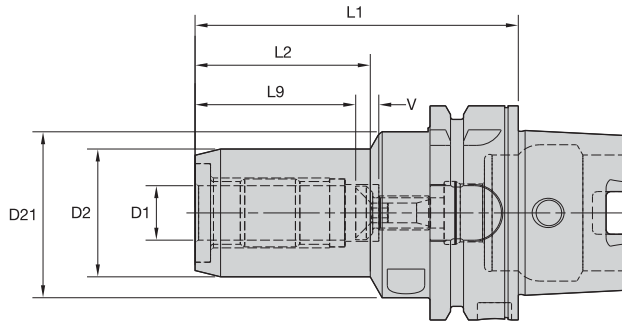
HSK63A

- DIN 69090 1–3 standard.
- Open-source solution.
- Universal for wet, MQL, or dry machining.
- Designed for all straight shanks.
- Equal dimensions for wet and MQL tools.



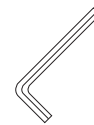
HSK63A Shank Tools

Hydraulic Chucks Standard Trend Line • MQL



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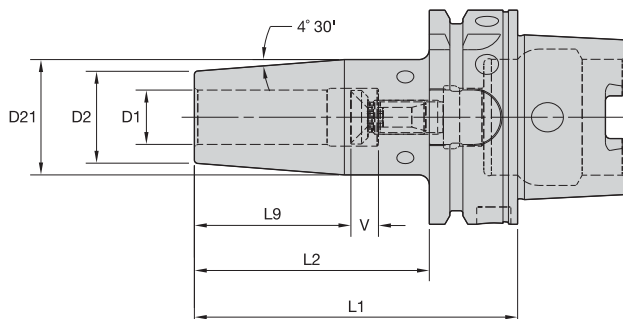
■ HCT • MQL • Metric



order number	catalog number	D1	D2	D21	L1	L2	L9	V	actuation wrench	wrench size actuation screw	length adjustment wrench	wrench size stop screw	kg
5006410	HSK63AHCTMQL1C06080M	6	25,7	50	80	34	27	10	170.135	5 mm	170.002	2.5 mm	1,00
5006411	HSK63AHCTMQL1C08080M	8	27,7	50	80	34	27	10	170.135	5 mm	170.003	3 mm	1,02
5006413	HSK63AHCTMQL1C10085M	10	29,7	50	85	39	31	10	170.135	5 mm	170.004	4 mm	1,06
5006414	HSK63AHCTMQL1C12090M	12	31,6	50	90	45	36	10	170.135	5 mm	—	5 mm	1,09
5006415	HSK63AHCTMQL1C14090M	14	33,6	50	90	46	36	10	170.135	5 mm	—	5 mm	1,11
5006416	HSK63AHCTMQL1C16095M	16	37,6	50	95	52	39	10	170.135	5 mm	—	5 mm	1,21
5006417	HSK63AHCTMQL1C18095M	18	39,6	50	95	52	39	10	170.135	5 mm	—	5 mm	1,24
5006418	HSK63AHCTMQL1C20100M	20	41,6	50	100	58	41	10	170.135	5 mm	—	5 mm	1,31
5006419	HSK63AHCTMQL1C25120M	25	49,8	70	120	53	47	10	170.136	6 mm	170.005	5 mm	2,10
5006430	HSK63AHCTMQL1C32125M	32	59,8	75	125	59	51	10	170.136	6 mm	170.005	5 mm	2,45

NOTE: Do not overtorque actuation screw. Tighten by hand until stop is felt.
Wrenches must be ordered separately.
Supplied with adjusting stop screw.
Reduction sleeves are available and must be ordered separately.
HSK coolant unit and wrench are available and must be ordered separately.
Shank of the cutting tool according to DIN69090.

- Balanceable — fine tune with optional M6 set screws.
- Suitable for carbide and HSS cutting tools (requirements below).



Cutting Tool Shank Requirements
metric (ISO standard)

cutting tool shank diameter	tolerance	
3	h4	0,000/-0,003
4	h4	0,000/-0,004
5	h5	0,000/-0,005
6	h6	0,000/-0,008
8 & 10	h6	0,000/-0,009
12, 14, 16, & 18	h6	0,000/-0,011
20 & 25	h6	0,000/-0,013
32	h6	0,000/-0,016

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■ HPVTT • MQL • Metric



order number	catalog number	D1	D2	D21	L1	L2	L9	V	screw	wrench size stop screw	kg
5008181	HSK63AHPVTTMQL1C06080M	6	21	27	80	54	26	10,0	06ASMQL1C05170M	2.5 mm	0,82
5008182	HSK63AHPVTTMQL1C08080M	8	21	27	80	54	26	10,0	08ASMQL1C06180M	3 mm	0,82
5008183	HSK63AHPVTTMQL1C10085M	10	24	32	85	59	31	10,0	10ASMQL1C08180M	4 mm	0,90
5008184	HSK63AHPVTTMQL1C12090M	12	24	32	90	64	36	10,0	12ASMQL1C10180M	5 mm	0,91
5008185	HSK63AHPVTTMQL1C14090M	14	27	34	90	64	36	10,0	14ASMQL1C10195M	5 mm	0,96
5008186	HSK63AHPVTTMQL1C16095M	16	27	34	95	69	39	10,0	16ASMQL1C10220M	5 mm	0,97
5008187	HSK63AHPVTTMQL1C18095M	18	33	42	95	69	39	10,0	18ASMQL1C10220M	5 mm	1,14
5008188	HSK63AHPVTTMQL1C20100M	20	33	42	100	74	41	10,0	20ASMQL1C10235M	5 mm	1,16
5008189	HSK63AHPVTTMQL1C25115M	25	44	53	115	89	47	10,0	25ASMQL1C10275M	5 mm	1,73
5008210	HSK63AHPVTTMQL1C32120M	32	44	53	120	94	51	10,0	32ASMQL1C10305M	5 mm	1,61

NOTE: Do not overheat. Overheating will destroy the accuracy and functionality of the toolholder.

Supplied with adjusting stop screw.

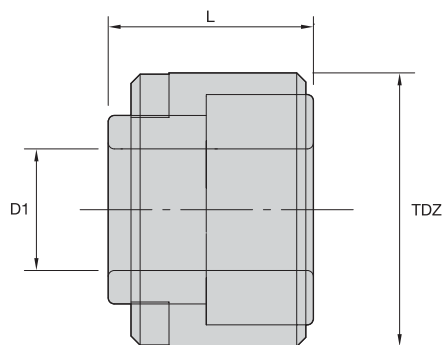
Adjusting stop screw, see page 7.

Optional M6~1.0P x 5mm lg fine-balancing screw set (10 pieces) is available.

Order number is MS1276PKG and must be ordered separately.

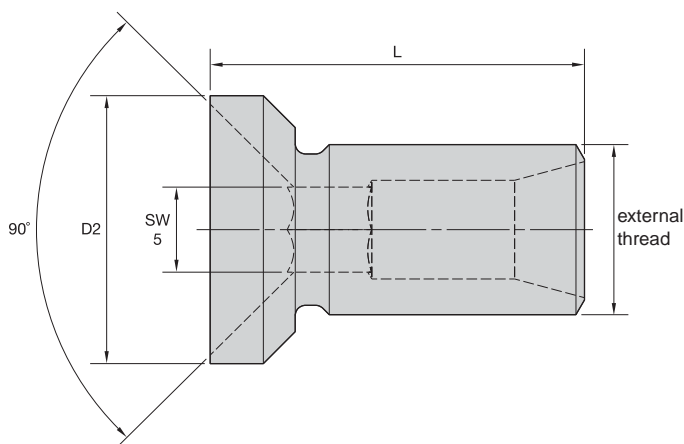
HSK coolant unit and wrench are available and must be ordered separately.

Shank of the cutting tool according to DIN69090.



■ FP • MQL

order number	catalog number	D1		L		TDZ
		mm	in	mm	in	
5086819	HSK40AFPMQL1C050095M	5,00	.197	9,50	.374	M12 X 1.0
5086840	HSK50AFPMQL1C064115M	6,40	.252	11,50	.453	M16 X 1.0
5086841	HSK63AFPMQL1C080135M	8,00	.315	13,50	.532	M18 X 1.0
5086842	HSK80AFPMQL1C080155M	8,00	.315	15,50	.610	M20 X 1.5
5086843	HSK100AFPMQL1C080175M	8,00	.315	17,50	.689	M24 X 1.5



■ AS • MQL

order number	catalog number	D2		L		external thread size	I.D. drive size
		mm	in	mm	in		
5086710	06ASMQML1C05170M	6	.226	17,00	.669	M5	2.5 mm
5086711	08ASMQML1C06180M	8	.305	18,00	.709	M6	3 mm
5086712	10ASMQML1C08180M	10	.384	18,00	.709	M8 X 1	4 mm
5086713	12ASMQML1C10180M	12	.463	18,00	.709	M10 X 1	5 mm
5086714	14ASMQML1C10195M	14	.541	19,50	.768	M10 X 1	5 mm
5086715	16ASMQML1C10220M	16	.620	22,00	.866	M10 X 1	5 mm
5086716	18ASMQML1C10220M	18	.699	22,00	.866	M10 X 1	5 mm
5086717	20ASMQML1C10235M	20	.778	23,50	.925	M10 X 1	5 mm
5086718	25ASMQML1C10275M	25	1.026	27,50	1.083	M10 X 1	5 mm
5086719	32ASMQML1C10305M	32	1.250	30,50	1.201	M10 X 1	5 mm

Environmental responsibility

We are deeply committed to offering environmentally responsible products that deliver high performance and proven value. With decades of experience in tooling and manufacturing, combined with the synergy of superior engineering, we offer customers some of the most effective opportunities for sustainable manufacturing in the industry.



Sustainable engineering

Leading the way with innovation, engineering, and service in standard and custom tooling. A proven methodology and partnership.

Successful project engineering requires planning, teamwork, and disciplined execution. Through our extensive experience in developing and implementing new project engineering strategies, we have pioneered a proven methodology to help you manufacture new products and bring them to market quickly. Service deliverables are carefully outlined and jointly agreed to before the project begins. We formally evaluate progress and results with you throughout the project through our stage-gate management systems.

With our best-in-class process, you'll experience accelerated time to market, lower overall costs, and reduced risks to implement new technologies.



TOOLING SYSTEMS

HSK63Q MQL

(MINIMUM QUANTITY LUBRICATION)

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