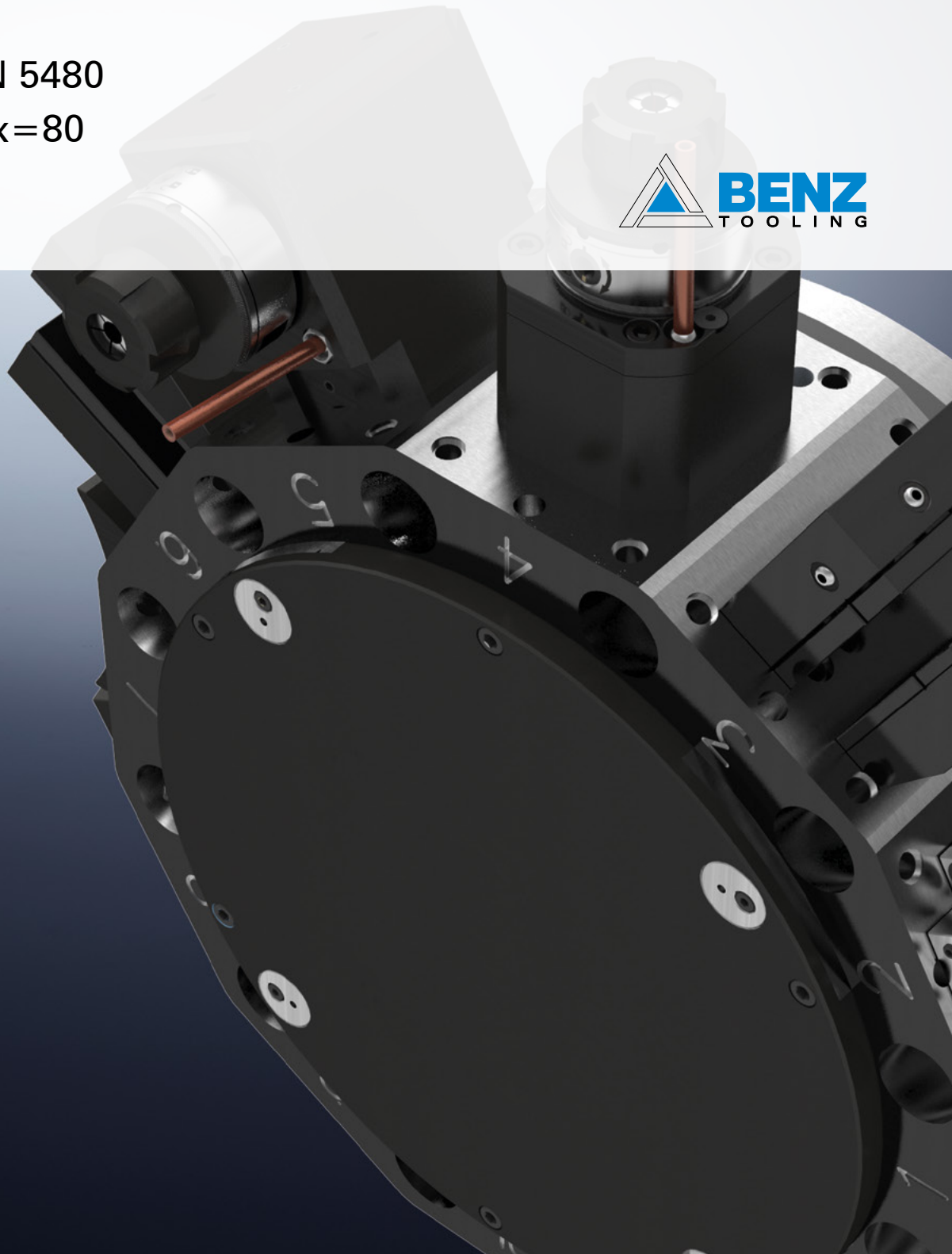


INITIAL TOOLING PACKAGE

VDI 30 - DIN 5480
Star Turret x=80

Metal Machining



INITIAL TOOLING PACKAGE OVERVIEW

VDI 30 - DIN 5480 / STAR TURRET X=80



| Package Content | | | | |
|-------------------|--|-------------------------|--------------|--------------------|
| Product Group | Type | Item Number | Details Page | Quantity / Package |
| LIVE TOOLS | Axial (EC) | 113DA01231E5A | 5 | 3 |
| | Axial (EC) | 113DA01200E5A | 5 | 3 |
| | Axial (EC/IC) | 113EA01231E5A | 5 | 3 |
| | Axial (EC) | 113DA01231S3 | 5 | 3 |
| | Axial (EC) | 113DA01200S3 | 5 | 3 |
| | Axial (EC/IC) | 113EA01231S3 | 5 | 3 |
| | Radial (EC) | 113FAX01239E5A(L/R)-80* | 5 | 3 |
| | Radial (EC/IC) | 113GAX01239E5A(L/R)-80* | 5 | 3 |
| | Radial (EC) | 113FAX01239S3(L/R)-80* | 5 | 3 |
| | Radial (EC/IC) | 113GAX01239S3(L/R)-80* | 5 | 3 |
| STATIC HOLDERS | Face and I.D.Turning Tool: C1 right hand | 113.5612070 | 6 | 2 |
| | Face and I.D.Turning Tool: C3 overhead, right hand | 113.5632070 | 6 | 2 |
| | Face and I.D.Turning Tool: C2 left hand | 113.5622070 | 6 | 2 |
| | Face and I.D.Turning Tool: C4 overhead, left hand | 113.5642070 | 6 | 2 |
| | Multiple Square Seats Turning Tool: D1 | 113.5652042 | 7 | 2 |
| | Boring Bar Holder: □32/H=85mm | 113AP012D32RB-85 | 7 | 3 |
| | Reducing Sleeve: 32/20 | 28.3220G200 | 7 | 3 |
| | Cut-Off Holder SH 26 | 113.583S0002 | 7 | 1 |
| ACCESSORIES | BENZ Solidfix® Adapter: Collet chuck 8° Type ER25 | 693.130E534 | 8 | 6 |
| | Hook Wrench DIN 1810B | D01810B045050 | 8 | 1 |
| | Clamping Wrench: external clamping nut | B136-E5 | 8 | 1 |
| | Clamping Wrench: internal clamping nut | B136-E5AX | 8 | 1 |
| | Inbus T-Wrench | KL8317-45039-SW5 | 9 | 1 |
| | Mounting Block S3 | B300-4-S3 | 9 | 1 |

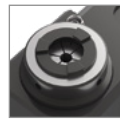
*(L/R) = left or right hand version / for detailed order numbers please see the product table on page 5

ORDER NUMBER

RADIAL TOOLS: LEFT HAND
VERSION

ORDER NUMBER

RADIAL TOOLS: RIGHT HAND
VERSION



Collet Chuck ER25



BENZ Solidfix® S3



PACKAGE 01

PACKAGE 05

PACKAGE 02

PACKAGE 03

PACKAGE 06

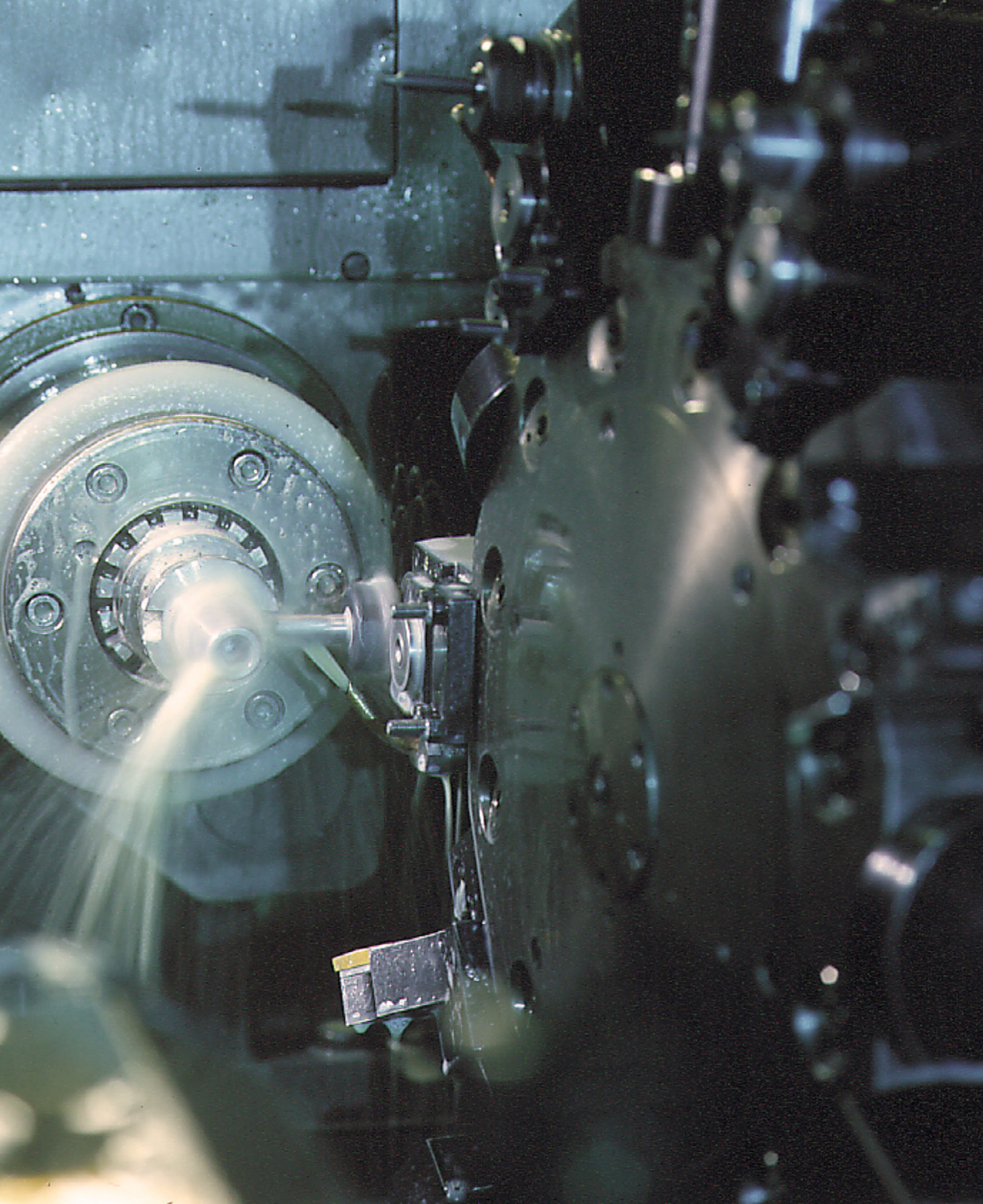
PACKAGE 04

| | | | | | |
|---|--|--|--|---|---|
| Collet Chuck ER25 External coolant supply, long | Collet Chuck ER25 External coolant supply, short | Collet Chuck ER25 External + Internal coolant supply, long | Collet Chuck ER25 External + Internal coolant supply, long | BENZ Solidfix® S3 External coolant supply short | BENZ Solidfix® S3 External + Internal coolant supply long |
|---|--|--|--|---|---|

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|---------------|---------------|---------------|---------------|---------------|---------------|
| 113SET0120001 | 113SET0120005 | 113SET0120002 | 113SET0120003 | 113SET0120006 | 113SET0120004 |
|---------------|---------------|---------------|---------------|---------------|---------------|


| | | | | | |
|---------------|---------------|---------------|---------------|---------------|---------------|
| 113SET0120011 | 113SET0120015 | 113SET0120012 | 113SET0120013 | 113SET0120016 | 113SET0120014 |
|---------------|---------------|---------------|---------------|---------------|---------------|



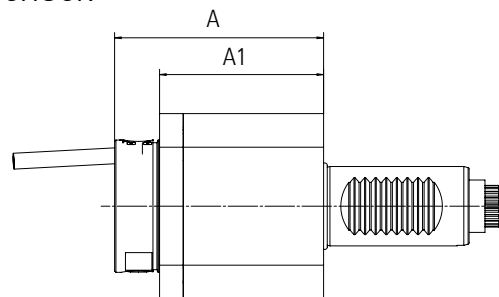
LIVE TOOLS

VDI 30


LIVE TOOL : AXIAL

| Model | Output Spindle | Technical Data | | | | | | Order No. |
|---|----------------|----------------|-----|----|------|-------------|---------------|--------------|
| | | Size | i | EC | IC | A max. [mm] | A1 [mm] | |
|  | BENZ SOLIDFIX® | S3 | 1:1 | ✓ | - | 79 | 62 | 113DA01231S3 |
| | | S3 | 1:1 | ✓ | - | 58 | 40,5 | 113DA01200S3 |
| | | S3 | 1:1 | ✓ | ✓ | 79 | 62 | 113EA01231S3 |
| COLLET CHUCK | ER25 | 1:1 | ✓ | - | 74,9 | 62 | 113DA01231E5A | |
| | | 1:1 | ✓ | - | 53,9 | 40,5 | 113DA01200E5A | |
| | | 1:1 | ✓ | ✓ | 79,9 | 62 | 113EA01231E5A | |

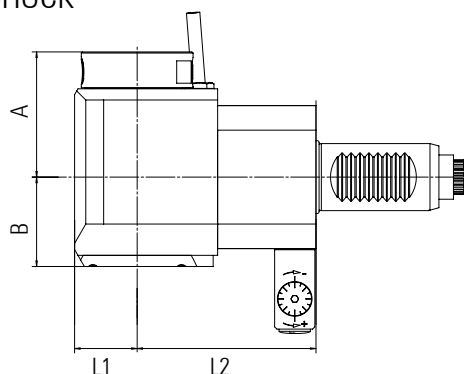
BENZ SOLIDFIX® | COLLET CHUCK



LIVE TOOL : AXIAL

| Model | Output Spindle | Technical Data | | | | | | | | Order No. |
|---|----------------|----------------|-----|----|------|--------|--------|---------|--------------------|-------------------|
| | | Size | i | EC | IC | A max. | B [mm] | L1 [mm] | L2 [mm] | |
|  | BENZ SOLIDFIX® | S3 | 1:1 | ✓ | - | 56 | 40 | 28 | 80 | 113FAX01239S3L-80 |
| | | S3 | 1:1 | ✓ | - | 56 | 40 | 28 | 80 | 113FAX01239S3R-80 |
| | | S3 | 1:1 | ✓ | ✓ | 56 | 58 | 28 | 80 | 113GAX01239S3L-80 |
| | | S3 | 1:1 | ✓ | ✓ | 56 | 58 | 28 | 80 | 113GAX01239S3R-80 |
| COLLET CHUCK | ER25 | 1:1 | ✓ | - | 56,9 | 40 | 28 | 80 | 113FAX01239E5AL-80 | |
| | | 1:1 | ✓ | - | 56,9 | 40 | 28 | 80 | 113FAX01239E5AR-80 | |
| | | 1:1 | ✓ | ✓ | 61,9 | 58 | 28 | 80 | 113GAX01239E5AL-80 | |
| | | 1:1 | ✓ | ✓ | 61,9 | 58 | 28 | 80 | 113GAX01239E5AR-80 | |


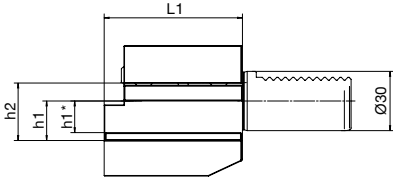
BENZ SOLIDFIX® | COLLET CHUCK




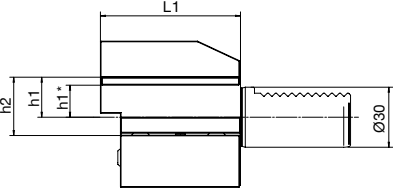
STATIC HOLDERS

VDI 30


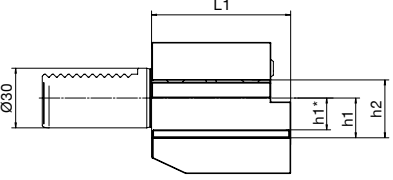
FACE AND I.D. TURNING TOOL - SINGLE

| Model | Drawing | Technical Data | | | Order No. |
|---|---|-------------------|--------------|--------------|-----------------------------|
| | | $h1/h1^*$ [mm] | $h2$ [mm] | $L1$ [mm] | |
|  |  | 20/16 | 29 | 70 | 113.5612070 |


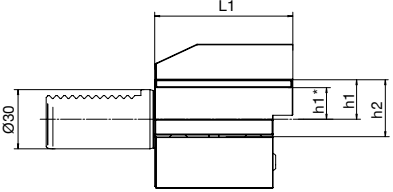
FACE AND I.D. TURNING TOOL - C3 OVERHEAD, RIGHT HAND

| Model | Drawing | Technical Data | | | Order No. |
|--|--|-------------------|--------------|--------------|-----------------------------|
| | | $h1/h1^*$ [mm] | $h2$ [mm] | $L1$ [mm] | |
|  |  | 20/16 | 29 | 70 | 113.5632070 |


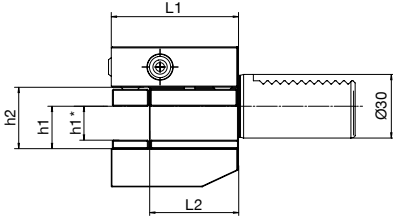
FACE AND I.D. TURNING TOOL - C2 LEFT HAND

| Model | Drawing | Technical Data | | | Order No. |
|---|---|-------------------|--------------|--------------|-----------------------------|
| | | $h1/h1^*$ [mm] | $h2$ [mm] | $L1$ [mm] | |
|  |  | 20/16 | 29 | 70 | 113.5622070 |


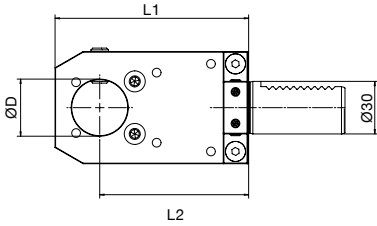
FACE AND I.D. TURNING TOOL - C4 OVERHEAD, LEFT HAND

| Model | Drawing | Technical Data | | | Order No. |
|---|---|-------------------|--------------|--------------|-----------------------------|
| | | $h1/h1^*$ [mm] | $h2$ [mm] | $L1$ [mm] | |
|  |  | 20/16 | 29 | 70 | 113.5642070 |


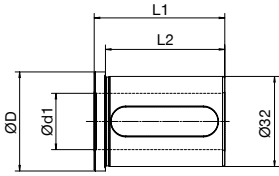
MULTI SQUARE SEATS TURNING TOOL - D1

| Model | Drawing | Technical Data | | | | Order No. |
|---|---|----------------|------|------|------|-----------------------------|
| | | h1/h1* | h2 | L1 | L2 | |
| | | [mm] | [mm] | [mm] | [mm] | |
|  |  | 20/16 | 29 | 60 | 42 | 113.5652042 |


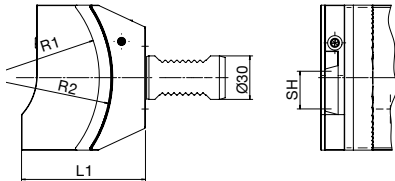
BORING BAR HOLDER - Ø32/H=85MM

| Model | Drawing | Technical Data | | | Order No. |
|--|--|----------------|------|------|----------------------------------|
| | | ØD | L1 | L2 | |
| | | [mm] | [mm] | [mm] | |
|  |  | 32 | 110 | 85 | 113AP012D32RB-85 |

REDUCING SLEEVE- 32/20

| Model | Drawing | Technical Data | | | | Order No. |
|---|---|----------------|------|------|------|-----------------------------|
| | | ØD | Ød1 | L1 | L2 | |
| | | [mm] | [mm] | [mm] | [mm] | |
|  |  | 40 | 20 | 58 | 53 | 28.3220G200 |


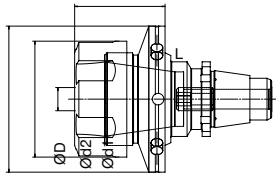
CUT-OFF HOLDER - SH 26

| Model | Drawing | Technical Data | | | | Order No. |
|---|---|----------------|------|------|------|------------------------------|
| | | SH | h2 | R1 | R2 | |
| | | [mm] | [mm] | [mm] | [mm] | |
|  |  | 26 | 85,5 | 80 | 88 | 113.583S0002 |

ACCESSORIES


VDI 30

BENZ SOLIDFIX® ADAPTER - COLLET CHUCK 8° - EXTERNAL CLAMPING NUT


| Model | Drawing | Technical Data | | | | | | Order No. |
|---|---|----------------|------|----|--------|-----|----|-----------------------------|
| | | Size | Type | ØD | Ød1 | Ød2 | L | |
|  |  | S3 | ER25 | 50 | 0,5-17 | 42 | 34 | 693.130E534 |

Collet chuck not included in delivery


HOOK WRENCH DIN 1810B

| Model | Technical Data Suitable for adapter | Order No. |
|--|--|-------------------------------|
|  | S3 X ER25 | D01810B045050 |


CLAMPING WRENCH - EXTERNAL CLAMPING NUT

| Model | Technical Data Suitable for adapter | Order No. |
|---|--|-------------------------|
|  | ER25 | B136-E5 |

CLAMPING WRENCH - INTERNAL CLAMPING NUT

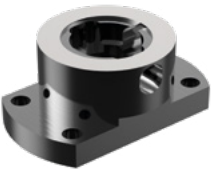
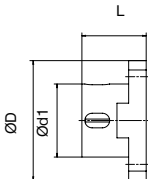
| Model | Technical Data Suitable for adapter | Order No. |
|---|--|---------------------------|
|  | ER25 | B136-E5AX |

INBUS T-WRENCH

| Model | Technical Data Suitable for adapter | Order No. |
|---|--|----------------------------------|
|  | 5 | KL8317-45039-SW5 |

Collet chuck not included in delivery

MOUNTING BLOCK








| Model | Drawing | Technical Data | | | | Order No. |
|--|--|----------------|----|-----|----|---------------------------|
| | | Size | ØD | Ød1 | L | |
|  |  | S3 | 83 | 50 | 44 | B300-4-S3 |

no clamping system integrated

SYMBOLS AND ABBREVIATIONS

EXPLANATION

OVERVIEW OF SYMBOLS AND ABBREVIATIONS

| Symbol | Specifications | Abbreviations |
|--------------------------------------|--|---|
| COOLANT SUPPLY TO CUTTING EDGE |  <p>Extern (EC) The tool is cooled using an external feed line (spray nozzle)</p> | <p>∅ diameter</p> <p>i ratio</p> <p>EC external coolant supply</p> <p>IC internal coolant supply</p> <p>WZ output spindle</p> <p>P page</p> <p>a possible</p> <p>- not possible</p> <p>+ included</p> <p>mm millimeter</p> <p>SW width across flats</p> <p>max. maximum</p> |
| |  <p>Combination (EC/IC) The tool is cooled by a combination of both systems - internal and external system</p> | |
| TURRET TYPE |  <p>Star Turret Tools are vertical / obliquely arranged to turret axis</p> | |
| DRIVE DIRECTION TO SPINDLE DIRECTION |  <p>Direction of rotation synchronous clockwise / clockwise</p> | |
| NUMBER OF OUTPUT SPINDLES |  <p>1 The unit has one output spindle</p> | |
| AXIS ANGLE |  <p>0° Unit for machining tasks at a 0° angle</p> | |
| |  <p>90° Unit for machining tasks at a 90° angle</p> | |

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