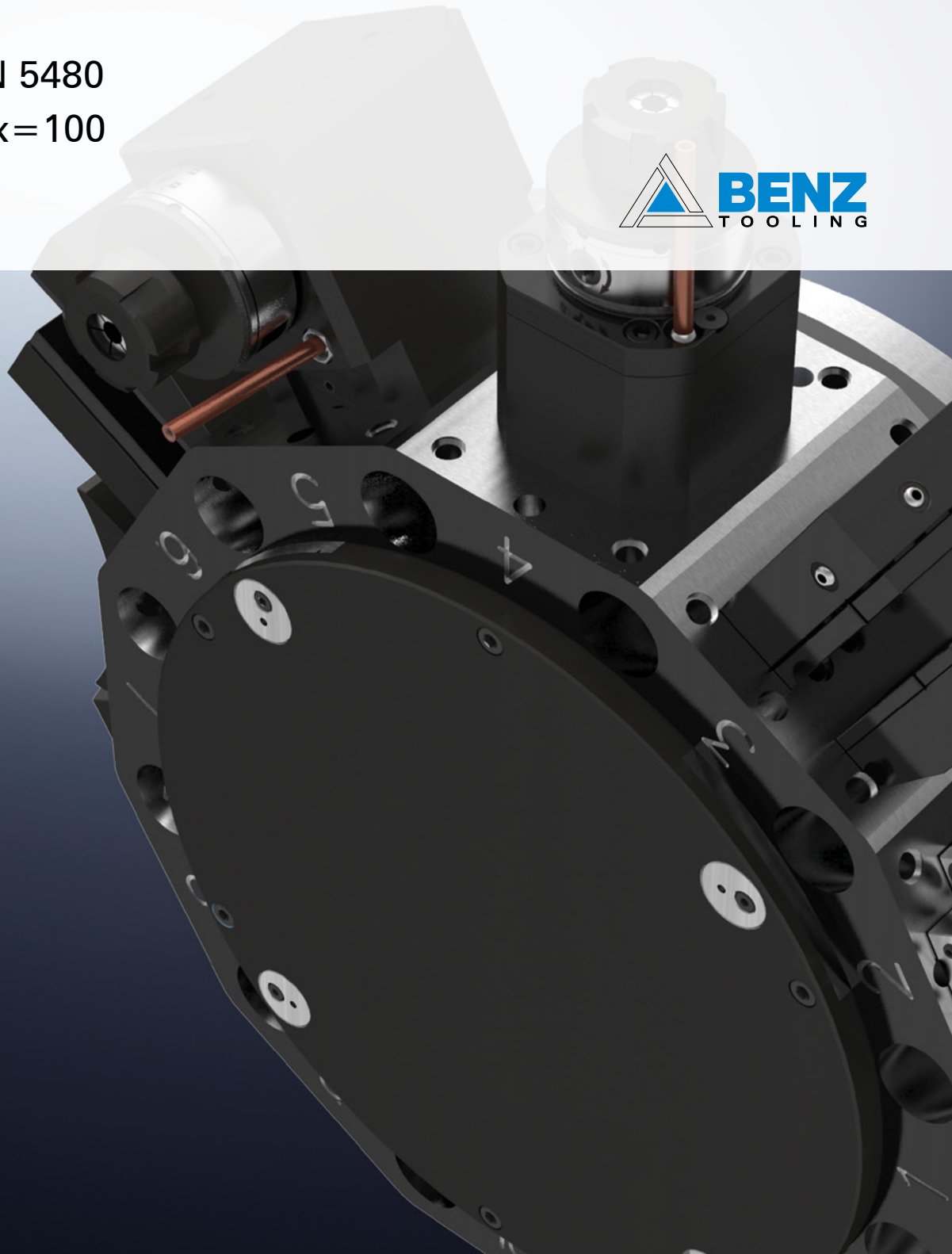


INITIAL TOOLING PACKAGE

VDI 40 - DIN 5480
Star Turret x=100

Metal Machining



INITIAL TOOLING PACKAGE OVERVIEW

VDI 40 - DIN 5480 / STAR TURRET X=100

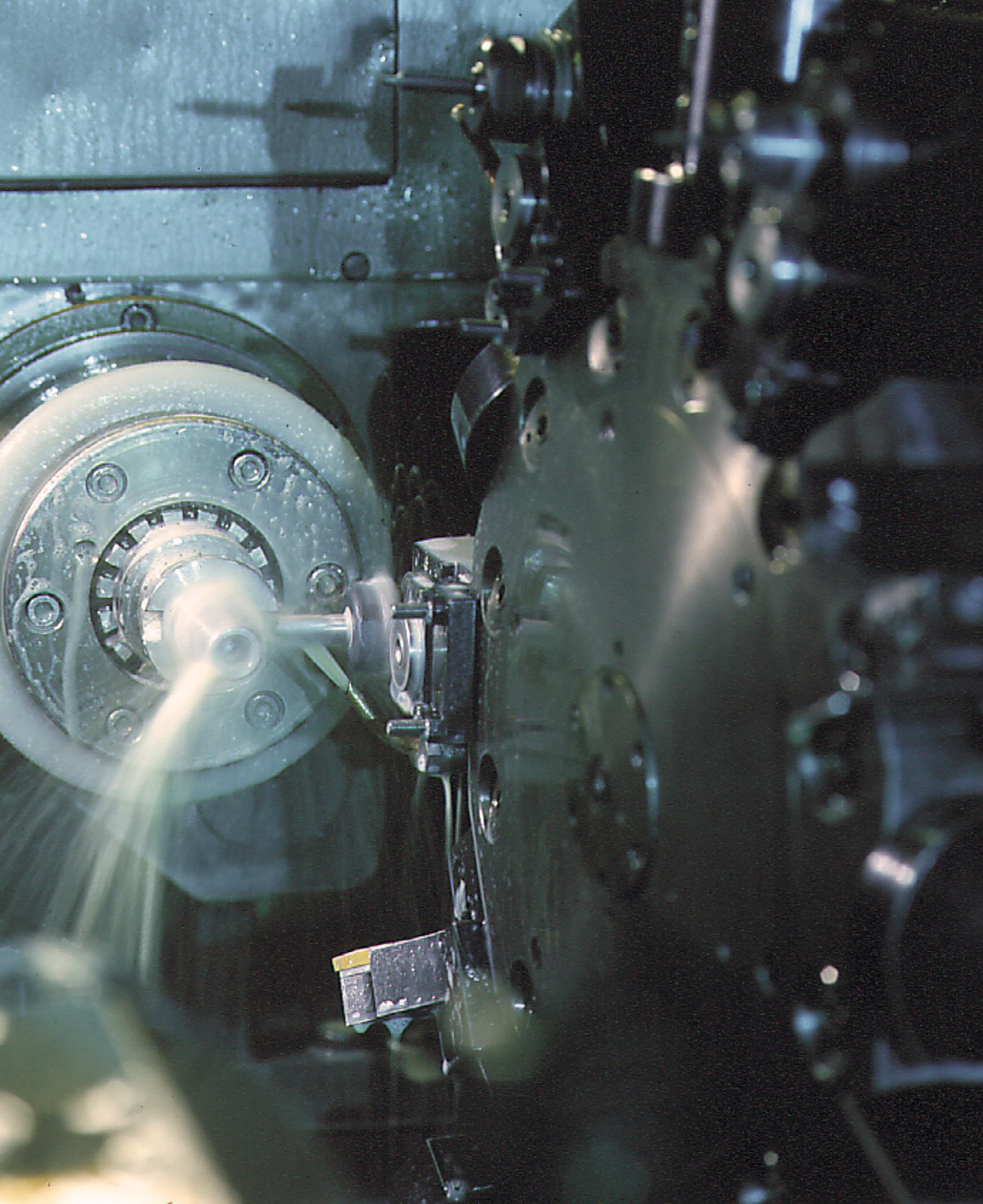


Package Content				
Product Group	Type	Item Number	Details Page	Quantity / Package
LIVE TOOLS	Axial (EC)	114DA03541E6A	5	3
	Axial (EC/IC)	114EA03541E6A	5	3
	Axial (EC)	114DA03541S4	5	3
	Axial (EC/IC)	114EA03541S4	5	3
	Radial (EC)	114FAX03549E6A(L/R)-100*	5	3
	Radial (EC/IC)	114GAX03549E6A(L/R)-100*	5	3
	Radial (EC)	114FAX03549S4(L/R)-100*	5	3
	Radial (EC/IC)	114GAX03549S4(L/R)-100*	5	3
STATIC HOLDERS	Face and I.D.Turning Tool: C1 right hand	114.5612585	6	2
	Face and I.D.Turning Tool: C3 overhead, right hand	114.5632585	6	2
	Face and I.D.Turning Tool: C2 left hand	114.5622585	6	2
	Face and I.D.Turning Tool: C4 overhead, left hand	114.5642585	6	2
	Multiple Square Seats Turning Tool: D1	114.5652550	7	2
	Boring Bar Holder: □40/H=100mm	114AP035D40RB-100	7	3
	Reducing Sleeve: 40/25	28.4025S	7	3
	Cut-Off Holder SH 32	114.583S0001	7	1
ACCESSORIES	BENZ Solidfix® Adapter: Collet Chuck 8° Type ER32	694.130E639	8	6
	Hook Wrench DIN 1810B	D01810B058062	8	1
	Clamping Wrench: external clamping nut	B136-E6	8	1
	Clamping Wrench: internal clamping nut	B136-E6AX	8	1
	Inbus T-Wrench	KL8317-45039-SW6	9	1
	Mounting Block S4	B300-4-S4	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



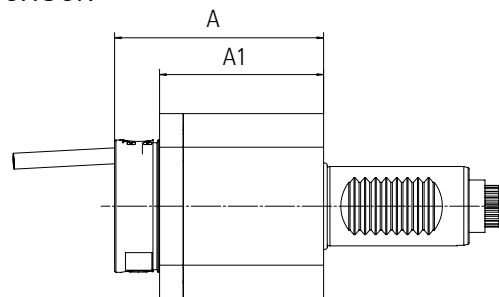
LIVE TOOLS

VDI 40


LIVE TOOL : AXIAL

Model	Output Spindle	Technical Data						Order No.
		Size	i	EC	IC	A max. [mm]	A1 [mm]	
	BENZ SOLIDFIX®	S4	1:1	✓	-	88	65	114DA03541S4
		S4	1:1	✓	✓	88	65	114EA03541S4
	COLLET CHUCK	ER32	1:1	✓	-	76,1	65	114DA03541E6A
		ER32	1:1	✓	✓	81,2	65	114EA03541E6A

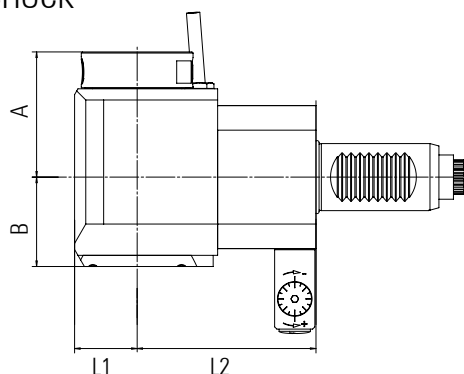
BENZ SOLIDFIX® | COLLET CHUCK



LIVE TOOL : RADIAL

Model	Output Spindle	Technical Data								Order No.
		Size	i	EC	IC	A max. B [mm]	L1. [mm]	L2 [mm]		
	BENZ SOLIDFIX®	S4	1:1	✓	-	72	50	38	100	114FAX03549S4L-100
		S4	1:1	✓	-	72	50	38	100	114FAX03549S4R-100
		S4	1:1	✓	✓	72	60	38	100	114GAX03549S4L-100
		S4	1:1	✓	✓	72	60	38	100	114GAX03549S4R-100
	COLLET CHUCK	ER32	1:1	✓	-	70	50	38	100	114FAX03549E6AL-100
		ER32	1:1	✓	-	70	50	38	100	114FAX03549E6AR-100
		ER32	1:1	✓	✓	76,2	60	38	100	114GAX03549E6AL-100
		ER32	1:1	✓	✓	76,2	60	38	100	114GAX03549E6AR-100

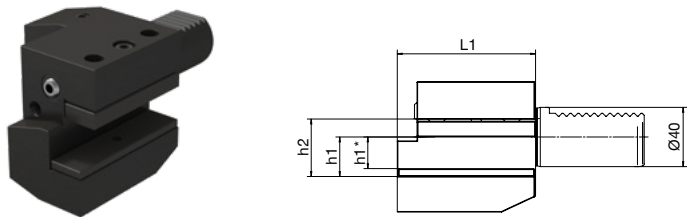
BENZ SOLIDFIX® | COLLET CHUCK



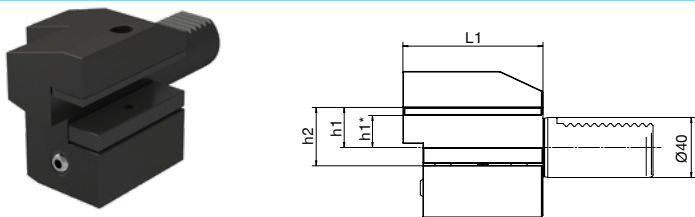
STATIC HOLDERS

VDI 40

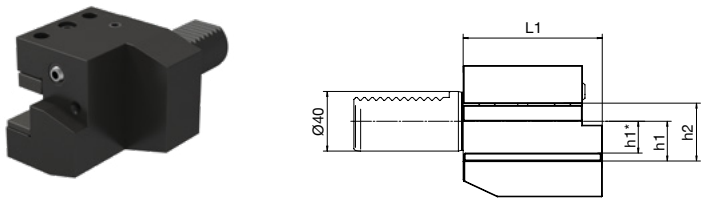
FACE AND I.D. TURNING TOOL - C1 RIGHT HAND

Model	Drawing	Technical Data			Order No.
		h1/h1* [mm]	h2 [mm]	L1 [mm]	
		25/20	34	85	114.5612585

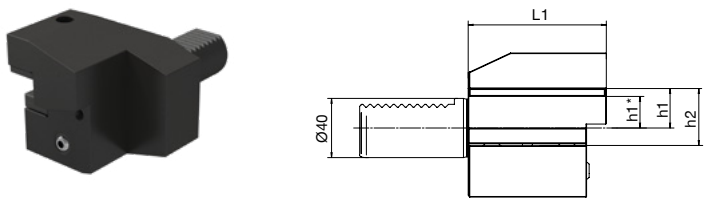
FACE AND I.D. TURNING TOOL - C3 OVERHEAD, RIGHT HAND

Model	Drawing	Technical Data			Order No.
		h1/h1* [mm]	h2 [mm]	L1 [mm]	
		25/20	34	85	114.5632585


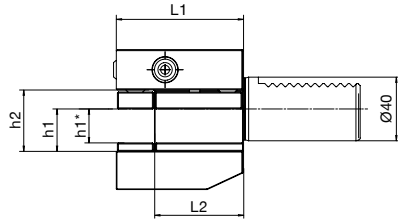
FACE AND I.D. TURNING TOOL - C2 LEFT HAND

Model	Drawing	Technical Data			Order No.
		h1/h1* [mm]	h2 [mm]	L1 [mm]	
		25/20	34	85	114.5622585


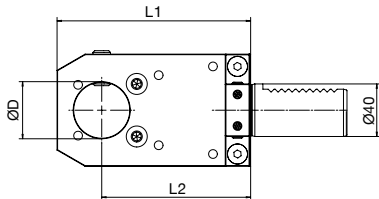
FACE AND I.D. TURNING TOOL - C4 OVERHEAD, LEFT HAND

Model	Drawing	Technical Data			Order No.
		h1/h1* [mm]	h2 [mm]	L1 [mm]	
		25/20	34	85	114.5642585


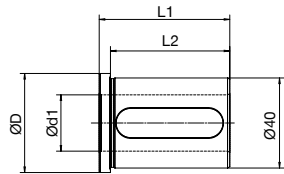
MULTI SQUARE SEATS TURNING TOOL - D1

Model	Drawing	Technical Data				Order No.
		h1/h1*	h2	L1	L2	
		[mm]	[mm]	[mm]	[mm]	
		25/20	34	72	50	114.5652550


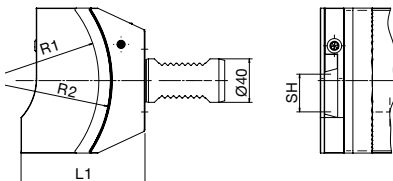
BORING BAR HOLDER - Ø40/H=100MM

Model	Drawing	Technical Data			Order No.
		ØD	L1	L2	
		[mm]	[mm]	[mm]	
		40	130	100	114AP035D40RB-100

REDUCING SLEEVE- 40/25

Model	Drawing	Technical Data				Order No.
		ØD	Ød1	L1	L2	
		[mm]	[mm]	[mm]	[mm]	
		44	25	58	53	28.4025S

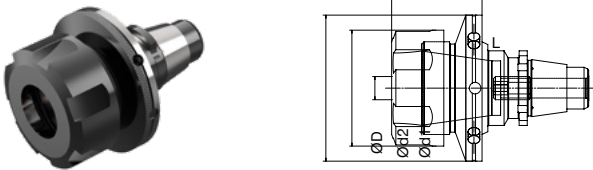
CUT-OFF HOLDER - SH 32

Model	Drawing	Technical Data				Order No.
		SH	h2	R1	R2	
		[mm]	[mm]	[mm]	[mm]	
		32	88,5	80	88	114.583S0001

ACCESSORIES


VDI 40

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


Model	Drawing	Technical Data						Order No.
		Size	Type	ØD	Ød1	Ød2	L	
		S4	ER32	63	1 - 22	50	39	694.130E639

Collet chuck not included in delivery


HOOK WRENCH DIN 1810B

Model	Technical Data Suitable for adapter	Order No.
	S4 X ER32	D01810B058062


CLAMPING WRENCH - EXTERNAL CLAMPING NUT

Model	Technical Data Suitable for adapter	Order No.
	ER32	B136-E6

CLAMPING WRENCH - INTERNAL CLAMPING NUT

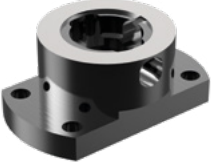
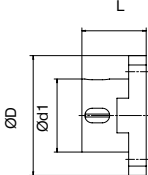
Model	Technical Data Suitable for adapter	Order No.
	ER32	B136-E6AX

INBUS T-WRENCH

Model	Technical Data SW	Order No.
	6	KL8317-45039-SW6

Collet chuck not included in delivery








MOUNTING BLOCK

Model	Drawing	Technical Data				Order No.
		Size	ØD	Ød1	L	
		S4	96	65	50	B300-4-S4

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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