Дин 69871 (исполнение II по ГОСТ 25827-93)

Размеры хвостовиков по DIN 69871

Форма AD + B

COЖ подается через отверстия на фланце (B), или, закрыв отверстия, через центр патрона (AD).

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Характеристика

Патроны формы AD+B поставляются с закрытыми резьбовыми заглушками каналами на фланце.
Подача COЖ производится через центр патрона (форма AD).
Для подачи COЖ через фланец надо выкрутить резьбовые заглушки (форма B)

Штревель

DIN 69872-A/B • ISO 7388/2A • ISO 7388/2B

Стр. 12.21 + 12.30
### 40 хвостовик - Форма AD + B

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Патрон для цанг типа ER
DIN 69871

Стандартный класс балансировки
G 6.3  12.000 об/мин

### 30 хвостовик - Форма AD

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### 40 хвостовик - Форма AD + B

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**DIN 69871 (Исполнение II по ГОСТ 25827-93)**

Патрон для цанг типа ER

**Стандартный класс балансировки**

G 6.3 12.000 об/мин

**45 хвостовик - Форма AD + B**

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**40 хвостовик - Форма AD + B**

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<td>50-G32S</td>
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<td>TCB40E.H160.ERC32</td>
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Повышенный класс балансировки

G 2,5 25.000 об/мин


### DIN 69871 (Исполнение II по ГОСТ25827-93)

Наборы (ER цанги+патрон)

**DIN 69871**

<table>
<thead>
<tr>
<th>Серия</th>
<th>Номер для заказа</th>
<th>Цанговый патрон</th>
<th>Цанги в наборе</th>
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<tr>
<td>301-021</td>
<td>BX.TC40.70/32-18</td>
<td>TCB40.H70.ERC32</td>
<td>ERC32: Ø 3÷20 шаг 1,0 мм. - 18 штук</td>
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<tr>
<td></td>
<td>BX.TC40.70/40-23</td>
<td>TCB40.H70.ERC40</td>
<td>ERC40: Ø 4÷26 шаг 1,0 мм. - 23 штуки</td>
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<tr>
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<td>BX.TC50.80/32-18</td>
<td>TCB50.H80.ERC32</td>
<td>ERC32: Ø 3÷20 шаг 1,0 мм. - 18 штук</td>
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<td></td>
<td>BX.TC50.80/40-23</td>
<td>TCB50.H80.ERC40</td>
<td>ERC40: Ø 4÷26 шаг 1,0 мм. - 23 штуки</td>
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Цанговый патрон для маленьких зажимаемых диаметров **DIN 69871**

<table>
<thead>
<tr>
<th>Серия</th>
<th>Номер для заказа</th>
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<th>L</th>
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<tr>
<td>301-032</td>
<td>TC40.H70.P8</td>
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<td>81</td>
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Двойной контакт повышенная точность и жесткость

Цанги на странице 6.12

Повышенный класс балансировки

**G 2,5 25.000 об/мин**
40 и 50 хвостовики - Форма AD

<table>
<thead>
<tr>
<th>Серия</th>
<th>Номер для заказа</th>
<th>Диапазон зажимаемых диаметров диаметр d, мм</th>
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<tbody>
<tr>
<td></td>
<td>TC40.H21.ERC32A</td>
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<tr>
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<td>TC50.H21.ERC32A</td>
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40 - 50 хвостовики - Форма AD + B

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<thead>
<tr>
<th>Серия</th>
<th>Номер для заказа</th>
<th>Рис.</th>
<th>Диапазон зажимаемых диаметров d, мм</th>
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<tr>
<td>301-117</td>
<td>TCB40.H40.ERC32A</td>
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<td>Нех 32</td>
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40 - 50 хвостовики - Форма AD + B

<table>
<thead>
<tr>
<th>Серия</th>
<th>Номер для заказа</th>
<th>A</th>
<th>C</th>
<th>D</th>
<th>Регулирование</th>
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<tbody>
<tr>
<td>TCB40.H91.ERC16RG</td>
<td>28-G16SE</td>
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<td>1</td>
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<td>TCB40.H96.ERC25RG</td>
<td>42-G25S</td>
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<td>16</td>
<td>± 0,12 мм.</td>
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<td>TCB40.H97.ERC32RG</td>
<td>50-G32S</td>
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<td>20</td>
<td>± 0,12 мм.</td>
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<tr>
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<td>66</td>
<td>2</td>
<td>20</td>
<td>± 0,12 мм.</td>
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<tr>
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<td>30</td>
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</table>

Характеристика

- Цанговые патроны разработаны для использования на станках, где бение шпинделя не позволяет выполнять точные операции фрезерования и сверления.

Удлинители

см. стр. 6.1
**DIN 69871 (Исполнение II по ГОСТ25827-93)**

Патрон для EOC цанги

**Диаметр, мм**

12.000

**Стандартный класс балансировки**

G 6,3

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### 30 хвостовик - Форма AD

<table>
<thead>
<tr>
<th>Серия</th>
<th>Номер для заказа</th>
<th>Диапазон зажимаемых диаметров d, мм</th>
<th>A</th>
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<tbody>
<tr>
<td>301-121</td>
<td>TC30.H60.EOC16</td>
<td>2 ± 16</td>
<td>43-GOC16</td>
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<tr>
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<td>TC30.H80.EOC25</td>
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<td>60-GOC25</td>
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### 40 хвостовик - Форма AD + B

<table>
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<th>Диапазон зажимаемых диаметров d, мм</th>
<th>A</th>
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</thead>
<tbody>
<tr>
<td>301-121</td>
<td>TC40.H70.EOC16</td>
<td>2 ± 16</td>
<td>43-GOC16</td>
</tr>
<tr>
<td></td>
<td>TC40.H100.EOC16</td>
<td>2 ± 16</td>
<td>43-GOC16</td>
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<td>TC40.H70.EOC25</td>
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<td></td>
<td>TC40.H100.EOC25</td>
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<tr>
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<td>TC40.H90.EOC32</td>
<td>4 ± 32</td>
<td>72-GOC32</td>
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### 50 хвостовик - Форма AD + B

<table>
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<tr>
<th>Серия</th>
<th>Номер для заказа</th>
<th>Диапазон зажимаемых диаметров d, мм</th>
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<tbody>
<tr>
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<td>TC50.H100.EOC16</td>
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<td></td>
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<tr>
<td></td>
<td>TC50.H90.EOC32</td>
<td>4 ± 32</td>
<td>72-GOC32</td>
</tr>
</tbody>
</table>

цанги на странице 9.38 - 9.40
**DIN 69871 (Исполнение II по ГОСТ25827-93)**

Плавающий патрон под развертку с внутренним подводом СОЖ

**DIN 69871**

---

### 40 - 50 хвостовики - Форма AD

<table>
<thead>
<tr>
<th>Серия</th>
<th>Номер для заказа</th>
<th>Цангги</th>
<th>Диапазон зажимаемых диаметров d, мм</th>
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<th>D1</th>
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<tr>
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<td>ERC20</td>
<td>D1 ÷ 13</td>
<td>34-G20SE</td>
<td>85</td>
<td>50</td>
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<td>TC40.RM25</td>
<td>ERC25</td>
<td>D1 ÷ 16</td>
<td>42-G2SS</td>
<td>88</td>
<td>57</td>
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<td>TC50.RM32</td>
<td>ERC32</td>
<td>D2 ÷ 20</td>
<td>50-G22S</td>
<td>93</td>
<td>58</td>
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Перемещение: ± 1 мм.

**Характеристики**

- Патрон радиально плавающий, самоцентрирующийся
- Гарантирована безустраничная соосность при развертывании отверстия,
  также патрон предназначен для работы на высоких скоростях
- С возможностью внутренней подачи СОЖ или воздуха
DIN 69871 (Исполнение II по ГОСТ25827-93)

Силовой прецизионный фрезерный патрон

DIN 69871

Стандартный класс балансировки

G 6,3 12.000 об/мин

40 - 50 хвостовики - Форма AD + B

<table>
<thead>
<tr>
<th>Серия</th>
<th>Номер для заказа</th>
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<th>D2</th>
<th>Цанги</th>
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<td>81</td>
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<td>3SR20 / 3 ÷ 16</td>
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<td>TCB40.H110.SWA32</td>
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<td>67,5</td>
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<td>3SR20 / 4 ÷ 25</td>
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<tr>
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<td>TCB50.H110.SWA20</td>
<td>20</td>
<td>81</td>
<td>51,5</td>
<td>50</td>
<td>3SR20 / 3 ÷ 16</td>
</tr>
<tr>
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<td>TCB50.H110.SWA32</td>
<td>32</td>
<td>106</td>
<td>67,5</td>
<td>70</td>
<td>3SR20 / 4 ÷ 25</td>
</tr>
</tbody>
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Никогда не затягивайте гайку, без установленного в патроне инструмента

Цанги на странице 9.51

Наборы

<table>
<thead>
<tr>
<th>Серия</th>
<th>Номер для заказа</th>
<th>Цанги в наборе</th>
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<td>301-129</td>
<td>BX-TCB40.SWA20</td>
<td>3SR20 - Ø 6 - 8 - 10 - 12 - 16</td>
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<td>BX-TCB40.SWA32</td>
<td>3SR32 - Ø 6 - 8 - 10 - 12 - 16 - 20 - 25</td>
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<td>BX-TCB50.SWA20</td>
<td>3SR20 - Ø 6 - 8 - 10 - 12 - 16</td>
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<tr>
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<td>BX-TCB50.SWA32</td>
<td>3SR32 - Ø 6 - 8 - 10 - 12 - 16 - 20 - 25</td>
</tr>
</tbody>
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DIN 69871 (Исполнение II по ГОСТ25827-93)

Переходник с DIN69871 на HSK

40 - 50 хвостовики - Форма AD + B

<table>
<thead>
<tr>
<th>Серия</th>
<th>Номер для заказа</th>
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<tbody>
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<td>TCB40.H60.HSK40AC</td>
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<td>TCB40.H65.HSK50AC</td>
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<td>TCB40.H75.HSK63AC</td>
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<tr>
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<td>TCB50.H60.HSK40AC</td>
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<td>TCB50.H75.HSK63AC</td>
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<td>TCB50.H85.HSK80AC</td>
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<tr>
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<td>TCB50.H100.HSK100AC</td>
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Переходник с DIN69871 на HSK с соплом для внутренней подачи СОЖ

50 хвостовик - Форма AD

<table>
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<tr>
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<tbody>
<tr>
<td>301-137</td>
<td>TCS0.H75.HSK63AR</td>
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</table>
**DIN 69871 (Исполнение II по ГОСТ25827-93)**

**Гидропластовый патрон DIN 69871**

**Стандартный класс балансировки**

G 6,3 15.000 об/мин

### 40 - 50 хвостовики - Форма AD + B

<table>
<thead>
<tr>
<th>Серия</th>
<th>Трубчатые хвостовики</th>
<th>D</th>
<th>L</th>
<th>D2</th>
<th>D3</th>
<th>D4</th>
<th>L1</th>
<th>L2</th>
<th>Усилие зажима</th>
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<td>301-140</td>
<td>TCB40.D6-66DT</td>
<td>6</td>
<td>65,5</td>
<td>22</td>
<td>26</td>
<td>47</td>
<td>26</td>
<td>35</td>
<td>15 Нн</td>
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<td>TCB40.D8-66DT</td>
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<td>65,5</td>
<td>24</td>
<td>28</td>
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<td>26</td>
<td>35</td>
<td>25 Нн</td>
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<td>TCB40.D10-74DT</td>
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<td>73,5</td>
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<td>30</td>
<td>47</td>
<td>36</td>
<td>41</td>
<td>55 Нн</td>
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<td>TCB40.D12-79DT</td>
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<td>78,5</td>
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<td>32</td>
<td>47</td>
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<td>46</td>
<td>115 Нн</td>
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<td>TCB40.D16-84DT</td>
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<td>83,5</td>
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<td>47</td>
<td>46</td>
<td>49</td>
<td>200 Нн</td>
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<td>TCB40.D20-84DT</td>
<td>20</td>
<td>83,5</td>
<td>38</td>
<td>42</td>
<td>47</td>
<td>48</td>
<td>51</td>
<td>350 Нн</td>
</tr>
<tr>
<td></td>
<td>TCB50.D20-84DT</td>
<td>20</td>
<td>83,5</td>
<td>38</td>
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<td>47</td>
<td>48</td>
<td>51</td>
<td>350 Нн</td>
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<td>95,5</td>
<td>54</td>
<td>54</td>
<td>54</td>
<td>76</td>
<td>61</td>
<td>1000 Нн</td>
</tr>
</tbody>
</table>

**По запросу изготавливаются патроны:**

TCB 40 - Ø 25 / 32  •  TCB50 - Ø 6 / 8 / 10 / 12 / 16 / 25  

**Характеристики гидропластового патрона DELLNER**

- Используется для зажима инструмента с цилиндрическим хвостовиком и хвостовиком типа Weldon.
- Точность хвостовика должна быть h6.
- Форма ROMBOID внутренней мембраны патрона позволяет увеличить силу зажима инструмента на 75%, по сравнению с традиционной цилиндрической мембраной.
- Несоосность хвостовика и отверстия составляет менее 0,003мм.
- Осевое регулирование вылета инструмента до 10 мм.
- **НИКОГДА НЕ КРУТИТЕ ВИНТ ДЛЯ ЗАЖИМА, ЕСЛИ ИНСТРУМЕНТА НЕТ В ПАТРОНЕ**

Биение не более 0,005 мм

цанги на странице 9.51

**Набор**

<table>
<thead>
<tr>
<th>Серия</th>
<th>Номер для заказа</th>
<th>Цанговый патрон</th>
<th>Цанги в наборе</th>
</tr>
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<tbody>
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- 1.13 -
DIN 69871 (Исполнение II по ГОСТ25827-93)

Сверлильный патрон
DIN 69871

30 - 40 - 50 хвостовики - Форма А

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Характеристика
- Сверлильный патрон и хвостовик DIN 69871
- Сверлильные патроны изготовлены из закаленной хром-мolibденовой стали, для обеспечения длительного срока службы.
- Поставляется в комплекте с ключом

Сменные сверлильные патроны
DIN 69871

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DIN 69871 (Исполнение II по ГОСТ 25827-93)

Хвостовики к сверлильным патронам

DIN 69871

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Сверлильные патроны с системой зажима EXAG-KEY

DIN 69871

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Характеристика
- Патрон используется для сверления, фрезерования, развертывания и нарезания резьбы.
- Высокое усилие зажима, гарантирует надежное крепление инструмента.

Сменные сверлильные патроны

DIN 69871

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DIN 69871 (Исполнение II по ГОСТ25827-93)

Оправка для крепления инструмента с хвостовиком типа "Weldon"
DIN 69871

30 хвостовик - Форма AD

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Стандартный класс балансировки
G 6,3 12.000 об/мин

Оправка для крепления инструмента с хвостовиком типа "Weldon" короткой серии
DIN 69871

30 хвостовик - Форма AD

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40 и 50 хвостовики - Форма AD + B

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Винты

Стр. 12.3
DIN 69871 (Исполнение II по ГОСТ 25827-93)

Оправка для крепления инструмента с хвостовиком типа “Weldon” средней и длинной серии

DIN 69871

Стандартный класс балансировки

G 6.3 12.000 об/мин

40 хвостовик - Форма AD + B

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45 хвостовик - Форма AD + B

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TCB45.H65.WE10 1 35
TCB45.H65.WE12 1 42
TCB45.H65.WE14 1 44
TCB45.H65.WE16 1 48
TCB45.H65.WE18 1 50
TCB45.H65.WE20 1 52
TCB45.H80.WE25 3 65
TCB45.H100.WE32 3 72
TCB45.H100.WE40 3 80
DIN 69871 (Исполнение II по ГОСТ 25827-93)

Оправка для крепления инструмента с хвостовиком типа “Weldon” средней и длинной серии

DIN 69871

Стандартный класс балансировки
G 6,3 12.000 об/мин

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DIN 69871 (Исполнение II по ГОСТ25827-93)

Оправка для крепления инструмента с хвостовиком типа "Weldon"
DIN 69871

Повышенный класс балансировки

G 2,5  20.000 об/мин

40 хвостовик - Форма AD + B

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40 хвостовик - Форма AD + B

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40 - 50 хвостовики - Форма AD + B

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Характеристика

- Патроны разработаны для использования на станках, где неисправность не позволяет точное фрезерование и сверление.
DIN 69871 (Application II per GOST25827-93)

Oправка для крепления инструмента с хвостовиком типа "Weldon" с каналами для подвода СОЖ к инструменту

DIN 69871

Стандартный класс балансировки

G 6,3 12.000 об/мин

40 - 50 хвостовики - Форма AD + В

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Характеристика

- Каналы подачи СОЖ направлены на режущую часть инструмента
- При закрытии канала уплотнительным кольцом, подвод СОЖ осуществляется через инструмент.
**DIN 69871 (Исполнение II по ГОСТ25827-93)**

Оправка для крепления инструмента с хвостовиком типа "Whistle Notch"  
*DIN 69871*

![Diagram](image)

**Стандартный класс балансировки**  
G 6,3 12.000 об/мин

### 40 хвостовик - Форма AD + B

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Патрон для крепления инструмента с хвостовиком по DIN 6327  
*DIN 69871*

![Diagram](image)

### 40 - 50 хвостовики - Форма AD

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Втулка переходная  
*DIN 69871*

![Diagram](image)

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- 1.21 -
**DIN 69871 (Исполнение II по ГОСТ25827-93)**

**Патрон для нарезания резьбы с компенсацией DIN 69871**

<table>
<thead>
<tr>
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<th>d max</th>
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<th>P</th>
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<td>TC50.SLZ25</td>
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<td>28</td>
<td>42</td>
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**Цанги ER с квадратом под хвостовик метчика**

**Герметичные цанги ER для внутреннего подвода СОЖ**

**Быстросменные вставки**

<table>
<thead>
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<th>P</th>
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*Для цанг с квадратом для метчика*
DIN 69871 (Исполнение II по ГОСТ25827-93)

Патрон с быстросменными вставками DIN 69871

30 - 40 - 50 хвостовики - Форма А

<table>
<thead>
<tr>
<th>Серия</th>
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<th>Диапазон нарезания резьбы</th>
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<th>A</th>
<th>B</th>
<th>Растяжение</th>
<th>Скатаие</th>
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<td>M6 + M20</td>
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По запросу поставляются с внутренним подводом СОЖ

Патрон с быстросменными вставками DIN 69871

40 и 50 хвостовики - Форма А

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<th>B</th>
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Быстросменные вставки с компенсацией и без компенсации

Стр. 9.55

- 1.23 -
DIN 69871 (Исполнение II по ГОСТ25827-93)

Плавающий патрон для ERCM цанг

DIN 69871

с компенсацией по длине на растяжение и сжатие

ЕРСМ цанги
стр. 9.14

40 - 50 хвостовики - Форма А

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<th>B</th>
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<th>Сжатие</th>
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<td>M 5 + M 27</td>
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<td>50-G32S</td>
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<td>42-G25S</td>
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Комбинированные фрезерные патроны DIN 69871

30 хвостовик - Форма A

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40 хвостовик - Форма AD

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<tbody>
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45 хвостовик - Форма A

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50 хвостовик - Форма AD

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Стр. 12.1
**DIN 69871 (Исполнение II по ГОСТ25827-93)**

Оправки для торцевых фрез с фланцевым креплением

ДИИ 69871

### 40 - 50 хвостовики - Форма А

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<tr>
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<td>66,7</td>
<td>M12 - L40</td>
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### 40 - 50 хвостовики - Форма AD + B

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<th>№</th>
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<td>101,6</td>
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Винты поставляются по запросу

Комбинированные фрезерные патроны

ДИИ 69871

### 30 хвостовик - Форма AD

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<th>Номер для заказа</th>
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### 45 хвостовик - Форма AD

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DIN 69871 (Исполнение II по ГОСТ25827-93)

Комбинированные фрезерные патроны
с внутренним подводом СОЖ

DIN 69871

стандарт

удлинённые

40 хвостовик - Форма AD
(Без подвода СОЖ)

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40 хвостовик - Форма AD + B

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<th>Рис.</th>
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<th>M</th>
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стр. 12.2 ÷ 12.3
### DIN 69871 (Исполнение II по ГОСТ25827-93)

Комбинированные фрезерные патроны с внутренним подводом СОЖ
DIN 69871

#### Рис. 1

![Стандарт](image1.png)

#### Рис. 2

![Удлиненные](image2.png)

#### Рис. 3

![Супер длинные](image3.png)

### 50 хвостовик - Форма AD + B

<table>
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### Серия № 301-270

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### 50 хвостовик - Форма AD + B

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Аксессуары

Стр. 4.17 – 4.18
DIN 69871 (Исполнение II по ГОСТ25827-93)

Патрон для крепления инструмента с конусом Морзе (с лапкой)
DIN 69871

30 - 40 - 50 хвостовики - Форма AD

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1. Стопорное кольцо с левой резьбой

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**DIN 69871 (Исполнение II по ГОСТ25827-93)**

**Контрольная оправка**

**ISO R230**

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<th>Серия</th>
<th>Номер для заказа</th>
<th>D</th>
<th>Точность</th>
<th>Биение</th>
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**Заготовка для специальных оправок**

**DIN 69871**

- **HRc 56 ÷ 58**
- **HRc 28 ÷ 32**

**40 - 50 хвостовики - Форма А**

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<td>TC50.H315.D97BL</td>
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- Материал: высококачественная углеродистая сталь
- Твердость хвостовика **HRc 56 ÷ 58**
- Твердость обрабатывающей части **HRc 28 ÷ 32**
**DIN 69871 (Исполнение II по ГОСТ25827-93)**

Патрон для центральной подачи СОЖ

**Давление СОЖ**

макс. 20 Бар / мин. 2 Бар

**Втулки**

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DIN 69871 (Исполнение II по ГОСТ25827-93)

Патрон с термозажимом

40 - 50 хвостовики - Форма AD + B

см. стр. 11.6

Повышенный класс балансировки
G 2,5 25.000 об/мин

см. стр. 11.1 ÷ 11.3

Установка индукционного нагрева

Технические данные

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<th>Свойство</th>
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<td>Напряжение</td>
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<td>Мощность нагрева</td>
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<td>Макс. высота, мм</td>
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<td>Вес</td>
<td>22 кг</td>
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