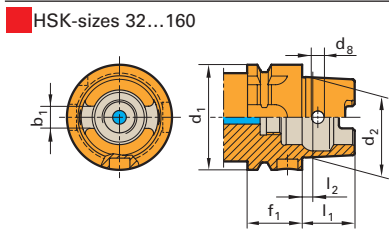
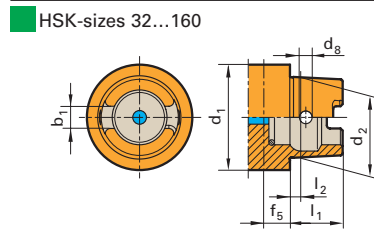


General overview of HSK shanks ISO 12164-1/DIN 69893

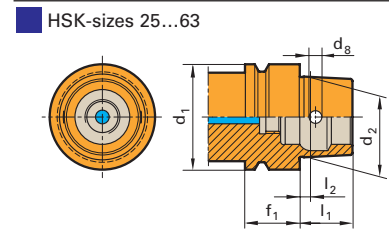
Form A DIN 69893 part 1



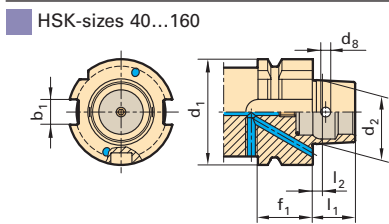
Form C DIN 69893 part 1



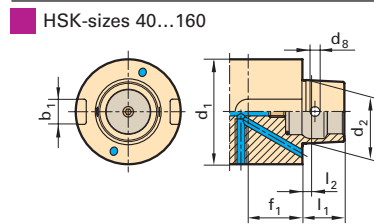
Form E DIN 69893 part 5



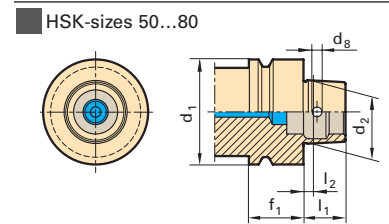
Form B DIN 69893 part 2



Form D DIN 69893 part 2



Form F DIN 69893 part 6



HSK for automatic tool change with gripper groove and index notch. Manual operation is via access hole in taper. Form B relies on driving dogs on the joint face as shank isn't slotted. Torque is transmitted through highly accurate connection.

HSK for manual tool change. Operation is via access hole in taper. Form D relies on driving dogs on the joint face as shank isn't slotted. Torque is transmitted through highly accurate connection.

HSK for automatic tool change. Torque is transmitted through highly accurate connection. Version with access hole acc. to DIN 69893-1 by arrangement.

HSK form A C E								
Nominal Ø d ₁ mm	d ₂ mm	l ₁ mm	l ₂ mm	f ₁ mm	f ₅ mm	d ₈ mm	b ₁ mm	
25	19.000	13	2.5	10	-	-	-	
32	24.007	16	3.2	20	10.0	4.0	7.05	
40	30.007	20	4.0	20	10.0	4.6	8.05	
50	38.009	25	5.0	26	12.5	6.0	10.54	
63	48.010	32	6.3	26	12.5	7.5	12.54	
80	60.012	40	8.0	26	16.0	8.5	16.04	
100	75.013	50	10.0	29	16.0	12.0	20.02	
125	95.016	63	12.5	29	-	-	25.02	
160	120.016	90	16.0	31	-	-	30.02	

HSK form B D F						
Nominal Ø d ₁ mm	d ₂ mm	l ₁ mm	l ₂ mm	f ₁ mm	d ₈ mm	b ₁ mm
25	-	-	-	-	-	-
32	-	-	-	-	-	-
40	24.007	16	3.2	20	4.0	10
50	30.007	20	4.0	26	4.6	12
63	38.009	25	5.0	26	6.0	16
80	48.010	32	6.3	26	7.5	18
100	60.012	40	8.0	29	8.5	20
125	75.013	50	10.0	29	12.0	25
160	95.016	63	12.5	31	12.0	32

Because the rotational speed is the largest influencing factor together with the limits regarding the spindle or spindle bearing interface, the following r.p.m. limits for HSK interfaces have been recommended as guidelines within the HSK standards:

HSK-A/C 32	to 50.000 rev./min
HSK-A/C 40	to 42.000 rev./min
HSK-A/C 50	to 30.000 rev./min
HSK-A/C 63	to 25.000 rev./min
HSK-A/C 80	to 20.000 rev./min
HSK-A/C 100	to 16.000 rev./min