



Drilling



Boring



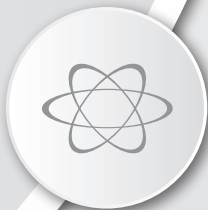
Reaming



Threading



Specials



Wohlhaupter®

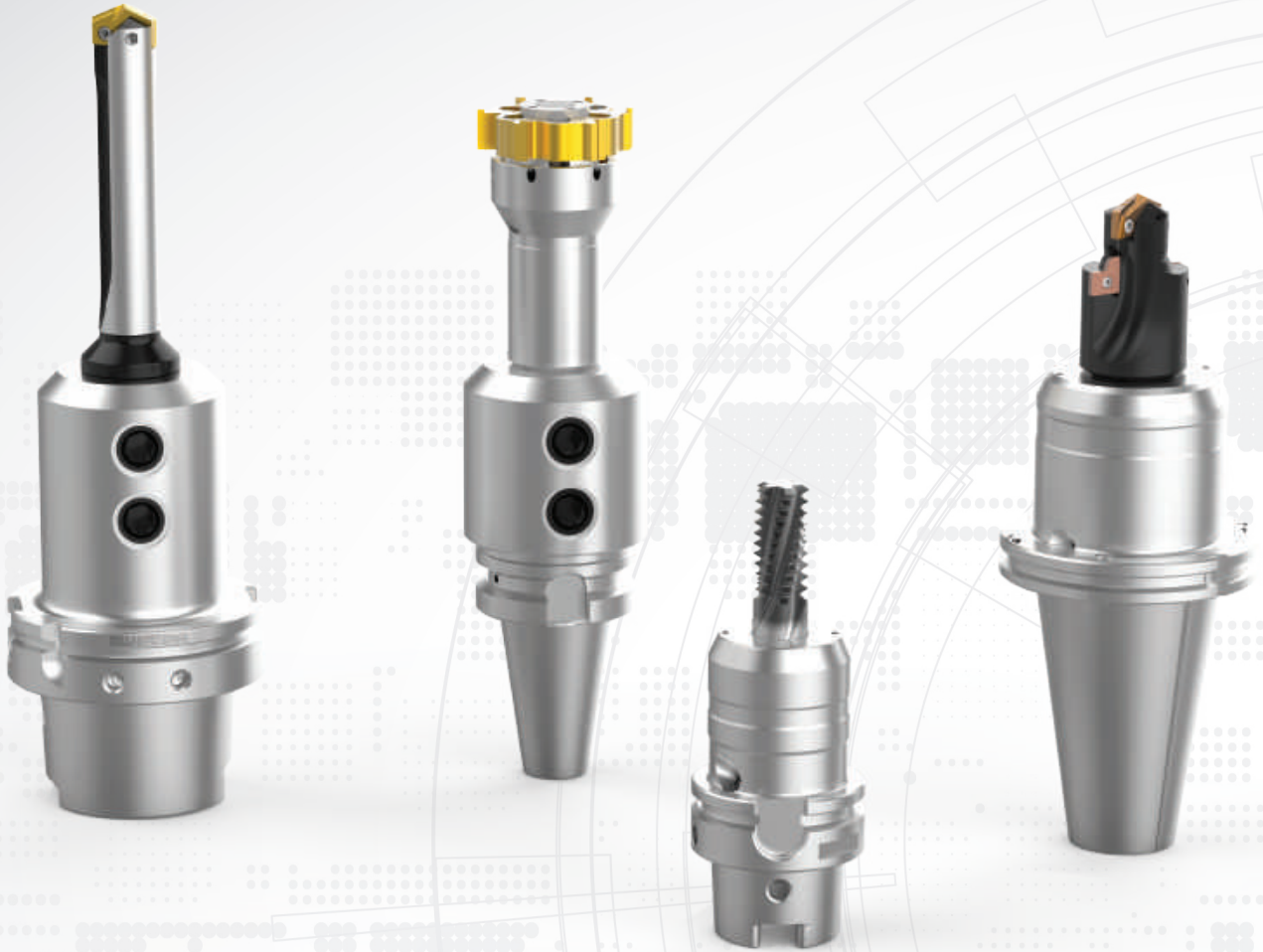
▶ *TOOL HOLDERS*

Precision Tool Holding

Tool Holders

Precision Tool Holders

► HSK-A 63/100, SK40/50 & MAS-BT40/50



From Edge to Spindle Solutions

Choosing the right tool holder is a critical part of the overall tool selection process. Our range of Weldon and Hydraulic tool holders ensure the best possible results in your hole production process.

The precision range of tool holders are an accessory that complements our cutting tool portfolio, combining excellent quality with a high level of accuracy.

High static & dynamic rigidity

High accuracy level when repeating a tool change

Safe machining at high speeds

Applicable Industries



Aerospace



Agriculture



Automotive



General
Machining



Oil & Gas



Renewable
Energy

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Product Overview



Weldon Holders

- Available in HSK, SK, & BT connections
- Replacement screws included

Weldon Holders	16	20	25	32	40	50
HSK 63	✓	✓	✓	✓	✓	
HSK 100		✓	✓	✓	✓	✓
SK40	✓	✓	✓	✓	✓	
SK50		✓	✓	✓	✓	✓
BT40	✓	✓	✓	✓	✓	
BT50		✓	✓	✓	✓	✓



Hydraulic Holders

- Available in HSK, SK, & BT connections
- For precision machining components
- Achieve smaller diameters with reducing sleeves
- Best suitable for drilling, reaming and milling operations

Hydraulic Holders	16*	18*	20	25*	32
HSK 63	✓		✓		
HSK 100	✓	✓	✓	✓	✓
SK40	✓		✓		
SK50	✓	✓	✓	✓	✓
BT40	✓		✓		
BT50	✓	✓	✓	✓	✓

*Reducing sleeve required

Advantages of HSK Tool Holders

Our tool holders, up to DIN 69 893 form A, fit straight into the machine spindle and can also be used for manual tool changes.

- ✓ **High level of accuracy**
when repeating or making a tool change
- ✓ **Balanced tool holders**
G 6.3 20,000 RPM
- ✓ **Available in weldon & hydraulic tool holders**
- ✓ **Supplied with central coolant feed facility**



HSK Tool Holder

Advantages of SK/BT Tool Holders

Our tool holders fit straight into the machine spindle and can also be used for manual tool changes.

- ✓ **40/50 taper sizes**
- ✓ **Balanced tool holders**
G 6.3 15,000 RPM
- ✓ **Available in weldon & hydraulic tool holders**
- ✓ **Supplied with central coolant feed facility**



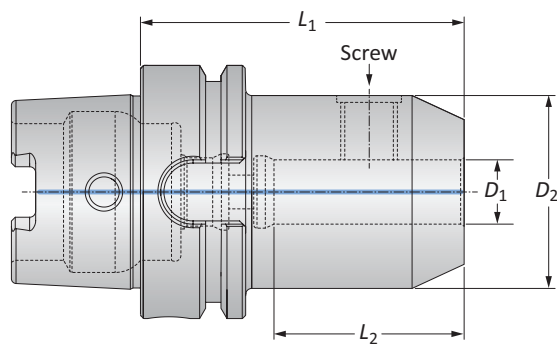
SK Tool Holder



BT Tool Holder

HSK-A 63 | HSK-A 100

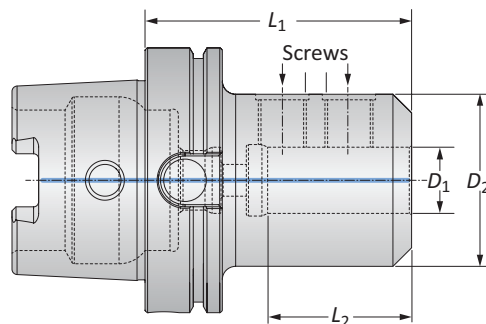
Weldon Holders



HSK-A 63 | DIN 69 893 HSK

Taper Size	Weldon Holder					Weight	Part No.	Clamping Screws	
	D_1	L_1	D_2	L_2	Screw Size			No. Screws	
HSK-A 63	16	80.00	48.00	54.00	1.35 (kg)	448025	M14x2	1	
HSK-A 63	20	80.00	52.00	54.00	2.33 (kg)	448031	M16x2	1	
HSK-A 63	25	110.00	65.00	84.00	1.48 (kg)	448034	M18x2	2	
HSK-A 63	32	110.00	72.00	84.00	2.55 (kg)	448036	M20x2	2	
HSK-A 63	40	125.00	80.00	99.00	3.32 (kg)	448038	M20x2	2	

Clamping and adjustment screws are included. Spare screws are available to order.
Balance quality: G 6.3 at 20,000 RPM



HSK-A 100 | DIN 69 893 HSK

Taper Size	Weldon Holder					Weight	Part No.	Clamping Screws	
	D_1	L_1	D_2	L_2	Screw Size			No. Screws	
HSK-A 100	20	100.00	52.00	71.00	4.52 (kg)	448054	M16x2	1	
HSK-A 100	25	100.00	65.00	71.00	4.81 (kg)	448056	M18x2	2	
HSK-A 100	32	120.00	72.00	91.00	2.90 (kg)	448058	M20x2	2	
HSK-A 100	40	120.00	80.00	91.00	3.10 (kg)	448060	M20x2	2	
HSK-A 100	50	130.00	100.00	101.00	3.99 (kg)	448061	M24x2	2	

Clamping and adjustment screws are included. Spare screws are available to order.
Balance quality: G 6.3 at 20,000 RPM

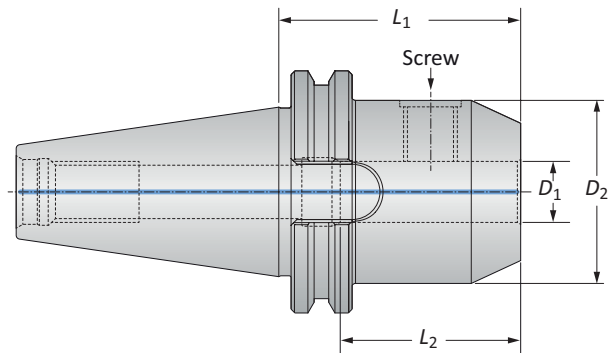
Connection Accessories

Clamping Screws		Screw Tightening Torque Size		
Screw Size	Part No.	Torque Size	Tightening Torque (Nm)	Part No.
M14x2	115684	6	36	115578
M16x2	115685	8	60	115579
M18x2	115686	10	60	115580
M20x2	115687	10	80	115580
M24x2	215293	12	100	215638

Ⓜ = Metric (mm)

SK40 | SK50

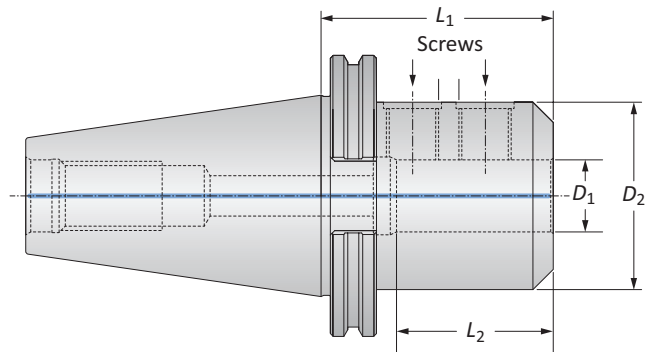
Weldon Holders



SK40 | DIN 69 871-A/AD / B

Taper Size	Weldon Holder					Weight	Part No.	Clamping Screws	
	D_1	L_1	D_2	L_2	Screw Size			No. Screws	
SK40	16	63.00	48.00	54.00	1.63 (kg)	413016	M14x2	1	
SK40	20	63.00	52.00	54.00	1.38 (kg)	413022	M16x2	1	
SK40	25	100.00	65.00	84.00	2.44 (kg)	413025	M18x2	2	
SK40	32	100.00	72.00	84.00	2.62 (kg)	413027	M20x2	2	
SK40	40	115.00	80.00	99.00	3.44 (kg)	413029	M20x2	2	

Clamping and adjustment screws are included. Spare screws are available to order.
Balance quality: G 6.3 at 15,000 RPM



SK50 | DIN 69 871-A/AD / B

Taper Size	Weldon Holder					Weight	Part No.	Clamping Screws	
	D_1	L_1	D_2	L_2	Screw Size			No. Screws	
SK50	20	63.00	52.00	43.90	3.33 (kg)	413052	M16x2	1	
SK50	25	80.00	65.00	60.90	4.03 (kg)	413055	M18x2	2	
SK50	32	100.00	72.00	80.90	4.80 (kg)	413058	M20x2	2	
SK50	40	120.00	80.00	100.90	5.76 (kg)	413060	M20x2	2	
SK50	50	120.00	100.00	100.90	6.99 (kg)	413062	M24x2	2	

Clamping and adjustment screws are included. Spare screws are available to order.
Balance quality: G 6.3 at 15,000 RPM

Connection Accessories

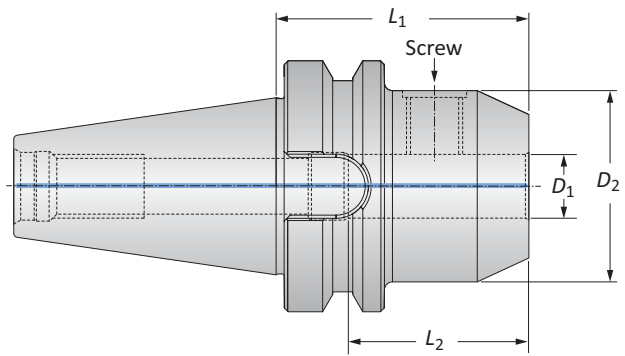
Clamping Screws		Screw Tightening Torque Size		
Screw Size	Part No.	Torque Size	Tightening Torque (Nm)	Part No.
M14x2	115684	6	36	115578
M16x2	115685	8	60	115579
M18x2	115686	10	60	115580
M20x2	115687	10	80	115580
M24x2	215293	12	100	215638

 = Metric (mm)

A
DRILLING
B
BORING
C
REAMING
D
BURNISHING
E
THREADING
X
SPECIALS

MAS-BT40 | MAS-BT50

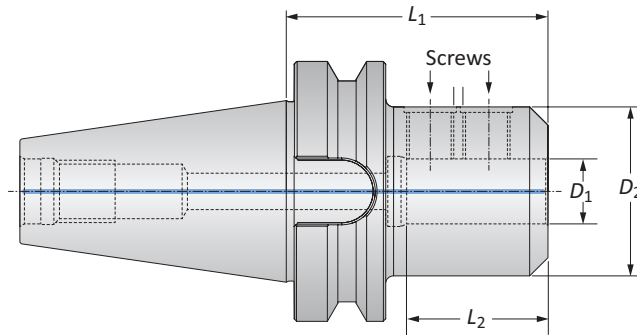
Weldon Holders



MAS-BT40

Taper Size	Weldon Holder					Part No.	Clamping Screws	
	D_1	L_1	D_2	L_2	Weight		Screw Size	No. Screws
MAS-BT40	16	63.00	48.00	36.00	1.43 (kg)	409024	M14x2	1
MAS-BT40	20	63.00	52.00	36.00	1.45 (kg)	409030	M16x2	1
MAS-BT40	25	90.00	65.00	63.00	2.30 (kg)	409033	M18x2	2
MAS-BT40	32	100.00	72.00	73.00	2.77 (kg)	409035	M20x2	2
MAS-BT40	40	105.00	80.00	78.00	3.20 (kg)	409037	M20x2	2

Clamping and adjustment screws are included. Spare screws are available to order.
Balance quality: G 6.3 at 15,000 RPM



MAS-BT50

Taper Size	Weldon Holder					Part No.	Clamping Screws	
	D_1	L_1	D_2	L_2	Weight		Screw Size	No. Screws
MAS-BT50	20	80.00	52.00	42.00	4.28 (kg)	409060	M16x2	1
MAS-BT50	25	100.00	65.00	62.00	5.04 (kg)	409063	M18x2	2
MAS-BT50	32	105.00	72.00	67.00	5.36 (kg)	409065	M20x2	2
MAS-BT50	40	115.00	80.00	77.00	5.90 (kg)	409067	M20x2	2
MAS-BT50	50	125.00	100.00	87.00	7.54 (kg)	409069	M24x2	2

Clamping and adjustment screws are included. Spare screws are available to order.
Balance quality: G 6.3 at 15,000 RPM

Connection Accessories

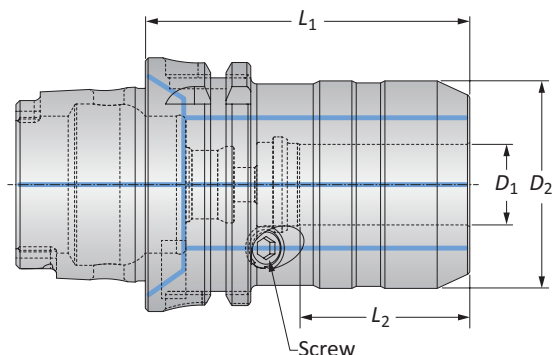
Side Lock Clamping Screws		Screw Tightening Torque Size		
Screw Size	Part No.	Torque Size	Tightening Torque (Nm)	Part No.
M14x2	115684	6	36	115578
M16x2	115685	8	60	115579
M18x2	115686	10	60	115580
M20x2	115687	10	80	115580
M24x2	215293	12	100	215638

Ⓜ = Metric (mm)

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HSK-A 63 & HSK-A 100 | SK40 & SK50 | MAS-BT40 & MAS-BT50

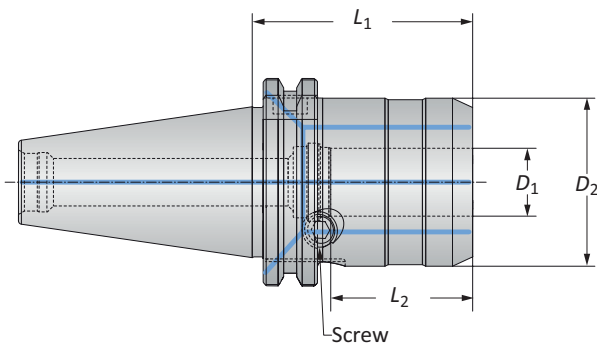
Hydraulic Holders



HSK-A 63 & HSK-A 100 | DIN 69 893 HSK

		Hydraulic Holder					Reducer Size (mm)	Part No.
Taper Size	D_1	L_1	D_2	L_2	Weight			
HSK-A 63	20	80.00	50.00	54.00	1.40 (kg)	16	412011	
	20	90.00	50.00	61.00	2.95 (kg)	16	412013	
HSK-A 100	32	110.00	72.00	81.00	4.20 (kg)	16, 18, 20, 25	412014	

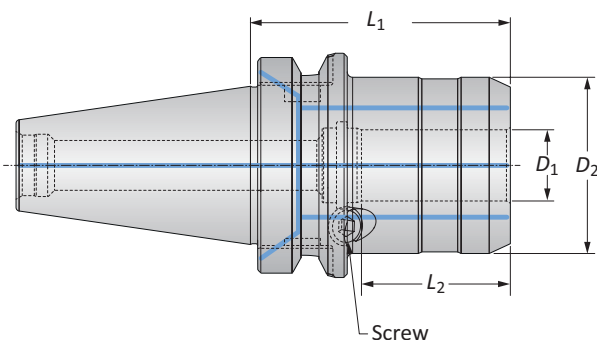
Reducers available on page 11, Pull Studs available on page 12
 Clamping and adjustment screws are included. Spare screws are available to order.
 Balance quality: G 2.5 at 25,000 RPM



SK40 & SK50 | DIN 69 871-A/AD / B

		Hydraulic Holder					Reducer Size (mm)	Part No.
Taper Size	D_1	L_1	D_2	L_2	Weight			
SK40	20	64.50	50.00	45.40	1.20 (kg)	16	412016	
	20	64.50	50.00	45.40	4.26 (kg)	16	412018	
SK50	32	81.00	72.00	61.90	3.03 (kg)	16, 18, 20, 25	412019	

Reducers available on page 11, Pull Studs available on page 12
 Clamping and adjustment screws are included. Spare screws are available to order.
 Balance quality: G 2.5 at 25,000 RPM



MAS-BT40 & MAS-BT50



		Hydraulic Holder					Reducer Size (mm)	Part No.
Taper Size	D_1	L_1	D_2	L_2	Weight			
MAS-BT40	20	72.50	50.00	42.00	1.61 (kg)	16	412004	
MAS-BT50	20	83.00	50.00	42.00	4.30 (kg)	16	412006	
	32	90.00	72.00	55.00	4.84 (kg)	16, 18, 20, 25	412007	

Reducers available on page 11, Pull Studs available on page 12
 Clamping and adjustment screws are included. Spare screws are available to order.
 Balance quality: G 2.5 at 25,000 RPM

Accessories

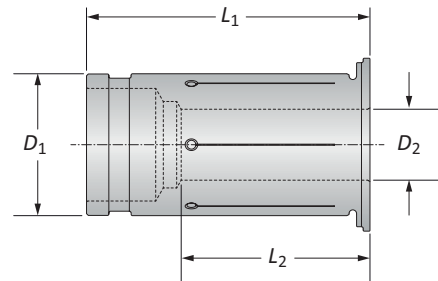
Hydraulic Clamping Accessories | Hydraulic Length Adjustment Accessories | Reducing Sleeves

Hydraulic Clamping Accessories

 Hydraulic Clamping Screw		 Screw Tightening Torque Size		
Screw Size	Part No.	Torque Size	Tightening Torque (Nm)	Part No.
Ø20 = M10x1.5P	515686	5	10-14	115577
Ø32 = M10x1.5P	515687	5	10-14	115577

Hydraulic Length Adjustment Accessories

 Length Adjustment Screw		 Tightening Torque Size	
Screw Size	Part No.	Torque Size	Part No.
M16 x 16	515685	8	115579



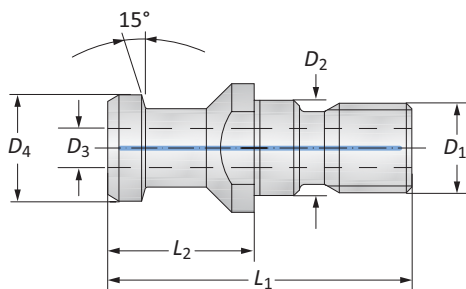
Reducing Sleeves

Reducing Sleeve					
	D_1	D_2	L_1	L_2	Part No.
III	20.00	16.00	52.50	40.00	452119
	32.00	16.00	63.50	40.00	452125
	32.00	18.00	63.50	40.00	452136
	32.00	20.00	63.50	40.00	452127
	32.00	25.00	63.50	42.00	452128

Accessories

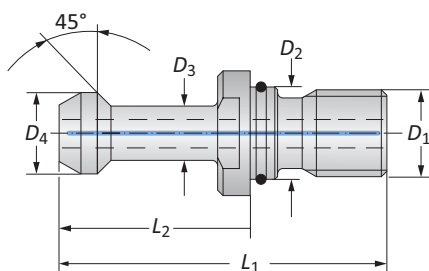
Pull Studs | SK40/50 & BT40/50

A
DRILLING
B
BORING
C
REAMING
D
BURNISHING
E
THREADING
X
SPECIALS



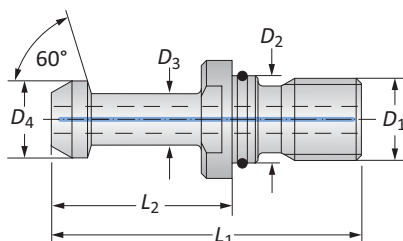
SK / DIN 69 872

		Pull Stud						
Taper Size		D_1	D_2	D_3	D_4	L_1	L_2	Part No.
m	40	M16	17.00	7.00	19.00	54.00	26.00	KW15004
	50	M24	25.00	11.50	28.00	74.00	34.00	KW14483



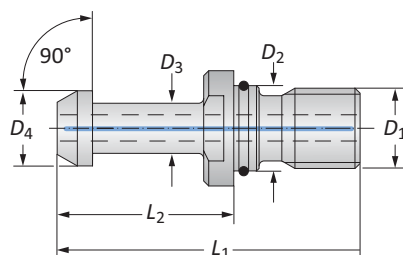
MAS-BT / JIS B 6339

		Pull Stud						
Taper Size		D_1	D_2	D_3	D_4	L_1	L_2	Part No.
m	40	M16	17.00	10.00	15.00	60.00	35.00	KW24299
	50	M24	25.00	17.00	23.00	85.00	45.00	KW24300



MAS-BT / JIS B 6339

		Pull Stud						
Taper Size		D_1	D_2	D_3	D_4	L_1	L_2	Part No.
m	40	M16	17.00	10.00	15.00	60.00	35.00	KW24301
	50	M24	25.00	17.00	23.00	85.00	45.00	KW24302

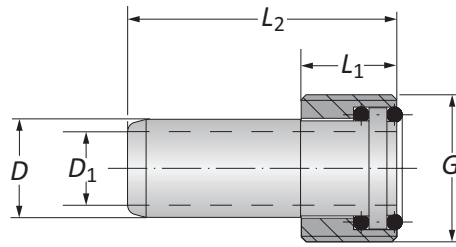


MAS-BT / JIS B 6339

		Pull Stud						
Taper Size		D_1	D_2	D_3	D_4	L_1	L_2	Part No.
m	40	M16	17.00	10.00	15.00	60.00	35.00	KW24303
	50	M24	25.00	17.00	23.00	85.00	45.00	KW24304

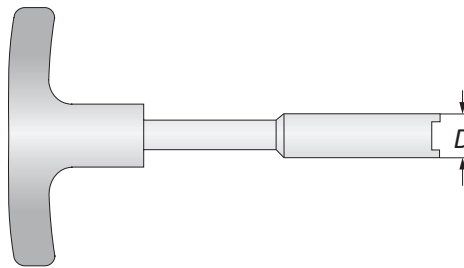
Accessories

HSK Coolant Adapter Sets | Service Keys



Coolant Adapter Sets

Taper Size	Coolant Adapter					Part No.
	G	D	D_1	L_1	L_2	
HSK-A 63	M18 x 1.0	12	8.00	11.50	36.20	262005
HSK-A 100	M24 x 1.5	16	12.00	15.50	43.60	262007



Service Keys

Taper Size	D	Part No.
HSK-A 63	16.50	215727
HSK-A 100	22.00	215728

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

F

THREADING

X

SPECIALS

Accessories

Mounting Fixtures

Central release button to swivel the receptacle into the set up position

Adapter

Basic body



Mounting Fixtures

Description	Taper Size	Part No.
Basic Body	-	098060
Adapter	SK40	098061
Adapter	SK50	098062
Adapter	HSK-A 63	098066
Adapter	HSK-A 100	098068

A
DRILLING
B
BORING
C
REAMING
D
BURNISHING
E
THREADING
X
SPECIALS



**ALLIED MACHINE
& ENGINEERING**

Warranty Information



Allied Machine & Engineering ("Allied Machine") warrants to original equipment manufacturers, distributors, industrial and commercial users of its products for one year from the original date of sale that each new product manufactured or supplied by Allied Machine shall be free from defects in material and workmanship.

Allied Machine's sole and exclusive obligation under this warranty is limited to, at its option, without additional charge, replacing or repairing this product or issuing a credit. For this warranty to be applied, the product must be returned freight prepaid to the plant designated by an Allied Machine representative and which, upon inspection, is determined by Allied Machine to be defective in material and workmanship.

Complete information as to operating conditions, machine, setup, and the application of cutting fluid should accompany any product returned for inspection. This warranty shall not apply to any Allied Machine products which have been subjected to misuse, abuse, improper operating conditions, improper machine setup or improper application of cutting fluid or which have been repaired or altered if such repair or alteration, in the judgement of Allied Machine, would adversely affect the performance of the product.

THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. Allied Machine shall have no liability or responsibility for any claim, whether in contract, tort or otherwise, for any loss or damage arising out of, connected with, or resulting from the manufacture, sale, delivery or use of any product sold hereunder, in excess of the cost of replacement or repair as provided herein.

Allied Machine shall not be liable in contract or in tort (including, without limitation, negligence, strict liability or otherwise) for economic losses of any kind or for any special, incidental, indirect, consequential, punitive or exemplary damages arising in any way out of the performance of, or failure to perform this agreement.

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