

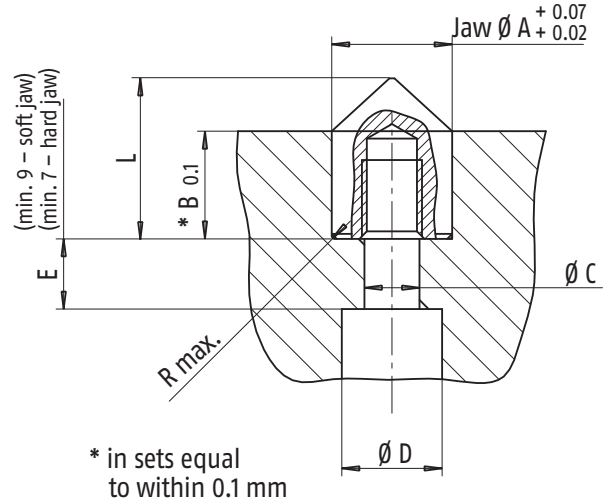
Installation instructions for SCHUNK Clamping Inserts

Typ HS

- Large penetration depth on high-strength surfaces
- Easy to change when worn
- Material: HSS

SCHUNK Model	Id.- No.	∅ A	B	∅ C	∅ D	L	E min. 9	R max.	Screw DIN EN ISO 4762
HS 6	184 110	6.0	7.5	3.4	6.0	10	9	0.3	M3 x 14
HS 8	184 114	8.0	8.5	4.5	8.0	12	9	0.5	M4 x 14
HS 10	184 111	10.0	9.5	5.5	10.0	14	9	0.5	M5 x 14
HS 12	184 112	12.0	10.5	6.6	12.0	16	11	0.5	M6 x 16
HS 13	184 113	12.7	10.5	6.6	12.7	16	11	0.5	M6 x 16

- Boring / chamfering depending on ∅

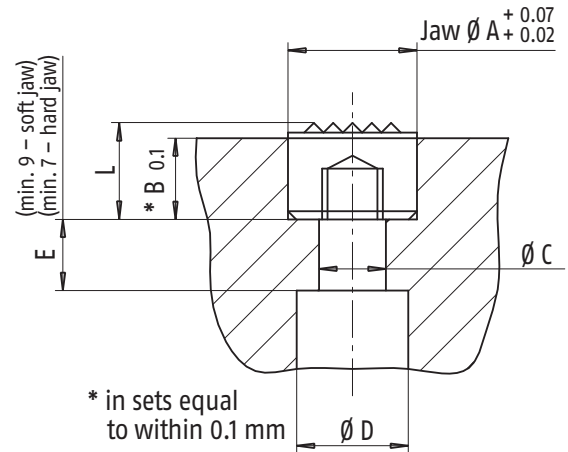


Typ HM

- Standard jaws are made into top-quality hard clamping jaws through simple installation
- Material: carbide with steel body

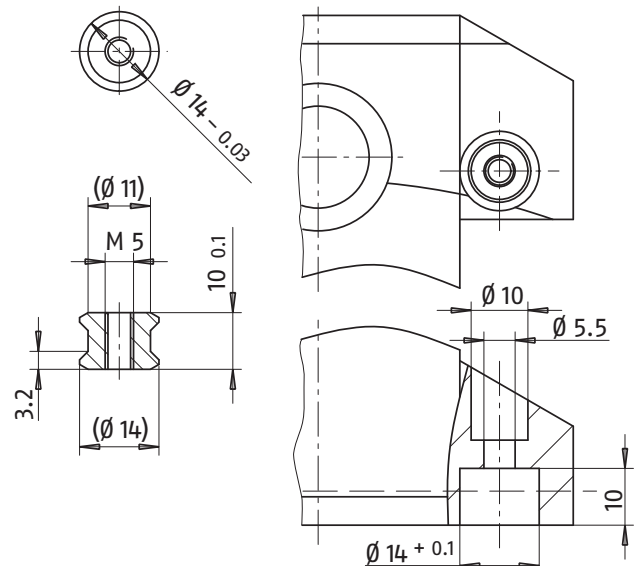
SCHUNK Model	Id.- No.	∅ A	B	∅ C	∅ D	L	E min. 9	Screw DIN EN ISO 4762
HM 6	184 106	6.0	8.5	3.4	6	10.0	9	M3 x 14
HM 8	184 107	8.0	8.5	4.5	8	10.0	9	M4 x 14
HM 10	184 100	10.0	8.5	5.5	10	10.0	9	M5 x 14
HM 11	184 101	12.7	8.0	5.5	10	9.5	9	M5 x 14
HM 12	184 102	12.7	11.2	6.6	11	12.7	11	M6 x 16
HM 13	184 103	15.8	8.0	6.6	11	9.5	11	M6 x 16
HM 14	184 104	19.0	8.0	6.6	11	9.5	11	M6 x 16
HM 15 angular design	184 104	12.7 ^{+0.05} / _{+0.15}	8.0	6.6	11	9.5	11	M6 x 16

- Boring / chamfering depending on ∅

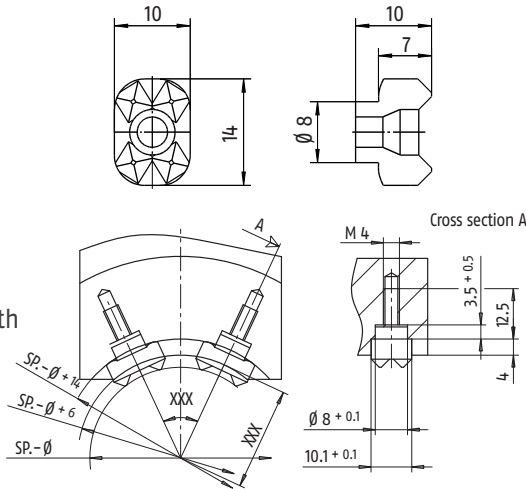
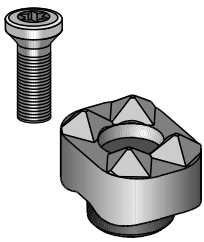


Typ RHS

- Secure clamping with short clamping depth
- In case of one-sided wear, reverse or turn to continue working
- Material: HSS
- Installation: Clamping ∅ + 7 mm boring / chamfering / milling



UGE 10 Id.-No. 100 000



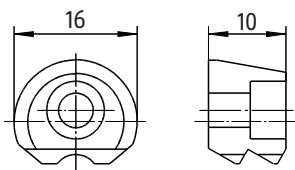
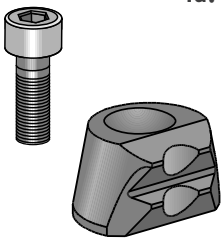
Scope of delivery:
Clamping insert with
Torx profile screw
M4 x 13.5

- For flat and round clamping surfaces
- For O.D. and I.D. clamping
- Support round or flat
- Mounting from the front
- Clamping insert seat: Groove (round or flat) and thread can easily be manufactured
- Hardening of jaws necessary

Installation instructions:

1. Clamping $\varnothing + 6$ mm + mill groove
2. Drill threads
3. Insert jaw and harden

UGE 20 Id.-No. 100 013 Precision cast Id.-No. 100 019 Carbide

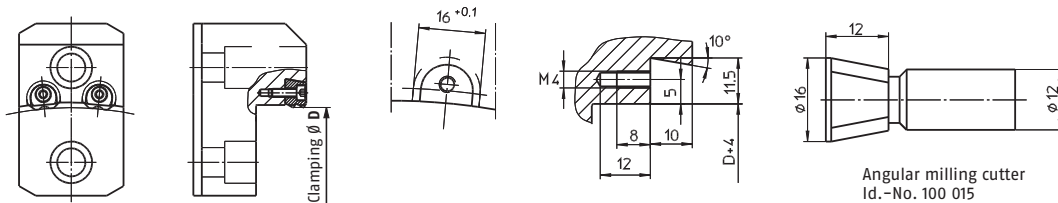


Scope of delivery:
Clamping insert with cylindrical screw M 4 x 12 DIN EN ISO 4762

- Mounting from above
- For O.D. and I.D. clamping
- Pull-down due to wedge shape
- Self-centering / oscillating
- Clamping insert seat: Milled recess can easily be manufactured with angular milling cutter
- No hardening of jaws necessary

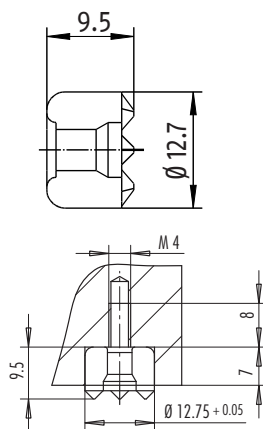
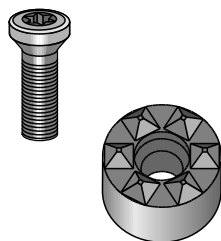
Installation instructions:

1. Turn/mill clamping $\varnothing + 4$ mm + workpiece support
2. Mill pocket + tap



Angular milling cutter
Id.-No. 100 015

UGE 30 Id.-No. 100 014



Scope of delivery:
Clamping insert with
Torx profile screw M4 x 13.5

The clamping insert for prismatic jaws and vises

- For O.D. and I.D. clamping of cubic parts
- For turning jaws, vises, devices
- Mounting from the front
- Clamping insert seat: Bore + thread can be manufactured easily Base 120° (standard drill) or flat drill
- Hardening of jaws is recommended for continuous operation

Installation instructions:

1. Drill 12.7 \varnothing base 120° or flat
2. Tap