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Tool Holder Catalog

TRAUB TNC65

VDI 30

Disclaimer

The illustrations in this documents may deviate from the delivered product. We reserve the right to make changes due to errors or based on technical advances.

Abbreviations used in the catalog:

AK	=	external cooling lubricant supply
ca.	=	approximately
D	=	diameter
max	=	maximum
min	=	minimum
IK	=	internal cooling lubricant supply
MK	=	Morse taper
R	=	radius
s	=	wrench size
SK	=	steep taper
Vkt	=	square

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For accessories for tool holders (such as collets, reducers & mounting sleeves, quick-change inserts, tool holders with parallel shank, cutting tools, presetting units, and polygon turning tools), see our catalog "Accessories for tool holders" (LY1002.10341) or visit <http://infoshop.index-werke.de/>

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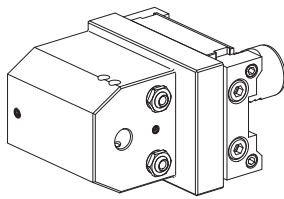
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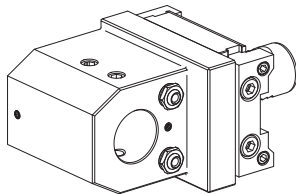
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W1340063 Drilling tool holder

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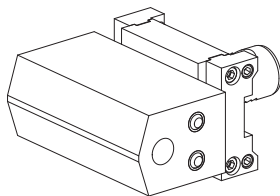
Fixation TRAUB bar (TNC42/65)
Mounting DIN 1835 B/E D12
Cooling external and internal, p_{max} 80 bar
X / Y / Z 78 (37) / – / 30 (1.18) mm (")



W1340064 Drilling tool holder

3-3

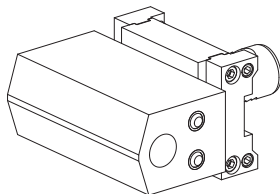
Fixation TRAUB bar (TNC42/65)
Mounting DIN 1835 B/E D32
Cooling external and internal, p_{max} 80 bar
X / Y / Z 78 (37) / – / 30 (1.18) mm (")



W1340065 Drilling tool holder, double

3-4

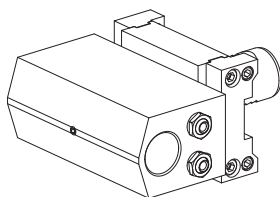
Fixation TRAUB bar (TNC42/65)
Mounting D16
Cooling external and internal, p_{max} 20 bar
X / Y / Z 70 (2.76) / – / 60 (2.36) mm (")



W1340066 Drilling tool holder, double

3-5

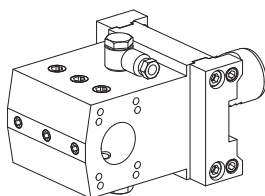
Fixation TRAUB bar (TNC42/65)
Mounting D20
Cooling external and internal, p_{max} 20 bar
X / Y / Z 70 (2.76) / – / 60 (2.36) mm (")



W1340067 Drilling tool holder, double

3-6

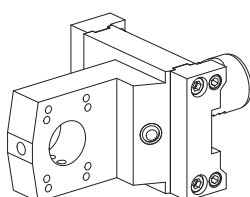
Fixation TRAUB bar (TNC42/65)
Mounting D25
Cooling external and internal, p_{max} 80 bar
X / Y / Z 70 (2.76) / – / 60 (2.36) mm (")



W1340068 Drilling tool holder, double

3-7

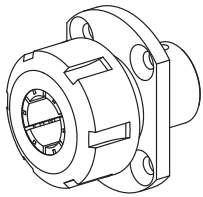
Fixation TRAUB bar (TNC42/65)
Mounting D25
Cooling external and internal, p_{max} 80 bar
X / Y / Z 70 (2.76) / – / 35 (1.38) mm (")



W1340069 Drilling tool holder

3-8

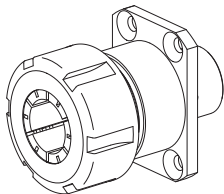
Fixation TRAUB bar (TNC42/65)
Mounting D25
Cooling external and internal, p_{max} 80 bar
X / Y / Z 70 (2.76) / – / 12.5 (0.49) mm (")



W9990706 Mount

3-9

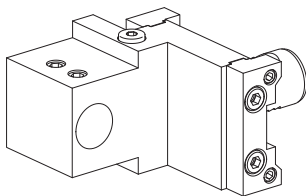
Fixation	–
Mounting	ER 25
Cooling	–
X / Y / Z	32 (1.26) / – / – mm (")



W9990707 Mount

3-10

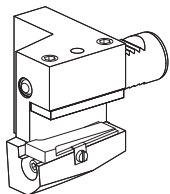
Fixation	–
Mounting	ER 32
Cooling	–
X / Y / Z	52 (25) / – / – mm (")



W1340072 Drilling tool holder

3-11

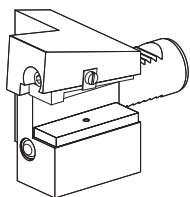
Fixation	TRAUB bar (TNC42/65)
Mounting	D25
Cooling	external, p _{max} 80 bar
X / Y / Z	70 (2.76) / – / -10 (-0.39) mm (")



W1300077 Turning tool holder, vertically adjustable

3-12

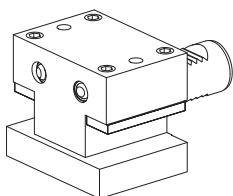
Fixation	–
Mounting	square 20x20
Cooling	external, p _{max} 20 bar
X / Y / Z	69 (2.72) / – / 42 (1.65) mm (")



W1300078 Turning tool holder, vertically adjustable

3-13

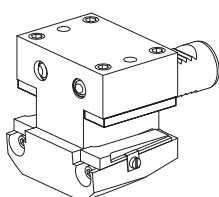
Fixation	–
Mounting	square 20x20
Cooling	external, p _{max} 20 bar
X / Y / Z	69 (2.72) / – / 42 (1.65) mm (")



W1300079 Turning tool holder, double

3-14

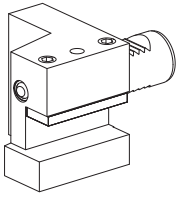
Fixation	–
Mounting	square 20x20
Cooling	external, p _{max} 20 bar
X / Y / Z	65 (2.56) / – / 42 (1.65) mm (")



W1300080 Turning tool holder, vertically adjustable, double

3-15

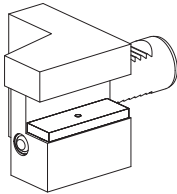
Fixation	–
Mounting	square 20x20
Cooling	external, p _{max} 20 bar
X / Y / Z	69 (2.72) / – / 42 (1.65) mm (")



W1300092 Turning tool holder, Form C1/C4

3-16

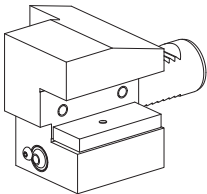
Fixation –
Mounting square 20x20
Cooling external, p_{max} 20 bar
X / Y / Z 65 (2.56) / – / 42 (1.65) mm (")



W1300094 Turning tool holder, Form C2/C3

3-17

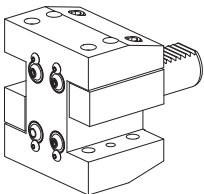
Fixation –
Mounting square 20x20
Cooling external, p_{max} 20 bar
X / Y / Z 65 (2.56) / – / 42 (1.65) mm (")



W1300001 Turning tool holder, Form C2/C3

3-18

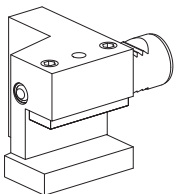
Fixation none
Mounting square 25x25
Cooling external, p_{max} 40 bar
X / Y / Z 70 (2.76) / – / 46 (1.81) mm (")



W1300011 Turning tool holder, double

3-19

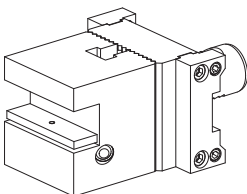
Fixation none
Mounting square 25x25
Cooling external, p_{max} 20 bar
X / Y / Z 64 (2.52) / – / 43 (1.69) mm (")



W1300093 Turning tool holder, Form C1/C4

3-20

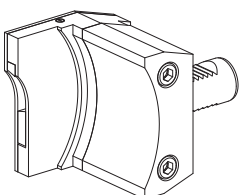
Fixation –
Mounting square 25x25
Cooling external, p_{max} 20 bar
X / Y / Z 65 (2.56) / – / 47 (1.85) mm (")



W1340071 Turning tool holder, vertically adjustable

3-21

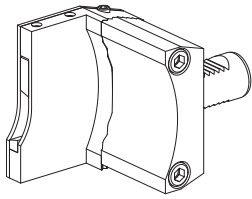
Fixation TRAUB bar (TNC42/65)
Mounting square 20x20
Cooling external, p_{max} 20 bar
X / Y / Z 95 (3.74) / – / 33 (1.3) mm (")



W1300083 Grooving tool holder, vertically adjustable

3-22

Fixation –
Mounting Trapezoid 32x8
Cooling external, p_{max} 20 bar
X / Y / Z 86 (3.39) / – / 59.5 (2.43) mm (")

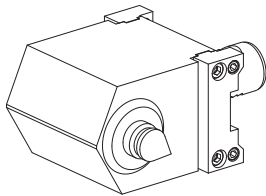


W1300084 Grooving tool holder, vertically adjustable

Catalog page

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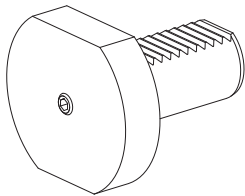
Fixation	–
Mounting	Trapezoid 32x8
Cooling	external, p_{\max} 20 bar
X / Y / Z	86 (3.39) / – / 59.5 (2.43) mm (")



W1340074 Center holder

3-24

Fixation	TRAUB bar (TNC42/65)
Mounting	–
Cooling	–
X / Y / Z	70 (2.76) / – / 78.5 (3.09) mm (")

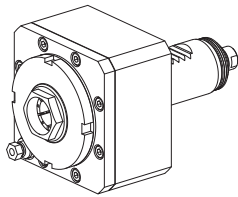


W1300060 Blanking plug

3-25

Fixation	none
Mounting	–
Cooling	–
X / Y / Z	16 (0.63) / – / – mm (")

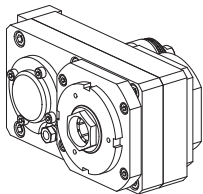
Catalog page



W1305041 Milling unit

4-2

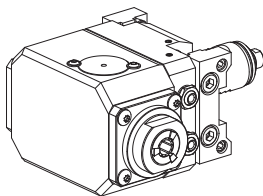
Fixation	–
Mounting	ER 25
Cooling	external, p_{max} 40 bar
Speed ratio	1:1 (1)
X / Y / Z	60 (2.36) / – / 0 mm (")



W1345099 Milling unit

4-3

Fixation	TRAUB bar (TNC42/65)
Mounting	ER 25
Cooling	external, p_{max} 40 bar
Speed ratio	3:1 (3)
X / Y / Z	49.1 (1.93) / – / 67.5 (2.66) mm (")



W1345104 Drilling unit

4-4

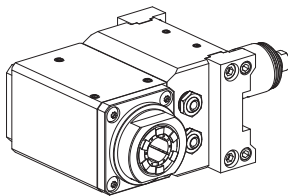
Fixation	TRAUB bar (TNC42/65)
Mounting	ER 16
Cooling	external, internal optional, p_{max} 80 bar
Speed ratio	1:3 (0.333)
X / Y / Z	70 (2.76) / – / 80 (3.15) mm (")

No picture available!

W1345095 Drilling unit

4-5

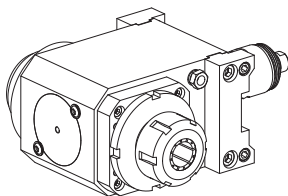
Fixation	TRAUB bar (TNC42/65)
Mounting	ER 20
Cooling	external, p_{max} 80 bar
Speed ratio	1:2 (0.5)
X / Y / Z	70 (2.76) / – / 39 (1.54) mm (")



W1345093 Milling unit

4-6

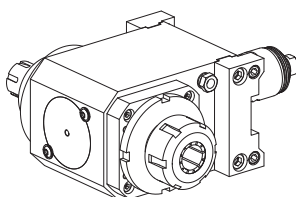
Fixation	TRAUB bar (TNC42/65)
Mounting	ER 25
Cooling	external, internal optional, p_{max} 80 bar
Speed ratio	1:1 (1)
X / Y / Z	78 (37) / – / 64 (2.52) mm (")



W1345094 Milling unit

4-7

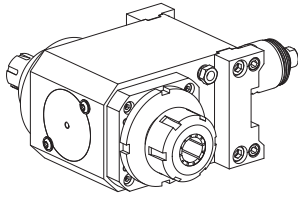
Fixation	TRAUB bar (TNC42/65)
Mounting	ER 25
Cooling	external, p_{max} 80 bar
Speed ratio	3:1 (3)
X / Y / Z	70 (2.76) / – / 78 (37) mm (")



W1345097 Milling unit

4-8

Fixation	TRAUB bar (TNC42/65)
Mounting	ER16/ER25
Cooling	external, p_{max} 80 bar
Speed ratio	1:1 (1)
X / Y / Z	70 (2.76) / – / 83 + 78 (3.27 + 3.07) mm (")



W1345098 Milling unit

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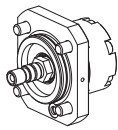
Fixation	TRAUB bar (TNC42/65)
Mounting	ER16/ER25
Cooling	external, p_{\max} 80 bar
Speed ratio	3:1 (3)
X / Y / Z	70 (2.76) / – / 82 + 78 (3.23 + 3.07) mm (")

No picture available!

W1345096 Drilling unit

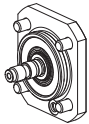
4-10

Fixation	TRAUB bar (TNC42/65)
Mounting	ER 11
Cooling	external, p_{\max} 80 bar
Speed ratio	1:1.88 (0.533)
X / Y / Z	60 (2.36) / – / – mm (")



W9990284 IC Attachment
for internal cooling lubricant supply, up to 160 bar

Catalog page
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W9990290 IC Attachment
for internal cooling lubricant supply, up to 80 bar
no dry run

5-3

W9800008EN Product note

External/internal cooling lubricant supply
Milling unit, lid convertible to IC 80 bar / 160 bar
Offset set screws

Technical Information
TRAUB TNC65

Warranty



When using tool holders that have not been set, checked and labeled accordingly by INDEX TRAUB, warranty is not applicable to the tool drive.

Information on wear parts

Tool holders and guide bushings are wear parts requiring correct handling.

In order to ensure a long service life, compressed air or coolant must not enter the gap seals of the holders or of the guide bushings.

Inspection of live tool holders and guide bushings



Tool holders and guide bushings must be inspected at regular intervals (at least twice a year) for smooth running and play.



The drive pinion and drive clutch of the live tool holders must be subjected to a visual inspection for damage or wear.

If one of the above-mentioned defects is detected during the inspection of the tool holders or guide bushings, they must be returned immediately for preventive maintenance or repair to the following address:

TRAUB Drehmaschinen GmbH & Co. KG
 Hauffstrasse 4
 D-73262 Reichenbach, Germany
 Phone +49 (0) 7153 502-554
 werkzeughalter@traub.de

Tool holders with cooling lubricant supply



Tool holders marked with this symbol must be operated with cooling lubricant (no dry run permitted).

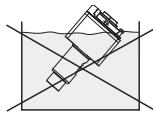


Tool holders marked with this symbol must be operated with cooling lubricant when converting from external cooling lubricant supply to internal cooling lubricant supply. Observe dry run capability of IC attachment!

Cooling lubricant filtering

When using live tool holders with internal cooling lubricant supply, it is necessary to use a cooling lubricant filter system with a retained particle size $\leq 50 \mu\text{m}$.

Cleaning live tool holders



Live tool holders must never be immersed in cleaning fluid since mixing the cleaning fluid with the bearing grease will reduce the service life of the tool holders.

Speed ratio specifications on tool holders

The value to be programmed is specified in the documentation and on the live tool holders
(= the input in the NC program).

$$n_{\text{prog}} = n_{\text{tool}} \times i$$

n_{tool} = speed at cutting tool edge

n_{PROG} = speed to be programmed

i = speed ratio in the tool holder

This means: the speed increase or speed reduction is not specified as a fraction but as **a number**.

This gives speed **increase** ratios as numbers **smaller than 1**.

Example:

$i = 0.333$ (corresponds to $i = 1:3$)

$i = 0.676$ (corresponds to $i = 1:1.48$)

Step-down ratios result in numbers **>1**

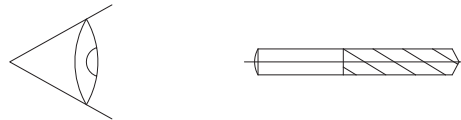
For example:

$i = 2$ (corresponds to $i = 2:1$)

$i = 1.333$ (corresponds to $i = 4:3$)

Direction of rotation specification



Definition of the viewing direction.
Viewing direction for determining the direction of rotation is always from behind (that is, from the drive direction) toward the shaft.



On the machine side, the direction of rotation has been set by parameters such that M03 always denotes clockwise rotation and M04 counter-clockwise run at the interface of the drive pinion of the tool holder.

The direction of rotation given on the holder thus always refers to a "change in direction within a holder".

M03 and M04 are machine functions to be programmed.

The  and  arrows indicate the direction of rotation of the cutting edges.

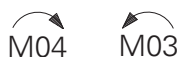
This means:

No reversal of direction of rotation



- When the holder drive shaft has the **same** direction of rotation as the tool cutting edge, the clockwise direction of run must be specified by M03 (clockwise rotation). Accordingly, counter-clockwise run must be specified by M04.

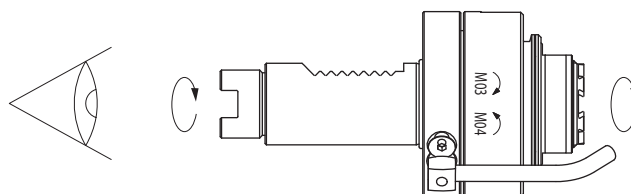
Reversal of direction of rotation



- When the holder drive shaft has the **opposite** direction of rotation as the tool cutting edge, the clockwise direction of rotation must be specified by M04. Accordingly, counter-clockwise run must be specified by M03.

Example

No reversal of direction of rotation



Tightening torque

The tightening torques of the clamping pieces to the tool holder mounting depends on the shank diameter of the tool holder.

Shank size	Tightening torque
Ø 30mm	25 Nm

Replacement seals for tool shank

See the accessories.

The gaskets on the tool shank and the cooling lubricant bushing must be regularly checked for damages.

Tool holders with fixation



Except for very few cases, all tool holders have been pre-adjusted with high precision and sealed with the INDEX V bar / TRAUB adjusting bar / W-serration. This setting must not be changed.

The INDEX V bar / TRAUB adjusting bar / W-serration ensures positional accuracy of the tool when re-inserted.

The tool holders are fixed around the shank axis by pins (DIN 69880).

DIN holders can be used.

Double serration of the tool holders allows several uses.

Load limits of live tools

The drive power and torques are indicated in the performance charts. These values represent the upper limit of the calculated theoretical performance values (average values). In case of interrupted cuts, e.g., for milling, the load peaks occurring when the cutting edge enters the material may be much higher than the theoretical torque according to the performance chart.



The cutter should be selected such that a cutting edge is constantly being used for cutting during the machining process.

Live tool holders

Only the tool located in the working position is live.

The live tool holders are inserted into the mounting bores in the tool carriers just like non-live tool holders.

Each turret station can accept one live tool.

The motor drives the tool that is exclusively in working position. In addition, the index drive is actuated by switching using the same motor.



Before using the machine, make sure that all mounting bores without a tool have been closed with a blanking plug and that the gasket on all tool holders is not damaged.



Any mounting bores not used must be closed with blanking plugs during machining processes.

Weight distribution on turret head



Tool holders may have considerably different weights depending on their function and equipment. Therefore, be sure to balance the tool holders evenly around the turret head when tooling.

Collision

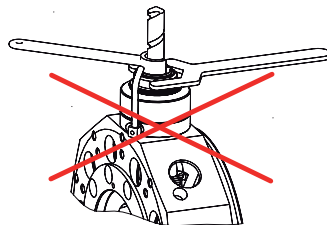


After a collision has occurred, check whether the tool carrier has been displaced. If this is the case, the tool carrier must be realigned to ensure that the drive and tool holder gears accurately engage with each other.

Tool change on live tool holders

To avoid damaging or changing the adjustment of the drive train in the turret, tools must **not** be changed on the live tool holders inserted in the turret.

Tools in live tool holders must be changed outside the machine.



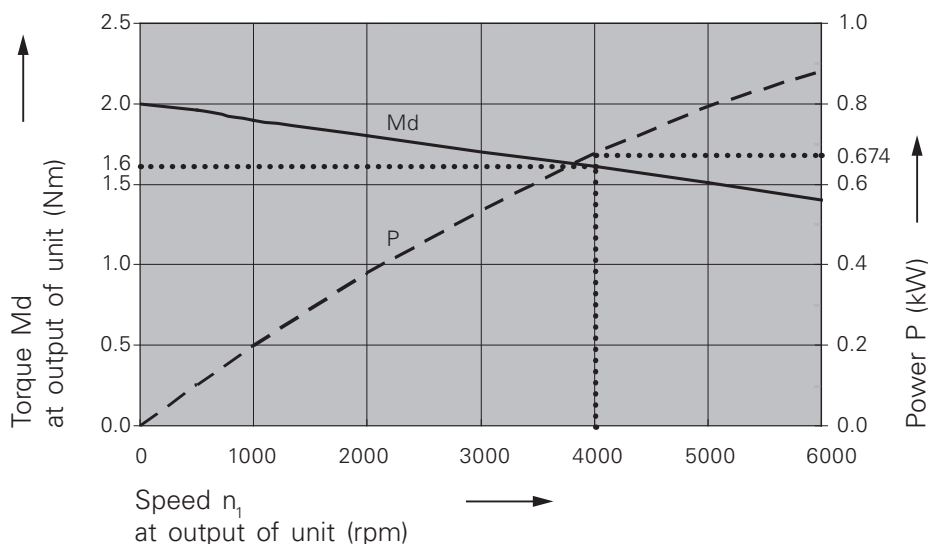
Notes on how to use the chart when using tool holders

The chart relates to the output speed **n** of the tool unit. The tool speed can be read directly from the chart only if the internal speed ratio **i** in the tool holder is 1:1.

For tool holders (e.g., VDI holders) with an internal speed ratio $i \neq 1$, the output speed **n** of the tool unit to be programmed must be calculated from the required tool speed and the speed ratio **i**. Afterwards, the actual powers or torques can be read off or determined.

Example (at 100% duty cycle):

live tool unit, tool speed $n_{Tool} = 1000$ rpm	
Internal speed ratio <i>i</i> of the tool holder	$i = 4$
Programmed speed n_{prog} for the drive of the unit	$n_{prog} = n_{Tool} \times i = 1000 \text{ rpm} \times 4 = 4000 \text{ rpm}$
Torque M_{Tool} at the output of the tool holder	Read-out M_d at speed $n_{prog} = 4000 \text{ rpm} = 1.6 \text{ Nm}$ $M_d = M_{Tool} : i$ Formula changed: $M_{Tool} = M_d \times i = 1.6 \text{ Nm} \times 4 = 6.4 \text{ Nm}$
Power <i>P</i> at the output of the tool holder ≈ Power <i>P</i> at the output of the setup	Read-out at 4000 rpm → $P = 0.67 \text{ kW}$ calculated: $P = 2 \times \pi \times n_{prog} \times M_d$ $P = \frac{2 \times \pi \times 4000 \times 1.6 \text{ Nm}}{60 \times 1000} = 0.67 \text{ kW}$



The speed ratio and the technical data of each tool holder are indicated on the next pages.

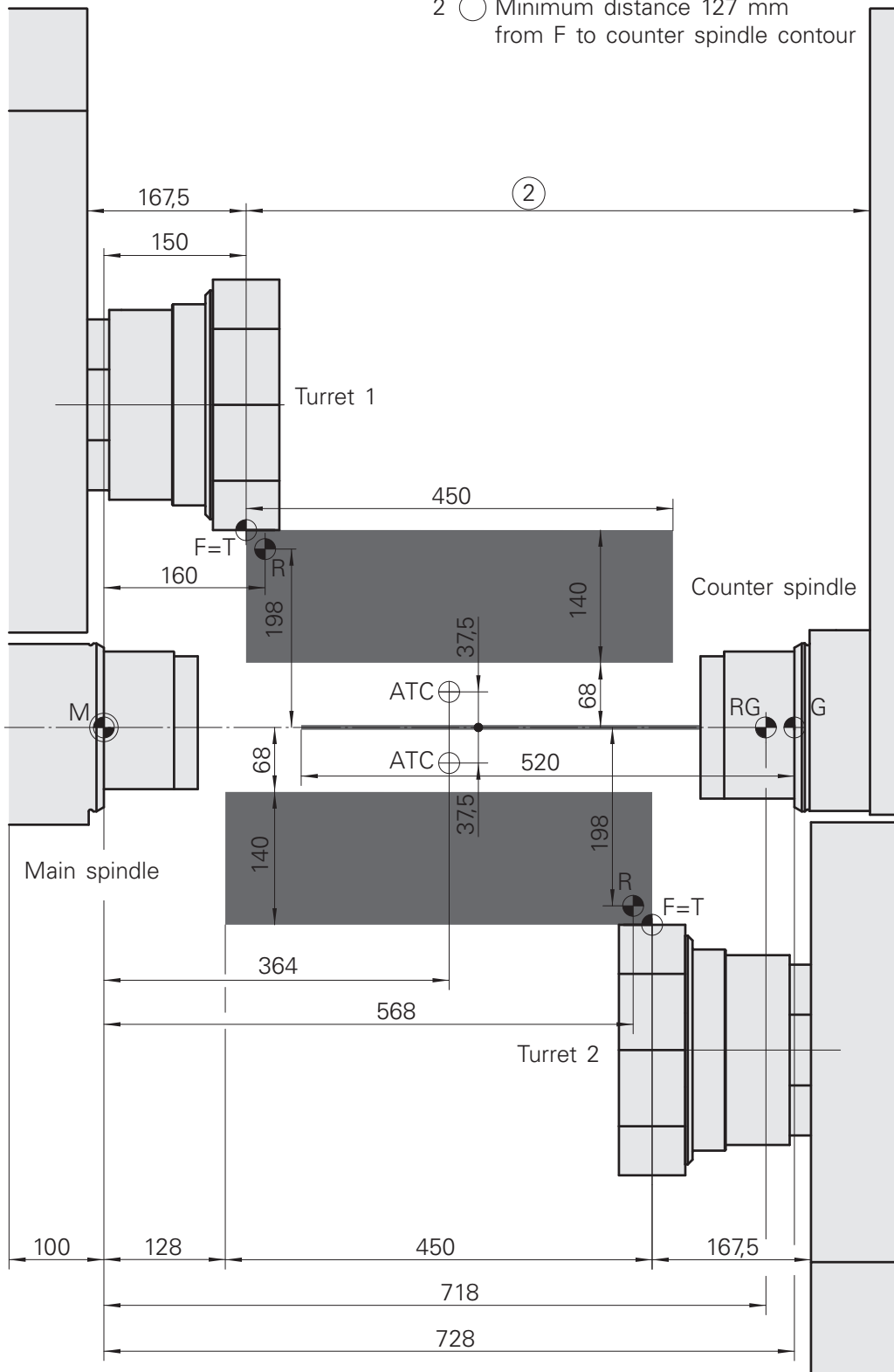
Usage Information
TRAUB TNC65

Work Area TNC65

Tool mounting VDI 30

- M Machine zero point
- R Turret reference point
- G Counter spindle reference point
- RG Reference point counter spindle
- F=T Tool carrier / tool reference point
- ATC Tool microscope reference point

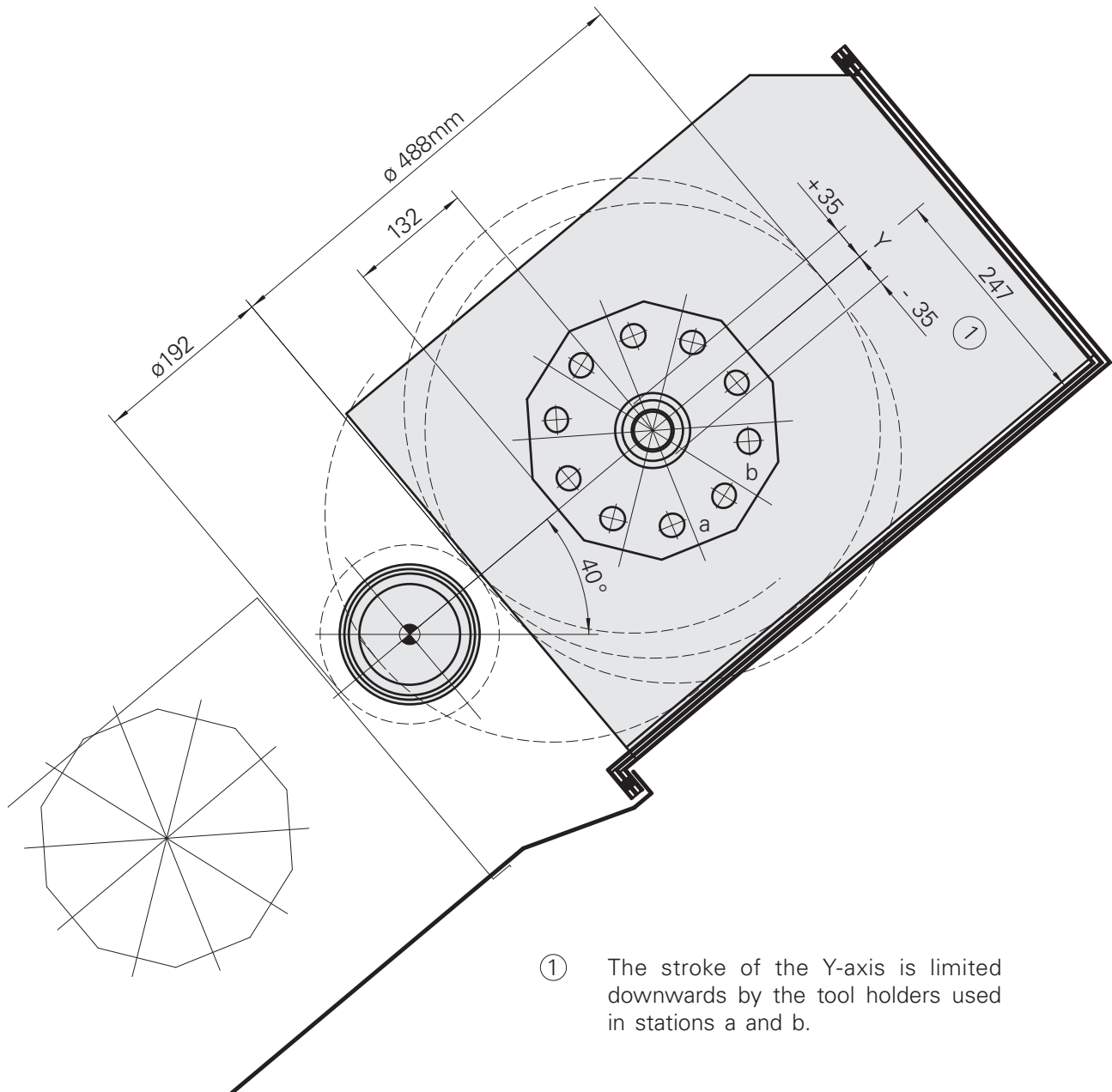
2 ○ Minimum distance 127 mm from F to counter spindle contour



Work Area TNC65

Turret 1

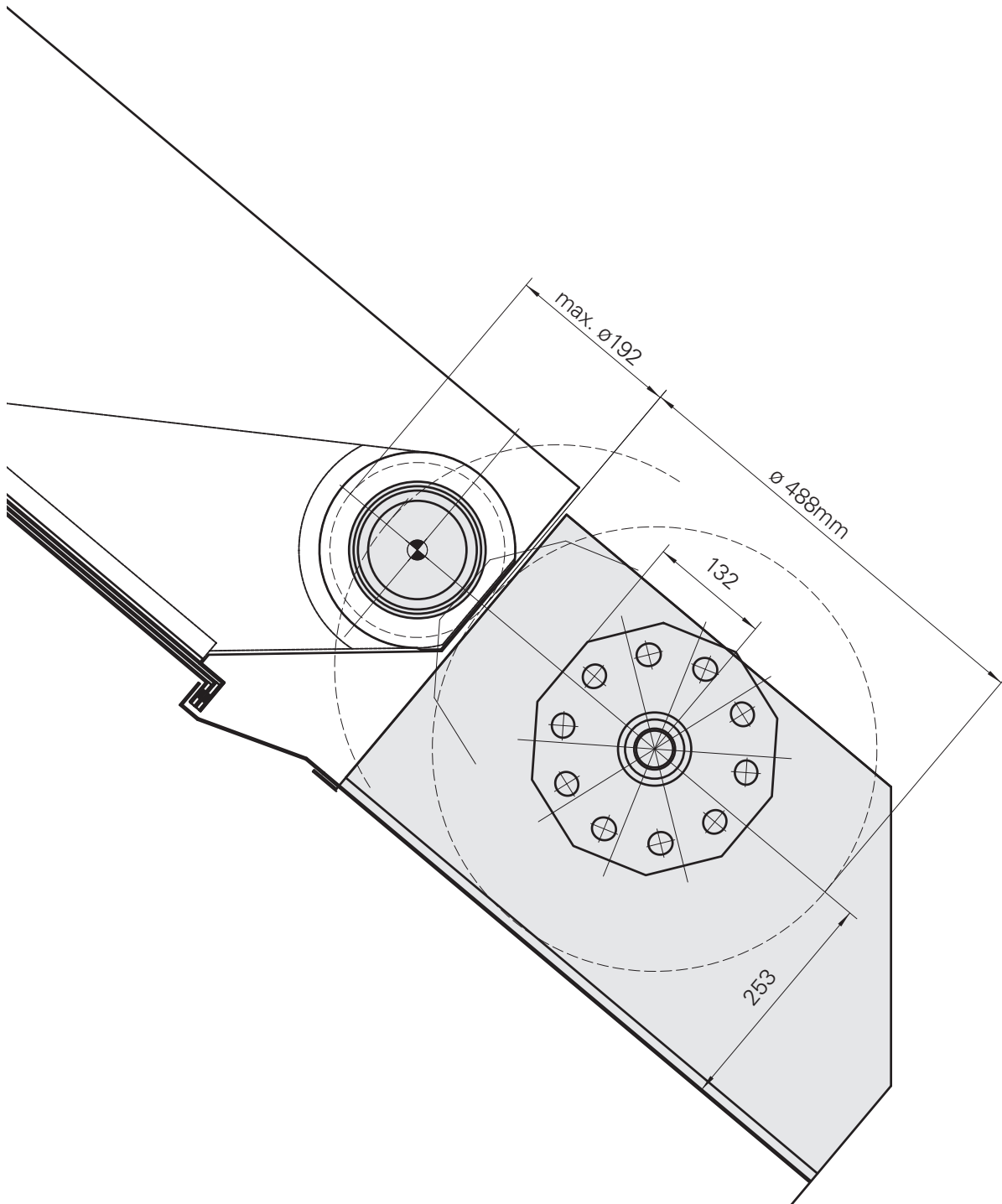
Tool mounting VDI 30



Work Area TNC65

Turret 2


Tool mounting VDI 30

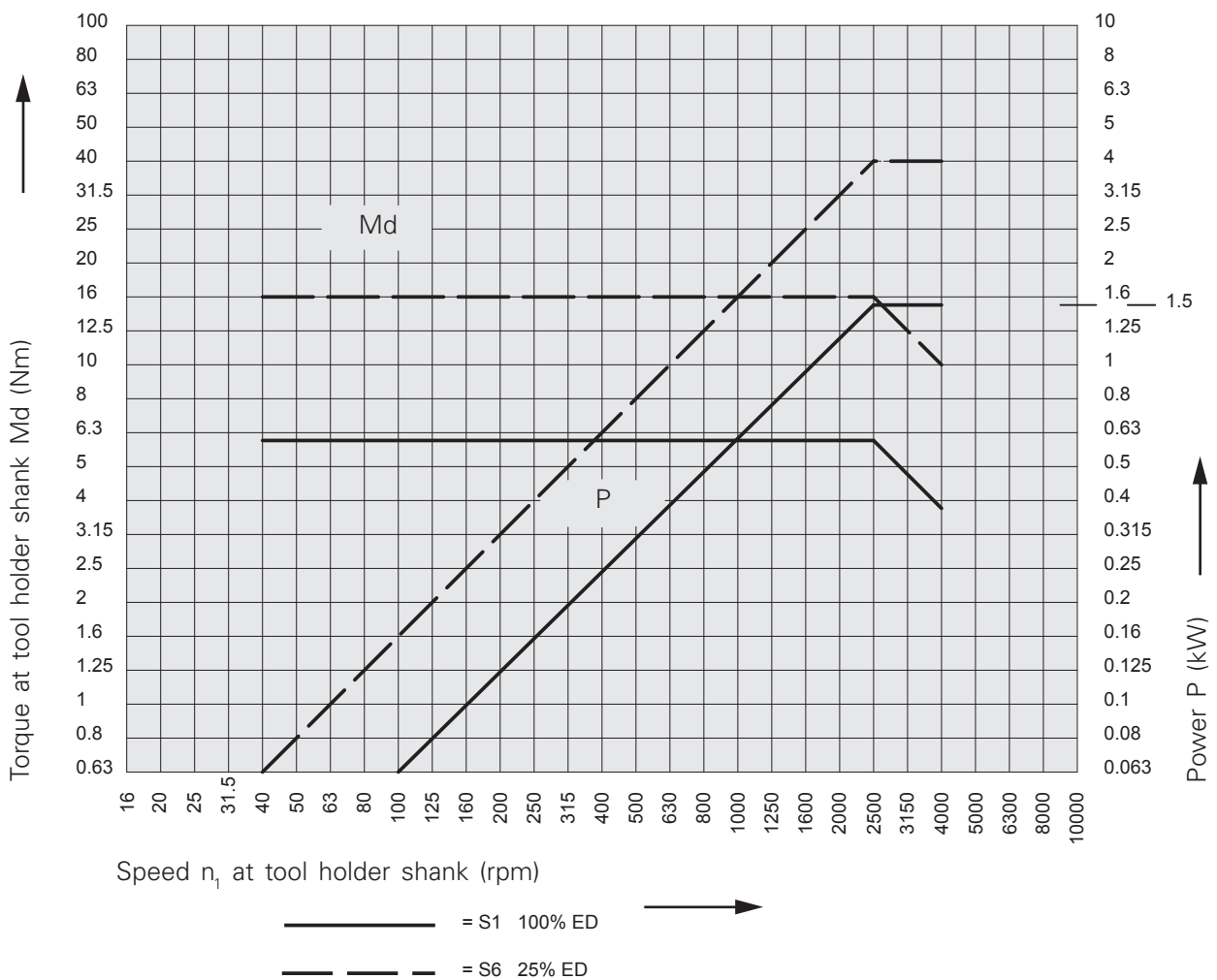


Performance Diagram

Live tools

Speed range 0-4000 rpm

 For information on how to use the diagram, see Chapter "Technical Information".



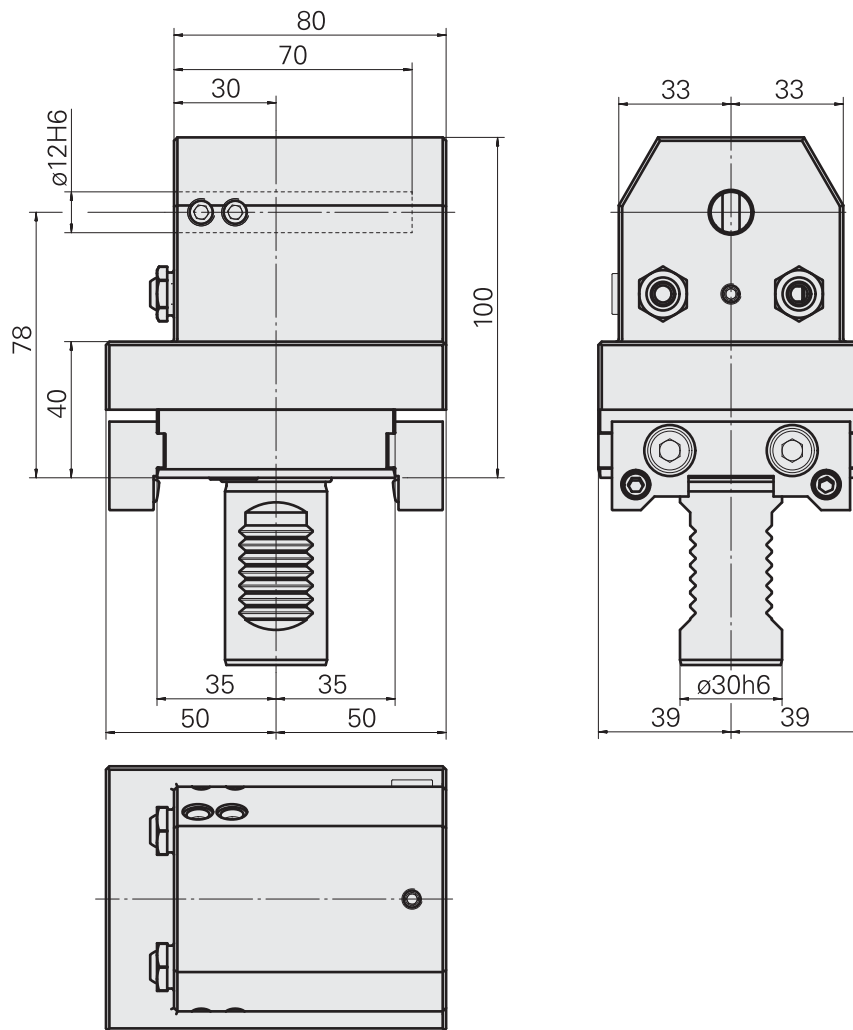
**Tool holder fix
shank VDI 30**

Drilling tool holder

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Mounting	DIN 1835 B/E D12
Cooling	external and internal, p_{max} 80 bar
reversible 180°	yes
X / Y / Z	78 (37) / - / 30 (1.18) mm (")

Matching accessories

Bush	W94280.21--
Bush	993112.----
Bush*	W67530.0824
Nozzle*	W67500.3208
Hollow screw*	W67530.0818



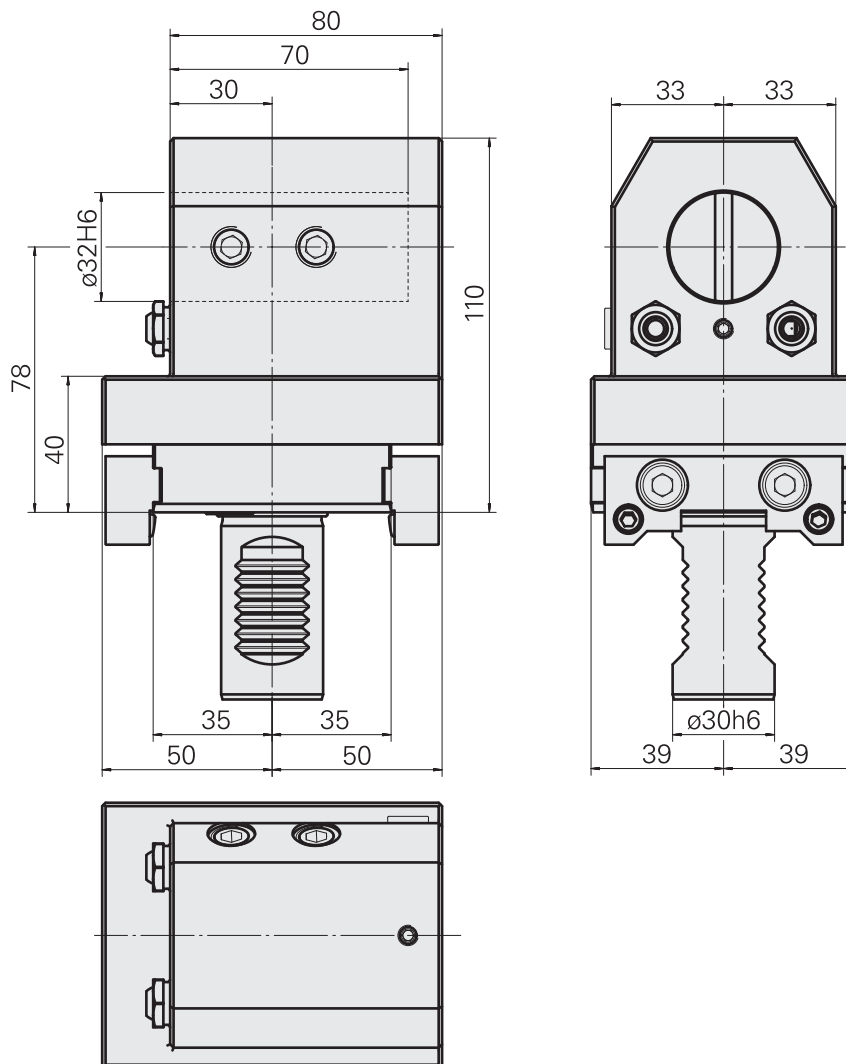
* This article is included

Drilling tool holder

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Mounting	DIN 1835 B/E D32
Cooling	external and internal, p_{max} 80 bar
reversible 180°	yes
X / Y / Z	78 (37) / - / 30 (1.18) mm (")

Matching accessories

Bush	W63220.02--
Bush	W63221.40--
Reduction sleeve	W9990097
Reduction sleeve	W9990098
Reduction sleeve	W9990099
Chucking sleeve	993132.----
Bush*	W67530.0824
Nozzle*	W67500.3208
Hollow screw*	W67530.0818



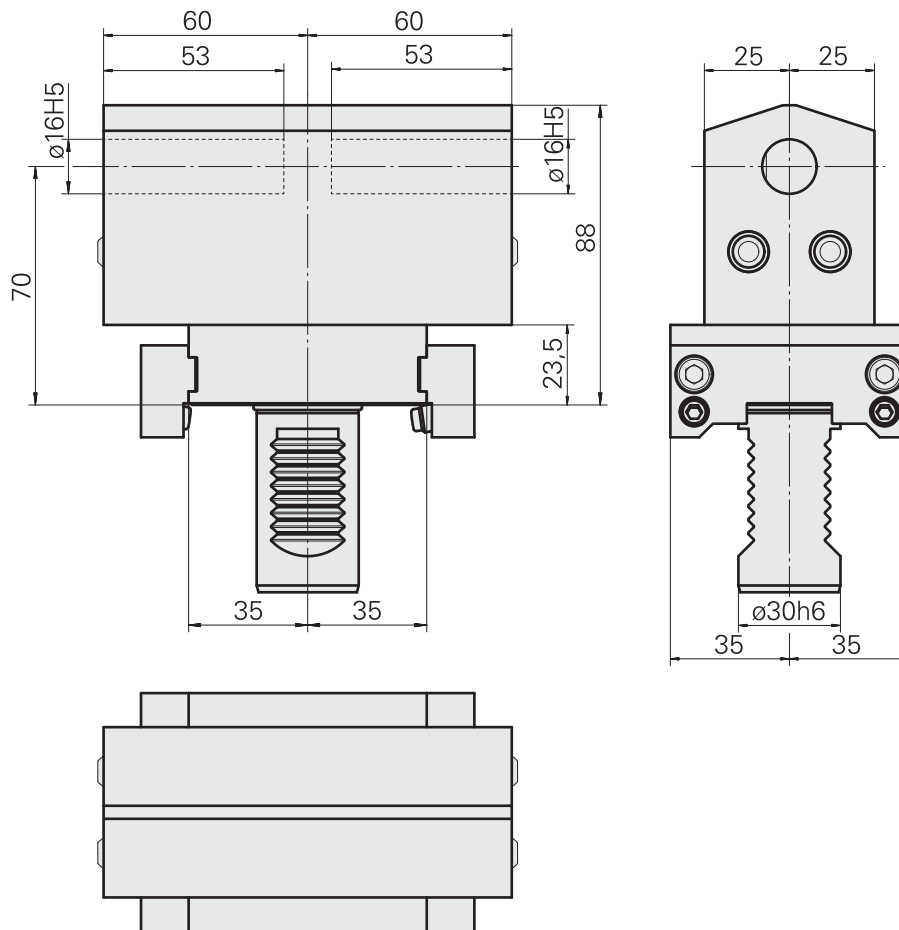
* This article is included

Drilling tool holder, double

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Mounting	D16
Cooling	external and internal, p_{max} 20 bar
reversible 180°	yes
X / Y / Z	70 (2.76) / - / 60 (2.36) mm (")

Matching accessories

Bush	W67511.04--
Bush	W95280.215-
Nozzle*	322092
Bush*	322093
Gasket ring*	322089
Pressure spring*	322091



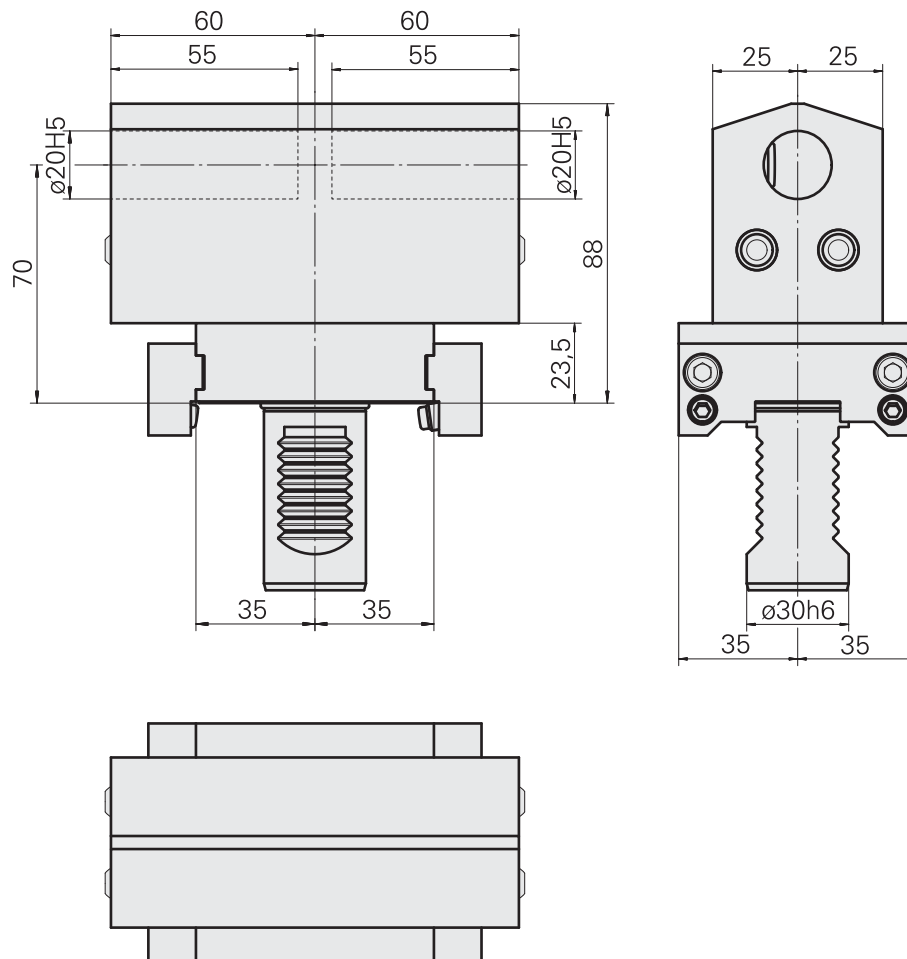
* This article is included

Drilling tool holder, double

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Mounting	D20
Cooling	external and internal, p_{max} 20 bar
reversible 180°	yes
X / Y / Z	70 (2.76) / - / 60 (2.36) mm (")

Matching accessories

Bush	W62220.01--
Bush	W68510.04--
Bush	993120.----
Bush	W37610.2012
Bush	W95280.115-
Nozzle*	322092
Bush*	322093
Gasket ring*	322089
Pressure spring*	322091



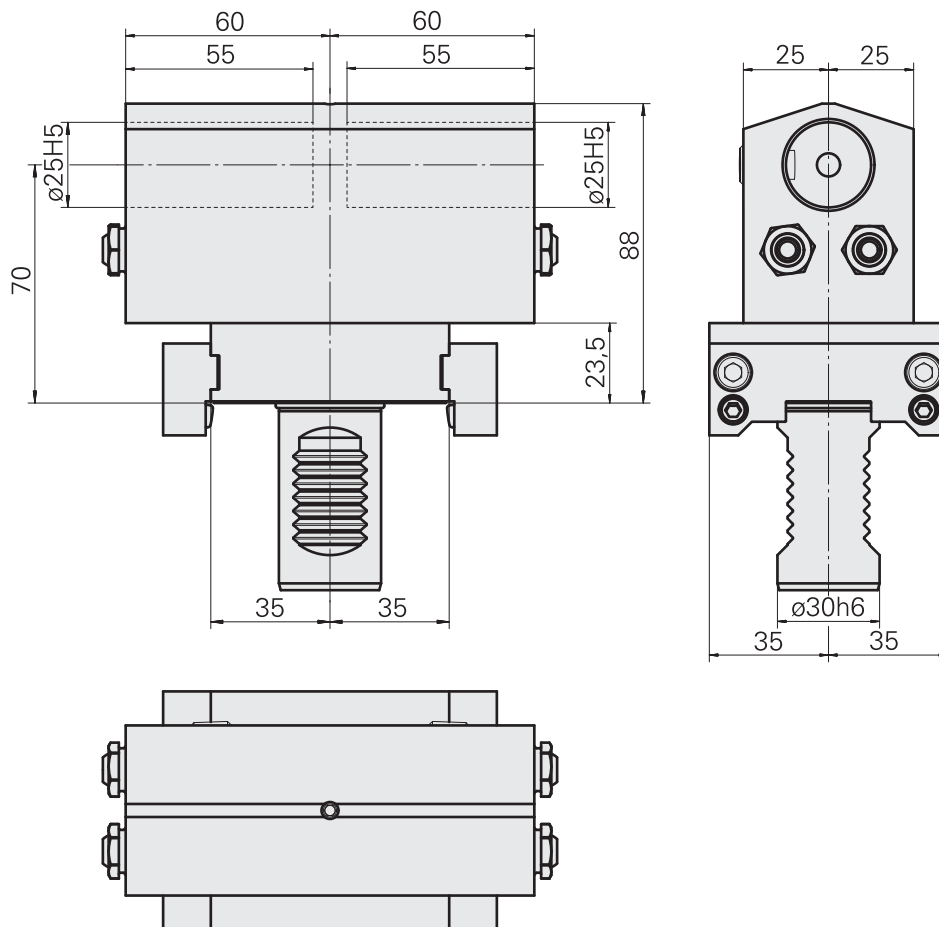
* This article is included

Drilling tool holder, double

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Mounting	D25
Cooling	external and internal, p_{max} 80 bar
reversible 180°	yes
X / Y / Z	70 (2.76) / - / 60 (2.36) mm (")

Matching accessories

Bush	W62221.41--
Bush	993125.----
Pressure pad	993825.----
Bush*	W67530.0824
Hollow screw*	W67530.0818
Nozzle*	W67500.3208



* This article is included

Drilling tool holder, double

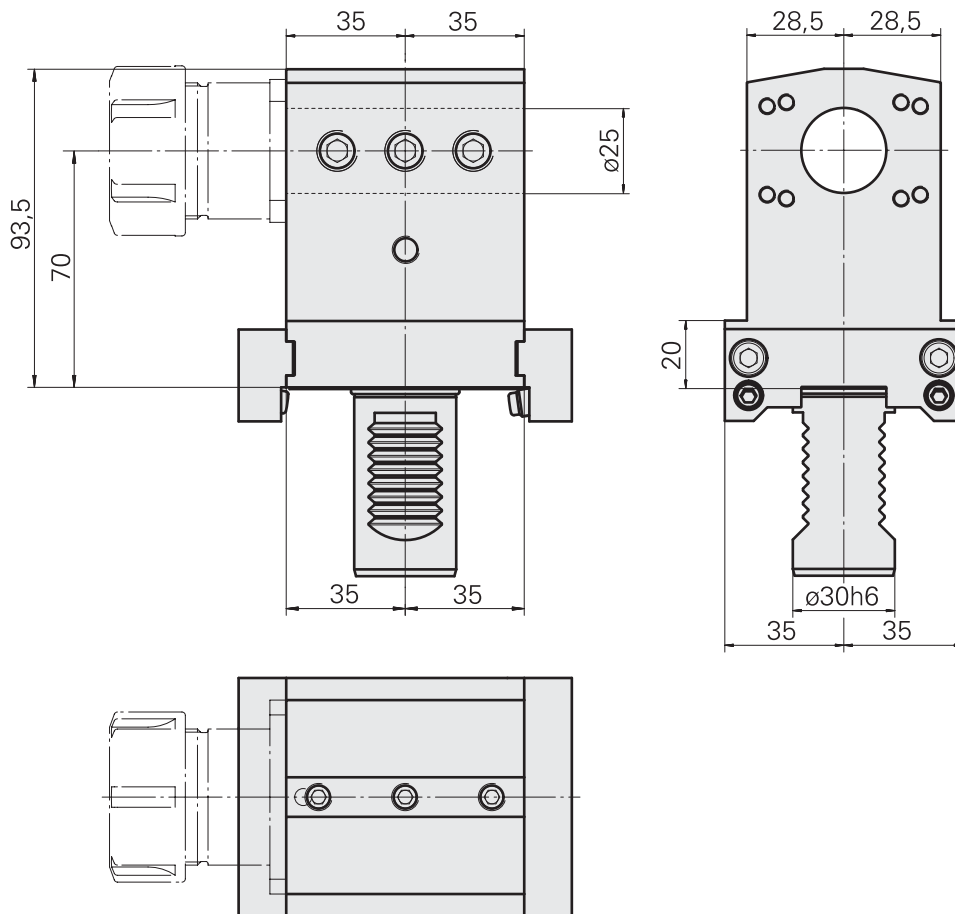
Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Mounting	D25
Cooling	external and internal, p_{\max} 80 bar
reversible 180°	yes
X / Y / Z	70 (2.76) / – / 35 (1.38) mm (")

Matching modules

Mount	W9990706
Mount	W9990707

Matching accessories

Multiple swivel joint*	314431
Clamp*	314439
Pressure spring*	314440



* This article is included

Drilling tool holder

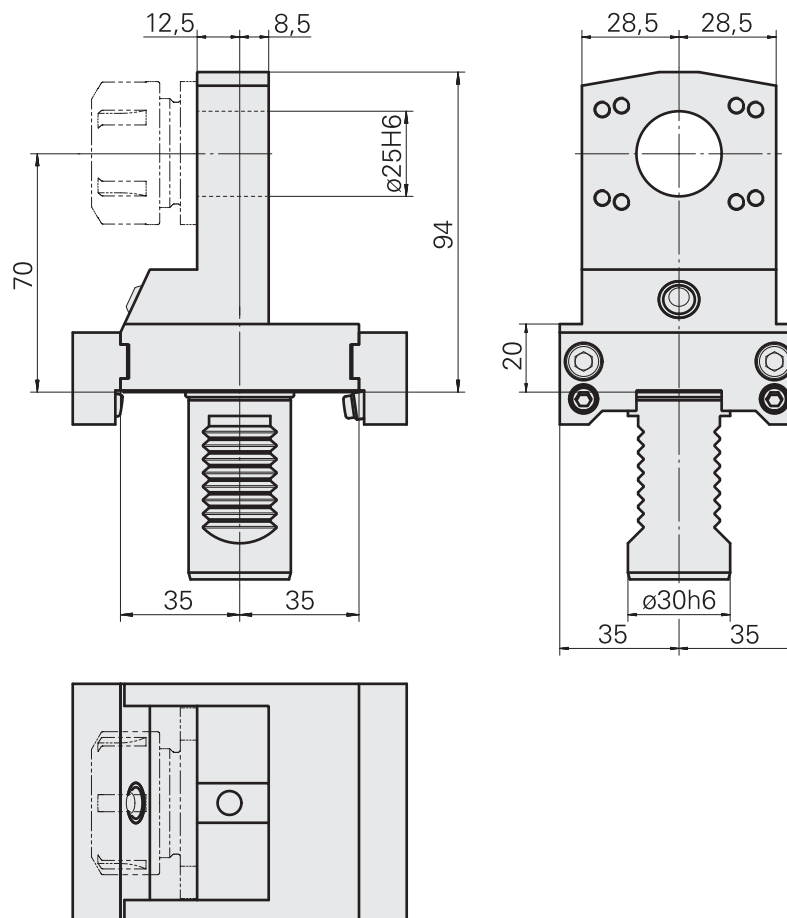
Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Mounting	D25
Cooling	external and internal, p_{max} 80 bar
reversible 180°	yes
X / Y / Z	70 (2.76) / - / 12.5 (0.49) mm (")

Matching modules

Mount	W9990706
Mount	W9990707

Matching accessories

Pressure spring*	322091
Gasket ring*	322089
Bush*	322093
Nozzle*	322092



* This article is included

Mount

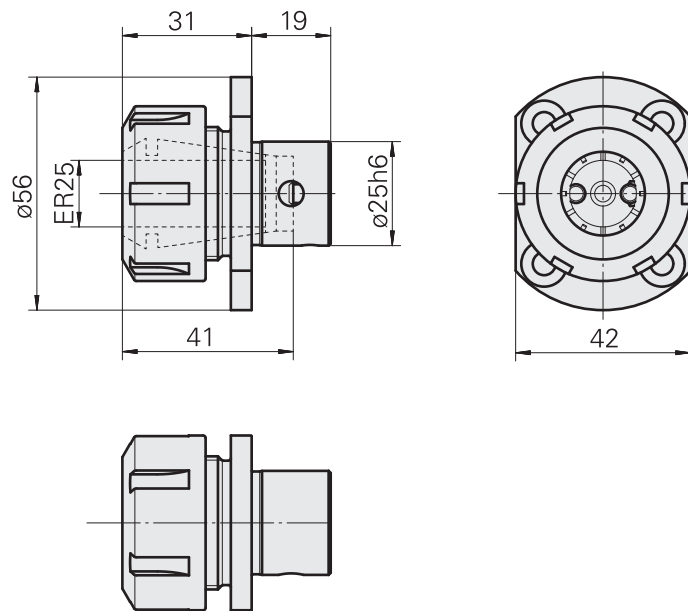
Shank	—
Fixation	—
Mounting	ER 25
Cooling	—
X / Y / Z	32 (1.26) / — / — mm (")

Matching base holder

Drilling tool holder	W1340069
Drilling tool holder	W1340068

Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping nut*	901939.0251
Spanner	490219.0251



* This article is included

Mount

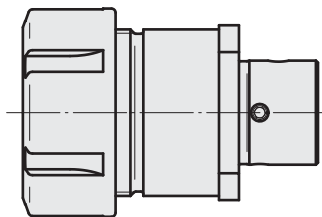
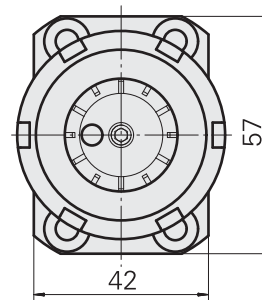
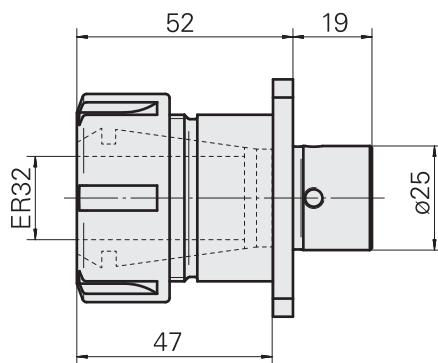
Shank	–
Fixation	–
Mounting	ER 32
Cooling	–
X / Y / Z	52 (25) / – / – mm (")

Matching base holder

Drilling tool holder	W1340069
Drilling tool holder	W1340068

Matching accessories

Clamping collet	901930.6---
tapping tool collet	3242--
tapping tool collet	WZ9990.9509F
Collet chuck	W999068-
Clamping nut*	901939.0321
Spanner	490219.0321



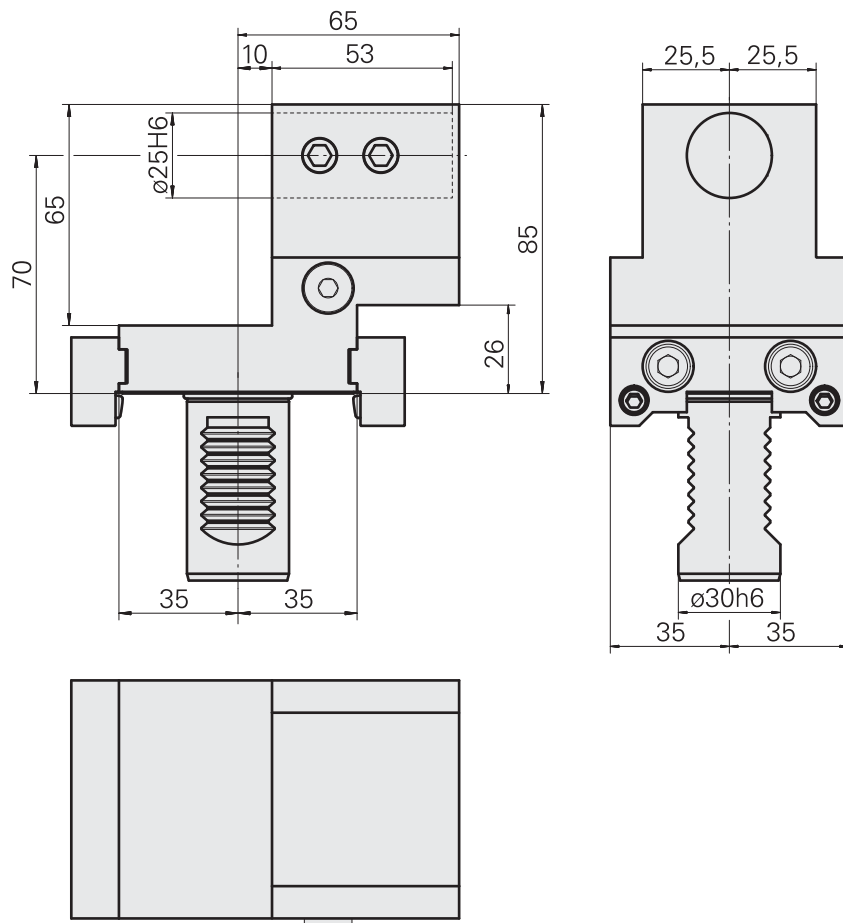
* This article is included

Drilling tool holder

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Mounting	D25
Cooling	external, p_{\max} 80 bar
reversible 180°	yes
X / Y / Z	70 (2.76) / - / -10 (-0.39) mm (")

Matching accessories

Bush	W62221.41--
Multiple swivel joint*	319562



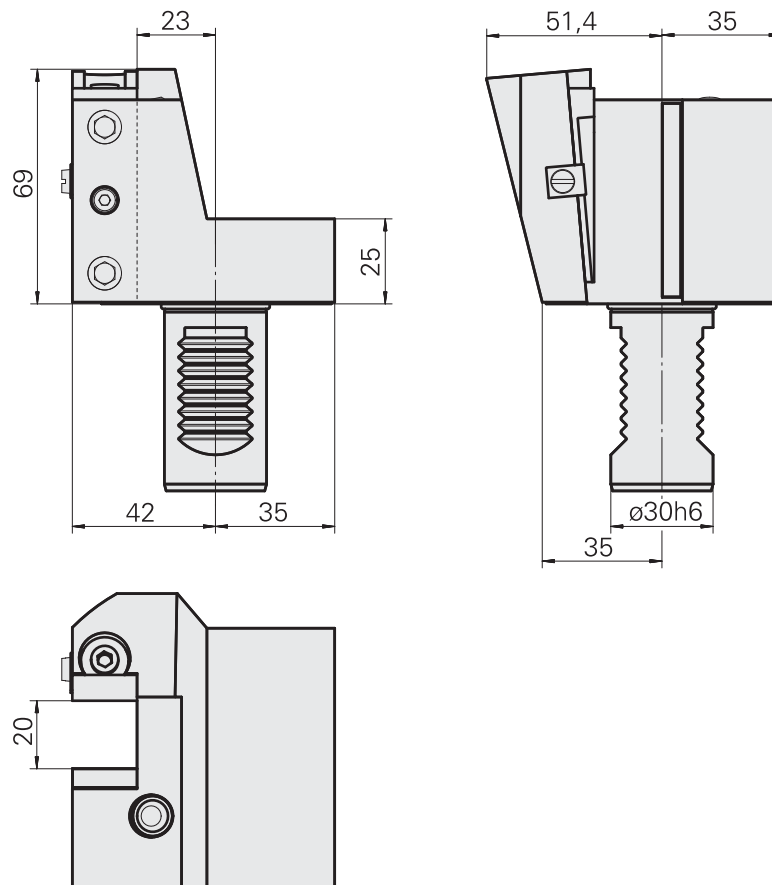
* This article is included

Turning tool holder, vertically adjustable

Shank	VDI 30
Fixation	–
Mounting	square 20x20
Cooling	external, p_{\max} 20 bar
reversible 180°	yes
X / Y / Z	69 (2.72) / – / 42 (1.65) mm (")

Matching accessories

Angle	W63300.0010
Angle	W63300.0020
Pressure spring*	322091
Gasket ring*	322089
Bush*	322093
Nozzle*	322092



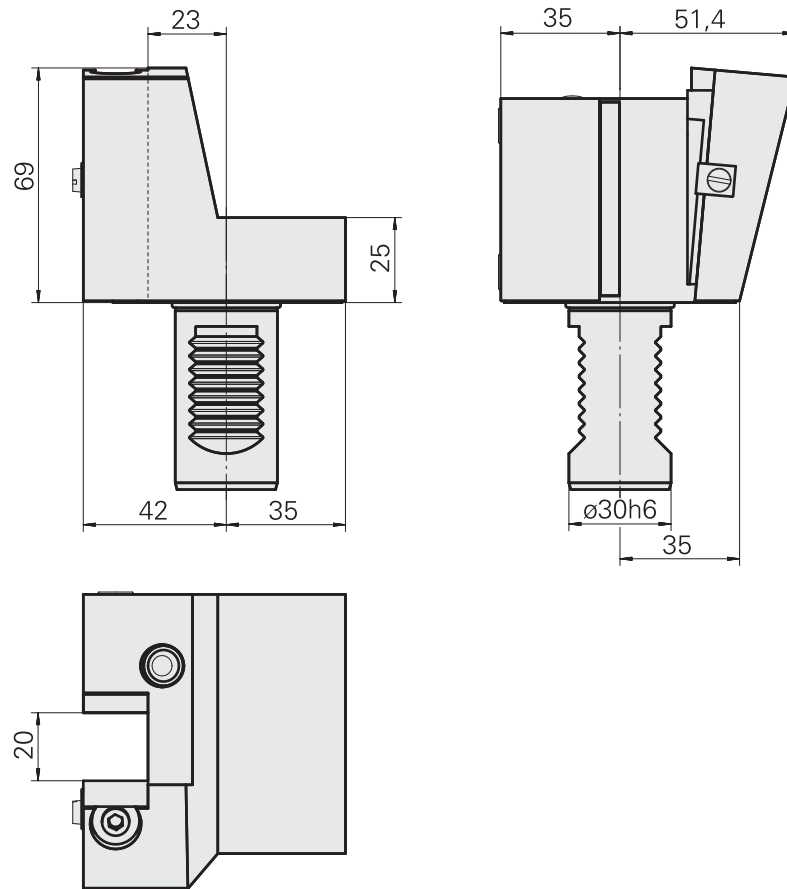
* This article is included

Turning tool holder, vertically adjustable

Shank	VDI 30
Fixation	–
Mounting	square 20x20
Cooling	external, p_{max} 20 bar
reversible 180°	yes
X / Y / Z	69 (2.72) / – / 42 (1.65) mm (")

Matching accessories

Angle	W63300.0010
Angle	W63300.0020
Pressure spring*	322091
Bush*	322093
Nozzle*	322092
Gasket ring*	322089



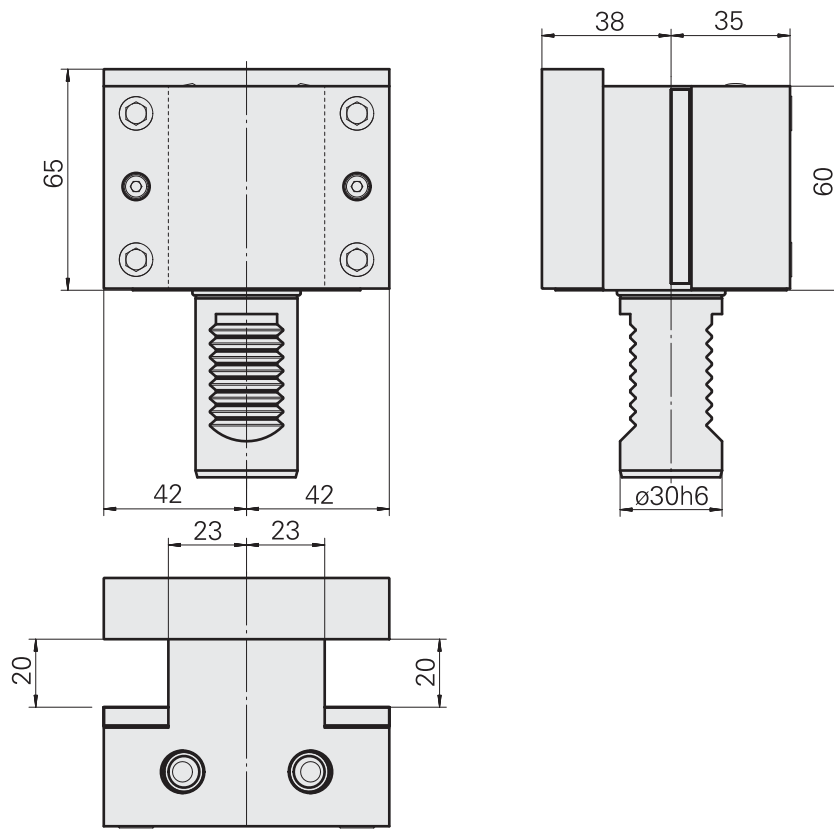
* This article is included

Turning tool holder, double

Shank	VDI 30
Fixation	–
Mounting	square 20x20
Cooling	external, p_{\max} 20 bar
reversible 180°	yes
X / Y / Z	65 (2.56) / – / 42 (1.65) mm (")

Matching accessories

Angle	W63300.0010
Angle	W63300.0020
Pressure spring*	322091
Gasket ring*	322089
Bush*	322093
Nozzle*	322092



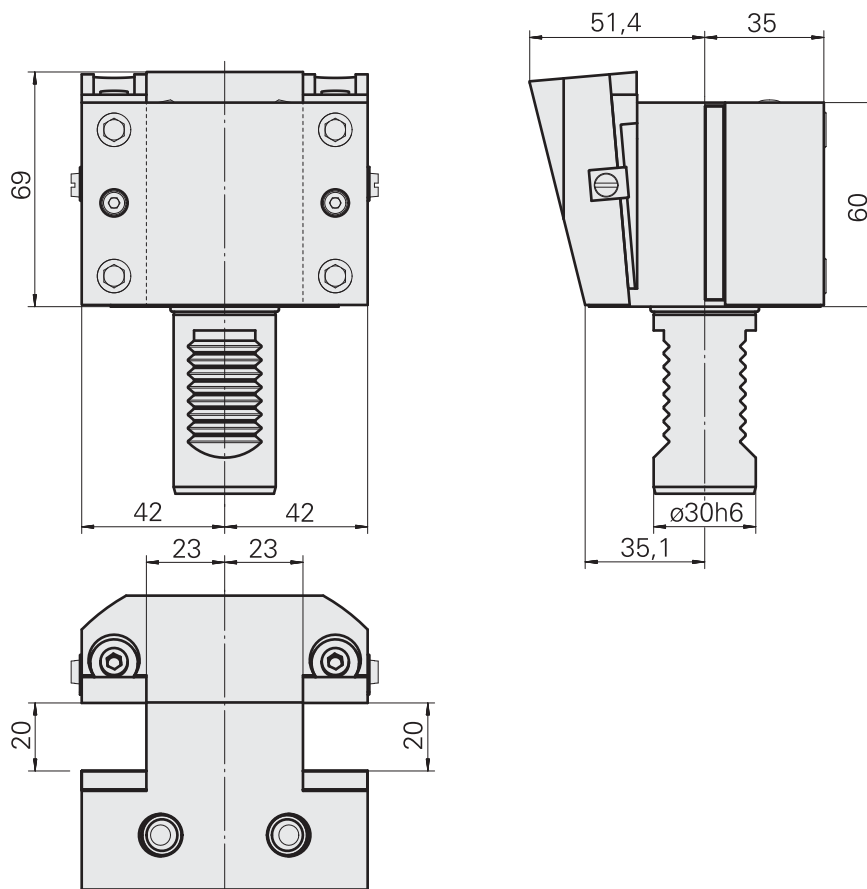
* This article is included

Turning tool holder, vertically adjustable, double

Shank	VDI 30
Fixation	–
Mounting	square 20x20
Cooling	external, p_{\max} 20 bar
reversible 180°	yes
X / Y / Z	69 (2.72) / – / 42 (1.65) mm (")

Matching accessories

Angle	W63300.0010
Angle	W63300.0020
Pressure spring*	322091
Gasket ring*	322089
Bush*	322093
Nozzle*	322092



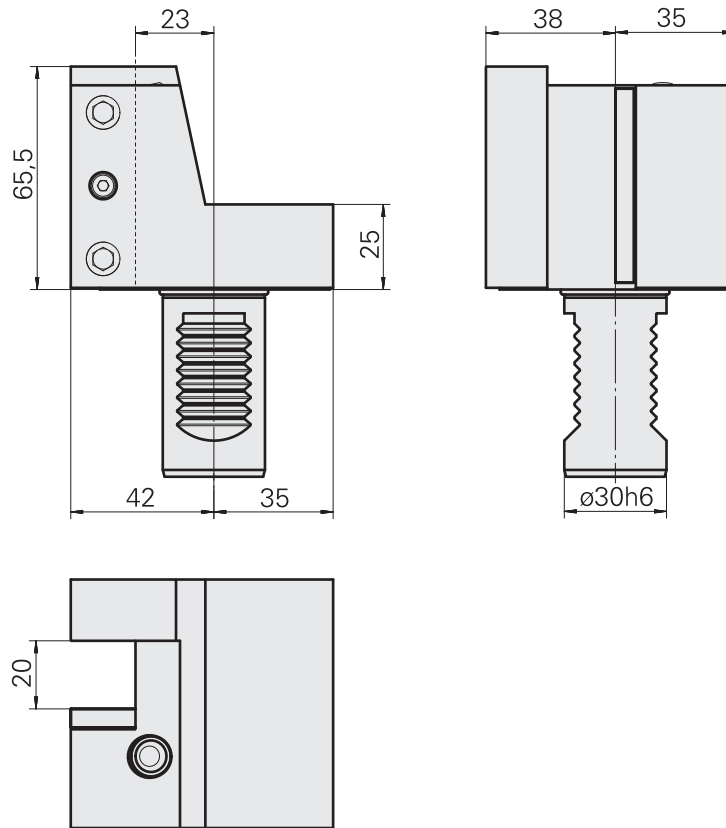
* This article is included

Turning tool holder, Form C1/C4

Shank	VDI 30
Fixation	–
Mounting	square 20x20
Cooling	external, p_{max} 20 bar
reversible 180°	yes
X / Y / Z	65 (2.56) / – / 42 (1.65) mm (")

Matching accessories

Angle	W63300.0010
Angle	W63300.0020
Pressure spring*	322091
Gasket ring*	322089
Nozzle*	322092
Bush*	322093



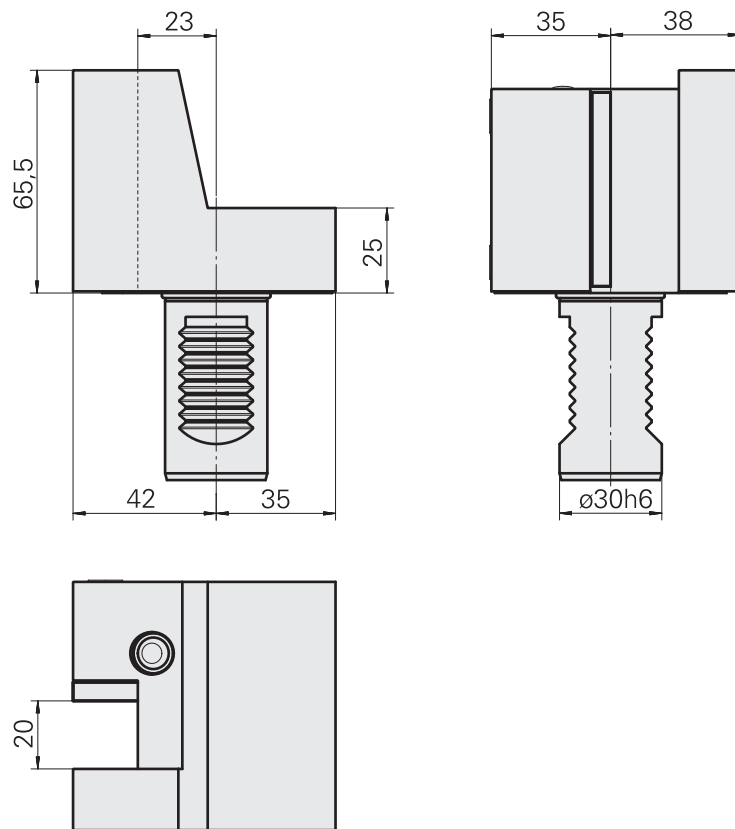
* This article is included

Turning tool holder, Form C2/C3

Shank	VDI 30
Fixation	–
Mounting	square 20x20
Cooling	external, p_{\max} 20 bar
reversible 180°	yes
X / Y / Z	65 (2.56) / – / 42 (1.65) mm (")

Matching accessories

Angle	W63300.0010
Angle	W63300.0020
Pressure spring*	322091
Gasket ring*	322089
Bush*	322093
Nozzle*	322092



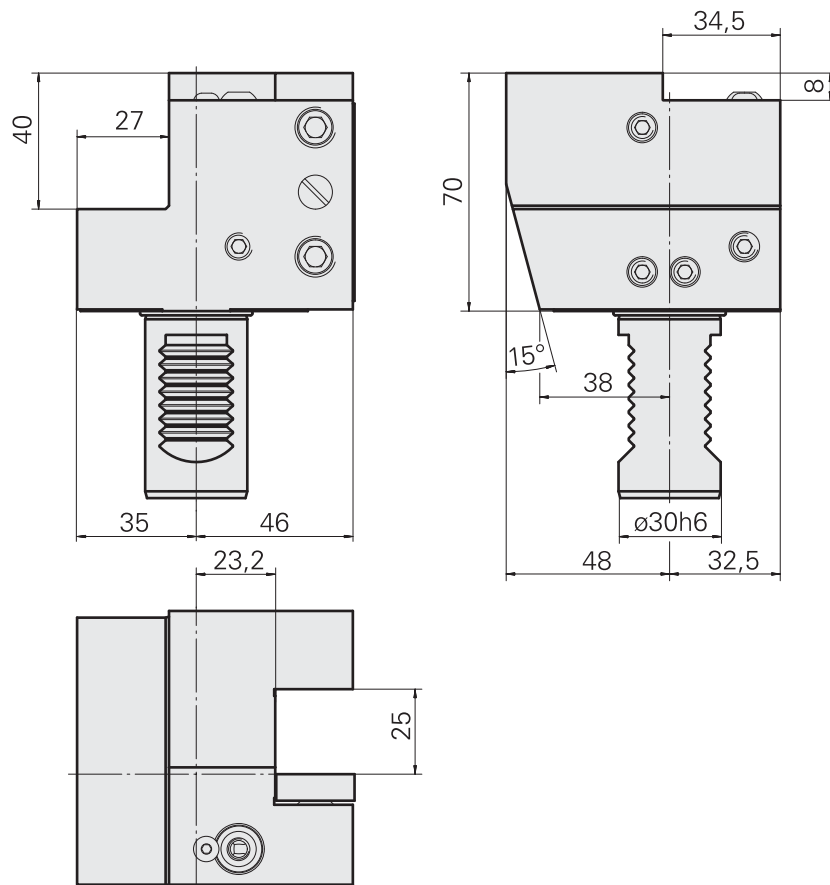
* This article is included

Turning tool holder, Form C2/C3

Shank	VDI 30
Fixation	none
Mounting	square 25x25
Cooling	external, p_{\max} 40 bar
reversible 180°	yes
X / Y / Z	70 (2.76) / - / 46 (1.81) mm (")

Matching accessories

Nozzle*	474550.0121
Cheese-head screw*	410232.0406



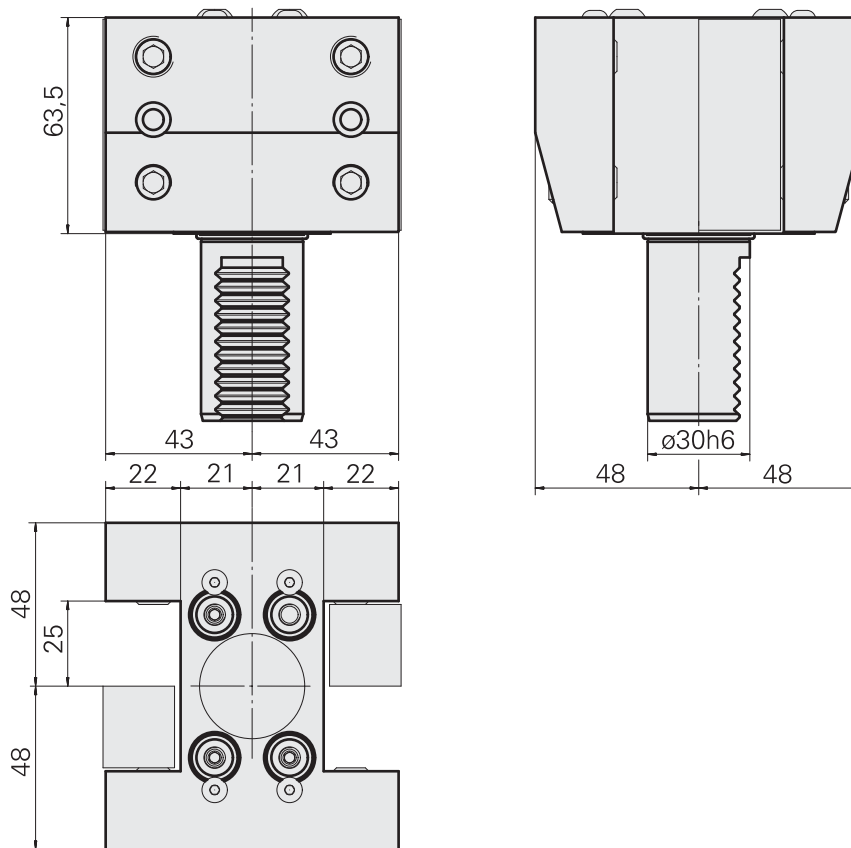
* This article is included

Turning tool holder, double

Shank	VDI 30
Fixation	none
Mounting	square 25x25
Cooling	external, p_{\max} 20 bar
reversible 180°	no
X / Y / Z	64 (2.52) / – / 43 (1.69) mm (")

Matching accessories

Nozzle*	W67500.3208
Countersunk screw*	410360.0410



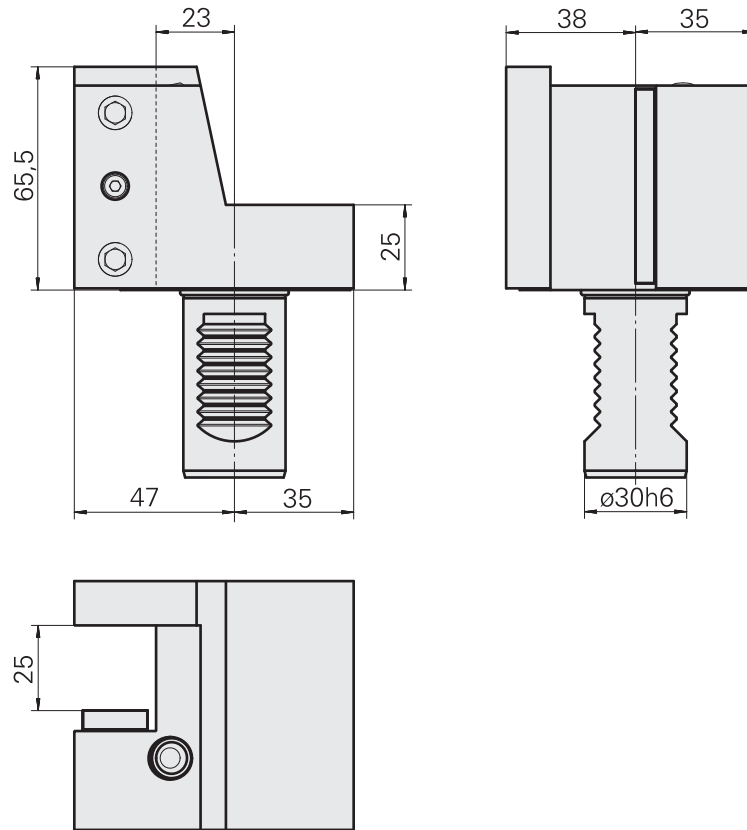
* This article is included

Turning tool holder, Form C1/C4

Shank	VDI 30
Fixation	–
Mounting	square 25x25
Cooling	external, p_{max} 20 bar
reversible 180°	yes
X / Y / Z	65 (2.56) / – / 47 (1.85) mm (")

Matching accessories

Pressure spring*	322091
Gasket ring*	322089
Nozzle*	322092
Bush*	322093



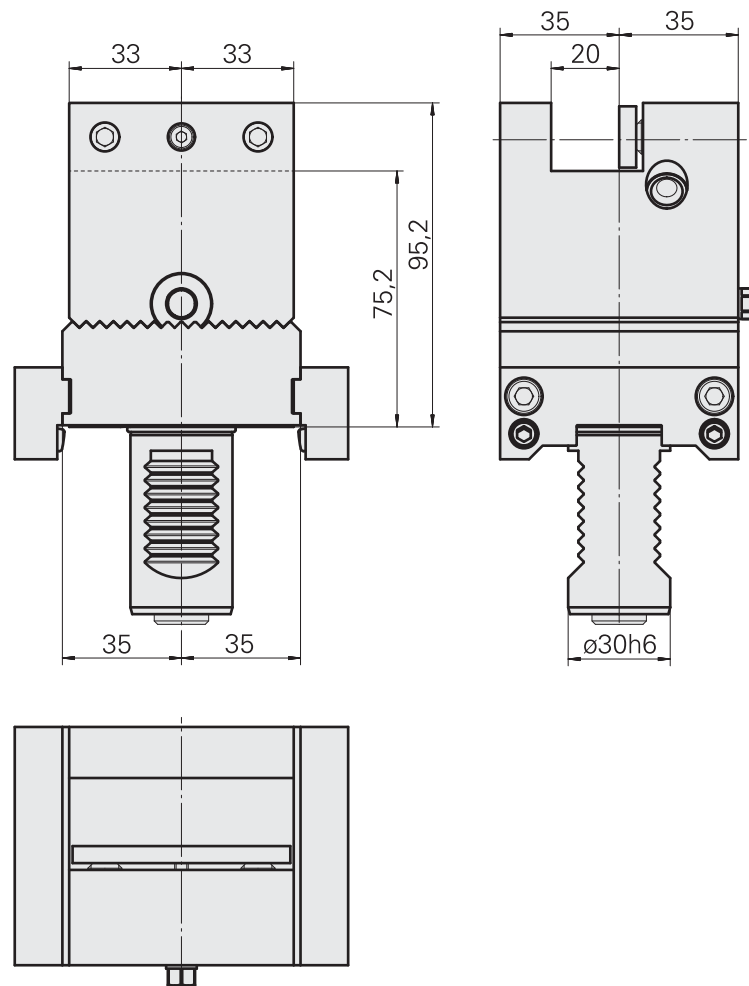
* This article is included

Turning tool holder, vertically adjustable

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Mounting	square 20x20
Cooling	external, p_{\max} 20 bar
reversible 180°	yes
X / Y / Z	95 (3.74) / - / 33 (1.3) mm (")

Matching accessories

Bush*	322093
Pressure spring*	322091
Nozzle*	322092



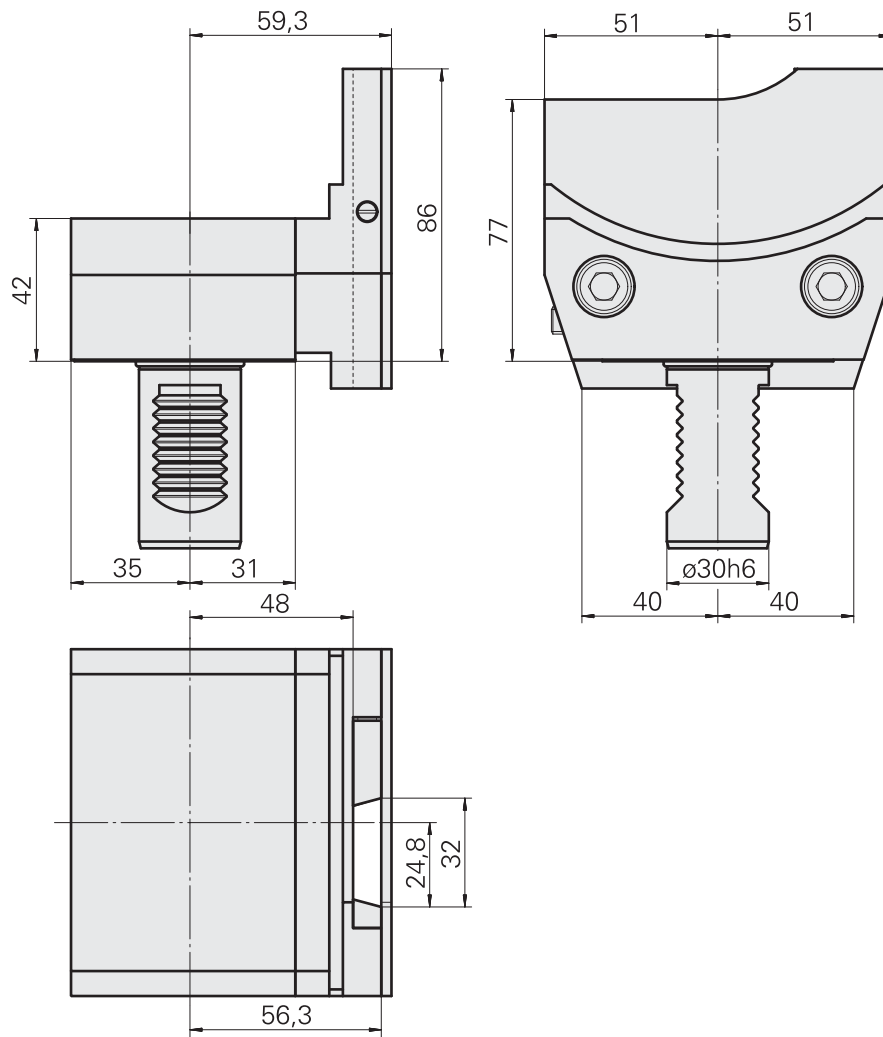
* This article is included


Grooving tool holder, vertically adjustable

Shank	VDI 30
Fixation	–
Mounting	Trapezoid 32x8
Cooling	external, p_{max} 20 bar
reversible 180°	yes
X / Y / Z	86 (3.39) / – / 59.5 (2.43) mm (")

Matching accessories

Tube*	776354
-------	--------



 Only for right-handed run!

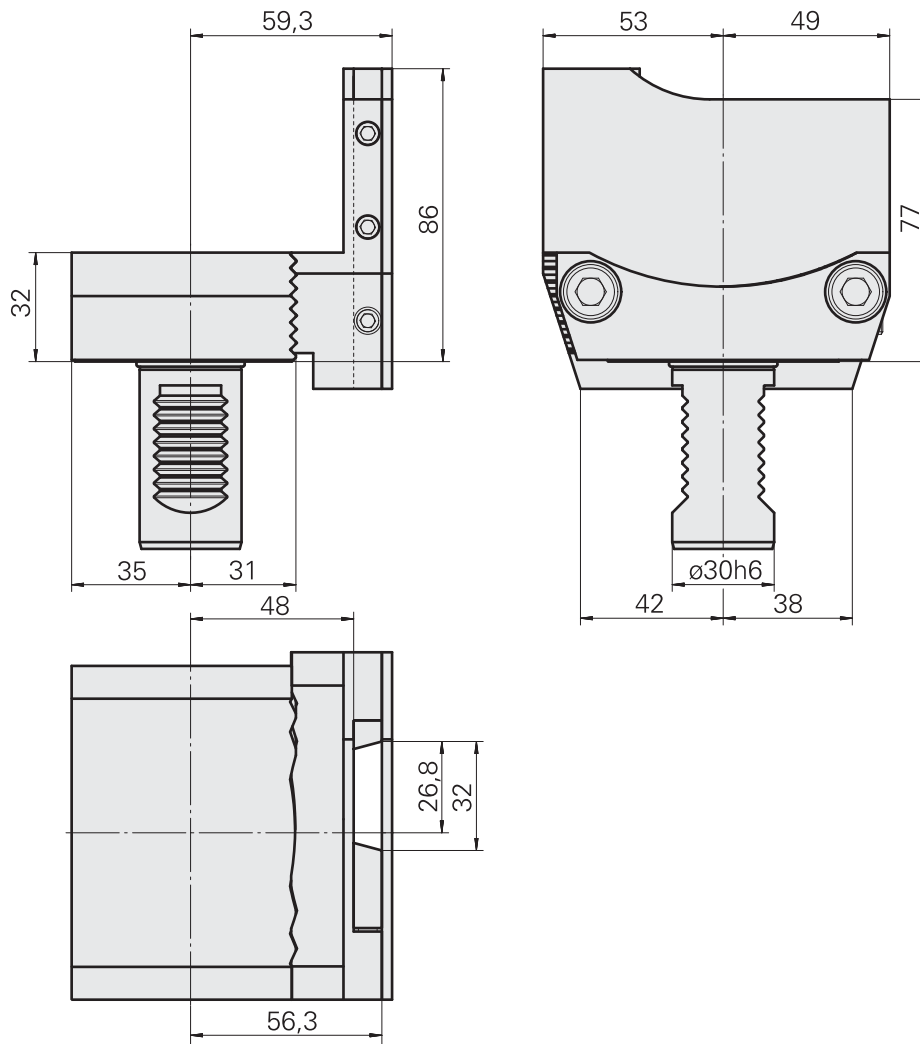
* This article is included


Grooving tool holder, vertically adjustable

Shank	VDI 30
Fixation	–
Mounting	Trapezoid 32x8
Cooling	external, p_{max} 20 bar
reversible 180°	yes
X / Y / Z	86 (3.39) / – / 59.5 (2.43) mm (")

Matching accessories

Tube*	776354
-------	--------

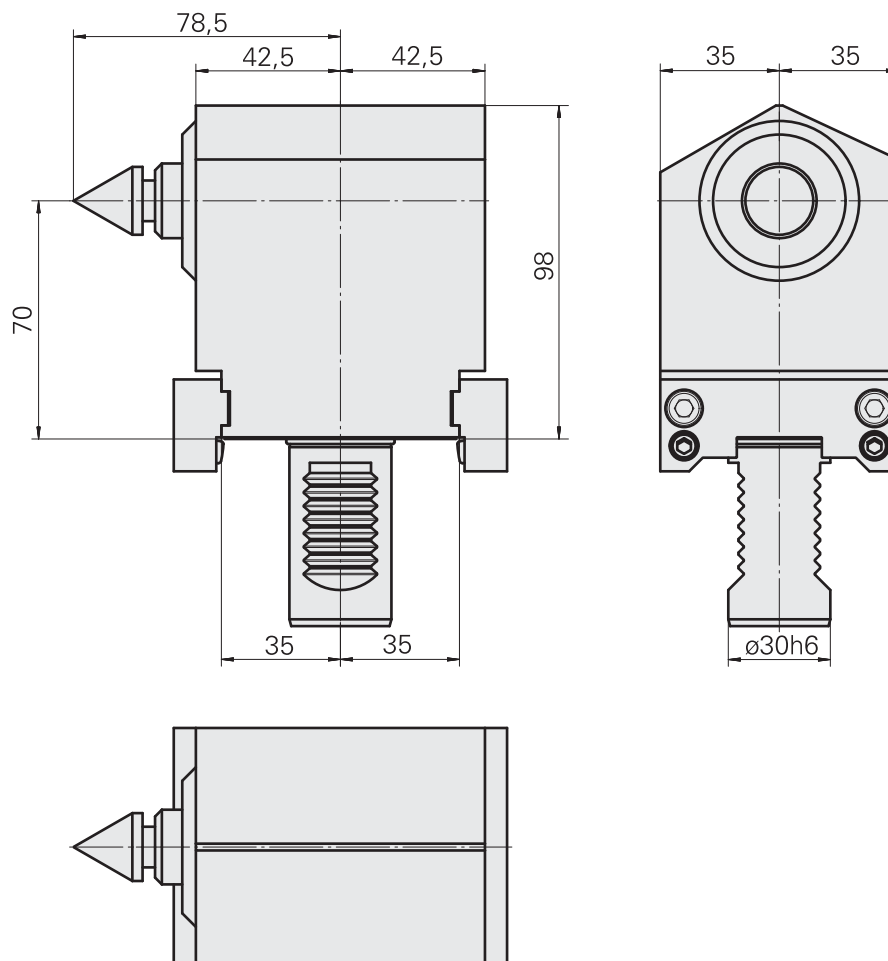


 Only for left-handed run!

* This article is included

Center holder

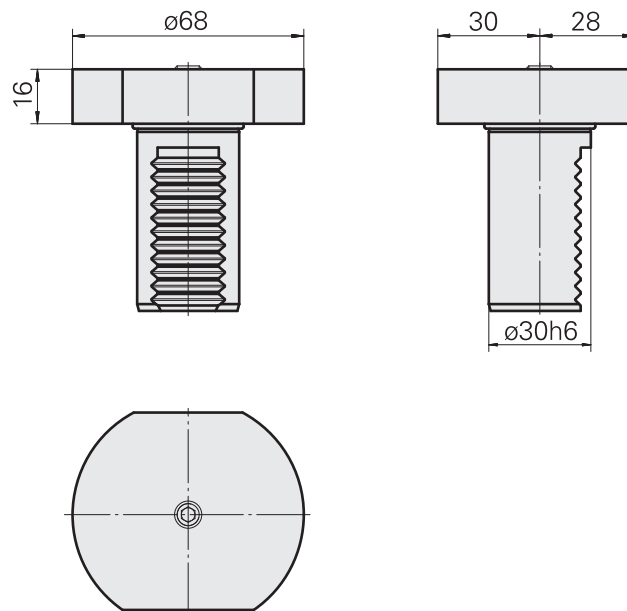
Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Mounting	–
Cooling	–
reversible 180°	yes
X / Y / Z	70 (2.76) / – / 78.5 (3.09) mm (")



Max. suspension travel = 3.12 mm
 Force at 1 mm = 800 N
 Max. force = 3100 N
 Concentricity = 0.005 mm
 Max. number of rev. = 6,300 1/min

Blanking plug

Shank	VDI 30
Fixation	none
Mounting	–
Cooling	–
reversible 180°	no
X / Y / Z	16 (0.63) / – / – mm (")



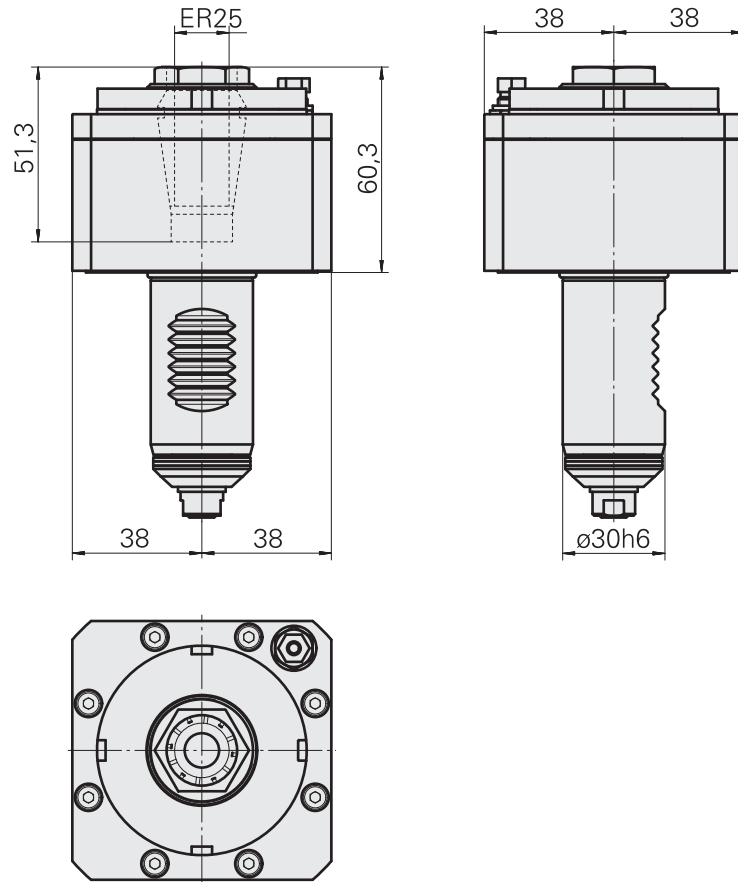
**Tool holder live
shank VDI 30**

Milling unit

Shank	VDI 30
Fixation	–
Drive	Beveled wheel (TNC42/65)
Mounting	ER 25
Cooling	external, p_{max} 40 bar
Speed ratio	1:1 (1)
Direction	same as drive direction
reversible 180°	no
X / Y / Z	60 (2.36) / – / 0 mm (")

Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Connector piece*	314420
Cap screw*	314423
Conical ring*	314422



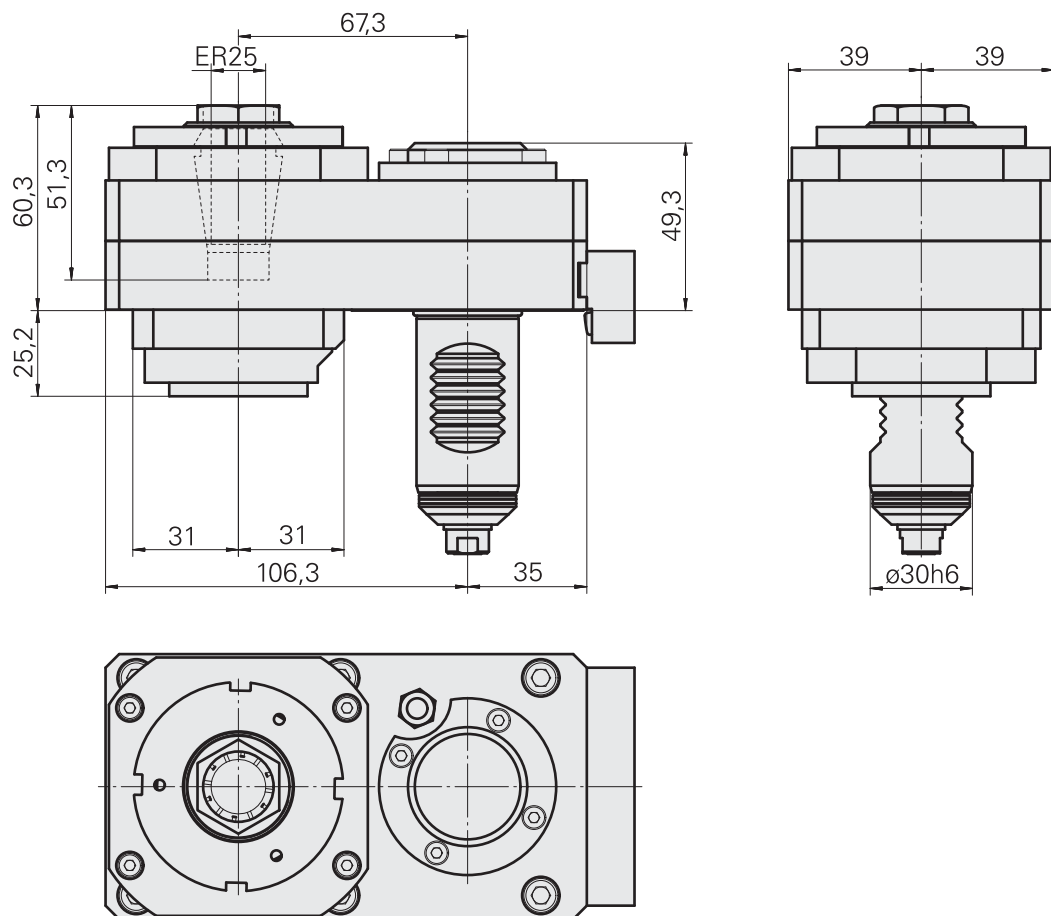
* This article is included

Milling unit

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Drive	Beveled wheel (TNC42/65)
Mounting	ER 25
Cooling	external, p_{\max} 40 bar
Speed ratio	3:1 (3)
Direction	same as drive direction
reversible 180°	yes
X / Y / Z	49.1 (1.93) / - / 67.5 (2.66) mm (")

Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping nut*	323610
Conical ring*	314739
Cap screw*	314740
Tube*	774895



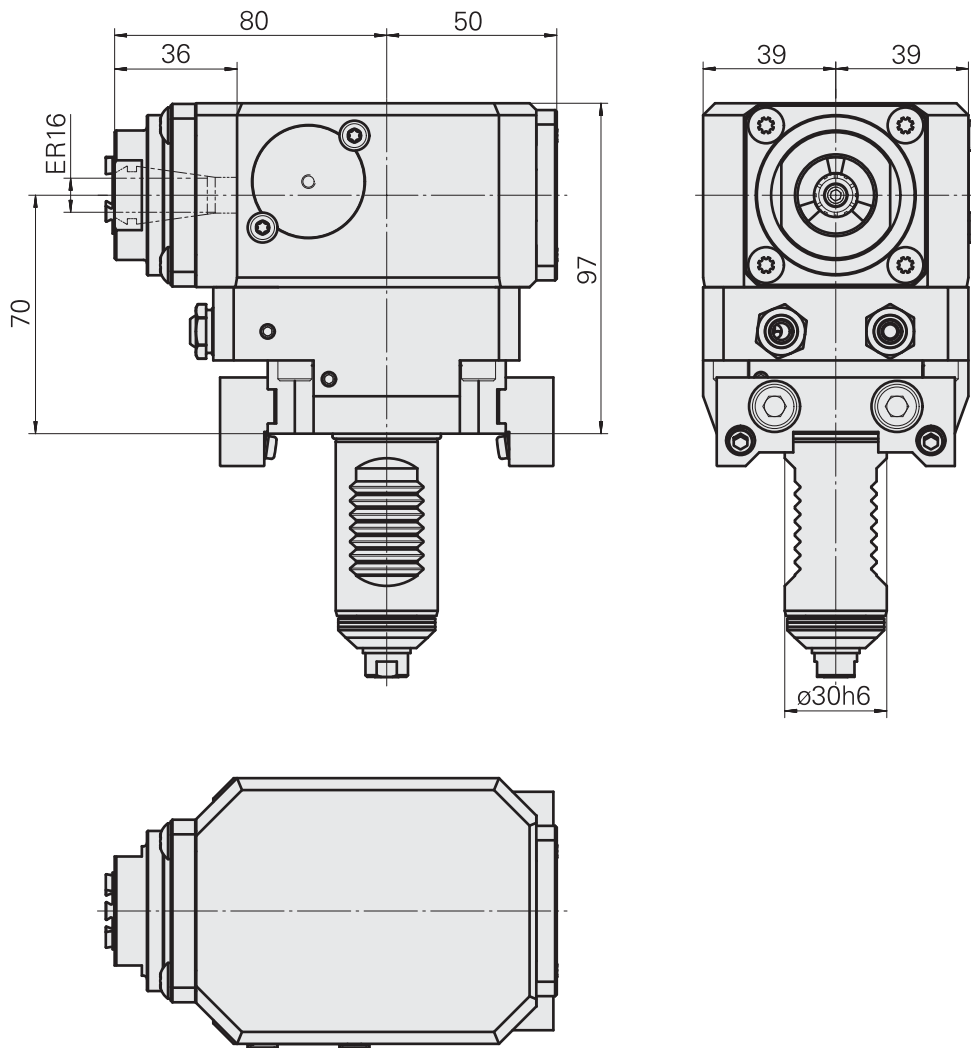
* This article is included

Drilling unit

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Drive	Beveled wheel (TNC42/65)
Mounting	ER 16
Cooling	external, internal optional, p_{max} 80 bar
Speed ratio	1:3 (0.333)
Direction	same as drive direction
reversible 180°	yes
X / Y / Z	70 (2.76) / - / 80 (3.15) mm (")

Matching accessories

Clamping collet	901930.1---
Clamping collet	W99903--
tapping tool collet	3230--
tapping tool collet	WZ9990.9506F
Collet chuck	W999065-
Clamping nut*	901939.5161
IC-attachment up to 160bar	W9990284
IC-attachment up to 80bar	W9990290
Bush*	W67530.0824
Hollow screw*	W67530.0818
Nozzle*	W67500.3208
Spanner	490219.3161



* This article is included

Drilling unit

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Drive	Beveled wheel (TNC42/65)
Mounting	ER 20
Cooling	external, p_{\max} 80 bar
Speed ratio	1:2 (0.5)
Direction	opposite to drive direction
reversible 180°	yes
X / Y / Z	70 (2.76) / – / 39 (1.54) mm (")

No picture available!

Milling unit

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Drive	Beveled wheel (TNC42/65)
Mounting	ER 25
Cooling	external, internal optional, p_{\max} 80 bar
Speed ratio	1:1 (1)
Direction	opposite to drive direction
reversible 180°	yes
X / Y / Z	78 (37) / - / 64 (2.52) mm (")

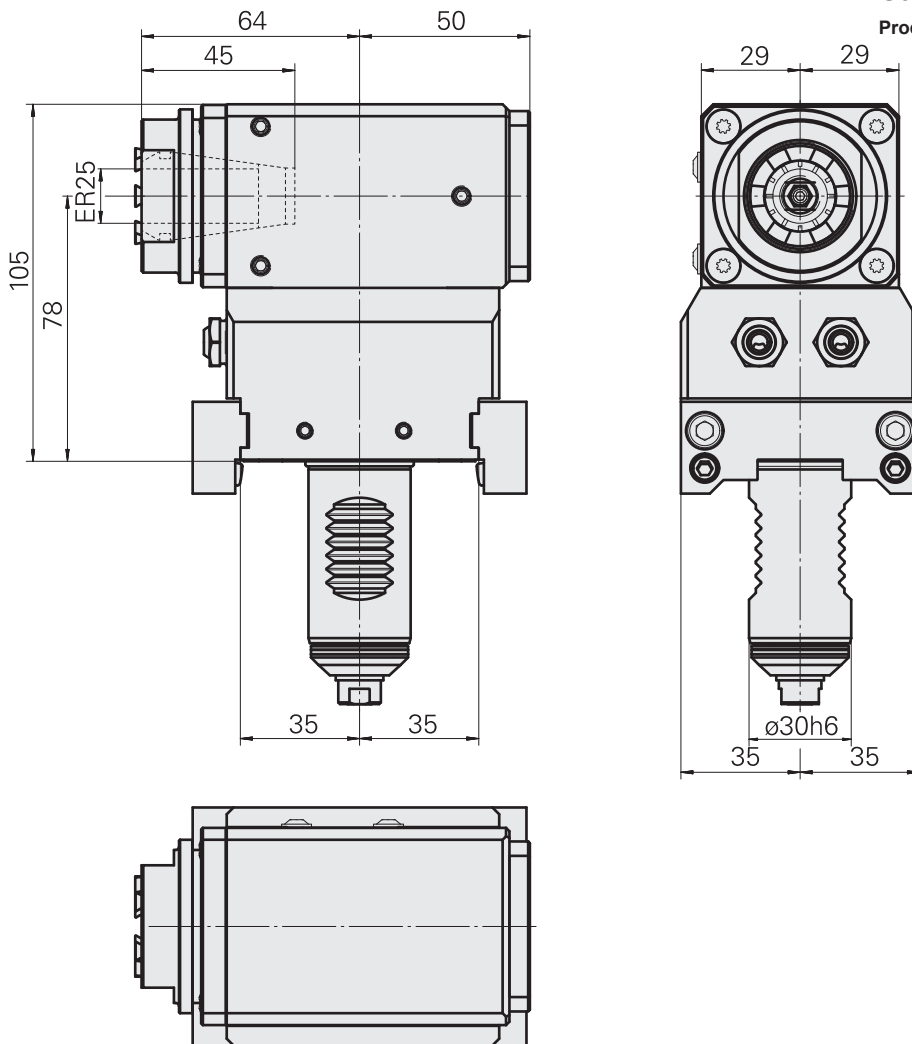
Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping nut	901939.5251
IC-attachment up to 160bar	W9990284
IC-attachment up to 80bar	W9990290
Nozzle*	W67500.3208
Hollow screw*	W67530.0818
Bush*	W67530.0824
Spanner	490219.3251

Other documents

Product note

[W9800008en](#)



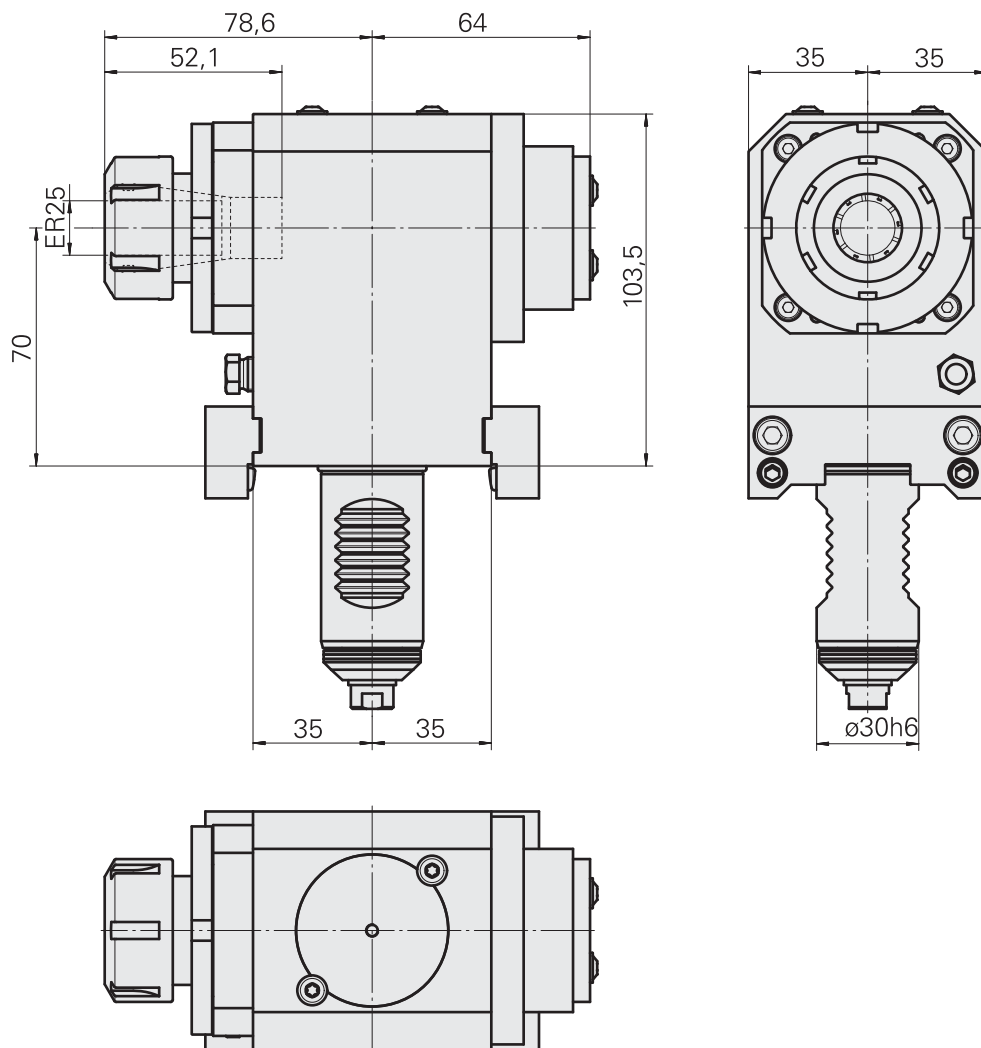
* This article is included

Milling unit

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Drive	Beveled wheel (TNC42/65)
Mounting	ER 25
Cooling	external, p_{\max} 80 bar
Speed ratio	3:1 (3)
Direction	same as drive direction
reversible 180°	yes
X / Y / Z	70 (2.76) / - / 78 (37) mm (")

Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping nut*	901939.0251
Cap screw*	314740
Conical ring*	314739
Tube*	774844
Spanner	490219.0251



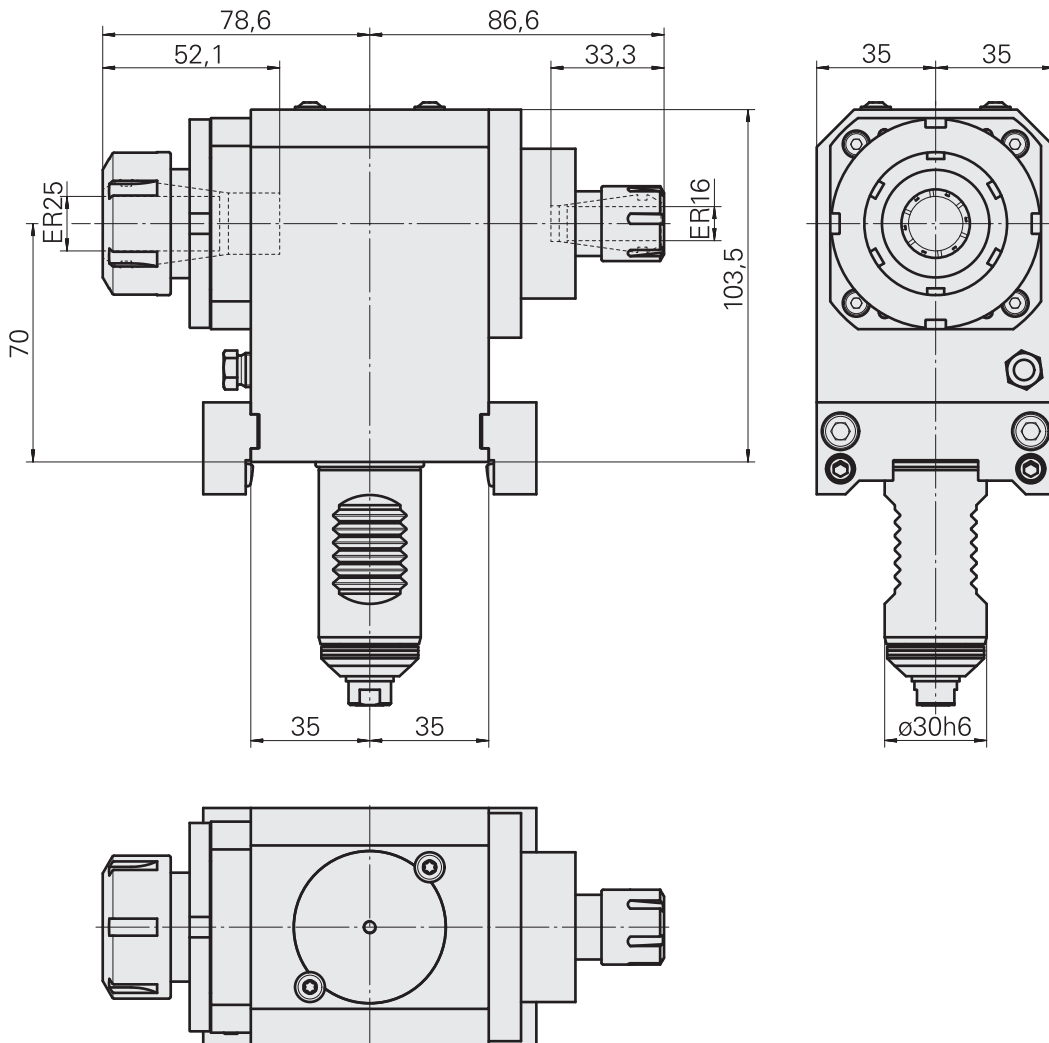
* This article is included

Milling unit

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Drive	Beveled wheel (TNC42/65)
Mounting	ER16/ER25
Cooling	external, p_{\max} 80 bar
Speed ratio	1:1 (1)
Direction	same as drive direction
reversible 180°	yes
X / Y / Z	70 (2.76) / - / 83 + 78 (3.27 + 3.07) mm (")

Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping collet	W99903--
Clamping collet	901930.1---
tapping tool collet	3230--
tapping tool collet	WZ9990.9506F
Collet chuck	W999065-
Clamping nut*	901939.0251
Clamping nut*	901939.6161
Conical ring*	314739
Cap screw*	314740
Tube*	774844
Spanner	490219.0251
Spanner	490219.2161



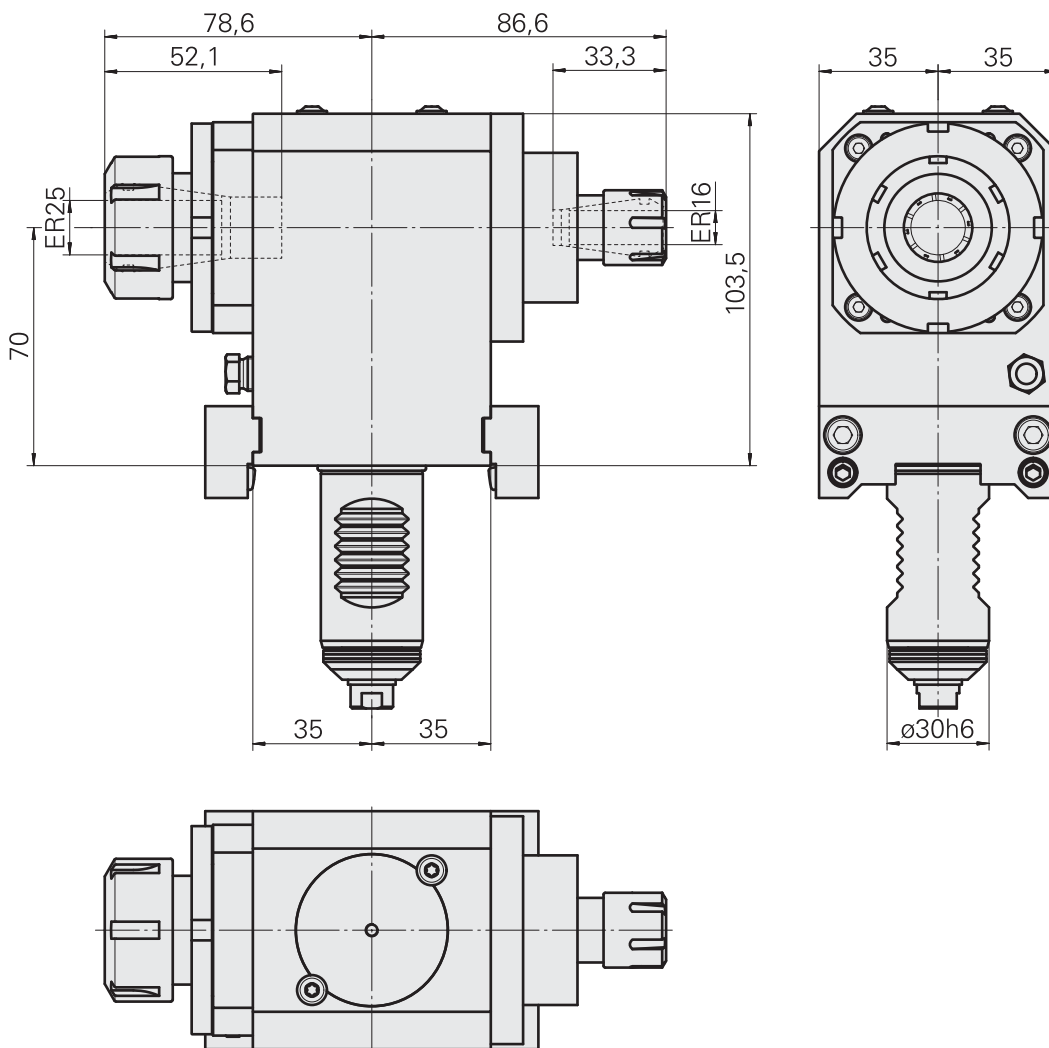
* This article is included

Milling unit

Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Drive	Beveled wheel (TNC42/65)
Mounting	ER16/ER25
Cooling	external, p_{\max} 80 bar
Speed ratio	3:1 (3)
Direction	same as drive direction
reversible 180°	yes
X / Y / Z	70 (2.76) / - / 82 + 78 (3.23 + 3.07) mm (")

Matching accessories

Clamping collet	901930.3---
tapping tool collet	3224--
tapping tool collet	WZ9990.9507F
Collet chuck	W999067-
Clamping collet	W99903--
Clamping collet	901930.1---
tapping tool collet	3230--
tapping tool collet	WZ9990.9506F
Collet chuck	W999065-
Clamping nut*	901939.0251
Clamping nut*	901939.6161
Conical ring*	314739
Cap screw*	314740
Tube*	774844
Spanner	490219.0251
Spanner	490219.2161



* This article is included

Drilling unit

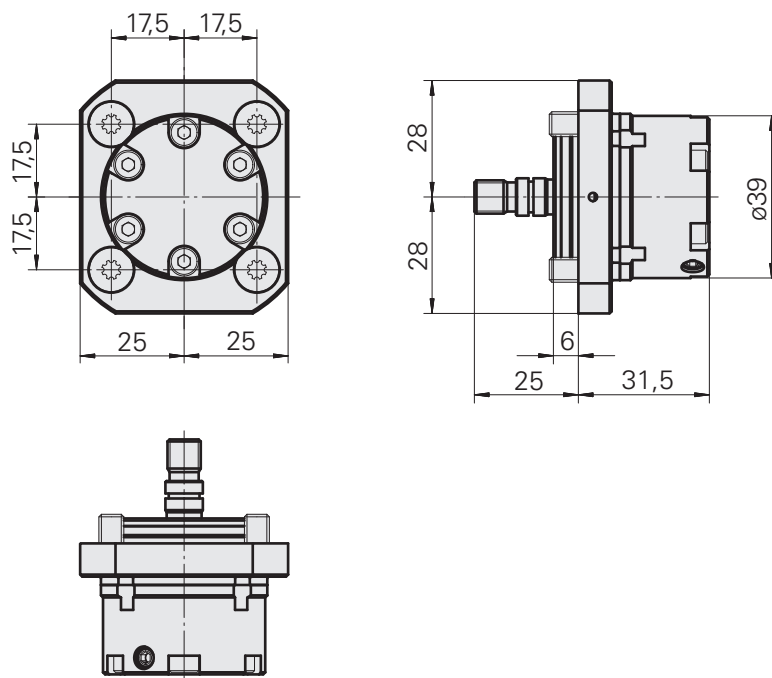
Shank	VDI 30
Fixation	TRAUB bar (TNC42/65)
Drive	Beveled wheel (TNC42/65)
Mounting	ER 11
Cooling	external, p_{\max} 80 bar
Speed ratio	1:1.88 (0.533)
Direction	opposite to drive direction
reversible 180°	yes
X / Y / Z	60 (2.36) / – / – mm (")

No picture available!

Accessories
TRAUB TNC65

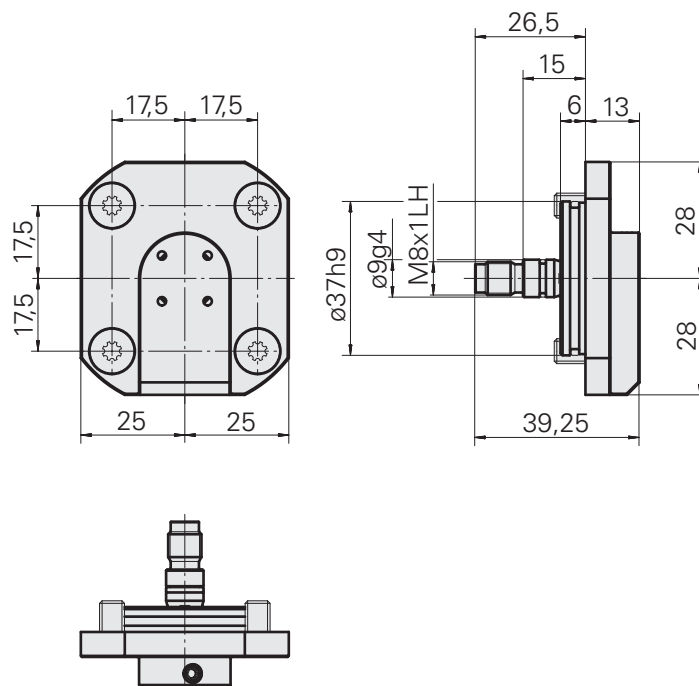
IC Attachment

for internal cooling lubricant supply, up to 160 bar
dry run



IC Attachment

for internal cooling lubricant supply, up to 80 bar
no dry run



Product information
TRAUB TNC65

Product note

External/internal cooling lubricant supply

Milling unit, lid convertible to IC 80 bar / 160 bar

Offset set screws

Disclaimer

The illustrations in this documents may deviate from the delivered product. We reserve the right to make changes due to errors or based on technical advances.

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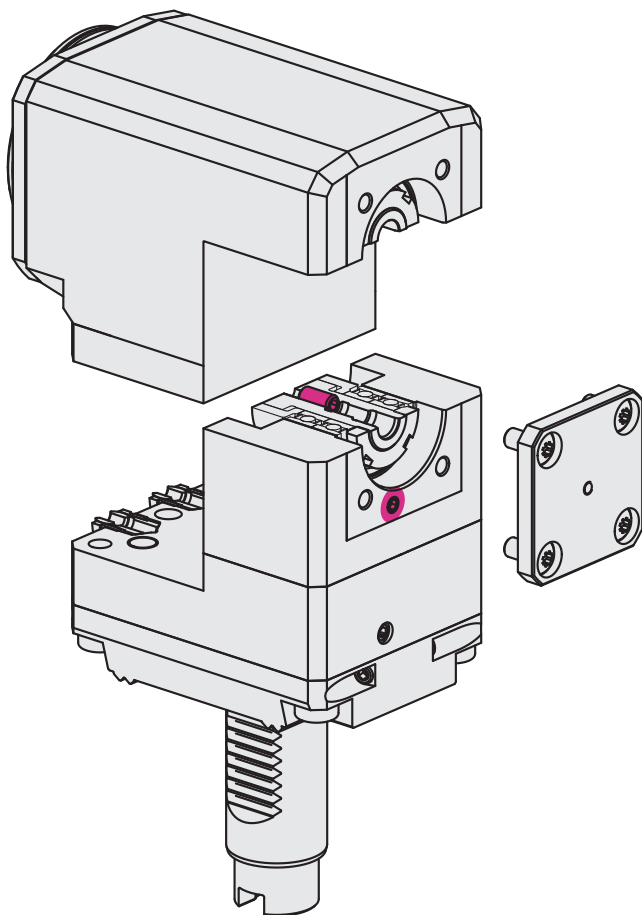
External/internal cooling lubricant supply

Milling unit, lid convertible to IC 80 bar / 160 bar

Offset set screws

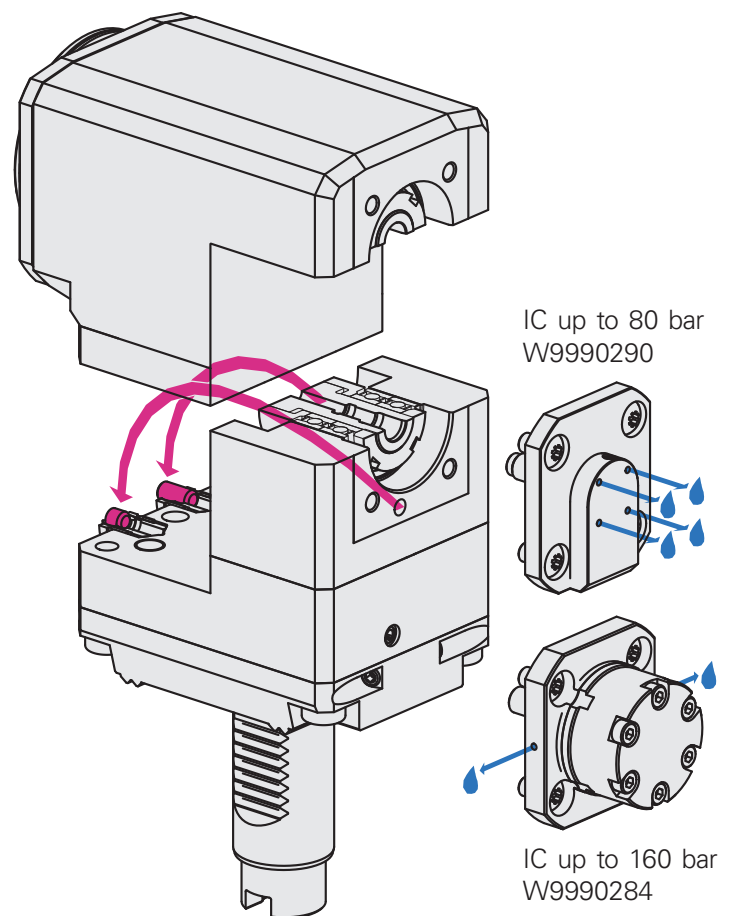
External cooling lubricant supply

Delivery condition



Internal cooling lubricant supply

Conversion possible with cooling lubricant attachment kit:
max. 80 bar W9990290, max. 160 bar W9990284



Conversion of set screws to IC 80 bar (W9990290), limited dry-running capability
not be used for drive Bevel wheel z18/m=1.15

- Cooling lubricant may briefly exit at 4 holes
- In case of prolonged exit, remove the cooling lubricant attachment kit (W9990290) again
- Check yellow ceramic disk; it should snugly seat against the spindle after the assembly

Conversion of set screws to IC 160 bar (W9990284), limited dry-running capability

- Cooling lubricant may briefly exit at 1 hole
- In case of prolonged exit, remove the tool holder from the turret disk
- Charge cooling lubricant supply briefly with compressed air; reinstall tool holder

If cooling lubricant continues to exit, please contact our tool holder advisers at +49 7153 502-9854.

Product note

External/internal cooling lubricant supply
W9800008EN-22.01.2013

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