

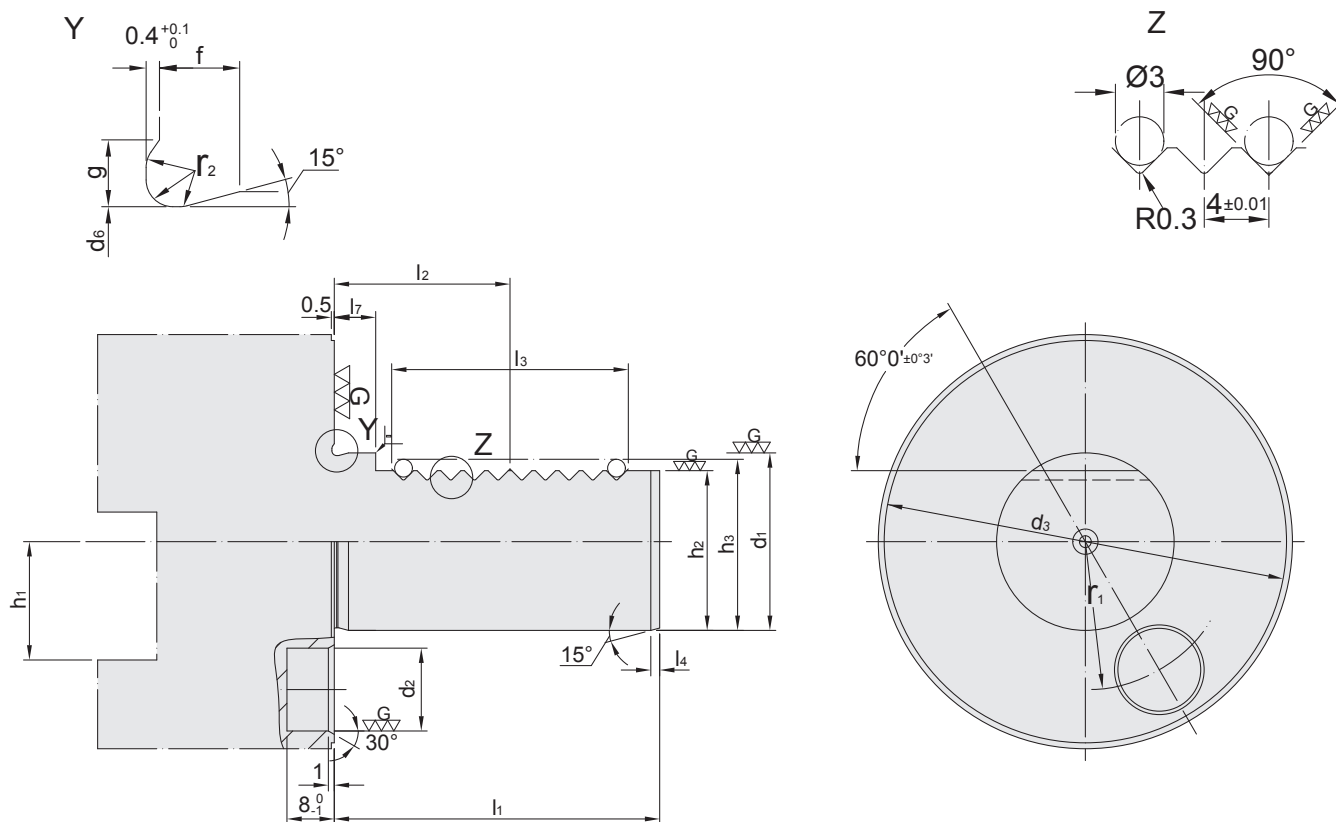
VDI CATEGORY

ISO 10889

BLANK	J-4
EXTERNAL TURNING TOOL HOLDER SYSTEM	J-5~6
FACE TURNING TOOL HOLDER SYSTEM	J-7~8
SIDE LOCK HOLDER	J-9
BORING BAR HOLDER	J-10
EOC COLLET CHUCK HOLDER	J-11
ER COLLET CHUCK HOLDER	J-11
SPU DRILL CHUCK	J-12

REFERENCE DETAILS

ISO 10889



$\nabla \nabla \nabla = Rz\ 2.5$

d ₁	l ₁	d ₂		d ₃	d ₆	f	g	h ₁	h ₂	l ₂	l ₃	l ₄	l ₇	r ₁	r ₂	O-Ring
h6	±0.3				⁰ -0.1			max	±0.1	±0.05	min	⁻¹ 0		±0.02		
16	32	8	H6	40	15.4	2	1.7	12	15	12.7	16	2	3.5	14.5	0.6	15 x 15
20	40	10	H6	50	19.1	2.4	2	16	18	21.7	24	2	7	18	0.8	18.77 x 1.78
25	48	10	H6	58	24.1	2.4	2	16	23.5	21.7	24	2	7	21	0.8	23.52 x 1.78
30	55	14	H8	68	29.1	2.4	2	20	27	29.7	40	2	7	25	0.8	28.3 x 1.78
40	63	14	H8	83	38.7	3.7	2.8	25	36	29.7	40	3	7	32	1.2	37.77 x 2.62
50	78	16	H8	98	48.7	3.7	2.8	32	45	35.7	48	3	8	37	1.2	47.29 x 2.62
60	94	16	H8	123	58.7	4.3	3.7	32	55	43.7	56	4	10	48	1.6	56.74 x 3.53
80	124	20	H8	158	78.7	4.3	3.7	40	72	59.7	80	4	10	65	1.6	75.79 x 3.53

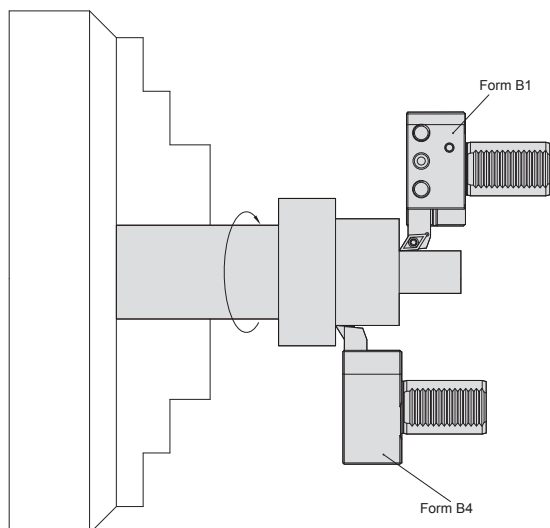
- DIN ISO 10889 Tool Holders have features as the following:
Advanced structure, high manufacturing precision, easy operation and strong exchangeability function, etc.
- DIN ISO 10889 Tool Holders have such tapers as VDI16, VDI20, VDI30, VDI40, VDI50, VDI60, VDI80, etc. It's available for customers to choose suitable types according to their requests, such as turning tool holder, boring bar holder, high speed drill tool holder, drill chuck tool holder, cutting tool holder, etc.
- The VDI shank part is precision-ground to ensure superior accuracy and stability in tool clamping.

SPINDLE ROTATES PATTERN

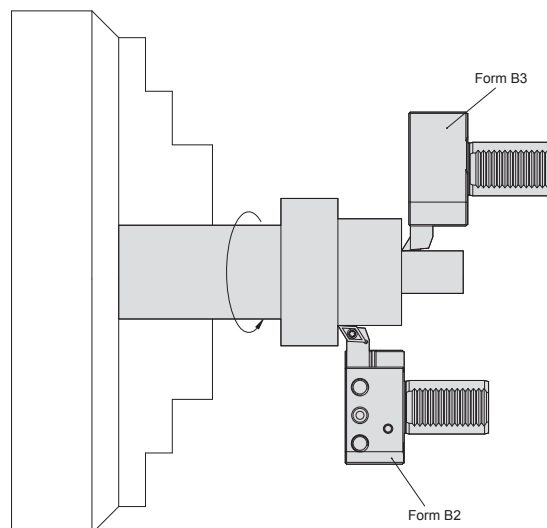
ISO 10889

VDI

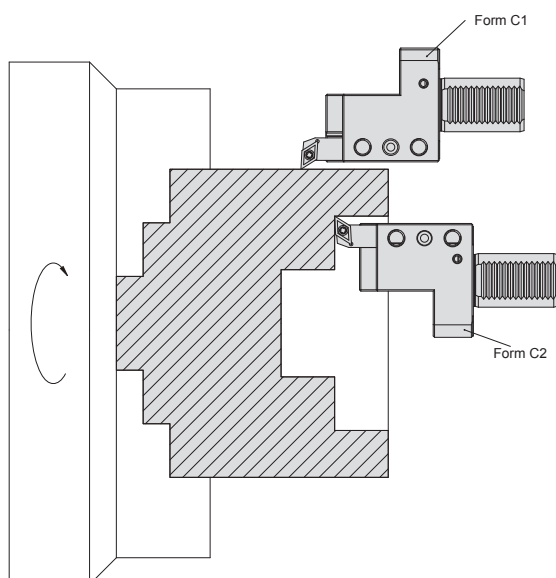
Spindle rotates counterclockwise:



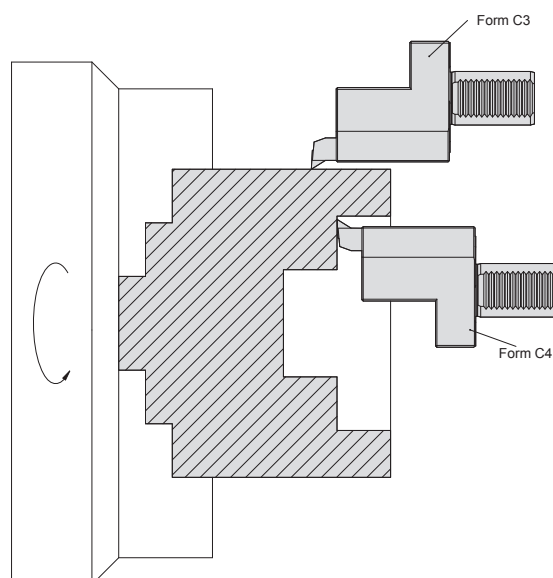
Spindle rotates clockwise:



Spindle rotates counterclockwise:



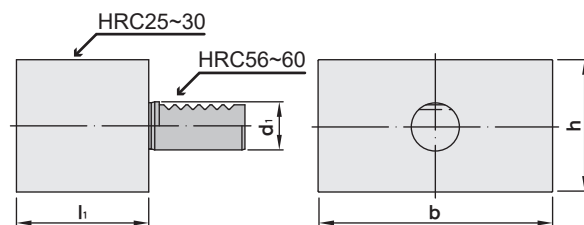
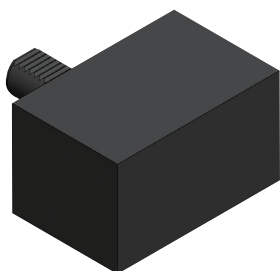
Spindle rotates clockwise:



VDI BLANK

VDI 素材

[A1/ISO 10889-2]

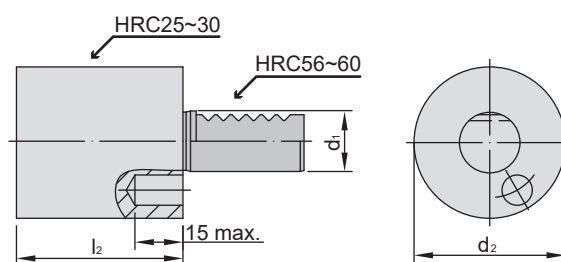


MODEL NO.	TYPE $d_1 \times l_1$	d_1	l_1	b	h
5241-A1-130-085	30 x 85	30	85	130	76
5242-A1-151-100	40 x 100	40	100	151	96
5243-A1-160-125	50 x 125	50	125	160	120

VDI BLANK

VDI 素材

[A2/ISO 10889-2]

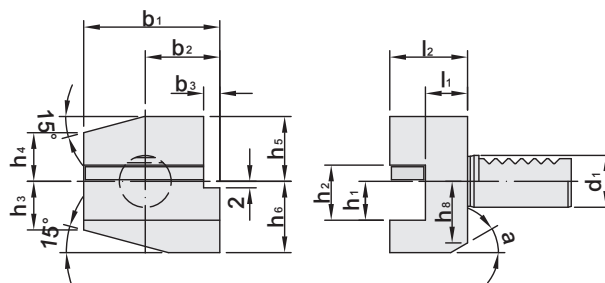


MODEL NO.	TYPE $d_1 \times l_2$	d_1	d_2	l_2
5241-A2-068-100	30 x 100	30	68	100
5241-A2-068-160	30 x 160	30	68	160
5241-A2-068-240	30 x 240	30	68	240
5242-A2-083-120	40 x 120	40	83	120
5242-A2-083-160	40 x 160	40	83	160
5242-A2-083-200	40 x 200	40	83	200
5242-A2-083-320	40 x 320	40	83	320
5243-A2-050-400	50 x 400	50	98	400

EXTERNAL TURNING TOOL HOLDER

外徑刀座

(B1/ISO 10889-3)



MODEL NO.	TYPE $d_1 \times h_1 \times l_2$	d_1	b_1	b_2	b_3	h_1	h_2	h_3	h_4	h_5	h_6	h_8	l_1	l_2	a
5241-B1-020-040	30 x 20 x 40	30	70	35	10	20	29	26	22	28	38	30	22	40	25°
5241-B1-020-060	30 x 20 x 60	30	70	35	10	20	29	26	22	28	38	30	42	60	25°
5242-B1-025-044	40 x 25 x 44	40	85	42.5	12.5	25	34	35	30	32.5	48	-	22	44	-
5243-B1-032-055	50 x 32 x 55	50	100	50	16	32	41	42	35	35	60	-	30	55	-

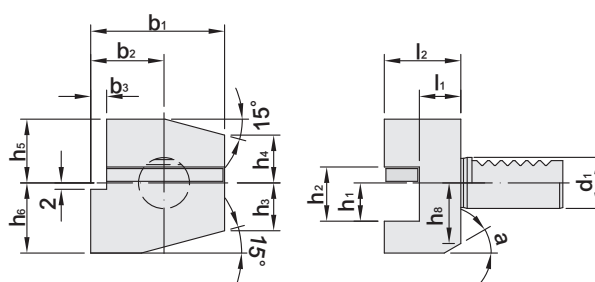
Features:

- ▶ Radial-right handed.
- ▶ Short tool holder.
- ▶ With coolant hole.

EXTERNAL TURNING TOOL HOLDER

外徑刀座

(B2/ISO 10889-3)



MODEL NO.	TYPE $d_1 \times h_1 \times l_2$	d_1	b_1	b_2	b_3	h_1	h_2	h_3	h_4	h_5	h_6	h_8	l_1	l_2	a
5241-B2-020-040	30 x 20 x 40	30	70	35	10	20	29	26	22	28	38	30	22	40	25°
5241-B2-020-060	30 x 20 x 60	30	70	35	10	20	29	26	22	28	38	30	42	60	25°
5242-B2-025-044	40 x 25 x 44	40	85	42.5	12.5	25	34	35	30	32.5	48	-	22	44	-
5243-B2-032-055	50 x 32 x 55	50	100	50	16	32	41	42	35	35	60	-	30	55	-

Features:

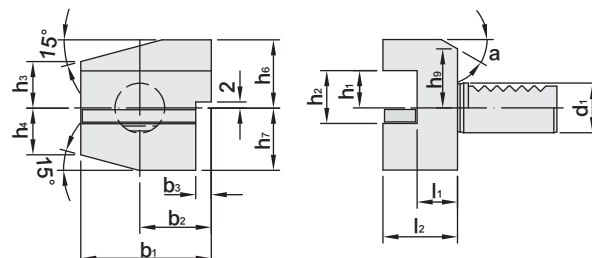
- ▶ Radial-left handed.
- ▶ Short tool holder.
- ▶ With coolant hole.



EXTERNAL TURNING TOOL HOLDER

外徑刀座

〔B3/ISO 10889-3〕



MODEL NO.	TYPE $d_1 \times h_1 \times l_2$	d_1	b_1	b_2	b_3	h_1	h_2	h_3	h_4	h_6	h_7	h_9	l_1	l_2	a
5241-B3-020-040	30 x 20 x 40	30	70	35	10	20	29	26	22	38	35	28	22	40	25°
5241-B3-020-060	30 x 20 x 60	30	70	35	10	20	29	26	22	38	35	28	42	60	25°
5242-B3-025-044	40 x 25 x 44	40	85	42.5	12.5	25	34	35	30	48	42.5	-	22	44	-
5243-B3-032-055	50 x 32 x 55	50	100	50	16	32	41	42	35	60	50	-	30	55	-

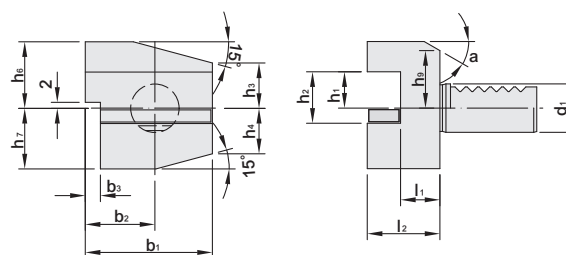
Features:

- ▶ Radial-right handed.
- ▶ Short tool holder.
- ▶ Turning insert downwards.
- ▶ With coolant hole.

EXTERNAL TURNING TOOL HOLDER

外徑刀座

〔B4/ISO 10889-3〕

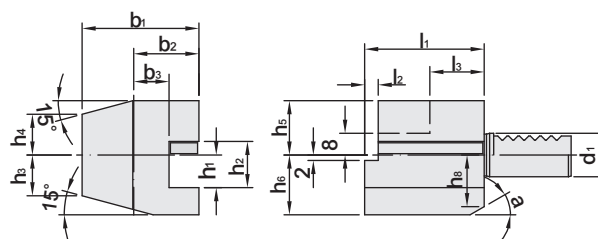


MODEL NO.	TYPE $d_1 \times h_1 \times l_2$	d_1	b_1	b_2	b_3	h_1	h_2	h_3	h_4	h_6	h_7	h_9	l_1	l_2	a
5241-B4-020-040	30 x 20 x 40	30	70	35	10	20	29	26	22	38	35	28	22	40	25°
5241-B4-020-060	30 x 20 x 60	30	70	35	10	20	29	26	22	38	35	28	42	60	25°
5242-B4-025-044	40 x 25 x 44	40	85	42.5	12.5	25	34	35	30	48	42.5	-	22	44	-
5243-B4-032-055	50 x 32 x 55	50	100	50	16	32	41	42	35	60	50	-	30	55	-

FACE TURNING TOOL HOLDER

端面刀座

(C1/ISO 10889-4)

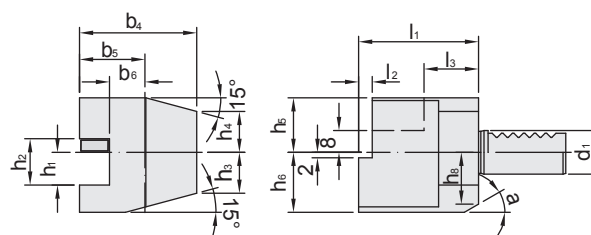


MODEL NO.	TYPE $d_1 \times h_1 \times l_1$	d_1	b_1	b_2	b_3	h_1	h_2	h_3	h_4	h_5	h_6	h_8	l_1	l_2	l_3	a
5241-C1-020-070	30 x 20 x 70	30	70	35	17	20	29	26	22	28	38	30	70	10	30	25°
5242-C1-025-085	40 x 25 x 85	40	85	42.5	21	25	34	35	30	32.5	48	-	85	12.5	30	-
5243-C1-032-100	50 x 32 x 100	50	100	50	26	32	41	42	35	35	60	-	100	16	40	-

FACE TURNING TOOL HOLDER

端面刀座

(C2/ISO 10889-4)

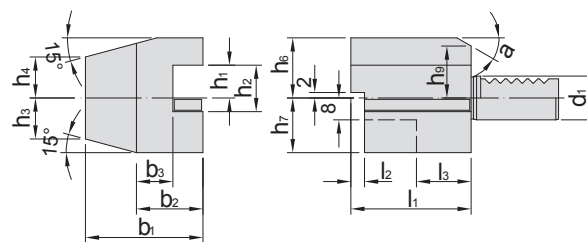


MODEL NO.	TYPE $d_1 \times h_1 \times l_1$	d_1	b_4	b_5	b_6	h_1	h_2	h_3	h_4	h_5	h_6	h_8	l_1	l_2	l_3	a
5241-C2-020-070	30 x 20 x 70	30	76	41	23	20	29	26	22	28	38	30	70	10	30	25°
5242-C2-025-085	40 x 25 x 85	40	90	47.5	25.5	25	34	35	30	32.5	48	-	85	12.5	30	-
5243-C2-032-100	50 x 32 x 100	50	105	55	30.5	32	41	42	35	35	60	-	100	16	40	-

FACE TURNING TOOL HOLDER

端面刀座

(C3/ISO 10889-4)

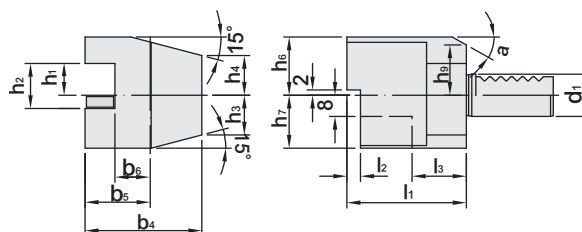


MODEL NO.	TYPE $d_1 \times h_1 \times l_1$	d_1	b_1	b_2	b_3	h_1	h_2	h_3	h_4	h_6	h_7	h_9	l_1	l_2	l_3	a
5241-C3-020-070	30 x 20 x 70	30	70	35	17	20	29	26	22	28	35	28	70	10	30	25°
5242-C3-025-085	40 x 25 x 85	40	85	42.5	21	25	34	35	30	48	42.5	-	85	12.5	30	-
5243-C3-032-100	50 x 32 x 100	50	100	50	26	32	41	42	35	60	50	-	100	16	40	-

FACE TURNING TOOL HOLDER

端面刀座

(C4/ISO 10889-4)



MODEL NO.	TYPE $d_1 \times h_1 \times l_1$	d_1	b_4	b_5	b_6	h_1	h_2	h_3	h_4	h_6	h_7	h_9	l_1	l_2	l_3	a
5241-C4-020-070	30 x 20 x 70	30	76	41	23	20	29	26	22	38	35	28	70	10	30	25°
5242-C4-025-085	40 x 25 x 85	40	90	47.5	25.5	25	34	35	30	48	42.5	-	85	12.5	30	-
5243-C4-032-100	50 x 32 x 100	50	105	55	30.5	32	41	42	35	60	50	-	100	16	40	-

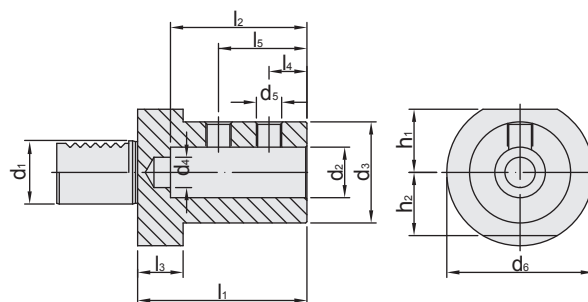
SIDE LOCK HOLDER

FOR HIGH SPEED DRILL

VDI

內孔側固式刀座 [用於快鑽]

(E1/ISO 10889-6)



MODEL NO.	TYPE $d_1 \times d_2 - d_1$	d_1	d_2	d_3	d_4	d_5	d_6	h_1	h_2	l_1	l_2	l_3	l_4	l_5
5241-E1-020-067	30 x 20 - 67	30	20	40	12	M10x1	68	28	30	67	54	22	15	35
5241-E1-025-071	30 x 25 - 71	30	25	45	17	M12x1	68	28	30	71	59	22	17	40
5241-E1-032-075	30 x 32 - 75	30	32	52	24	M12x1	68	28	30	75	63	22	17	44
5241-E1-040-090	30 x 40 - 90	30	40	65	24	M16x1	68	28	30	90	73	22	22	50
5242-E1-018-067	40 x 18 - 67	40	18	40	12	M10x1	83	32.5	-	67	54	22	15	35
5242-E1-020-067	40 x 20 - 67	40	20	40	12	M10x1	83	32.5	-	67	54	22	15	35
5242-E1-025-075	40 x 25 - 75	40	25	45	17	M12x1	83	32.5	-	75	59	22	17	40
5242-E1-032-075	40 x 32 - 75	40	32	52	24	M12x1	83	32.5	-	75	63	22	17	44
5242-E1-040-090	40 x 40 - 90	40	40	65	32	M16x1	83	32.5	-	90	73	22	22	50
5242-E1-050-100	40 x 50 - 100	40	50	83	32	M16x1	83	32.5	-	100	83	22	24	60
5243-E1-020-067	50 x 20 - 67	50	20	40	12	M10x1	98	35	-	67	54	30	15	35
5243-E1-025-080	50 x 25 - 80	50	25	45	17	M12x1	98	35	-	80	59	30	17	40
5243-E1-032-080	50 x 32 - 80	50	32	52	24	M12x1	98	35	-	80	63	30	17	44
5243-E1-040-090	50 x 40 - 90	50	40	65	32	M16x1	98	35	-	90	73	30	22	50
5243-E1-050-100	50 x 50 - 100	50	50	75	42	M16x1	98	35	-	100	83	30	24	60

Features:

- ▶ Tolerance of internal hole: H5.
- ▶ Applicable for High Speed Drill.
- ▶ With center coolant.

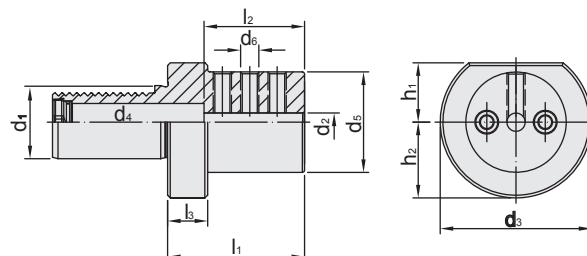


BORING BAR HOLDER

FOR INTERNAL TURNING BAR

內孔側固式刀座 [用於內徑車刀]

(E2/ISO 10889-6)



MODEL NO.	TYPE d ₁ x d ₂ - d ₁	d ₁	d ₂	d ₃	d ₄	d ₅	d ₆	h ₁	h ₂	l ₃	l ₁	l ₂
5241-E2-008-060	30 x 8 - 60	30	8	68	6	55	M6	28	30	22	60	51
5241-E2-010-060	30 x 10 - 60	30	10	68	8	55	M6	28	30	22	60	51
5241-E2-012-060	30 x 12 - 60	30	12	68	10	55	M8	28	30	22	60	51
5241-E2-014-060	30 x 14 - 60	30	14	68	10	55	M8	28	30	22	60	52
5241-E2-016-060	30 x 16 - 60	30	16	68	12	55	M8	28	30	22	60	51
5241-E2-018-060	30 x 18 - 60	30	18	68	10	55	M8	28	30	22	60	52
5241-E2-020-060	30 x 20 - 60	30	20	68	16.5	55	M8	28	30	22	60	51
5241-E2-025-060	30 x 25 - 60	30	25	68	16	55	M8	28	30	22	60	51
5241-E2-032-075	30 x 32 - 75	30	32	68	16	68	M8	28	30	22	75	61
5242-E2-010-075	40 x 10 - 75	40	10	83	8	55	M10	32.5	-	22	75	61
5242-E2-012-075	40 x 12 - 75	40	12	83	10	55	M10	32.5	-	22	75	61
5242-E2-014-075	40 x 14 - 75	40	14	83	10	55	M8	32.5	-	22	75	61
5242-E2-016-075	40 x 16 - 75	40	16	83	16.5	55	M10	32.5	-	22	75	61
5242-E2-018-075	40 x 18 - 75	40	18	83	10	55	M8	32.5	-	22	75	61
5242-E2-020-075	40 x 20 - 75	40	20	83	16.5	55	M10	32.5	-	22	75	61
5242-E2-025-075	40 x 25 - 75	40	25	83	20.5	55	M10	32.5	-	22	75	61
5242-E2-032-075	40 x 32 - 75	40	32	83	20.5	83	M10	32.5	-	22	75	61
5242-E2-040-090	40 x 40 - 90	40	40	83	20.5	83	M10	32.5	-	22	90	76
5242-E2-050-090	40 x 50 - 90	40	50	83	20.5	83	M12	32.5	-	22	90	76
5243-E2-012-075	50 x 12 - 75	50	12	98	10	55	M8	35	-	30	75	61
5243-E2-016-090	50 x 16 - 90	50	16	98	12	68	M10	35	-	30	90	76
5243-E2-020-090	50 x 20 - 90	50	20	98	16	68	M12	35	-	30	90	76
5243-E2-025-090	50 x 25 - 90	50	25	98	20	68	M12	35	-	30	90	76
5243-E2-032-090	50 x 32 - 90	50	32	98	25	68	M12	35	-	30	90	76
5243-E2-040-090	50 x 40 - 90	50	40	98	25	98	M12	35	-	30	90	76
5243-E2-050-100	50 x 50 - 100	50	50	98	25	98	M12	35	-	30	100	86

Features:

- ▶ Tolerance of internal hole: H5.
- ▶ Applicable for internal boring bar.
- ▶ With center coolant and side coolant(coolant holes).



EOC COLLET CHUCK HOLDER

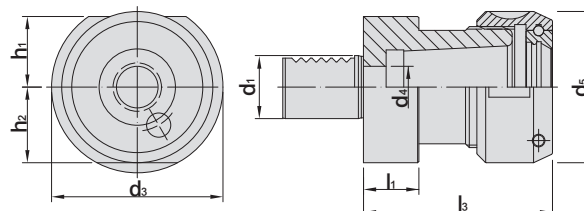
FOR EOC COLLETS

VDI



EOC 套筒式刀座

(E3/ISO 10889-6)



MODEL NO.	TYPE	d ₁	d ₃	d ₄ min	d ₅	h ₁	h ₂	l ₁	l ₃
5241-E3-025-075	30 x EOC25 - 75	30	68	16.5	60	28	30	22	75
5242-E3-025-075	40 x EOC25 - 75	40	83	20.5	60	32.5	-	22	75
5242-E3-032-090	40 x EOC32 - 90	40	83	20.5	72	32.5	-	22	90
5243-E3-025-075	50 x EOC25 - 75	50	98	25.5	60	35	-	30	75
5243-E3-032-090	50 x EOC32 - 90	50	98	25.5	72	35	-	30	90

Collet	Nut	Spanner
P.X-57	P.X-69	P.X-89

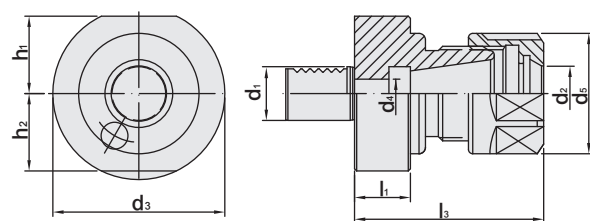
ER COLLET CHUCK HOLDER

FOR ER COLLETS



ER 套筒式刀座

(E4/ISO 10889-6)



MODEL NO.	TYPE	d ₁	d ₂ ER	d ₃	d ₄ min	d ₅	h ₁	h ₂	l ₁	l ₃
5241-E4-025-057	30 x ER25 - 57	30	25	68	16.5	42	28	30	22	57
5241-E4-032-062	30 x ER32 - 62	30	32	68	16.5	50	28	30	22	62
5241-E4-040-070	30 x ER40 - 70	30	40	68	16.5	63	28	30	22	70
5242-E4-025-057	40 x ER25 - 57	40	25	83	20.5	42	32.5	-	22	57
5242-E4-032-062	40 x ER32 - 62	40	32	83	20.5	50	32.5	-	22	62
5242-E4-040-075	40 x ER40 - 75	40	40	83	20.5	63	32.5	-	22	75
5243-E4-040-075	50 x ER40 - 75	50	40	98	20.5	63	35	-	30	75

Collet	Nut	Spanner
P.X-19~45	P.X-63	P.X-87

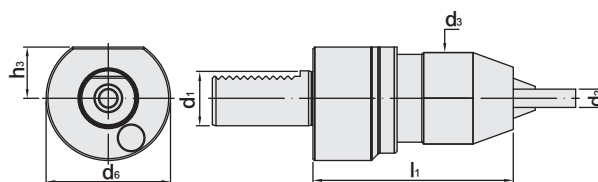
Features:

- ▶ It can match with ER Collets (ISO 15488 standard) and can clamp all kinds of straight shank tools.
- ▶ Rigidity can be raised by using ER Power Good Clamping Nut.



SPU DRILL CHUCK

SPU 鑽夾頭



MODEL NO.	TYPE	d ₁	d ₂	d ₃	d ₆	h ₃	l ₁
5241-669-008-075	30 x SPU8 - 75	30	1 ~ 8	37	68	28	75
5241-669-013-109	30 x SPU13 - 109	30	1 ~ 13	50	68	28	109
5241-669-016-115	30 x SPU16 - 115	30	3 ~ 16	57	68	28	115
5242-669-008-075	40 x SPU8 - 75	40	1 ~ 8	37	83	32.5	75
5242-669-013-090	40 x SPU13 - 90	40	1 ~ 13	50	83	32.5	90
5242-669-016-110	40 x SPU16 - 110	40	3 ~ 16	57	83	32.5	110
5243-669-013-100	50 x SPU13 - 100	50	1 ~ 13	50	98	35	100
5243-669-016-090	50 x SPU16 - 90	50	3 ~ 16	57	98	35	90

Features:

- ▶ The adapter has a taper design to assemble with drill chuck and then lock with a screw, ensuring to have better stability and drill chuck would not fall off.
- ▶ Used for drilling.

Standard Accessory: SPANNER

Spanner



P.X-89