

PRODUCT CATALOGUE



06 Clamping Systems

Edition X

[2026]

Clamping Systems



06

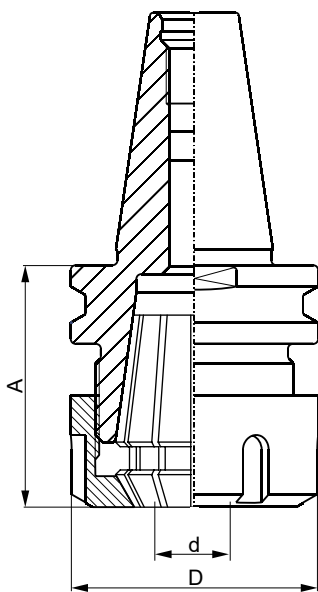


APPLICATION

For clamping shank tools on CNC milling machines with automatic tool change

TECHNICAL SPECIFICATIONS

Clamping taper according to DIN 69871-1
 ER-type collets
 For clamping shank diameters 3–25 mm
 Hardened and ground finish
 Fine-balanced
 Chucks are supplied including the clamping nut



Chucks for ER 32 collets

A mm	d mm	D mm	ID No.
48.5	3–20	50	900207

Chucks for ER 40 collets

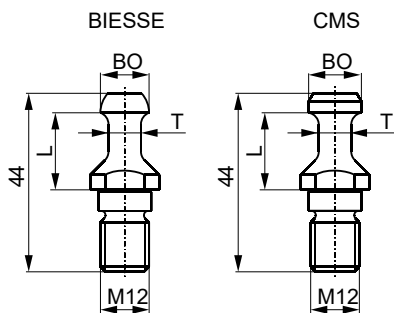
A mm	d mm	D mm	ID No.
58.5	4–25	63	900209

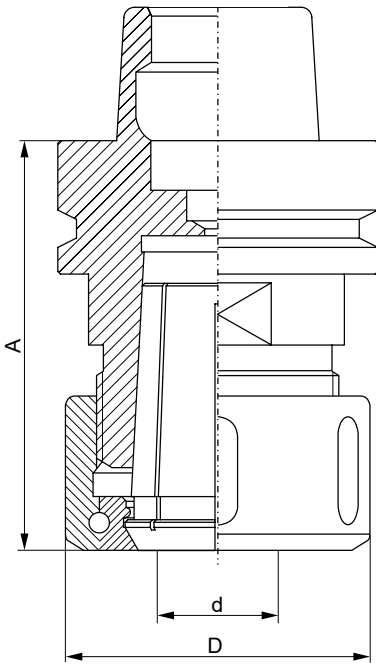
! Clamping collets are not included; they must be ordered separately (see separate chapter on page 101).
 The pull stud is not included.

Accessories	ID No.
ER32 spanner	710414
ER40 spanner	710415
ISO30 assembly fixture	217214063

Pull studs for ISO 30 chucks

Machine type	BO mm	T mm	L mm	ID No.
BIESE	12	8	19	900217
CMS	13	9	19	900219





APPLICATION

For clamping shank tools on CNC milling machines with automatic tool change

TECHNICAL SPECIFICATIONS

Clamping taper according to DIN 69893-6, form F
 OZ- and ER-type collets
 For clamping shank diameters 1–25 mm
 Hardened and ground finish
 Fine-balanced
 Chucks are supplied including the clamping nut
 Chucks are also available in left-hand (LH) version
 Extended version: A = 115 mm

Chucks for OZ 25 collets

A mm	d mm	D mm	ID No.
76	3–25	60	900101

Supplied with a ball-bearing clamping nut as standard

Chucks for ER 16 collets

A mm	d mm	D mm	ID No.
70	1–10	28	900103

Supplied with a balanced clamping nut as standard

Chucks for ER 25 collets

A mm	d mm	D mm	ID No.
70	2–16	42	900105

Supplied with a balanced clamping nut as standard

Chucks for ER 32 collets

A mm	d mm	D mm	ID No.
72	3–20	50	900107

Supplied with a balanced clamping nut as standard

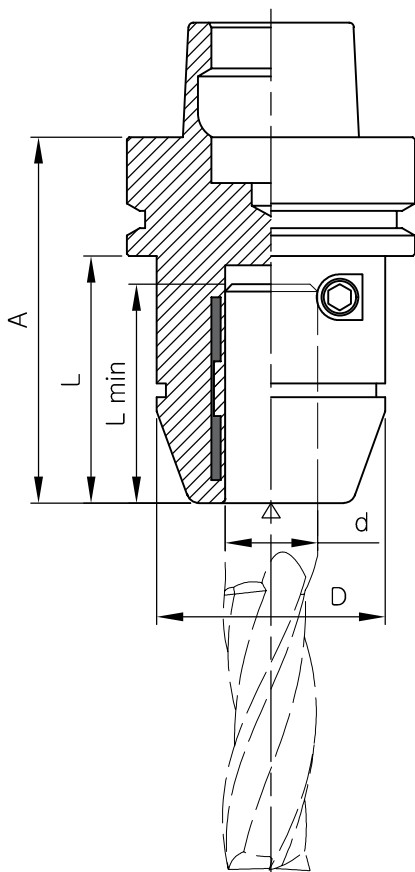
Chucks for ER 40 collets

A mm	d mm	D mm	ID No.
76	3–25	63	900109

Supplied with a balanced clamping nut as standard

! Clamping collets are not included; they must be ordered separately (see separate chapter on page 101).

Accessories	ID No.
OZ25 spanner	710403
ER16 spanner	710411
ER25 spanner	710413
ER32 spanner	710414
ER40 spanner	710415
HSK63F assembly fixture	217214048



APPLICATION

For simple and quick clamping of shank tools on CNC milling machines with automatic tool change

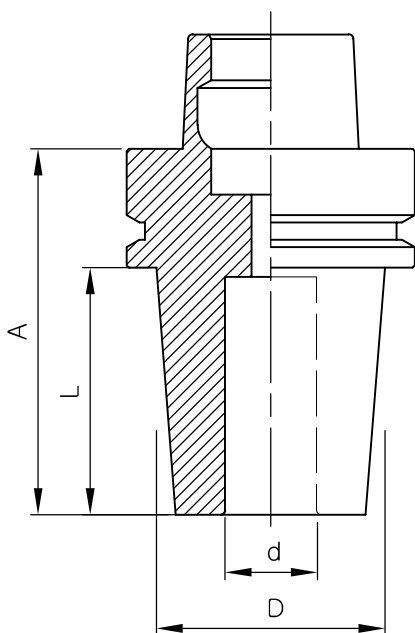
TECHNICAL SPECIFICATIONS

For clamping tool shanks with a diameter tolerance of g6 (h6)
 Rigid and compact design
 n_{max} : 30,000 RPM
 High-precision chuck with high radial run-out accuracy
 Suitable for both clockwise (RH) and counter-clockwise (LH) rotation
 L_{min} : minimum shank clamping length

d mm	D mm	L _{min} mm	L mm	A mm	ID No.
12	32	36	46	80	701001
16	38	39	49	80	701002
20	52.5	41	51	80	701003
25	52.5	47	57	84	701004

! The spanner (clamping wrench) is not included; it must be ordered separately.

Accessories	Designed for	ID No.
ISK4 KEY	701001	710204
ISK5 KEY	701002,3,4	710205



APPLICATION

For clamping shank tools on CNC milling machines with automatic tool change

TECHNICAL SPECIFICATIONS

Clamping taper according to DIN 69893-6, form F

For clamping tool shanks with diameters of 12/16/20/25 mm (h6 tolerance)

Hardened and ground finish

Pre-balanced n_{max} : 24,000 RPM

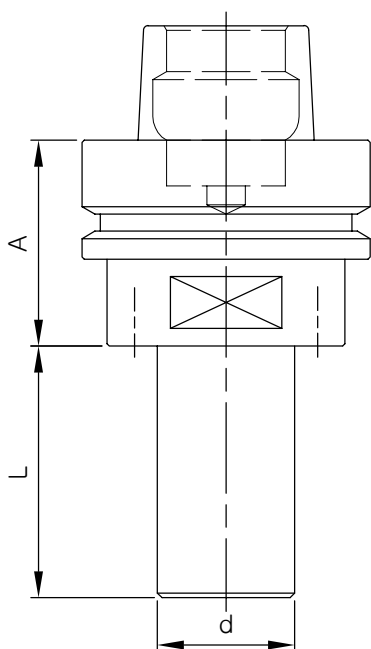
Maximum radial run-out of the test arbor, measured at a distance of $3 \times D$ from the holder face, is 0.003 mm.

d mm	D mm	L mm	A mm	ID No.
12	34	49	75	702001
16	34	49	75	702002
20	42	49	75	702003
25	42	64	90	702004

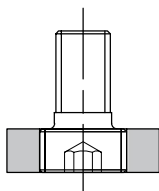


Other sizes available on request.

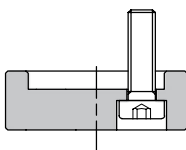
Precise tool clamping for cutting diameters up to 32 mm.



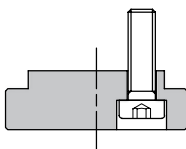
Type A



Type B



Type C



APPLICATION

Milling arbor for clamping tools with a mounting hole on CNC milling machines with automatic tool change

TECHNICAL SPECIFICATIONS

Clamping taper according to DIN 69893-6, form F
 Tools are secured against rotation via screws or pins
 Hardened and ground finish
 Fine-balanced
 20 mm diameter clamps are supplied including a type A clamping screw
 For 30 mm diameter clamps, a type B or C clamping attachment must be ordered separately.

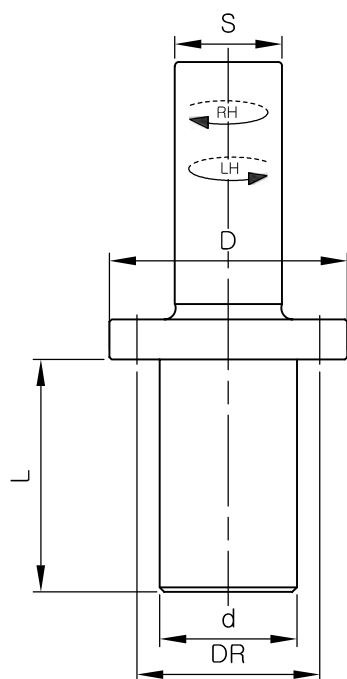
d mm	L mm	A mm	Attachment type	ID No.
20	55	45	A	900121
20	80	45	A	900122
30	55	45	B/C	900123
30	70	45	B/C	900225
30	90	45	B/C	900124
30	110	45	B/C	900227
30	130	45	B/C	900226
30	150	45	B/C	900228
30	200	45	B/C	900230

Separate arbor attachments ø30 mm

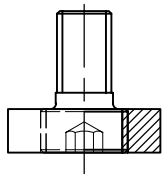
Attachment type	ID No.
B	902023
C	902024

Spare parts	Attachment type	ID No.
SCREW M6×20 ISK5	B/C	710028
ISK5 KEY	B/C	710205
ISK6 KEY	A	710206

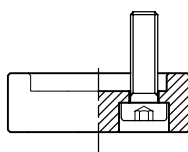
! For spacer rings, see page 104.



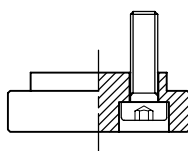
Type A



Type B



Type C



APPLICATION

For clamping tools with a hole on CNC milling machines

TECHNICAL SPECIFICATIONS

Tools are secured against rotation via screws or pins

Hardened and ground finish

Fine-balanced

Arbors are supplied including an adjusting screw, clamping screw, and the corresponding key

Right-hand (RH) or left-hand (LH) rotation

d mm	L mm	DR mm	S mm	D mm	Att. type	Rot. direction	ID No.
20	55	35	25	50	A	RH	900131
20	55	35	25	50	A	LH	900231
20	70	35	25	50	A	RH	900132
20	70	35	25	50	A	LH	900232
30	25	40	25	50	B/C	RH/LH	900133
30	40	40	25	50	B/C	RH/LH	900134

Separate arbor attachments

Attachment type	ID No.
A	
B	902023
C	902024

Spare parts	Attachment type	ID No.
SCREW M6×20 ISK5	B/C	710028
ISK5 KEY	B/C	710205
ISK6 KEY	A	710206



For spacer rings, see page 104.

Other dimensional configurations available on request.

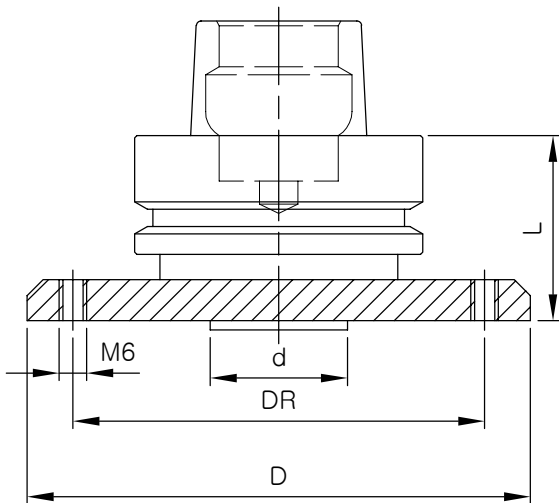


APPLICATION

Designed for clamping saw blades on CNC machining centres with automatic tool change

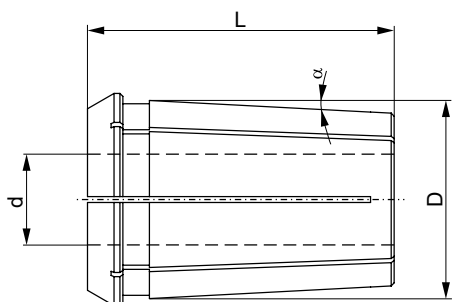
TECHNICAL SPECIFICATIONS

Flange-less clamping using 6×M6 countersunk screws
 Hardened and ground finish
 Clamping taper according to DIN 69893, form F
 Designed for saw blades up to \varnothing 350 mm with a 30 mm clamping hole
 High radial and axial run-out accuracy



d mm	L mm	DR mm	D mm	ID No.
30	40	90	110	T128.160.R
30	100	90	110	T128.165.R

Spare parts	ID No.
SCREW M6×10 TX20	710066
TX20 KEY	710240



APPLICATION

For precision clamping of tool shanks with diameters 2–25 mm

TECHNICAL SPECIFICATIONS

High clamping force and high radial accuracy are ensured by 12 slots
Hardened and ground finish

Clamping range of 0.5 mm (e.g. a collet with diameter of $d = 25$ mm allows clamping shanks with diameter $d = 24.5$ –25 mm)

Clamping diameter according to customer requirements

Type OZ 25—DIN 6388

d mm	D mm	L mm	α°	ID No.
3–25	33.6	52	3	9100xx

xx = internal collet diameter d; please specify when ordering

ER Collet //

APPLICATION

For precision clamping of tool shanks with diameters 1–25 mm
For collet chucks with an 8° taper

TECHNICAL SPECIFICATIONS

High clamping force and high radial accuracy are ensured by 16 slots
Hardened and ground finish

Clamping range of 1 mm (e.g. a collet with diameter of $d = 25$ mm allows clamping shanks with diameter $d = 24$ –25 mm)

Clamping diameter according to customer requirements

Clamping diameters available in 1 mm increments

Type ER 16—DIN 6499

d mm	D mm	L mm	α°	ID No.
1–10	17	27	8	9200xx

Type ER 20—DIN 6499

d mm	D mm	L mm	α°	ID No.
1–13	21	31.5	8	9600xx

Type ER 25—DIN 6499

d mm	D mm	L mm	α°	ID No.
2–16	26	34	8	9300xx

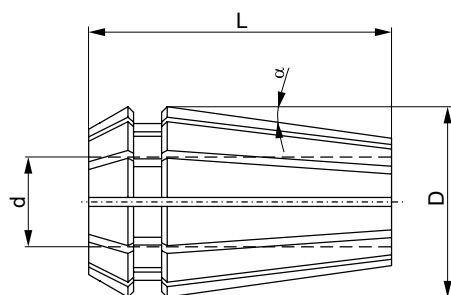
Type ER 32—DIN 6499

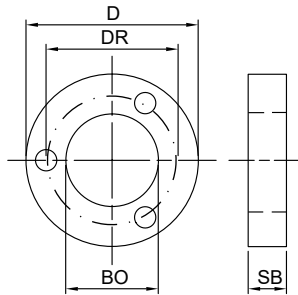
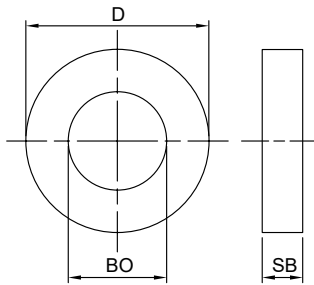
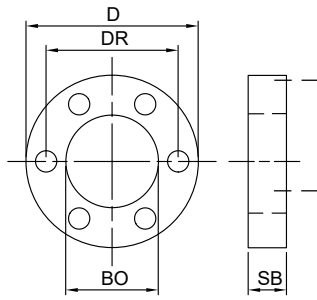
d mm	D mm	L mm	α°	ID No.
3–20	33	40	8	9400xx

Type ER 40—DIN 6499

d mm	D mm	L mm	α°	ID No.
4–25	41	46	8	9500xx

xx = internal collet diameter d; please specify when ordering



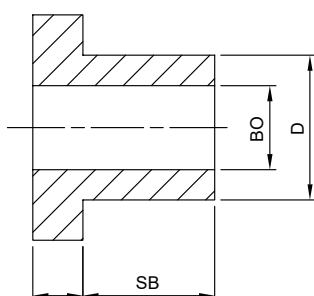
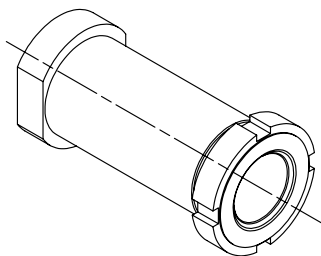
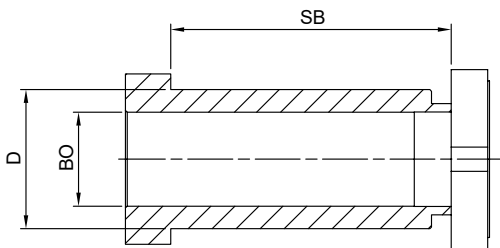


SB	D/BO/DR						
	50/30/40	60/30/45	60/32/47	65/35/50	70/40/55	80/50/65	90/60/75
0.1	495001	496001	496201	496501	497001	498001	499001
0.2	495002	496002	496202	496502	497002	498002	499002
0.3	495003	496003	496203	496503	497003	498003	499003
0.5	495005	496005	496205	496505	497005	498005	499005
1.0	495010	496010	496210	496510	497010	498010	499010

SB	D/BO				
	50/30	60/30	60/32	65/35	70/40
3.0	495030	496030	496230	496530	497030
5.0	495050	496050	496250	496550	497050
8.0	495080	496080	496280	496580	497080
10.0	495100	496100	496300	496600	497100
15.0	495150	496150	496350	496650	497150
20	495200	496200	496400	496700	497200

SB	D/BO/DR	
	80/50/65	90/60/75
3.0	498030	499030
5.0	498050	499050
8.0	498080	499080
10.0	498100	499100
15.0	498150	499150
20	498200	499200

\\ Clamping and Reduction Sleeves



! Information on sleeves is available upon request.

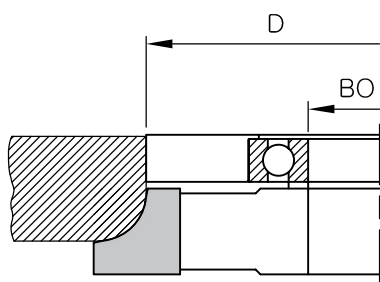
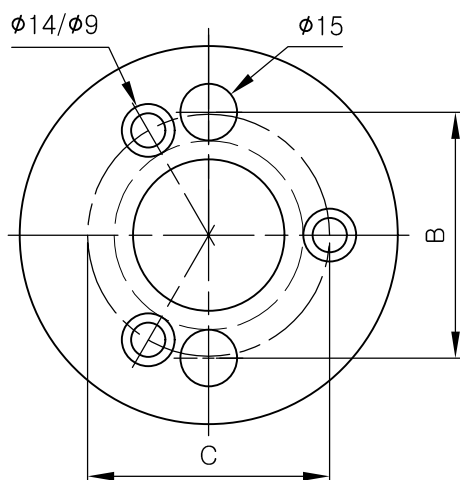
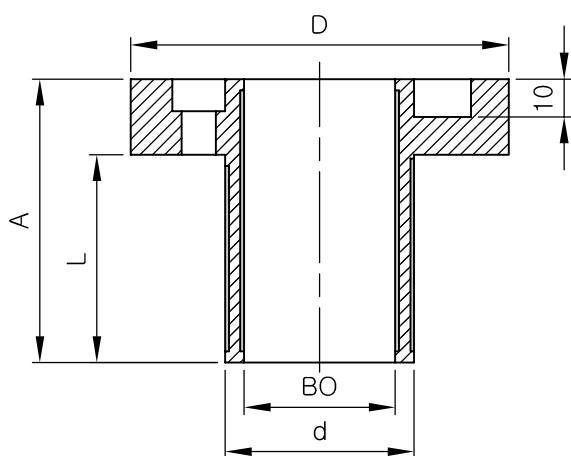


APPLICATION

For precision interchangeable tool clamping
HYDRO-GRIP CI premium-quality hydraulic clamping sleeve

TECHNICAL SPECIFICATIONS

Tools can be bolted directly to the sleeve flange
Several different tools can be clamped simultaneously
Closed-circuit sleeve design
Pressurisation is performed via a hexagon socket screw
No leakage of pressure medium, preventing contamination of the sleeve and workpieces (unlike systems using grease guns/nipples)



Type	BO mm	d mm	A mm	L mm	D mm	B mm	C mm	ID No.
CI 40/50-75	40	50	75	55	100	65	64	700110
CI 40/60-75	40	60	75	55	102	75	74	700111
CI 40/60-95	40	60	95	75	108	75	74	700112
CI 40/60-115	40	60	115	95	108	75	74	700113
CI 40/60-140	40	60	140	115	114	75	74	700114
CI 50/60-75	50	60	75	55	102	75	74	700115
CI 50/60-95	50	60	95	75	108	75	74	700116
CI 50/60-115	50	60	115	95	108	75	74	700117
CI 50/60-140	50	60	140	115	114	75	74	700118

Support rings with bearing //

D mm	Bo mm	ID No.
90	30	890090
95	30	890095
100	30	890100
105	30	890105
110	30	890110
115	30	890115
120	30	890120
125	30	890125
130	30	890130



APPLICATION

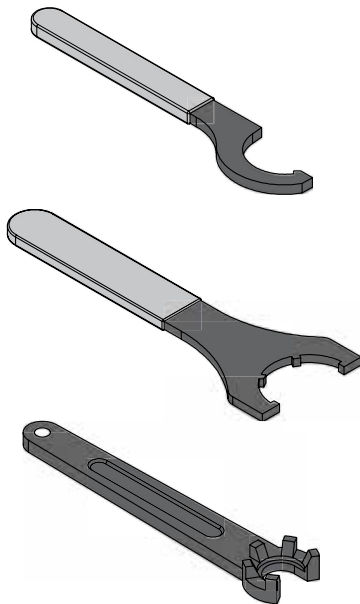
For clamping machining tools into collet chucks
Enables rapid clamping and easier, safer tool handling

TECHNICAL SPECIFICATIONS

Ready for mounting on a workbench
L = fixture height

Chuck type	SB mm	L mm	ID No.
HSK 63F	60.8	165	217214048
ISO 30	51.6	162	217214063

Clamping Spanners for Collet Chucks



APPLICATION

Designed for tightening clamping nuts on collet chucks

Hook spanner for a collet nut

Nut type	ID No.
ER25	710401
ER32	710402
ER40/OZ25	710403

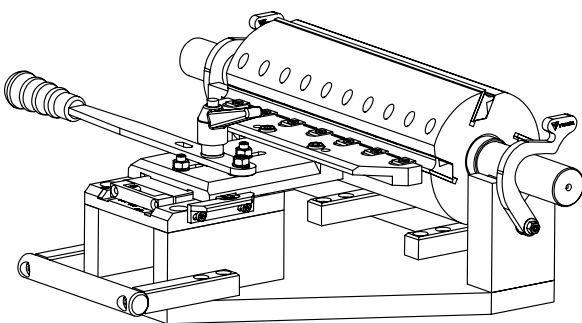
Spanner for a collet nut—slotted

Nut type	ID No.
ER16	710411
ER20	710412
ER25	710413
ER32	710414
ER40	710415

Spanner for MINI collet nut—slotted

Nut type	ID No.
ER16	710421
ER20	710422
ER25	710423

Setting Gauge for HS/HW Planing Knives



APPLICATION

The gauge is used for the precise setting of planing knives to the required diameter with high radial run-out accuracy

TECHNICAL SPECIFICATIONS

Designed for planing heads with a 40 mm clamping diameter, fitted with standard planing knives (SB×30×3, SB35×3)
Setting diameters: Ø 120, 125, 130, 140 mm
Max. planing head length: 310 mm

ID. No. 217214052



Clamping Ø 30, Ø 50 are available on request.



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