

Milling Chuck Features

Nikken is the inventor of the original Milling Chuck (U.S. Patent 7018919). Since its introduction in 1963, Nikken has sold over 3,000,000 Milling Chucks worldwide and never stopped improving upon its original design. Featuring multi-roller bearings, spiral coolant slots, and a heavy-duty nut, the Milling Chuck is the most reliable and powerful toolholder available.



**STRONGEST
MECHANICALLY
GRIPPING HOLDER
IN THE WORLD!**



Construction and Design



Forged Nickel Chrome Molybdenum 4340 ground on taper and base.



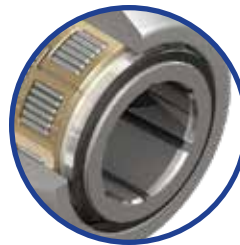
Staggered, coated steel cage packs 140% more needle rollers than competitors. This provides more gripping power. The retainer is NOT made of phosphor bronze, but rather of special steel which will never break.



Thick nut exerts immense gripping strength by collapsing tight taper on the mill chuck body.



Solid 1-piece base and thick wall provides rigidity for heavy machining.



Inner bore coolant slots project coolant at 2 degrees, assuring high pressure and volume of coolant during high RPM operations.



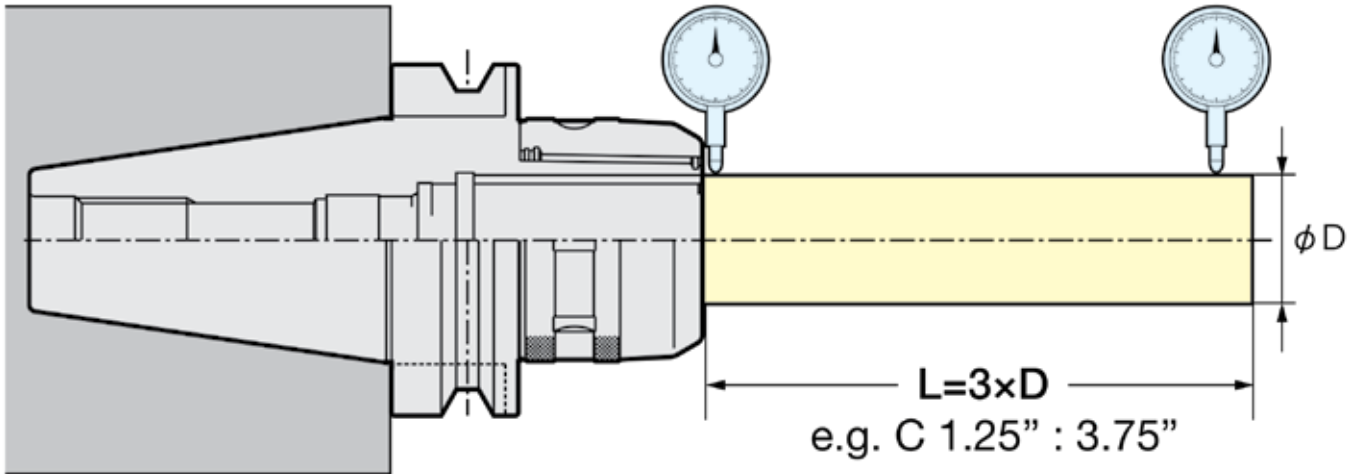
All milling chucks are cryogenically treated after heat treatment to stabilize concentrations of carbon. This prevents deformation and cracking when under stress for the life of the toolholder.



Milling Chuck Features

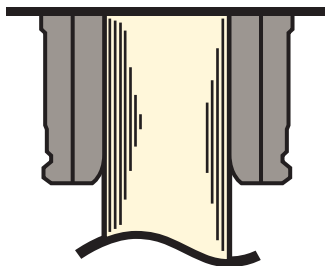
Superior Run Out Accuracy

Within 0.0002"

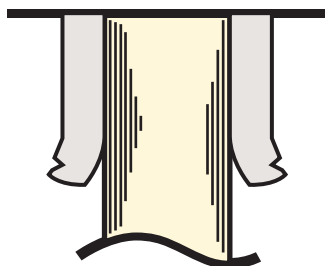


- Flange and taper grinding allow smooth and precise chucking of tool, resulting in minimal T.I.R.
- 0.0002 at 3.75" from the nose—guaranteed

STRONGEST Grip in the World UP TO 3,500 ft-lbs.!



NIKKEN Milling Chuck



OTHER Milling Chuck

Nikken's patented Milling Chuck design allows clamping force to be dispersed evenly around the entire cutting tool shank. Gripping force up to 3,500 ft-lbs. can be applied ensuring optimal cutting performance and rigidity.

HSK Milling Chucks

- Nikken patented design
- Nut body contact, nose clamping and anti-vibration mechanism
- Thick body and internal slots provide extremely strong chucking torque and rigidity
- Quiet and stable heavy milling
- 140% more bearing surface than competitors' milling chucks



T.I.R.: <0.0002" at 3xD



Speed: up to 20,000 RPM



Set-up: quick and easy



Coolant-Thru: thru-tool coolant



Milling



Drilling



Tapping



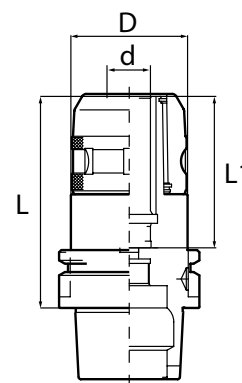
Reaming

Please note that the maximum RPM listed in our catalog may vary depending on the toolholder shank, weight, balanceability and the G rating.

HSK63A

Part Number	Collet Size	Clamping Range	Spanner Wrench	d	L	L1	D
HSK63A-C3/4-95	KM3/4	0.125-0.750"	9HC22	0.750"	3.740"	2.677"	2.027"
HSK63A-C3/4-110	KM3/4	0.125-0.750"	9HC22	0.750"	4.330"	3.149"	2.027"
HSK63A-C1-100	KM1	0.125-1.000"	9HC25	1.000"	3.937"	2.972"	2.342"
HSK63A-C1-130	KM1	0.125-1.000"	9HC25	1.000"	5.118"	3.149"	2.342"
HSK63A-C1.1/4-110	KM1.1/4	0.187-1.250"	9HC32	1.250"	4.330"	3.267"	2.716"
HSK63A-C1.1/4-130	KM1.1/4	0.187-1.250"	9HC32	1.250"	5.118"	3.188"	2.716"
HSK63A-C32-130	KM32	6 - 32mm	9HC32	32mm	5.118"	3.188"	2.716"

Note: Spanner wrench, coolant tube and coolant tube wrench not included. Please see page 117 for more details.

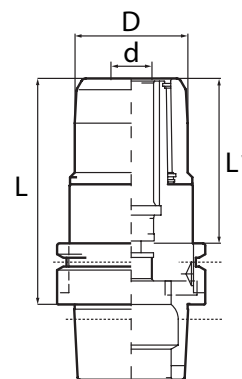


HSK63A High Speed

Part Number	Collet Size	Clamping Range	High-Speed Spanner Wrench	d	L	L1	D
HSK63A-C3/4-95G	KM3/4	0.125-0.750"	GH20	0.750"	3.740"	2.677"	1.889"
HSK63A-C3/4-110G	KM3/4	0.125-0.750"	GH20	0.750"	4.330"	3.149"	1.889"
HSK63A-C1-100G	KM1	0.125-1.000"	GH25	1.000"	3.937"	2.972"	2.149"
HSK63A-C1-130G	KM1	0.125-1.000"	GH25	1.000"	5.118"	2.149"	2.165"
HSK63A-C1.1/4-110G	KM1.1/4	0.187-1.250"	GH32	1.250"	4.330"	3.267"	2.677"
HSK63A-C1.1/4-130G	KM1.1/4	0.187-1.250"	GH32	1.250"	5.118"	3.188"	2.677"

Note:

- High-Speed Spanner wrench, coolant tube and coolant tube wrench not included. Please see page 117 for more details.
- High-speed HSK63A Milling Chucks use special high-speed spanner wrenches.

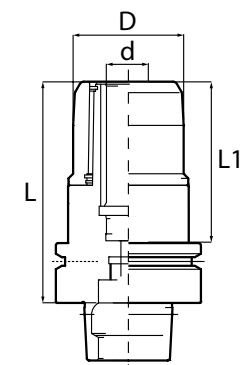


HSK63F High Speed

Part Number	Collet Size	Clamping Range	High-Speed Spanner Wrench	d	L	L1	D
HSK63F-C3/4-95G	KM3/4	0.125-0.750"	GH20	0.750"	3.740"	2.677"	3.307"
HSK63F-C1-100G	KM1	0.125-1.000"	GH25	1.000"	3.937"	2.952"	2.149"
HSK63F-C1.1/4-110G	KM1.1/4	0.187-1.250"	GH32	1.250"	4.330"	3.267"	2.677"

Note:

- High-Speed Spanner wrench, coolant tube, and coolant tube wrench not included. Please see page 117 for more details.
- High-speed HSK63F Milling Chucks use special high-speed spanner wrenches.



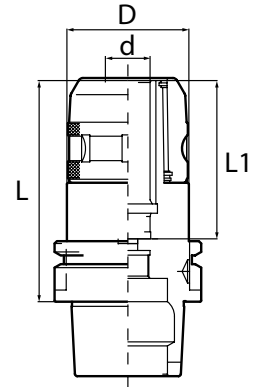
HSK Milling Chucks



HSK100A

Part Number	Collet Size	Clamping Range	Spanner Wrench	d	L	L1	D
HSK100A-C3/4-115	KM3/4	0.125-0.750"	9HC22	0.750"	4.527"	3.149"	2.027"
HSK100A-C3/4-135	KM3/4	0.125-0.750"	9HC22	0.750"	5.314"	3.149"	2.027"
HSK100A-C1-115	KM1	0.125-1.000"	9HC25	1.000"	4.527"	3.149"	2.342"
HSK100A-C1-135	KM1	0.125-1.000"	9HC25	1.000"	5.314"	3.149"	2.342"
HSK100A-C1.1/4-115	KM1.1/4	0.187-1.250"	9HC32	1.250"	4.527"	3.267"	2.716"
HSK100A-C1.1/4-165	KM1.1/4	0.187-1.250"	9HC32	1.250"	6.496"	3.188"	2.716"
HSK100A-C32-135	KM32	6 - 32mm	9HC32	32mm	5.314"	3.188"	2.716"
HSK100A-C2-125	KM2	1.000-2.000"	9HC50	2.000"	4.921"	3.543"	4.133"

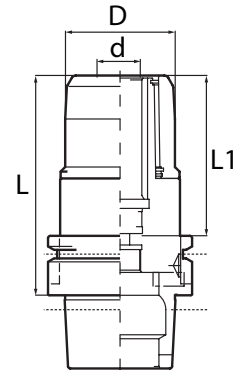
Note: Spanner wrench, coolant tube, and coolant tube wrench not included.
Please see page 117 for more details.



HSK100A High Speed

Part Number	Collet Size	Clamping Range	High-Speed Spanner Wrench	d	L	L1	D
HSK100A-C3/4-115G	KM3/4	0.125-0.750"	GH20	0.750"	4.527"	3.149"	2.047"
HSK100A-C3/4-135G	KM3/4	0.125-0.750"	GH20	0.750"	5.314"	3.149"	2.047"
HSK100A-C1-115G	KM1	0.125-1.000"	GH25	1.000"	4.527"	3.149"	2.362"
HSK100A-C1-135G	KM1	0.125-1.000"	GH25	1.000"	5.314"	3.149"	2.362"
HSK100A-C1.1/4-115G	KM1.1/4	0.187-1.250"	GH32	1.250"	4.527"	3.267"	2.716"
HSK100A-C1.1/4-165G	KM1.1/4	0.187-1.250"	GH32	1.250"	6.496"	3.188"	2.716"

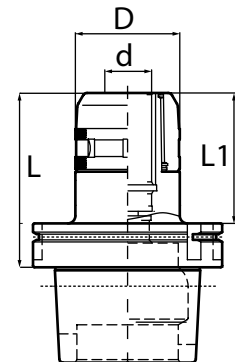
- Note:
- Spanner wrench, coolant tube, and coolant tube wrench not included. Please see page 117 for more details.
 - High-speed HSK100A Milling Chucks use special high-speed spanner wrenches.



HSK125A

Part Number	Collet Size	Clamping Range	Spanner Wrench	d	L	L1	D
HSK125A-C1-115	KM1	0.125-1.000"	9HC25	1.000"	4.527"	3.031"	2.047"
HSK125A-C1.1/4-115	KM1.1/4	0.187-1.250"	9HC32	1.250"	4.527"	3.386"	2.716"
HSK125A-C2-125	KM2	1.000-2.000"	9HC50	2.000"	4.921"	3.780"	4.134"

Note: Spanner wrench, coolant tube, and coolant tube wrench not included.
Please see page 117 for more details.



KM & NK
Collets
Pages 113-114



Spanner
Wrench
Page 117



Back-Up
Screw
Page 117



Coolant-Thru &
Slotted Nuts
Page 115-116