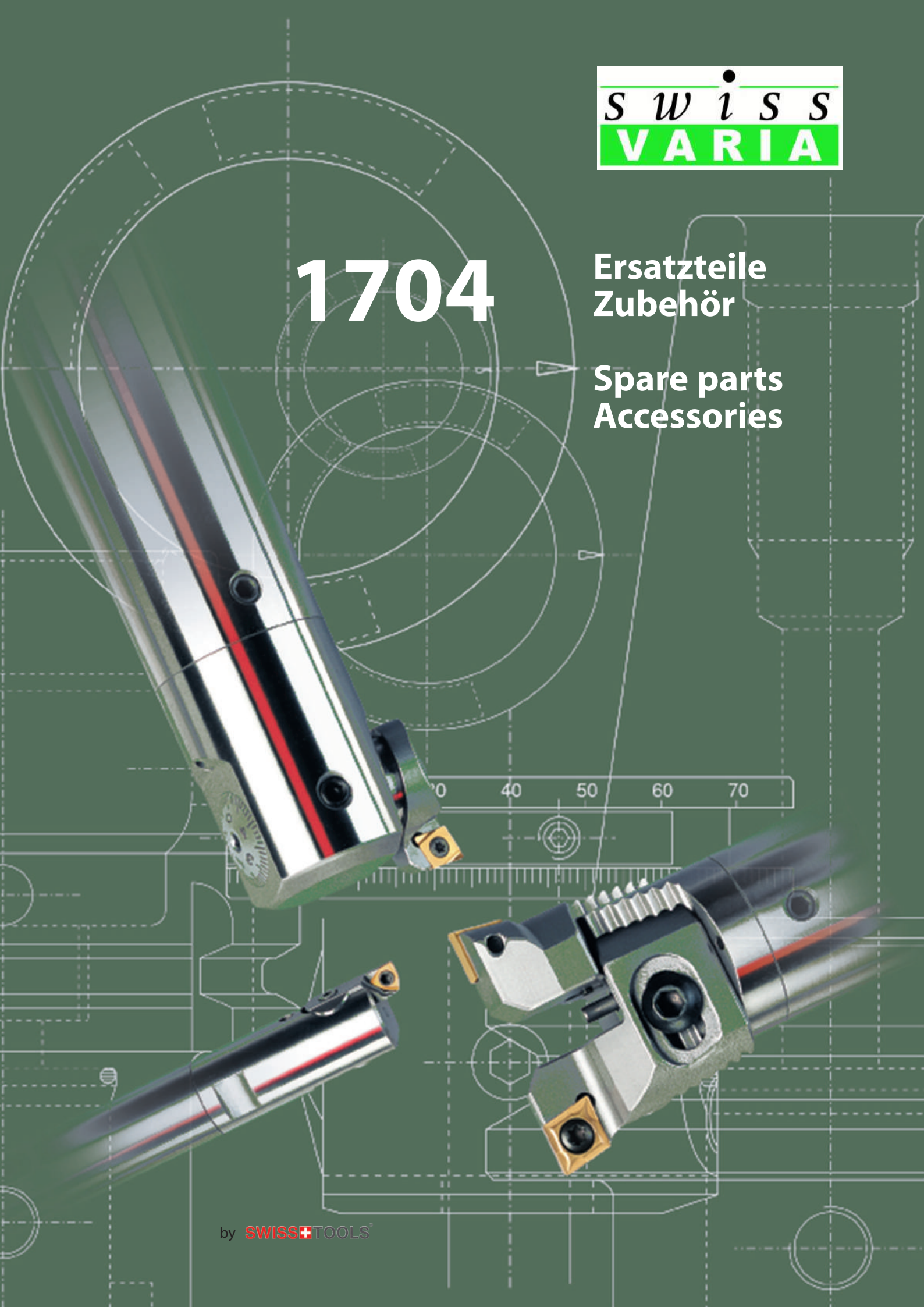


1704

**Ersatzteile
Zubehör**

**Spare parts
Accessories**



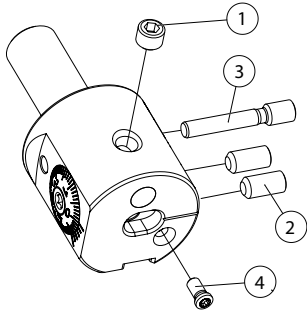
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Ersatzteile / Zubehör

Spare parts / Accessories

B04/B06

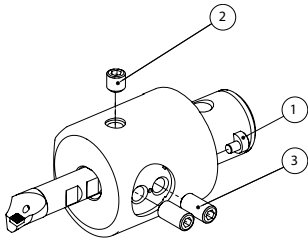


Type	max. Nm	S	Torque key	Bit	Service key
Type B04/B06.010.025.025					
① J00.204.005.004	1.4	2.5	J00.895.000.012	J00.895.001.025	J00.892.000.025
② J00.204.004.008	2.4	2	J00.895.000.022	J00.895.001.020	J00.892.000.020
③ A25-BG4.003.022					
④ J00.254.025.006					
Type 204/206.016.032.032					
① J00.204.006.005	2.4	3	J00.895.000.022	J00.895.001.030	J00.892.000.030
② J00.204.006.010	3.4	3	J00.895.000.030	J00.895.001.030	J00.892.000.030
③ A32-BG4.003.028					
④ J00.254.025.006					

Ersatzteile / Zubehör

Spare parts / Accessories

B04/B06/B08/B09/B11

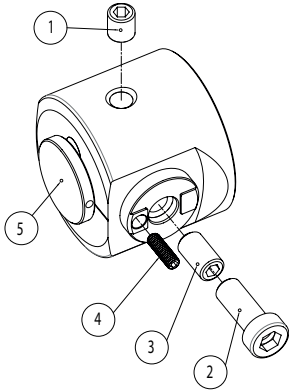


Type	max. Nm	S	Torque key	Bit	Service key
Type B04 / B06 / B08 / B09 / B11					
② J00.204.010.008	8.0	5	J00.895.000.057	J00.895.001.050	J00.892.000.050
③ J00.204.010.016	10.0	5			J00.892.000.050

Ersatzteile / Zubehör

Spare parts / Accessories

B05

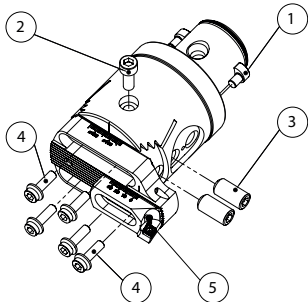


Type	max. Nm	S	Torque key	Bit	Service key
Type B05.063.025.050					
① J00.205.010.012	8.0	5	J00.895.000.057	J00.895.001.050	J00.892.000.050
② J00.205.010.025	10.0	8			J00.892.000.080
③ J00.205.010.018	10.0	5			J00.892.000.050
④ J00.205.003.014	3.0	2.5	J00.895.000.030	J00.895.001.025	J00.892.000.025
⑤ J00.805.000.032					

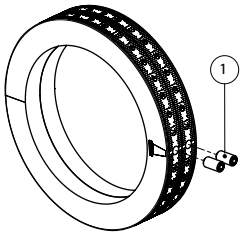
Ersatzteile / Zubehör

Spare parts / Accessories

B10



Type	max. Nm	S / Torx	Torque key	Bit	Service key	Service key
Type B10.xxx.xxx.xxx						
② J00.210.006.016	8.0	5	J00.895.000.057	J00.895.001.050		J00.892.000.050
③ J00.210.010.020	10.0	5				J00.892.000.050
④ J00.256.005.016	5.0	4	J00.895.000.050	J00.895.001.040		J00.892.000.040
⑤ J00.254.025.006 (256.xxx.006.xxx)	0.9	T7	J00.895.000.009	J00.895.002.007	J00.254.007.000	
⑤ J00.254.040.009 (256.xxx.009.xxx)	3.0	T15	J00.895.000.030	J00.895.002.015	J00.254.009.000	

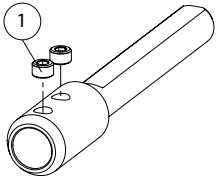


Ersatzteile / Zubehör

Spare parts / Accessories

B16




Type B16.xxxx.xxx.016	max. Nm	S	Torque key 	Bit 	Service key 
① J00.216.004.008	1.4	2	J00.895.000.012	J00.895.001.020	J00.892.000.020

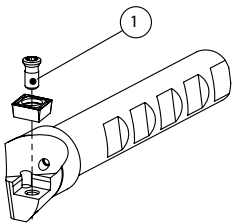


Ersatzteile / Zubehör

Spare parts / Accessories

B34



Type B34.016.010.128	max. Nm	S	Torque key 	Bit 	Service key 
① J00.234.006.003	3.4	3	J00.895.000.030	J00.895.001.030	J00.892.000.030
Type B34.016.016.148					
① J00.234.008.005	5.0	4	J00.895.000.050	J00.895.001.040	J00.892.000.040

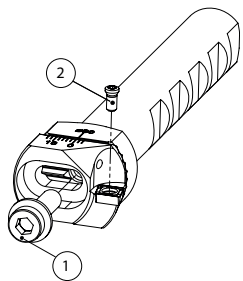


Ersatzteile / Zubehör

Spare parts / Accessories

B54

Type B54.010.006.075	max. Nm	Torx	Torque key 	Bit 	Service key 
① J00.254.025.005	0.9	T7	J00.895.000.009	J00.895.002.007	J00.254.007.000
Type B54.xxx.006.xxx					
① J00.254.025.006	0.9	T7	J00.895.000.009	J00.895.002.007	J00.254.007.000
Type B54.xxx.009.xxx					
① J00.254.040.009	3.0	T15	J00.895.000.030	J00.895.002.015	J00.254.009.000

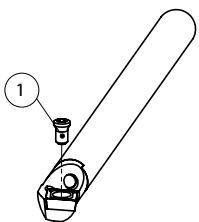


Ersatzteile / Zubehör

Spare parts / Accessories

B56




Type B56.xxx.xxx.115	max. Nm	S / Torx	Torque key 	Bit 	Service key 	Service key 
① J00.256.005.016	5.0	4	J00.895.000.050	J00.895.001.040	J00.892.000.040	
Type B56.xxx.006.xxx						
② J00.254.025.006	0.9	T7	J00.895.000.009	J00.895.002.007		J00.254.007.000
Type B56.xxx.009.xxx						
② J00.254.040.009	3.0	T15	J00.895.000.030	J00.895.002.015		J00.254.009.000

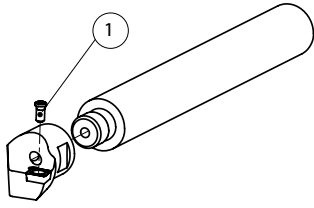


Ersatzteile / Zubehör

Spare parts / Accessories

B74

Type B74.xxx.002.xxx	max. Nm	Torx	Torque key 	Bit 	Service key 
① J00.254.020.004	0.6	T6	J00.895.000.006	J00.895.002.006	J00.254.006.000
Type B74.010.006.120					
① J00.254.025.005	0.9	T7	J00.895.000.009	J00.895.002.007	J00.254.007.000
Type B74.xxx.006.xxx					
① J00.254.025.006	0.9	T7	J00.895.000.009	J00.895.002.007	J00.254.007.000
Type B74.xxx.009.xxx					
① J00.254.040.009	3.0	15	J00.895.000.030	J00.895.002.015	J00.254.009.000

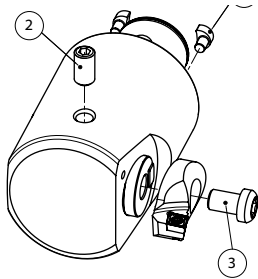


Ersatzteile / Zubehör

Spare parts / Accessories

B94

Type	max. Nm	Torx	Torque key	Bit	Service key
Type B94.009-012.006.0xx					
① J00.254.025.005	0.9	7	J00.895.000.009	J00.895.002.007	J00.254.007.000
Type B94.013-035.006.xxx					
① J00.254.025.006	0.9	7	J00.895.000.009	J00.895.002.007	J00.254.007.000



Ersatzteile / Zubehör

Spare parts / Accessories

C00/C01

Type	max. Nm	S / Torx	Torque key	Bit	Service key	Service key
Type C00.014.015.040						
② J00.881.280.140	0.9	1.5	J00.895.000.009	J00.895.001.015	J00.892.000.015	
③ J00.882.280.140	0.9	T6	J00.895.000.009	J00.895.002.006		J00.254.006.000
Type C00.016.017.040						
② J00.881.280.160	0.9	1.5	J00.895.000.009	J00.895.001.015	J00.892.000.015	
③ J00.882.280.160	0.9	T6	J00.895.000.009	J00.895.002.006		J00.254.006.000
Type C00.019.020.040						
② J00.881.280.180	0.9	1.5	J00.895.000.009	J00.895.001.015	J00.892.000.015	
③ J00.882.280.180	0.9	T6	J00.895.000.009	J00.895.002.006		J00.254.006.000
Type C00/C01.020.024.041						
② J00.304.004.003	1.2	2	J00.895.000.010	J00.895.001.020	J00.892.000.020	
③ J00.314.004.006	2.4	2.5	J00.895.000.022	J00.895.001.025	J00.892.000.025	
Type C00/C01.025.031.045						
② J00.304.005.004	1.4	2.5	J00.895.000.012	J00.895.001.025	J00.892.000.025	
③ J00.314.005.008	5.0	3	J00.895.000.050	J00.895.001.030	J00.892.000.030	
Type C00/C01.032.040.051						
② J00.304.006.005	2.4	3	J00.895.000.022	J00.895.001.030	J00.892.000.030	
③ J00.314.006.010	9.0	4			J00.892.000.040	

Ersatzteile / Zubehör

Spare parts / Accessories

C04/C05

Type C04/C05.020.024.045	max. Nm	S	Torque key 	Bit 	Service key 
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②	J00.304.004.003	1.2	2	J00.895.000.010	J00.895.001.020	J00.892.000.020
---	-----------------	-----	---	-----------------	-----------------	-----------------

③	J00.314.004.006	2.4	2.5	J00.895.000.022	J00.895.001.025	J00.892.000.025
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Type
C04/C05.025.031.056

②	J00.304.005.004	1.4	2.5	J00.895.000.012	J00.895.001.025	J00.892.000.025
---	-----------------	-----	-----	-----------------	-----------------	-----------------

③	J00.314.005.008	5.0	3	J00.895.000.050	J00.895.001.030	J00.892.000.030
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Type
C04/C05.032.040.066

②	J00.304.006.005	2.4	3	J00.895.000.022	J00.895.001.030	J00.892.000.030
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③	J00.314.006.010	9.0	4			J00.892.000.040
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Type
C04/C05 .039.051.075

②	J00.304.008.006	4.0	4	J00.895.000.038	J00.895.001.040	J00.892.000.040
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③	J00.314.008.012	10.0	5			J00.892.000.050
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Type
C04/C05.050.067.090

②	J00.304.010.010	8.0	5	J00.895.000.057	J00.895.001.050	J00.892.000.050
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③	J00.314.010.016	20.0	8			J00.892.000.080
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Type
C04/C05.063.087.110

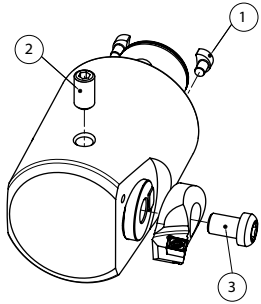
②	J00.304.010.018	8.0	5	J00.895.000.057	J00.895.001.050	J00.892.000.050
---	-----------------	-----	---	-----------------	-----------------	-----------------

③	J00.314.010.016	20.0	8			J00.892.000.080
---	-----------------	------	---	--	--	-----------------

Type
C04/C05.080.115.140

②	J00.304.010.030	8.0	5	J00.895.000.057	J00.895.001.050	J00.892.000.050
---	-----------------	-----	---	-----------------	-----------------	-----------------

③	J00.314.010.016	20.0	8			J00.892.000.080
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Ersatzteile / Zubehör

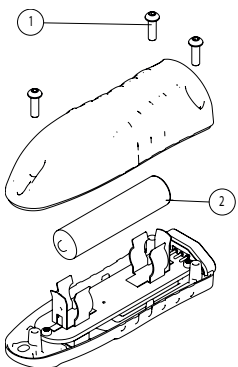
Spare parts / Accessories

C09

Type C09.028.024.077	Size	Torx	Service key 
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①	J00.309.022.008	T6	J00.254.006.000
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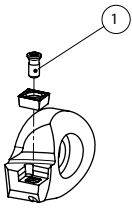
②	J00.308.011.045	AAA	
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Ersatzteile / Zubehör

Spare parts / Accessories

C02/C14/C15

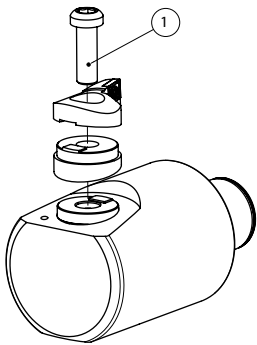






Type C02.005.017.002	max. Nm	Torx	Torque key 	Bit 	Service key 
J00.254.020.004	0.6	T6	J00.895.000.006	J00.895.002.006	J00.254.006.000
Type C14/C15.xxx.xxx.006					
J00.254.025.006	0.9	T7	J00.895.000.009	J00.895.002.007	J00.254.007.000
Type C14/C15.xxx.xxx.009					
J00.254.040.009	3.0	T15	J00.895.000.030	J00.895.002.015	J00.254.009.000

Ersatzteile / Zubehör

Spare parts / Accessories

C24







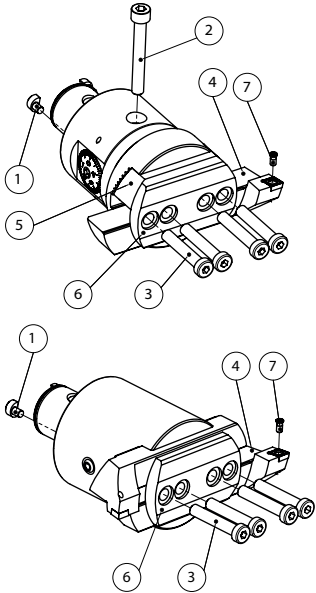
For reversal adapter Type	Order number 	max. Nm	S	Torque key 	Bit 	Service key 
C24.011.065.008	J00.324.004.012	2.4	2.5	J00.895.000.022	J00.895.001.025	J00.892.000.025
C24.011.080.008	J00.324.004.013	2.4	2.5	J00.895.000.022	J00.895.001.025	J00.892.000.025
C24.013.065.007	J00.324.005.014	3.4	3	J00.895.000.050	J00.895.001.030	J00.892.000.030
C24.013.100.007	J00.324.005.016	3.4	3	J00.895.000.050	J00.895.001.030	J00.892.000.030
C24.017.065.013	J00.324.006.015	5.0	4			J00.892.000.040
C24.017.100.013	J00.324.006.020	5.0	4			J00.892.000.040
C24.022.065.016	J00.324.008.020	10.0	5			J00.892.000.050
C24.022.120.016	J00.324.008.025	10.0	5			J00.892.000.050
C24.030.100.027	J00.324.010.030	20.0	8			J00.892.000.050

Ersatzteile / Zubehör

Spare parts / Accessories

C44/C54/D44/D54

Type C44/D44.064.086.112	max. Nm	S / Torx	Torque key 	Bit 	Service key 	Service key 
② J00.344.008.065	8.0	6	J00.895.000.057	J00.895.001.060	J00.892.000.060	
③ J00.344.008.044	25.0	6			J00.892.000.060	
Type C54/D54.086.138.009						
④ J00.354.086.009						
⑤ J00.345.020.086						
⑥ J00.345.010.086						
⑦ J00.254.040.009	3.0	T15	J00.895.000.030	J00.895.002.015		J00.254.009.000
Type C54/D54.086.138.012						
④ J00.354.086.012						
⑤ J00.345.020.086						
⑥ J00.345.010.086						
⑦ J00.254.050.010	5.0	T20	J00.895.000.050	J00.895.002.020		J00.254.012.000
Type C54/D54.136.220.009						
④ J00.354.136.009						
⑤ J00.345.020.136						
⑥ J00.345.010.136						
⑦ J00.254.040.009	3.0	T15	J00.895.000.030	J00.895.002.015		J00.254.009.000
Type C54/D54.136.220.012						
④ J00.354.136.012						
⑤ J00.345.020.136						
⑥ J00.345.010.136						
⑦ J00.254.050.010	5.0	T20	J00.895.000.050	J00.895.002.020		J00.254.012.000
Type C54/D54.188.302.009						
④ J00.354.188.009						
⑤ J00.345.020.136						
⑥ J00.345.010.136						
⑦ J00.254.040.009	3.0	T15	J00.895.000.030	J00.895.002.015		J00.254.009.000
Type C54/D54.242.402.009						
④ J00.354.242.009						
⑤ J00.345.020.136						
⑥ J00.345.010.136						
⑦ J00.254.040.009	3.0	T15	J00.895.000.030	J00.895.002.015		J00.254.009.000



Ersatzteile / Zubehör

Spare parts / Accessories

D04

Type	max. Nm	S	Torque key	Bit	Service key
D04.020.024.045					

②	J00.404.004.008	2.4	2.5	J00.895.000.022	J00.895.001.025	J00.892.000.025
③	J00.405.004.000					
④	J00.406.025.008					

Type
D04.025.031.056

②	J00.404.005.012	5.0	3	J00.895.000.050	J00.895.001.030	J00.892.000.030
③	J00.405.005.000					
④	J00.406.025.008					

Type
D04.032.040.066

②	J00.404.006.016	9.0	4			J00.892.000.040
③	J00.405.006.000					
④	J00.406.030.012					

Type
D04.040.051.075

②	J00.404.008.020	20.0	5			J00.892.000.050
③	J00.405.008.000					
④	J00.406.030.014					

Type
D04.050.067.090

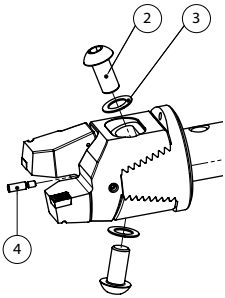
②	J00.404.010.025	35.0	6			J00.892.000.060
③	J00.405.010.000					
④	J00.406.040.020					

Type
D04.063.087.110

②	J00.404.012.025	35.0	8			J00.892.000.080
③	J00.405.012.000					
④	J00.406.060.020					

Type
D04.080.115.140





②	J00.404.016.035	35.0	10			J00.892.000.100
③	J00.405.016.000					
④	J00.406.060.020					

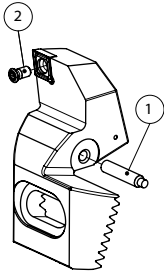


Ersatzteile / Zubehör

Spare parts / Accessories

D14/D24/D37





Type D14/D24/D37	max. Nm	S / Torx	Torque key 	Bit 	Service key 	Service key 
020.024.006						
① J00.414.004.007		2			J00.892.000.020	
② J00.254.025.006	0.9	T7	J00.895.000.009	J00.895.002.007		J00.254.007.000
Type D14/D24/D37 025.031.006						
① J00.414.004.010		2			J00.892.000.020	
② J00.254.025.006	0.9	T7	J00.895.000.009	J00.895.002.007		J00.254.007.000
Type D14/D24/D37 032.040.009						
① J00.414.004.013		2			J00.892.000.020	
② J00.254.040.009	3.0	T15	J00.895.000.030	J00.895.002.015		J00.254.009.000
Type D14/D24/D37 039.051.009						
① J00.414.006.014		3			J00.892.000.030	
② J00.254.040.009	3.0	T15	J00.895.000.030	J00.895.002.015		J00.254.009.000
Type D14/D24/D37 050.067.xxx						
① J00.415.006.020		3			J00.892.000.030	
② J00.254.050.010	5.0	T20	J00.895.000.050	J00.895.002.020		J00.254.012.000
Type D14/D24/D37 064.087.xxx						
① J00.415.006.020		3			J00.892.000.030	
② J00.254.050.010	5.0	T20	J00.895.000.050	J00.895.002.020		J00.254.012.000
Type D14/D24/D37 090.115.xxx						
① J00.415.006.020		3			J00.892.000.030	
② J00.254.050.010	5.0	T20	J00.895.000.050	J00.895.002.020		J00.254.012.000

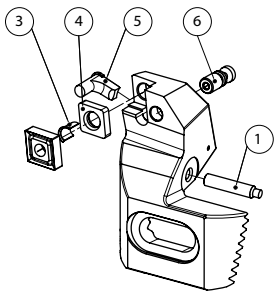


Ersatzteile / Zubehör

Spare parts / Accessories

D14/D24

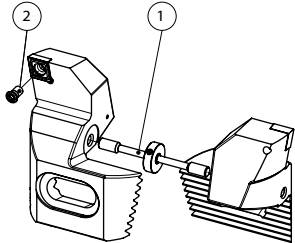
Type D14/D24.050.067.112	max. Nm	S	Torque key 	Bit 	Service key 	Service key 
③ J00.416.012.000						
④ J00.417.012.000						
⑤ J00.418.012.000						
⑥ J00.419.012.000		3			J00.892.000.030	
Type D14/D24.064.087.116						
③ J00.416.016.000						
④ J00.417.016.000						
⑤ J00.418.016.000						
⑥ J00.419.016.000		3			J00.892.000.030	
Type D14/D24.064.087.116						
③ J00.416.016.000						
④ J00.417.016.000						
⑤ J00.418.016.000						
⑥ J00.419.016.000		4			J00.892.000.040	



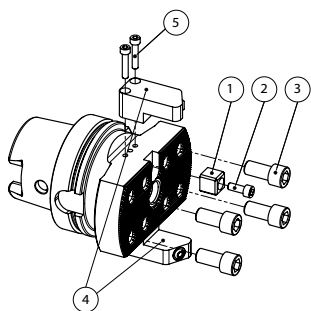
Ersatzteile / Zubehör

Spare parts / Accessories

D34






Type	max. Nm	S / Torx	Torque key	Bit	Service key	Service key
Type D34.020.024.006						
① J00.434.004.018		2			J00.892.000.020	
② J00.254.025.006	0.9	T7	J00.895.000.009	J00.895.002.007		J00.254.007.000
Type D34.025.031.006						
① J00.434.004.023		2			J00.892.000.020	
② J00.254.025.006	0.9	T7	J00.895.000.009	J00.895.002.007		J00.254.007.000
Type D34.032.040.009						
① J00.434.004.030		2			J00.892.000.020	
② J00.254.040.009	3.0	T15	J00.895.000.030	J00.895.002.015		J00.254.009.000
Type D34.039.051.009						
① J00.434.006.040		3			J00.892.000.030	
② J00.254.040.009	3.0	T15	J00.895.000.030	J00.895.002.015		J00.254.009.000
Type D34.050.067.012						
① J00.434.006.052		3			J00.892.000.030	
② J00.254.050.010	5.0	T20	J00.895.000.050	J00.895.002.020		J00.254.012.000
Type D34.064.087.012						
① J00.434.006.068		3			J00.892.000.030	
② J00.254.050.010	5.0	T20	J00.895.000.050	J00.895.002.020		J00.254.012.000
Type D34.090.115.012						
① J00.434.006.090		3			J00.892.000.030	
② J00.254.050.010	5.0	T20	J00.895.000.050	J00.895.002.020		J00.254.012.000

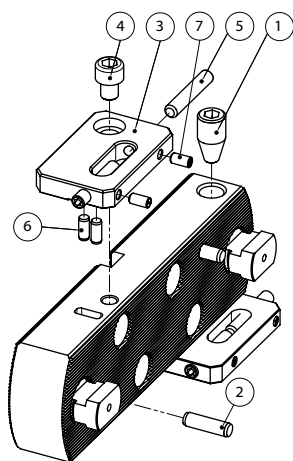


Ersatzteile / Zubehör

Spare parts / Accessories

E04/E14/E34/E44/E54




Type E04/E14/E34/E44/E54	max. Nm	S	Torque key 	Bit 	Service key 
① J00.514.016.016					
② J00.515.006.015	8	5			J00.892.000.050
③ J00.516.012.025	60	10			J00.892.000.100
④ J00.500.028.015					
⑤ J00.500.005.025	5	4			J00.892.000.040



Ersatzteile / Zubehör

Spare parts / Accessories




E60/E62/E64

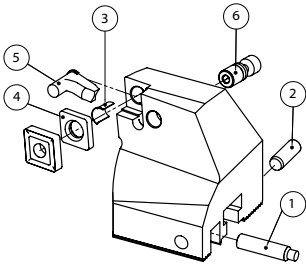
Type E60/E64	max. Nm	S / Torx	Torque key 	Bit 	Service key 
① J00.560.016.030	50.0	8			J00.892.000.080
② J00.560.008.028					
⑦ J00.560.006.012					
Type E60.130.130/230.030					
③ J00.560.080.012					
④ J00.560.110.012	35.0	8			J00.892.000.080
⑤ J00.560.008.045		4			J00.892.000.040
⑥ J00.560.006.014					
Type E64.000.xxx.048 E60.130.180/280-580. xxx					
③ J00.560.080.012					
④ J00.560.110.018	35.0	8			J00.892.000.080
⑤ J00.560.008.045		4			J00.892.000.040
⑥ J00.560.006.014					

Ersatzteile / Zubehör

Spare parts / Accessories

E70/E80




Type E70/E80	max. Nm	S / Torx	Torque key 	Bit 	Service key 
① J00.570.008.035		4			J00.892.000.040
② J00.570.008.024					
Type E70.070.012.075					
③ J00.416.012.000					
④ J00.417.012.000					
⑤ J00.418.012.000					
⑥ J00.419.012.000		3			J00.892.000.030
Type E70/E80.070.012.075					
③ J00.416.019.000					
④ J00.417.019.000					
⑤ J00.418.019.000					
⑥ J00.419.019.000		3			J00.892.000.030

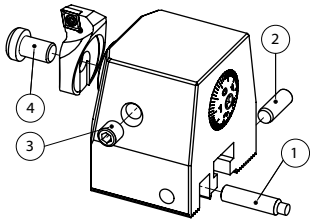


Ersatzteile / Zubehör

Spare parts / Accessories

E90/E91/E94





Type E90/E91.070.030.075	max. Nm	S / Torx	Torque key 	Bit 	Service key 
① J00.570.008.035		4			J00.892.000.040
② J00.570.008.024					
③ J00.590.010.020	8	5	J00.895.000.057	J00.895.001.050	J00.892.000.050
④ J00.314.010.016	35.0	8			J00.892.000.080
Type E94.070.065.072					
① J00.570.008.035		4			J00.892.000.040
② J00.570.008.024					

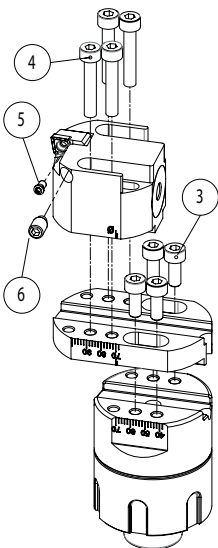


Ersatzteile / Zubehör

Spare parts / Accessories

E98

Type E98.040.070.009	max. Nm	S / Torx	Torque key 	Bit 	Service key 	Service key 
③ J00.726.004.010	4.5	3	J00.895.000.042	J00.895.001.030	J00.892.000.030	
④ J00.726.004.025	4.5	3	J00.895.000.042	J00.895.001.030	J00.892.000.030	
⑤ J00.254.025.006	0.9	T7	J00.895.000.009	J00.895.002.007		J00.254.007.000
⑥ J00.598.005.008	1.2	2.5	J00.895.000.010	J00.895.001.025	J00.892.000.025	





Torque key	Nm
J00.895.000.006	0.6
J00.895.000.009	0.9
J00.895.000.010	1.0
J00.895.000.012	1.2
J00.895.000.018	1.8
J00.895.000.022	2.2
J00.895.000.030	3.0
J00.895.000.038	3.8
J00.895.000.042	4.2
J00.895.000.050	5.0
J00.895.000.057	5.7



Service key set	S
J00.892.015.080	1.5 - 8
J00.892.015.100	1.5-10



Service key	S
J00.892.000.015	1.5
J00.892.000.020	2
J00.892.000.025	2.5
J00.892.000.030	3
J00.892.000.040	4
J00.892.000.050	5
J00.892.000.060	6
J00.892.000.080	8
J00.892.000.100	10
J00.892.000.120	12
J00.892.000.140	14



Torx bit	Tx
J00.895.002.005	5
J00.895.002.006	6
J00.895.002.007	7
J00.895.002.008	8
J00.895.002.009	9
J00.895.002.010	10
J00.895.002.015	15
J00.895.002.020	20



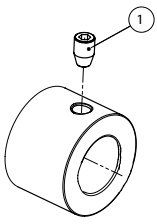
Hexagon bit	S
J00.895.001.015	1.5
J00.895.001.020	2
J00.895.001.025	2.5
J00.895.001.030	3
J00.895.001.040	4
J00.895.001.050	5
J00.895.001.060	6
J00.895.001.080	8



Torx key	Tx
J00.254.006.000	6
J00.254.007.000	7
J00.254.009.000	15
J00.254.012.000	20

Dimensionen

Dimensions

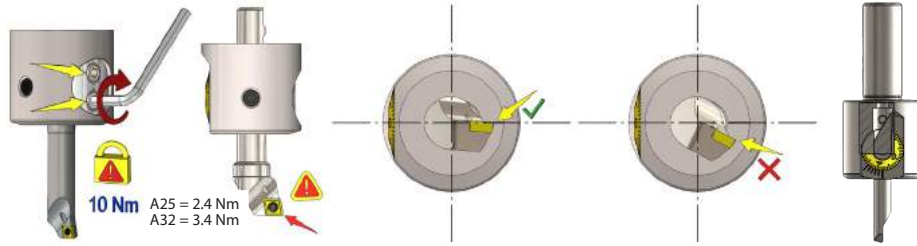


WH	Klemmschraube / Clamping screw ①	D	d1	L	M	Anzugsdrehmoment / Torque	Hex size
WH1	J00.100.005.008	20	11	13	M5x0.5	3.5Nm	2.5
WH2	J00.100.008.008	25	14	18	M8x1	12Nm	4
WH3	J00.100.008.010	32	18	22	M8x1	12Nm	4
WH4	J00.100.010.015	40	22	28	M10x1	22Nm	5
WH5	J00.100.012.017	50	28	28	M12x1	25Nm	6
WH6	J00.100.016.021	63	36	40	M16x1.5	30Nm	8
WH8	J00.100.016.029	80	36	40	M16x1.5	30Nm	8

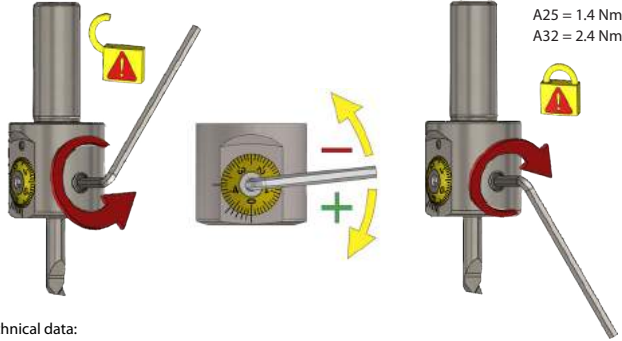
INSTRUCTION MANUAL
Ø 0.3 - 19.1 mm



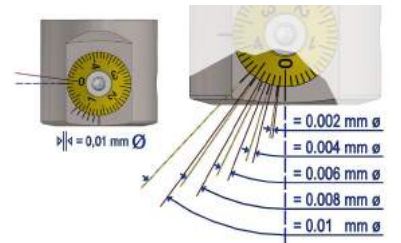
assembling boring bar



diameter adjustment



scale / vernier



Technical data:

Boring range: A25 Ø 0.3 - 7.1 mm
 A32 Ø 0.3 - 19.1 mm

Tool holder bore: A25 Ø 4.0 mm
 A32 Ø 7.0 mm

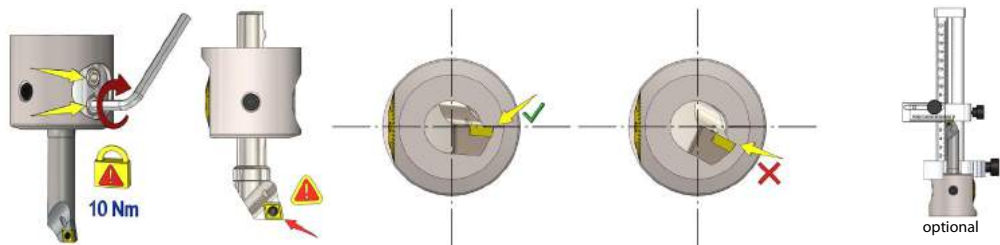
Max. Spindle speed: 30.000 rpm

Adjustment range: A25 -0.1 / + 3.0 mm Ø
 A32 -0.1 / + 5.0 mm Ø

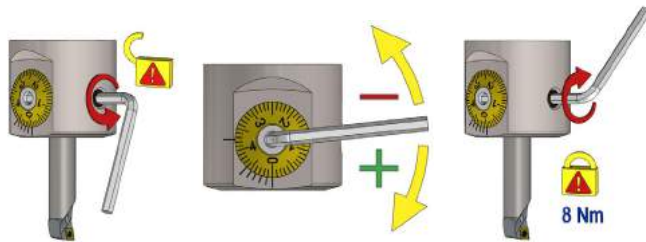
INSTRUCTION MANUAL
Ø 3.0 - 88.1 mm



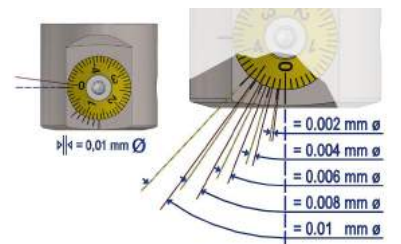
assembling boring bar



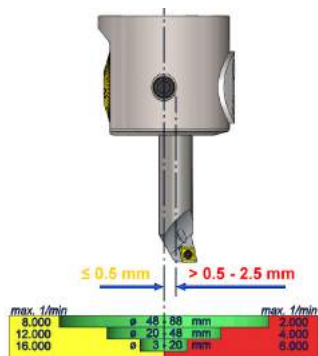
diameter adjustment



scale / vernier



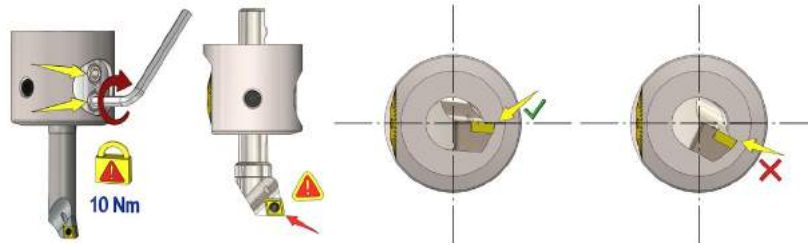
Max. revolution



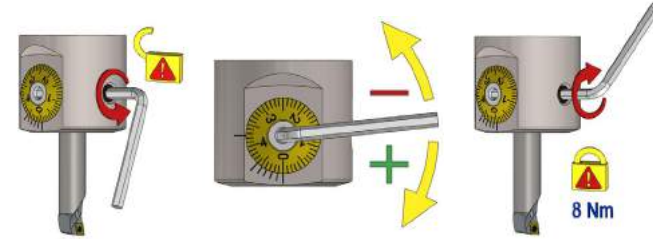
INSTRUCTION MANUAL
Multi-Head Ø 3-320 mm



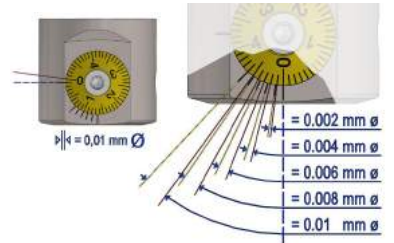
assembling boring bar



diameter adjustment



scale / vernier



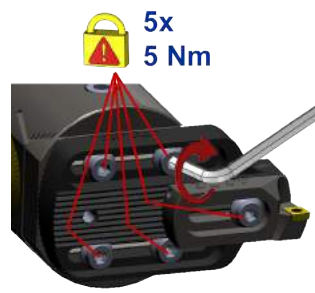
optional

Max. revolution

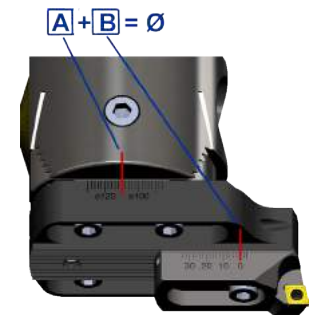
max. 1/min	≤ 0.5 mm	> 0.5 - 2.5 mm	max. 1/min
8.000	48.98 mm	2.000	4.000
12.000	20.148 mm	4.000	8.000
16.000	3.20 mm	8.000	16.000

Vmax 450 m/min (Ø88.0 - 164.0)
Vmax 250 m/min (Ø164.0 - 320.0)

assembling Ø86-320mm



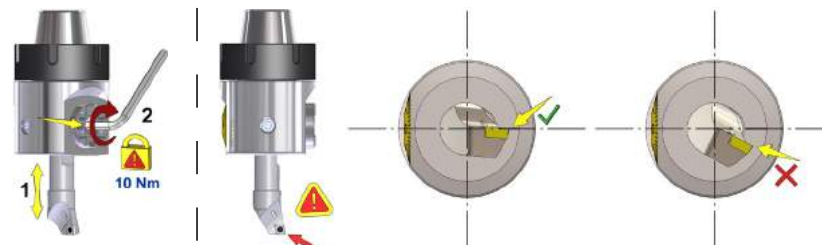
presetting scale



INSTRUCTION MANUAL
VARIO HEAD Ø 3 - 152 mm



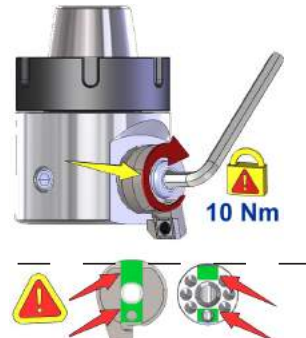
assembling boring bar



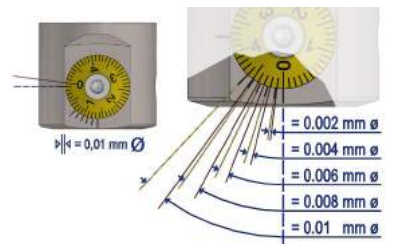
assembling coolant plug



assembling insertholder

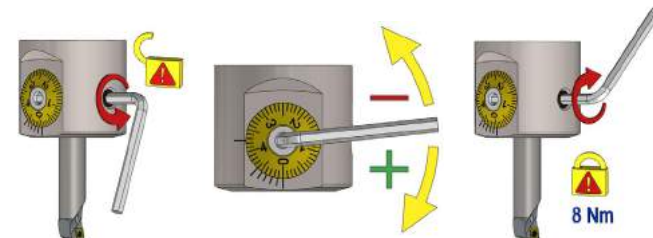


scale / vernier

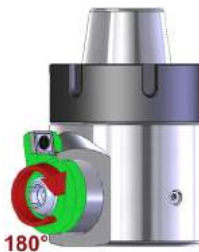


optional

diameter adjustment

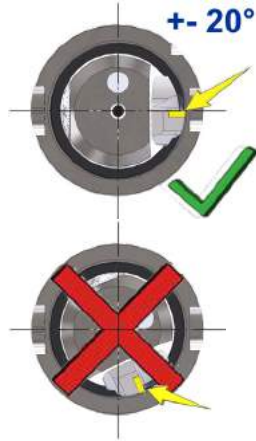


back boring

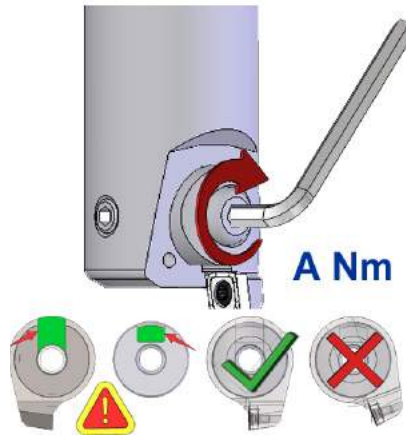


FINE BORING HEAD
Ø 24 - 171 mm

assembling boring head



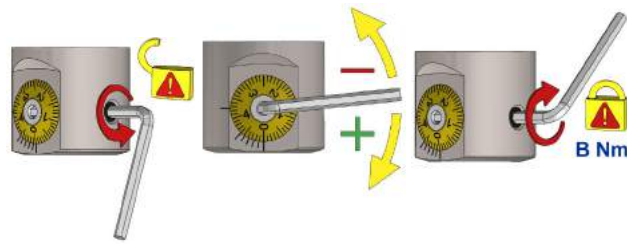
assembling insertholder



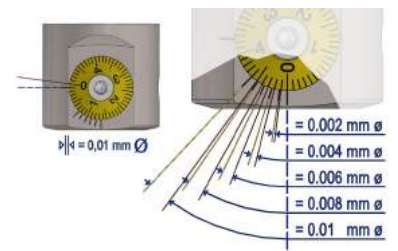
back boring (requires a reversal adapter)



diameter adjustment



scale / vernier

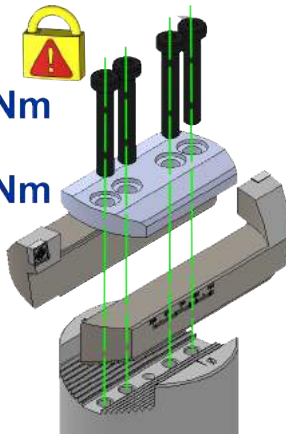


Fine boring head	Nm A	Nm B	max. rpm balanced	max. rpm unbalanced
D20 / Ø 24-31	2.4	1.2	12,000	9,000
D25 / Ø 31-40	3.4	1.4	10,000	7,500
D32 / Ø 40-51	5.0	2.4	8,000	5,250
D42 / Ø 51-67	10	4.0	6,500	4,000
D55 / Ø 67-87	20	8	5,000	3,000
D72 / Ø 87-116	20	8	4,000	2,500
D94 / Ø 116 - 171	20	8	3,000	1,750

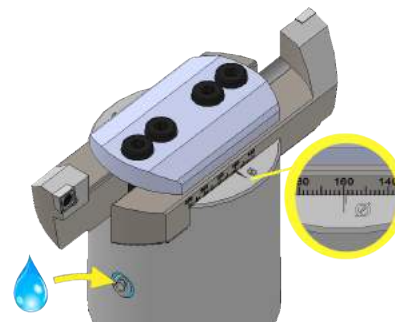
INSTRUCTION MANUAL
Fine + Rough boring head
Ø 86 - 402 mm

assembling

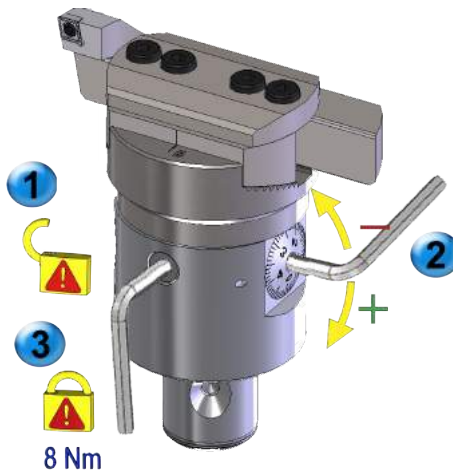
Ø86 - 138
2x 25Nm
 < Ø136
4x 25Nm



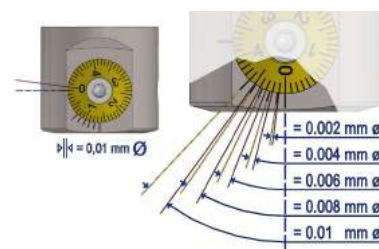
pre adjustment / coolant



adjustment fine boring

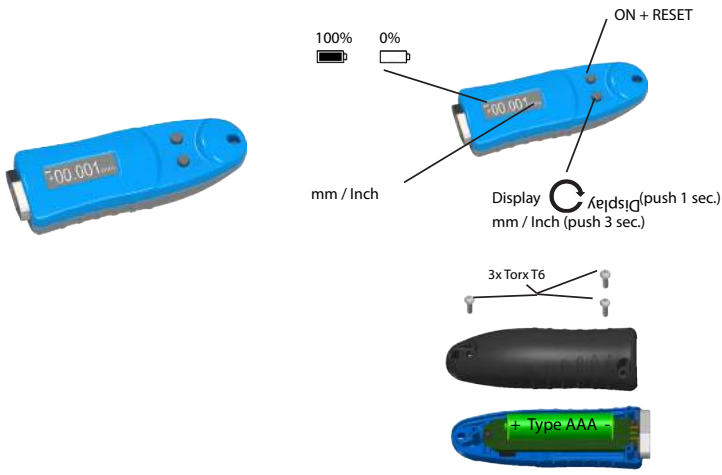


scale / vernier

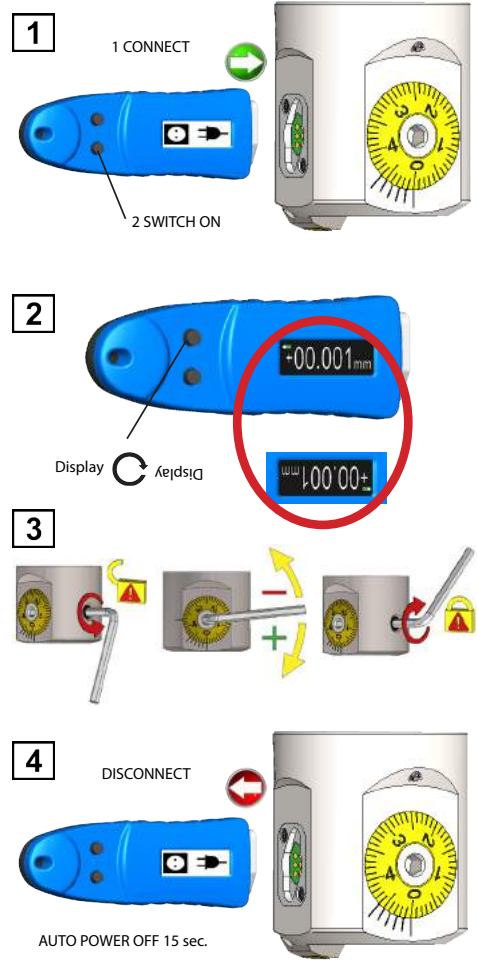


Digital display unit

Function / maintenance



Handling



assembling boring bar



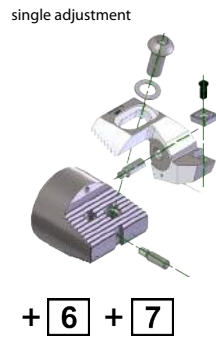
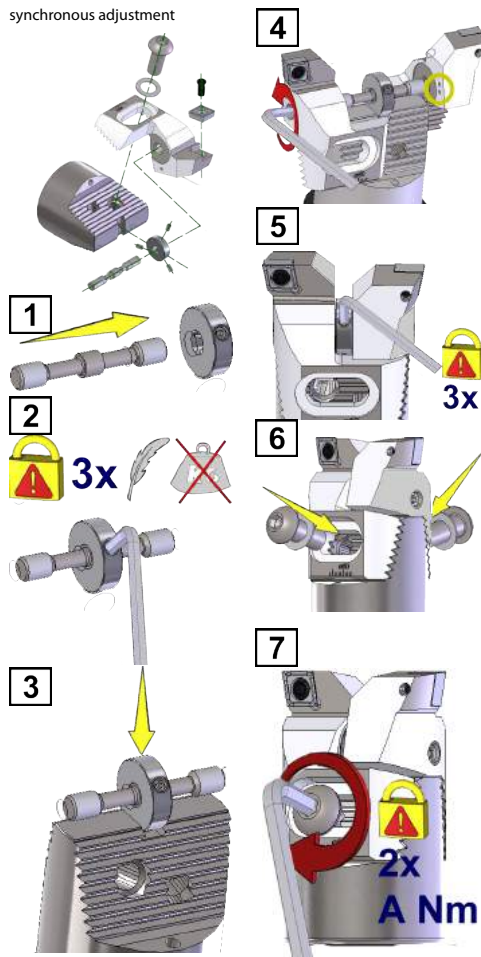
ø A min.	ø A max.	D	L	L1	Wendeplatte / Insert	M	SW	Nm
8.75	14.1	8	56	91	CC...06 02..	5	7	6
9.75	15.1	9	63	98	CC...06 02..	5	8	6
10.75	16.1	10	70	105	CC...06 02..	6	8	9
11.75	17.1	11	77	112	CC...06 02..	6	9	9
12.75	18.1	12	84	119	CC...06 02..	6	10	9
13.75	19.1	13	91	126	CC...06 02..	6	11	9
14.75	20.1	14	98	133	CC...06 02..	6	12	9
15.75	21.1	14	98	133	CC...06 02..	6	12	9
16.75	22.1	16	112	147	CC...06 02..	10	14	20
17.75	23.1	16	112	147	CC...06 02..	10	14	20
19.75	25.1	16	112	147	CC...06 02..	10	14	20
21.75	27.1	16	112	147	CC...06 02..	10	14	20
24.75	30.1	16	112	147	CC...06 02..	10	14	20
27.75	33.1	16	112	147	CC...06 02..	10	14	20
31.75	37.1	16	112	147	CC...06 02..	10	14	20
34.75	40.1	16	112	147	CC...06 02..	10	14	20

ROUGH BORING HEAD
Ø 23 - 153 mm

assembling insertholder
synchronous adjustment

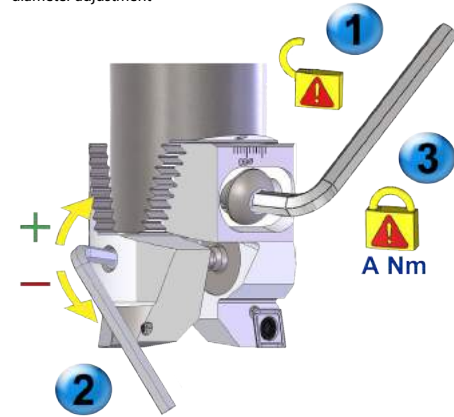
single adjustment

torque / revolution



Rough boring head	Nm A	max. rpm
D20 / Ø 23-31	2.4	12.000
D25 / Ø 31-40	5	10.000
D32 / Ø 40-51	9	8.000
D42 / Ø 51-67	20	6.500
D55 / Ø 67-87	35	5.000
D72 / Ø 87-116	35	4.000
D94 / Ø 116 - 153	35	3.000

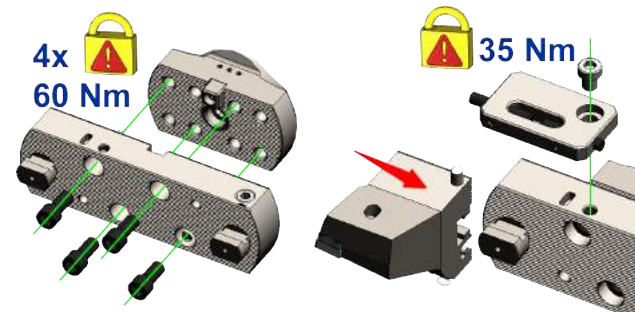
diameter adjustment



INSTRUCTION MANUAL
BRIDGE TOOLS Ø 150 - 655 mm

assembling

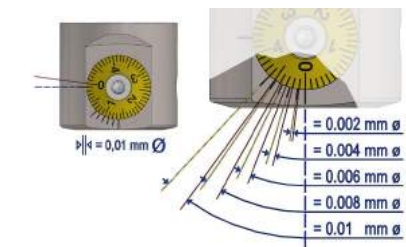
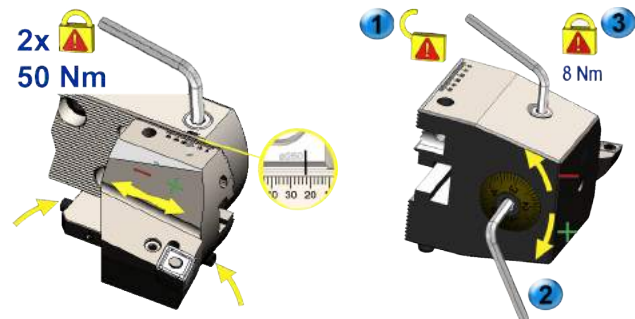
revolution



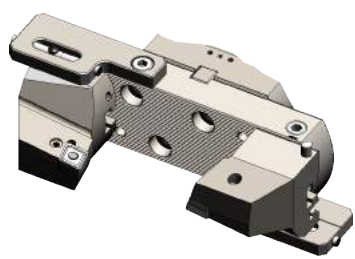
diameter	max. rpm
Ø150-205	1.250
Ø200-255	1.000
Ø250-305	850
Ø300-355	700
Ø350-405	600
Ø400-455	530
Ø450-505	480
Ø500-555	440
Ø550-605	400
Ø600-655	360

pre adjustment

scale / vernier



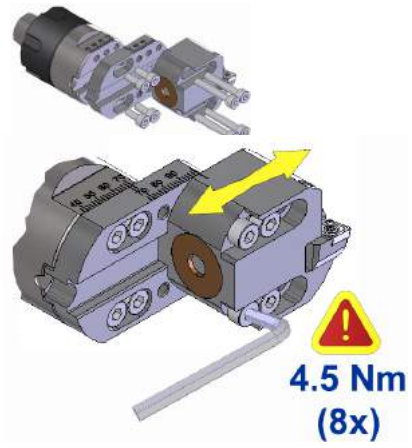
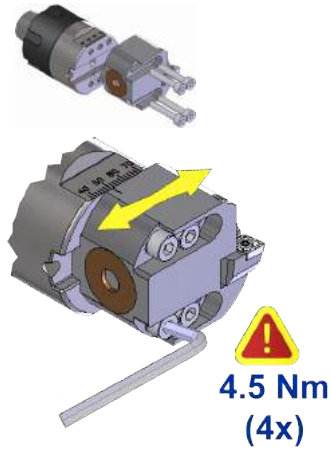
pin turning



INSTRUCTION MANUAL
ECO HEAD Ø 39.9 - 100.1 mm

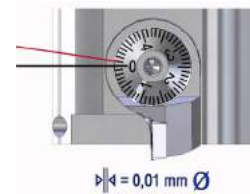
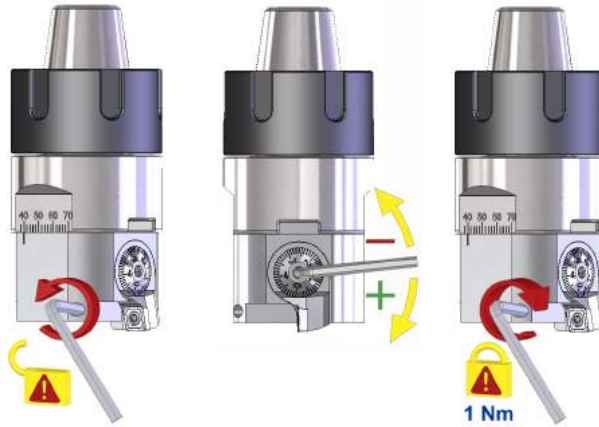
assembling rough adjustment Ø 39.9 - 70.1mm

assembling rough adjustment Ø 69.9 - 100.1mm



diameter fine adjustment

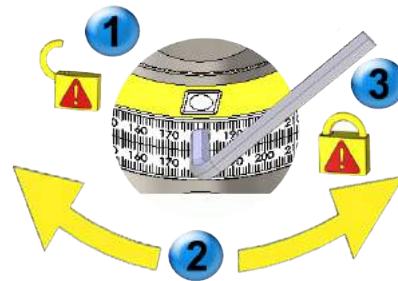
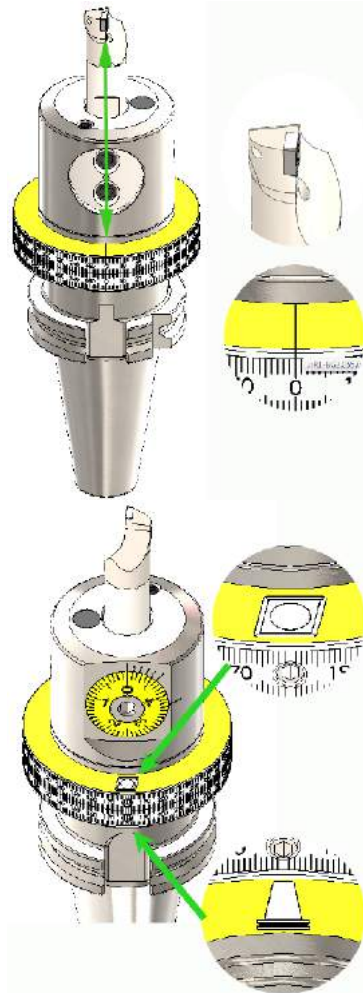
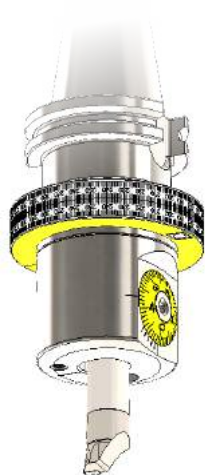
scale / vernier



maximum spindle speed

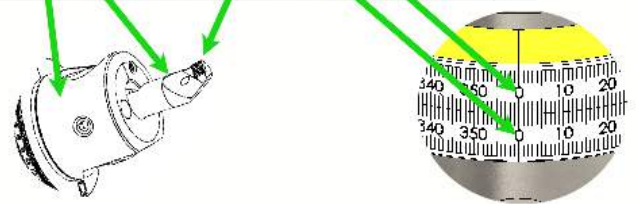
$V_{max} = 450 \text{ m/min } (\varnothing 40-70)$
 $V_{max} = 250 \text{ m/min } (\varnothing 70-100)$

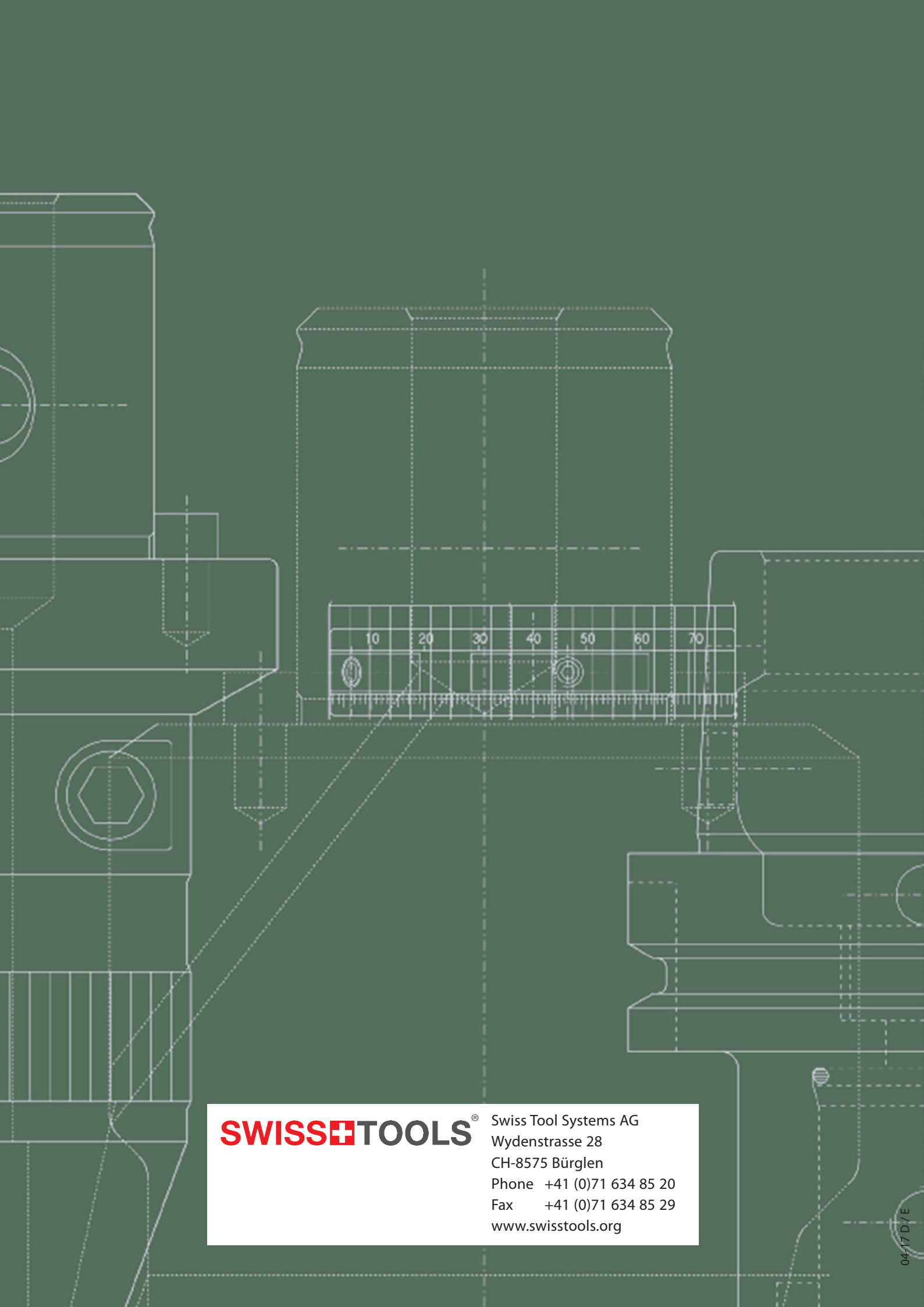
Balancing ring



Auswuchttabelle / balancing chart

Ausdrehkopf / fine boring head		Einstellwert am Auswuchtring / presetting value on the balancing ring											
Bestellnummer / order number													
262.550.045													
Ausdrehstahl / boring bar													
Bestellnummer / order number		\varnothing	\varnothing	\varnothing	\varnothing	\varnothing	\varnothing	\varnothing	\varnothing	\varnothing	\varnothing	\varnothing	\varnothing
272.010.006		10	103	284	11	81	290	12	84	291	13		
272.012.006		12	104	295	13	81	291	14	84	292	15		
272.014.006		14	104	295	15	81	291	16	83	292	17		
272.015.008		15	105	297	16	82	292	17	83	293	18		
272.016.006		16	107	299	17	82	293	18	83	294	19		
272.018.006		18	108	301	19	83	294	20	83	295	21		





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