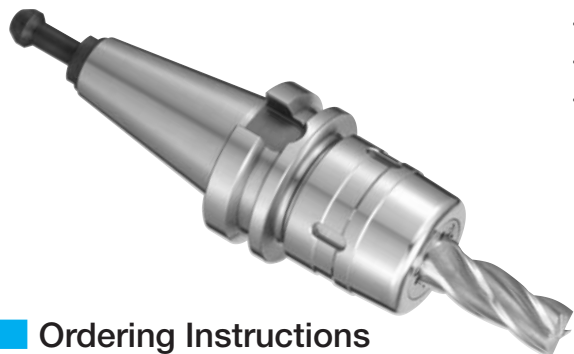
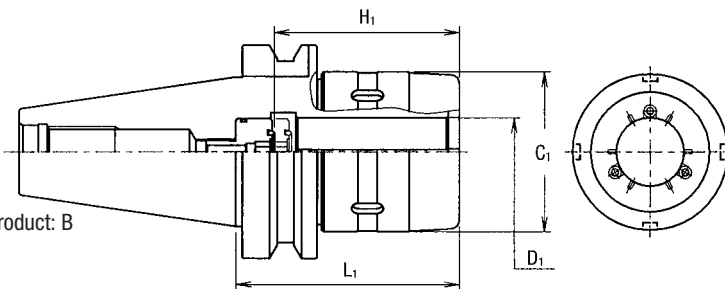


Milling Chuck for High Spindle Speeds Milling Chuck "MILL ACE"/MLA

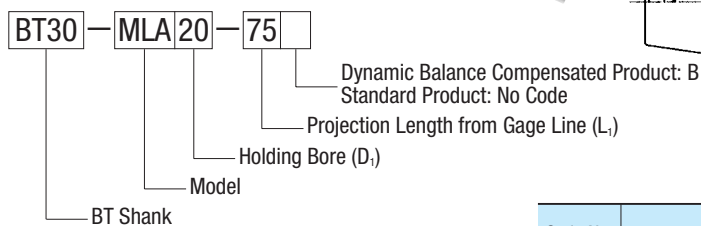


- Applicable to high spindle speeds.
- Applicable to high pressure coolant supply.
- High accuracy, high rigidity, high holding power.

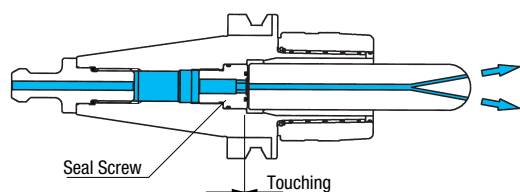
Center-through



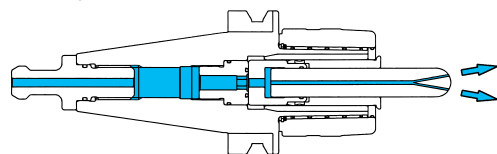
Ordering Instructions



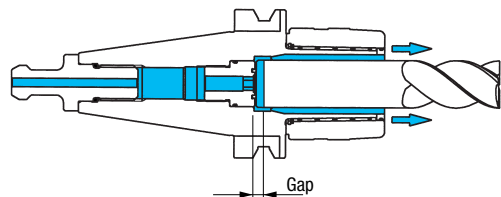
● Tool with Oil Holes



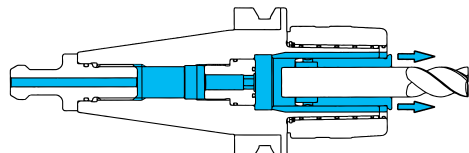
● Straight Collet/CSM + Tool with Oil Holes



● Tool without Oil Holes

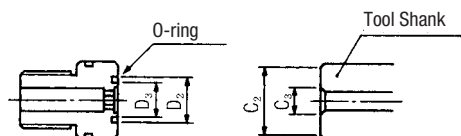


● Straight Collet/CSR + Tool without Oil Holes



CAUTION

- For tools with oil holes, the oil hole diameter (C_3) should be smaller than the seal screw O-ring bore (D_3), and the tool shank chamfered diameter (C_2) should be larger than the O-ring outside diameter (D_2).
- In the same way, for the two-hole specification, use tools that are smaller than the O-ring bore (D_3).



(Unit: mm)

Code No. 394	Model No.	D_1	L_1	C_1	H_1	Weight (kg)	Allowable Spindle Speed (min^{-1})	
							Standard Product	Dynamic Balance Compensated Product
993561	BT30-MLA16-70	16	70	44	55~47	0.9	20,000	40,000
993341	-MLA20-75	20	75	52	66~58	1.2	20,000	30,000
993562	BT40-MLA16-75	16	75	44	55~47	1.5	20,000	30,000
993342	MLA20-80	20	80	52	66~58	1.8	20,000	30,000
993563	-105		105			2.2	20,000	30,000
993343	-MLA25-80		80			2.0	20,000	25,000
993564	-105	25	105	62	71~63	2.6	20,000	25,000
993565	-135		135			3.3	15,000	20,000
993344	MLA32-105	32	105	75	87~79	3.1	15,000	20,000
993566	-135		135			3.9	15,000	20,000
993345	BT50-MLA20-105		105			4.6	15,000	20,000
993346	-135	20	135	52	66~58	5.0	15,000	20,000
993347	-165		165			5.4	12,000	15,000
993348	MLA25-105		105			4.6	15,000	20,000
993349	-135	25	135	62	71~63	5.2	15,000	20,000
993350	-165		165			5.9	12,000	15,000
993351	MLA32-105		105			5.5	15,000	20,000
993352	-135	32	135	75	87~79	6.4	15,000	20,000
993353	-165		165			7.4	12,000	15,000
993354	MLA42-105	42	105	93	99~95	6.2	12,000	15,000
993355	-135		135			7.7	12,000	15,000

- A seal screw is incorporated in the body.
- Spanners are not included, and should be ordered separately.
- The allowable spindle speed is greatly affected by the machine rigidity.

When using at high spindle speeds, increase the speed gradually from a low rotation speed to select the appropriate rotation speed.

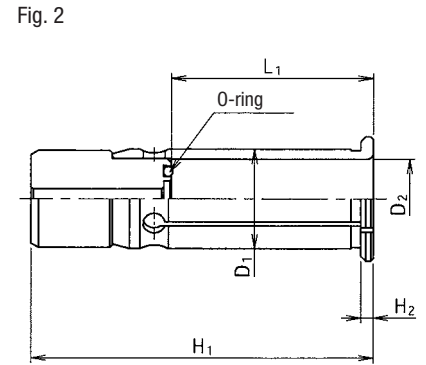
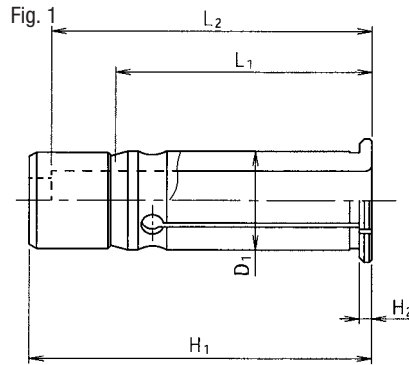
(Unit: mm)

Model	D_2	D_3	O-ring	
			Circumference	Side Face
MLA-16	13.5	8.5	JASO 1012	P10
MLA-20	16	11	JASO 1016	P11
MLA-25			S22	
MLA-32	20	15	S28	P15
MLA-42			S38	

Accessories for “MILL ACE”

Coolant Fed Straight Collet/CSM

• This is a collet for holding straight shank tools in coolant applications.



(Unit: mm)

Ordering Instructions

CSM20-6

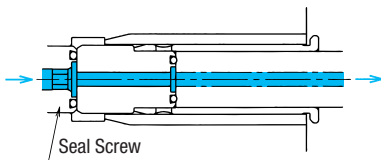
Collet Bore (D₂)
Collet External Diameter (D₁)
Model

Usage Method

Before mounting the straight collet, screw the MILLACE seal screw fully into the body.

• Tool-through Applications

When using tool that have oil holes, contact the end face of collet to the seal screw inside the MILL ACE body.



When using tools without oil holes, use the Straight Collet/CSR.

Code No. 395	Model No.	Fig.	D ₁	D ₂	H ₁	H ₂	L ₁	L ₂							
993356	CSM20- 6	1	20	6	69.5	2.5	42	—							
993357	- 8														
993358	-10														
993359	-12														
993378	-16	2	25	16	75.5	3	52	65							
993360	CSM25- 6	1		6			91.5	3	42	—					
993361	- 8														
993362	-10														
993363	-12														
993364	-16	2		16			104	3.5	52	—					
993379	-20														
993365	CSM32- 6			1							6	103.5	3	60	85
993366	- 8														
993367	-10														
993368	-12														
993369	-16														
993370	-20														
993380	-25	2	25	42	103.5	3	51.5	—							
993371	CSM42- 6	1	6				103.5	3	60	85					
993372	- 8														
993373	-10														
993374	-12														
993375	-16														
993376	-20														
993377	-25														
993381	-32		2	32	42	103.5					3	66	—		
993371	CSM42- 6	1	6	103.5			3	60	85						
993372	- 8														
993373	-10														
993374	-12														
993375	-16														
993376	-20														
993377	-25														
993381	-32		2		32	42				103.5	3	66	—		

• For applications in which coolant is being applied, insert the tool shank to the depth L₁.

Hook Spanner/FS



For details, see page 28.

Code No. 213	Model No.	Applicable Chuck
—	FS-45	MLA16
865420	FS-55	MLA20
865421	FS-62	MLA25
865422	FS-75	MLA32
865423	FS-92	MLA42