

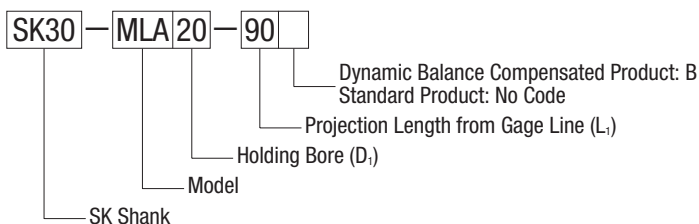
Milling Chuck for High Spindle Speeds Milling Chuck "MILL ACE"/MLA



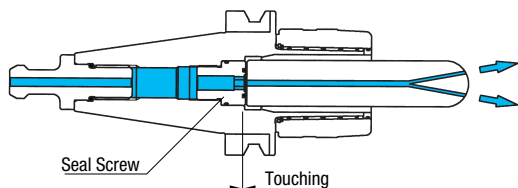
- Applicable high spindle speeds.
- Applicable to high pressure coolant supply.
- High accuracy, high rigidity, high holding power.

Center-through

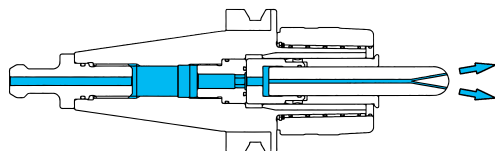
Ordering Instructions



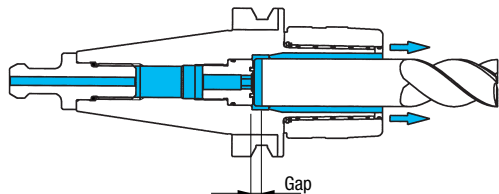
● Tool with Oil Holes



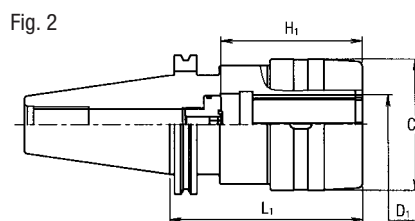
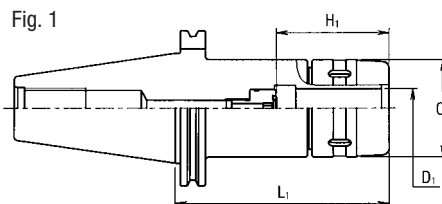
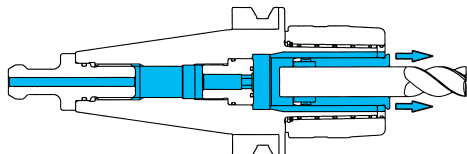
● Straight Collet/CSM + Tool with Oil Holes



● Tool without Oil Holes



● Straight Collet/CSR + Tool without Oil Holes



(Unit: mm)

Code No. 394	Model No.	Fig.	D ₁	L ₁	C ₁	H ₁	Weight (kg)	Allowable Spindle Speed (min ⁻¹)
	SK30-MLA16- 80	2	16	80	44	55~47	1.0	20000
	-MLA20- 90		20	90	52	66~58	1.4	20000
	SK40-MLA16- 80	2	16	80	44	55~47	1.6	20000
	-MLA20- 85		20	85	52	66~58	1.6	20000
	-105			105	52	66~58	1.8	
	-MLA25- 90		25	90	62	71~63	2.0	20000
	-105			105	62	71~63	2.3	
	-135			135	62	71~63	2.8	
	-MLA32-135	32	135	75	87~79	3.7	15000	
	SK50-MLA20-105	1	20	105	52	66~58	3.8	15000
	-135			135			4.3	
	-165			165			4.8	
	-MLA25-105		25	105	62	71~63	4.2	15000
	-135			135			5.0	
	-165			165			5.7	
	-MLA32-105		32	105	75	87~79	5.0	15000
	-135			135			6.0	
	-165			165			7.0	
	-MLA42-105		2	42	105	93	99~95	7.0
	-135	135			8.3			

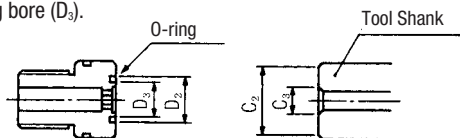
- A seal screw is incorporated in the body.
- Spanners are not included, and should be ordered separately.
- The allowable spindle speed is greatly affected by the machine rigidity.

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

CAUTION

- For tools with oil holes, the oil hole diameter (C₃) should be smaller than the seal screw O-ring bore (D₃), and the tool shank chamfered diameter (C₂) should be larger than the O-ring outside diameter (D₂).

In the same way, for the two-hole specification, use tools that are smaller than the O-ring bore (D₃).



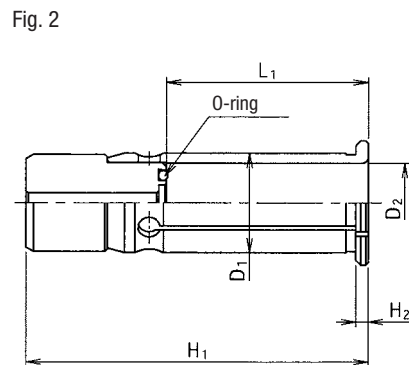
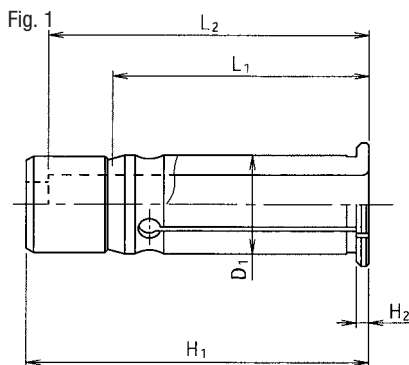
(Unit: mm)

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

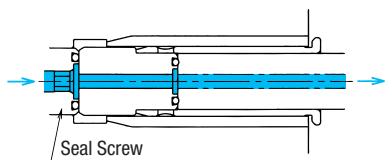
Collet Bore (D₂)
Collet External Diameter (D₁)
Model

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	41	65								
993360	CSM25- 6	1		6			91.5	3	42	—						
993361	- 8															
993362	-10															
993363	-12															
993364	-16	2		32			16	104	3.5	52	—					
993379	-20															
993365	CSM32- 6						1					6	91.5	3	42	—
993366	- 8															
993367	-10															
993368	-12															
993369	-16	2		42			16	103.5	3	60	85					
993370	-20															
993371	CSM42- 6		1		6	104	3.5					52	—			
993372	- 8															
993373	-10															
993374	-12															
993375	-16	2	32	16	103.5	3	60	85								
993376	-20															
993377	-25															
993380	-25															
993381	-32	2	32	25	104	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 190.

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