

Accessories

Reduction Sleeves for ETP Toolholders

The reduction sleeves are designed to fit with the ETP Toolholders. They are specially suited for high precision clamping of cylindrical tool shanks per DIN 6335 form HA, HB and HE, as well as tool shanks per DIN 1835 form B, C, D and E.

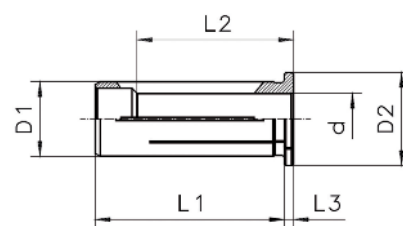
The special design of the reduction sleeves allows an efficient use of coolant through cutting tools.

Benefits and features

- High runout accuracy < 3 µm.
- Clamping of different tool shank diameters. 4 standard sizes: 12, 20, 25, and 32 mm.
- Metal-to-metal seal for cutting tools with internal coolant channels.
- When using reduction sleeves the transmittable torque is increased.

Outer-Ø of reduction sleeve corresponds to the type.

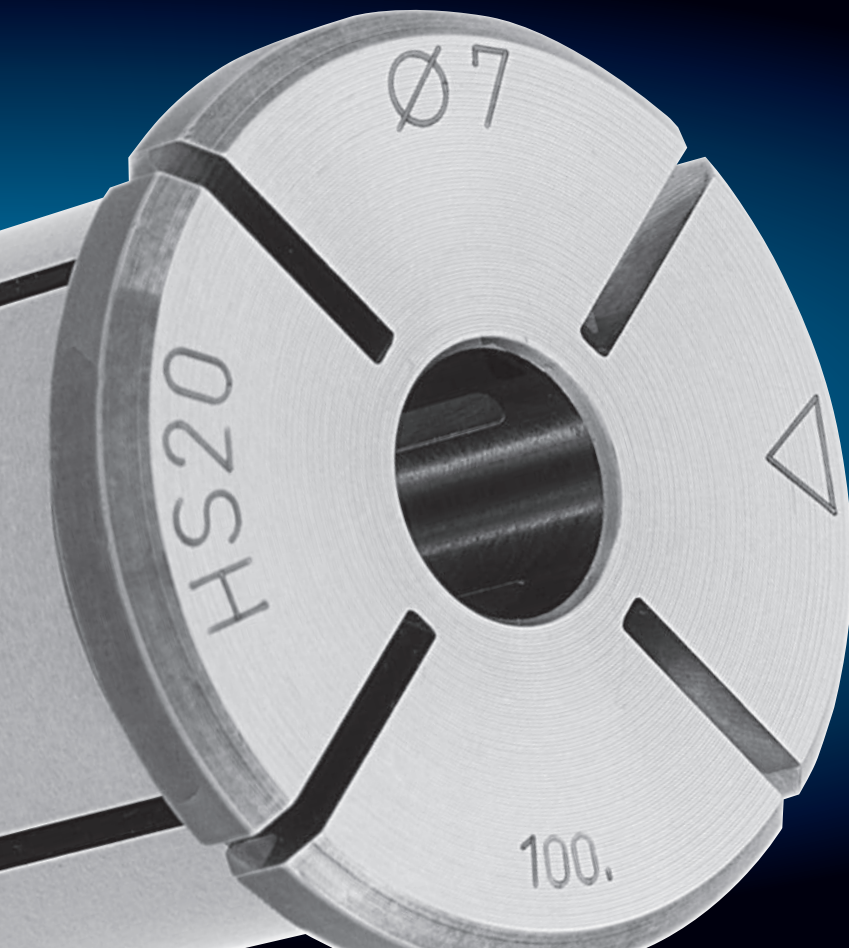
HS12 = Ø 12 mm
HS20 = Ø 20 mm
HS25 = Ø 25 mm
HS32 = Ø 32 mm



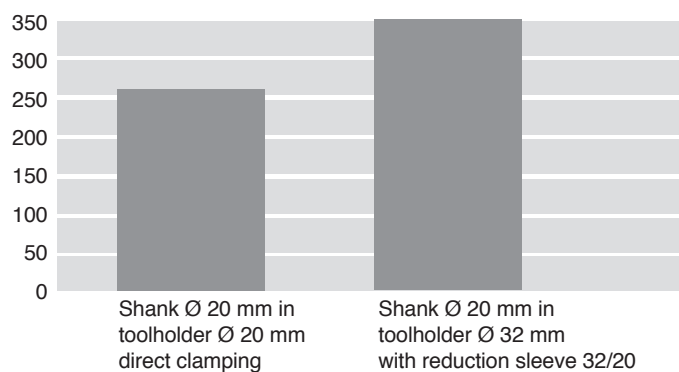
Reduction Sleeves HS 12 • HS 20 • HS 25 • HS 32

Item description	d [mm]	Part no.	D1 [mm]	D2 [mm]	L1 [mm]	L2 [mm]	L3 [mm]
HS 12 / Ø 3.00	3.000	R1912.03000	12	16	40	29	4
HS 12 / Ø 4.00	4.000	R1912.04000	12	16	40	29	4
HS 12 / Ø 5.00	5.000	R1912.05000	12	16	40	29	4
HS 12 / Ø 6.00	6.000	R1912.06000	12	16	40	36	4
HS 12 / Ø 8.00	8.000	R1912.08000	12	16	40	37	4
HS 20 / Ø 3.00	3.000	R1920.03000	20	25	50	28	4
HS 20 / Ø 4.00	4.000	R1920.04000	20	25	50	28	4
HS 20 / Ø 5.00	5.000	R1920.05000	20	25	50	28	4
HS 20 / Ø 6.00	6.000	R1920.06000	20	25	50	36	4
HS 20 / Ø 8.00	8.000	R1920.08000	20	25	50	37	4
HS 20 / Ø 10.00	10.000	R1920.10000	20	25	50	40	4
HS 20 / Ø 12.00	12.000	R1920.12000	20	25	50	45	4
HS 20 / Ø 14.00	14.000	R1920.14000	20	25	50	45	4
HS 25 / Ø 6.00	6.000	R1925.06000	25	30	56	37	4
HS 25 / Ø 8.00	8.000	R1925.08000	25	30	56	37	4
HS 25 / Ø 10.00	10.000	R1925.10000	25	30	56	40	4
HS 25 / Ø 12.00	12.000	R1925.12000	25	30	56	46	4
HS 25 / Ø 14.00	14.000	R1925.14000	25	30	56	47	4
HS 25 / Ø 16.00	16.000	R1925.16000	25	30	56	48	4
HS 25 / Ø 20.00	20.000	R1925.20000	25	30	56	50	4
HS 32 / Ø 12.00	12.000	R1932.12000	32	36	60	45	4
HS 32 / Ø 16.00	16.000	R1932.16000	32	36	60	48	4
HS 32 / Ø 20.00	20.000	R1932.20000	32	36	60	50	4
HS 32 / Ø 25.00	25.000	R1932.25000	32	36	60	56	4

Additional sizes available on request



Comparison of Transmittable Torque at Ø 20 mm



HYDRO-GRIP Torque wrench

Use torque wrench to ensure correct tightening independent on user. Should be used with all HYDRO-GRIP® holders.

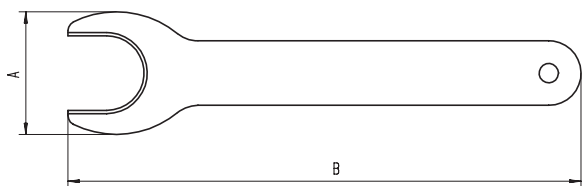
Torque: 6 Nm: HYDRO-GRIP, HYDRO-GRIP PENCIL, ECOGRIP.

Torque: 10 Nm: HYDRO-GRIP HD.



Extractor

Item description	Part No.	For Sizes	A	B
			[mm]	[mm]
EHS 12 - 1/2"	E7321.12000	HS 12	24.6	100
EHS 20 - 3/4"	E7321.20000	HS 20	38.0	160
EHS 25 - 1"	E7321.25000	HS 25	51.0	180
EHS 32 - 1 1/4"	E7321.32000	HS 32	63.0	200



The extractor helps to remove the reduction sleeve from the toolholder.

- Improper assembly can damage the concentricity of the reduction sleeve.
- Insert tools the full length of the reduction sleeve.
- Only clamp h6 tool shanks.
- Do not clamp reduction sleeve without a tool. Reduction Sleeve will be damaged.

