

CoroChuck® 930

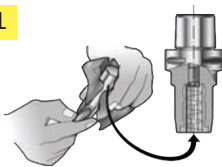


SANDVIK
Coromant

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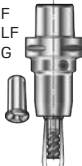
Handling

1



Clean shaft and bore

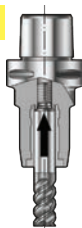
393.CF
393.CLF
393.CG



393. CGS



2



3



NOTICE

For best performance, the actuating screw must always reach the mechanical stop. Apply a torque of 8 Nm for P, S, and T types, and 10 Nm for HD. If the screw does not reach the stop at the recommended torque, check the torque wrench and the screw for possible issues.

Torque wrench

Ordering code: 5680 099-01

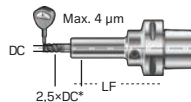
				
Bore Ø mm	Cylindrical	Weldon	Whistle Notch	ISO 9766
With collet 	✓	✓	✓	✓
6, 8, 10	✓	✓	✗	✗
12, 20	✓	✓	✗	✗
25, 32	✓	✗	✗	✗

Technical specifications

Max run-out

P, S, T, HD

LF ≤ 125 mm (4.921 inch)



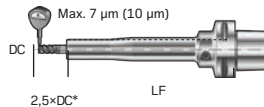
P, S

LF < 190 mm (7.480 inch)

max. run-out 7 µm

LF > 190 mm (7.480 inch)

max. run-out 10 µm



*) 2,5×DC and max 50 mm
(1.97 inch)

Learn more about
CoroChuck® 930
sandvik.coromant.com/corochuck930

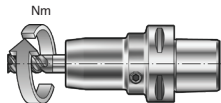


Rev 25.11

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Technical specifications

Min torque transmission *)



Bore Ø mm	P	S, T	HD
6	12 Nm	18 Nm	-
8	25 Nm	28 Nm	-
10	50 Nm	55 Nm	-
12	77 Nm	80 Nm	-
20	255 Nm	300 Nm	400 Nm
25	-	400 Nm	600 Nm
32	-	-	900 Nm

*) Tested with h6 shank with min tolerance

Temperature

Operating temperature:
20-70°C (60-170°F)

Optimal temperature:
max 50°C (120°F)

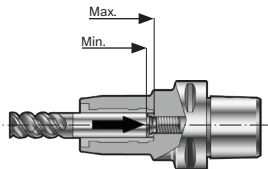
Clamping length min/max

Type	Bore Ø mm	Min. mm	Max. mm
P	6	27	37
P	8	27	37
P	10	31	41
P	12	36	46
P	20	41	51

Type	Bore Ø mm	Min. mm	Max. mm
S, T	6	27	37
S, T	8	27	37
S, T	10	31	41
S, T	12	36	46
S, HD, T	20	41	51
S, HD	25	47	57
HD	32	51	61

Balancing

Balancing according to
ISO 16084



The length adjustment screw allows for a 10 mm adjustment. To ensure best performance in heavy-duty and high-feed applications, use the maximum clamping length. This applies whether clamping the tool directly in the chuck or using a reduction collet. In the latter case, both the tool and the collet should be clamped to their full length.

Minimum torque transmission with reduction collet

P (Pencil)

		Bore with reduction collet Ø mm								
Bore Ø mm		4	6	8	10	12	16	18	20	
	6	6	12	-	-	-	-	-	-	
	12	10	17	28	44	77	-	-	-	
	20	30	34	60	65	95	135	195	255	

S (Slender), T

		Bore with reduction collet Ø mm							
Bore Ø mm		6	8	10	12	16	18	20	
	-	6	8	10	12	16	18	20	
	12	20	40	60	80	-	-	-	
	20	40	80	100	125	200	250	300	

HD (Heavy Duty)

		Bore with reduction collet Ø mm						
Bore Ø mm		12	16	18	20	25	32	
	-	12	16	18	20	25	32	
	20	150	230	290	400	-	-	
	25	200	350	420	530	600	-	
	32	240	320	350	400	540	900	

Test-Gauge

Use the Test-Gauge to verify the clamping functionality of the CoroChuck® 930

Type	Bore Ø mm	Base unit	Test Gauge Ordering code
P	6	Metric	930-GAU-06-1
S, T	6	Metric	930-GAU-06-2
P	8	Metric	930-GAU-08-1
S, T	8	Metric	930-GAU-08-2
P	10	Metric	930-GAU-10-1
S, T	10	Metric	930-GAU-10-2
P	12	Metric	930-GAU-12-1
S, T	12	Metric	930-GAU-12-2
P, HD	20	Metric	930-GAU-20-1
S, T	20	Metric	930-GAU-20-2
HD	25	Metric	930-GAU-25-1
S	25	Metric	930-GAU-25-2
HD	32	Metric	930-GAU-32-1

1

20°C-25°C
68°F-77°F

2

3

