# Stationary chuck

**3**

# GTO

## Stationary chuck

■ **For standard collets**
■ **Manual actuated**

### Application/customer benefits
• Highest clamping forces and stiffness for best machining quality
• Maximum economy due to quick change of collets and fast mounting
• High flexibility due to the use of standard collets
• Ideal for 5-axis machining due to the compact design
• Sensitive adjustment of the clamping force

### Technical features
• Manual actuated by fast clamping function (clamping wrench SW 12)
• Repeatability ≤ 0.01 mm
• Pull-down effect
• Workpiece stop optional
• Horizontal or vertical mounting
• Threads for mounting a front stop

### Standard equipment
Stationary chuck with clamping wrench
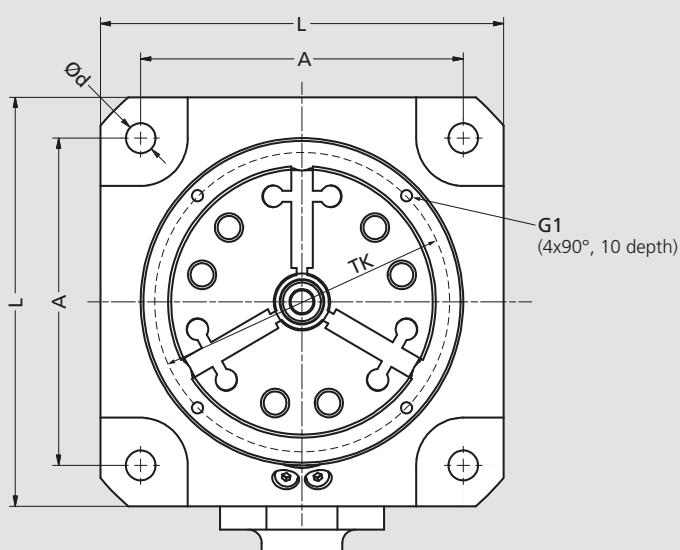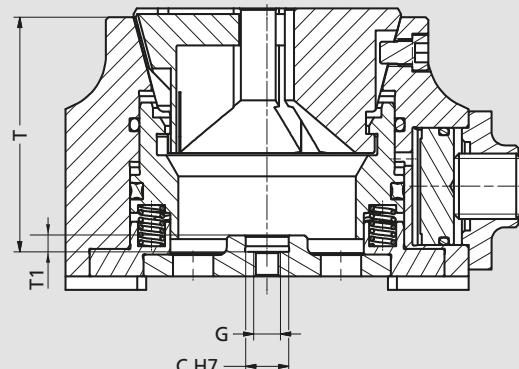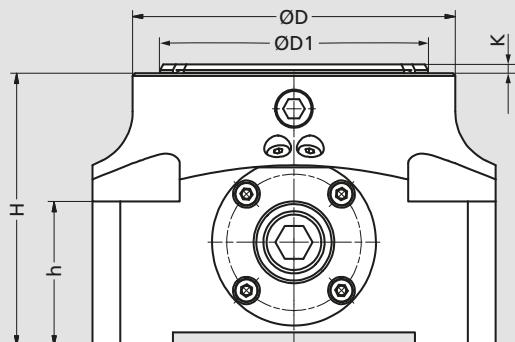


Subject to technical changes.

## Order review

| Type | Id.-No. | A | L | B | H | ØD | ØD1 | Ød | h | K | G | G1 | T | T1 | TK | ØC | Max. [kN] | Clamp. range [mm] | Weight [kg] |
|------|---------|---|---|---|---|----|----|----|----|----|----|----|----|----|----|----|----|----|----|
| GTO 42 | 462500 | 100 | 130 | 130 | 100 | 100 | 81 | 11 | 53 | 5.5 | M8 | M5 | 87 | 7 | 90 | 12 | 80 | 4 - 42 | 7.9 |
| GTO 65 | 462501 | 120 | 150 | 150 | 100 | 120 | 101.2 | 11 | 53 | 6 | M10 | M5 | 86 | 6 | 110 | 16 | 105 | 4 - 65 | 9.6 |
| GTO 100 | 462502 | 170 | 200 | 200 | 110 | 165 | 146 | 13 | 60 | 4 | M12 | M5 | 95 | 10 | 155 | 20 | 150 | 40 - 100 | 17.5 |

D1 = Diameter of the collet (unclamped)
Max. kN = Maximum total clamping force

Pneumatic actuated version on request.

# Collets for GTO 42

## Steel collets with axial and radial grooves  ($\triangle$ smooth, $\triangle\triangle$ radial grooves)
## ROUND*

| Ø | 4$\triangle$ | 5$\triangle$ | 6$\triangle$ | 7$\triangle$ | 8$\triangle\triangle$ | 9$\triangle\triangle$ | 10$\triangle\triangle$ | 11 | 12 | 13 | 14 | 15 | 16 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Id. No. | 192173 | 192174 | 192175 | 192176 | 192177 | 192178 | 192179 | 192180 | 192181 | 192182 | 192183 | 192184 | 192185 |
| Ø | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 |
| Id. No. | 192186 | 192187 | 192188 | 192189 | 192190 | 192191 | 192192 | 192193 | 192194 | 192195 | 192196 | 192197 | 192198 |
| Ø | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 | 41 | 42 |
| Id. No. | 192199 | 192200 | 192201 | 192202 | 192203 | 192204 | 192205 | 192206 | 192207 | 192208 | 192209 | 192210 | 192211 |

Collets in 0.5 mm increments on request

## Steel collets with smooth clamping surface
## ROUND*

| Ø | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Id. No. | 192173 | 192174 | 192175 | 192176 | 193135 | 193136 | 193137 | 193138 | 193139 | 193140 | 193141 | 193142 | 193143 |
| Ø | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 |
| Id. No. | 193144 | 192807 | 193145 | 192808 | 193146 | 193147 | 193148 | 193149 | 193150 | 193151 | 193152 | 193153 | 193154 |
| Ø | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 | 41 | 42 |
| Id. No. | 193155 | 193156 | 193083 | 193157 | 193158 | 193159 | 193160 | 193161 | 193162 | 193163 | 193164 | 193165 | 193219 |

Collets in 0.5 mm increments on request

## SQUARE**

| □ | 7$\triangle$ | 8$\triangle\triangle$ | 9$\triangle\triangle$ | 10$\triangle\triangle$ | 11$\triangle\triangle$ | 12$\triangle\triangle$ | 13$\triangle\triangle$ | 14$\triangle\triangle$ | 15$\triangle\triangle$ | 16$\triangle\triangle$ | 17$\triangle\triangle$ | 18$\triangle\triangle$ | 19$\triangle\triangle$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Id. No. | 192212 | 192213 | 192214 | 192215 | 192216 | 192217 | 192218 | 192219 | 192220 | 192221 | 192222 | 192223 | 192224 |
| □ | 20$\triangle\triangle$ | 21$\triangle\triangle$ | 22$\triangle\triangle$ | 23$\triangle\triangle$ | 24$\triangle\triangle$ | 25$\triangle\triangle$ | 26$\triangle\triangle$ | 27$\triangle\triangle$ | 28$\triangle\triangle$ | 29$\triangle\triangle$ | 30$\triangle\triangle$ | | |
| Id. No. | 192225 | 192226 | 192227 | 192228 | 192229 | 192230 | 192231 | 192232 | 192233 | 192234 | 192235 | | |

## HEXAGONAL**

| ⬡ | 7$\triangle$ | 8$\triangle\triangle$ | 9$\triangle\triangle$ | 10$\triangle\triangle$ | 11$\triangle\triangle$ | 12$\triangle\triangle$ | 13$\triangle\triangle$ | 14$\triangle\triangle$ | 15$\triangle\triangle$ | 16$\triangle\triangle$ | 17$\triangle\triangle$ | 18$\triangle\triangle$ | 19$\triangle\triangle$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Id. No. | 192236 | 192237 | 192238 | 192239 | 192240 | 192241 | 192242 | 192243 | 192244 | 192245 | 192246 | 192247 | 192248 |
| ⬡ | 20$\triangle\triangle$ | 21$\triangle\triangle$ | 22$\triangle\triangle$ | 23$\triangle\triangle$ | 24$\triangle\triangle$ | 25$\triangle\triangle$ | 26$\triangle\triangle$ | 27$\triangle\triangle$ | 28$\triangle\triangle$ | 29$\triangle\triangle$ | 30$\triangle\triangle$ | 31$\triangle\triangle$ | 32$\triangle\triangle$ |
| Id. No. | 192249 | 192250 | 192251 | 192252 | 192253 | 192254 | 192255 | 192256 | 192257 | 192258 | 192259 | 192260 | 192261 |

## Soft steel collets (pre-bored)
## ROUND

| Ø | 5 | 15 | 30 |
|---|---|---|---|
| Id. No. | 192262 | 192263 | 192264 |

## Boring ring 42 for soft steel collets

| Id. No. | 193399 |
|---|---|

\* Concentricity similar DIN 6343
\*\* Concentricity has to be agreed

# Collets for GTO 65

## Steel collets with axial and radial grooves (△ smooth, △△ radial grooves)
### ROUND*

| Ø | 5△ | 6△ | 7△ | 8△△ | 9△△ | 10△△ | 11 | 12 | 13 | 14 | 15 | 16 | 17 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Id. No. | 192265 | 192266 | 192267 | 192268 | 192269 | 192270 | 192271 | 192272 | 192273 | 192274 | 192275 | 192276 | 192277 |
| Ø | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 |
| Id. No. | 192278 | 192279 | 192280 | 192281 | 192282 | 192283 | 192284 | 192285 | 192286 | 192287 | 192288 | 192289 | 192290 |
| Ø | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 | 41 | 42 | 43 |
| Id. No. | 192291 | 192292 | 192293 | 192294 | 192295 | 192296 | 192297 | 192298 | 192299 | 192300 | 192301 | 192302 | 192303 |
| Ø | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 |
| Id. No. | 192304 | 192305 | 192306 | 192307 | 192308 | 192309 | 192310 | 192311 | 192312 | 192313 | 192314 | 192315 | 192316 |
| Ø | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | | | | |
| Id. No. | 192317 | 192318 | 192319 | 192320 | 192321 | 192322 | 192323 | 192324 | 192325 | | | | |

Collets in 0.5 mm increments on request

## Steel collets with smooth clamping surface
### ROUND*

| Ø | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Id. No. | 192265 | 192266 | 192267 | 193172 | 193173 | 192682 | 193174 | 192787 | 193175 | 193176 | 193177 | 193169 | 193178 |
| Ø | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 |
| Id. No. | 193179 | 193180 | 193181 | 193182 | 192683 | 193183 | 193170 | 193065 | 193184 | 193066 | 193068 | 193069 | 193070 |
| Ø | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 | 41 | 42 | 43 |
| Id. No. | 193185 | 192684 | 193186 | 193187 | 193188 | 193189 | 193190 | 193191 | 193192 | 192685 | 193193 | 193194 | 193171 |
| Ø | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 |
| Id. No. | 193196 | 193197 | 193198 | 193199 | 193200 | 193201 | 193202 | 193203 | 193204 | 193205 | 193206 | 193207 | 193208 |
| Ø | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | | | | |
| Id. No. | 193195 | 193209 | 193210 | 193211 | 193212 | 193213 | 193214 | 193215 | 193216 | | | | |

Collets in 0.5 mm increments on request

### SQUARE**

| □ | 8△△ | 9△△ | 10△△ | 11△△ | 12△△ | 13△△ | 14△△ | 15△△ | 16△△ | 17△△ | 18△△ | 19△△ | 20△△ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Id. No. | 192326 | 192327 | 192328 | 192329 | 192330 | 192331 | 192332 | 192333 | 192334 | 192335 | 192336 | 192337 | 192338 |
| □ | 21△△ | 22△△ | 23△△ | 24△△ | 25△△ | 26△△ | 27△△ | 28△△ | 29△△ | 30△△ | 31△△ | 32△△ | 33△△ |
| Id. No. | 192339 | 192340 | 192341 | 192342 | 192343 | 192344 | 192345 | 192346 | 192347 | 192348 | 192349 | 192350 | 192351 |
| □ | 34△△ | 35△△ | 36△△ | 37△△ | 38△△ | 39△△ | 40△△ | 41△△ | 42△△ | 43△△ | 44△△ | 45△△ | 46△△ |
| Id. No. | 192352 | 192353 | 192354 | 192355 | 192356 | 192357 | 192358 | 192359 | 192360 | 192361 | 192362 | 192363 | 192364 |

### HEXAGONAL**

| ⬡ | 10△△ | 11△△ | 12△△ | 13△△ | 14△△ | 15△△ | 16△△ | 17△△ | 18△△ | 19△△ | 20△△ | 21△△ | 22△△ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Id. No. | 192365 | 192366 | 192367 | 192368 | 192369 | 192370 | 192371 | 192372 | 192373 | 192374 | 192375 | 192376 | 192377 |
| ⬡ | 23△△ | 24△△ | 25△△ | 26△△ | 27△△ | 28△△ | 29△△ | 30△△ | 31△△ | 32△△ | 33△△ | 34△△ | 35△△ |
| Id. No. | 192378 | 192379 | 192380 | 192381 | 192382 | 192383 | 192384 | 192385 | 192386 | 192387 | 192388 | 192389 | 192390 |
| ⬡ | 36△△ | 37△△ | 38△△ | 39△△ | 40△△ | 41△△ | 42△△ | 43△△ | 44△△ | 45△△ | 46△△ | 47△△ | 48△△ |
| Id. No. | 192391 | 192392 | 192393 | 192394 | 192395 | 192396 | 192397 | 192398 | 192399 | 192400 | 192401 | 192402 | 192403 |
| ⬡ | 49△△ | 50△△ | | | | | | | | | | | |
| Id. No. | 192404 | 192405 | | | | | | | | | | | |

## Soft steel collets (pre-bored)
### ROUND

| Ø | 8 | 20 | 40 |
|---|---|---|---|
| Id. No. | 192406 | 192407 | 192408 |

## Boring ring 65 for soft steel collets

| Id. No. | 193400 |
|---|---|

\*   Concentricity similar DIN 6343
\*\* Concentricity has to be agreed

## Collets for GTO 100

**Steel collets with axial and radial grooves**
**ROUND***

| Ø | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Id. No. | 195081 | 195082 | 195083 | 195084 | 195085 | 195086 | 195087 | 195088 | 195089 | 195090 | 195091 | 195092 | 195093 |
| Ø | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 |
| Id. No. | 195094 | 195095 | 195096 | 195097 | 195098 | 195099 | 195100 | 195101 | 195102 | 195103 | 195104 | 195105 | 195106 |
| Ø | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| Id. No. | 195107 | 195108 | 195109 | 195110 | 195111 | 195112 | 195113 | 195114 | 195115 | 195116 | 195117 | 195118 | 195119 |
| Ø | 81 | 82 | 83 | 84 | 85 | 86 | 87 | 88 | 89 | 90 | 91 | 92 | 93 |
| Id. No. | 195120 | 195121 | 195122 | 195123 | 195124 | 195125 | 195126 | 195127 | 195128 | 195129 | 195130 | 195131 | 195132 |
| Ø | 94 | 95 | 96 | 97 | 98 | 99 | 100 | | | | | | |
| Id. No. | 195133 | 195134 | 195135 | 195136 | 195137 | 195138 | 194742 | | | | | | |

**Steel collets with smooth clamping surface**
**ROUND***

| Ø | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Id. No. | 195141 | 195142 | 195143 | 195144 | 195145 | 195146 | 195147 | 195148 | 195149 | 195150 | 195151 | 195152 | 195153 |
| Ø | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 |
| Id. No. | 195154 | 195155 | 195156 | 195157 | 195158 | 195159 | 195160 | 195161 | 195162 | 195163 | 195164 | 195165 | 195166 |
| Ø | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| Id. No. | 195167 | 195168 | 195169 | 195170 | 195171 | 195172 | 195173 | 195174 | 195175 | 195176 | 195177 | 195178 | 195179 |
| Ø | 81 | 82 | 83 | 84 | 85 | 86 | 87 | 88 | 89 | 90 | 91 | 92 | 93 |
| Id. No. | 195180 | 195181 | 195182 | 195183 | 195184 | 195185 | 195186 | 195187 | 195188 | 194743 | 195189 | 195190 | 195191 |
| Ø | 94 | 95 | 96 | 97 | 98 | 99 | 100 | | | | | | |
| Id. No. | 195192 | 195193 | 195194 | 195195 | 195196 | 195197 | 195198 | | | | | | |

* Concentricity similar DIN 6343

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# Changing device for GTO 42, 65, 100

**Changing device**



| Accessories \ Size | GTO 42 | GTO 65 | GTO 100 |
|---|---|---|---|
| Manual | 196842 | 196844 | - |
| Pneumatic | 192151 | 192153 | 194744 |