

# WOHLHAUPTER®

## **Torque** Couple de serrage

**Wohlhaupter GmbH Präzisionswerkzeuge**

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## Fixing screws for replaceable inserts

Vis pour fixation des plaquettes de coupe

Insert form Forme de plaquette	Countersunk screw Vis à tête conique Order No. No de cde.	Clamping jaws Elément de serrage	Clamping bolt Boulon de serrage	Key size Dimension de la clé	Torx size Dimension Torx	Torque Couple de serrage lbf/ft (Nm)
04	415977				T 15	2.21 (3.0)
05	415949				T 20	3.68 (5.0)
20	115535				T 7	0.66 (0.9)
39	115673				T15	2.21 3.0
47	315324	315323			T 6	0.44 (0.6)
89	115676				T 8	0.88 (1.2)
90	115531				T 8	0.88 (1.2)
91	115802				T 8	0.88 (1.2)
101	115676				T 8	0.88 (1.2)
103	< Ø 1.457" 115672				T 15	2.21 (3.0)
103	> Ø 1.417" 115673*				T 15	2.21 (3.0)
104	215149				T 20	3.68 (5.0)
105	215149				T 20	3.68 (5.0)
111	115531				T 8	0.88 (1.2)
112	< Ø 1.457" 115672				T 15	2.21 (3.0)
112	> Ø 1.417" 115673				T 15	2.21 (3.0)
113	215149				T 20	3.68 (5.0)
114	215149				T 20	3.68 (5.0)
161	115676				T 8	0.88 (1.2)
163	115673				T 15	2.21 (3.0)
211	215377				T 6	0.44 (0.6)
262	215987				T 8	0.88 (1.2)
264	115673				T 15	2.21 (3.0)
304	215392				T 20	3.68 (5.0)
325	315321	315320			0,5x3	0.22 (0.3)
394	215915				T 8	0.88 (1.2)
395	215985				T 8	0.88 (1.2)
396	415320				T 15	2.21 (3.0)
397	215149				T 20	3.68 (5.0)

\* use for all Combi-Line insert holders in Form 103

\* pour tous les porte plaquettes Combi-Line utilisez la forme 103

## Tool clamping precision boring tools

Blocage des outils d'alésage de très haute précision

Precision boring tool Outil d'alésage de très haute précision		Key size Dim. de la clé	Torque Couple de serrage
Imperial	Metric		lbf/ft (Nm)
263019**	236019**	s2.5	2.21 (3.0)
249001, 249002, 249003	248001, 248002, 248003	s2	1.10 (1.5)
320010	310010	s2	1.10 (1.5)
320020, 320001, 320003	310020, 310001, 310003	s2.5	1.47 (2.0)
320004, 320005, 320006, 320007, 320008, 320009	310004, 310005, 310006, 310007, 310008, 310009	s4	4.42 (6.0)
338037	337017	s4	4.42 (6.0)
365030	364030	s2,0	1.47 (2.0)
365031, 365032	364031, 364032	s2.5	1.84 (2.5)
365033**	364033**	s2.5	2.21 (3.0)
365034**	364034**	s3	2.95 (4.0)
365045**, 365046**, 365047**, 365048**, 365049**	364045**, 364046**, 364047**, 364048**, 364049**	s4	4.42 (6.0)
404003	401003	s2.5	1.10 (1.5)
404004, 404005	401004, 401005	s2.5	2.21 (3.0)
404006, 404007	401006, 401007	s3	2.95 (4.0)
404008, 404009	401008, 401009	s4	5.16 (7.0)
404010, 404011	401010, 401011	s4	7.37 (10.0)
420001	410001	s2	1.10 (1.5)
420002	410002	s2	1.47 (2.0)
451001	450001	s4	5.16 (7.0)
465003, 465033	464003, 464033	s2.5	1.84 (2.5)
465004, 465034	464004, 464034	s2.5	2.21 (3.0)
465005, 465035	464005, 464035	s3	2.95 (4.0)
465006, 465007, 465008, 465009, 465010	464006, 464007, 464008, 464009, 464010	s4	4.42 (6.0)
465036, 465037, 465038, 465039, 465040	464036, 464037, 464038, 464039, 464040		
504001, 504004, 504005, 504019	501001, 501004, 501005, 501019	s4	5.90 (8.0)
511001, 511005	510001, 510004, 510005	s3	2.95 (4.0)
511021,	510021, 510024	s4	4.42 (6.0)
538001**	537001**	s4	4.42 (6.0)
538051, 538052	537051, 537052	s4	3.68 (5.0)
565034	564034	s3	2.95 (4.0)
565045, 565046, 565047, 565048, 565049	564045, 564046, 564047, 564048, 564049	s4	4.42 (6.0)
563001, 563002	536001, 536002, 536052	s2.5	2.21 (3.0)

\*\* this tool is no longer part of our current product range

\*\* Cet outil ne fait plus partie de notre gamme de produits actuelle

## The Wohlhaupter MVS colour-coding system

Le code couleur Wohlhaupter MVS

MVS-connection Connexion MVS	Threaded taper pin tightening torque Tige filetage à embout conique couple de serrage
M 8	20 Nm
19,5 – 11	3,5 Nm
22 – 11	3,5 Nm
25 – 14	12 Nm
32 – 18	12 Nm
40 – 22	22 Nm
50 – 28	25 Nm
63 – 36	30 Nm
80 – 36	30 Nm
100 – 56	45 Nm
D 40	
D 60	