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## Spindle Specification



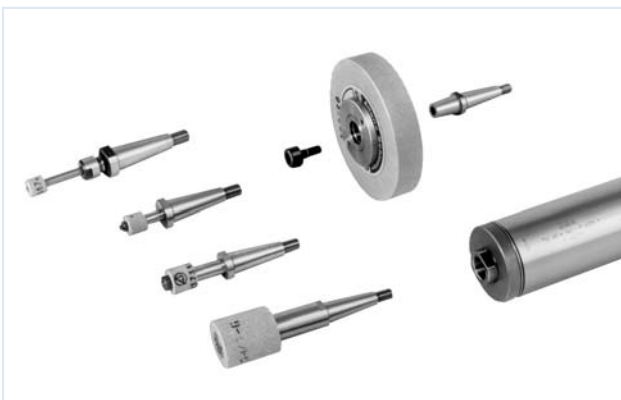
### TSA, TSA..c

external taper, belt driven

- ▶ duplex pair of GMN precision bearing
- ▶ TSA..c with [hybrid ceramic bearings](#)
- ▶ permanently grease lubricated
- ▶ spring preloaded design

Applications

- ▶ high speed grinding
- ▶ wide speed range
- ▶ small, medium and large bores



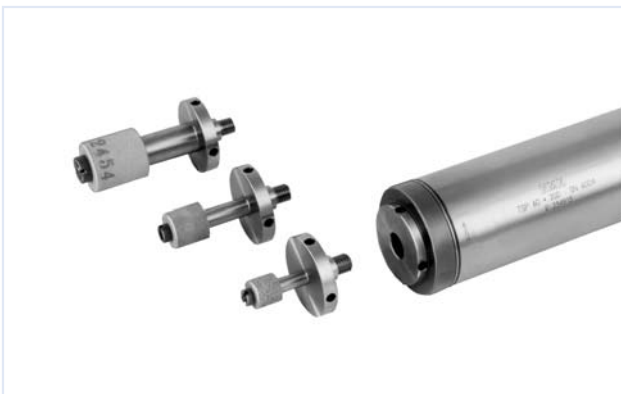
### TSI, TSI..c

internal taper, belt driven

- ▶ duplex pair of GMN precision bearing
- ▶ TSI..c with [hybrid ceramic bearings](#)
- ▶ permanently grease lubricated
- ▶ spring preloaded design

Applications

- ▶ high speed grinding
- ▶ wide speed range
- ▶ small, medium and large bores



### TSP, TSP..c

internal cylindrical pilot with draw thread and face clamping, belt driven

- ▶ duplex pair of GMN precision bearing
- ▶ TSP..c with [hybrid ceramic bearings](#)
- ▶ permanently grease lubricated
- ▶ spring preloaded design

Applications

- ▶ high speed grinding
- ▶ wide speed range
- ▶ small, medium and large bores



### TSAV

external taper, belt driven

- ▶ quad set of precision bearings at nose end
- ▶ solid preload design
- ▶ permanently grease lubricated

Applications

- ▶ large deep bores
- ▶ for high loads
- ▶ for high stiffness requirements

## Spindle Specification



### TSL

external taper and stepped spindle housing, for deep internal bore grinding, belt driven

- ▶ quad set of precision bearings at nose end
- ▶ solid preload design
- ▶ permanently grease lubricated

Applications

- ▶ medium and large, deep bores



### TSE, TSE..c

with air cooled motor

- ▶ tool interface: integrated collet nose, HSK or according to customer's requirements
- ▶ precision bearings
- ▶ permanent oil/air or grease lubrication
- ▶ TSE..c with **hybrid ceramic bearings**
- ▶ clamping on cylindrical housing
- ▶ frequency inverter compatible
- ▶ for low power requirements
- ▶ for light machining operations
- ▶ for high speed grinding



### TSEV

with air cooled motor

- ▶ external style grinding taper
- ▶ precision bearings, solid preloaded
- ▶ permanent grease lubrication
- ▶ clamping on cylindrical housing
- ▶ frequency converter compatible or direct AC voltage
- ▶ economical support equipment
- ▶ for heavy machining operations
- ▶ for high requirement stiffness



### TS, HLS

Opto spindles with ball bearings, static or dynamic air bearings

- ▶ speeds up to 160,000 rpm
- ▶ synchronous running values < 5 ppm

Please ask for catalog # 2509.

## Spindle Specification



### HS, HS-T, HSX, HV-X, HV-XS

High frequency spindle with integral asynchronous motor, liquid cooled front bearings and stator

- ▶ ultra precision ball bearings
- ▶ hybrid ceramic bearings
- ▶ oil/air lubricated
- ▶ for manual tool change via pilot with draw thread and clamping face

Please ask for catalog # 2508.

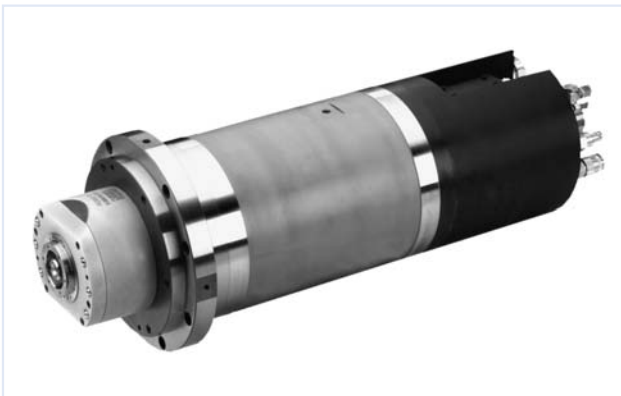


### HSP, HV-P

High frequency spindle with integral asynchronous motor, liquid cooled front bearings and stator

- ▶ ultra precision ball bearings
- ▶ hybrid ceramic bearings
- ▶ oil/air or permanently grease lubricated
- ▶ for manual tool change via HSK interface

Please ask for catalog # 2508.

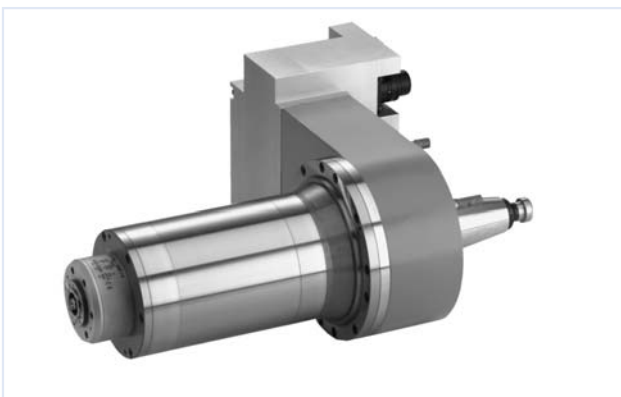


### HC, HCS

High frequency spindle for automatic tool change and asynchronous motor or synchronous motor for closed-loop drive (vectordrive), liquid cooled front bearings and stator

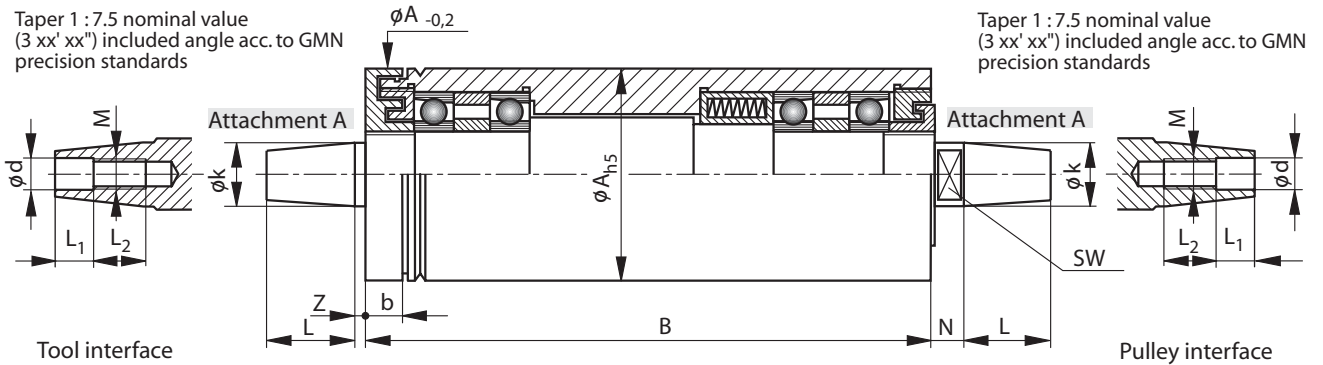
- ▶ ball bearings of ultra precision quality
- ▶ hybrid ceramic bearings
- ▶ oil/air or permanently grease lubricated
- ▶ ISO taper or HSK tool interface
- ▶ airblast for tool connection cleaning

Please ask for catalog # 2505.

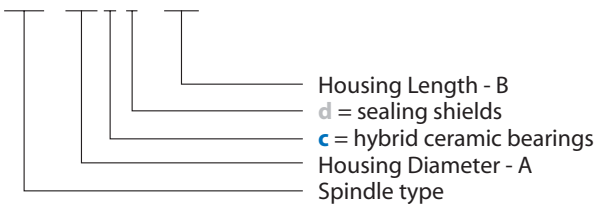


Special spindles per customer's requirements.

## TSA - Style



| Spindle Style <sup>1)</sup> | Attachment |       |    |      |                |                | Z   | b    | N  | SW | Max. Speed <sup>2)</sup><br>for bearing types<br>[rpm] |        |
|-----------------------------|------------|-------|----|------|----------------|----------------|-----|------|----|----|--|--------|
|                             | k          | L     | d  | M    | L <sub>1</sub> | L <sub>2</sub> |     |      |    |    | Steel  | Hybrid |
| <b>TSA 20 x 125</b>         | A 07       |       |    |      |                |                | 2   | 5    | 7  | 6  | 80000  | +      |
| TSA 20 x 160                | A 07       |       |    |      |                |                |     |      |    |    | 60000  | +      |
| TSA 20 x 200                | 7.5        | 10    | 4  | M 4  | 5              | 7              | 2   | 5    | 7  | 6  | 60000  | +      |
| TSA 20 x 250                |            |       |    |      |                |                |     |      |    |    | A 08   |        |
| <b>TSA 26 x 125</b>         | A 08       |       |    |      |                |                | 2   | 6.5  | 7  | 7  | 40000  | +      |
| TSA 26 x 160                | A 08       |       |    |      |                |                |     |      |    |    | 30000  | +      |
| TSA 26 x 200                | 8          | 11.25 | 4  | M 4  | 5              | 7              | 2   | 6.5  | 7  | 7  | 40000  | +      |
| TSA 26 x 250                |            |       |    |      |                |                |     |      |    |    | A 10   |        |
| TSA 26 x 315                | A 10       |       |    |      |                |                | 2.5 | 6    | 8  | 8  | 40000  | +      |
| <b>TSA 32 x 125</b>         | A 10       |       |    |      |                |                |     |      |    |    | 30000  | +      |
| <b>TSA 32 x 160</b>         | A 10       |       |    |      |                |                | 2.5 | 6    | 8  | 8  | 60000  | +      |
| TSA 32 x 200                | A 10       |       |    |      |                |                |     |      |    |    | 40000  | +      |
| TSA 32 x 250                | 10         | 15    | 5  | M 5  | 7              | 8              | 2.5 | 6    | 8  | 8  | 30000  | +      |
| TSA 32 x 315                |            |       |    |      |                |                |     |      |    |    | A 13   |        |
| TSA 32 x 355                | A 13       |       |    |      |                |                | 3   | 10.5 | 8  | 11 | 35000  | 42000  |
| <b>TSA 40 x 160</b>         | A 13       |       |    |      |                |                |     |      |    |    | 45000  | 55000  |
| <b>TSA 40 x 200</b>         | A 13       |       |    |      |                |                | 3   | 10.5 | 8  | 11 | 35000  | 42000  |
| TSA 40 x 250                | A 13       |       |    |      |                |                |     |      |    |    | 45000  | 55000  |
| <b>TSA 50 x 160</b>         | A 18       |       |    |      |                |                | 3   | 10.5 | 9  | 15 | 30000  | 35000  |
| <b>TSA 50 x 200</b>         | A 18       |       |    |      |                |                |     |      |    |    | 35000  | 42000  |
| TSA 50 x 250                | 13.5       | 20    | 6  | M 6  | 8              | 12             | 3   | 10.5 | 8  | 11 | 35000  | 42000  |
| <b>TSA 60 x 160</b>         |            |       |    |      |                |                |     |      |    |    | A 18   |        |
| <b>TSA 60 x 200</b>         | A 18       |       |    |      |                |                | 3   | 10.5 | 9  | 15 | 30000  | 35000  |
| TSA 60 x 250                | A 18       |       |    |      |                |                |     |      |    |    | 30000  | 35000  |
| TSA 60 x 315                | 18         | 25    | 8  | M 8  | 11             | 14             | 3   | 10.5 | 9  | 15 | 30000  | 35000  |
| <b>TSA 80 x 200</b>         |            |       |    |      |                |                |     |      |    |    | A 27   |        |
| TSA 80 x 250                | A 27       |       |    |      |                |                | 4   | 14.5 | 12 | 24 | 20000  | 25000  |
| TSA 80 x 315                | A 27       |       |    |      |                |                |     |      |    |    | 20000  | 25000  |
| TSA 100 x 250               | A 38       |       |    |      |                |                | 4   | 16   | 15 | 32 | 15000  | 20000  |
| TSA 100 x 315               | A 38       |       |    |      |                |                |     |      |    |    | 15000  | 20000  |
| TSA 100 x 355               | 38         | 52.5  | 16 | M 16 | 25             | 25             | 4   | 16   | 15 | 32 | 15000  | 20000  |



- 1) Preference types are in bold.  
 2) Without tool.

Depending on tool design and weight the maximum operating speed may be reduced.

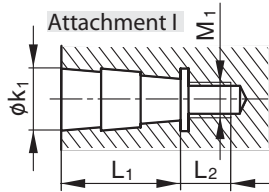
+ ... Ceramic balls on request.

1 mm = 0.03937 in.

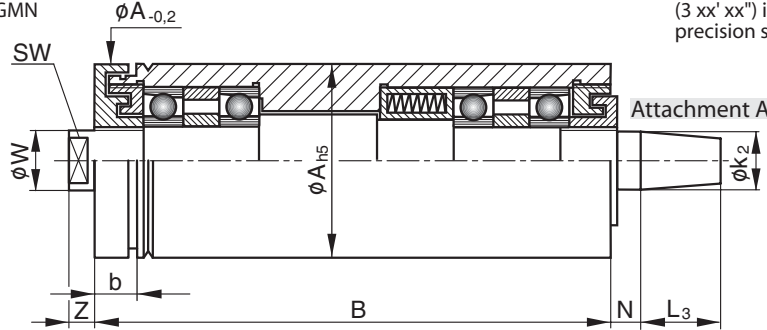
Please state direction of rotation.

## TSI - Style

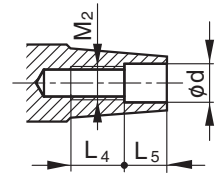
Taper 1 : 7.5 nominal value  
(3 xx' xx'') included angle acc. to GMN  
precision standards



Tool interface

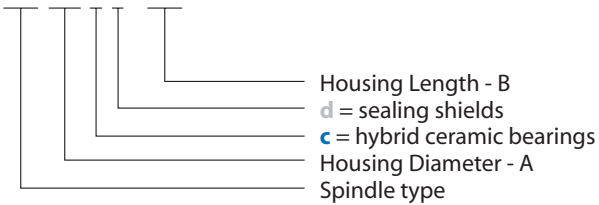


Taper 1 : 7.5 nominal value  
(3 xx' xx'') included angle acc. to GMN  
precision standards



Pulley interface

| Spindle Style <sup>1)</sup> | Attachment     |                |                |                | W    | Z  | SW | b    | N  | Attachment     |                |      |                |                | Max. speed <sup>2)</sup><br>for bearing types<br>[rpm] |       |        |
|-----------------------------|----------------|----------------|----------------|----------------|------|----|----|------|----|----------------|----------------|------|----------------|----------------|--|-------|--------|
|                             | k <sub>1</sub> | L <sub>1</sub> | L <sub>2</sub> | M <sub>1</sub> |      |    |    |      |    | k <sub>2</sub> | L <sub>3</sub> | d    | M <sub>2</sub> | L <sub>4</sub> | L <sub>5</sub>   | Steel | Hybrid |
| <b>TSI 40</b> ■ ■ x 160     |                |                | I 10           |                | 19   | 6  | 17 | 9.5  | 6  |                |                | A 10 |                |                |  | 45000 | 55000  |
| <b>TSI 40</b> ■ ■ x 200     | 10             | 26             | 16             | M 6            |      |    |    |      |    | 10             | 15             | 5    | M 5            | 8              | 7  |       |        |
| <b>TSI 40</b> ■ ■ x 250     |                |                |                |                |      |    |    |      |    |                |                |      |                |                |  |       |        |
| TSI 50 ■ ■ x 160            |                |                | I 14           |                | 22   | 6  | 19 | 10.5 | 7  |                |                | A 13 |                |                |  | 35000 | 42000  |
| <b>TSI 50</b> ■ ■ x 200     | 14             | 35             | 17             | M 8            |      |    |    |      |    | 13.5           | 20             | 6    | M 6            | 12             | 8  |       |        |
| <b>TSI 50</b> ■ ■ x 250     |                |                |                |                |      |    |    |      |    |                |                |      |                |                |  |       |        |
| TSI 60 ■ ■ x 160            |                |                | I 18           |                | 27   | 8  | 24 | 10.5 | 7  |                |                | A 18 |                |                |  | 30000 | 35000  |
| <b>TSI 60</b> ■ ■ x 200     |                |                |                |                |      |    |    |      |    |                |                |      |                |                |  |       |        |
| <b>TSI 60</b> ■ ■ x 250     | 18             | 45             | 19             | M 10           |      |    |    |      |    | 18             | 25             | 8    | M 8            | 14             | 11   |       |        |
| TSI 60 ■ ■ x 315            |                |                |                |                |      |    |    |      |    |                |                |      |                |                |  |       |        |
| TSI 60 ■ ■ x 355            |                |                |                |                |      |    |    |      |    |                |                |      |                |                |  |       |        |
| <b>TSI 80</b> ■ ■ x 200     |                |                | I 25           |                | 33.7 | 11 | 30 | 14.5 | 8  |                |                | A 27 |                |                |  | 20000 | 25000  |
| <b>TSI 80</b> ■ ■ x 250     | 25             | 63             | 25             | M 12           |      |    |    |      |    | 27.67          | 35             | 12   | M 12           | 21             | 13   |       |        |
| TSI 80 ■ ■ x 315            |                |                |                |                |      |    |    |      |    |                |                |      |                |                |  |       |        |
| TSI 80 ■ ■ x 355            |                |                |                |                |      |    |    |      |    |                |                |      |                |                |  |       |        |
| TSI 100 ■ ■ x 250           |                |                | I 32           |                | 43.7 | 13 | 41 | 16   | 12 |                |                | A 38 |                |                |  | 15000 | 20000  |
| TSI 100 ■ ■ x 315           | 32             | 80             | 34             | M 20           |      |    |    |      |    | 38             | 52.5           | 16   | M 16           | 25             | 25   |       |        |
| TSI 100 ■ ■ x 355           |                |                |                |                |      |    |    |      |    |                |                |      |                |                |  |       |        |



1) **Preference types** are in bold.

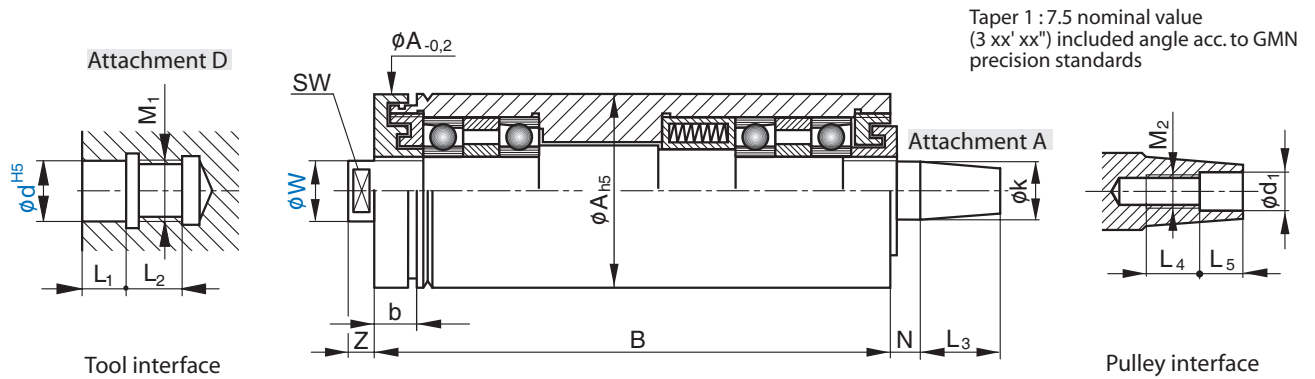
2) Without tool.

Depending on tool design and weight the maximum operating speed may be reduced .

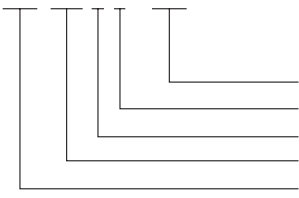
Please state direction of rotation.

1 mm = 0.03937 in.

## TSP - Style



| Spindle Style <sup>1)</sup> | Attachment D [d] / [W] | L <sub>1</sub> | L <sub>2</sub> | M <sub>1</sub> | b    | Z  | SW | N  | Attachment |                |                |                |                |                | Max. speed <sup>2)</sup> for bearing types [rpm] |        |
|-----------------------------|------------------------|----------------|----------------|----------------|------|----|----|----|------------|----------------|----------------|----------------|----------------|----------------|--|--------|
|                             |                        |                |                |                |      |    |    |    | k          | L <sub>3</sub> | d <sub>1</sub> | M <sub>2</sub> | L <sub>4</sub> | L <sub>5</sub> | Steel  | Hybrid |
| <b>TSP 40</b> ■ x 160       | D 08/14                | 12             | 14             | M 8            | 9.5  | 6  | 13 | 6  | A 10       |                |                |                |                |                | 45000  | 55000  |
| <b>TSP 40</b> ■ x 200       |                        |                |                |                |      |    |    |    | 10         | 15             | 5              | M 5            | 8              | 7              |  |        |
| <b>TSP 40</b> ■ x 250       |                        |                |                |                |      |    |    |    |            |                |                |                |                |                |  |        |
| <b>TSP 50</b> ■ x 160       | D 10/18                | 15             | 19             | M 10           | 10.5 | 8  | 15 | 7  | A 13       |                |                |                |                |                | 35000  | 42000  |
| <b>TSP 50</b> ■ x 200       |                        |                |                |                |      |    |    |    | 13.5       | 20             | 6              | M 6            | 12             | 8              |  |        |
| <b>TSP 50</b> ■ x 250       |                        |                |                |                |      |    |    |    |            |                |                |                |                |                |  |        |
| <b>TSP 60</b> ■ x 160       | D 14/23                | 20             | 19             | M 14 x 1.5     | 10.7 | 10 | 19 | 7  | A 18       |                |                |                |                |                | 30000  | 35000  |
| <b>TSP 60</b> ■ x 200       |                        |                |                |                |      |    |    |    | 18         | 25             | 8              | M 8            | 14             | 11             |  |        |
| <b>TSP 60</b> ■ x 315       |                        |                |                |                |      |    |    |    |            |                |                |                |                |                |  |        |
| <b>TSP 60</b> ■ x 355       |                        |                |                |                |      |    |    |    |            |                |                |                |                |                |  |        |
| <b>TSP 80</b> ■ x 200       | D 16/33                | 24             | 19             | M 16 x 1.5     | 14.5 | 11 | 27 | 8  | A 27       |                |                |                |                |                | 20000  | 25000  |
| <b>TSP 80</b> ■ x 250       |                        |                |                |                |      |    |    |    | 27.67      | 35             | 12             | M 12           | 21             | 13             |  |        |
| <b>TSP 80</b> ■ x 315       |                        |                |                |                |      |    |    |    |            |                |                |                |                |                |  |        |
| <b>TSP 80</b> ■ x 355       |                        |                |                |                |      |    |    |    |            |                |                |                |                |                |  |        |
| <b>TSP 100</b> ■ x 250      | D 28/43                | 42             | 25             | M 28 x 2       | 16   | 13 | 36 | 12 | A 38       |                |                |                |                |                | 15000  | 20000  |
| <b>TSP 100</b> ■ x 315      |                        |                |                |                |      |    |    |    | 38         | 52.5           | 16             | M 16           | 25             | 25             |  |        |
| <b>TSP 100</b> ■ x 355      |                        |                |                |                |      |    |    |    |            |                |                |                |                |                |  |        |



1) Preference types are in bold.

2) Without tool.

Depending on tool design and weight the maximum operating speed may be reduced.

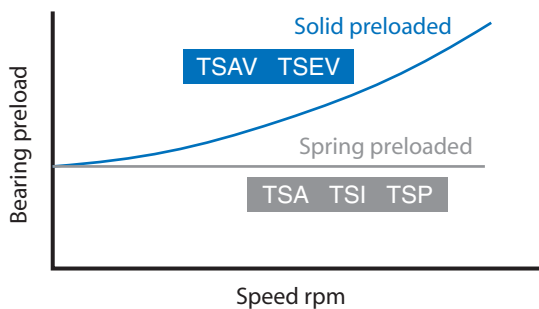
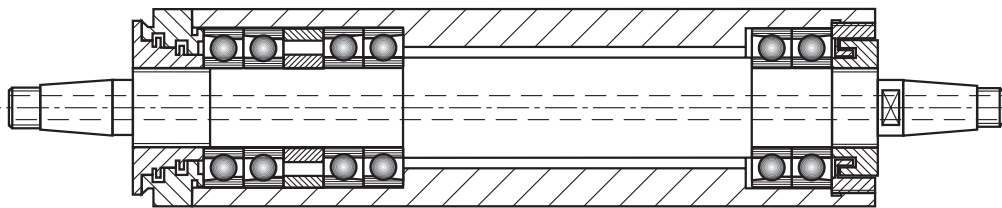
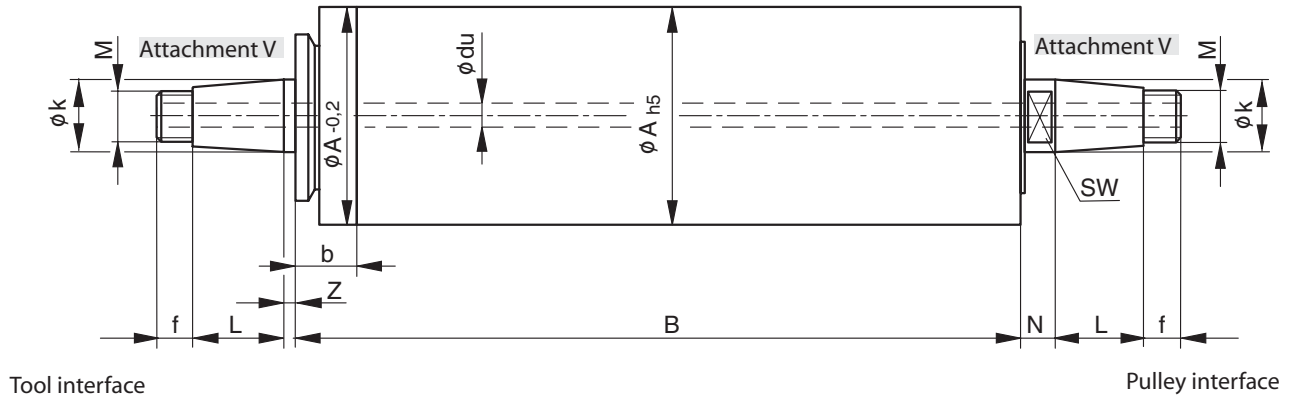
Please state direction of rotation.

1 mm = 0.03937 in.

## TSAV - Style

Taper 1 : 7.5 nominal value  
(3 xx' xx'') included angle acc. to GMN  
precision standards

Taper 1 : 7.5 nominal value  
(3 xx' xx'') included angle acc. to GMN  
precision standards



TSAV and TSEV spindle styles have a solid bearing arrangement as opposed to the other belt driven designs which are spring preloaded. The solid bearing mounting provides for higher spindle stiffness and load carrying capacity at maximum spindle speed.

This arrangement limits the spindle speed in comparison to the same bearing bore sizes used in the TSA, TSI, TSP and TSE styles.

Another advantage is low axial shaft movement, which is required for face grinding.

Higher speeds are available, but with **reduced preload**.

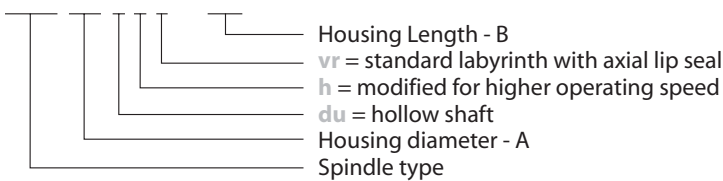
Hollow shafts are an option for allowing **low pressure coolant through** to the work piece.

TSAV designs with **High Pressure Rotary Coolant Unions** are available, starting at 100 mm body diameter.



## TSAV - Style

| Spindle Style <sup>1)</sup> | Attachment |      |            | Dimensions [mm] |     |      |    |    |                  | Max. Speed <sup>2)</sup> [rpm] |              |
|-----------------------------|------------|------|------------|-----------------|-----|------|----|----|------------------|--------------------------------|--------------|
|                             | k          | L    | M          | f               | Z   | b    | N  | SW | du <sup>3)</sup> | Execution                      | Modification |
| TSAV 40 x 160               | 12.83      | 15   | M 10 x 1   | 7               | 2.5 | 9.5  | 7  | 10 | 6                | 13000                          | 32000        |
| <b>TSAV 40</b> x 200        |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 40 x 250               |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 40 x 315               |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 40 x 355               | 15.5       | 20   | M 12 x 1   | 7               | 3   | 11.5 | 8  | 13 | 8                | 10500                          | 26000        |
| TSAV 50 x 200               |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 50 x 250               |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 50 x 315               |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 50 x 355               | 20         | 25   | M 16 x 1   | 10              | 3   | 10.5 | 9  | 17 | 10               | 8500                           | 20000        |
| <b>TSAV 60</b> x 200        |            |      |            |                 |     |      |    |    |                  |                                |              |
| <b>TSAV 60</b> x 250        |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 60 x 315               |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 60 x 355               | 27.67      | 35   | M 20 x 1   | 12              | 4   | 14   | 12 | 24 | 14               | 6500                           | 15000        |
| TSAV 60 x 400               |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 60 x 500               |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 60 x 630               |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 80 x 250               | 38         | 52.5 | M 30 x 1   | 12.5            | 4   | 17   | 15 | 32 | 20               | 5500                           | 10000        |
| <b>TSAV 80</b> x 315        |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 80 x 355               |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 80 x 400               |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 80 x 500               | 52         | 65   | M 36 x 1   | 17.5            | 5   | 28   | 18 | 46 | 25               | 4500                           | 7000         |
| TSAV 80 x 630               |            |      |            |                 |     |      |    |    |                  |                                |              |
| <b>TSAV 100</b> x 315       |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 100 x 355              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 100 x 400              | 56         | 75   | M 40 x 1.5 | 17.5            | 5   | 32.5 | 18 | 48 | 30               | 3500                           | 6000         |
| TSAV 100 x 500              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 100 x 630              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 100 x 800              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 120 x 355              | 87         | 110  | M 65 x 1.5 | 20              | 6   | 33.5 | 21 | 60 | 35               | 2500                           | 5000         |
| TSAV 120 x 400              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 120 x 500              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 120 x 630              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 120 x 800              | 87         | 110  | M 65 x 1.5 | 20              | 6   | 35   | 24 | 75 | 40               | 1500                           | 3000         |
| TSAV 120 x 1000             |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 140 x 400              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 140 x 500              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 140 x 630              | 87         | 110  | M 65 x 1.5 | 20              | 6   | 35   | 24 | 75 | 40               | 1500                           | 2000         |
| TSAV 140 x 800              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 140 x 1000             |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 160 x 400              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 160 x 500              | 87         | 110  | M 65 x 1.5 | 20              | 6   | 35   | 24 | 75 | 40               | 1500                           | 2000         |
| TSAV 160 x 630              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 200 x 400              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 200 x 500              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 200 x 630              | 87         | 110  | M 65 x 1.5 | 20              | 6   | 35   | 24 | 75 | 40               | 1500                           | 2000         |
| TSAV 200 x 630              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 200 x 800              |            |      |            |                 |     |      |    |    |                  |                                |              |
| TSAV 200 x 1000             |            |      |            |                 |     |      |    |    |                  |                                |              |



1 mm = 0.03937 in.

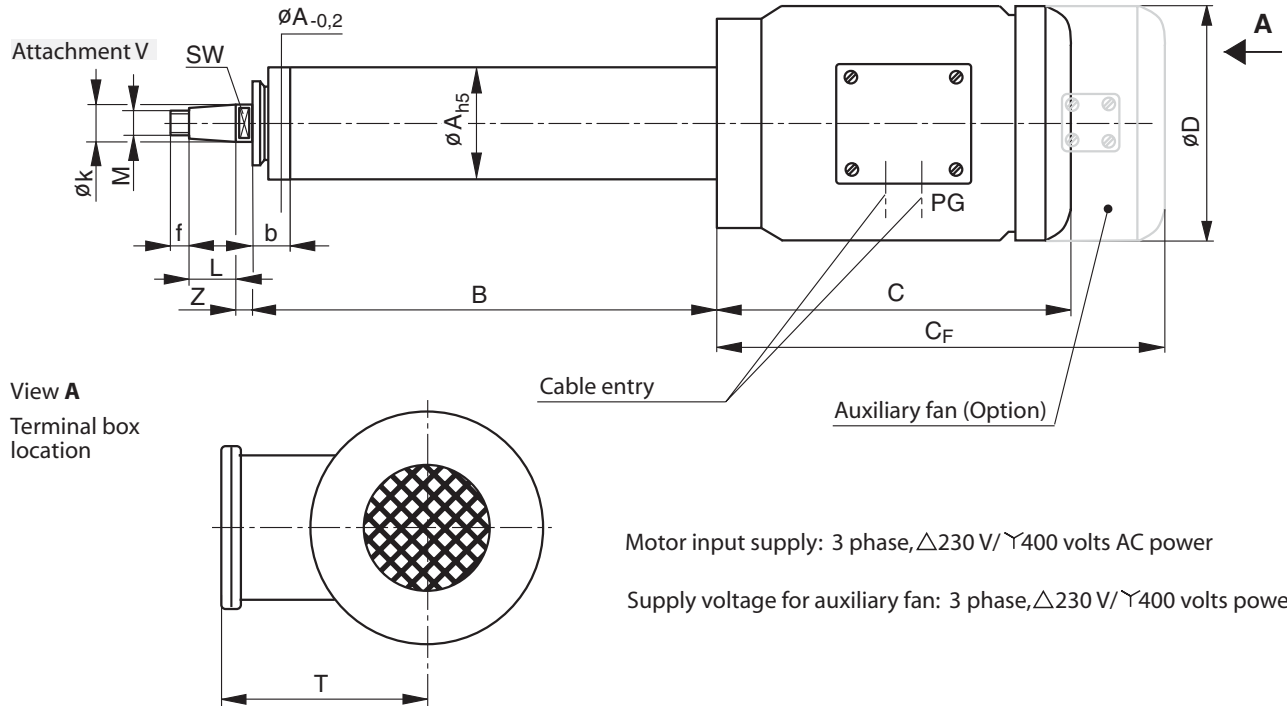
Please ask for max. speed for vr.  
Option "anti-rotation" for dual rotation.

- 1) **Preference types** are in bold.
- 2) Without tool.  
Depending on tool design and weight the maximum operating speed may be reduced.
- 3) Option: du

Please state direction of rotation.

## TSEV - Style

Taper 1 : 7.5 nominal value  
(3 xx' xx'') included angle acc. to GMN  
precision standards



Motor input supply: 3 phase,  $\Delta$ 230 V/  $\Upsilon$ 400 volts AC power

Supply voltage for auxiliary fan: 3 phase,  $\Delta$ 230 V/  $\Upsilon$ 400 volts power

TSEV-spindles are equipped with air cooled asynchronous motors. The speeds shown in the chart below are the available ranges, and are calculated per the following formula:

$$n = \frac{120 \times f}{p}$$

$n$  = Speed  
 $f$  = Frequency  
 $p$  = Number of poles

Specified speed

| Number of poles | 2     | 4    | 6    |
|-----------------|-------|------|------|
| Frequency       |       |      |      |
| at 50 Hz        | 3000  | 1500 | 1000 |
| at 60 Hz        | 3600  | 1800 | 1200 |
| at 100 Hz       | 6000  | 3000 | 2000 |
| at 200 Hz       | 12000 | 6000 | 4000 |

The motors are designed to operate up to 200 hertz. Special motors are required for speeds, which exceed those specified in the chart.

Frequency converters allow the spindles to be operated over a variable speed range. When selecting a converter special attention should be paid to the smoothness of the sine wave, which is critical to the performance of the spindle.

Erratic sine wave peaks can cause the motor to run hot, which causes a loss of output power, and also increases the electromagnetic interference.

The cooling fan is attached to the rear of the spindle shaft, and operates at the specified speed of the spindle. The cooling is sufficient for the output power of the motor, and noise levels are minimal. Increasing the spindle speed above the specified range can increase the decibel level to UN-acceptable, and also cause damage to the fan and spindle.

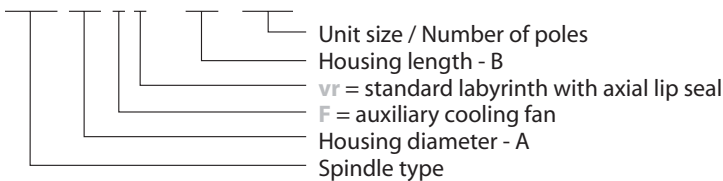
Speeds above 100 hertz require an auxiliary fan motor.

Additional features:

- ▶ PTC resistors and thermistors are imbedded in the motor windings for temperature monitoring
- ▶ Motor housings are painted RAL 7032 Grey, as a standard
- ▶ Power cables can be supplied
- ▶ Spindles with increased output power can be supplied, but will require liquid cooled motors

## TSEV - Style

| Spindle Style <sup>1)</sup>         | Attachment                          |            |   | Dimensions [mm] |      |      |      |     |       |                |       | Power <sup>2)</sup><br>[kW] | Max. Speed <sup>3)</sup><br>[rpm] |                                |               |               |
|-------------------------------------|-------------------------------------|------------|---|-----------------|------|------|------|-----|-------|----------------|-------|-----------------------------|-----------------------------------|--------------------------------|---------------|---------------|
|                                     | k                                   | L          | M | f               | Z    | b    | SW   | D   | C     | C <sub>F</sub> | T     |                             | n <sub>B</sub> <sup>4)</sup>      | n <sub>max</sub> <sup>5)</sup> |               |               |
|                                     | <b>TSEV 50</b> x <b>200 - 071/2</b> | V 15       |   |                 | 15.5 | 8    | 11.5 | 13  | 138   | 222            | 326   |                             | 127                               | 11                             | 0.55          | 4800          |
| TSEV 50 x 250 - 071/2               | 20                                  | M 12 x 1   |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 50 x 315 - 071/2               |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 60 x 200 - 080/2               |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| <b>TSEV 60</b> x <b>250 - 080/2</b> | V 20                                |            |   | 20              | 9    | 11.5 | 17   | 156 | 238.5 | 343.5          | 138.5 | 16                          | 1.1                               | 4800                           | 8500<br>20000 |               |
| TSEV 60 x 315 - 080/2               | 25                                  | M 16 x 1   |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 60 x 355 - 080/2               |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 80 x 250 - 090/2               |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| <b>TSEV 80</b> x <b>315 - 090/2</b> | V 27                                |            |   | 27.67           | 12   | 12   | 14.5 | 24  | 176   | 282.5          | 386.5 | 151                         | 16                                | 2.2                            | 4800          | 6500<br>15000 |
| TSEV 80 x 355 - 090/2               | 35                                  | M 20 x 1   |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 80 x 400 - 090/2               |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 80 x 500 - 090/2               |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 100 x 315 - 112/2              | V 38                                |            |   | 38              | 12.5 | 15   | 17.5 | 32  | 218   | 312.5          | 406.5 | 169.5                       | 16                                | 4                              | 4800          | 5500<br>10000 |
| TSEV 100 x 355 - 112/2              | 52.5                                | M 30 x 1   |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 100 x 400 - 112/2              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 100 x 500 - 112/2              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 100 x 630 - 112/2              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 100 x 315 - 112/4              | V 38                                |            |   | 38              | 12.5 | 15   | 17.5 | 32  | 218   | 312.5          | 406.5 | 169.5                       | 16                                | 4                              | 2400          | 5500<br>6000  |
| TSEV 100 x 355 - 112/4              | 52.5                                | M 30 x 1   |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 100 x 400 - 112/4              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 100 x 500 - 112/4              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 100 x 630 - 112/4              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 120 x 355 - 132/2              | V 52                                |            |   | 52              | 17.5 | 18   | 28   | 46  | 258   | 397            | 528   | 189.5                       | 16                                | 7.5                            | 4800          | 4800<br>6000  |
| TSEV 120 x 400 - 132/2              | 65                                  | M 36 x 1   |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 120 x 500 - 132/2              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 120 x 800 - 132/2              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 120 x 1000 - 132/2             |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 120 x 355 - 132/4              | V 52                                |            |   | 52              | 17.5 | 18   | 28   | 46  | 258   | 397            | 528   | 189.5                       | 16                                | 7.5                            | 2400          | 4500<br>6000  |
| TSEV 120 x 400 - 132/4              | 65                                  | M 36 x 1   |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 120 x 500 - 132/4              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 120 x 800 - 132/4              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 120 x 1000 - 132/4             |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 140 x 400 - 132/2              | V 56                                |            |   | 56              | 17.5 | 18   | 32.5 | 48  | 258   | 402            | 518   | 189.5                       | 16                                | 7.5                            | 3500          | 3500<br>4000  |
| TSEV 140 x 500 - 132/2              | 75                                  | M 40 x 1.5 |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 140 x 630 - 132/2              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 140 x 800 - 132/2              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 140 x 1000 - 132/2             |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 140 x 400 - 132/4              | V 56                                |            |   | 56              | 17.5 | 18   | 32.5 | 48  | 258   | 409            | 539   | 189.5                       | 16                                | 7.5                            | 2400          | 3500<br>4000  |
| TSEV 140 x 500 - 132/4              | 75                                  | M 40 x 1.5 |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 140 x 630 - 132/4              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 140 x 800 - 132/4              |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 140 x 1000 - 132/4             |                                     |            |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 160 x 400 - 160/4              | V 87                                |            |   | 87              | 20   | 21   | 33.5 | 60  | 310   | 521            | 672   | 225                         | 21                                | 11                             | 2400          | 2500<br>4500  |
| TSEV 160 x 500 - 160/4              | 110                                 | M 65 x 1.5 |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |
| TSEV 160 x 400 - 160/6              | V 87                                |            |   | 87              | 20   | 21   | 33.5 | 60  | 310   | 521            | 672   | 225                         | 21                                | 11                             | 1600          | 2500<br>3000  |
| TSEV 160 x 500 - 160/6              | 110                                 | M 65 x 1.5 |   |                 |      |      |      |     |       |                |       |                             |                                   |                                |               |               |



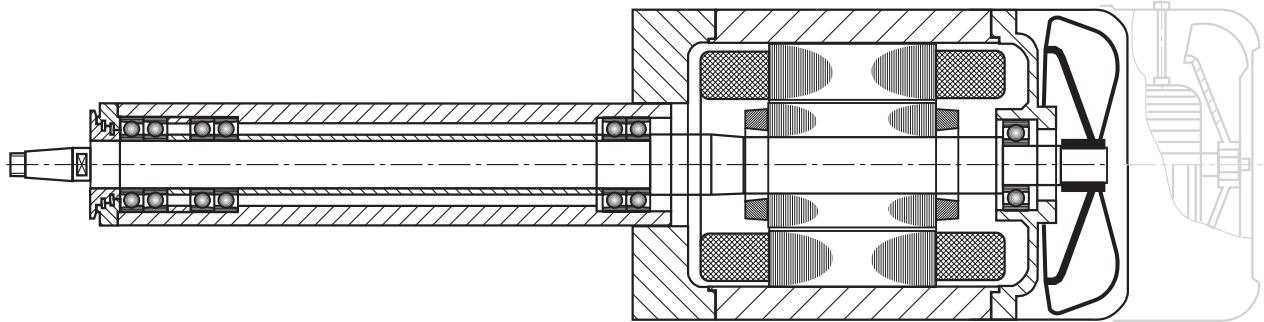
Please ask for max. speed for vr.

Please state speed range and direction of rotation.

- 1) **Preference types** are in bold.
- 2) Power at 50 Hz.
- 3) Without tool.  
Depending on tool design and weight the maximum operating speed may be reduced.
- 4) Max. speed for standard fan.
- 5) Speed for standard bearing application.  
**Marked** = Speed for modified bearing application and if necessary a special motor.

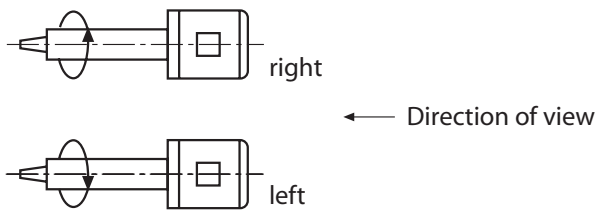
1 mm = 0.03937 in.  
1 kW = 1.34102 h.p.

## TSEV - Style



### Technical Characteristics

- ▶ Spindle powered by an AC induction motor, with IP 54-protection rating, including PTC 145 and KTY 80-134 for over-temperature monitoring
- ▶ Precision ball bearing, in a solid arrangement
- ▶ Permanent grease lubricated
- ▶ External grinding taper
- ▶ Capable of operating from direct AC power supply or converter compatible for variable speed operation
- ▶ Auxiliary motors, dependent on speed and output power requirements
- ▶ The direction of rotation either **R** (right hand) or **L** (left hand) is determined by viewing the spindle from the rear as shown



### Ordering data

- ▶ Type designation \_\_\_\_\_ see chart on page 13
- ▶ Direction of rotation data \_\_\_\_\_  
Option: From spindle diameter A = 50 deliverable for both direction of rotation types
- ▶ Maximum speed from \_\_\_\_\_ up to \_\_\_\_\_

### Options

- ▶ Higher output power with lower decibel levels with an auxiliary cooling fan
- ▶ Automatic wheel balancing capabilities for 160 mm and larger, see page 29 / 31
- ▶ Electronic control, see page 30

### Accessories

- ▶ Flange
- ▶ Puller for flange TSEV
- ▶ Balancing quill for flange
- ▶ Tool for wheel change
- ▶ Storage and transport box
- ▶ Power cable

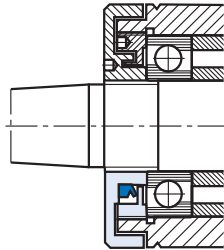
| TSEV              | Current [A]<br>bei 230V/400V | Cable type |
|-------------------|------------------------------|------------|
| TSEV 50           | 2.25 / 1.3                   | SAK 18     |
| TSEV 60           | 4.3 / 2.5                    | SAK 18     |
| TSEV 80           | 7.5 / 4.3                    | SAK 18     |
| TSEV 100, 2 poles | 14 / 8.1                     | SAK 18     |
| TSEV 100, 4 poles | 14.9 / 8.6                   | SAK 18     |
| TSEV 120, 2 poles | 25.1 / 14.5                  | SAK 33     |
| TSEV 120, 4 poles | 26.8 / 15.4                  | SAK 33     |
| TSEV 140, 2 poles | 25.2 / 14.5                  | SAK 33     |
| TSEV 140, 4 poles | 26.8 / 15.4                  | SAK 33     |
| TSEV 160, 4 poles | 37.5 / 21.5                  | SAK 41     |
| TSEV 160, 6 poles | 39 / 22.5                    | SAK 41     |

- ▶ Thermistor amplifier

## Sealing Options

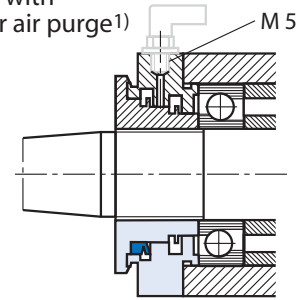
Standard: Labyrinth seal

up to TSAV 100/  
TSEV 100



Standard: Labyrinth seal with connection for air purge<sup>1)</sup>

from TSAV 120/  
TSEV 120



Option: Axial lip seal

The mechanical labyrinth seal design protects bearing system against the ingress of contamination during operation. The seal can be enhanced by the addition of an air purge port.

Spindle operating plane must be advised at the time of an order.

Contact type seals are available, depend upon maximum speed (see table at right).

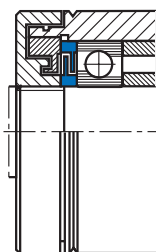
Option: Labyrinth seal with axial lip seal

| Spindle Style         | Speed limit (Sliding seal) [rpm] |
|-----------------------|----------------------------------|
| TSAV 40               | 6300                             |
| TSAV 50/<br>TSEV 50   | 5000                             |
| TSAV 60/<br>TSAV 60   | 4100                             |
| TSAV 80/<br>TSEV 80   | 3100                             |
| TSAV 100/<br>TSEV 100 | 2400                             |
| TSAV 120/<br>TSEV 120 | 1700                             |
| TSAV 140/<br>TSEV 140 | 1600                             |
| TSAV 160/<br>TSEV 160 | 1300                             |
| TSAV 200              | 1000                             |

<sup>1)</sup> Please note: The fitting is not part of the standard shipment.

Option

from TSA 50/  
TSI 50/  
TSP 50



Sealing shields

Closely machined sealing shields can be incorporated into the TSA, TSI and TSP style spindles, to improve the sealing effects of the standard labyrinth seals. Radial stiffness will be slightly reduced.

## Cutting Speed

| Spindle speed [rpm] | Wheel diameter E [mm] |      |      |      |      |      |      |      |      |      |      |      |      |      |      |      |      |      |
|---------------------|-----------------------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|
|                     | 4                     | 5    | 6    | 8    | 10   | 13   | 16   | 20   | 32   | 40   | 50   | 63   | 80   | 100  | 125  | 175  | 200  | 250  |
| 80000               | 16.8                  | 20.9 | 25.1 | 33.5 | 41.9 | 54.5 | 67.0 | 83.8 |      |      |      |      |      |      |      |      |      |      |
| 70000               | 14.7                  | 18.3 | 22.0 | 29.3 | 36.7 | 47.6 | 58.6 | 73.3 |      |      |      |      |      |      |      |      |      |      |
| 60000               | 12.6                  | 15.7 | 18.8 | 25.1 | 31.4 | 40.8 | 50.3 | 62.8 |      |      |      |      |      |      |      |      |      |      |
| 55000               | 11.5                  | 14.4 | 17.3 | 23.0 | 28.8 | 37.4 | 46.1 | 57.6 | 92.2 |      |      |      |      |      |      |      |      |      |
| 50000               | 10.5                  | 13.1 | 15.7 | 20.9 | 26.2 | 34.0 | 41.9 | 52.4 | 83.8 |      |      |      |      |      |      |      |      |      |
| 45000               |                       | 11.8 | 14.1 | 18.8 | 23.6 | 30.6 | 37.7 | 47.1 | 75.4 | 94.2 |      |      |      |      |      |      |      |      |
| 40000               |                       | 10.5 | 12.6 | 16.8 | 20.9 | 27.2 | 33.5 | 41.9 | 67.0 | 83.8 |      |      |      |      |      |      |      |      |
| 35000               |                       |      | 11.0 | 14.7 | 18.3 | 23.8 | 29.3 | 36.7 | 58.6 | 73.3 | 91.6 |      |      |      |      |      |      |      |
| 33000               |                       |      | 10.4 | 13.8 | 17.3 | 22.5 | 27.6 | 34.6 | 55.3 | 69.1 | 86.4 |      |      |      |      |      |      |      |
| 32000               |                       |      | 10.1 | 13.4 | 16.8 | 21.8 | 26.8 | 33.5 | 53.6 | 67.0 | 83.8 |      |      |      |      |      |      |      |
| 30000               |                       |      |      | 12.6 | 15.7 | 20.4 | 25.1 | 31.4 | 50.3 | 62.8 | 78.5 | 99.0 |      |      |      |      |      |      |
| 27000               |                       |      |      | 11.3 | 14.1 | 18.4 | 22.6 | 28.3 | 45.2 | 56.5 | 70.7 | 89.1 |      |      |      |      |      |      |
| 25000               |                       |      |      | 10.5 | 13.1 | 17.0 | 20.9 | 26.2 | 41.9 | 52.4 | 65.4 | 82.5 |      |      |      |      |      |      |
| 24000               |                       |      |      | 10.1 | 12.6 | 16.3 | 20.1 | 25.1 | 40.2 | 50.3 | 62.8 | 79.2 |      |      |      |      |      |      |
| 23000               |                       |      |      |      | 12.0 | 15.7 | 19.3 | 24.1 | 38.5 | 48.2 | 60.2 | 75.9 | 96.3 |      |      |      |      |      |
| 22500               |                       |      |      |      | 11.8 | 15.3 | 18.8 | 23.6 | 37.7 | 47.1 | 58.9 | 74.2 | 94.2 |      |      |      |      |      |
| 21000               |                       |      |      |      | 11.0 | 14.3 | 17.6 | 22.0 | 35.2 | 44.0 | 55.0 | 69.3 | 88.0 |      |      |      |      |      |
| 20000               |                       |      |      |      | 10.5 | 13.6 | 16.8 | 20.9 | 33.5 | 41.9 | 52.4 | 66.0 | 83.8 |      |      |      |      |      |
| 19000               |                       |      |      |      |      | 12.9 | 15.9 | 19.9 | 31.8 | 39.8 | 49.7 | 62.7 | 79.6 | 99.5 |      |      |      |      |
| 18000               |                       |      |      |      |      | 12.3 | 15.1 | 18.8 | 30.2 | 37.7 | 47.1 | 59.4 | 75.4 | 94.2 |      |      |      |      |
| 16000               |                       |      |      |      |      | 10.9 | 13.4 | 16.8 | 26.8 | 33.5 | 41.9 | 52.8 | 67.0 | 83.8 |      |      |      |      |
| 15000               |                       |      |      |      |      |      | 12.6 | 15.7 | 25.1 | 31.4 | 39.3 | 49.5 | 62.8 | 78.5 | 98.2 |      |      |      |
| 14000               |                       |      |      |      |      |      | 11.7 | 14.7 | 23.5 | 29.3 | 36.7 | 46.2 | 58.6 | 73.3 | 91.6 |      |      |      |
| 13500               |                       |      |      |      |      |      | 11.3 | 14.1 | 22.6 | 28.3 | 35.3 | 44.5 | 56.5 | 70.7 | 88.4 |      |      |      |
| 13000               |                       |      |      |      |      |      | 10.9 | 13.6 | 21.8 | 27.2 | 34.0 | 42.9 | 54.5 | 68.1 | 85.1 |      |      |      |
| 12500               |                       |      |      |      |      |      | 10.5 | 13.1 | 20.9 | 26.2 | 32.7 | 41.2 | 52.4 | 65.4 | 81.8 |      |      |      |
| 12000               |                       |      |      |      |      |      | 10.1 | 12.6 | 20.1 | 25.1 | 31.4 | 39.6 | 50.3 | 62.8 | 78.5 |      |      |      |
| 11500               |                       |      |      |      |      |      |      | 12.0 | 19.3 | 24.1 | 30.1 | 37.9 | 48.2 | 60.2 | 75.3 |      |      |      |
| 11000               |                       |      |      |      |      |      |      | 11.5 | 18.4 | 23.0 | 28.8 | 36.3 | 46.1 | 57.6 | 72.0 |      |      |      |
| 10500               |                       |      |      |      |      |      |      | 11.0 | 17.6 | 22.0 | 27.5 | 34.6 | 44.0 | 55.0 | 68.7 | 96.2 |      |      |
| 10000               |                       |      |      |      |      |      |      | 10.5 | 16.8 | 20.9 | 26.2 | 33.0 | 41.9 | 52.4 | 65.4 | 91.6 |      |      |
| 9000                |                       |      |      |      |      |      |      |      | 15.1 | 18.8 | 23.6 | 29.7 | 37.7 | 47.1 | 58.9 | 82.5 | 94.2 |      |
| 8000                |                       |      |      |      |      |      |      |      | 13.4 | 16.8 | 20.9 | 26.4 | 33.5 | 41.9 | 52.4 | 73.3 | 83.8 |      |
| 7500                |                       |      |      |      |      |      |      |      | 12.6 | 15.7 | 19.6 | 24.7 | 31.4 | 39.3 | 49.1 | 68.7 | 78.5 | 98.2 |
| 7000                |                       |      |      |      |      |      |      |      | 11.7 | 14.7 | 18.3 | 23.1 | 29.3 | 36.7 | 45.8 | 64.1 | 73.3 | 91.6 |
| 6000                |                       |      |      |      |      |      |      |      | 10.1 | 12.6 | 15.7 | 19.8 | 25.1 | 31.4 | 39.3 | 55.0 | 62.8 | 78.5 |
| 5500                |                       |      |      |      |      |      |      |      |      | 11.5 | 14.4 | 18.1 | 23.0 | 28.8 | 36.0 | 50.4 | 57.6 | 72.0 |
| 5000                |                       |      |      |      |      |      |      |      |      | 10.5 | 13.1 | 16.5 | 20.9 | 26.2 | 32.7 | 45.8 | 52.4 | 65.4 |
| 4000                |                       |      |      |      |      |      |      |      |      |      | 10.5 | 13.2 | 16.8 | 20.9 | 26.2 | 36.7 | 41.9 | 52.4 |
| 2860                |                       |      |      |      |      |      |      |      |      |      |      |      | 12.0 | 15.0 | 18.7 | 26.2 | 29.9 | 37.4 |
| 1440                |                       |      |      |      |      |      |      |      |      |      |      |      |      |      |      | 13.2 | 15.1 | 18.8 |

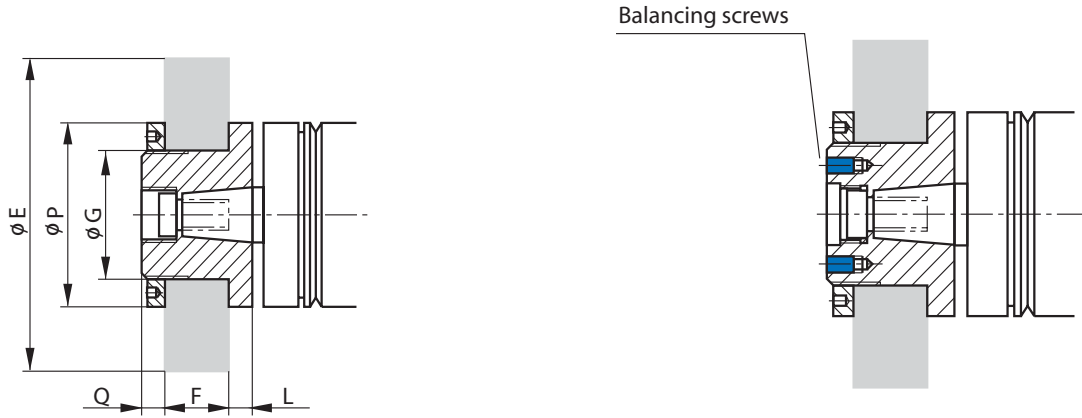
Cutting speed  $v_c$  [m/s]

$$v_c = \frac{E \cdot \pi \cdot n}{60 \cdot 1000} \text{ [m/s]}$$

E = Wheel diameter [mm]  
n = Spindle speed [1/min]

1 mm = 0.03937 in.  
1 m = 1.09361 yd.

## TSA - Grinding Wheel Flanges

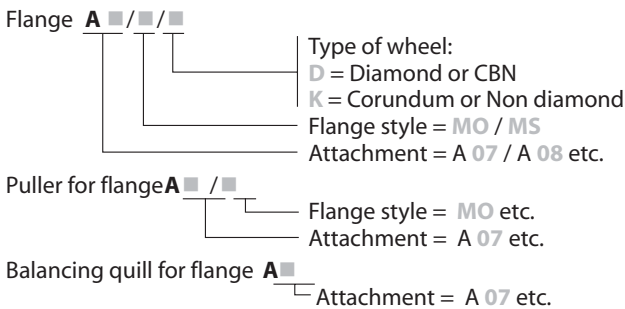


Flange style MO

Flange style MS

| Spindle style | Attachment | Flange style | Flange dimensions [mm] |     |     | Grinding wheel [mm] |    |                 | Max. speed <sup>2)</sup> [rpm] |
|---------------|------------|--------------|------------------------|-----|-----|---------------------|----|-----------------|--------------------------------|
|               |            |              | P                      | Q   | L   | E                   | F  | G <sup>1)</sup> |                                |
| TSA 20        | A 07       | MO           | 20                     | 6.5 | 1.5 | 25                  | 8  | 13              | 27000                          |
| TSA 26        | A 08       | MO           | 26                     | 5.5 | 3.5 | 36                  | 10 | 16              | 20000                          |
| TSA 32        | A 10       | MO           | 32                     | 6.5 | 3.5 | 50                  | 13 | 20              | 15000                          |
| TSA 40        | A 10       | MS           | 40                     | 6   | 6   | 63                  | 16 | 25              | 12000                          |
| TSA 50        | A 13       | MS           | 50                     | 6   | 9   | 80                  | 20 | 32              | 10000                          |
| TSA 60        | A 18       | MS           | 60                     | 7   | 9   | 100                 | 25 | 32              | 8000                           |
| TSA 80        | A 27       | MS           | 80                     | 9   | 10  | 125                 | 32 | 51              | 6000                           |
| TSA 100       | A 38       | MS           | 100                    | 15  | 13  | 150                 | 40 | 76              | 5000                           |

### Ordering Information:



- 1) Wheel bore fits:  
Corundum or Non diamond:  $G_{f7}$   
Diamond or CBN:  $G_{h4}$
- 2) Wheel selection must be in accordance with the manufacturer's recommendation for maximum speed. Compliance with ANSI Safety Requirements B 7.1 must be adhered to.

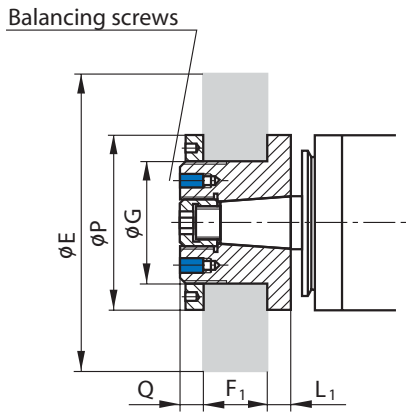
### Balancing Specifications:

For safety reasons, noise levels, and finish quality all rotating components including the grinding wheels must be balanced. GMN recommend balancing the system within G 2.5 level, according to ISO 1940.

Please state direction of rotation, see page 35, for information.

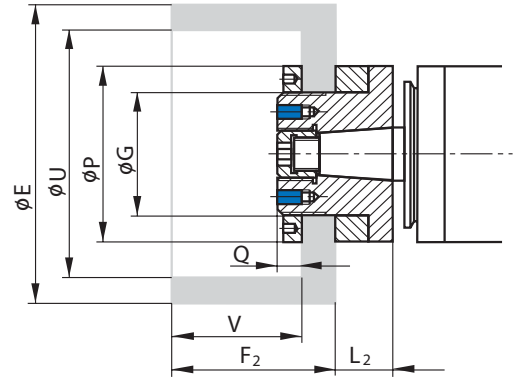
1 mm = 0.03937 in.

Fig. 1



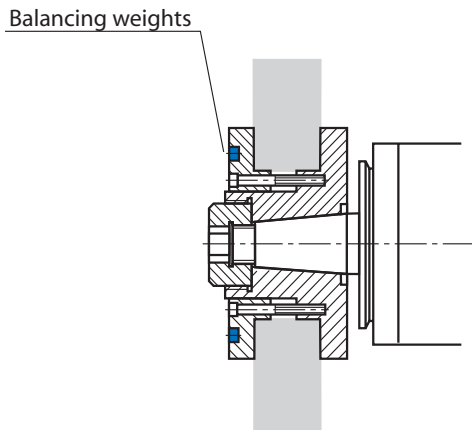
Flange style MS

Fig. 2



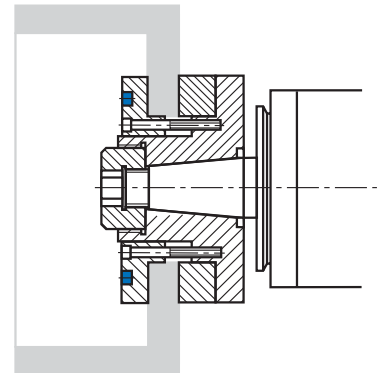
Flange style MS

Fig. 3



Flange style SN

Fig. 4



Flange style SN



## TSAV / TSEV - Grinding Wheel Flanges

| Spindle Style         | Attachment | Fig. | Flange dimensions [mm] |      |                |                | E   | G <sup>1)</sup> | Grinding wheel [mm]                                     |                                 |     |     | Max. speed <sup>2)</sup><br>( $v_c = 35$ m/s)<br>[rpm] |
|-----------------------|------------|------|------------------------|------|----------------|----------------|-----|-----------------|---|---------------------------------|-----|-----|--|
|                       |            |      | P                      | Q    | L <sub>1</sub> | L <sub>2</sub> |     |                 | Straight wheel<br>F <sub>1</sub><br>(Chucking capacity) | Cup wheel<br>F <sub>2</sub> U V |     |     |  |
| TSAV 40               | V 12       | 1+2  | 40                     | 6    | 6              | 14             | 100 | 25              | 16<br>(11-16)   | 50                              | 90  | 42  | 6600   |
|                       |            | 1    | 40                     | 6    | 6              | ---            | 80  | 25              | 16<br>(11-16)   | ---                             | --- | --- | 8300   |
| TSAV 50/<br>TSEV 50   | V 15       | 1+2  | 50                     | 6    | 9              | 19             | 125 | 32              | 20<br>(14-20)   | 63                              | 110 | 53  | 5300   |
|                       |            | 1    | 50                     | 6    | 9              | ---            | 100 | 32              | 20<br>(14-20)   | ---                             | --- | --- | 6600   |
| TSAV 60/<br>TSEV 60   | V 20       | 1+2  | 60                     | 7    | 9              | 21             | 150 | 40              | 25<br>(17-25)   | 80                              | 130 | 67  | 4400   |
|                       |            | 2    | 60                     | 7    | 9              | ---            | 125 | 40              | 25<br>(17-25)   | ---                             | --- | --- | 5300   |
| TSAV 80/<br>TSEV 80   | V 27       | 1+2  | 80                     | 9    | 10             | 22             | 200 | 51              | 32<br>(21-32)   | 100                             | 170 | 80  | 3300   |
|                       |            | 2    | 80                     | 9    | 10             | ---            | 150 | 51              | 32<br>(21-32)   | ---                             | --- | --- | 4400   |
| TSAV 100/<br>TSEV 100 | V 38       | 3+4  | 110                    | 13   | 13             | 28             | 250 | 76              | 40<br>(20-40)   | 125                             | 190 | 100 | 2600   |
|                       |            | 1+2  | 110                    | 13.5 | 13             | 30             | 175 | 76              | 40<br>(30-40)   | ---                             | --- | --- | 3800   |
| TSAV 120/<br>TSEV 120 | V 52       | 3+4  | 165                    | 16   | 16             | 44             | 350 | 127             | 60<br>(25-60)   | 150                             | 235 | 118 | 1900   |
|                       |            | 1    | 120                    | 15   | 16             | ---            | 200 | 76              | 60<br>(45-60)   | ---                             | --- | --- | 3300   |
| TSAV 140/<br>TSEV 140 | V 56       | 3+4  | 180                    | 18   | 18             | 46             | 450 | 127             | 60<br>(32-60)   | 150                             | 260 | 118 | 1400   |
|                       |            | 1    | 140                    | 14   | 18             | ---            | 250 | 76              | 60<br>(46-60)   | ---                             | --- | --- | 2600   |
| TSAV 160/<br>TSEV 160 | V 87       | 3+4  | 270                    | 22   | 22             | ---            | 600 | 203             | 80<br>(40-80)   | ---                             | --- | --- | 1100   |
| TSAV 200              | V 87       | 3+4  | 270                    | 22   | 22             | ---            | 600 | 203             | 80<br>(40-80)   | ---                             | --- | --- | 1100   |

### Ordering Information:

Flange **V** ■/■/■/■

- Type of wheel:
  - D** = Diamond or CBN
  - K** = Corundum or Non diamond
- G** = straight wheel
- T** = cup wheel
- Flange style = **MS / SN**
- Attachment **V 12 / V 15** etc.

Puller for flange **V 12 / V 15** etc.

Balancing quill for flange **V 12 / V 15** etc.

<sup>1)</sup> Wheel bore fits:

Corundum or Non diamond: G<sub>r7</sub>

Diamond or CBN: G<sub>h4</sub>

<sup>2)</sup> Wheel selection must be in accordance with the manufacturer's recommendation for maximum speed. Compliance with ANSI Safety Requirements B 7.1 must be adhered to.

### TSAV / TSEV 50 - 80:

► Flange style MS (Fig. 1, 2):  
Option: anti-rotation slot

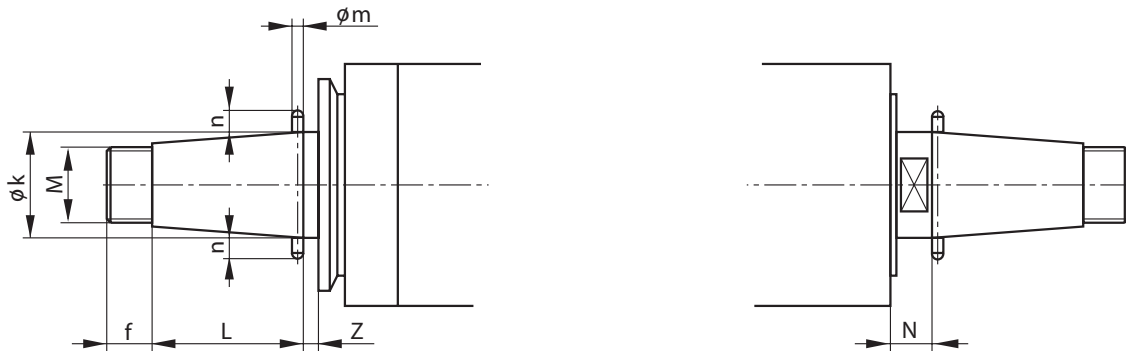
### From TSAV / TSEV 100:

► Flange style SN (Fig. 3, 4):  
Standard: anti-rotation slot

Please state direction of rotation, see page 35, for information.

1 mm = 0.03937 in.  
1 m = 1.09361 yd.

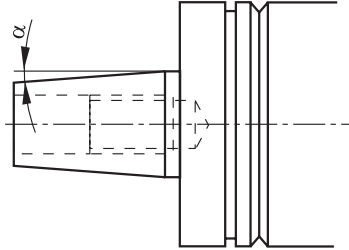
## Anti-Rotation Option



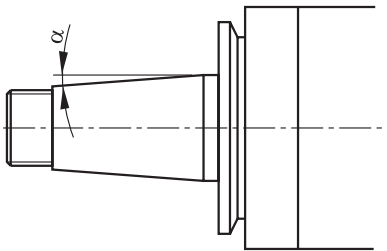
| Spindle Style | Attachment | Attachment dimensions [mm] |      |            | Dimensions [mm] |   |   |    |    |  |
|---------------|------------|----------------------------|------|------------|-----------------|---|---|----|----|--|
|               |            | k                          | L    | M          | f               | m | n | Z  | N  |  |
| TSAV 40       | V 12       | 12.83                      | 15   | M 10 x 1   | 7               |   |   |    |    |  |
| TSAV 50       | V 15       | 15.5                       | 20   | M 12 x 1   | 7               | 3 | 3 | 3  | 8  |  |
| TSAV 60       | V 20       | 20                         | 25   | M 16 x 1   | 10              | 3 | 3 | 3  | 9  |  |
| TSAV 80       | V 27       | 27.67                      | 35   | M 20 x 1   | 12              | 4 | 3 | 4  | 12 |  |
| TSAV 100      | V 38       | 38                         | 52.5 | M 30 x 1   | 12.5            | 5 | 4 | 4  | 15 |  |
| TSAV 120      | V 52       | 52                         | 65   | M 36 x 1   | 17.5            | 6 | 5 | 5  | 18 |  |
| TSAV 140      | V 56       | 56                         | 75   | M 40 x 1.5 | 17.5            | 6 | 5 | 5  | 18 |  |
| TSAV 160      | V 87       | 87                         | 110  | M 65 x 1.5 | 20              | 8 | 6 | 6  | 21 |  |
| TSAV 200      | V 87       | 87                         | 110  | M 65 x 1.5 | 20              | 8 | 6 | 6  | 24 |  |
| TSEV 50       | V 15       | 15.5                       | 20   | M 12 x 1   | 7               | 3 | 3 | 8  |    |  |
| TSEV 60       | V 20       | 20                         | 25   | M 16 x 1   | 10              | 3 | 3 | 9  |    |  |
| TSEV 80       | V 27       | 27.67                      | 35   | M 20 x 1   | 12              | 4 | 3 | 12 |    |  |
| TSEV 100      | V 38       | 38                         | 52.5 | M 30 x 1   | 12.5            | 5 | 4 | 15 |    |  |
| TSEV 120      | V 52       | 52                         | 65   | M 36 x 1   | 17.5            | 6 | 5 | 18 |    |  |
| TSEV 140      | V 52       | 56                         | 75   | M 40 x 1.5 | 17.5            | 6 | 5 | 18 |    |  |
| TSEV 160      | V 87       | 87                         | 110  | M 65 x 1.5 | 20              | 8 | 6 | 24 |    |  |

1 mm = 0.03937 in.

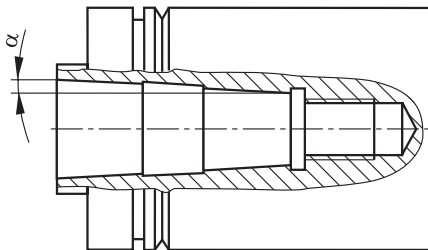
## Taper Specifications



| Spindle Style | Attachment | Taper angle $\alpha$ |
|---------------|------------|----------------------|
| TSA 20        | A 07       | 3° 50' 03"           |
| TSA 26        | A 08       | 3° 49' 33"           |
| TSA 32        | A 10       | 3° 49' 19"           |
| TSA 40        | A 10       | 3° 49' 19"           |
| TSA 50        | A 13       | 3° 48' 28"           |
| TSA 60        | A 18       | 3° 48' 13"           |
| TSA 80        | A 27       | 3° 48' 55"           |
| TSA 100       | A 38       | 3° 50' 28"           |



| Spindle Style          | Attachment | Taper angle $\alpha$ |
|------------------------|------------|----------------------|
| TSAV 40                | V 12       | 3° 49' 15"           |
| TSAV 50 /<br>TSEV 50   | V 15       | 3° 49' 06"           |
| TSAV 60 /<br>TSEV 60   | V 20       | 3° 48' 51"           |
| TSAV 80 /<br>TSEV 80   | V 27       | 3° 48' 55"           |
| TSEV 100 /<br>TSAV 100 | V 38       | 3° 50' 28"           |
| TSAV 120 /<br>TSEV 120 | V 52       | 3° 48' 51"           |
| TSAV 140 /<br>TSEV 140 | V 56       | 3° 49' 27"           |
| TSAV 160 /<br>TSEV 160 | V 87       | 3° 48' 48"           |
| TSAV 200               | V 87       | 3° 48' 48"           |

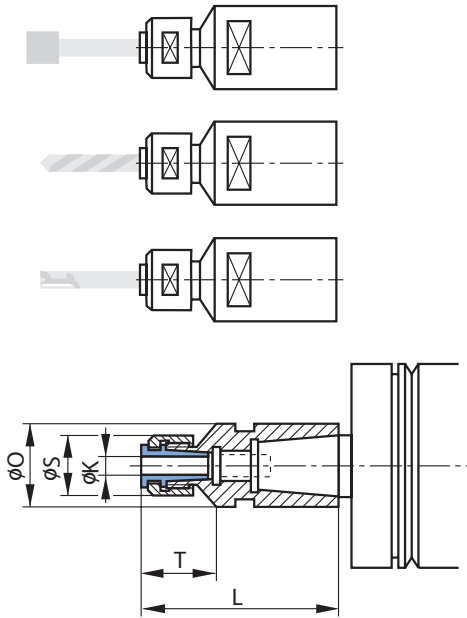


| Spindle Style | Attachment | Taper angle $\alpha$ |
|---------------|------------|----------------------|
| TSI 40        | I 10       | 3° 49' 00"           |
| TSI 50        | I 14       | 3° 48' 42"           |
| TSI 60        | I 18       | 3° 48' 52"           |
| TSI 80        | I 25       | 3° 48' 49"           |
| TSI 100       | I 32       | 3° 49' 00"           |

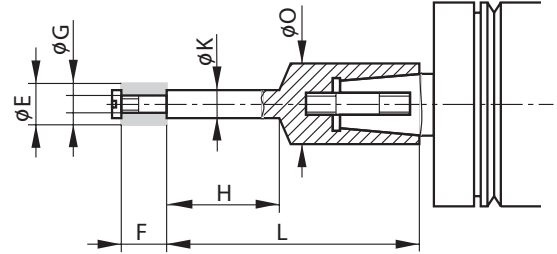
Taper angle  $\alpha$  according to GMN standard.

## Tooling Accessories

### TSA - Collet Chuck



### TSA - Grinding Quill



| Spindle Style | Attachment | Dimensions [mm]    |      |    |    |      |
|---------------|------------|--------------------|------|----|----|------|
|               |            | K                  | T    | L  | S  | O    |
| TSA 20        | A 07       | 2<br>3<br>4        | 13.5 | 36 | 14 | 10.5 |
| TSA 26        | A 08       | 2<br>3<br>4        | 13.5 | 37 | 14 | 12   |
| TSA 32        | A 10       | 2<br>3<br>4        | 13.5 | 37 | 14 | 13.5 |
| TSA 40        | A 10       | 3<br>4<br>5<br>6   | 15.5 | 42 | 16 | 13.5 |
| TSA 50        | A 13       | 3<br>4<br>5<br>6   | 15.5 | 47 | 16 | 18   |
| TSA 60        | A 18       | 3<br>4<br>5<br>6   | 15.5 | 54 | 16 | 23   |
| TSA 80        | A 27       | 6<br>8<br>10<br>12 | 27   | 87 | 35 | 34   |

#### Ordering Information:

Collet chuck **A** ■ / ■  
 Housing diameter = 20 / 26 etc.  
 Attachment = A 07 / A 08 etc.

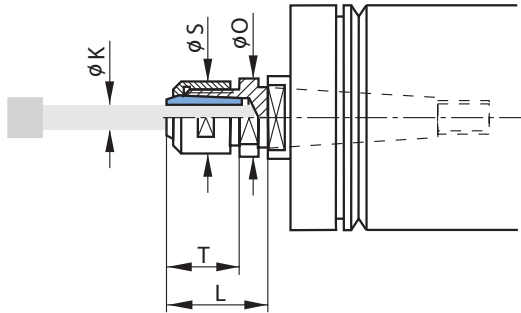
Clamping chuck for collet chuck **A** ■ / ■ - ■  
 Housing diameter = 20 etc.  
 Attachment = A 07 etc.

Please state direction of rotation, see page 35, when ordering.

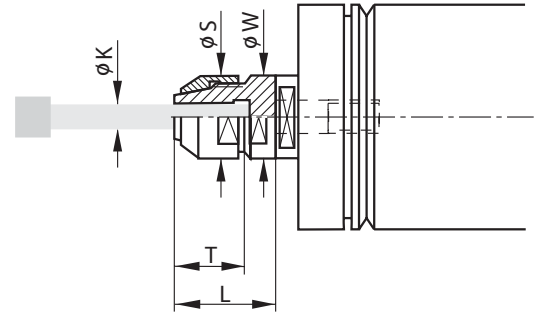
1 mm = 0.03937 in.

## Tooling Accessories

### TSI - Collet Chuck



### TSP - Clamping Chuck



| Spindle Style | Attachment | Dimensions [mm] |      |    |    |      |
|---------------|------------|-----------------|------|----|----|------|
|               |            | K               | T    | L  | S  | O    |
| TSI 40        | I 10       | 3               | 15.5 | 25 | 16 | 13.5 |
|               |            | 4               |      |    |    |      |
|               |            | 5               |      |    |    |      |
|               |            | 6               |      |    |    |      |
|               |            | 6               |      |    |    |      |
| TSI 50        | I 14       | 3               | 15.5 | 25 | 16 | 18   |
|               |            | 4               |      |    |    |      |
|               |            | 5               |      |    |    |      |
|               |            | 6               |      |    |    |      |
|               |            | 6               |      |    |    |      |
| TSI 60        | I 18       | 3               | 15.5 | 28 | 16 | 23   |
|               |            | 4               |      |    |    |      |
|               |            | 5               |      |    |    |      |
|               |            | 6               |      |    |    |      |
|               |            | 6               |      |    |    |      |
| TSI 80        | I 25       | 6               | 36   | 43 | 35 | 34   |
|               |            | 8               |      |    |    |      |
|               |            | 10              |      |    |    |      |
|               |            | 12              |      |    |    |      |
|               |            | 12              |      |    |    |      |

| Spindle Style | Attachment D [d] / [W] | Dimensions [mm] |    |    |    |
|---------------|------------------------|-----------------|----|----|----|
|               |                        | K               | T  | L  | S  |
| TSP 40        | D 08/14                | 3               | 20 | 26 | 14 |
| TSP 50        | D 10/18                | 6               | 20 | 30 | 18 |
| TSP 60        | D 14/23                | 6               | 20 | 30 | 23 |

**Ordering Information:**

Clamping chuck **D 08/14** etc.

Please state direction of rotation, see page 35, when ordering.

**Ordering Information:**

Collet chuck **I ■**  
Attachment = **I 10 / I 14** etc.

Clamping chuck for collet chuck **I ■ - ■**  
Attachment = **I 10 / I 14** etc.

Please state direction of rotation, see page 35, when ordering.

1 mm = 0.03937 in.

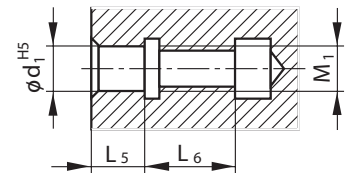
## TSP - / TSI- Grinding Quills

| Spindle type | Surface speeds<br>at maximum spindle speed [m/s] |    |    |    |    |    |    |    |    | Spindle nose |             |                |
|--------------|--|----|----|----|----|----|----|----|----|--------------|-------------|----------------|
|              |  |    |    |    |    |    |    |    |    |              | Designation | H <sub>0</sub> |
| TSP 40 c     | 23   | 29 | 37 |    |    |    |    |    |    | D 08/14      | 6           | 13             |
| TSP 40       | 19   | 24 | 31 |    |    |    |    |    |    | D 08/14      | 6           | 13             |
| TSP 50 c     |  | 22 | 29 | 35 | 44 |    |    |    |    | D 10/18      | 8           | 16             |
| TSP 50       |  | 18 | 24 | 29 | 37 |    |    |    |    | D 10/18      | 8           | 16             |
| TSP 60 c     |  |    | 24 | 29 | 37 | 46 |    |    |    | D 14/23      | 8           | 21             |
| TSP 60       |  |    | 20 | 25 | 31 | 39 |    |    |    | D 14/23      | 8           | 21             |
| TSP 80 c     |  |    |    | 21 | 26 | 33 | 42 |    |    | D 16/33      | 10          | 27             |
| TSP 80       |  |    |    | 17 | 21 | 26 | 34 |    |    | D 16/33      | 10          | 27             |
| TSP 100 c    |  |    |    |    |    | 26 | 34 | 42 | 52 | D 28/43      | 12          | 38             |
| TSP 100      |  |    |    |    |    | 20 | 25 | 31 | 39 | D 28/43      | 12          | 38             |

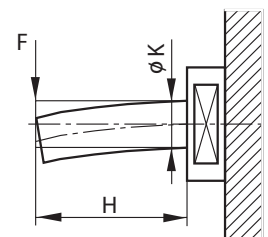
|           |    |    |    |    |    |    |    |    |    |      |    |    |
|-----------|----|----|----|----|----|----|----|----|----|------|----|----|
| TSI 40 c  | 23 | 29 | 37 |    |    |    |    |    |    | I 10 | 5  | 11 |
| TSI 40    | 19 | 24 | 31 |    |    |    |    |    |    | I 10 | 5  | 11 |
| TSI 50 c  |    | 22 | 29 | 35 | 44 |    |    |    |    | I 14 | 6  | 15 |
| TSI 50    |    | 18 | 24 | 29 | 37 |    |    |    |    | I 14 | 6  | 15 |
| TSI 60 c  |    |    | 24 | 29 | 37 | 46 |    |    |    | I 18 | 6  | 19 |
| TSI 60    |    |    | 20 | 25 | 31 | 39 |    |    |    | I 18 | 6  | 19 |
| TSI 80 c  |    |    |    | 21 | 26 | 33 | 42 |    |    | I 25 | 8  | 27 |
| TSI 80    |    |    |    | 17 | 21 | 26 | 34 |    |    | I 25 | 8  | 27 |
| TSI 100 c |    |    |    |    |    | 26 | 34 | 42 | 52 | I 32 | 10 | 41 |
| TSI 100   |    |    |    |    |    | 20 | 25 | 31 | 39 | I 32 | 10 | 41 |

|                              |                |    |    |     |     |     |     |     |    |    |
|------------------------------|----------------|----|----|-----|-----|-----|-----|-----|----|----|
| For wheel dimensions<br>[mm] | E              | 8  | 10 | 13  | 16  | 20  | 25  | 32  | 40 | 50 |
|                              | F              | 10 | 10 | 13  | 16  | 20  | 25  | 25  | 32 | 40 |
|                              | G              | 3  | 3  | 4   | 6   | 8   | 10  | 13  | 16 | 20 |
| Quill diameter               | K              | 5  | 6  | 8   | 10  | 13  | 16  | 20  | 25 | 32 |
| Wheel mount                  |                | KI | KI | PS  | PS  | PS  | PS  | PS  | MU | MU |
|                              | see fig.       | 2  | 2  | 3+4 | 3+4 | 3+4 | 3+4 | 3+4 | 5  | 5  |
| Close-fit hole<br>attachment | d <sub>1</sub> |    |    | 4   | 6   | 8   | 10  | 13  |    |    |
|                              | M <sub>1</sub> |    |    | M3  | M5  | M6  | M8  | M12 |    |    |
|                              | L <sub>5</sub> |    |    | 5   | 7   | 9   | 12  | 13  |    |    |
|                              | L <sub>6</sub> |    |    | 8   | 11  | 12  | 14  | 17  |    |    |

Close-fit hole for fig. 2 and 3



| Quill stiffness<br>[N/μm] | Grinding quill length<br>H [mm] | Grinding quill diameter<br>K [mm] |     |      |      |      |      |      |      |      |
|---------------------------|---------------------------------|-----------------------------------|-----|------|------|------|------|------|------|------|
|                           |                                 | 5                                 | 6   | 8    | 10   | 13   | 16   | 20   | 25   | 32   |
|                           | 16                              | 4.7                               | 9.8 |      |      |      |      |      |      |      |
|                           | 20                              | 2.4                               | 5.0 | 15.8 | 38.7 |      |      |      |      |      |
|                           | 25                              | 1.2                               | 2.6 | 8.1  | 19.8 | 56.5 |      |      |      |      |
|                           | 32                              |                                   |     | 3.9  | 9.4  | 27   | 61.9 | 151  |      |      |
|                           | 40                              |                                   |     |      | 4.8  | 13.8 | 31.7 | 77.3 | 189  |      |
|                           | 50                              |                                   |     |      |      | 7.1  | 16.2 | 39.6 | 96.6 | 259  |
|                           | 63                              |                                   |     |      |      |      | 8.1  | 19.8 | 48.3 | 130  |
|                           | 80                              |                                   |     |      |      |      |      |      | 23.6 | 63,3 |
|                           | 100                             |                                   |     |      |      |      |      |      |      | 32.4 |



1 mm = 0.03937 in.  
1 m = 1.09361 yd.  
1 N/μm = 5710 lb./in.

## TSP - / TSI - Grinding Quills

### Examples For TSP - Quill Applications

Fig. 2: TSP - Cemented wheel (KI)

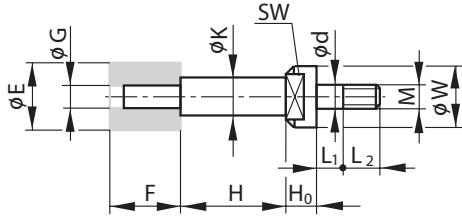


Fig. 3: TSP - Close-fit wheel screw (PS)

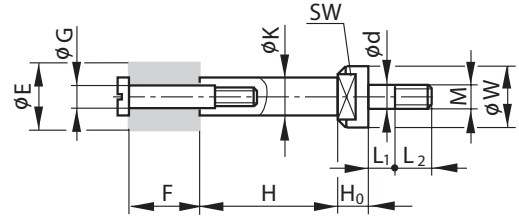


Fig. 4: TSP - Threaded wheel studs (PS)

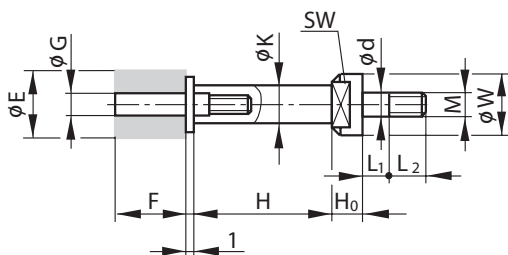
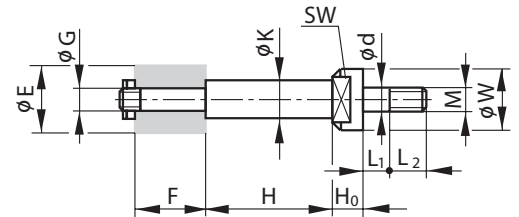


Fig. 5: TSP - Quill with nut (MU)



### Examples For TSI - Quill Applications

Fig. 2: TSI - Cemented wheel (KI)

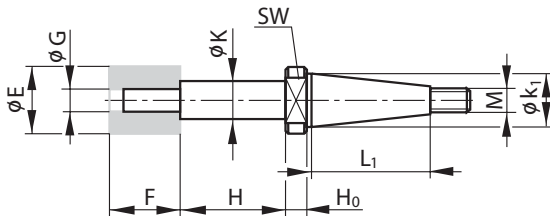


Fig. 3: TSI - Close-fit wheel screw (PS)

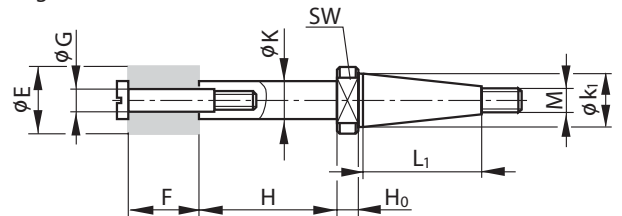


Fig. 4: TSI - Threaded wheel studs (PS)

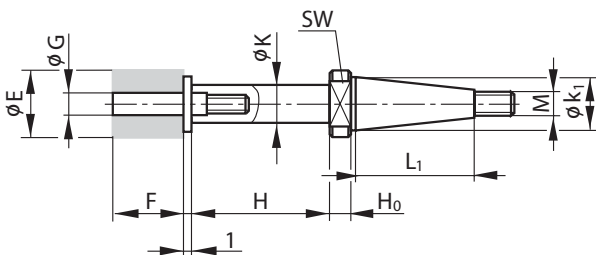
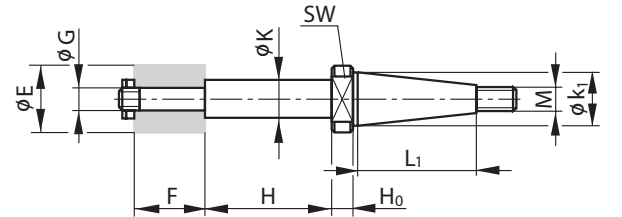
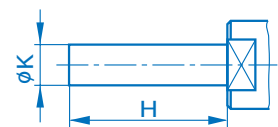


Fig. 5: TSI - Quill with nut (MU)



### TSP - / TSI - Grinding Quills - Semifinished

| Semifinished Quills | Attachment | K [mm] | H [mm] | Attachment | Semifinished Quills |
|---------------------|------------|--------|--------|------------|---------------------|
| TSP 40 (c)          | D08/14     | 13     | 70     | I 10       | TSI 40 (c)          |
| TSP 50 (c)          | D10/18     | 18     | 90     | I 14       | TSI 50 (c)          |
| TSP 60 (c)          | D14/23     | 23     | 135    | I 18       | TSI 60 (c)          |
| TSP 80 (c)          | D16/33     | 33     | 180    | I 25       | TSI 80 (c)          |
| TSP 100 (c)         | D28/43     | 43     | 240    | I 32       | TSI 100 (c)         |



1 mm = 0.03937 in.

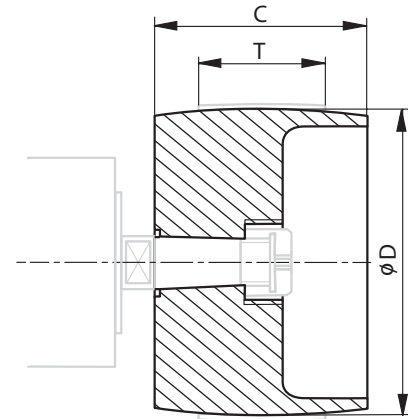
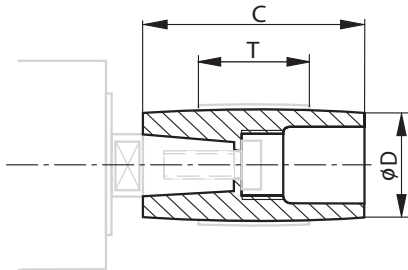
## Grinding Quill Selection Data

|   |        | Maximum speed [rpm] |       |       |       |
|---|--------|---------------------|-------|-------|-------|
| <b>Spindle nose interface: D 08/14 I 10</b> |        | H [mm]              |       |       |       |
| Spindle designation                         | K [mm] | < 16                | 20    | 25    | 32    |
| TSP 40 c                                    | 5      | 54000               |       |       |       |
| TSI 40 c                                    | 6      | 55000               | 53000 |       |       |
|   | 8      | 55000               | 55000 | 52000 | 50000 |
| TSP 40                                      | 5      | 45000               |       |       |       |
| TSI 40                                      | 6      | 45000               | 45000 |       |       |
|   | 8      | 45000               | 45000 | 45000 | 45000 |
| <b>Spindle nose interface: D 10/18 I 14</b> |        | H [mm]              |       |       |       |
| Spindle designation                         | K [mm] | < 25                | 32    | 40    |       |
| TSP 50 c                                    | 6      | 42000               |       |       |       |
| TSI 50 c                                    | 8      | 42000               | 42000 |       |       |
|   | 10     | 42000               | 42000 | 42000 |       |
| TSP 50                                      | 6      | 35000               |       |       |       |
| TSI 50                                      | 8      | 35000               | 35000 |       |       |
|   | 10     | 35000               | 35000 | 35000 |       |
| <b>Spindle nose interface: D 14/23 I 18</b> |        | H [mm]              |       |       |       |
| Spindle designation                         | K [mm] | < 32                | 40    | 50    | 63    |
| TSP 60 c                                    | 8      | 35000               |       |       |       |
| TSI 60 c                                    | 10     | 35000               | 35000 | 30000 |       |
|   | 13     | 35000               | 35000 | 35000 |       |
|   | 16     | 35000               | 35000 | 35000 | 35000 |
| TSP 60                                      | 8      | 30000               |       |       |       |
| TSI 60                                      | 10     | 30000               | 30000 | 30000 |       |
|   | 13     | 30000               | 30000 | 30000 |       |
|   | 16     | 30000               | 30000 | 30000 | 30000 |
| <b>Spindle nose interface: D 16/33 I 25</b> |        | H [mm]              |       |       |       |
| Spindle designation                         | K [mm] | < 63                | 80    |       |       |
| TSP 80 c                                    | 10     | 25000               |       |       |       |
| TSI 80 c                                    | 13     | 25000               | 25000 |       |       |
|   | 16     | 25000               | 25000 |       |       |
|   | 20     | 25000               | 25000 |       |       |
| TSP 80                                      | 10     | 20000               |       |       |       |
| TSI 80                                      | 13     | 20000               | 20000 |       |       |
|   | 16     | 20000               | 20000 |       |       |
|   | 20     | 20000               | 20000 |       |       |
| <b>Spindle nose interface: D 28/43 I 32</b> |        | H [mm]              |       |       |       |
| Spindle designation                         | K [mm] | < 80                | 100   | 125   | 160   |
| TSP 100 c                                   | 16     | 20000               |       |       |       |
| TSI 100 c                                   | 20     | 20000               | 20000 |       |       |
|   | 25     | 20000               | 20000 | 18000 |       |
|   | 32     | 20000               | 20000 | 20000 | 18000 |
| TSP 100                                     | 16     | 15000               |       |       |       |
| TSI 100                                     | 20     | 15000               | 15000 |       |       |
|   | 25     | 15000               | 15000 | 15000 |       |
|   | 32     | 15000               | 15000 | 15000 | 15000 |

1 mm = 0.03937 in.



## Pulleys



| For Spindle<br>TSA, TSI, TSP | Dimensions [mm]             |    |    |
|------------------------------|-----------------------------|----|----|
|                              | D                           | C  | T  |
| A 07                         | 14<br>28                    | 20 | 10 |
| A 08                         | 16<br>36                    | 25 | 15 |
| A 10                         | 18<br>50                    | 30 | 20 |
|                              | 17<br>20<br>25<br>63        | 40 |    |
|                              | 20<br>25<br>32<br>80        | 50 |    |
|                              | 25<br>32<br>40<br>100       | 60 |    |
| A 13                         | 40<br>45<br>50<br>56<br>125 | 70 | 50 |
|                              | 20<br>25<br>32<br>80        | 50 |    |
|                              | 25<br>32<br>40<br>100       | 60 |    |
|                              | 40<br>45<br>50<br>56<br>125 | 70 |    |
| A 18                         | 50<br>63<br>160             | 80 | 60 |
|                              | 25<br>32<br>40<br>100       | 60 |    |

| For Spindle<br>TSAV | Dimensions [mm] |     |     |
|---------------------|-----------------|-----|-----|
|                     | D               | C   | T   |
| V 12                | 40<br>50        | 40  | 30  |
| V 15                | 50<br>63        | 50  | 40  |
| V 20                | 63<br>80        | 60  | 50  |
| V 27                | 80<br>100       | 70  | 60  |
| V 38                | 80<br>125       | 80  | 50  |
| V 52                | 90<br>160       | 100 | 80  |
| V 56                | 120<br>210      | 100 | 80  |
| V 87                | 280             | 130 | 100 |

### Ordering Information:

Pulley **A** ■ - ■  
 Attachment **A 07 / A 08** etc.  
 Puller for pulley **A 07 / A 08** etc.

Pulley **V** ■ - ■  
 Attachment **V 12 / V 15** etc.  
 Puller for pulley **V 12 / V 15** etc.

### V 15 - V 27 (TSAV 50 - TSAV 80):

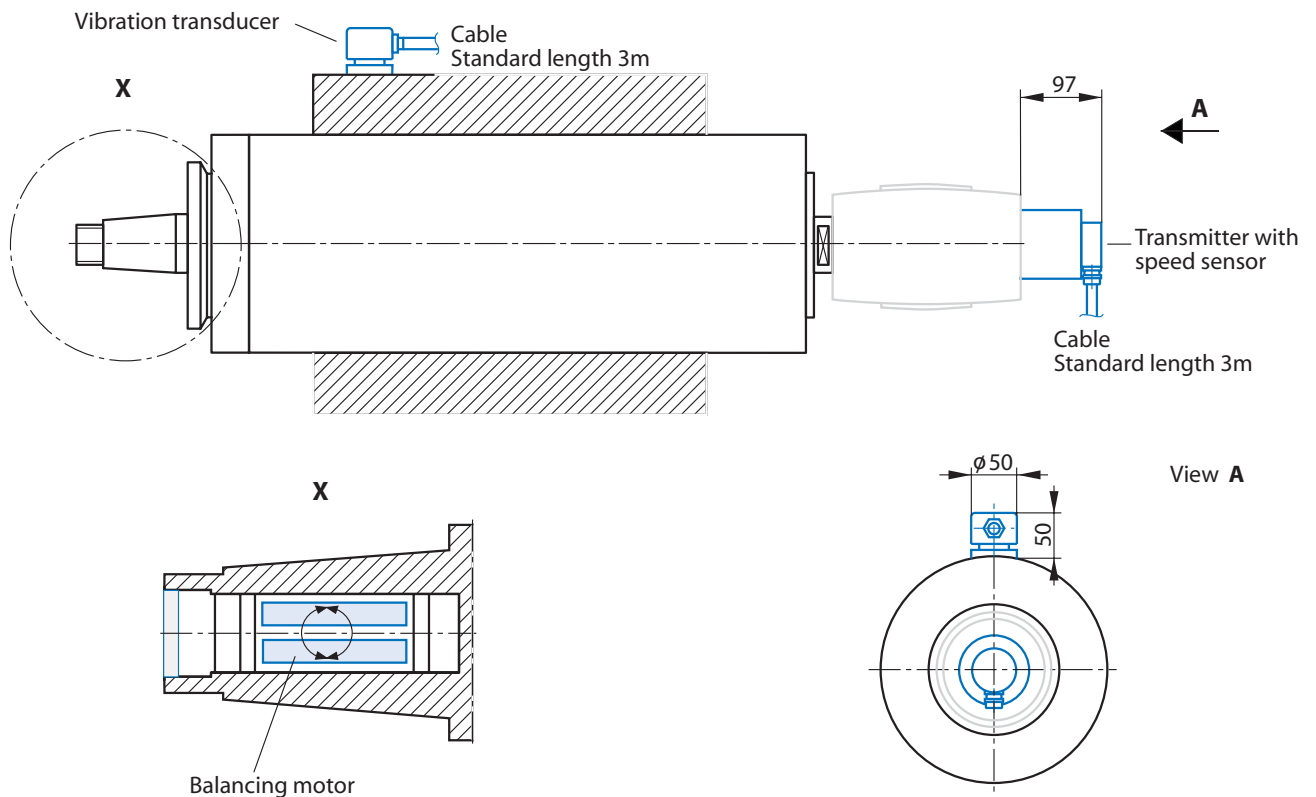
► Option: anti-rotation slot

### From V 38 (TSAV 100):

► Standard: anti-rotation slot

1 mm = 0.03937 in.

## TSAV - Balancing System



### Electromechanical balancing system TSAV-Spindles with housing diameter 160 and 200 mm

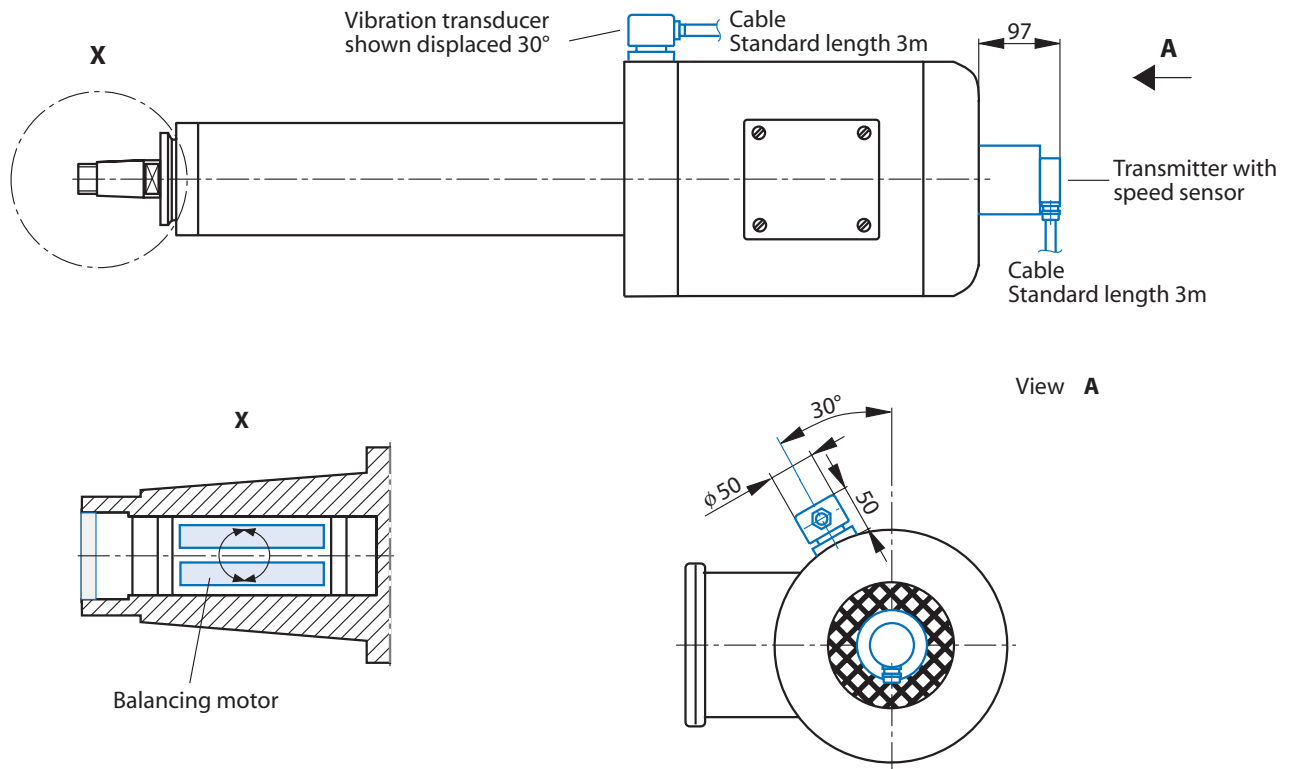
|                |                |
|----------------|----------------|
| TSAV 160 x 400 | TSAV 200 x 400 |
| TSAV 160 x 500 | TSAV 200 x 500 |
| TSAV 160 x 630 | TSAV 200 x 630 |

Consisting of: ▶ Balancing motor  
▶ Vibration transducer  
▶ Transmitter with speed sensor

Options: ▶ Extension cable for vibration transducer  
▶ Extension cable for balancing motor

Electronic control, see page 30.

## TSEV - Balancing System



### Electromechanical balancing system TSEV-Spindles with housing diameter 160 mm

TSEV 160 x 400 - ...  
TSEV 160 x 500 - ...

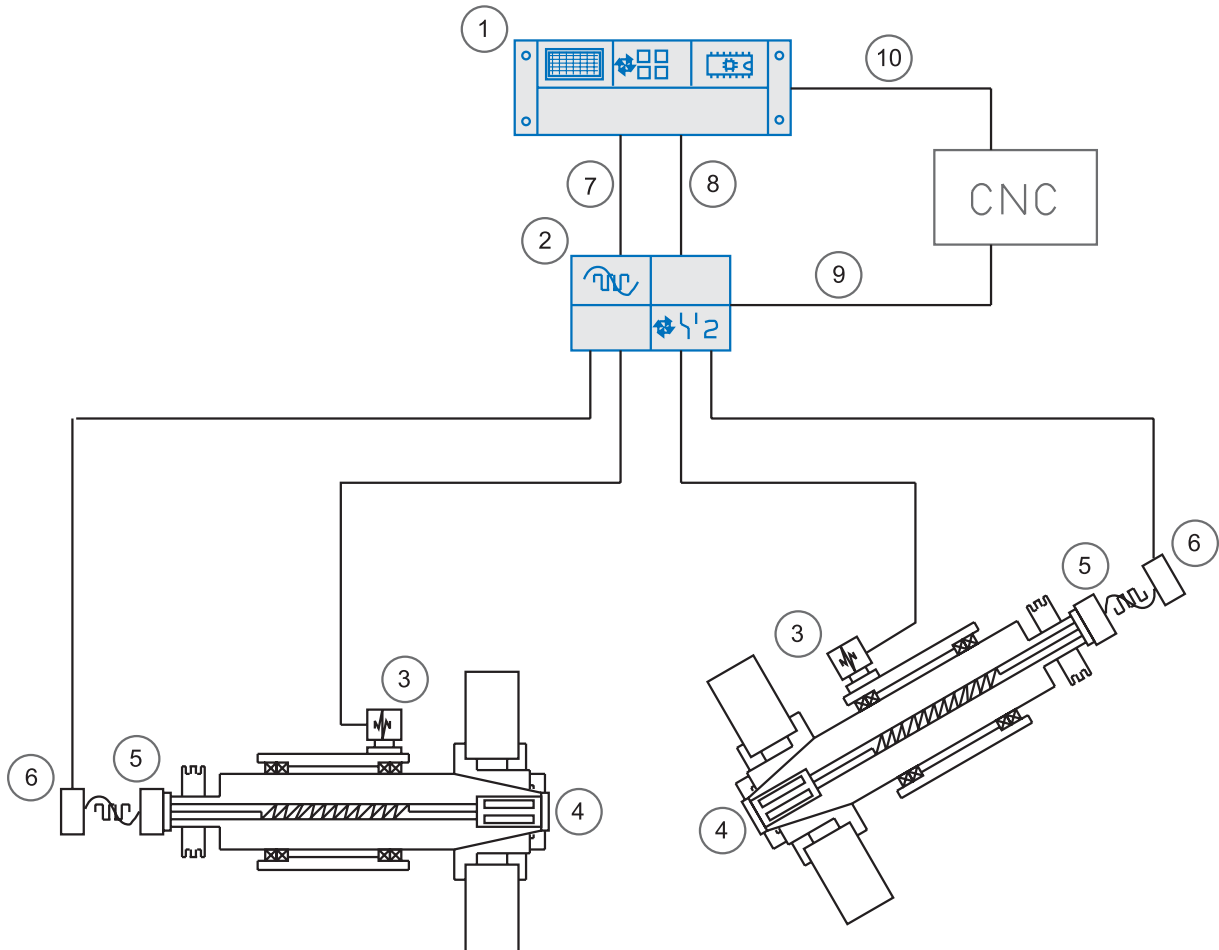
Consisting of: ▶ Balancing motor  
▶ Vibration transducer  
▶ Transmitter with speed sensor

Options: ▶ Extension cable for vibration transducer  
▶ Extension cable for balancing motor

Electronic control, see page 30.

## Balancing System

### Automatic Balancing System



If a condition of unbalance, e.g. in the series production of grinding disks, should be determined, monitored and eliminated, then the application of automatic counterbalancing electronics is recommended.

In this case it is also possible under economic aspects to monitor two spindles in alternating operation using one indication and control device as well as one switchover unit.

A few features of counterbalance systems for installation:

- ▶ Suitable for fitting in all grinding machines with hollow spindle
- ▶ Incorporation without problems
- ▶ Fully automatic balancing mass positioning
- ▶ Can be used completely in the wet area
- ▶ Collision-free balancing masses in quietly running 1-level-technique
- ▶ For speeds up to approx. 12,000 rpm

- ① Electronic control
- ② Multiplexer is required for multi spindle machines

Included in the delivery of the spindle:

- ③ Vibration transducer with 3m cable  
Option: Extension cable
- ④ Internal balancing sensor
- ⑤ Receiver
- ⑥ Transmitter with integrated speed sensor  
3m cable  
Option: Extension cable

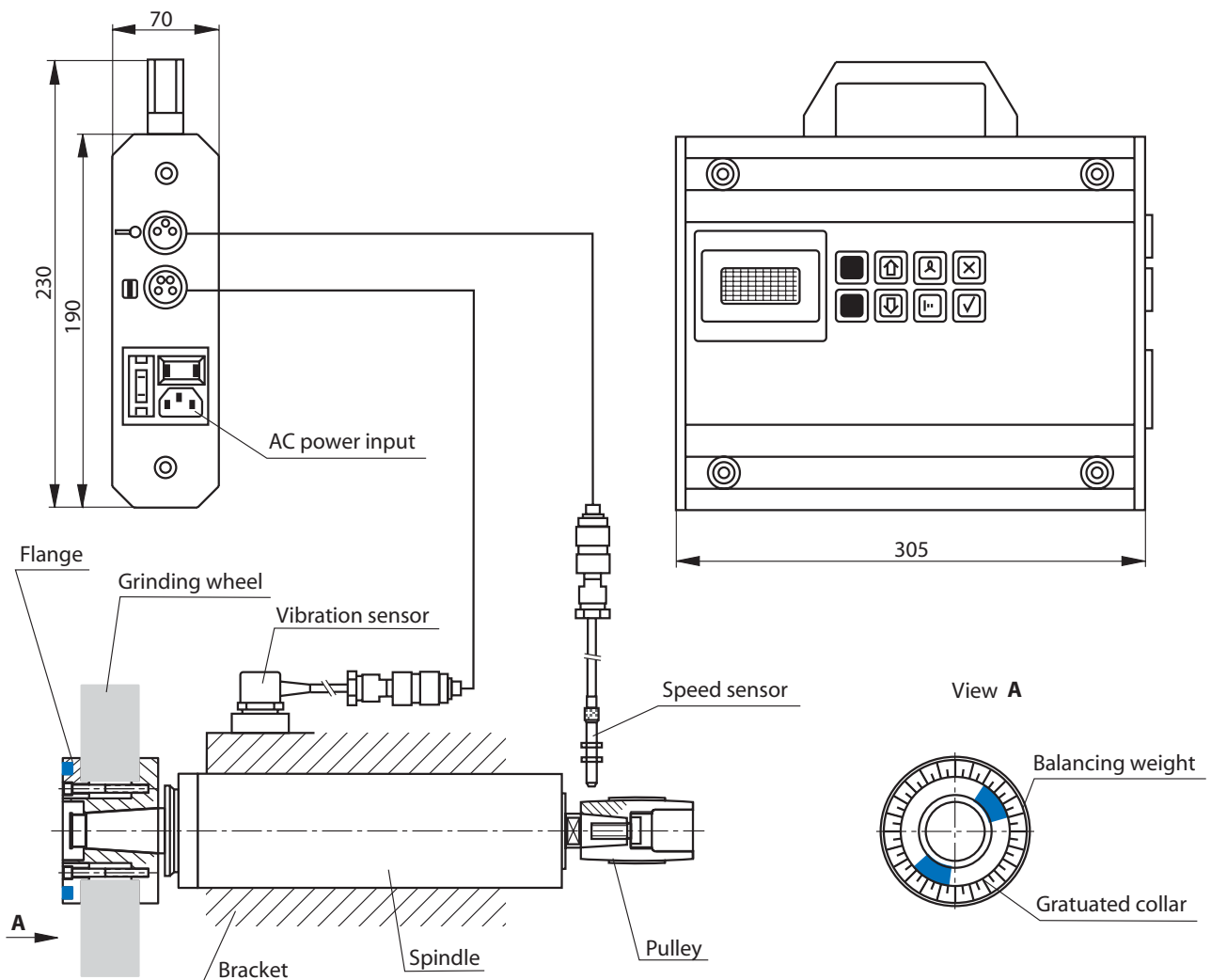
Accessories:

- ⑦ Extension cable
- ⑧ Extension cable
- ⑨ Extension cable
- ⑩ Extension cable

Please state length when ordering.

## Balancing System

### Portable Unit For Manual Balancing

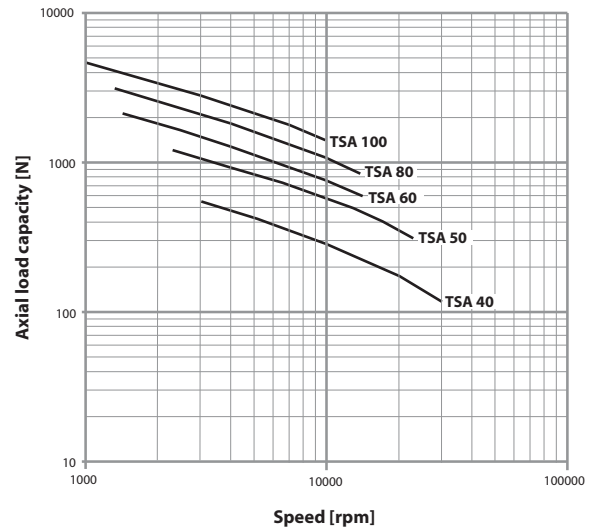
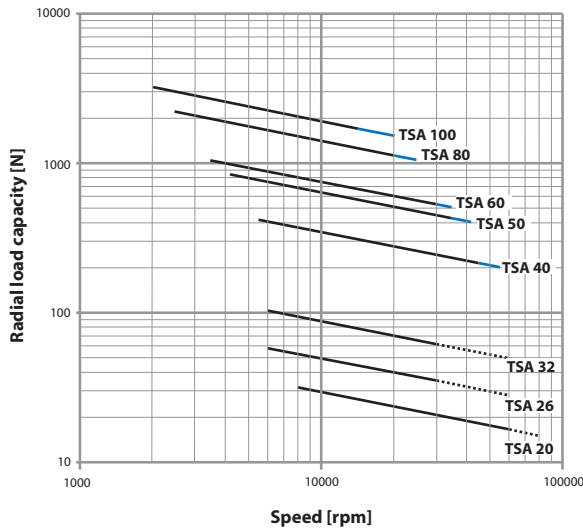


Every rotating part incorporates a degree of unbalance, which causes sinuous vibration during rotation. To reduce the effect of unbalancing forces, the unbalancing mass of all rotating parts has to be limited. Shafts and all rotating components of GMN high precision spindles are always balanced. As a result of higher cutting speeds this process is also required for tools. For large spindles automatic balancing systems are available. We recommend the portable balancing system for smaller spindles.

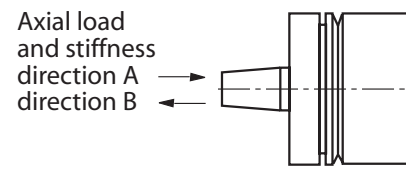
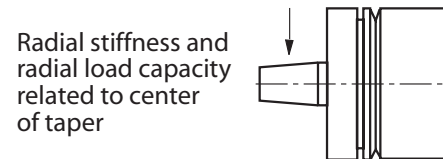
#### Process

- ▶ The vibration transducer with a magnetic base is attached to either the spindle housing or mounting bracket
- ▶ Speed sensor must be positioned to read the speed of the spindle
- ▶ Portable unit automatically:
  - ▶ Records the spindle speed
  - ▶ Records vibration levels
  - ▶ Indicates the amount and position of unbalance
  - ▶ Calculates and indicates the corrected results
- ▶ To fix the balancing weight
- ▶ Control and if necessary correction

## Stiffness - Load Capacity



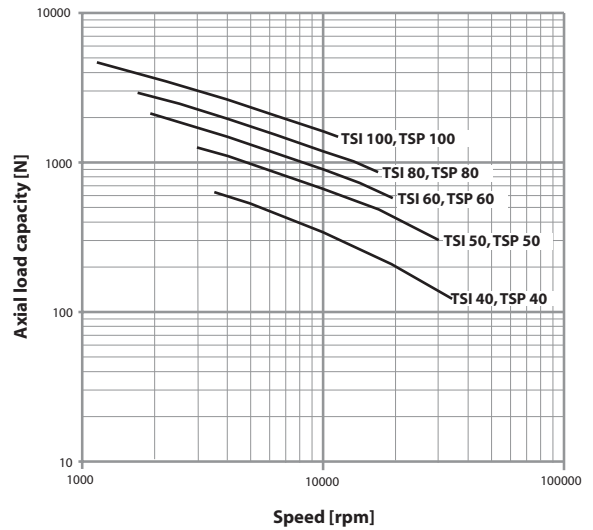
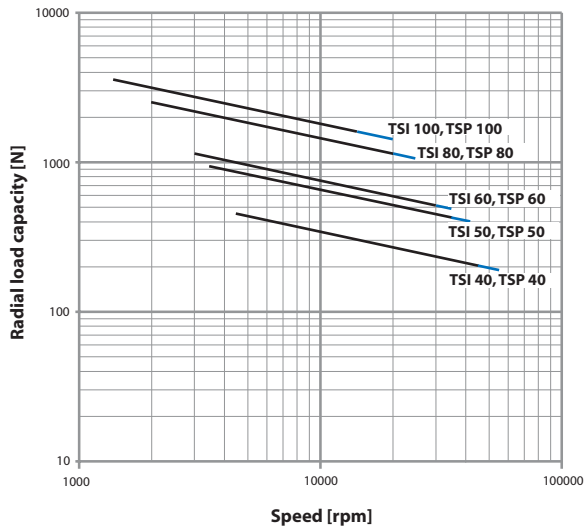
| Style        | Stiffness [N/μm] |        | Load capacity [N] |                  |             |
|--------------|------------------|--------|-------------------|------------------|-------------|
|              | axial<br>A u. B  | radial | A                 | B                | radial      |
| TSA 20 x 125 | 12               | 3.5    | 70 <sup>1)</sup>  | 35 <sup>1)</sup> | see diagram |
| TSA 20 x 160 |                  |        |                   |                  |             |
| TSA 20 x 200 | 17               | 3.5    | 70 <sup>1)</sup>  | 70 <sup>1)</sup> |             |
| TSA 20 x 250 |                  |        |                   |                  |             |
| TSA 26 x 125 | 14               | 5.0    | 70 <sup>1)</sup>  | 35 <sup>1)</sup> |             |
| TSA 26 x 160 |                  |        |                   |                  |             |
| TSA 26 x 200 |                  |        |                   |                  |             |
| TSA 26 x 250 | 20               | 5.0    | 70 <sup>1)</sup>  | 70 <sup>1)</sup> |             |
| TSA 26 x 315 |                  |        |                   |                  |             |
| TSA 32 x 125 | 15               | 8.0    | 70 <sup>1)</sup>  | 35 <sup>1)</sup> |             |
| TSA 32 x 160 |                  |        |                   |                  |             |
| TSA 32 x 200 |                  |        |                   |                  |             |
| TSA 32 x 250 | 21               | 8.0    | 70 <sup>1)</sup>  | 70 <sup>1)</sup> |             |
| TSA 32 x 315 |                  |        |                   |                  |             |
| TSA 32 x 355 |                  |        |                   |                  |             |
| TSA 40*      | 32               | 25     | see diagram       | 150              |             |
| TSA 50*      | 41               | 41     |                   | 225              |             |
| TSA 60*      | 51               | 57     |                   | 300              |             |
| TSA 80*      | 67               | 96     |                   | 450              |             |
| TSA 100*     | 78               | 113    | 540               |                  |             |



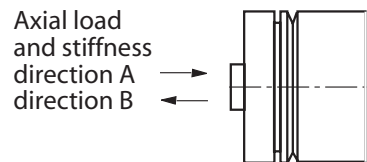
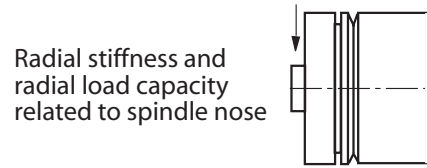
\* Data applicable to all spindle length.

<sup>1)</sup> For low speed operation (< 0.4 catalog specified speed). Axial load of 2 to 3 times higher than indicated can be applied, for short periods, depending on noise and vibration levels.

|        |                          |
|--------|--------------------------|
| 1 N    | = 0.2248 lb <sub>f</sub> |
| 1 N/μm | = 5710 lb./in.           |



| Style         | Stiffness [N/μm] |        | Load capacity [N] |     |                |
|---------------|------------------|--------|-------------------|-----|----------------|
|               | axial<br>A u. B  | radial | axial             |     | radial         |
|               |                  |        | A                 | B   |                |
| TSI / TSP 40  | 32               | 36     | see<br>diagram    | 150 | see<br>diagram |
| TSI / TSP 50  | 41               | 65     |                   | 225 |                |
| TSI / TSP 60  | 51               | 85     |                   | 300 |                |
| TSI / TSP 80  | 67               | 140    |                   | 450 |                |
| TSI / TSP 100 | 78               | 170    |                   | 540 |                |



Data applicable to all spindle lengths.

The data provided is to serve as a guide for the proper selection of spindles for a particular application.

The load capacities provided are for either pure radial or axial loads. Combined loads can not be used at the maximum values. Application should be analyzed by GMN Engineering Department for proper spindle selection.

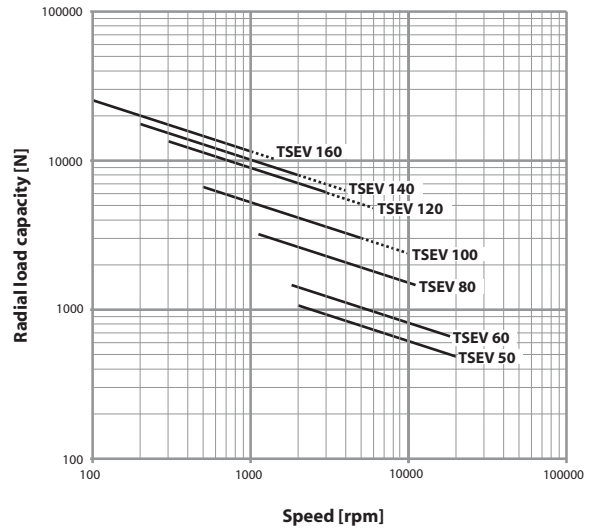
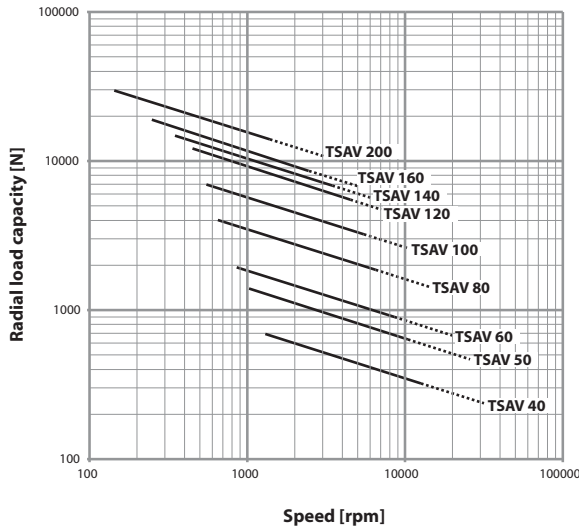
The data can be used as a reference to suit your application and selection of a spindle to meet your requirements. GMN Engineering should be provided with all pertinent data to review each application to provide the optimum spindle for your application.

5000 hours of B10 bearing life were used as a minimum for the calculation of spindle capacity.

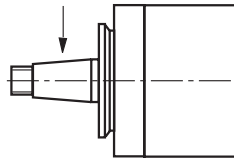
Axial and radial stiffness' calculation are static values.

|        |   |                        |
|--------|---|------------------------|
| 1 N    | = | 0.2248 lb <sub>f</sub> |
| 1 N/μm | = | 5710 lb./in.           |

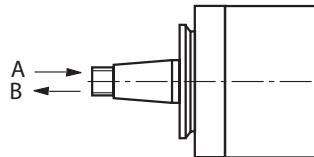
## Stiffness - Load Capacity



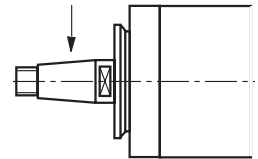
Radial stiffness and radial load capacity related to center of taper



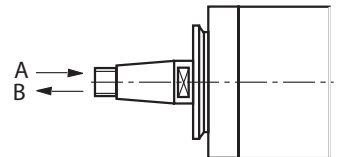
Axial load and stiffness in direction A and B is equal



Radial stiffness and radial load capacity related to center of taper



Axial load and stiffness in direction A and B is equal



| Style  | Stiffness [N/μm] |        | Load capacity [N]   |        | see diagram |
|--------|------------------|--------|---------------------|--------|-------------|
|        | axial            | radial | axial <sup>1)</sup> | radial |             |
| TS 40  | 56               | 29     | 300                 |        | see diagram |
| TS 50  | 75               | 37     | 600                 |        |             |
| TS 60  | 90               | 60     | 600                 |        |             |
| TS 80  | 133              | 75     | 1500                |        |             |
| TS 100 | 165              | 108    | 2400                |        |             |
| TS 120 | 212              | 170    | 3000                |        |             |
| TS 140 | 230              | 170    | 3600                |        |             |
| TS 160 | 300              | 245    | 4800                |        |             |
| TS 200 | 345              | 342    | 6000                |        |             |

| Style   | Stiffness [N/μm] |        | Load capacity [N]   |        | see diagram |
|---------|------------------|--------|---------------------|--------|-------------|
|         | axial            | radial | axial <sup>1)</sup> | radial |             |
| TSE 50  | 75               | 28     | 600                 |        | see diagram |
| TSE 60  | 90               | 45     | 600                 |        |             |
| TSE 80  | 133              | 56     | 1500                |        |             |
| TSE 100 | 165              | 80     | 2400                |        |             |
| TSE 120 | 212              | 132    | 3000                |        |             |
| TSE 140 | 230              | 132    | 3600                |        |             |
| TSE 160 | 300              | 195    | 4800                |        |             |

Data applicable to all spindle lengths.

Data applicable to all spindle lengths.

<sup>1)</sup> Axial load of 2 to 3 times higher than indicated can be applied, depending on noise and vibration levels.

1 N = 0.2248 lb<sub>f</sub>  
1 N/μm = 5710 lb./in.



## General Safety Rules

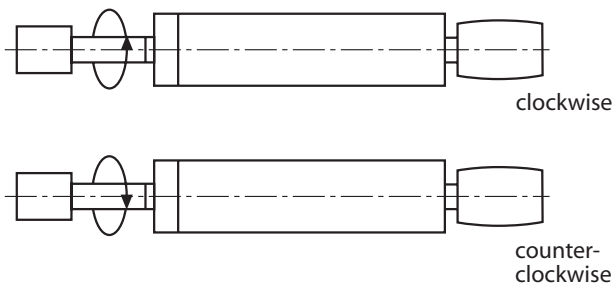
### Guidelines

Choosing the proper spindle and accessories is essential in obtaining quality grinding performance, long operating life, and operator safety.

GMN's extensive manufacturing program can satisfy all your requirements.

Selection criteria:

1. Choose the spindle with the largest diameter and the shortest length possible.
2. Choose quills, flanges and other wheel mounting accessories as large, robust and compact as possible.
3. Choose the largest spindle, with the necessary speed requirements, as recommended by the wheel manufacturer, or a spindle with slightly higher capabilities. This will assure maximum bearing life.
4. If possible always select a direct motorized style over the belt driven design. The total system is more compact, speed changes are effortless, and belt tensioning is eliminated.
5. Always provide the direction of rotation of the wheel, when looking into the pulley end of the spindle.

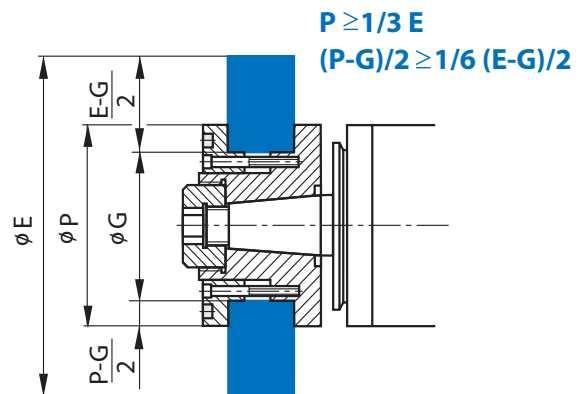


### Grinding Wheels

The grinding wheel sizes illustrated in the catalog correspond to DIN 69 120 standards. To select the proper wheel for each application, please consult with the wheel manufacturer.

Grinding wheel speeds and use must adhere to the corresponding regulations for safety. ANSI B7.1 "Safety Requirements for USE, Care and Protection of Abrasive Wheels".

Safety guards or protection hoods must be used when the wheel size reaches a 2 inch diameter and larger. For all internal grinding applications, hinged or swivel type wheel guards are required to protect the operator. Wheels must be mounted between steel or cast iron flanges, in compliance with the minimum dimensional size at various points, bearing area, reliefs and commonality as specified in the ANSI or DIN standards. Both flanges must be alike in diameter and bearing area. Mounting of wheels between dissimilar flanges is one of the most common causes of wheel failure. Flange diameters must not be less than 1/3 of the grinding wheel diameter. Wheels must be properly fit to spindles or mounting devices. Never force a wheel onto the mounting surface, also the fits should not be too loose. The clearances should be between 0.002" to 0.003" for small wheels and 0.010" to 0.012" for larger bores. Blotters (compressible washers – paper) shall always be used between the flanges and grinding wheels. Most wheels are supplied with blotters already mounted.



Small diameter wheels are cemented to the quill or arbors, which provides the following advantages.

No wheel breakage, due to tightening, better balance quality due to the elimination of locknuts, and a quieter operation, and smoother performance.

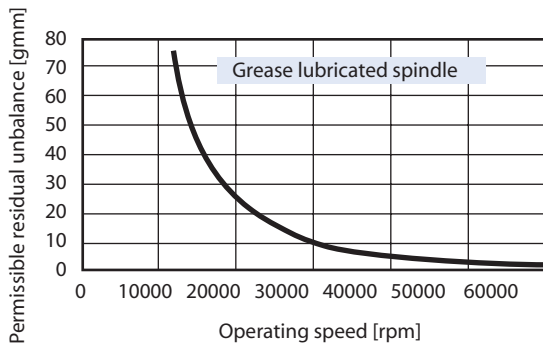
## General Safety Rules

### Unbalanced State

Every spindle shaft and every tool incorporates a degree of unbalance, which causes sinuous vibration during rotation. To reduce the effect of unbalancing forces, the unbalancing mass of all rotating parts has to be limited. Shafts of GMN high frequency spindles are always balanced.

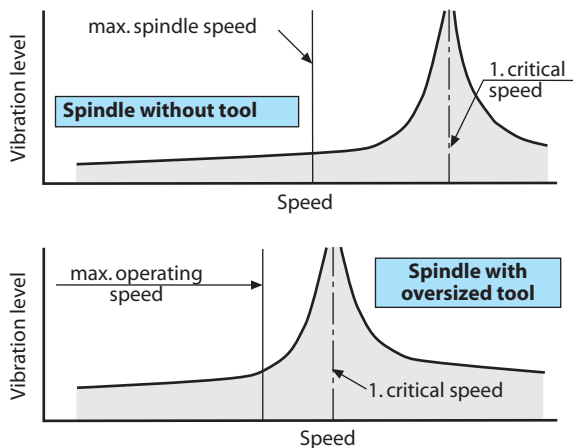
As a result of higher cutting speeds this process is also required for tools.

We recommend for precision cutting a permissible residual unbalance for tools according to the following diagram:



### Critical Speed

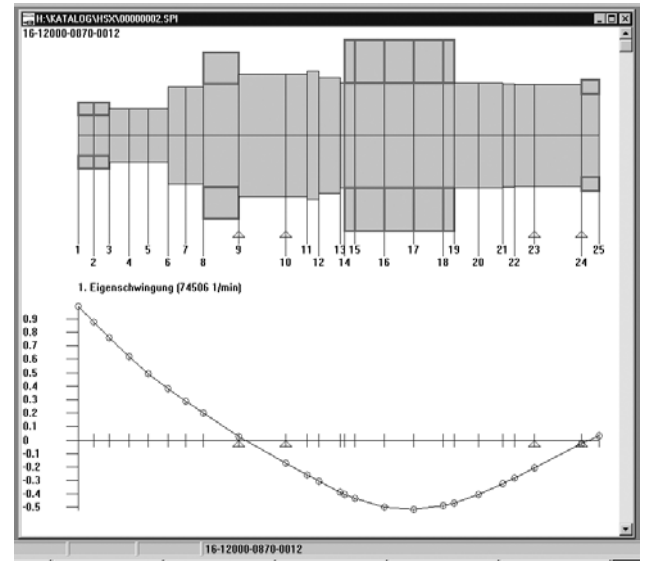
GMN machining spindles are designed so that the critical speeds remain above the maximum speed. When using inappropriate tooling the critical speed can be decreased to a level within the operating speed range. This can lead to poor part quality, decreased spindle performance, as well as jeopardizing the safety of the operator and machine.



We recommend consulting our application engineering staff when tools which are extremely long and heavy are to be used.

Let GMN analyse your spindle and tooling requirements with our specifically designed computer software. In addition to the critical frequencies the static and dynamic stiffness and load carrying capacity of each single bearing can be calculated.

Through proper analysis the correct spindle can be selected or tips for improvement of tools can be made.



### Centrifugal Forces Acting On Tools

Centrifugal forces created by high rotating speed not only act as unbalancing forces but also induce stress into the tool.

Insert type milling cutters are the worst case scenario, with the weakening of the screws or clamps, the carbide inserts can become projectiles.

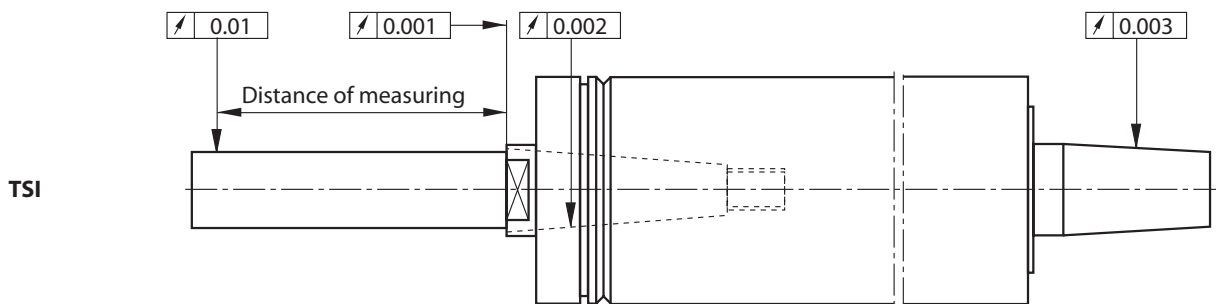
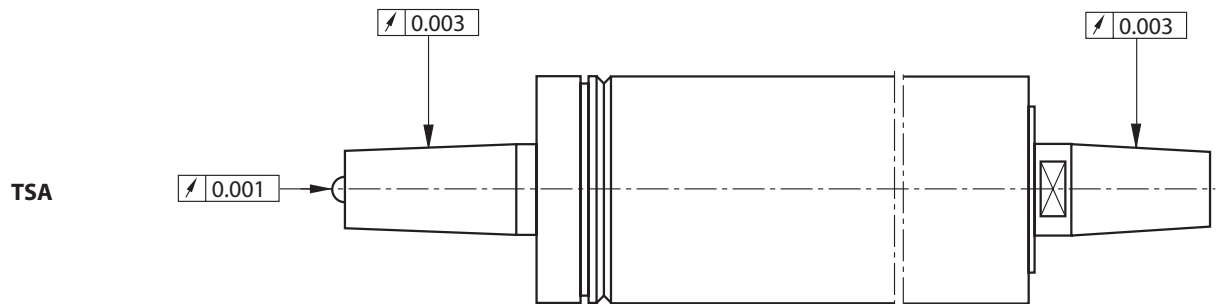
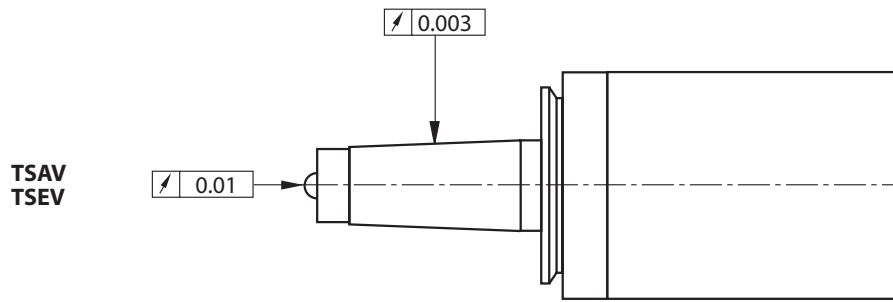
### Vibration Monitoring

Vibration monitoring equipment can less the risk of damage to both the spindle and machine, and also help prevent personnel injury by early detection of wear and looseness in both the spindle and tooling.

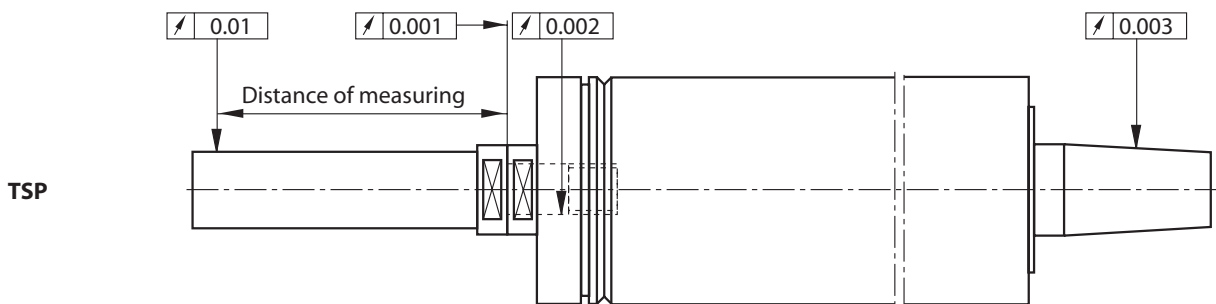
When selecting and installing monitoring equipment it should be noted that vibration from the machine and related components must be filtered out or ignored, so as to prevent unnecessary shut down of the machine.

1 mm = 0.03937 in.

## Radial And Axial Runout



Distance of measuring: five times taper dia. ( $k_1$ ) max. 100 mm (3.937 inch)



Distance of measuring: five times taper dia. (d) max. 100 mm (3.937 inch)

Spindles with increased radial and axial runout on request.

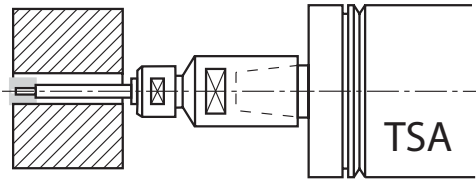


Fig. 1

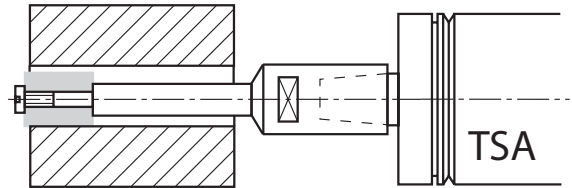
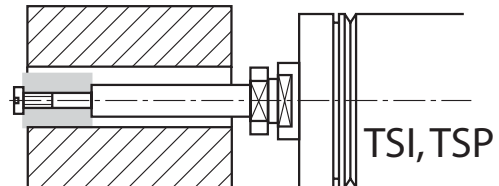
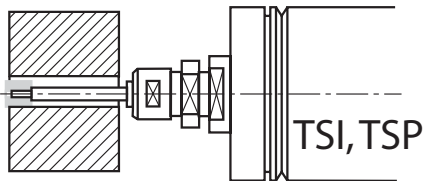


Fig. 2



For grinding bores **smaller** than the outside diameter of the chosen spindle style, the TSI or TSP spindle is recommended, because the wheel will be mounted closer to the bearing complement for better rigidity.

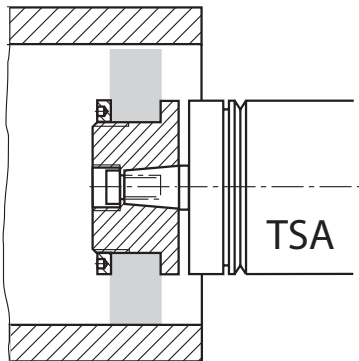


Fig. 3

For grinding bores **larger** than the outside diameter of the chosen spindle style, the TSA spindle is recommended, because the wheel will be mounted closer to the bearing complement for better rigidity.

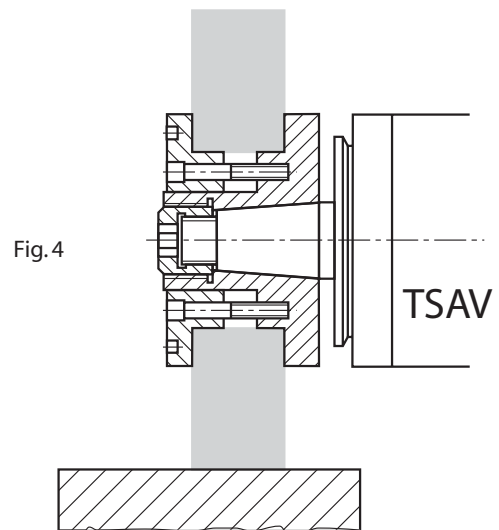


Fig. 4

For external and surface grinding the TSAV spindle is recommended, because the quad bearing arrangement, and external taper provide higher rigidity, and the uses of larger diameter wheels.