

# Stop Block Mounting

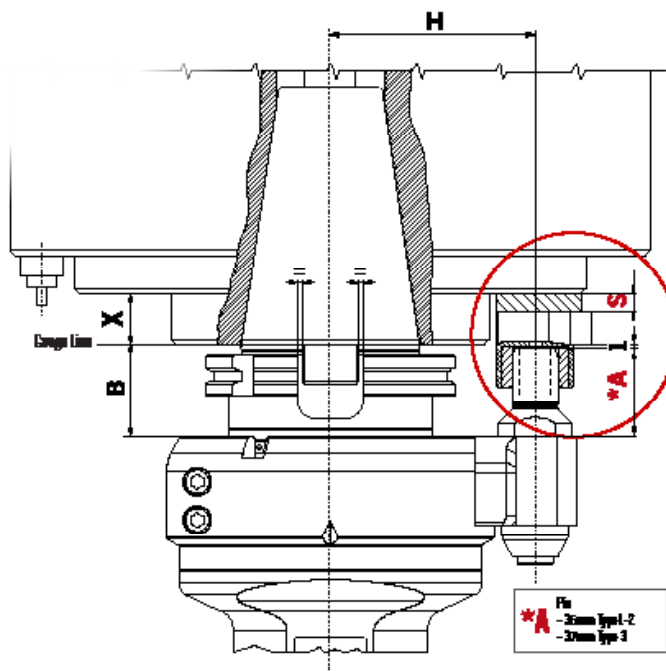
## CHECK SUITABILITY OF THE MACHINE TOOL SPINDLE TO MOUNT A STOP BLOCK.

### If stop block is already mounted on the machine tool.

1. Check the bushing diameter in the stop block (18mm or 28mm)
2. Calculate the "A" dimension based on the shank choices in the chart.  
Note "B" is calculated from Spindle Gage Line

### If no stop block is mounted on the machine spindle.

1. The standard positioning pin is OK and it will be necessary to make a spacer if dimension X is larger than the values indicated in table 1.
2. The positioning pin must be shortened if dimension X is (Incl.) between values indicated in table 1 (Max shortening 8mm with angle heads type 1 & 2, Max 6,5mm with angle heads type 3).
3. It will be necessary for a special positioning pin if dimension X is less than the values indicated in table 1.



**TABLE 1 - STANDARD 35 MM (TYPE 3 = 37 MM) SHORTENED S = 8 MM SPECIAL**

SHANKS	B	X	"S" CALCULATION FOR SPACER THICKNESS	X	"A" HEIGHT PIN CALCULATION	X
SK-CAT-BT30 SK-CAT-BT40 SK-CAT50	35	$X \geq 23,5$ mm	H = 65/80/110 - $\emptyset 18$ S = X-15,5 mm	24 > X > 16,5 mm	A = (X+B) -23,5	X < 16,
	37	$X \geq 24$ mm	H = 110 - $\emptyset 28$ S = X-16 mm		A = (X+B) -24	
BT50	43	$X \geq 15,5$ mm	H = 65/80/110 - $\emptyset 18$ S = X-7,5 mm	16 > X > 8,5 mm	A = (X+B) -23,5	16 > X > 8,5 mm
	45	$X \geq 16$ mm	H = 110 - $\emptyset 28$ S = X-8 mm		A = (X+B) -24	
HSK-63	44	$X \geq 14,5$ mm	H = 65/80/110 - $\emptyset 18$ S = X-6,5 mm	15 > X > 7,5 mm	A = (X+B) -23,5	15 > X > 7,5 mm
		$X \geq 15$ mm	H = 110 - $\emptyset 28$ S = X-7 mm		A = (X+B) -24	
HSK-80 HSK-100	46	$X \geq 12,5$ mm	H = 80/110 - $\emptyset 18$ S = X-4,5 mm	13 > X > 5,5 mm	A = (X+B) -23,5	13 > X > 5,5 mm
		$X \geq 13$ mm	H = 110 - $\emptyset 28$ S = X-5 mm		A = (X+B) -24	

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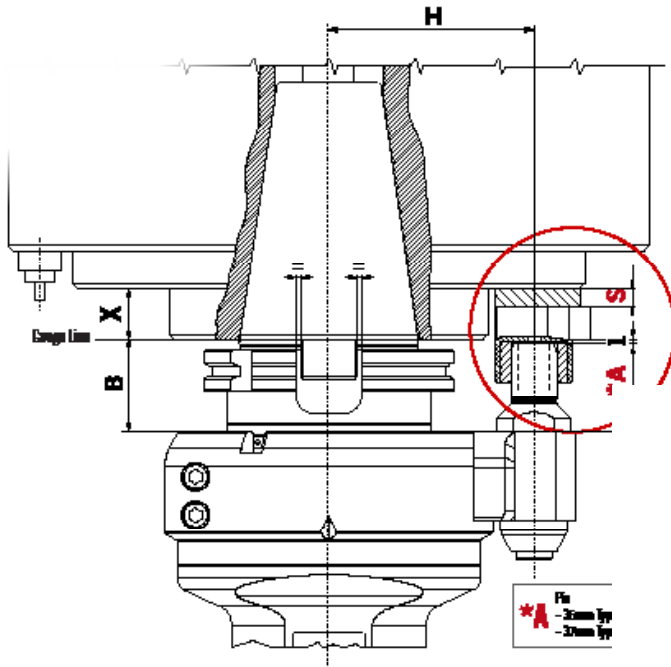


TABLE 2 Check pitch "H" through table 2  
MAX MACHINE SPINDLE DIAMETER  
FOR STANDARD PITCH

Pin	"H" Pitch	Ø Max
Ø18	65	Ø99
	80	Ø129
Ø28	80	Ø106
	110	Ø166

### ATTENTION!

The calculation for the location of the stop block must be done to allow 1 mm of free play remaining in the release pin travel. This will insure that the anti-rotation system is free to rotate without deflection caused by fixed length anti-rotation pin contact of the bottom of the stop block.

### EXAMPLE OF CALCULATION FOR SPACER THICKNESS

X = 23,5 mm

B = 35 mm (SK40)

$$S = X (23,5) - 15,5 = 8$$

N.B:

23,5 is also the minimum X to use the standard pin

8 is the spacer thickness

