

Accessories

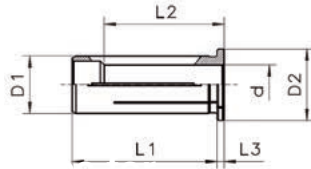
Reduction Sleeves for ETP Toolholders

The reduction sleeves are designed to fit with the ETP Toolholders. They are specially suited for high precision clamping of cylindrical tool shanks per DIN 6335 form HA, HB and HE, as well as tool shanks per DIN 1835 form B, C, D and E.

The special design of the reduction sleeves allows an efficient use of coolant through cutting tools.

Outer-Ø of reduction sleeve corresponds to the type.

HS12 = Ø 12 mm
 HS20 = Ø 20 mm
 HS25 = Ø 25 mm
 HS32 = Ø 32 mm



Benefits and features

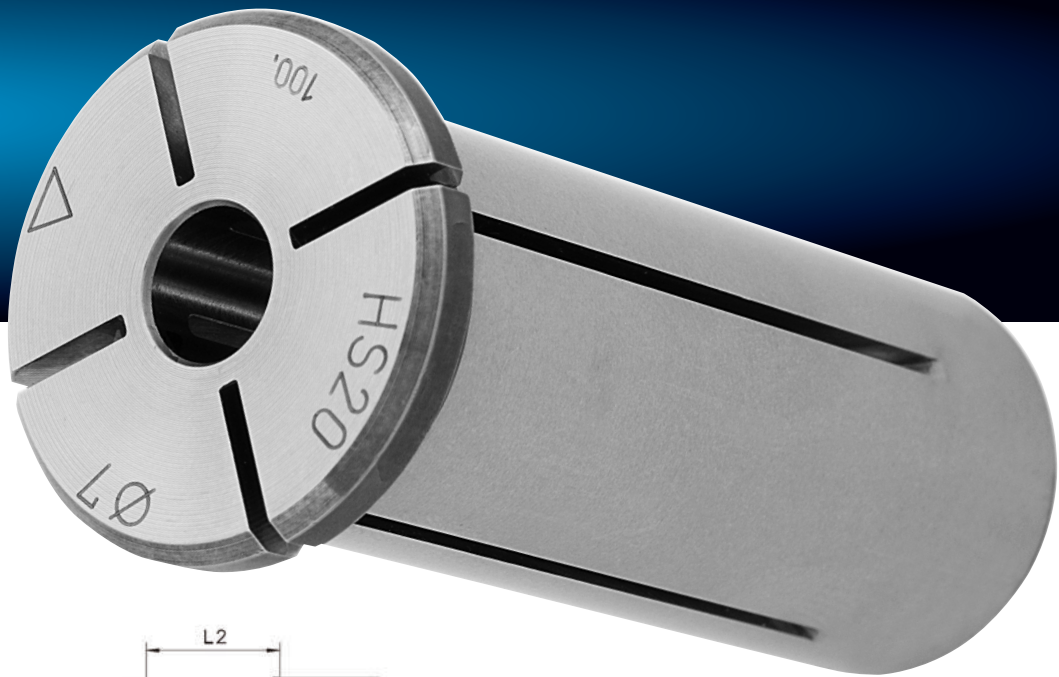
- **Standard version HS suited for internal cooling**
 Metal-to-metal seal for cutting tools with internal coolant channels.
- **HS-CF version suited for peripheral cooling**
 The coolant flush reduction sleeves HS-CF can be used for peripheral cooling due to their coolant channels.
- **Accurate precision**
 High runout accuracy < 3 µm.
- **High flexibility**
 Clamping of different tool shank diameters. 12, 20, 25, 32 mm and 1/2", 3/4", 1", 1 1/4".
- **Power increase**
 When using reduction sleeves the transmittable torque is increased.

Reduction Sleeves mm to mm

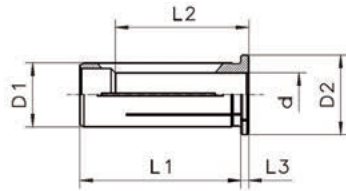
Item description	d [mm]	Part no.	D1 [mm]	D2 [mm]	L1 [mm]	L2 [mm]	L3 [mm]
Reduction Sleeves HS 12-MB (Micro Bore)							
○ HS 12-MB / Ø 1.00	1.000	R1912.01009	12	16	40	20	4
○ HS 12-MB / Ø 1.50	1.500	R1912.01509	12	16	40	20	4
○ HS 12-MB / Ø 2.00	2.000	R1912.02009	12	16	40	20	4
○ HS 12-MB / Ø 2.50	2.500	R1912.02509	12	16	40	20	4
Reduction Sleeves HS 12							
● HS 12 / Ø 3.00	3.000	R1912.03000	12	16	40	29	4
● HS 12 / Ø 4.00	4.000	R1912.04000	12	16	40	29	4
● HS 12 / Ø 5.00	5.000	R1912.05000	12	16	40	29	4
● HS 12 / Ø 6.00	6.000	R1912.06000	12	16	40	36	4
○ HS 12 / Ø 7.00	7.000	R1912.07000	12	16	40	37	4
○ HS 12 / Ø 8.00	8.000	R1912.08000	12	16	40	37	4
○ HS 12 / Ø 9.00	9.000	R1912.09000	12	16	40	37	4
● HS 12 / Ø 10.00	10.000	R1912.10000	12	16	40	40	4

Reduction Sleeves mm to mm

Item description	d [mm]	Part no.	D1 [mm]	D2 [mm]	L1 [mm]	L2 [mm]	L3 [mm]
Reduction Sleeves HS 12-CF							
○ HS 12-CF / Ø 3.00	3.000	R1912.03002	12	16	40	29	4
○ HS 12-CF / Ø 4.00	4.000	R1912.04002	12	16	40	29	4
○ HS 12-CF / Ø 5.00	5.000	R1912.05002	12	16	40	29	4
○ HS 12-CF / Ø 6.00	6.000	R1912.06002	12	16	40	36	4
○ HS 12-CF / Ø 8.00	8.000	R1912.08002	12	16	40	37	4
Reduction Sleeves HS 20							
● HS 20 / Ø 3.00	3.000	R1920.03000	20	25	50	28	4
● HS 20 / Ø 4.00	4.000	R1920.04000	20	25	50	28	4
● HS 20 / Ø 5.00	5.000	R1920.05000	20	25	50	28	4
● HS 20 / Ø 6.00	6.000	R1920.06000	20	25	50	36	4
○ HS 20 / Ø 7.00	7.000	R1920.07000	20	25	50	38	4
○ HS 20 / Ø 8.00	8.000	R1920.08000	20	25	50	37	4
○ HS 20 / Ø 9.00	9.000	R1920.09000	20	25	50	38	4
● HS 20 / Ø 10.00	10.000	R1920.10000	20	25	50	40	4
○ HS 20 / Ø 11.00	11.000	R1920.11000	20	25	50	40	4
● HS 20 / Ø 12.00	12.000	R1920.12000	20	25	50	45	4
○ HS 20 / Ø 13.00	13.000	R1920.13000	20	25	50	45	4
○ HS 20 / Ø 14.00	14.000	R1920.14000	20	25	50	45	4
○ HS 20 / Ø 15.00	15.000	R1920.15000	20	25	50	45	4
● HS 20 / Ø 16.00	16.000	R1920.16000	20	25	50	48	4
● HS 20 / Ø 18.00	18.000	R1920.18000	20	25	50	48	4
Reduction Sleeves HS 20-CF							
○ HS 20-CF / Ø 3.00	3.000	R1920.03002	20	25	50	28	4
○ HS 20-CF / Ø 4.00	4.000	R1920.04002	20	25	50	28	4
○ HS 20-CF / Ø 5.00	5.000	R1920.05002	20	25	50	28	4
○ HS 20-CF / Ø 6.00	6.000	R1920.06002	20	25	50	36	4
○ HS 20-CF / Ø 8.00	8.000	R1920.08002	20	25	50	37	4
○ HS 20-CF / Ø 10.00	10.000	R1920.10002	20	25	50	40	4
○ HS 20-CF / Ø 12.00	12.000	R1920.12002	20	25	50	45	4
○ HS 20-CF / Ø 14.00	14.000	R1920.14002	20	25	50	45	4
○ HS 20-CF / Ø 16.00	16.000	R1920.16002	20	25	50	48	4
Reduction Sleeves HS 25							
● HS 25 / Ø 3.00	3.000	R1925.03000	25	30	56	29	4
● HS 25 / Ø 4.00	4.000	R1925.04000	25	30	56	29	4
● HS 25 / Ø 5.00	5.000	R1925.05000	25	30	56	29	4
● HS 25 / Ø 6.00	6.000	R1925.06000	25	30	56	37	4
○ HS 25 / Ø 7.00	7.000	R1925.07000	25	30	56	37	4
● HS 25 / Ø 8.00	8.000	R1925.08000	25	30	56	37	4
○ HS 25 / Ø 9.00	9.000	R1925.09000	25	30	56	38	4
● HS 25 / Ø 10.00	10.000	R1925.10000	25	30	56	40	4
● HS 25 / Ø 12.00	12.000	R1925.12000	25	30	56	46	4
● HS 25 / Ø 14.00	14.000	R1925.14000	25	30	56	47	4
● HS 25 / Ø 16.00	16.000	R1925.16000	25	30	56	48	4
● HS 25 / Ø 18.00	18.000	R1925.18000	25	30	56	48	4
● HS 25 / Ø 20.00	20.000	R1925.20000	25	30	56	50	4
Reduction Sleeves HS 32							
○ HS 32 / Ø 3.00	3.000	R1932.03000	32	36	60	29	4
○ HS 32 / Ø 4.00	4.000	R1932.04000	32	36	60	29	4
○ HS 32 / Ø 5.00	5.000	R1932.05000	32	36	60	29	4
● HS 32 / Ø 6.00	6.000	R1932.06000	32	36	60	36	4
○ HS 32 / Ø 7.00	7.000	R1932.07000	32	36	60	37	4
● HS 32 / Ø 8.00	8.000	R1932.08000	32	36	60	36	4
○ HS 32 / Ø 9.00	9.000	R1932.09000	32	36	60	37	4
● HS 32 / Ø 10.00	10.000	R1932.10000	32	36	60	40	4
○ HS 32 / Ø 11.00	11.000	R1932.11000	32	36	60	40	4
● HS 32 / Ø 12.00	12.000	R1932.12000	32	36	60	45	4
○ HS 32 / Ø 13.00	13.000	R1932.13000	32	36	60	45	4
● HS 32 / Ø 14.00	14.000	R1932.14000	32	36	60	46	4
○ HS 32 / Ø 15.00	15.000	R1932.15000	32	36	60	46	4
● HS 32 / Ø 16.00	16.000	R1932.16000	32	36	60	48	4
○ HS 32 / Ø 17.00	17.000	R1932.17000	32	36	60	48	4
● HS 32 / Ø 18.00	18.000	R1932.18000	32	36	60	49	4
○ HS 32 / Ø 19.00	19.000	R1932.19000	32	36	60	49	4
● HS 32 / Ø 20.00	20.000	R1932.20000	32	36	60	50	4
● HS 32 / Ø 22.00	22.000	R1932.22000	32	36	60	50	4
● HS 32 / Ø 25.00	25.000	R1932.25000	32	36	60	56	4
Reduction Sleeves HS 32-CF							
○ HS 32-CF / Ø 6.00	6.000	R1932.06002	32	36	60	36	4
○ HS 32-CF / Ø 8.00	8.000	R1932.08002	32	36	60	36	4
○ HS 32-CF / Ø 10.00	10.000	R1932.10002	32	36	60	40	4
○ HS 32-CF / Ø 12.00	12.000	R1932.12002	32	36	60	45	4
○ HS 32-CF / Ø 14.00	14.000	R1932.14002	32	36	60	46	4
○ HS 32-CF / Ø 16.00	16.000	R1932.16002	32	36	60	48	4
○ HS 32-CF / Ø 18.00	18.000	R1932.18002	32	36	60	49	4
○ HS 32-CF / Ø 20.00	20.000	R1932.20002	32	36	60	50	4
○ HS 32-CF / Ø 25.00	25.000	R1932.25002	32	36	60	56	4



Outer-Ø of reduction sleeve corresponds to the type.
 HS 1/2" = Ø 1/2"
 HS 3/4" = Ø 3/4"
 HS 1" = Ø 1"
 HS 1 1/4" = Ø 1 1/4"



Reduction Sleeves inch to inch

Item description	d [inch"]	Part no.	D1 [inch"]	D2 [mm]	L1 [mm]	L2 [mm]	L3 [mm]
Reduction Sleeves HS 1/2"							
● HS 1/2" / 1/8"	.1250"	R1913.03182	.500"	16	40	29	4
● HS 1/2" / 3/16"	.1875"	R1913.04762	.500"	16	40	29	4
● HS 1/2" / 1/4"	.2500"	R1913.06352	.500"	16	40	36	4
● HS 1/2" / 5/16"	.3125"	R1913.07942	.500"	16	40	37	4
● HS 1/2" / 3/8"	.3750"	R1913.09522	.500"	16	40	40	4
Reduction Sleeves HS 3/4"							
● HS 3/4" / 1/8"	.1250"	R1919.03182	.750"	25	50	28	4
● HS 3/4" / 3/16"	.1875"	R1919.04762	.750"	25	50	28	4
● HS 3/4" / 1/4"	.2500"	R1919.06352	.750"	25	50	36	4
● HS 3/4" / 5/16"	.3125"	R1919.07942	.750"	25	50	37	4
● HS 3/4" / 3/8"	.3750"	R1919.09522	.750"	25	50	36	4
● HS 3/4" / 7/16"	.4375"	R1919.11112	.750"	25	50	40	4
● HS 3/4" / 1/2"	.5000"	R1919.12702	.750"	25	50	45	4
● HS 3/4" / 9/16"	.5625"	R1919.14292	.750"	25	50	45	4
● HS 3/4" / 5/8"	.6250"	R1919.15882	.750"	25	50	48	4
Reduction Sleeves HS 1"							
● HS 1" / 1/8"	.1250"	R1926.03182	1.000"	30	56	29	4
○ HS 1" / 3/16"	.1875"	R1926.04762	1.000"	30	56	29	4
● HS 1" / 1/4"	.2500"	R1926.06352	1.000"	30	56	37	4
○ HS 1" / 5/16"	.3125"	R1926.07942	1.000"	30	56	37	4
● HS 1" / 3/8"	.3750"	R1926.09522	1.000"	30	56	38	4
○ HS 1" / 7/16"	.4375"	R1926.11112	1.000"	30	56	40	4
● HS 1" / 1/2"	.5000"	R1926.12702	1.000"	30	56	46	4
○ HS 1" / 9/16"	.5625"	R1926.14292	1.000"	30	56	47	4
● HS 1" / 5/8"	.6250"	R1926.15882	1.000"	30	56	48	4
○ HS 1" / 11/16"	.6875"	R1926.17462	1.000"	30	56	48	4
● HS 1" / 3/4"	.7500"	R1926.19052	1.000"	30	56	48	4
Reduction Sleeves HS 1 1/4"							
○ HS 1 1/4" / 3/16"	.1875"	R1931.04762	1.250"	36	60	29	4
○ HS 1 1/4" / 1/4"	.2500"	R1931.06352	1.250"	36	60	36	4
○ HS 1 1/4" / 5/16"	.3125"	R1931.07942	1.250"	36	60	36	4
● HS 1 1/4" / 3/8"	.3750"	R1931.09522	1.250"	36	60	37	4
○ HS 1 1/4" / 7/16"	.4375"	R1931.11112	1.250"	36	60	45	4
● HS 1 1/4" / 1/2"	.5000"	R1931.12702	1.250"	36	60	45	4
○ HS 1 1/4" / 9/16"	.5625"	R1931.14292	1.250"	36	60	46	4
● HS 1 1/4" / 5/8"	.6250"	R1931.15882	1.250"	36	60	46	4
○ HS 1 1/4" / 11/16"	.6875"	R1931.17462	1.250"	36	60	48	4
● HS 1 1/4" / 3/4"	.7500"	R1931.19052	1.250"	36	60	50	4
○ HS 1 1/4" / 1"	1.000"	R1931.25402	1.250"	36	60	56	4

● From stock
 ○ On request

Reduction Sleeves mm to inch

Item description	d [inch"]	Part no.	D1 [mm]	D2 [mm]	L1 [mm]	L2 [mm]	L3 [mm]
Reduction Sleeves HS 12							
● HS 12 / 1/8"	.1250"	R1912.03181	12	16	40	29	4
● HS 12 / 3/16"	.1875"	R1912.04761	12	16	40	29	4
● HS 12 / 1/4"	.2500"	R1912.06351	12	16	40	29	4
● HS 12 / 5/16"	.3125"	R1912.07941	12	16	40	36	4
● HS 12 / 3/8"	.3750"	R1912.09521	12	16	40	37	4
Reduction Sleeves HS 20							
● HS 20 / 1/8"	.1250"	R1920.03181	20	25	50	28	4
● HS 20 / 3/16"	.1875"	R1920.04761	20	25	50	28	4
● HS 20 / 1/4"	.2500"	R1920.06351	20	25	50	36	4
● HS 20 / 5/16"	.3125"	R1920.07941	20	25	50	37	4
● HS 20 / 3/8"	.3750"	R1920.09521	20	25	50	36	4
● HS 20 / 7/16"	.4375"	R1920.11111	20	25	50	40	4
● HS 20 / 1/2"	.5000"	R1920.12701	20	25	50	45	4
● HS 20 / 9/16"	.5625"	R1920.14291	20	25	50	45	4
● HS 20 / 5/8"	.6250"	R1920.15881	20	25	50	48	4
Reduction Sleeves HS 25							
● HS 25 / 1/8"	.1250"	R1925.03181	25	30	56	29	4
○ HS 25 / 3/16"	.1875"	R1925.04761	25	30	56	29	4
● HS 25 / 1/4"	.2500"	R1925.06351	25	30	56	37	4
○ HS 25 / 5/16"	.3125"	R1925.07941	25	30	56	37	4
● HS 25 / 3/8"	.3750"	R1925.09521	25	30	56	38	4
○ HS 25 / 7/16"	.4375"	R1925.11111	25	30	56	40	4
● HS 25 / 1/2"	.5000"	R1925.12701	25	30	56	46	4
○ HS 25 / 9/16"	.5625"	R1925.14291	25	30	56	47	4
● HS 25 / 5/8"	.6250"	R1925.15881	25	30	56	48	4
○ HS 25 / 11/16"	.6875"	R1925.17461	25	30	56	48	4
● HS 25 / 3/4"	.7500"	R1925.19051	25	30	56	48	4
○ HS 25 / 13/16"	.8125"	R1925.20631	25	30	56	50	4
Reduction Sleeves HS 32							
○ HS 32 / 3/16"	.1875"	R1932.04761	32	36	60	29	4
○ HS 32 / 1/4"	.2500"	R1932.06351	32	36	60	36	4
○ HS 32 / 5/16"	.3125"	R1932.07941	32	36	60	36	4
● HS 32 / 3/8"	.3750"	R1932.09521	32	36	60	37	4
○ HS 32 / 7/16"	.4375"	R1932.11111	32	36	60	45	4
● HS 32 / 1/2"	.5000"	R1932.12701	32	36	60	45	4
○ HS 32 / 9/16"	.5625"	R1932.14291	32	36	60	46	4
● HS 32 / 5/8"	.6250"	R1932.15881	32	36	60	46	4
○ HS 32 / 11/16"	.6875"	R1932.17461	32	36	60	48	4
● HS 32 / 3/4"	.7500"	R1932.19051	32	36	60	50	4
○ HS 32 / 13/16"	.8125"	R1932.20631	32	36	60	50	4
● HS 32 / 7/8"	.8750"	R1932.22221	32	36	60	50	4
○ HS 32 / 15/16"	.9375"	R1932.23811	32	36	60	52	4
● HS 32 / 1"	1.000"	R1932.25401	32	36	60	56	4