



Shrink Fit Heating Machine

RATED VOLTAGE	POWER	CURRENT
AC220	6KW	16A

PRODUCT CODE	TYPE	SIZE (W×D×H)	CLAMP DIAMETER	INNER COIL DIAMETER	KG
SF-DRU-6K	Small Diameter	540×400×780mm	ø4~20	50mm	25
SF-DRU-6K2	Large Diameter	540×400×780mm	ø4~32	68mm	25

SF-DRU-6K2
Electromagnetic
Coil



Model	Diameter Range	Height (mm)	Inner Diameter (mm)	Outer Diameter (mm)	Black Wire (mm)	Red Wire (mm)	Blue Wire (mm)
H325	4-12mm	42	35	128	24	32	/
H655	12-25mm	62	55	135	30	37	47
H668	25-32mm	62	68	144	/	/	48



Type	Contents of the Attached Product Set	QUANTITY
6K	Positioning rings ø4,ø6,ø8,ø10,ø12,ø16,ø20	1 set
	Heat-resistant gloves	1 pair
	Pliers (scratch-resistant blade type)	1 piece
6K2	Positioning rings ø4,ø6,ø8,ø10,ø12,ø16,ø20,ø25,ø32	1 set
	Heat-resistant gloves	1 pair
	Pliers (scratch-resistant blade type)	1 piece

Accessories Included with Equipment

Optional Add-ons



Positioning Ring

Model No.	øD
HP-K4	4
HP-K6	6
HP-K8	8
HP-K10	10
HP-K12	12
HP-K16	16
HP-K20	20
HP-K25	25
HP-K30	30



Conversion Lock Set

Taper	Model No.
For BT	BT30
	SH-BT40
For HSK	SH-HSK25
	SH-HSK32
	SH-HSK40
	SH-HSK50
	SH-HSK63



Heating Ring

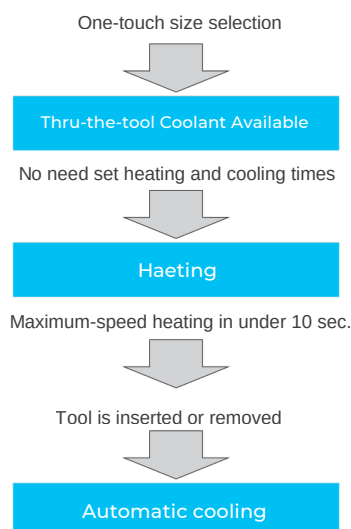
Model No.	Compatible Coil	Applicable Diameter
HG55SR1216	H655	ø12-ø16
HG55SR1825	H655	ø18-ø25
HG68SRC2532	H655	ø25-ø32

Further reduces heating time.

ACCESSORY

HIGH-FREQUENCY INDUCTION HEATER

(CONSOLE MODEL, AUTOMATIC TYPE)



Heating and cooling times for each holder (standard) are set by the sequencer. Settings for special holders are also possible.

- Specifications: Compatible with cemented carbide, high-speed steel, and steel tools

Model	SF-DRU-15K
Dimensions	690mm (W) × 500mm (L) × 1780mm (H)
High-frequency output	15KW
Input power supply	AC200V (3-phase)
Power supply capacity	60A (18KVA) [at max. output]
Air source	For cylinder raising and lowering. For on-machine tooling cooling
Air capacity	0.4MPa (200L/min)
Weight	About 100kg
Applicable holder shank shape(standard)	BT40 • 50 / HSK-63 • 100
Applicable holder size	SF04 ~ SF50.8 (regular type holders, etc.)
Applicable tool shank diameter and tolerance	Ø4 ~ Ø50.8 / h6 tolerance within h6
Included standard coils (3 types)	For SF04 to SF12, SF16 to SF32, and SF42 to SF50.8
Tool insertion and removal direction	Upward
Upwardraising&lowering mechanism and stroke	Automatic type : 700MM

※For cemented carbide and steel tools, specifications will vary depending on the holder shape ; please inquire for details.

- Heating time

Holder size	Tool shank	Heating time
SF04 ~ SF12	Ø4 ~ Ø12	Under 10 seconds
SF16 ~ SF32	Ø16 ~ Ø32	
SF42 ~ SF50.8	Ø42 ~ Ø50.8	

Heating coil (same coil be used for models SF-DRU-15K and SF-DRU-S15K)

- Compatible with tool shank diameters of 4 to 50.8mm using 3 types of standard coils (model SF-DRU-15K)
- Compatible with tool shank diameters of 4 to 12mm using 1 types of standard coils (model SF-DRU-S15K)
- Connector type for easy replacement.

Optional Coil

- Special shapes require separate consultation.
(For example, one coil can support TY-type holders from SF06 to SF32.)

ACCESSORY

HIGH-FREQUENCY INDUCTION HEATER (CONSOLE MODEL, MANUAL TYPE)

Manual setting of heating conditions

- Heating time setting
- Output (output power) setting



Heating

Maximum-speed heating in under 10 sec.



Tool is inserted or removed



Manual cooling

Compatible with optional on machine air cooling



- Specifications: Compatible with cemented carbide, high-speed steel, and steel tools

Model	SF-DRU-S15K
Dimensions	690mm (W) × 550mm (L) × 1445mm (H)
High-frequency output	15KW
Input power supply	AC200V (3-phase)
Power supply capacity	60A (18KVA) [at max. output]
Air source	For coil cooling ※ optional (For on-machine tooling cooling)
Air capacity	0.4MPa (200L/min)
Weight	About 80kg
Applicable holder shank shape(standard)	BT40 • 50 / HSK-63 • 100
Applicable holder size	SF04 ~ SF50.8 (regular type holders, etc.)
Applicable tool shank diameter and tolerance	Ø4 ~ Ø12 / h6 tolerance within h6 ※ optional (Ø 16 to Ø 50.8) tolerance within h6
Included standard coils (3 types)	For SF04 to SF12
Tool insertion and removal direction	Upward
Upwardraising&lowering mechanism and stroke	Automatic type : 700MM

※For cemented carbide and steel tools, specifications will vary depending on the holder shape ; please inquire for details.

- Heating time

Holder size	Tool shank	Heating time
SF04 ~ SF12	Ø 4 ~ Ø 12	Under 10 seconds
SF16 ~ SF32	Ø 16 ~ Ø 32	
SF42 ~ SF50.8	Ø 42 ~ Ø 50.8	

Heating coil (same coil can be used for models SF-DRU-15K and SF-DRU-S15K)

- Compatible with tool shank diameters of 4 to 50.8mm using 3 types of standard coils (model SF-DRU-15K)
- Compatible with tool shank diameters of 4 to 12mm using 1 types of standard coils (model SF-DRU-S15K)
- Connector type for easy replacement.

Optional Coil

- Inquire regarding special shapes
(One-coil capability for SF06 to SF32 TY Type holders, etc.)

ACCESSORY

HIGH-FREQUENCY INDUCTION HEATER (BENCH MODEL, MANUAL TYPE)

FEATURES

- Lightweight, compact shrinking tooling system that is both user-friendly and eco-friendly and can be used anywhere the single included standard.
- Coil enables cemented carbide cutting tools with a shank diameter of 4 to 12mm to be mounted.
- The only operation required is to set the appropriate heating time for the tool holder, no bothersome adjustment.

Model	SF-DRU-1.2KT
Dimensions	480mm (W) × 500mm (L) × 790mm (H)
High-frequency output	1200W
Input power supply	※ AC200V 50/60Hz
Power supply capacity	10A
Weight	About 20kg
Applicable holder shank shape(standard)	Ø4 ~ Ø12 / h6 tolerance within h6 ※ optional (Ø 16 to Ø 50.8) tolerance within h6
Applicable holder size	BT40 • 50 / HSK-63 • 100
Applicable tool shank diameter and tolerance	SF04 ~ SF20 (New slimtype, Tytype holders)
Included standard coils (1 types)	Ø 4 ~ Ø 20 tolerance within h6
Tool insertion and removal direction	Upward
Upward raising & lowering mechanism and stroke	Manual type ; 400mm



● Heating time

Holder size		Tool shank diameter	Heating time
Main type	Size	Ø 4 ~ Ø 20	20 to 35 seconds
New slim	SF04 ~ SF20		
TY			
Straight			

※Will vary according to the holder's shape and the tool's shank tolerance.

ACCESSORY

EXAMPLE OF COOLING SYSTEM USE (SF-DRU-15K + CA-1116A COOLING UNIT)

This cooling system comprises a cooling head for force-cooling the holder chuck after high temperature heat expansion for shrink fitting, and a cooling unit that supplies cooling head.

■ How the cooling system is used.

Simply place the cooling head on the shrink fitting holder and cooling begins immediately.

※The cooling unit and SF-DRU-15K high-frequency induction heater are sold separately.



ACCESSORY COOLING UNIT (HEATER NOT INCLUDED)

FEATURES

This cooling unit force-cools the cooling head and holder chuck after high temperature heat expansion for shrink fitting.

The CA-1115a cooling unit can be used with the 3 types of high-frequency induction heaters.

Model	CA-1116A
Dimensions	354mm (W) × 384mm (L) × 851mm (H)
Weight	About 41kg
Rated power supply	AC100V



ACCESSORY COOLING HEAD AND ADAPTORS

Cooling head	φD	φd	L	Cooling adaptors	Applicable holders (examples)
CL-HD-090	90	33	65	CL-AD-090-04 -AD-090-06 -AD-090-08 -AD-090-10 -AD-090-12	SBT40-SF04-090-NS -SF06-090-NS -SF08-090-NS -SF10-090-NS -SF12-090-NS
CL-HD-120	120	55	65	CL-AD-120-06 -AD-120-08 -AD-120-10 -AD-120-12 -AD-120-16 -AD-120-20 -AD-120-25	SBT50-SF06-090-N -SF08-090-N -SF10-090-N -SF12-090-N -SF16-105-N -SF20-105-N -SF25-105-N
CL-HD-125	125	46	110	-CL-AD-125-04 -AD-125-06 -AD-125-08 -AD-125-10 -AD-125-12 -AD-125-16 -AD-125-20 -AD-125-25 -	SBT50-SF04-175-N-TY -SF06-175-N-TY -SF08-175-N-TY -SF10-175-N-TY -SF12-175-N-TY -SF16-175-N-TY -SF20-175-N-TY -SF25-175-N-TY -SF32-175-N-TY
CL-HD-150	150	85	100	CL-AD-150-32 -AD-150-42 -AD-150-50.8	SBT50-SF32-105-N -SF42-120-N -SF50.8-115-N

