

Long Series Power Collet Chuck for Bar Machining

Long Body/Wide Range

High accuracy spring collets require a longer body design but Klamp collet chuck design ensures that all external dimensions have been optimised to provide maximum tool clearance. Gripping capacities of the series range from 1.6mm to 80mm

High Speed

Direct mount design ensures high concentricity suitable for higher speed operations.

First & Second Operation Collet Chuck

Klamp CRL collet chucks are suitable for spring, varibore and rubberflex collets increasing its flexibility. Varibore and rubberflex collets allow rough, unfinished bar to be machined in the first operation and spring collets can be used for high accuracy in the second operation.

Fixed Length Collet

Workpiece remains in a fixed position during actuation allowing for precise z-axis positioning. A tapered sleeve is pushed forward, compressing the collet and gripping the workpiece.

Problem Free Installation

Klamp collet chucks are provided with mounting bolts and an optional custom machined drawtube connector allowing you to start using the Klamp collet chuck straight out of the box.



Quick & Easy Mounting

Klamp collet chucks mount directly to the lathe spindle or use a precision adaptor plate to ensure a consistent mounting without the need for correction. The precision fit of the Klamp collet chuck enhances the rigidity of the overall system. The need for adjustment is minimal, meaning less machine downtime.

Long service life

All Klamp collet chucks are case hardened, optimising the rigidity, strength and durability.

Adjustable Collets Mounted Workstop for Spring Collets



- Easy to use, installation time – less than one minute
- Available for D173E (Part No: **WS-D173E**) and D185E (Part No: **WS-D185E**) spring collet types
- Suitable for round, square and hexagon spring collets
- No deformation of collet shank
- No influence on clamping characteristics of collet or collet chuck

Designed for Bar Pushers/Barfeeders

Fixed-length Klamp collet chucks are designed to work with bar loaders and bar feeders by not interfering with the process of the bar feeder action.



3 Different Collet Types Available



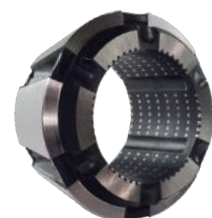
Spring Collets*

Suited for second operation work, collets are size matched according to gripped diameters, enabling you to have a high gripping accuracy. Collets can be supplied as smooth or serrated as required.



Varibore Collets**

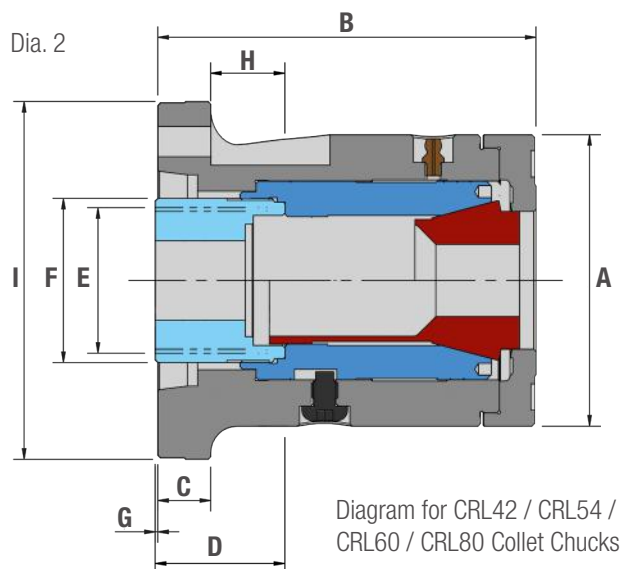
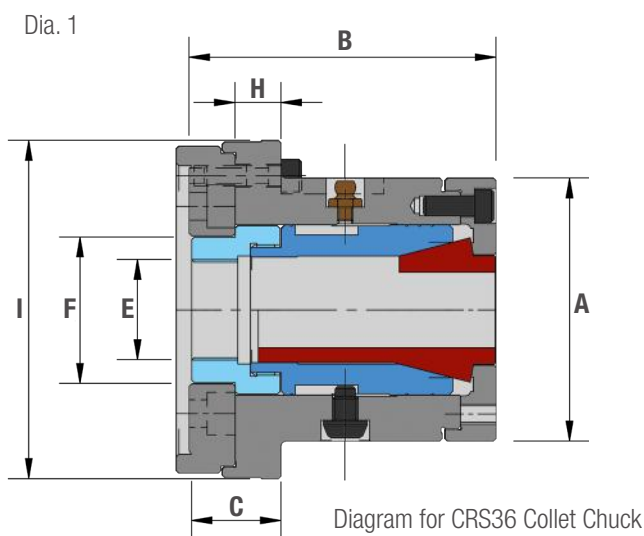
Ideal for first operation work as they have a 2-3mm gripping range enabling you to handle rough bar. Supplied either as smooth, serrated or super grip.



Rubberflex Collets***

The same accuracy specification as spring collets. Elastic rubber-metal vulcanization allows a clamping range of +/- 1mm to the nominal diameter.

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KLAMP Type		CRS36	CRL42		CRL54	CRL60			CRL80		
Mounting		Z115	Z140	A5	A6	A6	Z170	A6	A8	Z220	A8
Part Number		CRS36	CRL42	CRL42A5	CRL42A6	CRL54A6	CRL60	CRL60A6	CRL60A8	CRL80	CRL80A8
Spring Collet Type		D171E	D173E		D853	D185E			D193E		
Spring Collet Gripping Range *	Minimum	1.6	2		2	3			12		
	Maximum	36	42		54	60			80		
Spring Collet Increments		0.5	0.5		0.5	0.5			0.5		
Varibore Collet Type		D671	D673		D120	D677			D660		
Varibore Collet Gripping range**	Minimum	4	4		4	4			12		
	Maximum	36	42		53.9	60			80		
Varibore Collet Increments		2	2		3	2			3		
Rubberflex Collet Type		-	DRFC673		-	DRFC677			-		
Rubberflex Collet Gripping Range***	Minimum	-	7*		-	19*			-		
	Maximum	-	43*		-	65*			-		
Rubberflex Collet Increments		-	2		-	2			-		
A		105	110		138	138			190		
B		125	128	143	145	166	143	160	156	170	176
C		18	20	20	30	27	24	27	36	19	25
D		35	49		48	48			63		
E Maximum		M50 x 1.5	M55 x 1.5		M70 x 1.5	M70 x 1.5			M90 x 2.0		
F		58	62		80	80			100		
G Maximum		-1	16	1	-1	-2	15	-2	2	48	42
		-8	9	-6	-8	-12	8	-9	-5	36	30
G Minimum		-8	9	-6	-8	-12	8	-9	-5	36	30
		-8	9	-6	-8	-12	8	-9	-5	36	30
H		18	18	28	19	23	14	23	9	13	13
I		135	160	135	165	165	190	165	210	230	220
Sleeve stroke		7	7		10	7			12		
Max. input force	kN	18	25		30	30			45		
Max. Gripping Force	kN	36	55		60	60			78		
Max. Speed	min ⁻¹	7000	7100		6300	6300			4500		
Net Weight	kg	8	9	9.5	11	16	15.2	16	19	30	30
Matching Kitagawa Cylinders		S1036	S1246		S1552	S1552/S1875			S2091		

* See pages 14-18 for more Spring Collet information.

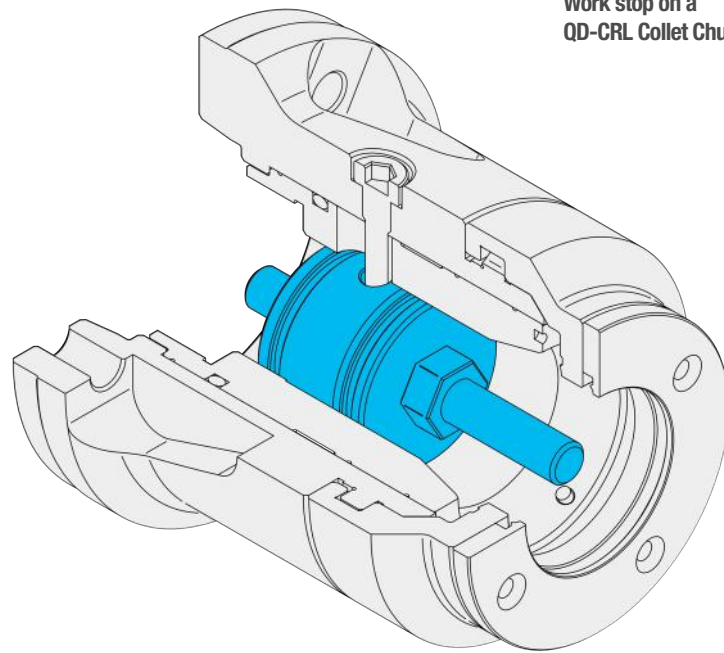
** See pages 22-23 for more Varibore Collet information.

*** DRFC673 Rubber-flex collets are only suitable for the CRL42 Collet chuck and are available in smooth and full grip versions (smooth version is only available for 11mm diameters and smaller). DRFC677 Rubber-flex collets are only suitable for the CRL60 Collet chuck and are available in smooth and full grip versions (smooth version is only available for 61mm diameters and larger). See pages 24-25 for more information.

QC & C Series Standard Accessories

Work Stops

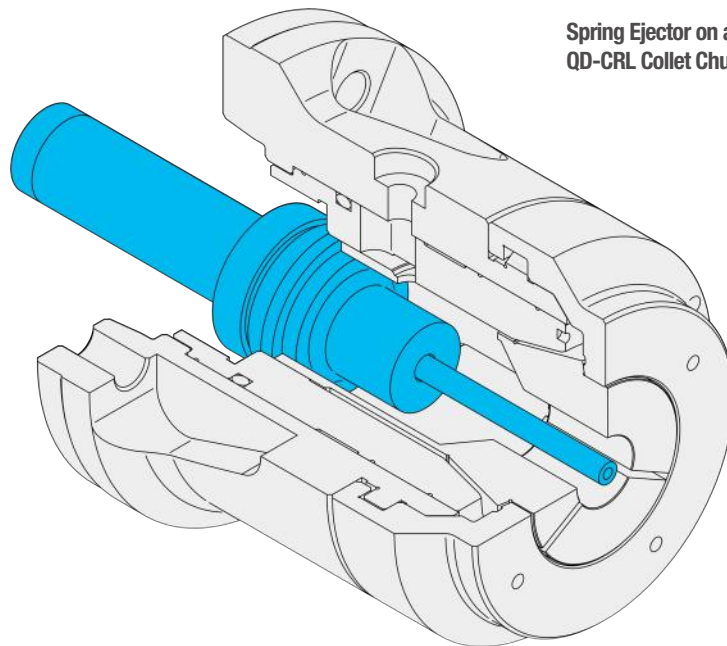
- Stops can be provided to allow for accurate z-axis positioning of short workpieces within the collet chuck.
- A threaded stud is provided for easy adjustment to suit your work piece
- All stops are easily installed from the front face utilising a side bolt to hold the stop securely in place.
- These stops can be installed on all QC & C series collet chucks.
- Full length spindle stops can also be provided for long work pieces, these can utilise the entire length of your machine spindle, please contact your Klamp supplier to see the maximum length stop your machine could accommodate.



Work stop on a QD-CRL Collet Chuck

Spring Ejectors

- Standard spring ejectors for QC & C series are used for second-spindle operations to expel finished workpieces into the parts catcher.
- Many variants of spring ejector are available to suit your production process.
- Spring ejectors can be installed on all QC & C series collet chucks.
- Full length hydraulic or pneumatic ejectors can also be provided for long work pieces, this can utilise the entire length of your machine spindle, please contact your Klamp supplier to see the maximum length stop your machine could accommodate.



Spring Ejector on a QD-CRL Collet Chuck