

**Short Series Power Collet Chuck for Bar Machining**

**Short Body/Wide Range**

Varibore & rubber-flex collets allow for a compact body design maximising the lathe work envelope. Gripping capacities of the series range from 3 mm to 66mm

**High Speed**

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

**First Operation Collet Chuck**

Klamp CRS collet chucks are suitable for collets which have a large gripping range. Allowing the collet chuck to handle very rough and unfinished bar, preparing it for a high accuracy 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.



**Designed for Bar Pushers/ Barfeeders**



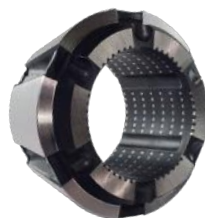
Fixed-length Klamp collet chucks are designed to work with bar loaders and bar feeders by not interfering with the process of the bar feeder action.

**2 Different Collet Types Available**



**Varibore Collets\*\***

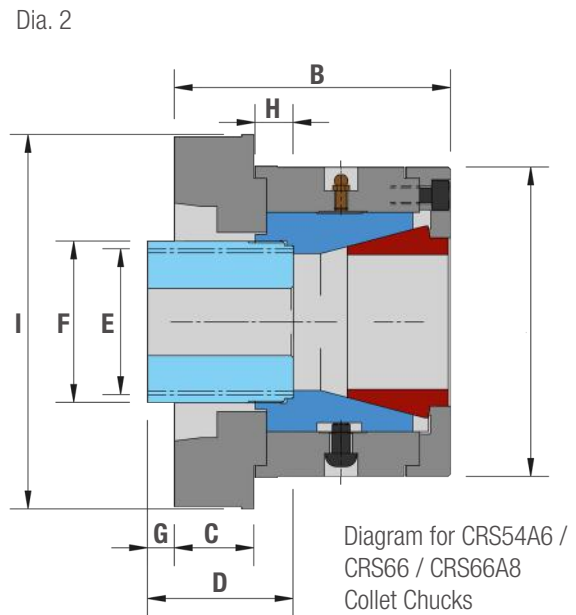
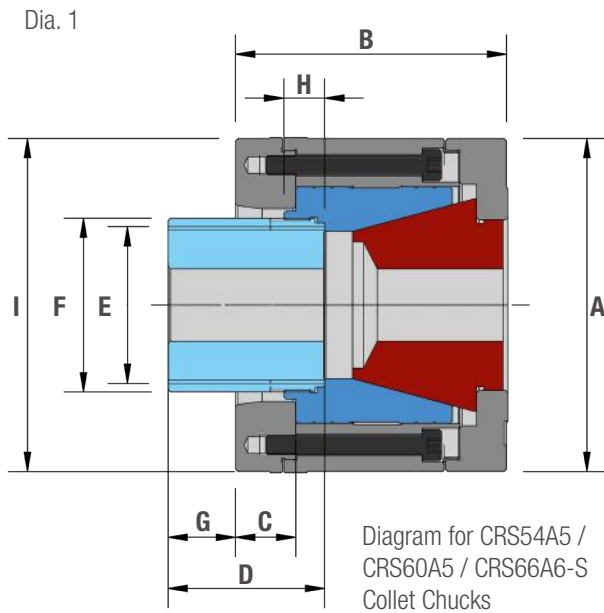
Ideal for first operation work as they have a 2-3mm gripping range enabling you to handle rough bar. Supplied either as smooth, serrated or super grip.



**Rubberflex Collets\*\*\***

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

## Short Series Power Collet Chuck for Bar Machining

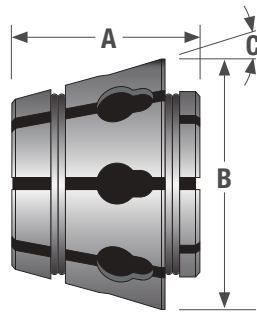


KLAMP Type		CRS54		CRS60	CRS66		
Mounting		A5	A6	A5	Z220	A6	A8
Part number		CRS54A5	CRS54A6	CRS60A5	CRS66	CRS66A6-S	CRS66A8
Varibore Collet Type		D-120		D-677	D-285		
Varibore Collet Gripping range*	Minimum	3		4	3.2		
	Maximum	53.9		60	66.6		
Varibore Collet Increments		3		2	3		
Rubberflex Collet Type		-		DRFC677	-		
Rubberflex Collet Gripping Range**	Minimum	-		19*	-		
	Maximum	-		65*	-		
Rubberflex Collet Increments		-		2	-		
A		138		138	150	165	150
B		113	127.4	107.5	134	131	140
C		25	41	25	24	N/A	30
D		65		65	80		
E Maximum		M65 x 1.5		M65 x 1.5	M80 x 2.0		
F		72		72	90		
G Maximum		28	12	28	27	29.5	21
G Minimum		18	2	21	17	19.5	11
H		17		17	24		
I		N/A	167	N/A	230	N/A	210
Sleeve stroke		10		7	10		
Max. input force	kN	30		30	38		
Max. Gripping Force	kN	60		60	84		
Max. Speed	min <sup>-1</sup>	6300		6300	4500		
Net Weight	kg	11	12.5	11	19		18
Matching Kitagawa Cylinders		S1552		S1552	S1875		

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

\*\* DRFC677 Rubber-flex collets are only suitable for the CRS60 Collet chuck and are available in smooth and full grip versions (smooth version is only available for 61 mm diameters and larger).

## Varibore Collets for CRS54, QCRL54, CRS66, QCRS66, QCRL66 & QCRS80 Collet Chucks



### Varibore Collets

- Round, Hexagon or Square
- Specify which gripping surface you require – Supergrip Serrations (Heavy duty), Annular Serrations or Smooth
- Other shapes available upon request

### Dimensions (Metric)

Part No.	A	B	C
D120	62.7	88	15°
D285	73.2	99.3	15°
D175	80	120	15°

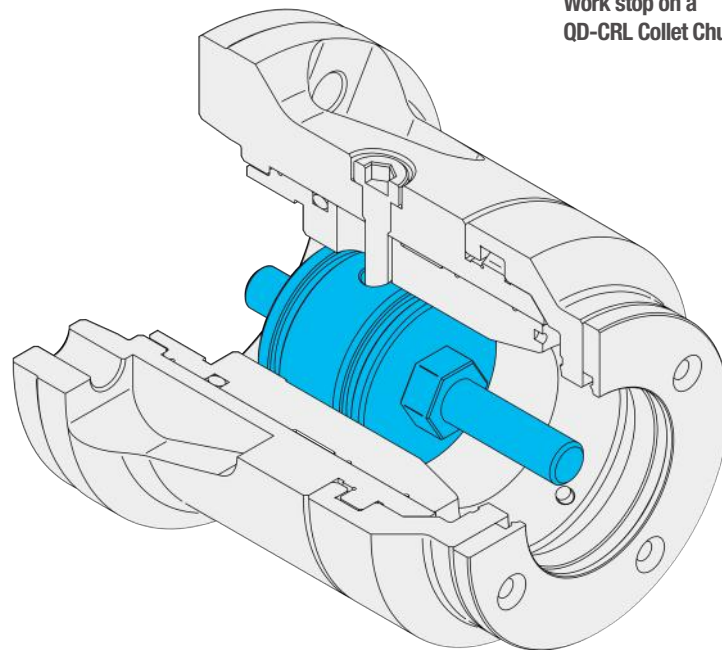
Gripping Range		D120 for CRS54 & QCRL54			D285 for CRS66, QCRS66 & QCRL66			D175 for QCRS80		
Inch	mm	Round	Hexagon	Square	Round	Hexagon	Square	Round	Hexagon	Square
1/16 - 3/16	1.58 - 4.76	D120R-D01	-	-	-	-	-	-	-	-
1/8 - 1/4	3.17 - 6.35	D120R-D02	D120X-D69	D120S-D87	D285R-E02	D285X-E69	D285S-E87	-	-	-
1/4 - 3/8	6.35 - 9.52	D120R-D03	D120X-D70	D120S-D88	D285R-E03	D285X-E70	D285S-E88	-	-	-
3/8 - 1/2	9.52 - 12.70	D120R-D04	D120X-D71	D120S-D89	D285R-E04	D285X-E71	D285S-E89	-	-	-
1/2 - 5/8	12.70 - 15.87	D120R-D05	D120X-D72	D120S-D90	D285R-E05	D285X-E72	D285S-E90	D175R-F05	D175X-F72	D175S-F100
5/8 - 3/4	15.87 - 19.05	D120R-D06	D120X-D73	D120S-D91	D285R-E06	D285X-E73	D285S-E91	D175R-F06	D175X-F73	D175S-F101
3/4 - 7/8	19.05 - 22.22	D120R-D07	D120X-D74	D120S-D92	D285R-E07	D285X-E74	D285S-E92	D175R-F07	D175X-F74	D175S-F102
7/8 - 1	22.22 - 25.40	D120R-D08	D120X-D75	D120S-D93	D285R-E08	D285X-E75	D285S-E93	D175R-F08	D175X-F75	D175S-F103
1 - 1.1/8	25.40 - 28.57	D120R-D09	D120X-D76	D120S-D94	D285R-E09	D285X-E76	D285S-E94	D175R-F09	D175X-F76	D175S-F104
1.1/8 - 1.1/4	28.57 - 31.75	D120R-D10	D120X-D77	D120S-D95	D285R-E10	D285X-E77	D285S-E95	D175R-F10	D175X-F77	D175S-F105
1.1/4 - 1.3/8	31.75 - 34.92	D120R-D11	D120X-D78	D120S-D96	D285R-E11	D285X-E78	D285S-E96	D175R-F11	D175X-F78	D175S-F106
1.3/8 - 1.1/2	34.92 - 38.10	D120R-D12	D120X-D79	D120S-D97	D285R-E12	D285X-E79	D285S-E97	D175R-F12	D175X-F79	D175S-F107
1.1/2 - 1.5/8	38.10 - 41.27	D120R-D13	D120X-D80	D120S-D98	D285R-E13	D285X-E80	D285S-E98	D175R-F13	D175X-F80	D175S-F108
1.5/8 - 1.3/4	41.27 - 44.45	D120R-D14	D120X-D81	-	D285R-E14	D285X-E81	D285S-E99	D175R-F14	D175X-F81	D175S-F109
1.3/4 - 1.7/8	44.45 - 47.62	D120R-D15	D120X-D82	-	D285R-E15	D285X-E82	-	D175R-F15	D175X-F82	D175S-F110
1.7/8 - 2	47.62 - 50.80	D120R-D16	D120X-D83	-	D285R-E16	D285X-E83	-	D175R-F16	D175X-F83	D175S-F111
2 - 2.1/8	50.80 - 53.97	D120R-D17	-	-	D285R-E17	D285X-E84	-	D175R-F17	D175X-F84	D175S-F112
2.1/8 - 2.1/4	53.97 - 57.15	-	-	-	D285R-E18	D285X-E85	-	D175R-F18	D175X-F85	-
2.1/4 - 2.3/8	57.15 - 60.32	-	-	-	D285R-E19	-	-	D175R-F19	D175X-F86	-
2.3/8 - 2.1/2	60.32 - 63.50	-	-	-	D285R-E20	-	-	D175R-F20	D175X-F87	-
2.1/2 - 2.5/8	63.50 - 66.67	-	-	-	D285R-E21	-	-	D175R-F21	D175X-F88	-
2.5/8 - 2.3/4	66.67 - 69.85	-	-	-	-	-	-	D175R-F22	-	-
2.3/4 - 2.7/8	69.85 - 73.02	-	-	-	-	-	-	D175R-F23	-	-
2.7/8 - 3	73.02 - 76.20	-	-	-	-	-	-	D175R-F24	-	-
3 - 3.1/8	76.20 - 79.37	-	-	-	-	-	-	D175R-F25	-	-

Emergency Collets with soft face and pilot hole is available for all types

## QC & C Series Standard Accessories

### Work Stops

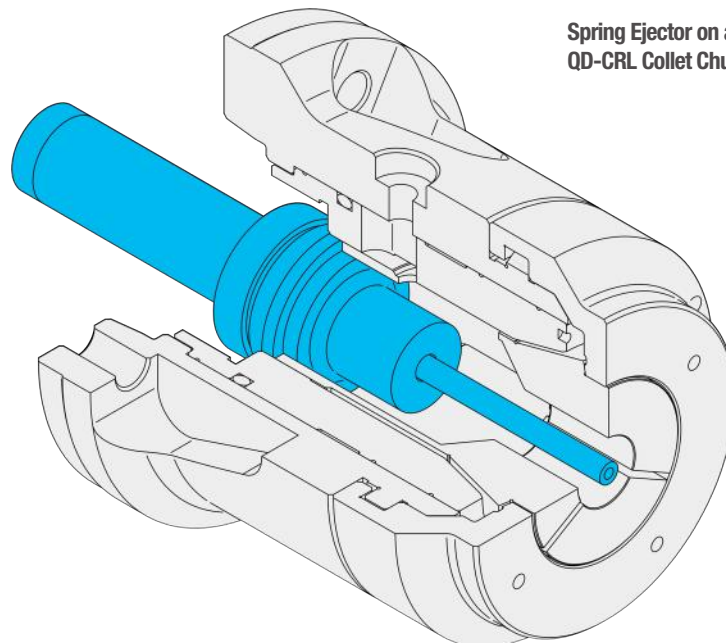
- Stops can be provided to allow for accurate z-axis positioning of short workpieces within the collet chuck.
- A threaded stud is provided for easy adjustment to suit your work piece
- All stops are easily installed from the front face utilising a side bolt to hold the stop securely in place.
- These 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