

Fixed Length Series Power Collet Chuck for Bar Machining

First & Second Operation Collet Chuck

Designed with a fixed length actuation system that ensures the collet is held stationary. Allowing the collet chuck to be used in bar feeding operations and highly accurate second operations. Klamp DKF collet chucks are suitable for collets which have a +/-0.5mm gripping range.

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 a 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 down-time.

Long Service Life

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

Short Body/Wide Range

DC Varibore collets allow for a compact body design maximising the lathe work envelope. Gripping capacities of the series range from 4mm to 65mm.

Low-Profile Nose

Klamp DKF Series Collet Chucks have a small nose diameter for superior tool clearance.

Fully Sealed

No grease required to operate the collet chuck. O-ring seals are incorporated within the design to prevent coolant and chip ingress.

High Speed

Direct mount design ensures high concentricity that is suitable for higher speed operations that are not appropriate for conventional 3-jaw chuck due to the negative effects of centrifugal force.

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.

Ultra-Fast 10 Second Collet Changes



Suitable for DC Varibore Collet Types



Klamp DKF collet chucks accept DC Varibore Collets that have the same accuracy specification as spring collets whilst maintaining a gripping range of +/- 0.5mm. Supplied with either smooth or serrated gripping surface. Serrated collets are ideal for aggressive first operation gripping of rough bar work.

Vulcanized rubber between the hardened steel collet segments provides excellent protection against coolant and chip ingress. Counter boring and special profile shapes are available upon request.



Insert & Unlock DC Collet



Remove DC Collet

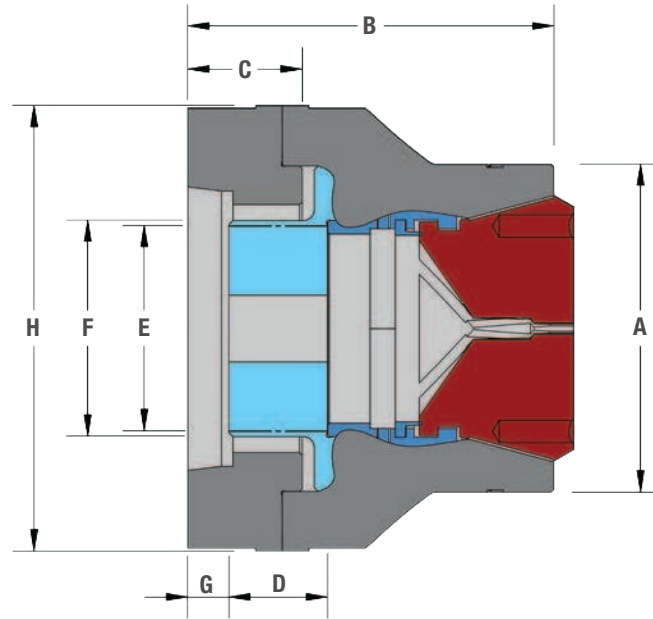


Insert DC Collet



Lock & Remove DC

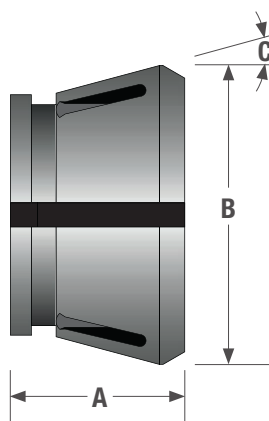
Fixed Length Series Power Collet Chuck for Bar Machining



KLAMP Type	DKF42			DKF52			DKF65				DKF80					
Mounting	Z140	A5	A6	Z140	A5	A6	Z140	A5	A6	A8	Z220	A6	A8	A11		
Part Number	DKF42	DKF42A5	DKF42A6	DKF52	DKF52A5	DKF52A6	DKF65	DKF65A5	DKF65A6	DKF65A8	DKF80	DKF80A6	DKF80A8	DKF80A11		
Varibore Collet Type	DC42			DC52			DC65				DC80					
Varibore Collet Gripping range*	Min.	3			4			4				5				
	Max.	42			52			65				80				
Varibore Collet Increments	1			1			1				1					
A	103			106			123				138					
B	121			132		137		137.5		161.5		146.2		164.25 142 186.25		
C	42.5			44.5		49.5		43		67		50		67.8 45.75 47		
D	30.5			31			37				51.5					
E Maximum	M50			M60			M75		M74		M75		M80			
	x 2.0			x 2.0			x 2.0		x 2.0		x 2.0		x 2.0			
F	66			68			81		79.5		81		97			
G Maximum	12		17		14		24		10.5		15.5		39.5		2 27 4.75 49	
	7.5		12.5		9.5		19.5		6		11		35		2.5 22.5 0.25 44.5	
H	152		157		162			167				201.5		232 207 280		
Sleeve stroke	4.5			4.5			4.5				4.5					
Max. input force	kN 40			kN 40			kN 45				kN 50					
Max. Gripping Force	kN 94			kN 94			kN 105				kN 114					
Max. Speed	min ⁻¹ 6500			min ⁻¹ 6500			min ⁻¹ 6000				min ⁻¹ 5000					
Net Weight	kg 11			kg 12			kg 13		kg 14		kg 13		kg 19		kg 22 27 21 34	
Matching Kitagawa Cylinders	S1246 SS1246 SR1146			S1552 SS1452 SR1453			S1875 SS1770 SR1566				S2091 SS1881 SR1781					



DC Quick Change Collets to Suit DHP42 Collet Chucks



DC42 Varibore Collets

- Round, Hexagon, Square or Emergency types available
- Please specify which gripping surface you require – Serrated or Smooth
- Clamping tolerance of +/- 0.5mm
- Counter boring and special profile shapes are available upon request

Dimensions (Metric)

Part No.	A	B	C
DC42	47	79.3	15°
DC42S	42	79.3	15°

DC42 Round Collets

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
3mm	-	DC42S-R03
4mm	-	DC42S-R04
5mm	-	DC42S-R05
6mm	-	DC42S-R06
7mm	-	DC42S-R07
8mm	DC42-R08*	DC42S-R08
9mm	DC42-R09*	DC42S-R09
10mm	DC42-R10*	DC42S-R10
11mm	DC42-R11	DC42S-R11
12mm	DC42-R12	DC42S-R12
13mm	DC42-R13	DC42S-R13
14mm	DC42-R14	DC42S-R14
15mm	DC42-R15	DC42S-R15
16mm	DC42-R16	DC42S-R16

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
17mm	DC42-R17	DC42S-R17
18mm	DC42-R18	DC42S-R18
19mm	DC42-R19	DC42S-R19
20mm	DC42-R20	DC42S-R20
21mm	DC42-R21	DC42S-R21
22mm	DC42-R22	DC42S-R22
23mm	DC42-R23	DC42S-R23
24mm	DC42-R24	DC42S-R24
25mm	DC42-R25	DC42S-R25
26mm	DC42-R26	DC42S-R26
27mm	DC42-R27	DC42S-R27
28mm	DC42-R28	DC42S-R28
29mm	DC42-R29	DC42S-R29

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
30mm	DC42-R30	DC42S-R30
31mm	DC42-R31	DC42S-R31
32mm	DC42-R32	DC42S-R32
33mm	DC42-R33	DC42S-R33
34mm	DC42-R34	DC42S-R34
35mm	DC42-R35	DC42S-R35
36mm	DC42-R36	DC42S-R36
37mm	DC42-R37	DC42S-R37
38mm	DC42-R38	DC42S-R38
39mm	DC42-R39	DC42S-R39
40mm	DC42-R40	DC42S-R40
41mm	DC42-R41	DC42S-R41
42mm	DC42-R42	DC42S-R42

* Radial grooves only - larger sizes have axial and radial grooves

DC42 Hexagon Collets

Available from 7mm to 38mm across flats sides of the hexagon in 1mm increments. Part number is **DC42-X****. Please state which size you require, smooth (7-38mm) or serrated (8-38mm) gripping surface is available.

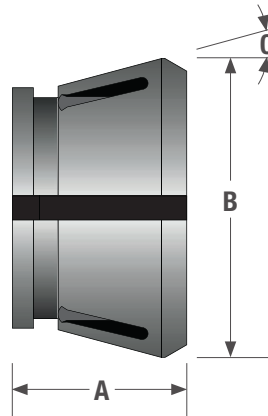
DC42 Square Collets

Available from 7mm to 28mm across flats sides of the square in 1mm increments. Part number is **DC42-S****. Please state which size you require, smooth (7-28mm) or serrated (8-28mm) gripping surface is available.

DC42 Emergency Collets

Available only with 5mm, 15mm or 30mm pilot holes. Part number is **DC42-E**** Please state which size you require.

DC Quick Change Collets to Suit DHP52 Collet Chucks



DC52 Varibore Collets

- Round, Hexagon, Square or Emergency types available
- Please specify which gripping surface you require – Serrated or Smooth
- Clamping tolerance of +/- 0.5mm
- Counter boring and special profile shapes are available upon request

Dimensions (Metric)

Part No.	A	B	C
DC52	46	79.2	15°

DC52 Round Collets

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
3mm	-	DC52S-R03
4mm	-	DC52S-R04
5mm	-	DC52S-R05
6mm	-	DC52S-R06
7mm	-	DC52S-R07
8mm	DC52-R08*	DC52S-R08
9mm	DC52-R09*	DC52S-R09
10mm	DC52-R10*	DC52S-R10
11mm	DC52-R11	DC52S-R11
12mm	DC52-R12	DC52S-R12
13mm	DC52-R13	DC52S-R13
14mm	DC52-R14	DC52S-R14
15mm	DC52-R15	DC52S-R15
16mm	DC52-R16	DC52S-R16
17mm	DC52-R17	DC52S-R17
18mm	DC52-R18	DC52S-R18
19mm	DC52-R19	DC52S-R19

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
20mm	DC52-R20	DC52S-R20
21mm	DC52-R21	DC52S-R21
22mm	DC52-R22	DC52S-R22
23mm	DC52-R23	DC52S-R23
24mm	DC52-R24	DC52S-R24
25mm	DC52-R25	DC52S-R25
26mm	DC52-R26	DC52S-R26
27mm	DC52-R27	DC52S-R27
28mm	DC52-R28	DC52S-R28
29mm	DC52-R29	DC52S-R29
30mm	DC52-R30	DC52S-R30
31mm	DC52-R31	DC52S-R31
32mm	DC52-R32	DC52S-R32
33mm	DC52-R33	DC52S-R33
34mm	DC52-R34	DC52S-R34
35mm	DC52-R35	DC52S-R35
36mm	DC52-R36	DC52S-R36

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
37mm	DC52-R37	DC52S-R37
38mm	DC52-R38	DC52S-R38
39mm	DC52-R39	DC52S-R39
40mm	DC52-R40	DC52S-R40
41mm	DC52-R41	DC52S-R41
42mm	DC52-R42	DC52S-R42
43mm	DC52-R43	DC52S-R43
44mm	DC52-R44	DC52S-R44
45mm	DC52-R45	DC52S-R45
46mm	DC52-R46	DC52S-R46
47mm	DC52-R47	DC52S-R47
48mm	DC52-R48	DC52S-R48
49mm	DC52-R49	DC52S-R49
50mm	DC52-R50	DC52S-R50
51mm	DC52-R51	DC52S-R51
52mm	DC52-R52	DC52S-R52

* Radial grooves only - larger sizes have axial and radial grooves

DC52 Hexagon Collets

Available from 7mm to 45mm across flats sides of the hexagon in 1mm increments. Part number is **DC52-X****. Please state which size you require, smooth (7-45mm) or serrated (8-45mm) gripping surface is available.

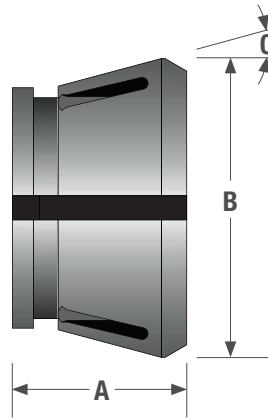
DC52 Square Collets

Available from 7mm to 36mm across flats sides of the square in 1mm increments. Part number is **DC52-S****. Please state which size you require, smooth (7-36mm) or serrated (8-36mm) gripping surface is available.

DC52 Emergency Collets

Available only with 5mm, 15mm or 30mm pilot holes. Part number is **DC52-E****. Please state which size you require.

DC Quick Change Collets to Suit DHP65/DHF65/DRF65 Collet Chucks



DC65 Varibore Collets

- Round, Hexagon, Square or Emergency types available
- Please specify which gripping surface you require – Serrated or Smooth
- Clamping tolerance of +/- 0.5mm
- Counter boring and special profile shapes are available upon request

Dimensions (Metric)

Part No.	A	B	C
DC65	58	99.5	15°
DC65S	53	99.5	15°

DC65 Round Collets

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
4mm	-	DC65S-R04
5mm	-	DC65S-R05
6mm	-	DC65S-R06
7mm	-	DC65S-R07
8mm	DC65-R08*	DC65S-R08
9mm	DC65-R09*	DC65S-R09
10mm	DC65-R10*	DC65S-R10
11mm	DC65-R11	DC65S-R11
12mm	DC65-R12	DC65S-R12
13mm	DC65-R13	DC65S-R13
14mm	DC65-R14	DC65S-R14
15mm	DC65-R15	DC65S-R15
16mm	DC65-R16	DC65S-R16
17mm	DC65-R17	DC65S-R17
18mm	DC65-R18	DC65S-R18
19mm	DC65-R19	DC65S-R19
20mm	DC65-R20	DC65S-R20
21mm	DC65-R21	DC65S-R21
22mm	DC65-R22	DC65S-R22
23mm	DC65-R23	DC65S-R23
24mm	DC65-R24	DC65S-R24

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
25mm	DC65-R25	DC65S-R25
26mm	DC65-R26	DC65S-R26
27mm	DC65-R27	DC65S-R27
28mm	DC65-R28	DC65S-R28
29mm	DC65-R29	DC65S-R29
30mm	DC65-R30	DC65S-R30
31mm	DC65-R31	DC65S-R31
32mm	DC65-R32	DC65S-R32
33mm	DC65-R33	DC65S-R33
34mm	DC65-R34	DC65S-R34
35mm	DC65-R35	DC65S-R35
36mm	DC65-R36	DC65S-R36
37mm	DC65-R37	DC65S-R37
38mm	DC65-R38	DC65S-R38
39mm	DC65-R39	DC65S-R39
40mm	DC65-R40	DC65S-R40
41mm	DC65-R41	DC65S-R41
42mm	DC65-R42	DC65S-R42
43mm	DC65-R43	DC65S-R43
44mm	DC65-R44	DC65S-R44
45mm	DC65-R45	DC65S-R45

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
46mm	DC65-R46	DC65S-R46
47mm	DC65-R47	DC65S-R47
48mm	DC65-R48	DC65S-R48
49mm	DC65-R49	DC65S-R49
50mm	DC65-R50	DC65S-R50
51mm	DC65-R51	DC65S-R51
52mm	DC65-R52	DC65S-R52
53mm	DC65-R53	DC65S-R53
54mm	DC65-R54	DC65S-R54
55mm	DC65-R55	DC65S-R55
56mm	DC65-R56	DC65S-R56
57mm	DC65-R57	DC65S-R57
58mm	DC65-R58	DC65S-R58
59mm	DC65-R59	DC65S-R59
60mm	DC65-R60	DC65S-R60
61mm	DC65-R61	DC65S-R61
62mm	DC65-R62	DC65S-R62
63mm	DC65-R63	DC65S-R63
64mm	DC65-R64	DC65S-R64
65mm	DC65-R65	DC65S-R65

* Radial grooves only - larger sizes have axial and radial grooves

DC65 Hexagon Collets

Available from 7mm to 56mm across flats sides of the hexagon in 1mm increments. Part number is **DC65-X****. Please state which size you require, smooth (7-56mm) or serrated (8-56mm) gripping surface is available.

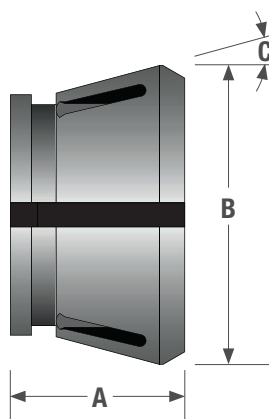
DC65 Square Collets

Available from 8mm to 46mm across flats sides of the square in 1mm increments. Part number is **DC65-S****. Please state which size you require, smooth (7-46mm) or serrated (8-46mm) gripping surface is available.

DC65 Emergency Collets

Available only with 5mm, 10mm, 20mm or 40mm pilot holes. Part number is **DC65-E****. Please state which size you require.

DC Quick change collets to suit DHP80/DHF80/DRF80 Collet chucks



DC80 Varibore Collets

- Round, Hexagon, Square or Emergency types available
- Please specify which gripping surface you require – Serrated or Smooth
- Clamping tolerance of +/- 0.5mm
- Counter boring and special profile shapes are available upon request

Dimensions (Metric)

Part No.	A	B	C
DC80	53	114.5	15°

DC80 Round Collets

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
5mm	-	DC80S-R05
6mm	-	DC80S-R06
7mm	-	DC80S-R07
8mm	DC80-R08*	DC80S-R08
9mm	DC80-R09*	DC80S-R09
10mm	DC80-R10*	DC80S-R10
11mm	DC80-R11	DC80S-R11
12mm	DC80-R12	DC80S-R12
13mm	DC80-R13	DC80S-R13
14mm	DC80-R14	DC80S-R14
15mm	DC80-R15	DC80S-R15
16mm	DC80-R16	DC80S-R16
17mm	DC80-R17	DC80S-R17
18mm	DC80-R18	DC80S-R18
19mm	DC80-R19	DC80S-R19
20mm	DC80-R20	DC80S-R20
21mm	DC80-R21	DC80S-R21
22mm	DC80-R22	DC80S-R22
23mm	DC80-R23	DC80S-R23
24mm	DC80-R24	DC80S-R24
25mm	DC80-R25	DC80S-R25
26mm	DC80-R26	DC80S-R26
27mm	DC80-R27	DC80S-R27
28mm	DC80-R28	DC80S-R28
29mm	DC80-R29	DC80S-R29

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
30mm	DC80-R30	DC80S-R30
31mm	DC80-R31	DC80S-R31
32mm	DC80-R32	DC80S-R32
33mm	DC80-R33	DC80S-R33
34mm	DC80-R34	DC80S-R34
35mm	DC80-R35	DC80S-R35
36mm	DC80-R36	DC80S-R36
37mm	DC80-R37	DC80S-R37
38mm	DC80-R38	DC80S-R38
39mm	DC80-R39	DC80S-R39
40mm	DC80-R40	DC80S-R40
41mm	DC80-R41	DC80S-R41
42mm	DC80-R42	DC80S-R42
43mm	DC80-R43	DC80S-R43
44mm	DC80-R44	DC80S-R44
45mm	DC80-R45	DC80S-R45
46mm	DC80-R46	DC80S-R46
47mm	DC80-R47	DC80S-R47
48mm	DC80-R48	DC80S-R48
49mm	DC80-R49	DC80S-R49
50mm	DC80-R50	DC80S-R50
51mm	DC80-R51	DC80S-R51
52mm	DC80-R52	DC80S-R52
53mm	DC80-R53	DC80S-R53
54mm	DC80-R54	DC80S-R54

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
55mm	DC80-R55	DC80S-R55
56mm	DC80-R56	DC80S-R56
57mm	DC80-R57	DC80S-R57
58mm	DC80-R58	DC80S-R58
59mm	DC80-R59	DC80S-R59
60mm	DC80-R60	DC80S-R60
61mm	DC80-R61	DC80S-R61
62mm	DC80-R62	DC80S-R62
63mm	DC80-R63	DC80S-R63
64mm	DC80-R64	DC80S-R64
65mm	DC80-R65	DC80S-R65
66mm	DC80-R66	DC80S-R66
67mm	DC80-R67	DC80S-R67
68mm	DC80-R68	DC80S-R68
69mm	DC80-R69	DC80S-R69
70mm	DC80-R70	DC80S-R70
71mm	DC80-R71	DC80S-R71
72mm	DC80-R72	DC80S-R72
73mm	DC80-R73	DC80S-R73
74mm	DC80-R74	DC80S-R74
75mm	DC80-R75	DC80S-R75
76mm	DC80-R76	DC80S-R76
77mm	DC80-R77	DC80S-R77
78mm	DC80-R78	DC80S-R78
79mm	DC80-R79	DC80S-R79
80mm	DC80-R80	DC80S-R80

* Radial grooves only - larger sizes have axial and radial grooves

DC80 Hexagon Collets

Available from 7mm to 68mm across flats sides of the hexagon in 1mm increments. Part number is **DC80-X****. Please state which size you require, smooth (7-68mm) or serrated (8-68mm) gripping surface is available.

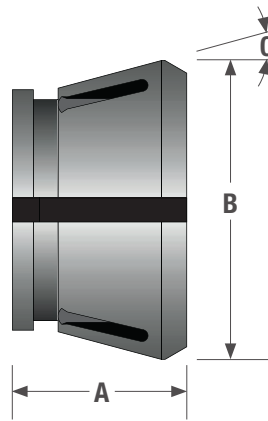
DC80 Square Collets

Available from 7mm to 56mm across flats sides of the square in 1mm increments. Part number is **DC80-S****. Please state which size you require, smooth (7-56mm) or serrated (8-56mm) gripping surface is available.

DC80 Emergency Collets

Available only with 8mm, 20mm or 40mm or 60mm pilot holes. Part number is **DC80-E****. Please state which size you require.

DC Quick Change Collets



DC100 Vari bore Collets

- Round, Hexagon, Square or Emergency types available
- Please specify which gripping surface you require – Serrated or Smooth
- Clamping tolerance of +/- 0.5mm
- Counter boring and special profile shapes are available upon request

Dimensions (Metric)

Part No.	A	B	C
DC100	59	144.5	15°

DC100 Round Collets

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
16mm	DC100-R16	DC100S-R16
17mm	DC100-R17	DC100S-R17
18mm	DC100-R18	DC100S-R18
19mm	DC100-R19	DC100S-R19
20mm	DC100-R20	DC100S-R20
21mm	DC100-R21	DC100S-R21
22mm	DC100-R22	DC100S-R22
23mm	DC100-R23	DC100S-R23
24mm	DC100-R24	DC100S-R24
25mm	DC100-R25	DC100S-R25
26mm	DC100-R26	DC100S-R26
27mm	DC100-R27	DC100S-R27
28mm	DC100-R28	DC100S-R28
29mm	DC100-R29	DC100S-R29
30mm	DC100-R30	DC100S-R30
31mm	DC100-R31	DC100S-R31
32mm	DC100-R32	DC100S-R32
33mm	DC100-R33	DC100S-R33
34mm	DC100-R34	DC100S-R34
35mm	DC100-R35	DC100S-R35
36mm	DC100-R36	DC100S-R36
37mm	DC100-R37	DC100S-R37
38mm	DC100-R38	DC100S-R38
39mm	DC100-R39	DC100S-R39
40mm	DC100-R40	DC100S-R40
41mm	DC100-R41	DC100S-R41
42mm	DC100-R42	DC100S-R42
43mm	DC100-R43	DC100S-R43
44mm	DC100-R44	DC100S-R44

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
45mm	DC100-R45	DC100S-R45
46mm	DC100-R46	DC100S-R46
47mm	DC100-R47	DC100S-R47
48mm	DC100-R48	DC100S-R48
49mm	DC100-R49	DC100S-R49
50mm	DC100-R50	DC100S-R50
51mm	DC100-R51	DC100S-R51
52mm	DC100-R52	DC100S-R52
53mm	DC100-R53	DC100S-R53
54mm	DC100-R54	DC100S-R54
55mm	DC100-R55	DC100S-R55
56mm	DC100-R56	DC100S-R56
57mm	DC100-R57	DC100S-R57
58mm	DC100-R58	DC100S-R58
59mm	DC100-R59	DC100S-R59
60mm	DC100-R60	DC100S-R60
61mm	DC100-R61	DC100S-R61
62mm	DC100-R62	DC100S-R62
63mm	DC100-R63	DC100S-R63
64mm	DC100-R64	DC100S-R64
65mm	DC100-R65	DC100S-R65
66mm	DC100-R66	DC100S-R66
67mm	DC100-R67	DC100S-R67
68mm	DC100-R68	DC100S-R68
69mm	DC100-R69	DC100S-R69
70mm	DC100-R70	DC100S-R70
71mm	DC100-R71	DC100S-R71
72mm	DC100-R72	DC100S-R72
73mm	DC100-R73	DC100S-R73

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
74mm	DC100-R74	DC100S-R74
75mm	DC100-R75	DC100S-R75
76mm	DC100-R76	DC100S-R76
77mm	DC100-R77	DC100S-R77
78mm	DC100-R78	DC100S-R78
79mm	DC100-R79	DC100S-R79
80mm	DC100-R80	DC100S-R80
81mm	DC100-R81	DC100S-R81
82mm	DC100-R82	DC100S-R82
83mm	DC100-R83	DC100S-R83
84mm	DC100-R84	DC100S-R84
85mm	DC100-R85	DC100S-R85
86mm	DC100-R86	DC100S-R86
87mm	DC100-R87	DC100S-R87
88mm	DC100-R88	DC100S-R88
89mm	DC100-R89	DC100S-R89
90mm	DC100-R90	DC100S-R90
91mm	DC100-R91	DC100S-R91
92mm	DC100-R92	DC100S-R92
93mm	DC100-R93	DC100S-R93
94mm	DC100-R94	DC100S-R94
95mm	DC100-R95	DC100S-R95
96mm	DC100-R96	DC100S-R96
97mm	DC100-R97	DC100S-R97
98mm	DC100-R98	DC100S-R98
99mm	DC100-R99	DC100S-R99
100mm	DC100-R100	DC100S-R100

DC100 Hexagon Collets

Available from 50mm to 86mm across flats sides of the hexagon in 1mm increments. Part number is **DC100-X****. Please state which size you require, smooth or serrated gripping surface is available.

DC100 Square Collets

Available from 50mm to 70mm across flats sides of the square in 1mm increments. Part number is **DC100-S****. Please state which size you require, smooth or serrated gripping surface is available.

DC100 Emergency Collets

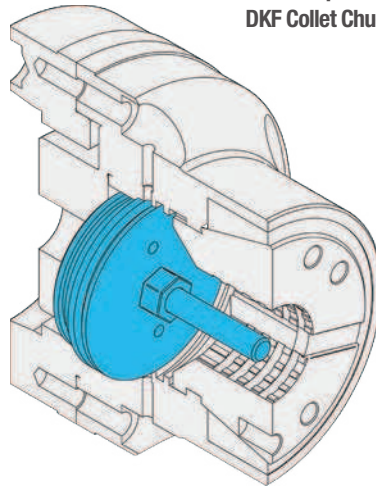
Available only with 30mm, 45mm, 65mm or 90mm pilot holes. Part number is **DC100-E****. Please state which size you require.

D Series Standard Accessories

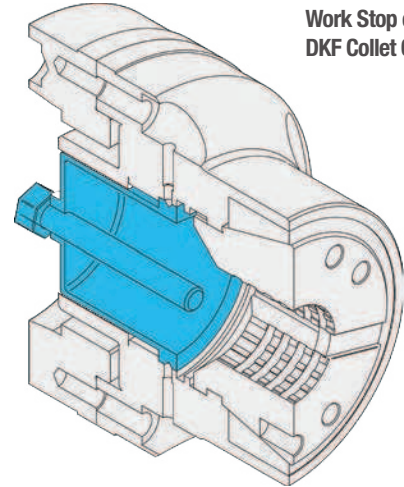
Work Stops

- 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 DHP & DKF 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 DKF Collet Chuck



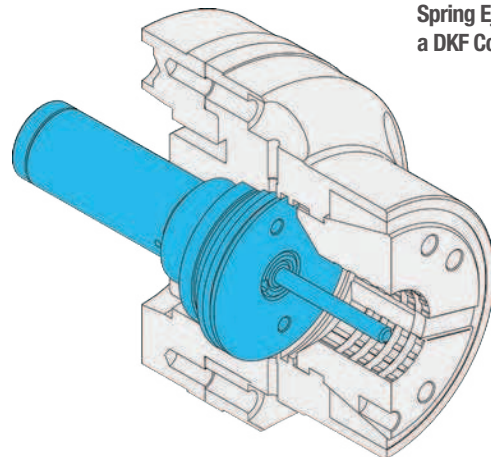
Additional Length Work Stop on a DKF Collet Chuck



Spring Ejectors DKF Series Only

- Standard spring ejectors for in the DKF series are use for second-spindle operations to expel finished workpiece into the parts catcher.
- All spring ejectors are easily installed from the front face utilising a supplied key
- Many variants of spring ejector are available to suit your production process.
- 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 DKF Collet Chuck



Collet Changing Device D Series Collet Chucks

- Easy to use device to allow DC Collets to be removed or installed.
- Simply insert the steel pins into the Collet face holes and squeeze the trigger to collapse the DC Collet.
- Availabel in both manual and pneumatic versions.

Part Number	To Suit		Type
	DHP Series	DHF Series	
DCD42	DHP42	DKF42	Manual
DCD52	DHP52	DKF52	Manual
DCD65	DHP65	DKF65	Manual
DCD80	DHP80	DKF80	Pneumatic
DCD100	-	DKF100	Pneumatic



Data required to manufacture drawtube actuator

Check which model is required

Fig. 1

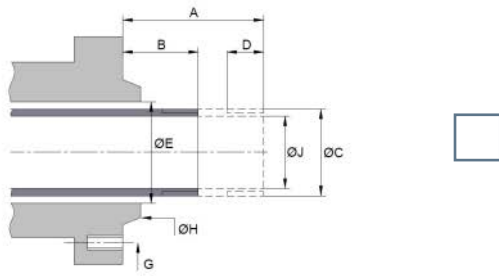


Fig. 2

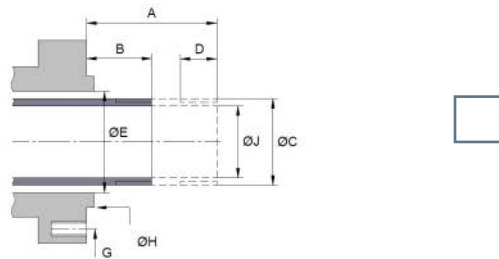


Fig. 3

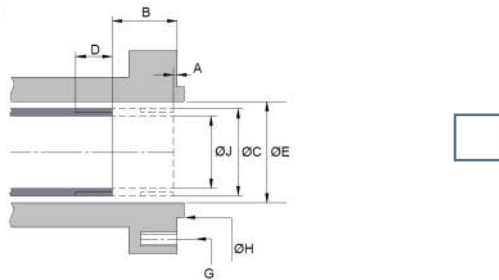
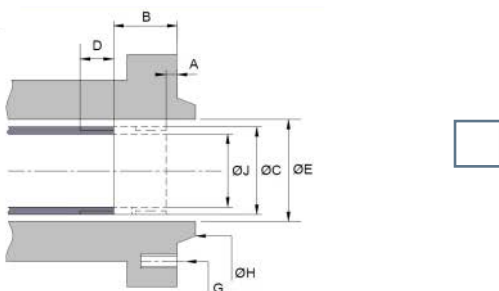


Fig. 4



A) Forward position of (drawtube from spindle face)

B) Backward position of (drawtube from spindle face)

C) Thread diameter form and pitch

State if RH or LH and external or internal

D) Operative length of full thread

E) Spindle bore diameter

State if taper

G) Fixing details. Thread size =

PCD = _____ QTY = _____

Spacing = _____

J) Drawtube internal diameter

American spindle mount

State type

Straight spindle mount

State diameter

Drawtube Connector / Machine Spindle Information

Machine Make:

Model:

Year:

Chuck Make:

Model:

Serial Number:

Cylinder Make:

Model:

Serial Number:

Contact Name:	Position:
Company Name:	
Address:	
Postal Code/ZIP:	Country:
Telephone:	Fax:
Email:	Website: