



Schlenker
SPANNWERKZEUGE

EDGE ● ● ●
TECHNOLOGIES



THINK DIFFERENT —
CREATE INNOVATIONS



THE COMPANY

SINCE 1952

For more than 70 years Schlenker Spannwerkzeuge GmbH & Co. KG dedicates all its passion and knowhow to the production of high-quality clamping tools.

In the beginning the company focused on the manufacturing of collets for manual as well as CNC lathes. When Dipl. Ing. Josef Meißner took over the company in 1986, he developed the first bar feed collet for loading lathes in close cooperation with loading magazine manufacturers. After the first sliding headstock lathes came to the market, the company expanded its product portfolio with guide bushes. These products are still essential for the company today.

Unimpressed by the first relocations of production by German companies abroad, Schlenker always stayed true to its roots and continued to produce at its home location in Villingen-Schwenningen.

Britta Hoffmann continues this tradition since 2008 as Managing Director in the second generation. The family-owned company is highly regarded by the market as a technological leader for clamping tools and is continuously expanding its business with customer-specific and innovative product solutions.

This success is driven by the company's more than 100 highly qualified and passionate employees, who form the heart of Schlenker.

„Think different, create innovations“
Always on the leading edge to give you added value.

B. Hoffmann
Britta Hoffmann
CEO

WHO WE ARE

WE PRODUCE EVERYTHING 100% OURSELVES!

Since it was founded in 1952 by Hans Schlenker, the Schlenker company has specialized entirely in the manufacture of high-quality clamping tools. Anyone who decides to work with us can rely on a reliable and solution-oriented partner.



100% PRODUCTION DEPTH
Maximum flexibility. Fast and individual. All from a single source.



OEM COMPETENCE
Partnership. Technologically leading. Absolute trust.



FIRST-CLASS QUALITY
Leading Performance. Safety. No compromises.



CUSTOMER PROXIMITY
Close dialogue. Fast solution competence. Innovative strength.



INDIVIDUAL SOLUTIONS
Customized. Perfectly matched. Maximum Performance.



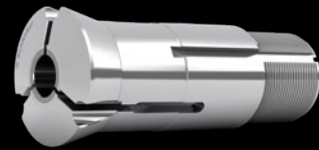
WELCOME TO THE TEAM
We look forward to welcoming you as a partner.



SUSTAINABILITY
Responsible. Digitalization. Resource savings.

OVERVIEW PRODUCT SOLUTIONS

SLIDING HEADSTOCK LATHE



ADJUSTABLE GUIDE BUSHES



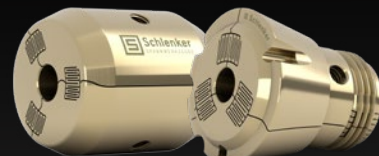
SUB SPINDLE COLLETS



PROGRAMMABLE GUIDE BUSHES



SUB SPINDLE LONG NOSE COLLETS



FLEXIBLE GUIDE BUSHES



OPTION LONG PARTS



MAIN SPINDLE COLLETS



REDUCING TUBES



SHK BAR FEED COLLETS



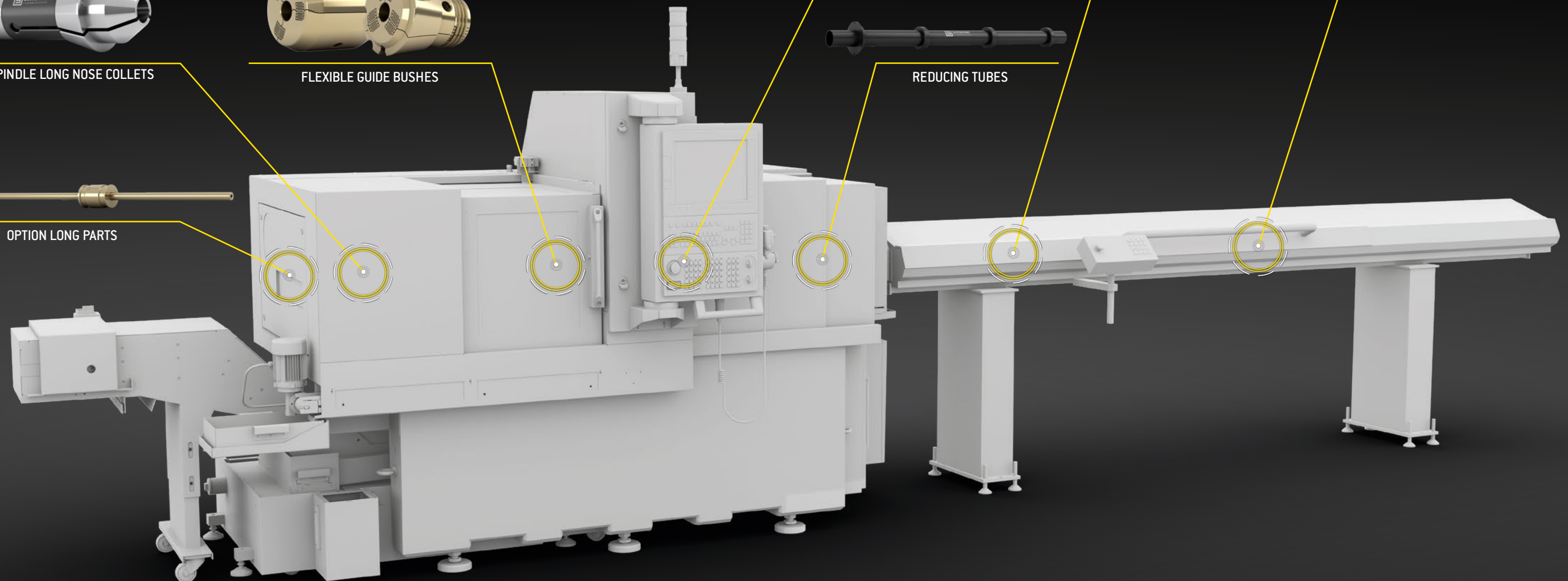
HSL ROTATING INSERTS



TURBO BAR FEED COLLETS



TURBO ROTATING INSERTS



OVERVIEW PRODUCT SOLUTIONS

MULTI-SPINDLE



OUTER STOPS



INSIDE CLAMPING SLEEVES INDEX MS



IEMCA ROTATING INSERTS



SHK BAR FEED COLLETS



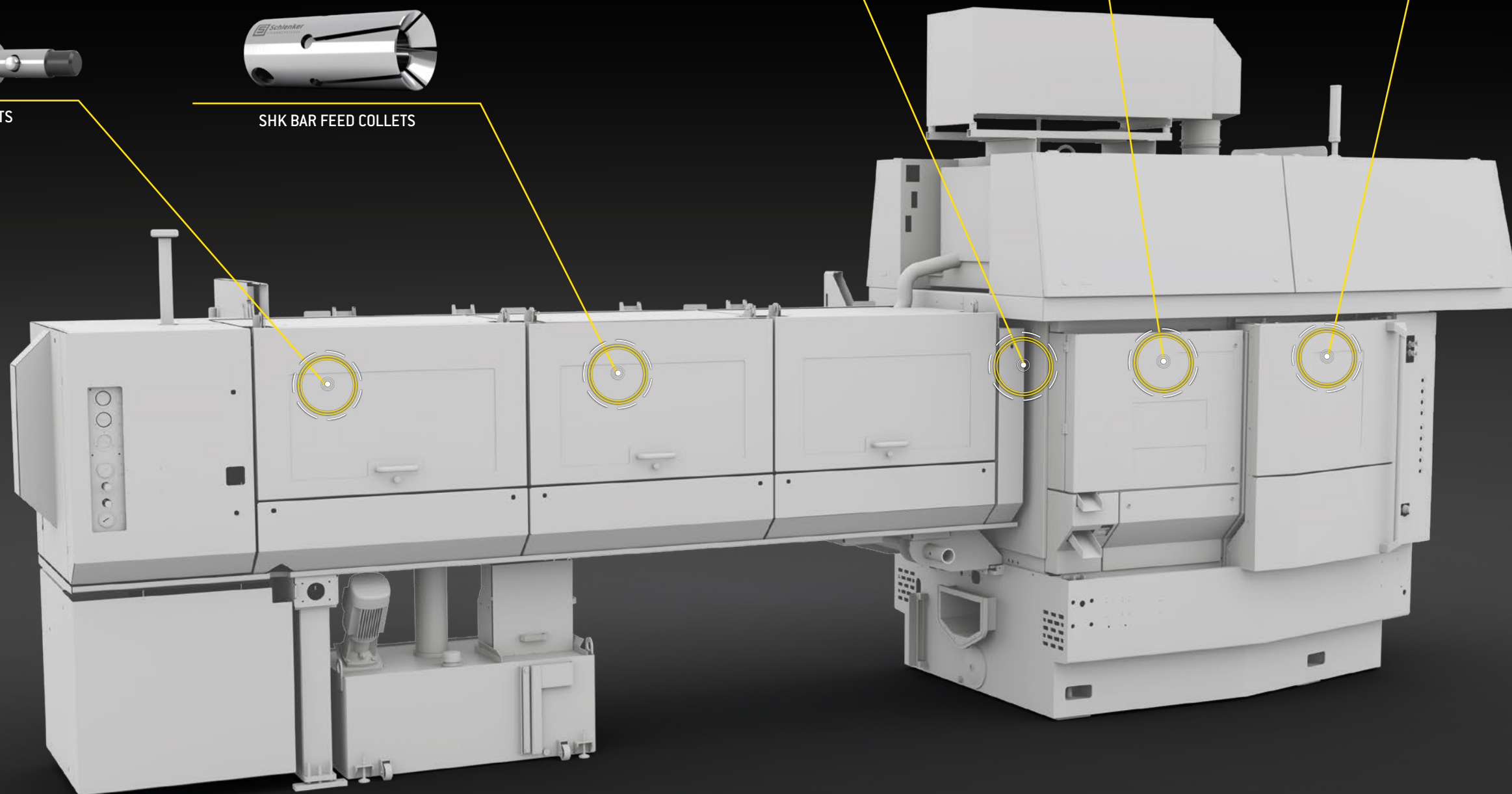
REDUCING TUBES



MULTI-SPINDLE COLLETS MSP

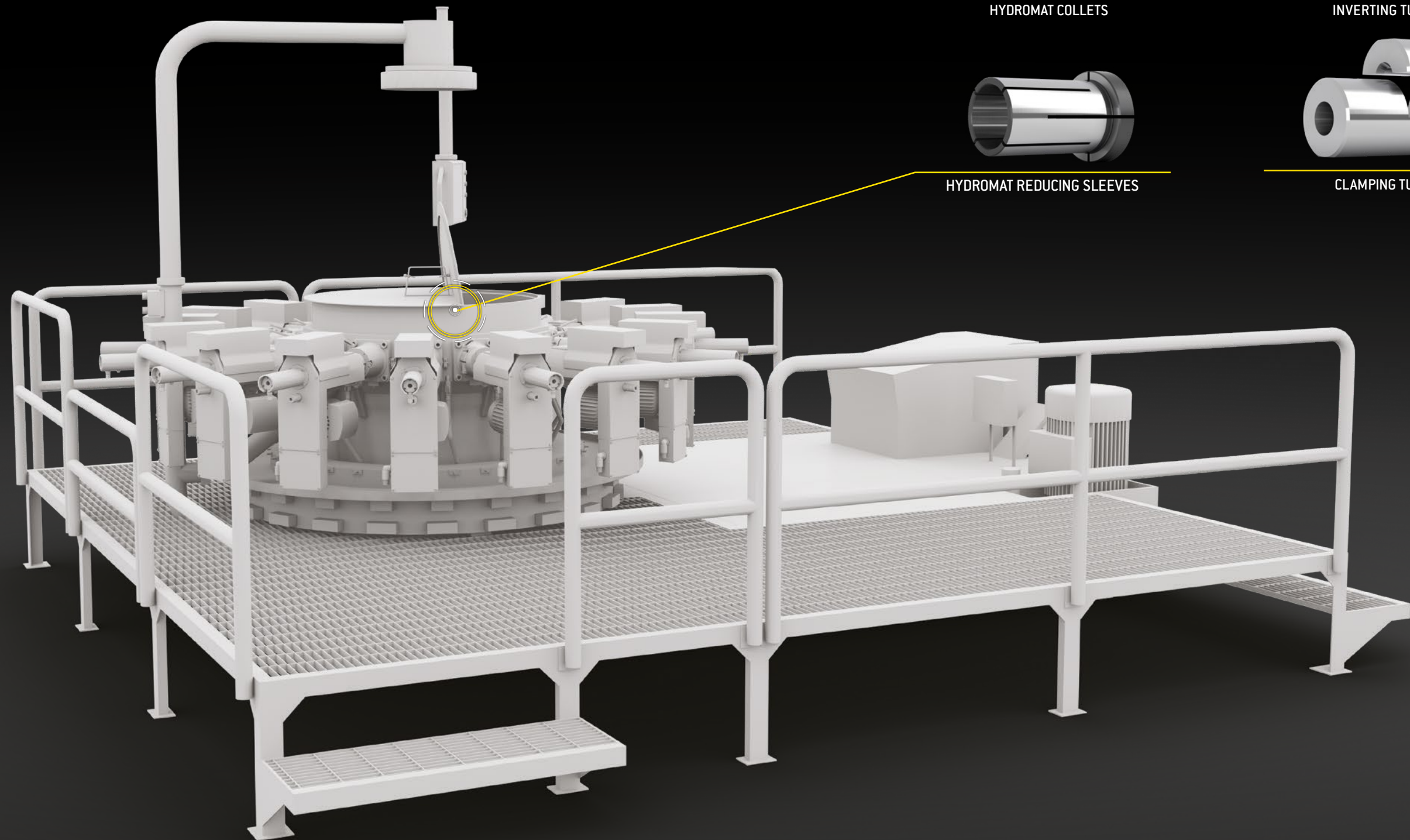


MULTI-SPINDLE COLLETS SSP

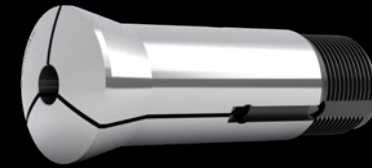


OVERVIEW PRODUCT SOLUTIONS

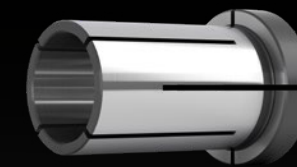
ROTARY TRANSFER



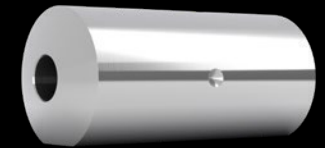
EJECTOR BAR / EJECTOR HEADS



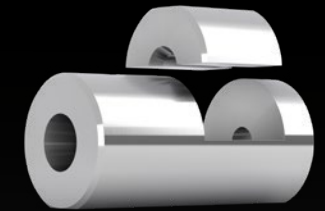
HYDROMAT COLLETS



HYDROMAT REDUCING SLEEVES



INVERTING TUBES



CLAMPING TUBES

THINK DIFFERENT

CREATE INNOVATIONS



COLLETS

01

GUIDE BUSHES

02

BAR FEED COLLETS

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COLLETS



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DEAD LENGTH COLLETS



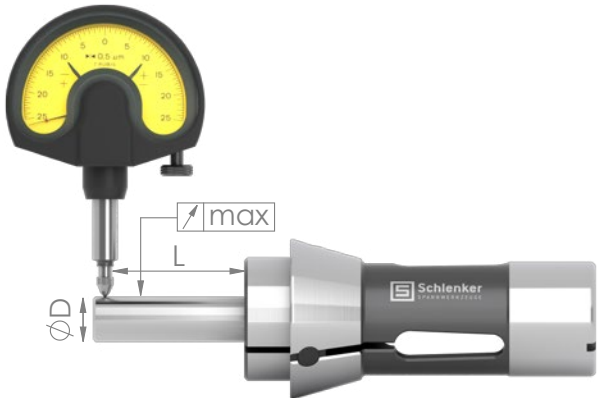
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USE OF DEAD LENGTH COLLETS

Dead length collets are used in the main and sub spindle. The collets can be installed in various types of machines, such as turning machines, sliding headstock automatic lathes, multi-spindle machines, conventional lathes, cam-controlled lathes and in special purpose machine constructions.

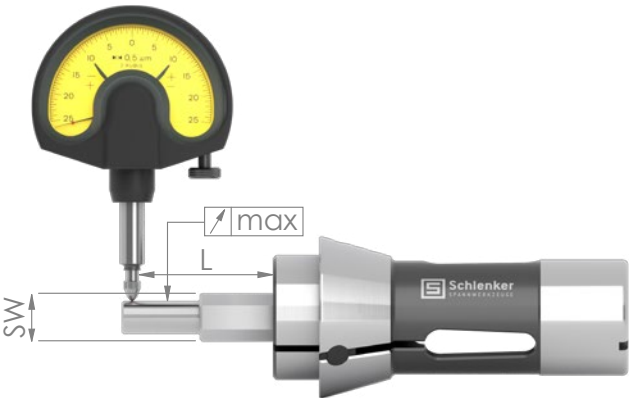
The collet is clamped via the pressure sleeve, which presses the collet in axial direction against the cap nut.

RUNOUT TOLERANCE



DIAMETER

ØD		L	Schlenker norm	
from	to		standard	UP
0.5	0.9	3	<0.01	<0.005
1.0	1.5	6	<0.01	<0.005
1.6	3.0	10	<0.015	<0.008
3.1	6.0	16	<0.015	<0.008
6.1	10.0	25	<0.015	<0.008
10.1	18.0	40	<0.02	<0.01
18.1	24.0	50	<0.02	<0.01
24.1	30.0	60	<0.02	<0.01
30.0		80	<0.03	<0.015



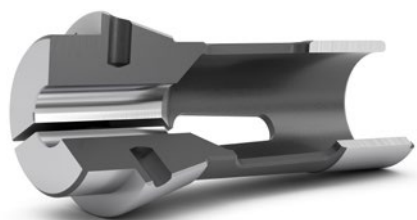
PROFILE

SW		L	standard	Schlenker norm	
from	to			standard	UP
0.5	0.9	3	0.12	<0.02	<0.01
1.0	1.5	6	0.12	<0.02	<0.01
1.6	3.0	10	0.12	<0.02	<0.01
3.1	6.0	16	0.12	<0.02	<0.01
6.1	10.0	25	0.15	<0.02	<0.01
10.1	18.0	40	0.2	<0.02	<0.01
18.1	24.0	50	0.2	<0.02	<0.01
24.1	30.0	60	0.2	<0.02	<0.01
30.0		80	0.2	<0.02	<0.01

DEAD LENGTH COLLET OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- POSITIONING
- ADDITIONAL VERSIONS
- INSERTS

CLAMPING SURFACE DESIGNS



SMOOTH

- Mainly used on the sub spindle
- Collets up to Ø5.9 mm standard smooth, collet type E177 and larger up to Ø8.9 mm standard smooth



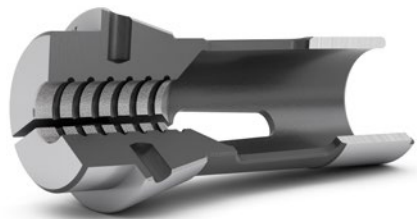
GROOVED – STANDARD

- Standard collet
- Mainly used on the main spindle
- Collets from Ø6.0 mm standard grooved, collet type E177 and larger from Ø9.0 mm standard grooved



AXIAL & RADIAL GROOVES

- Higher clamping force compared to the grooved standard collet due to the additional axial grooves




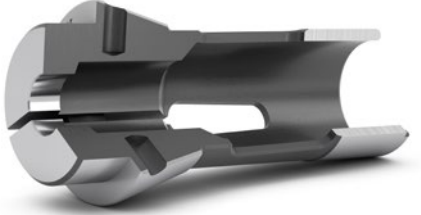
CARBIDE COATING

- Carbide coating possible for all shapes
- Higher coefficient of friction than a standard collet
- Higher clamping force
- Repeated / afterward coating possible








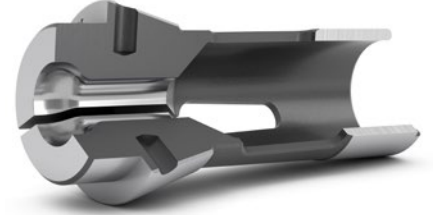
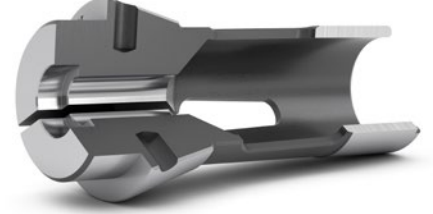
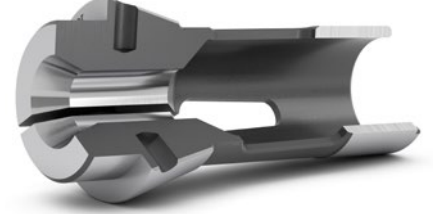
SUPERGRIP

- Highest clamping force at the same clamping pressure of the machine due to very closely spaced axial and radial grooves



	<p>EXTENDED CLAMPING LENGTH</p> <ul style="list-style-type: none"> • Can be used for long workpieces with multiple grooves • Higher wrap around at the workpiece perimeter, therefore more force to clamp • More stable clamping for long workpieces
	<p>SHORTENED CLAMPING LENGTH</p> <ul style="list-style-type: none"> • Application for workpieces whose geometry behind the clamping diameter shouldn't be damaged • Used for short workpieces so the ejector can be lead closer to the clamping diameter


SHAPES

	<p>SMALL BORE SIZES</p> <ul style="list-style-type: none"> • Available from Ø0.2 - 0.99 mm
	<p>SQUARE</p> <ul style="list-style-type: none"> • Square collets are supplied from SW8 with grooves as standard • Collet type E177 and larger are available from SW10 with grooves as standard
	<p>HEXAGON</p> <ul style="list-style-type: none"> • Hexagon collets are supplied from SW8 with grooves as standard • Collet type E177 and larger are available from SW10 with grooves as standard
	<p>SPECIAL PROFILES</p> <ul style="list-style-type: none"> • Various profiles can be realized by ram EDM or wire EDM • Profiles can be adapted individually to the workpiece

	<p>ECCENTRIC</p> <ul style="list-style-type: none"> • Eccentric bore can be eroded individually according to application • Through hole or offset hole is possible
	<p>SPECIAL CONTOURS</p> <ul style="list-style-type: none"> • Complex contours can be realized by hard milling, hard turning and grinding • Possible with smallest diameters from 0.2 mm
	<p>STEPS</p> <ul style="list-style-type: none"> • Steps are suitable for simultaneous clamping of several diameters of a workpiece • Very high precision as both steps are ground in one step
	<p>INNER CONICAL</p> <ul style="list-style-type: none"> • For gripping conical workpieces • The clamping angle is precisely adapted to the workpiece

SLOT DESIGNS


	<p>S-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Gentle clamping on the material • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use
	<p>L-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Gentle clamping on the material • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use • Ideal for clamping on short clamping surfaces

	<p>W-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Gentle clamping on the material • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use
	<p>Z-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Gentle clamping on the material • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use
	<p>THIN SLOTTED</p> <ul style="list-style-type: none"> • More gentle clamping on the material • Prevents the entry of machining chips, as the collet closes almost completely • Recommended for small bore sizes



WEAR REDUCTION

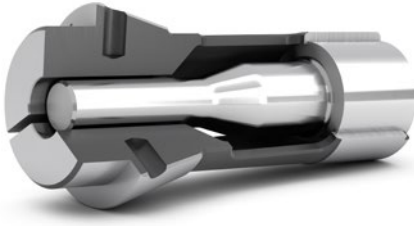



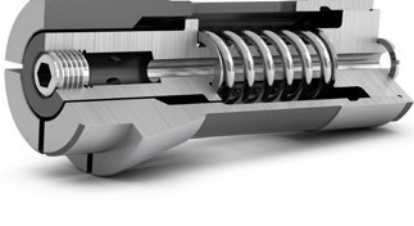


	<p>CARBIDE INSERT</p> <ul style="list-style-type: none"> • High wear resistance • Prevents pressure marks on the workpiece • Higher service life
	<p>BL COATING</p> <ul style="list-style-type: none"> • Smooth surface • Fewer clamping marks on the material • Especially suitable for material with poor gliding properties • Prevents the welding of the material in the collet
	<p>PREMIUM BLUE COATING</p> <ul style="list-style-type: none"> • Economical alternative to collets with carbide insert • High wear resistance • Can also be used for special shapes • Are completely coated on the functional surfaces like cone and shaft therefore more durable

POSITIONING

	<p>SLOT IN CONE</p> <ul style="list-style-type: none"> • Slot is placed in the cone of the collet • Used to position the collet in the machine for special as well as square and hexagon shapes
	<p>SLOT IN SHAFT</p> <ul style="list-style-type: none"> • Slot is placed in the shaft of the collet • Used to position the collet in the machine for special as well as square and hexagon shapes
	<p>SLOT IN FRONT-SURFACE</p> <ul style="list-style-type: none"> • Slot is placed in the front-surface of the collet • Used to position the collet in the machine for special as well as square and hexagon shapes
	<p>ALIGNMENT SURFACE</p> <ul style="list-style-type: none"> • The alignment surface on the collet is used to position complex profiles and special contours • Is only producible in combination with a slot

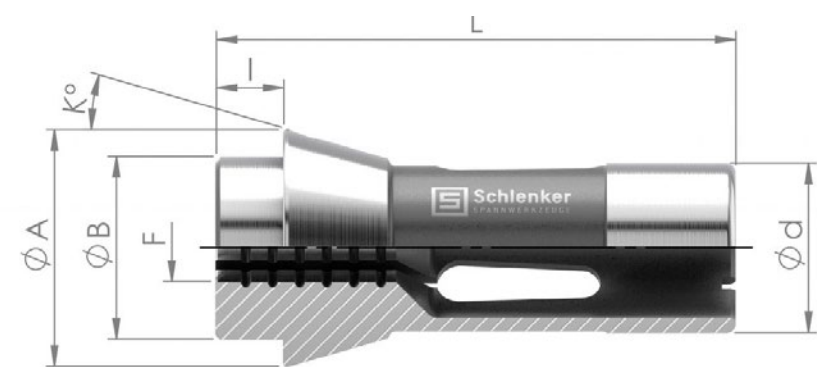
ADDITIONAL VERSIONS

	<p>EMERGENCY COLLET SOFT DESIGN</p> <ul style="list-style-type: none"> • Is not hardened • Clamping diameter can be turned out by the user himself • Used for the production of prototypes, samples and one-off productions
	<p>EMERGENCY COLLET HARDENED & TEMPERED HEAD</p> <ul style="list-style-type: none"> • Is hardened, slotted and widened • Head is tempered so clamping bore can still be turned out by the user himself • Suitable for workpiece clamping in small to medium series production




	INTERNAL STOP <ul style="list-style-type: none"> Suitable for manual loading of the machine at a certain length Prevents the displacement of the workpiece at high axial forces Used to stabilize the workpiece when the clamping length is too short
	INSERT AID <ul style="list-style-type: none"> Is inserted in main spindle collets Is mainly used for small diameters Minimizes vibrations as the bar material is supported along its total length
	BUSH <ul style="list-style-type: none"> Is inserted in main spindle collets An alternativ to the insert aid Is mainly used for small to medium diameters Absorbs the vibrations of the bar material, supports it at the back and keeps it axially aligned
	SUPPORTING BUSH <ul style="list-style-type: none"> Is inserted in sub spindle collets Minimizes vibrations as the bar material is supported along its total length and keeps it axially aligned Ejection is made possible in a process-safe way
	EJECTOR & INNER COOLING <ul style="list-style-type: none"> Mechanical ejection of the workpieces If required internal cooling of components can be integrated For flushing the clamping surface Simple change of the ejector within one collet type possible
	UP VERSION <ul style="list-style-type: none"> High precision
	UUP VERSION <ul style="list-style-type: none"> Highest precision

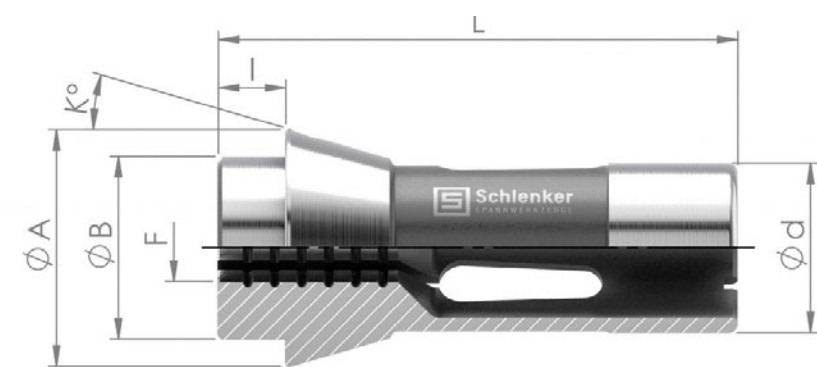
	SEALED <ul style="list-style-type: none"> Prevents the entry of machining chips The whole slot area can be sealed Resealing possible Not usable with high pressure flushing in the machine
INSERTS	
	PEEK / PLASTIC INSERTS <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping
	ALUMINUM INSERTS <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping
	BRASS INSERTS <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping
	BRONZE INSERTS <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping
	PERMAGLIS INSERTS <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping
	INSERTS FOR SELF-TURNING <ul style="list-style-type: none"> Clamping diameter can be turned out by the user himself Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping

DEAD LENGTH COLLETS






d Shaft-Ø A Head-Ø B Nose-Ø I Nose length L Total length K Taper angle F Shape

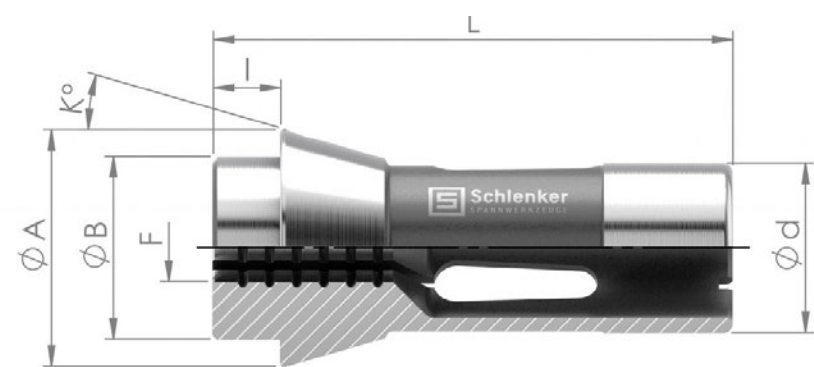
Article	Ø d [mm]	Ø A [mm]	Ø B [mm]	I [mm]	L [mm]	K [degree]	F min. – max. [mm]		
									
E101 F8-577 TF8	8	12	8	4.5	42	16	0.5 – 5.0	1.0 – 3.5	1.0 – 4.5
E109 F10 TF10	10	16	10	5.5	47.5	20	0.5 – 7.0	1.0 – 5.0	1.0 – 6.5
E112	11	19	12	6	41	22	0.5 – 7.0	1.0 – 5.0	1.0 – 6.5
E116 F13	13	19	13	6	64	16	0.5 – 9.5	2.0 – 7.0	2.0 – 8.5
E118	14	19.5	15	6	46	15	0.5 – 10.0	2.0 – 7.0	2.0 – 9.0
E120 F15 TF15	15	21	15	6	64	16	0.5 – 12.0	2.0 – 8.5	2.0 – 10.5
EF16 E1212 TF16	16	21	16	6	64	16	0.5 – 12.0	2.0 – 8.5	2.0 – 10.5
SYF16 M14x0.75	16	21	16	8	66	16	0.5 – 12.0	2.0 – 8.5	2.0 – 10.5
E127 TF18	18	25	18	6	67	16	0.5 – 13.0	2.0 – 9.5	2.0 – 11.5
E136 F20-201	20	26	19	5	54	15	0.5 – 16.5	2.0 – 12.0	2.0 – 14.5
E138 F20-87 TF20	20	28	21	7	67	16	0.5 – 16.0	2.0 – 11.5	2.0 – 14.0
E140 F22 TF22	22	30	21	6	55	15	0.5 – 16.5	2.0 – 12.0	2.0 – 14.5






d Shaft-Ø A Head-Ø B Nose-Ø I Nose length L Total length K Taper angle F Shape

Article	Ø d [mm]	Ø A [mm]	Ø B [mm]	I [mm]	L [mm]	K [degree]	F min. – max. [mm]		
									
TF24	23.8	28	22	7	62	15	0.5 – 18.5	2.0 – 13.0	2.0 – 16.0
E144	25	34	25	6	65	15	0.5 – 20.0	2.0 – 14.5	2.0 – 17.0
E145 F25 TF25	25	35	27	10	77	16	0.5 – 20.0	2.0 – 14.5	2.0 – 17.5
E147 F27-22	27	38	30	8	72.7	15	0.5 – 23.0	2.0 – 16.0	2.0 – 20.0
E148 F28	28	38	28	7	70	15	0.5 – 23.0	2.0 – 16.0	2.0 – 20.0
BS20	28	35	27	10	77	16	0.5 – 23.0	2.0 – 16.0	2.0 – 20.0
E157 F30 TF30	30	42	34	10	80	16	0.5 – 25.0	2.0 – 18.0	2.0 – 22.0
E1446 EF30	30	38	32	6	65	15	0.5 – 26.0	2.0 – 18.5	2.0 – 22.5
E161 F32	32	45	34	8	75	15	1.0 – 25.5	2.0 – 18.0	2.0 – 22.5
0166	32	40	34	6	65	15	1.0 – 28.0	2.0 – 20.0	2.0 – 24.5
E162	35	43	34	7	70	15	1.0 – 29.5	2.0 – 21.0	2.0 – 25.5
E163 F35	35	48	38	8	80	15	1.0 – 30.5	2.0 – 21.5	2.0 – 25.5
EF37 E1536 TF37	37	47	40	10	92	16	1.0 – 32.0	2.0 – 22.5	2.0 – 27.0

DEAD LENGTH COLLETS



d Shaft-Ø A Head-Ø B Nose-Ø I Nose length L Total length K Taper angle F Shape

Article	Ø d [mm]	Ø A [mm]	Ø B [mm]	I [mm]	L [mm]	K [degree]	F min. – max. [mm]		
									
EF38 E164	38.08	49	38	9.5	108	15	1.0 – 32.0	2.0 – 22.5	2.0 – 28.0
EF40	40	47	40	10	92	16	1.0 – 36.0	2.0 – 25.5	2.0 – 31.5
E171 F42	42	55	42	9	94	15	1.0 – 37.0	4.0 – 26.5	4.0 – 32.0
TF43	43	53	46	10	92	16	1.0 – 39.0	4.0 – 27.5	4.0 – 33.5
TF44	44	52	44	10	92	16	1.0 – 38.0	4.0 – 27.0	4.0 – 33.0
E173 F48	48	60	50	9	94	15	1.0 – 42.0	4.0 – 30.0	4.0 – 36.5
TF48	48	60	50	9	94	15	1.0 – 42.0	4.0 – 30.0	4.0 – 36.5
BS38	48	54	44	10	100	15	1.0 – 40.0	4.0 – 28.0	4.0 – 34.5
E177 F58	58	70	60	9	94	15	3.0 – 52.0	4.0 – 37.0	4.0 – 45.0
E185 F66	66	84	73	9	110	15	3.0 – 60.0	5.0 – 42.5	5.0 – 52.0
E185 - short F66		85	73	9	40	15	61.0 – 65.0		
E190 F88	88	106	94	10	115	15	60.0 – 80.0	20.0 – 56.0	20.0 – 69.0
E193 F90	90	107	92	12.5	130	15	PR	PR	PR

i DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

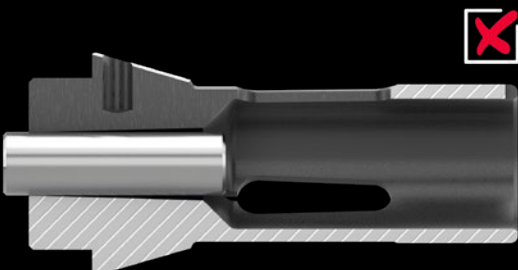
CORRECT CLAMPING
EASY EXPLAINED

With the following examples, we would like to explain you how to get optimum clamping results and what should be prevented when clamping the workpieces.



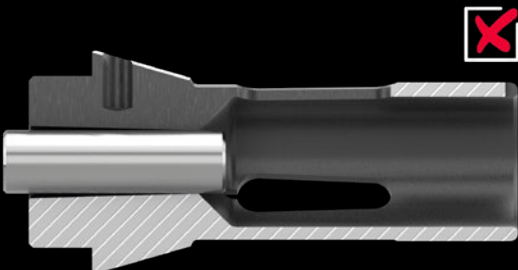
Visualization of a form-fit and cylindrical clamping

If you want to clamp for example a workpiece with Ø10.0 mm, you should use a collet with Ø10.0 mm so the workpiece can be clamped form-fit and cylindrically as shown in our illustration.



Visualization of a punctual ring clamping in the front area of the clamping surface

In case that your workpiece has a smaller diameter than the collet, as in our example Ø9.9 mm, a punctual ring clamping occurs in the front area of the clamping surface. This means that form-fitting and cylindrical clamping is not possible. The resulting consequences would be process uncertainties, errors in runout, tumbling or variations in the length of your workpiece.



Visualization of a punctual ring clamping in the rear area of the clamping surface

If the workpiece has a Ø10.1 mm, the collet cannot close into its initial geometry. This results a punctual ring clamping in the rear area of the clamping surface. The consequences would also be process uncertainties, errors in runout, tumbling or variations in the length of the workpiece.

It is also important to avoid unloaded clamping of collets, as this shortens the service life of the collet enormously. Furthermore, in-correct clamping can cause damage to the collet or the workpiece.

LONG NOSE COLLETS



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USE OF LONG NOSE COLLETS

Long nose collets are used in the sub spindle for gripping the workpiece. To prevent the long nose collets from breaking during short clamping, they are supplied with a reinforced spring area.

COLLETS WITH THREE-DIMENSIONAL PROFILES AND CONTOURS

Being 100% vertically integrated we are able to manufacture collets with complex contours by hard milling, hard turning and grinding while also complex profiles can be realized utilizing our EDM and wire EDM capabilities which for example allow us to produce collets for the easy and efficient manufacturing of dental implants (abutments) with three-dimensional contours.



Collet for dental implants with 3D profile

Workpiece e.g. abutment

LONG NOSE COLLET OPTIONS

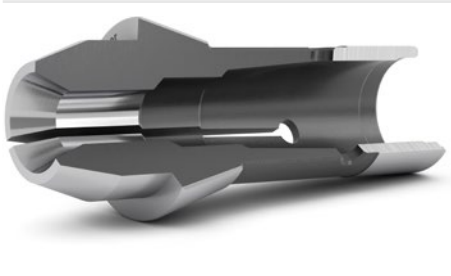




- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- POSITIONING
- ADDITIONAL VERSIONS
- INSERTS


CLAMPING SURFACE DESIGNS

	SMOOTH – STANDARD <ul style="list-style-type: none"> • Standard long nose collet • Mainly used on the sub spindle
	GROOVED <ul style="list-style-type: none"> • Mainly used on the sub spindle • With additional grooves
	CARBIDE COATING <ul style="list-style-type: none"> • Carbide coating possible for all shapes • Higher coefficient of friction than a standard collet • Higher clamping force • Repeated / afterward coating possible
	EXTENDED CLAMPING LENGTH <ul style="list-style-type: none"> • Can be used for long workpieces with multiple grooves • Higher wrap around at the workpiece perimeter, therefore more force to clamp • More stable clamping for long workpieces
	SHORTENED CLAMPING LENGTH <ul style="list-style-type: none"> • Application for workpieces whose geometry behind the clamping diameter shouldn't be damaged • Used for short workpieces so the ejector can be lead closer to the clamping diameter


SHAPES


	<p>SMALL BORE SIZES</p> <ul style="list-style-type: none">• Available from Ø0.2 - 0.99 mm
	<p>SQUARE</p> <ul style="list-style-type: none">• Suitable for clamping square material
	<p>HEXAGON</p> <ul style="list-style-type: none">• Suitable for clamping hexagon material
	<p>SPECIAL PROFILES</p> <ul style="list-style-type: none">• Various profiles can be realized by ram EDM or wire EDM• Profiles can be adapted individually to the workpiece
	<p>ECCENTRIC</p> <ul style="list-style-type: none">• Eccentric bore can be eroded individually according to application• Through hole or offset hole is possible
	<p>SPECIAL CONTOURS</p> <ul style="list-style-type: none">• Complex contours can be realized by hard milling, hard turning and grinding• Already possible with smallest diameters from 0.2 mm
	<p>STEPS</p> <ul style="list-style-type: none">• Steps are suitable for simultaneous clamping of several diameters of a workpiece• Very high precision as both steps are ground in one step


	<p>INNER CONICAL</p> <ul style="list-style-type: none">• For gripping conical workpieces• The taper angle of the collet is precisely adapted to the workpiece
	<p>S-SLOT</p> <ul style="list-style-type: none">• High and constant clamping force• Clamping with virtually no clamping marks• Alternatively usable for profile material (corner clamping)• Prevents the entry of machining chips, as the collet closes almost completely• Easy to clean after use
	<p>L-SLOT</p> <ul style="list-style-type: none">• High and constant clamping force• Clamping with virtually no clamping marks• Alternatively usable for profile material (corner clamping)• Prevents the entry of machining chips, as the collet closes almost completely• Easy to clean after use• Ideal for clamping on short clamping surfaces
	<p>W-SLOT</p> <ul style="list-style-type: none">• High and constant clamping force• Clamping with virtually no clamping marks• Alternatively usable for profile material (corner clamping)• Prevents the entry of machining chips, as the collet closes almost completely• Easy to clean after use
	<p>Z-SLOT</p> <ul style="list-style-type: none">• High and constant clamping force• Clamping with virtually no clamping marks• Alternatively usable for profile material (corner clamping)• Prevents the entry of machining chips, as the collet closes almost completely• Easy to clean after use

	<p>THIN SLOTTED</p> <ul style="list-style-type: none"> • Clamping with virtually no clamping marks • Prevents the entry of machining chips, as the collet closes almost completely • Recommended for small bore sizes
--	---


WEAR REDUCTION


	<p>CARBIDE INSERT</p> <ul style="list-style-type: none"> • High wear resistance • Prevents pressure marks on the workpiece • Higher service life
--	--


	<p>BL COATING</p> <ul style="list-style-type: none"> • Smooth surface • Fewer clamping marks on the material • Especially suitable for material with poor gliding properties • Prevents the welding of the material in the collet
---	--


	<p>PREMIUM BLUE COATING</p> <ul style="list-style-type: none"> • Economical alternative to collets with carbide insert • High wear resistance • Can also be used for special shapes • Are completely coated on the functional surfaces like cone and shaft therefore more durable
--	--

POSITIONING

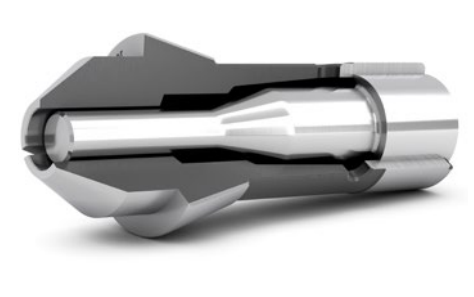
	<p>SLOT IN CONE</p> <ul style="list-style-type: none"> • Slot is placed in the cone of the collet • Used to position the collet in the machine for special as well as square and hexagon shapes
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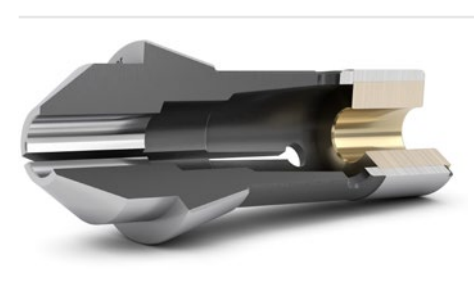
	<p>SLOT IN SHAFT</p> <ul style="list-style-type: none"> • Slot is placed in the shaft of the collet • Used to position the collet in the machine for special as well as square and hexagon shapes
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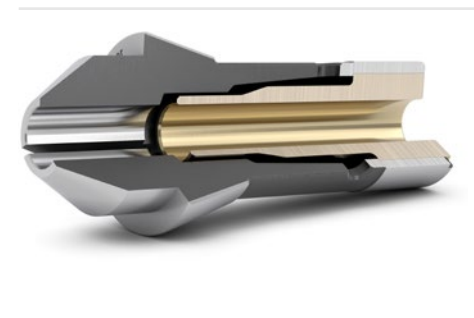
	<p>SLOT IN FRONT-SURFACE</p> <ul style="list-style-type: none"> • Slot is placed in the front-surface of the collet • Used to position the collet in the machine for special as well as square and hexagon shapes
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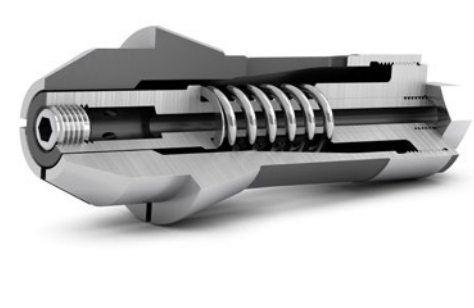
	<p>ALIGNMENT SURFACE</p> <ul style="list-style-type: none"> • The alignment surface on the collet is used to position complex profiles and special contours • Is only producible in combination with a slot
---	--

ADDITIONAL VERSIONS

	<p>INTERNAL STOP</p> <ul style="list-style-type: none"> • Suitable for manual loading of the machine at a certain length • Prevents the displacement of the workpiece at high axial forces • Used to stabilize the workpiece when the clamping length is too short
--	--




	<p>BUSH</p> <ul style="list-style-type: none"> • Is inserted in sub spindle collets • Is mainly used for small to medium diameters • Absorbs the vibrations of the bar material, supports it at the back and keeps it axially aligned
---	---




	<p>SUPPORTING BUSH</p> <ul style="list-style-type: none"> • Is inserted in sub spindle collets • Minimizes vibrations as the bar material is supported along its total length and keeps it axially aligned • Ejection is made possible in a process-safe way
---	--

	<p>EJECTOR & INNER COOLING</p> <ul style="list-style-type: none"> • Mechanical ejection of the workpieces • If required internal cooling of components can be integrated • For flushing the clamping surface • Simple change of the ejector within one collet type possible
---	--

	UP VERSION <ul style="list-style-type: none"> • High precision
	UUP VERSION <ul style="list-style-type: none"> • Highest precision
	SEALED <ul style="list-style-type: none"> • Prevents the entry of machining chips • The whole slot area can be sealed • Resealing possible • Not usable with high pressure flushing in the machine

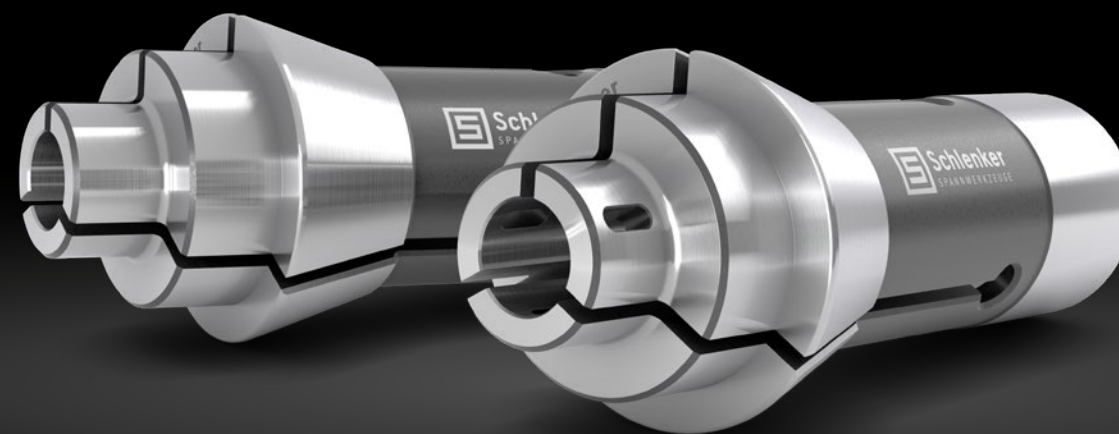
INSERTS

	PEEK / PLASTIC INSERTS <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping
	ALUMINIUM INSERTS <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping
	BRASS INSERTS <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping

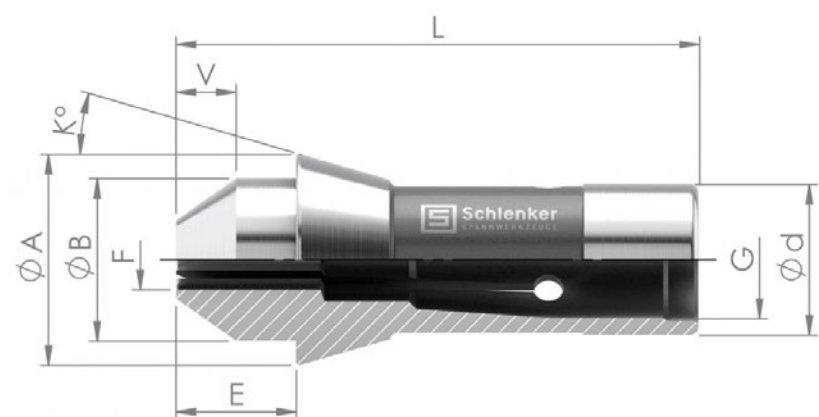
	BRONZE INSERTS <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping
	PERMAGLIS INSERTS <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping
	INSERTS FOR SELF-TURNING <ul style="list-style-type: none"> • Clamping diameter can be turned out by the user himself • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping

LONG NOSE COLLETS – OFFSET AND WITH CUTOUTS

- Allows to process the workpiece through the long nose of the collet
- Individual cutouts adapted to the workpiece are possible
- Offset long nose for better accessibility of the tools

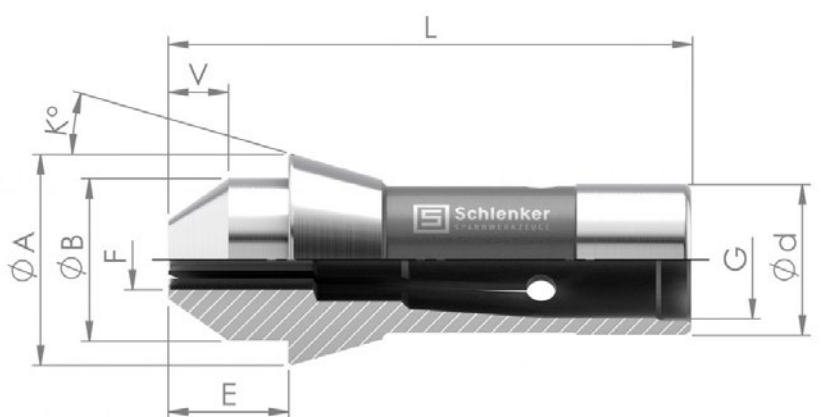


LONG NOSE COLLETS



d Shaft-Ø A Head-Ø B Nose-Ø V Long nose length E Total long nose length
L Total length K Taper angle G Thread F Shape

Article	Ø d [mm]	Ø A [mm]	Ø B [mm]	V [mm]	E [mm]	L [mm]	K [degree]	G	F min. – max.
									●
E116 VBV F13-2014	13	19	13	6	12	70	16		0.5 – 9.5
E116 VBV M11x0.75	13	19	13	6	12	70	16	M11x0.75	0.5 – 9.5
E120 VBV F15	15	21	15	7 9	13 15	71 73	16		0.5 – 12.0
E120 VBV M12x0.75	15	21	15	7 9	13 15	71 73	16	M12x0.75	0.5 – 12.0
EF16 VBV E1212	16	21	16	7 9	13 15	71 73	16		0.5 – 12.0
EF16 VBV E1212 M14x0.75	16	21	16	7 9	12 14	70 72	16	M14x0.75	0.5 – 12.0
E136 VBV F20	20	26	19	8 10	13 15	62 64	15		0.5 – 16.0
E136 VBV M18x1	20	26	19	8 10	13 15	62 64	15	M18x1	0.5 – 16.0
E138 VBV F20	20	28	21	8 13	15 20	75 80	16		0.5 – 16.0
E138 VBV M17x0.75	20	28	21	8 13	15 20	75 80	16	M17x0.75	0.5 – 16.0
E145 VBV F25	25	35	27	10 15	20 25	87 92	16		0.5 – 20.0



d Shaft-Ø A Head-Ø B Nose-Ø V Long nose length E Total long nose length
L Total length K Taper angle G Thread F Shape

Article	Ø d [mm]	Ø A [mm]	Ø B [mm]	V [mm]	E [mm]	L [mm]	K [degree]	G	F min. – max.
									●
E145 VBV M22x1	25	35	27	10 15	20 25	87 92	16	M22x1	0.5 – 20.0
E1446 VBV EF30-101	30	38	32	14	20	79	15		1.0 – 26.0
E161 VBV F32-221	32	45	34	15	23	90	15		1.0 – 25.0
E163 VBV F35	35	48	38	19	27	99	15		1.0 – 30.0
EF37 VBV E1536	37	47	40	10 15	20 25	102 107	16		1.0 – 32.0
E164 VBV F38-76-2004	38.08	49	38	15	24.5	123	15		1.0 – 32.0
E173 VBV F48-76-2006	48	60	50	19	28	113	15		2.0 – 42.0



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

OVERGRIP COLLETS

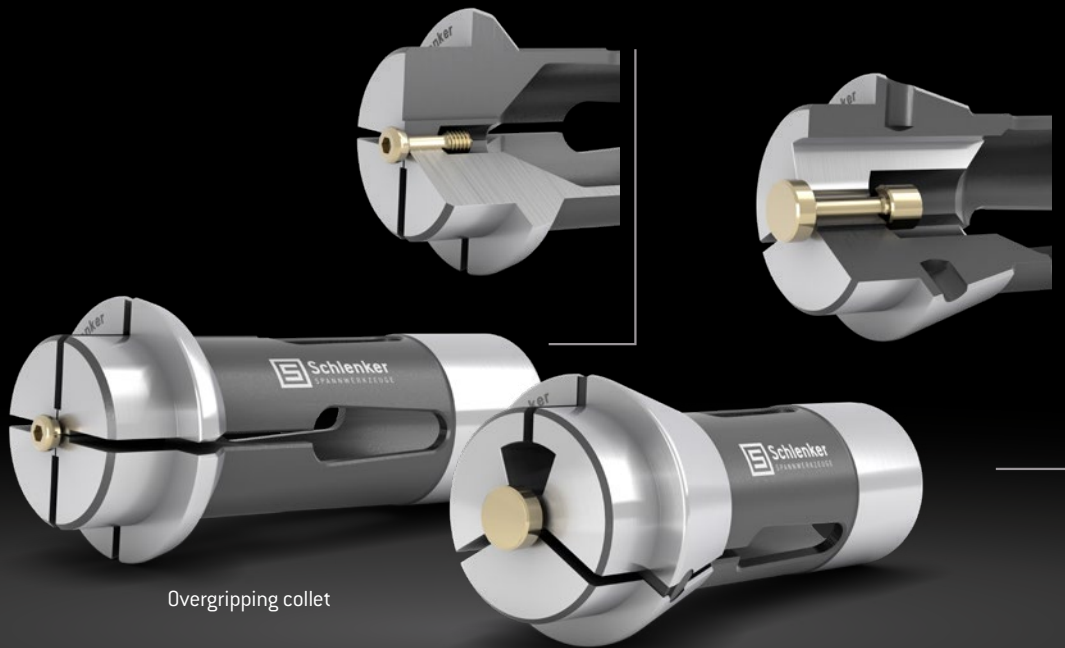


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USE OF OVERGRIP COLLETS

The overgrip collets are often used in production when the diameter to be clamped is smaller than the diameter to be overgripped. The maximum diameter difference to be overgripped should not be larger than 2.5mm. The decisive factors here are the stroke, the clamping length and the machine type which must be individually adapted to the workpiece.

OVERGRIPPING AND OFFSET GRIPPING COLLETS



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OVERGRIP COLLET VERSIONS



- OVERGRIPPING 30°**
- Taper angle of the collet is adjusted to the respective degree
 - Producable with long nose
 - Suitable for toggle clamping
 - Taper angle of the pressure sleeve must be adapted



- OVERGRIPPING 45°**
- Taper angle of the collet is adjusted to the respective degree
 - Producable with long nose
 - Suitable for toggle clamping
 - Taper angle of the pressure sleeve must be adapted



- OVERGRIPPING 16 / 45°**
- Taper angle of the collet is adjusted
 - Producable with long nose
 - Overgripping of max. 2.5 mm possible
 - The clamping stroke of the pressure sleeve should be at least 2.5 mm
 - Adaption of the taper angle of the pressure sleeve not required

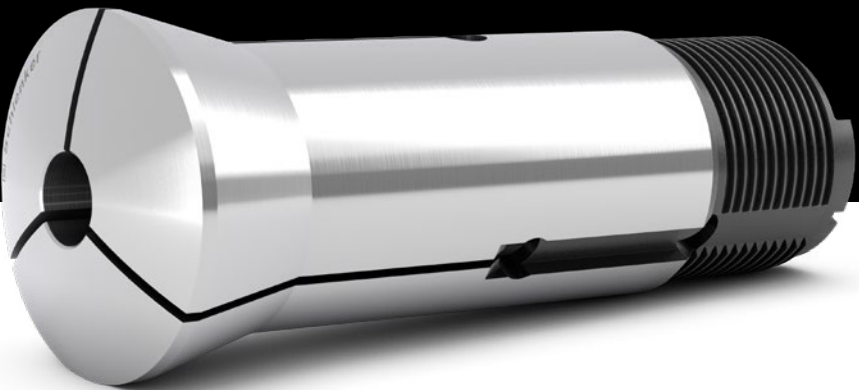


- OFFSET GRIPPING**
- Are used if the diameter to be clamped is smaller than the diameter to be overgripped
 - X-axis on the sub spindle is required



MASA TOOL MICROCONIC OVERGRIP COLLETS CAN BE FOUND ON PAGES 120 – 145.

HYDROMAT COLLETS

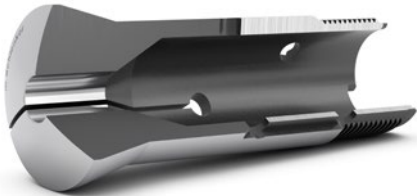
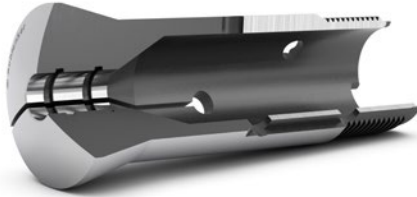


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USE OF HYDROMAT COLLETS

Hydromat collets are used for workpiece clamping as well as in rotary transfer machines such as Eubama, Hydromat and Pfiffner (FFG). Hydromat collets are available with threaded or quick change version. They can also be supplied with a saw burr cut in the clamping area. Suitable for the Hydromat collets, Hydromat reducing sleeves, ejector bar, ejector sleeves and stop heads can be manufactured.



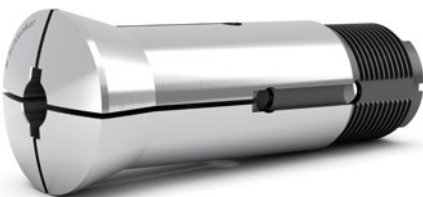
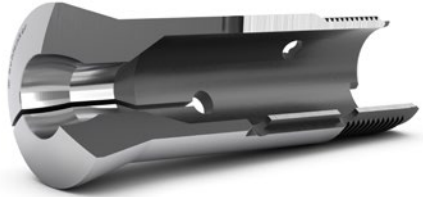
CLAMPING SURFACE DESIGNS

	SMOOTH <ul style="list-style-type: none">• Standard Hydromat collet
	SAW BURR CUT <ul style="list-style-type: none">• Improved runout, as sawing burr can be reliably picked up in the clearance area


HYDROMAT COLLET OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- VERSIONS
- ACCESSORIES


SHAPES

	SQUARE <ul style="list-style-type: none">• Suitable for clamping square material
	HEXAGON <ul style="list-style-type: none">• Suitable for clamping hexagon material
	SPECIAL PROFILES <ul style="list-style-type: none">• Various profiles possible• Profiles can be adapted individually to the workpiece
	SPECIAL CONTOURS <ul style="list-style-type: none">• Complex contours can be realized by hard milling, hard turning and grinding• Already possible with smallest diameters from 0.2 mm



SLOT DESIGNS

	<p>S-SLOT</p> <ul style="list-style-type: none">• High and constant clamping force• Clamping with virtually no clamping marks• Alternatively usable for profile material (corner clamping)• Prevents the entry of machining chips, as the collet closes almost completely• Easy to clean after use
	<p>L-SLOT</p> <ul style="list-style-type: none">• High and constant clamping force• Clamping with virtually no clamping marks• Alternatively usable for profile material (corner clamping)• Prevents the entry of machining chips, as the collet closes almost completely• Easy to clean after use• Ideal for clamping on short clamping surfaces
	<p>W-SLOT</p> <ul style="list-style-type: none">• High and constant clamping force• Clamping with virtually no clamping marks• Alternatively usable for profile material (corner clamping)• Prevents the entry of machining chips, as the collet closes almost completely• Easy to clean after use
	<p>Z-SLOT</p> <ul style="list-style-type: none">• High and constant clamping force• Clamping with virtually no clamping marks• Alternatively usable for profile material (corner clamping)• Prevents the entry of machining chips, as the collet closes almost completely• Easy to clean after use
	<p>THIN SLOTTED</p> <ul style="list-style-type: none">• Clamping with virtually no clamping marks• Prevents the entry of machining chips, as the collet closes almost completely• Recommended for small bore sizes

VERSIONS

	<p>QUICK CHANGE VERSION</p> <ul style="list-style-type: none">• The quick change version is screwed into the collet sleeve and locks itself automatically
---	--

ACCESSORIES

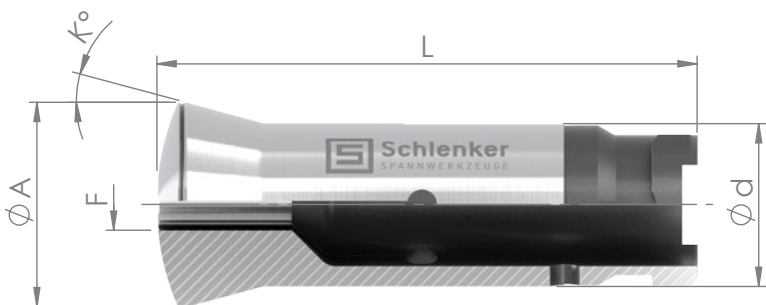
	<p>HYDROMAT REDUCING SLEEVES</p> <ul style="list-style-type: none">• Are inserted in Hydromat collets, this allows to clamp two different diameters with one collet
	<p>EJECTOR BAR / EJECTOR HEADS</p> <ul style="list-style-type: none">• Are part of a module for Hydromat collets to eject or stop workpieces

HYDROMAT COLLETS



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

Article	Ø d [mm]	Ø A [mm]	L [mm]	K [degree]	G	F min. – max. [mm]			Step bore
SHW20	20	26.3	96.5	15	Ø19.7x1.666 45°/5°	1.0 – 13.5	2.0 – 9.5	2.0 – 11.5	
SHW20	20	26.3	96.5	15	Ø19.7x1.666 45°/5°	13.51 – 20.0	PR	PR	PR
SHW25	25	33.7	97.6	15	Ø24.7x1.693 45°/5°	3.0 – 17.5	3.0 – 12.0	3.0 – 15.0	
SHW25	25	33.7	97.6	15	Ø24.7x1.693 45°/5°	17.51 – 25.0	PR	PR	PR
SHB32	32	40	106	15	Ø29.7x1.693 45°/5°	3.0 – 23.5	3.0 – 16.5	3.0 – 20.0	
SHB32	32	40	106	15	Ø29.7x1.693 45°/5°	23.51 – 28.0	PR	PR	PR
SHB32/45	32	53	122	15	Ø29.7x1.693 45°/5°	3.0 – 23.5	3.0 – 16.5	3.0 – 20.0	
SHB32/45	32	53	122	15	Ø29.7x1.693 45°/5°	23.51 – 41.0	PR	PR	PR
SHB45	45	53	115	15	M42x1.5	3.0 – 36.0	3.0 – 25.0	3.0 – 31.0	
SHB45	45	53	115	15	M42x1.5	36.01 – 41.0	PR	PR	PR
SHB45/60	45	68	PR	15	M42x1.5	PR	PR	PR	
SHB45/60	45	68	PR	15	M42x1.5	PR	PR	PR	PR



d Shaft-Ø A Head-Ø L Total length K Taper angle G Interface F Shape

Article	Ø d [mm]	Ø A [mm]	L [mm]	K [degree]	G	F min. – max. [mm]			Step bore
SHW25QC	25	33.7	97.6	15	Quick change	3.0 – 17.5	3.0 – 12.0	3.0 – 15.0	
SHW25QC	25	33.7	97.6	15	Quick change	17.51 – 25.0	PR	PR	PR
SHB32QC	32	40	106	15	Quick change	3.0 – 23.5	3.0 – 16.5	3.0 – 20.0	
SHB32QC	32	40	106	15	Quick change	23.51 – 28.0	PR	PR	PR
SHB45QC	45	53	116.5	15	Quick change	3.0 – 36.0	3.0 – 25.0	3.0 – 31.0	
SHB45QC	45	53	116.5	15	Quick change	36.01 – 41.0	PR	PR	PR

DRAW-IN COLLETS

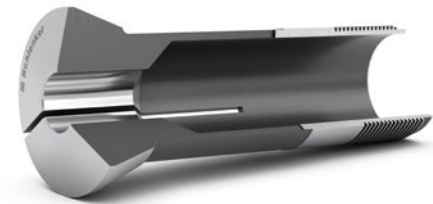




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USE OF DRAW-IN COLLETS

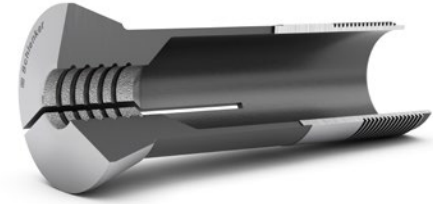

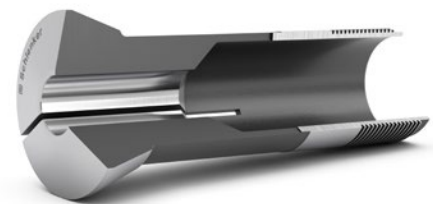
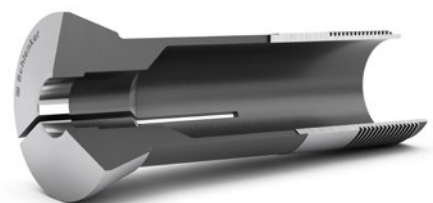
Draw-in collets are used for workpiece clamping as well as in all common grinding machines, dividing heads and manual turning machines. Clamping is performed by retracting the draw-in collet into the collet sleeve.

CLAMPING SURFACE DESIGNS





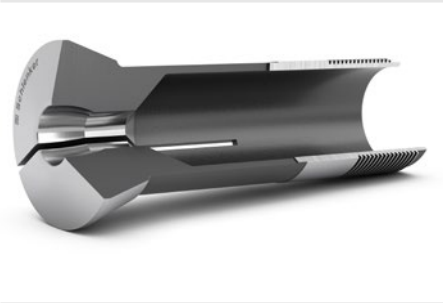
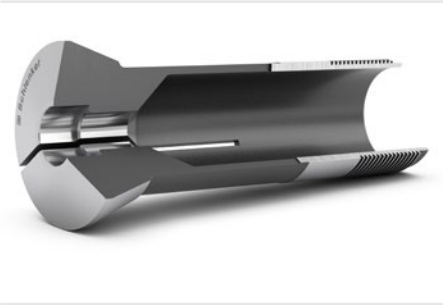
	SMOOTH – STANDARD <ul style="list-style-type: none"> Standard draw-in collet
	GROOVED <ul style="list-style-type: none"> With additional grooves
	AXIAL & RADIAL GROOVES <ul style="list-style-type: none"> Higher clamping force compared to the to the standard grooved collet due to the additional axial grooves

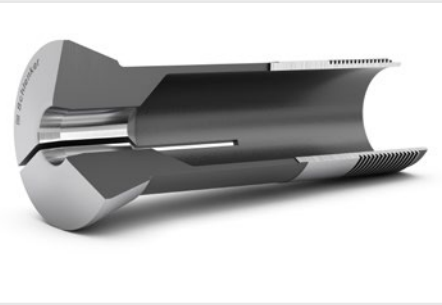
DRAW-IN COLLET OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- ADDITIONAL VERSIONS
- INSERTS
- VERSIONS



	CARBIDE COATING <ul style="list-style-type: none"> Carbide coating possible for all shapes Higher coefficient of friction than a standard collet Higher clamping force Repeated / afterward coating possible
	SUPERGRIP <ul style="list-style-type: none"> Highest clamping force at the same clamping pressure of the machine due to very closely spaced axial grooves
	EXTENDED CLAMPING LENGTH <ul style="list-style-type: none"> Can be used for long workpieces with multiple grooves Higher wrap around at the workpiece perimeter, therefore more force to clamp More stable clamping for long workpieces
	SHORTENED CLAMPING LENGTH <ul style="list-style-type: none"> Application for workpieces whose geometry behind the clamping diameter shouldn't be damaged Used for short workpieces so the ejector can be lead closer to the clamping diameter


SHAPES

	<p>SQUARE</p> <ul style="list-style-type: none">• Suitable for clamping square material
	<p>HEXAGON</p> <ul style="list-style-type: none">• Suitable for clamping hexagon material
	<p>SPECIAL PROFILES</p> <ul style="list-style-type: none">• Various profiles can be realized by ram EDM or wire EDM• Profiles can be adapted individually to the workpiece
	<p>ECCENTRIC</p> <ul style="list-style-type: none">• Eccentric bore can be eroded individually according to application• Through hole or offset hole is possible
	<p>SPECIAL CONTOURS</p> <ul style="list-style-type: none">• Complex contours can be realized by hard milling, hard turning and grinding• Already possible with smallest diameters from 0.2 mm
	<p>STEPS</p> <ul style="list-style-type: none">• Steps are suitable for simultaneous clamping of several diameters of a workpiece• Very high precision as both steps are ground in one step

	<p>INNER CONICAL</p> <ul style="list-style-type: none">• For gripping conical workpieces• The clamping angle is precisely adapted to the workpiece
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SLOT DESIGNS

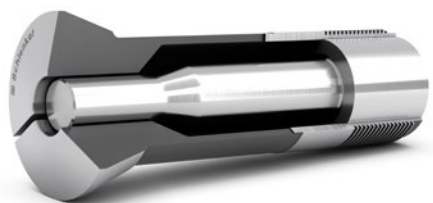
	<p>S-SLOT</p> <ul style="list-style-type: none">• High and constant clamping force• Clamping with virtually no clamping marks• Alternatively usable for profile material (corner clamping)• Prevents the entry of machining chips, as the collet closes almost completely• Easy to clean after use
	<p>L-SLOT</p> <ul style="list-style-type: none">• High and constant clamping force• Clamping with virtually no clamping marks• Alternatively usable for profile material (corner clamping)• Prevents the entry of machining chips, as the collet closes almost completely• Easy to clean after use• Ideal for clamping on short clamping surfaces
	<p>W-SLOT</p> <ul style="list-style-type: none">• High and constant clamping force• Clamping with virtually no clamping marks• Alternatively usable for profile material (corner clamping)• Prevents the entry of machining chips, as the collet closes almost completely• Easy to clean after use
	<p>Z-SLOT</p> <ul style="list-style-type: none">• High and constant clamping force• Clamping with virtually no clamping marks• Alternatively usable for profile material (corner clamping)• Prevents the entry of machining chips, as the collet closes almost completely• Easy to clean after use

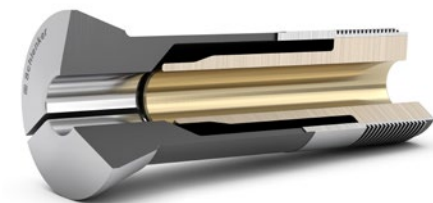
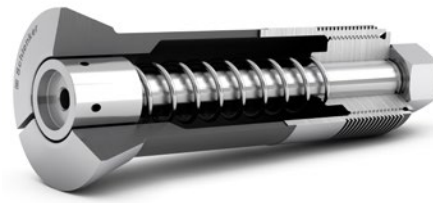

	<p>THIN SLOTTED</p> <ul style="list-style-type: none"> • Clamping with virtually no clamping marks • Prevents the entry of machining chips, as the collet closes almost completely • Recommended for small bore sizes
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WEAR REDUCTION


	<p>CARBIDE INSERT</p> <ul style="list-style-type: none"> • High wear resistance • Prevents pressure marks on the workpiece • Higher service life
	<p>BL COATING</p> <ul style="list-style-type: none"> • Smooth surface • Fewer clamping marks on the material • Especially suitable for material with poor gliding properties • Prevents the welding of the material in the collet
	<p>PREMIUM BLUE COATING</p> <ul style="list-style-type: none"> • Economical alternative to collets with carbide insert • High wear resistance • Can also be used for special shapes • Are completely coated on the functional surfaces like cone and shaft therefore more durable

ADDITIONAL VERSIONS

	<p>INTERNAL STOP</p> <ul style="list-style-type: none"> • Suitable for manual loading of the machine at a certain length • Prevents the displacement of the workpiece at high axial forces • Used to stabilize the workpiece when the clamping length is too short
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	<p>SUPPORTING BUSH</p> <ul style="list-style-type: none"> • Minimizes vibrations as the bar material is supported along its total length and keeps it axially aligned • Ejection is made possible in a process-safe way
	<p>EJECTOR & INNER COOLING</p> <ul style="list-style-type: none"> • Mechanical ejection of the workpieces • If required internal cooling of components can be integrated • For flushing the clamping surface • Simple change of the ejector within one collet type possible
	<p>UP VERSION</p> <ul style="list-style-type: none"> • High precision
	<p>UUP VERSION</p> <ul style="list-style-type: none"> • Highest precision
	<p>SEALED</p> <ul style="list-style-type: none"> • Prevents the entry of machining chips • The whole slot area can be sealed • Resealing possible • Not usable with high pressure flushing in the machine

INSERTS

	<p>PEEK / PLASTIC INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping
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	ALUMINIUM INSERTS <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping
	BRASS INSERTS <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping
	BRONZE INSERTS <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping
	PERMAGLIS INSERTS <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping
	INSERTS FOR SELF-TURNING <ul style="list-style-type: none"> Clamping diameter can be turned out by the user himself Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping

VERSIONS

	LONG NOSE <ul style="list-style-type: none"> Are used for workpiece clamping Better accessibility to the workpiece
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DRAW-IN COLLETS



	d	A	L	K	G	F
	Shaft-Ø	Head-Ø	Total length	Taper angle	Thread	Shape
Article	Ø d [mm]	Ø A [mm]	L [mm]	K [degree]	G	F min. – max. [mm]
						● ■ ◆
E324	15	21.5	53	20	M13x1	1.0 – 9.0 2.0 – 6.5 2.0 – 8.0
E3409	20	28	90	8	Tr.20x1.5	2.0 – 14.5 PR PR
E351	20	28	80	20	Tr.20x1.5	1.0 – 15.0 2.0 – 10.5 2.0 – 13.0
E358	23	32	81.5	20	M21x1	1.0 – 16.5 2.0 – 11.0 2.0 – 14.5
E359	23	32	89.5	20	Tr.23x1.5	1.0 – 18.0 2.0 – 12.0 2.0 – 16.0
E363	25	33.5	84	16	M23x1	1.0 – 17.5 2.0 – 12.5 2.0 – 15.5
E366	28	36	100	18	Tr.27x1/20"	1.0 – 21.0 2.0 – 15.0 2.0 – 18.0
E367	28	38	100	20	Tr.28x1.5	1.0 – 22.0 2.0 – 15.5 2.0 – 19.0
E385	31.75	37.5	83	10	Outside: 31.45x1/20" Inside: 26.44x1.058	1.0 – 25.0 2.0 – 17.5 2.0 – 21.5
E386	32	45	110	20	Tr.32x1.5	1.0 – 27.0 3.0 – 19.0 3.0 – 23.5
E666	25	35	59.5	20	M25x1	3.0 – 20.0 PR PR
K20	20	28	80	20	Tr.20x1.5	1.0 – 15.0 2.0 – 10.5 2.0 – 13.0
K23	23	32	89.5	20	Tr.23x1.5	1.0 – 18.0 2.0 – 13.0 2.0 – 16.0
K32	32	45	110	20	Tr.32x1.5	1.0 – 27.0 4.0 – 19.0 3.0 – 23.5
K45	45	60	140	20	Tr.45x2	5.0 – 36.5 5.0 – 26.0 5.0 – 32.0
KDT38	58	70.3	99	15	M50x1.5	10.0 – 38.0 8.0 – 26.0 8.0 – 32.0



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

DRAW-IN COLLETS SW&B



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USE OF DRAW-IN COLLETS SW&B

Draw-in collets are used for workpiece clamping as well as in all common grinding machines, dividing heads and manual turning machines. Clamping is performed by retracting the draw-in collet into the collet sleeve.

CLAMPING SURFACE DESIGNS

	SMOOTH – STANDARD <ul style="list-style-type: none">• Standard draw-in collet
	GROOVED <ul style="list-style-type: none">• With additional grooves
	AXIAL & RADIAL GROOVES <ul style="list-style-type: none">• Higher clamping force compared to the grooved standard collet due to the additional axial grooves
	CARBIDE COATING <ul style="list-style-type: none">• Carbide coating possible for all shapes• Higher coefficient of friction than a standard collet• Higher clamping force• Repeated / afterward coating possible

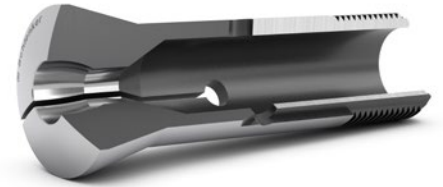
DRAW-IN COLLET SW&B OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- ADDITIONAL VERSIONS
- INSERTS


	SUPERGRIP <ul style="list-style-type: none">• Highest clamping force at the same clamping pressure of the machine due to very closely spaced axial grooves
	EXTENDED CLAMPING LENGTH <ul style="list-style-type: none">• Can be used for long workpieces with multiple grooves• Higher wrap around at the workpiece perimeter, therefore more force to clamp• More stable clamping for long workpieces
	SHORTENED CLAMPING LENGTH <ul style="list-style-type: none">• Application for workpieces whose geometry behind the clamping diameter shouldn't be damaged• Used for short workpieces so the ejector can be lead closer to the clamping diameter


SHAPES

	SQUARE <ul style="list-style-type: none">• Suitable for clamping square material
	HEXAGON <ul style="list-style-type: none">• Suitable for clamping hexagon material

	<p>SPECIAL PROFILES</p> <ul style="list-style-type: none"> • Various profiles can be realized by ram EDM or wire EDM • Profiles can be adapted individually to the workpiece
	<p>ECCENTRIC</p> <ul style="list-style-type: none"> • Eccentric bore can be eroded individually according to application • Through hole or offset hole is possible
	<p>SPECIAL CONTOURS</p> <ul style="list-style-type: none"> • Complex contours can be realized by hard milling, hard turning and grinding • Already possible with smallest diameters from 0.2 mm
	<p>STEPS</p> <ul style="list-style-type: none"> • Steps are suitable for simultaneous clamping of several diameters of a workpiece • Very high precision as both steps are ground in one step
	<p>INNER CONICAL</p> <ul style="list-style-type: none"> • For gripping conical workpieces • The taper angle of the collet is precisely adapted to the workpiece

SLOT DESIGNS

	<p>S-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use
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	<p>L-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use • Ideal for clamping on short clamping surfaces
	<p>W-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use
	<p>Z-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use
	<p>THIN SLOTTED</p> <ul style="list-style-type: none"> • Clamping with virtually no clamping marks • Prevents the entry of machining chips, as the collet closes almost completely • Recommended for small bore sizes


WEAR REDUCTION

	<p>CARBIDE INSERT</p> <ul style="list-style-type: none"> • High wear resistance • Prevents pressure marks on the workpiece • Higher service life
	<p>BL COATING</p> <ul style="list-style-type: none"> • Smooth surface • Fewer clamping marks on the material • Especially suitable for material with poor gliding properties • Prevents the welding of the material in the collet

	<p>PREMIUM BLUE COATING</p> <ul style="list-style-type: none"> • Economical alternative to collets with carbide insert • High wear resistance • Can also be used for special shapes • Are completely coated on the functional surfaces like cone and shaft therefore more durable
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ADDITIONAL VERSIONS

	<p>INTERNAL STOP</p> <ul style="list-style-type: none"> • Suitable for manual loading of the machine at a certain length • Prevents the displacement of the workpiece at high axial forces • Used to stabilize the workpiece when the clamping length is too short
	<p>SUPPORTING BUSH</p> <ul style="list-style-type: none"> • Minimizes vibrations as the bar material is supported along its total length and keeps it axially aligned • Ejection is made possible in a process-safe way
	<p>EJECTOR & INNER COOLING</p> <ul style="list-style-type: none"> • Mechanical ejection of the workpieces • If required internal cooling of components can be integrated • For flushing the clamping surface • Simple change of the ejector within one collet type possible
	<p>UP VERSION</p> <ul style="list-style-type: none"> • High precision
	<p>UUP VERSION</p> <ul style="list-style-type: none"> • Highest precision

	<p>SEALED</p> <ul style="list-style-type: none"> • Prevents the entry of machining chips • The whole slot area can be sealed • Resealing possible • Not usable with high pressure flushing in the machine
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INSERTS

	<p>PEEK / PLASTIC INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping
	<p>ALUMINIUM INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping
	<p>BRASS INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping
	<p>BRONZE INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping
	<p>PERMAGLIS INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping
	<p>INSERTS FOR SELF-TURNING</p> <ul style="list-style-type: none"> • Clamping diameter can be turned out by the user himself • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping

DRAW-IN COLLETS SW&B



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

Article	Ø d [mm]	Ø A [mm]	L [mm]	K [degree]	G	F min. – max. [mm]			Step bore
						●	■	⬡	
SW12 80-2 E318	12	16	46	15	Ø11.75x1.25 45°/5°	0.5 – 8.0	PR	PR	
SW12 80-2 E318	12	16	46	15	Ø11.75x1.25 45°/5°	8.01 – 12.5	PR	PR	PR
SW15 80-3 E321	15	20.2	58.3	15	Ø14.75x1.25 45°/5°	0.5 – 10.5	PR	PR	
SW15 80-3 E321	15	20.2	58.3	15	Ø14.75x1.25 45°/5°	10.51 – 16.0	PR	PR	PR
SW20 80-4 E349	20	26.3	73	15	Ø19.7x1.666 45°/5°	0.5 – 14.5	2.0 – 10.0	2.0 – 12.0	
SW20 80-4 E349	20	26.3	73	15	Ø19.7x1.666 45°/5°	14.51 – 23.0	PR	PR	PR
SW25 80-5 E364	25	33.7	97.6	15	Ø24.7x1.693 45°/5°	0.5 – 18.0	2.0 – 12.5	2.0 – 15.5	
SW25 80-5 E364	25	33.7	97.6	15	Ø24.7x1.693 45°/5°	18.1 – 29.0	PR	PR	PR
B32 72-65	32	40	106	15	Ø29.7x1.693 45°/5°	1.0 – 24.0	3.0 – 16.5	3.0 – 20.5	
B32 72-65	32	40	106	15	Ø29.7x1.693 45°/5°	24.01 – 32.0	PR	PR	PR



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

Article	Ø d [mm]	Ø A [mm]	L [mm]	K [degree]	G	F min. – max. [mm]			Step bore
						●	■	⬡	
B45 72-199	45	53	115	15	M42x1.5	5.0 – 36.0	5.0 – 25.5	5.0 – 31.0	
B45 72-199	45	53	115	15	M42x1.5	36.01 – 45.0	PR	PR	PR



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

DRAW-IN LONG NOSE COLLETS SW&B

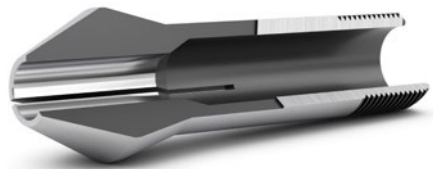
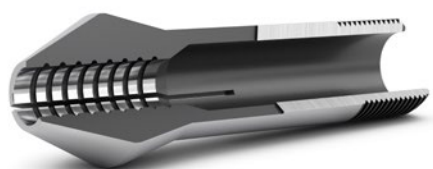
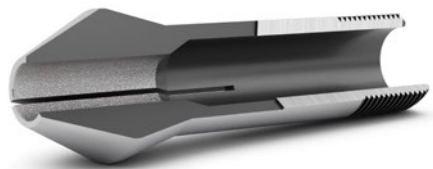


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USE OF DRAW-IN LONG NOSE COLLETS SW&B

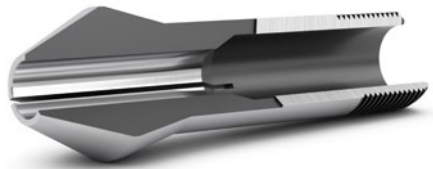
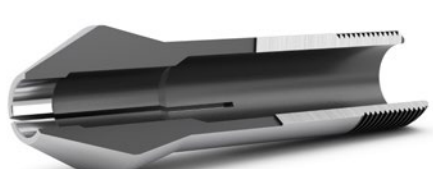
Draw-in long nose collets are used for workpiece clamping as well as in all common grinding machines, dividing heads and manual turning machines. The long nose provides better accessibility to the workpiece.

CLAMPING SURFACE DESIGNS



	SMOOTH – STANDARD <ul style="list-style-type: none">• Standard draw-in long nose collet
	GROOVED <ul style="list-style-type: none">• With additional grooves
	CARBIDE COATING <ul style="list-style-type: none">• Carbide coating possible for all shapes• Higher coefficient of friction than a standard collet• Higher clamping force• Repeated / afterward coating possible


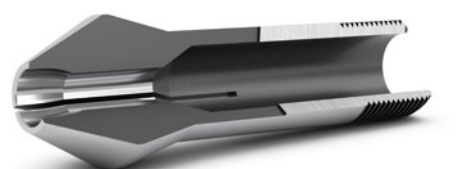
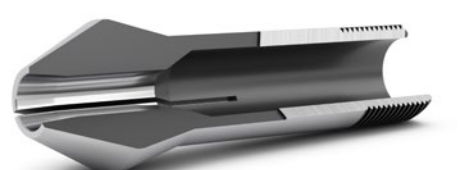
DRAW-IN LONG NOSE COLLET SW&B OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- ADDITIONAL VERSIONS
- INSERTS


	EXTENDED CLAMPING LENGTH <ul style="list-style-type: none">• Can be used for long workpieces with multiple grooves• Higher wrap around at the workpiece perimeter, therefore more force to clamp• More stable clamping for long workpieces
	SHORTENED CLAMPING LENGTH <ul style="list-style-type: none">• Application for workpieces whose geometry behind the clamping diameter shouldn't be damaged• Used for short workpieces so the ejector can be lead closer to the clamping diameter





SHAPES

	SQUARE <ul style="list-style-type: none">• Suitable for clamping square material
	HEXAGON <ul style="list-style-type: none">• Suitable for clamping hexagon material


	<p>SPECIAL PROFILES</p> <ul style="list-style-type: none"> • Various profiles can be realized by ram EDM or wire EDM • Profiles can be adapted individually to the workpiece
	<p>ECCENTRIC</p> <ul style="list-style-type: none"> • Eccentric bore can be eroded individually according to application • Through hole or offset hole is possible
	<p>SPECIAL CONTOURS</p> <ul style="list-style-type: none"> • Complex contours can be realized by hard milling, hard turning and grinding • Already possible with smallest diameters from 0.2 mm
	<p>STEPS</p> <ul style="list-style-type: none"> • Steps are suitable for simultaneous clamping of several diameters of a workpiece • Very high precision as both steps are ground in one step
	<p>INNER CONICAL</p> <ul style="list-style-type: none"> • For gripping conical workpieces • The taper angle of the collet is precisely adapted to the workpiece

SLOT DESIGNS

	<p>S-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use
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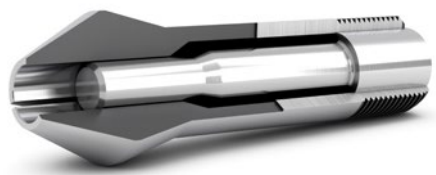
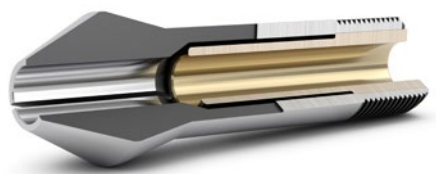
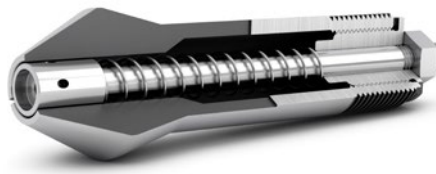

	<p>L-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use • Ideal for clamping on short clamping surfaces
	<p>W-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use
	<p>Z-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use
	<p>THIN SLOTTED</p> <ul style="list-style-type: none"> • Clamping with virtually no clamping marks • Prevents the entry of machining chips, as the collet closes almost completely • Recommended for small bore sizes

WEAR REDUCTION

	<p>CARBIDE INSERT</p> <ul style="list-style-type: none"> • High wear resistance • Prevents pressure marks on the workpiece • Higher service life
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	<p>BL COATING</p> <ul style="list-style-type: none"> • Smooth surface • Fewer clamping marks on the material • Especially suitable for material with poor gliding properties • Prevents the welding of the material in the collet
	<p>PREMIUM BLUE COATING</p> <ul style="list-style-type: none"> • Economical alternative to collets with carbide insert • High wear resistance • Can also be used for special shapes • Are completely coated on the functional surfaces like cone and shaft therefore more durable




ADDITIONAL VERSIONS

	<p>INTERNAL STOP</p> <ul style="list-style-type: none"> • Suitable for manual loading of the machine at a certain length • Prevents the displacement of the workpiece at high axial forces • Used to stabilize the workpiece when the clamping length is too short
	<p>SUPPORTING BUSH</p> <ul style="list-style-type: none"> • Minimizes vibrations as the bar material is supported along its total length and keeps it axially aligned • Ejection is made possible in a process-safe way
	<p>EJECTOR & INNER COOLING</p> <ul style="list-style-type: none"> • Mechanical ejection of the workpieces • If required internal cooling of components can be integrated • For flushing the clamping surface • Simple change of the ejector within one collet type possible
	<p>UP VERSION</p> <ul style="list-style-type: none"> • High precision

	<p>UUP VERSION</p> <ul style="list-style-type: none"> • Highest precision
	<p>SEALED</p> <ul style="list-style-type: none"> • Prevents the entry of machining chips • The whole slot area can be sealed • Resealing possible • Not usable with high pressure flushing in the machine

INSERTS




	<p>PEEK / PLASTIC INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping
	<p>ALUMINIUM INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping
	<p>BRASS INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping

	BRONZE INSERTS <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping
	PERMAGLIS INSERTS <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping
	INSERTS FOR SELF-TURNING <ul style="list-style-type: none"> Clamping diameter can be turned out by the user himself Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping

DRAW-IN LONG NOSE COLLETS SW&B



d Shaft-Ø A Head-Ø V Long nose length L Total length K Taper angle G Thread F Shape

Article	Ø d [mm]	Ø A [mm]	V [mm]	L [mm]	K [degree]	G	F min. – max. [mm]			Step bore
										
SW12 E318	12	16	8.8	52	15	Ø11.75x1.25 45°/5°	0.5 – 8.0	PR	PR	
SW12 E318	12	16	8.8	52	15	Ø11.75x1.25 45°/5°	8.01 – 10.0	PR	PR	PR
SW15 E321	15	20.2	12	67	15	Ø14.75x1.25 45°/5°	0.5 – 10.5	PR	PR	
SW15 E321	15	20.2	12	67	15	Ø14.75x1.25 45°/5°	10.51 – 12.5	PR	PR	PR
SW20 E349	20	26.3	15.5	84.5	15	Ø19.7x1.666 45°/5°	0.5 – 14.5	PR	PR	
SW20 E349	20	26.3	15.5	84.5	15	Ø19.7x1.666 45°/5°	14.51 – 16.0	PR	PR	PR
SW25 E364	25	33.7	19.5	112	15	Ø24.7x1.693 45°/5°	1.0 – 18.0	PR	PR	
SW25 E364	25	33.7	19.5	112	15	Ø24.7x1.693 45°/5°	18.01 – 25.0	PR	PR	PR
B32	32	40	24	124	15	Ø29.7x1.693 45°/5°	10.0 – 24.0	PR	PR	
B32	32	40	24	124	15	Ø29.7x1.693 45°/5°	24.01 – 28.0	PR	PR	PR
B32/45	32	53	32.5	148.5	15	Ø29.7x1.693 45°/5°	5.0 – 24.0	PR	PR	
B32/45	32	53	32.5	148.5	15	Ø29.7x1.693 45°/5°	24.01 – 40.0	PR	PR	PR



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

MAIN SPINDLE MULTI-SPINDLE COLLETS



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MAIN SPINDLE MULTI-SPINDLE COLLETS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- ADDITIONAL VERSIONS

USE OF MAIN SPINDLE MULTI-SPINDLE COLLETS

Multi-Spindle collets are used for workpiece clamping as well as in all common multi-spindle machines.

Figure 1



Figure 2



Figure 3



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

Article	Ø d [mm]	Ø A [mm]	L [mm]	K [degree]	G	F min. – max. [mm]		
Figure 1								
E9007	32	41.5	79	15	M28x1L	23.5	16.5	20.0
E9012	34	42	85	16	M30x1L	25.0	17.5	21.5
E9016	32	41.5	79	15	M30x1L	23.5	16.5	20.0
E9018	35	45	105	16	M33x1	27.5	19.0	23.5
E9021	25	35	92	16	M25x1	20.5	14.5	17.5
E9039	46	60.3	112	15	M40x1.5L	33.5	23.5	29.0
E9049	46	60.3	112	15	M40x1.5L	33.5	23.5	29.0
E9070	53	69.3	129	15	M47x1.5L	40.5	28.5	35.0
E9112	62.9	78.3	147	15	M56x1.5L	49.5	35.0	42.5
Figure 2								
E9001	25	35	73	15	M22x1	19.5	13.5	16.5
E9017	38	45.5	85	16	M34.5x0.75L	30.5	21.5	26.0
E9020	36	45	105	16	M33x1.25	27.5	19.0	23.5
E9034	41.25	54.6	130	15	1.484" – 1/24"L	32.5	23.0	28.0
E9069	53	69.4	128	15	M48x15L	41.5	29.0	35.5
Figure 3								
TW20	26	23	75	15	M20x1	3.0 – 15.0	4.0 – 10.0	4.0 – 12.0

SUB SPINDLE MULTI-SPINDLE COLLETS



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USING SUB SPINDLE MULTI-SPINDLE COLLETS

Multi-Spindle collets are used for workpiece clamping as well as in all common multi-spindle machines.

Figure 1

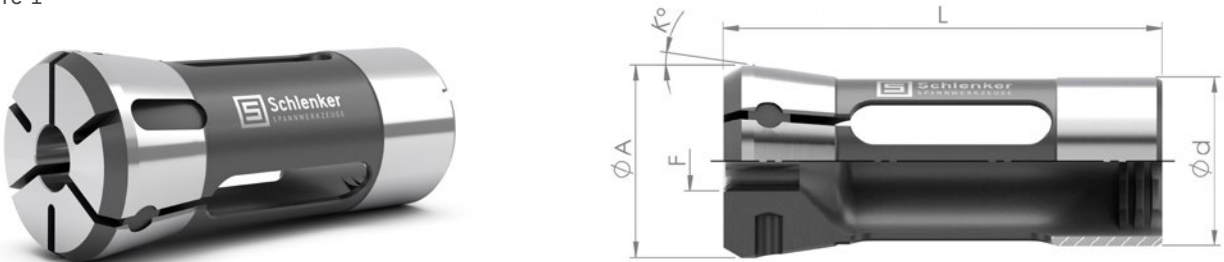


Figure 2

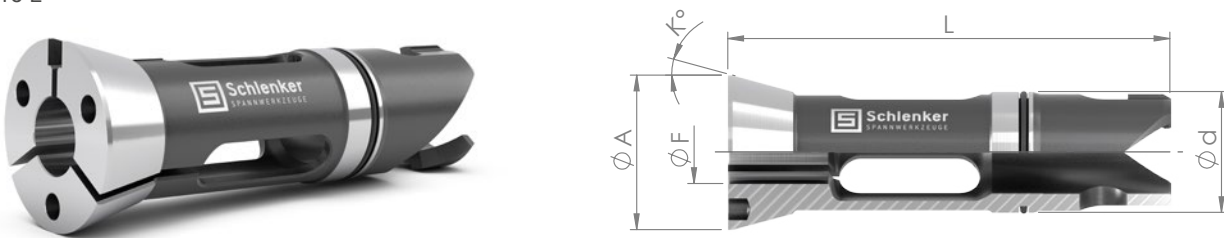


Figure 3

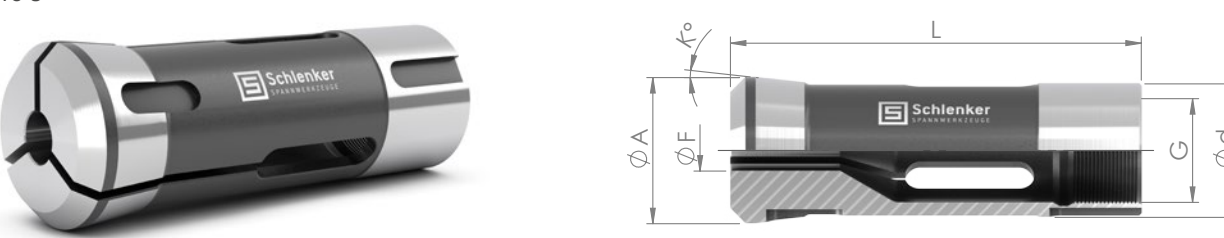
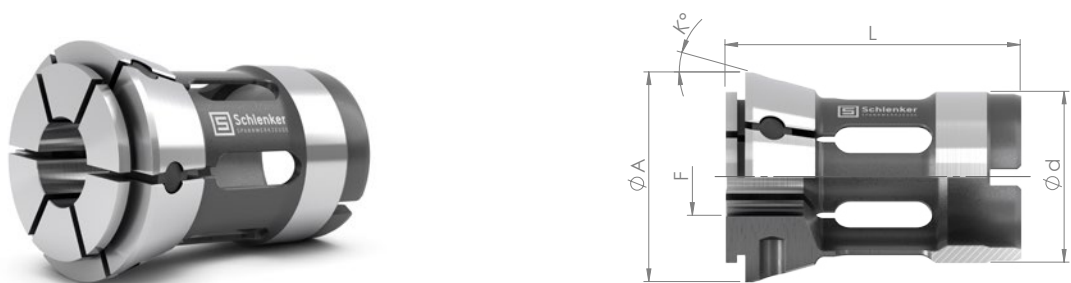


Figure 4



SUB SPINDLE MULTI-SPINDLE COLLETS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- ADDITIONAL VERSIONS

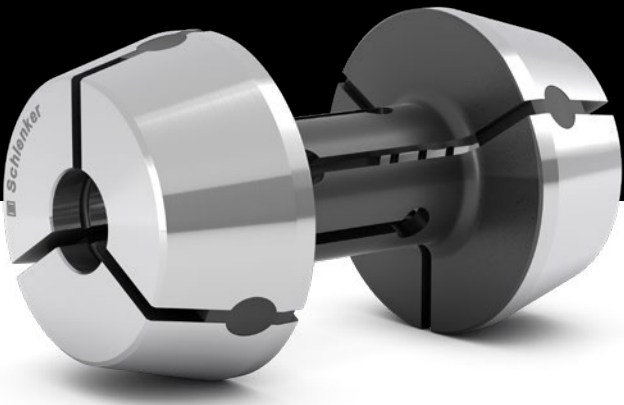
d Shaft-Ø A Head-Ø L Total length K Taper angle G Interface F Shape

Article	Ø d [mm]	Ø A [mm]	L [mm]	K [degree]	G	F min. – max. [mm]		
Figure 1								
ETPU 9012	28	32	73	8	Bayonet inside	24.5	17.0	21.0
ETPU 9039	35.5	40	80	8	Bayonet inside	32.0	22.5	27.5
G90699 H-G	39	44	82	8	Bayonet inside	32.0	22.5	27.5
Figure 2								
E3439	18.7	25	51.5	8	Bayonet outside	16.0	11.0	13.5
G35161	25	32.1	91.5	15	Bayonet outside	19.5	13.5	16.5
Figure 3								
EG9012/ E3560	26	28.5	80	6	M21.5x 0.75	20.0	14.0	17.0
G9016 E/G	28	36	50	15	M24x1.5L	22.5	15.5	19.0
GM20	28	32	62	8	M24 x1.5L	20.5	14.5	17.5
Figure 4								
G9039 E/G	34	42	53	15		26.0	18.0	22.5
G9070 E/G	52	60.6	60	15		40.0	28.0	34.5
G9139 E/G	63	71.6	60	15		51.0	36.0	44.0
G91397 H/G	59	67	76	16		51.0	36.0	44.0
G907034 H/G	44	54	76	16		36.0	25.0	31.0

DOUBLE CONE MULTI-SPINDLE COLLETS



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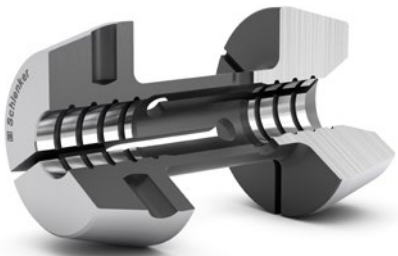
USE OF DOUBLE CONE MULTI-SPINDLE COLLETS

Double cone multi-spindle collets are used for workpiece clamping as well as in the main spindle of Tornos multi-spindle machines.

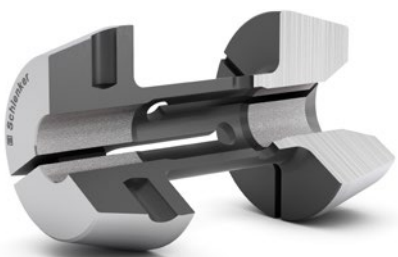
CLAMPING SURFACE DESIGNS



- SMOOTH**
- Mainly used on the main spindle



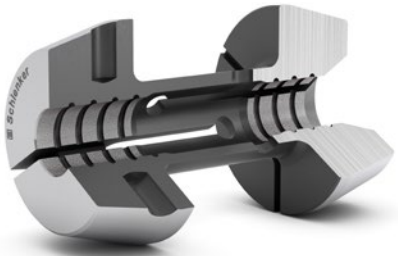
- GROOVED - STANDARD**
- Standard double cone collet
 - Mainly used on the main spindle



- CARBIDE COATING**
- Carbide coating possible for all shapes
 - Higher coefficient of friction than a standard collet
 - Higher clamping force
 - Repeated / afterward coating possible

DOUBLE CONE MULTI-SPINDLE COLLET OPTIONS

- CLAMPING SURFACE DESIGNS
- WEAR REDUCTION
- SLOT DESIGNS
- ADDITIONAL VERSIONS



- GROOVED & CARBIDE COATING**
- Carbide coating possible for all shapes
 - Higher coefficient of friction than a standard collet
 - Higher clamping force
 - Repeated / afterward coating possible

SLOT DESIGNS



- S-SLOT**
- High and constant clamping force
 - Clamping with virtually no clamping marks
 - Alternatively usable for profile material (corner clamping)
 - Prevents the entry of machining chips, as the collet closes almost completely
 - Easy to clean after use



- W-SLOT**
- High and constant clamping force
 - Clamping with virtually no clamping marks
 - Alternatively usable for profile material (corner clamping)
 - Prevents the entry of machining chips, as the collet closes almost completely
 - Easy to clean after use



Z-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use



THIN SLOTTED

- Clamping with virtually no clamping marks
- Prevents the entry of machining chips, as the collet closes almost completely
- Recommended for small bore sizes

WEAR REDUCTION



BL COATING

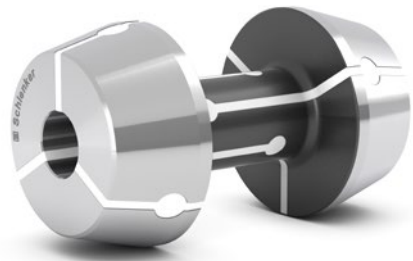
- Smooth surface
- Fewer clamping marks on the material
- Especially suitable for material with poor gliding properties
- prevents the welding of the material in the collet



PREMIUM BLUE COATING

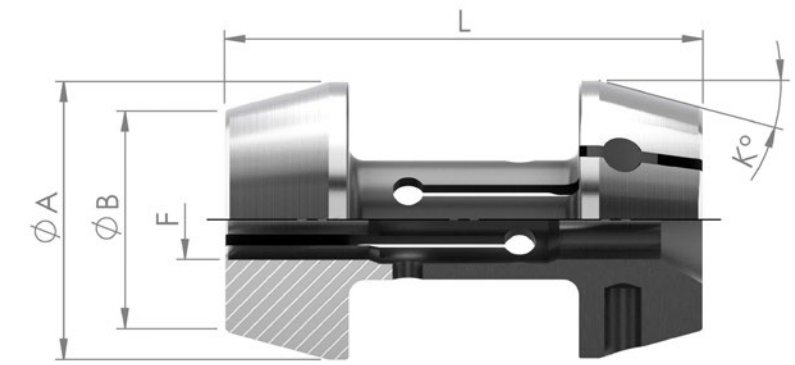
- High wear resistance
- Can also be used for special shapes
- Are completely coated on the functional surfaces like cone and shaft therefore more durable

ADDITIONAL VERSIONS




SEALED

- Prevents the entry of machining chips
- The whole slot area can be sealed
- Resealing possible
- Not usable with high pressure flushing in the machine

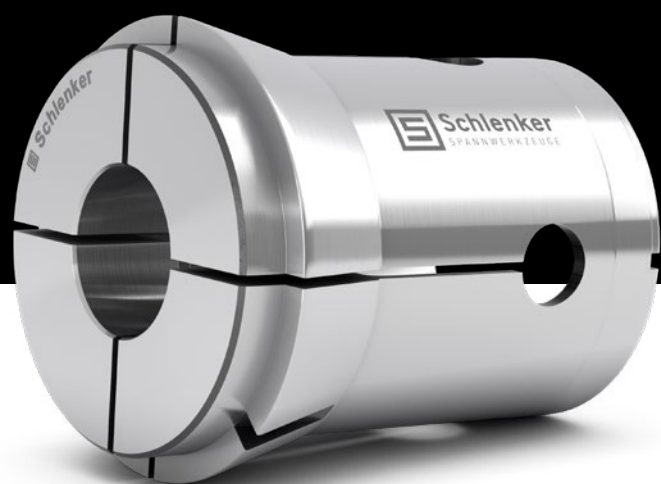


A	Head-Ø	B	Nose-Ø	L	Total length	K	Taper angle	F	Shape
---	--------	---	--------	---	--------------	---	-------------	---	-------

Article	Ø A [mm]	Ø B [mm]	L [mm]	K [degree]	F min. – max. [mm]
					
E8731	35	28	60	15	8.0 – 25.0
E8810	43	35	68	14	10.0 – 32.0

NOTES

PICK UP COLLETS



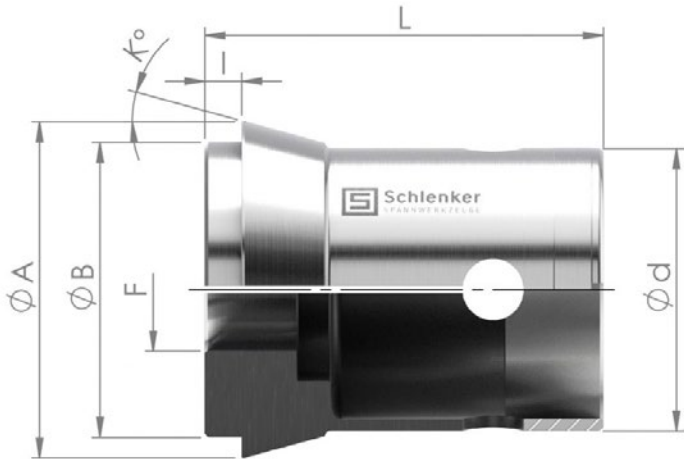
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USE OF PICK UP COLLETS




Pick up collets are available for all common automatic lathes.

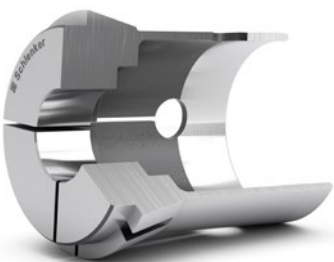
PICK UP COLLET OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- POSITIONING
- WEAR REDUCTION
- ADDITIONAL VERSIONS
- INSERTS



d Shaft-Ø A Head-Ø B Nose-Ø I Nose length L Total length K Taper angle F Shape

Article	Ø d [mm]	Ø A [mm]	Ø B [mm]	I [mm]	L [mm]	K [degree]	Typ	F min. – max. [mm]		
										
M105	12	14.5	10.5	6	21	16	STROHM	1.0 – 8.5	PR	PR
M105 Long nose	12	14.5	10.5	variable	variable	16	STROHM	3.0 – 8.0	PR	PR
M125	15	17	13	2	17	16	STROHM	1.0 – 10.0	PR	PR
M125 Long nose	15	17	13	variable	variable	16	STROHM	1.0 – 10.0	PR	PR
M205	24	28	22	6	36	16	STROHM	2.0 – 19.0	PR	PR
M612	35	40	32	6	46	15	TNS28	1.0 – 29.0	PR	PR
GM612	35	40	32	6	46	15	MANURHIN K'MX	1.0 – 30.0	PR	PR
G721	46	55	48	6	65	15	TNS30/42	1.0 – 42.0	PR	PR
G722	44.5	54	42	8.5	64	15		3.0 – 37.0	PR	PR
G952	61.5	71.5	62	6	65	15	TNM65	5.0 – 59.0	PR	PR



SMOOTH – STANDARD

- Standard pick up collet



SQUARE

- Suitable for clamping square material



HEXAGON

- Suitable for clamping hexagon material

SYNCHRONOUS COLLETS



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USE OF SYNCHRONOUS COLLETS

Synchronous collets are available especially for the INDEX/TRAUB automatic lathes.



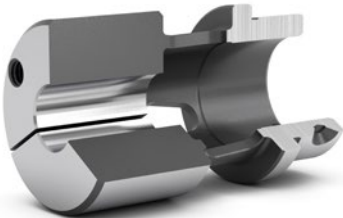
d Shaft-Ø A Head-Ø L Total length F Shape

Article	Ø d [mm]	Ø A [mm]	L [mm]	Typ	F min. – max. [mm]
					●
E1444	30	36	62	GS30	4.0 – 30.0
E1462	30	48	62	GS42, GB42, GB65, GSC42	4.0 – 42.0
E1465	30	62	94	GS65, GSC65, GS42S	6.0 – 56.0

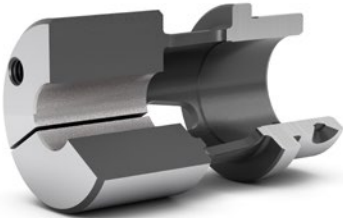
SYNCHRONOUS COLLET OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES

CLAMPING SURFACE DESIGNS



- SMOOTH**
- Mainly used on the sub spindle



- CARBIDE COATING**
- Carbide coating possible for all shapes
 - Higher coefficient of friction than a standard collet
 - Higher clamping force
 - Repeated / afterward coating possible

SHAPES



- SQUARE**
- Suitable for clamping square material



- HEXAGON**
- Suitable for clamping hexagon material

COLLETS FOR INTERNAL CLAMPING



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USE OF COLLETS FOR INTERNAL CLAMPING

Collets for internal clamping are suitable for clamping all rotationally symmetrical workpieces from the inside. Furthermore, the clamping is purely mechanical. Due to the internal clamping, the surface of the outer diameter from the workpiece won't be damaged. If inner contours deviate from the cylindrical shape, the internal clamping can be specifically adapted to the component geometry.



DEAD LENGTH COLLETS FOR INTERNAL CLAMPING

- Available for all dead length collet types from our range



DRAW-IN COLLETS FOR INTERNAL CLAMPING

- Available for all draw-in collet types from our range



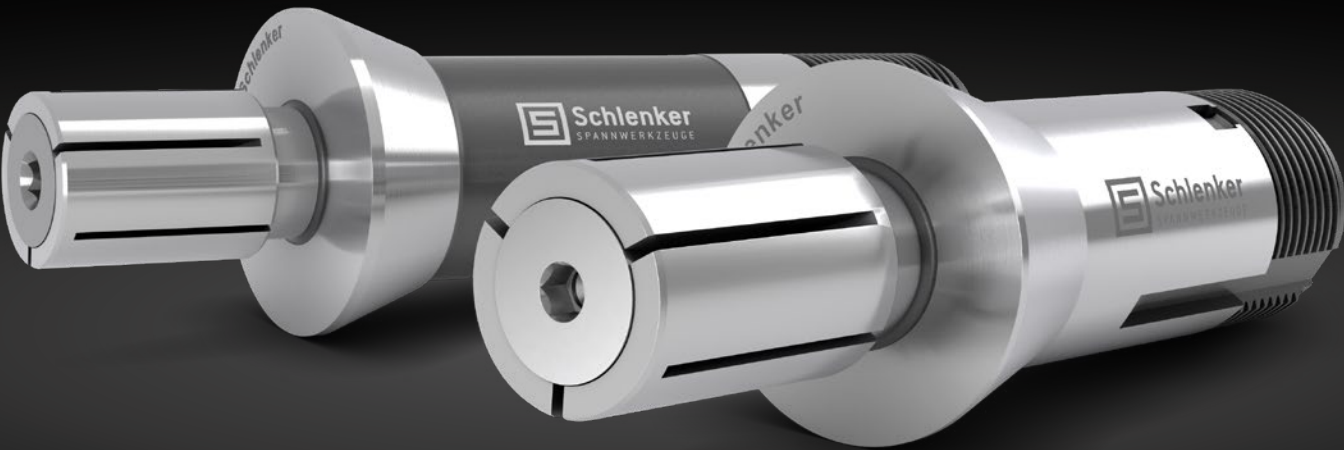
DRAW-IN COLLETS SW&B FOR INTERNAL CLAMPING

- Available for all draw-in collet types SW&B from our range

DRAW-IN COLLETS FOR INTERNAL CLAMPING WITH BUSH

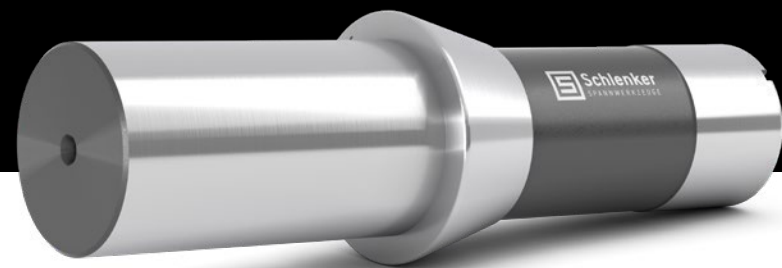
Draw-in collets for internal clamping are suitable for clamping all rotationally symmetrical workpieces from the inside. Furthermore, the clamping is purely mechanical. Due to the internal clamping, the surface of the outer diameter from the workpiece won't be damaged. If inner contours deviate from the cylindrical shape, the internal clamping can be specifically adapted to the component geometry.

Due to the bush, a more form-fit clamping of the workpiece is possible. Larger diameters can also be clamped. Available for all draw-in collet types as well as SW&B from our range.



You would like to order a draw-in collet for internal clamping?
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COLLET ALIGNMENT MANDRELS



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USE OF COLLET ALIGNMENT MANDRELS

The high-precision alignment mandrels are particularly suitable for checking the axial or radial offset of machine axes or the offset of the main spindle to the sub spindle of the machine geometry. Furthermore, alignment mandrels are used for checking the runout and tumbling on main or sub spindle.



DEAD LENGTH COLLET ALIGNMENT MANDRELS
• Available for all dead length collet types from our range



DRAW-IN COLLET ALIGNMENT MANDRELS
• Available for all draw-in collet types from our range



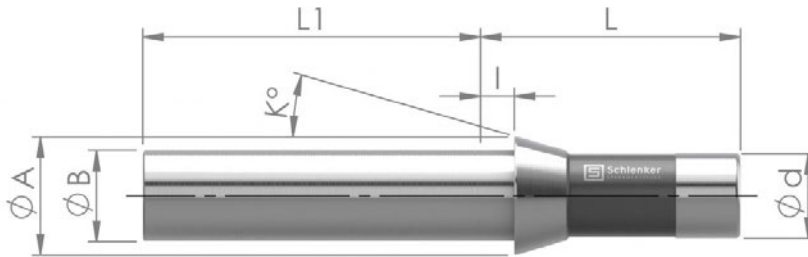
DRAW-IN COLLET SW&B ALIGNMENT MANDRELS
• Available for all draw-in collet types SW&B from our range

i MULTI-SPINDLE ALIGNMENT MANDRELS ARE AVAILABLE FOR ALL MULTI-SPINDLE COLLET TYPES FROM OUR RANGE.

COLLET ALIGNMENT MANDREL VERSIONS

- DEAD LENGTH COLLETS
- DRAW-IN COLLETS
- DRAW-IN COLLETS SW&B

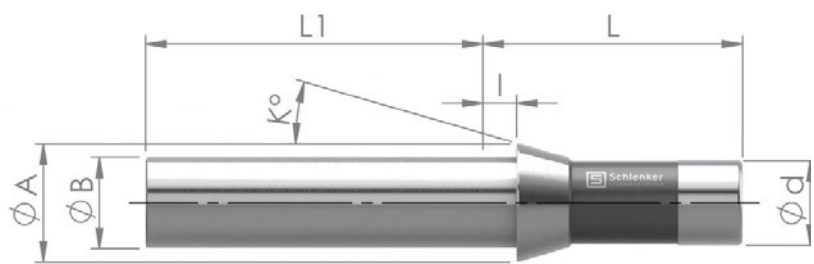
DEAD LENGTH COLLET ALIGNMENT MANDRELS



d Shaft-Ø A Head-Ø B Nose-Ø l Nose length L1 Length L1 L Total length K Taper angle

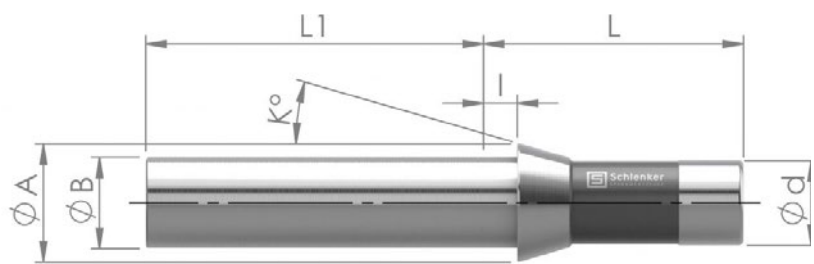
Article	Ø d [mm]	Ø A [mm]	Ø B [mm]	l [mm]	L1 [mm]	L [mm]	K [degree]
E101 F8-577 TF8	8	12	8	4.5	70	42	16
E109 F10 TF10	10	16	10	5.5	70	47.5	20
E112	11	19	12	6	70	41	22
E116 F13	13	19	13	6	70	64	16
E118	14	19.5	15	6	70	46	15
E120 F15 TF15	15	21	15	6	70	64	16
EF16 E1212 TF16	16	21	16	6	70	64	16
SYF16 M14x0.75	16	21	16	8	70	66	16

DEAD LENGTH COLLET ALIGNMENT MANDRELS



d Shaft-Ø A Head-Ø B Nose-Ø I Nose length L1 Length L1 L Total length K Taper angle

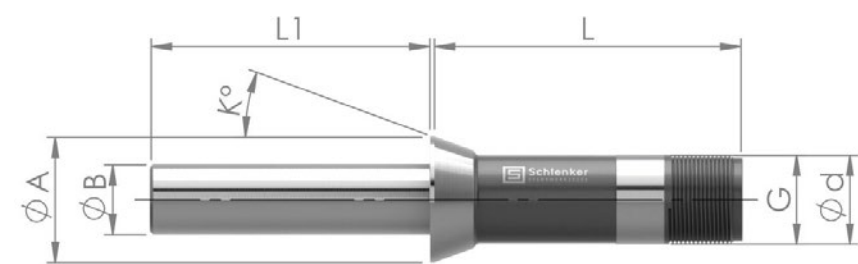
Article	Ø d [mm]	Ø A [mm]	Ø B [mm]	I [mm]	L1 [mm]	L [mm]	K [degree]
E127 TF18	18	25	18	6	70	67	16
E136 F20-201	20	26	19	5	100	54	15
E138 F20-87 TF20	20	28	21	7	100	67	1
E140 F22 TF22	22	30	21	6	100	55	15
TF24	23.8	28	22	7	100	62	15
E144	25	34	25	6	100	65	15
E145 F25 TF25	25	35	27	10	100	77	16
E147 F27-22	27	38	30	8	100	73	15
E148 F28	28	38	28	7	100	70	15
BS20	28	35	27	10	100	77	16
E157 F30 TF30	30	42	34	10	100	80	16
EF30 E1446	30	38	32	6	100	65	15
E161 F32	32	45	34	8	100	75	15
0166	32	40	34	6	100	65	15
E162	35	43	34	7	100	70	15



d Shaft-Ø A Head-Ø B Nose-Ø I Nose length L1 Length L1 L Total length K Taper angle

Article	Ø d [mm]	Ø A [mm]	Ø B [mm]	I [mm]	L1 [mm]	L [mm]	K [degree]
E163 F35	35	48	38	8	100	80	15
EF37 E1536 TF37	37	47	40	10	100	92	16
EF38 E164	38.08	49	38	9.5	100	108	15
EF40	40	47	40	10	100	92	16
E171 F42	42	55	42	9	100	94	15
TF43	43	53	46	10	100	92	16
TF44	44	52	44	10	100	92	16
E173 F48	48	60	50	9	100	94	15
TF48	48	60	50	9	100	94	15
BS38	48	54	44	10	100	100	15
E177 F58	58	70	60	9	150	94	15
E185 F66	66	84	73	9	150	110	15

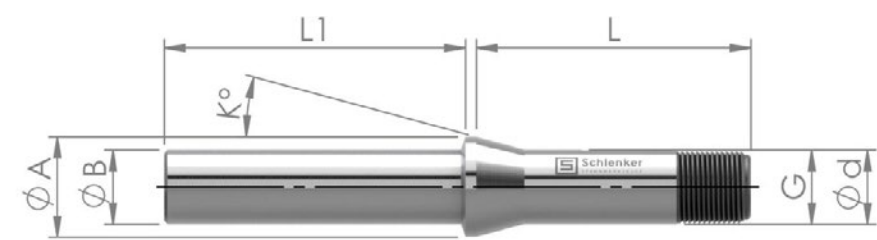
DRAW-IN COLLET ALIGNMENT MANDRELS



d Shaft-Ø A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle G Thread

Article	Ø d [mm]	Ø A [mm]	Ø B [mm]	L1 [mm]	L [mm]	K [degree]	Thread
E324	15	21.5	14	70	53	20	M13x1
E3409	20	28	17	100	90	8	Tr.20x1.5
E351	20	28	17	100	80	20	Tr.20x1.5
E358	23	32	20	100	81.5	20	M21x1
E359	23	32	20	100	89.5	20	Tr.23x1.5
E363	25	33.5	21	100	84	16	M23x1
E366	28	36	22	100	100	18	Tr.27x1/20"
E367	28	38	22	100	100	20	Tr.28x1.5
E385	31.75	37.5	25	100	83	10	Outside: 31.45x1/20" Inside: 26.44x1.058
E386	32	45	25	100	110	20	Tr.32x1.5
E666	25	35	21	100	59.5	20	M25x1
K20	20	28	17	100	80	20	Tr.20x1.5
K23	23	32	20	100	89.5	20	Tr.23x1.5
K32	32	45	25	100	110	20	Tr.32x1.5
K45	45	60	30	100	140	20	Tr.45x2
KDT38	58	70.3	30	100	99	15	M50x1.5

DRAW-IN COLLET SW&B ALIGNMENT MANDRELS



d Shaft-Ø A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle G Thread

Article	Ø d [mm]	Ø A [mm]	Ø B [mm]	L1 [mm]	L [mm]	K [degree]	Thread
SW12 80-2 E318	12	16	10	70	46	15	Ø11.75x1.25 45°/5°
SW15 80-3 E321	15	20.2	14	70	58.3	15	Ø14.75x1.25 45°/5°
SW20 80-4 E349	20	26.3	17	100	73.00	15	Ø19.7x1.666 45°/5°
SW25 80-5 E364	25	33.7	21	100	97.6	15	Ø24.7x1.693 45°/5°
B32 72-65	32	40	25	100	106	15	Ø29.7x1.693 45°/5°
B45 72-199	45	53	30	100	115	15	M42x1.5

ORDERING GUIDE



THINK DIFFERENT
CREATE INNOVATIONS

ORDERING GUIDE



DEAD LENGTH COLLET / DRAW-IN COLLETS

- Collet type (if not given: main sizes you can see in catalogue)
- ID shape (i.e. round, hex. or square) & size
- If it is a profiled collet -> drawing (step files/3D Models) and Keyway location (i.e. shaft or cone)
- Clamping surface design
- Slot design (e.g. S-Slot, W-Slot, Z-Slot...)
- Material to be made of or alternatively material to be processed



LONG NOSE COLLETS

- Collet type (if not given: main sizes you can see in catalogue)
- ID shape (i.e. round, hex. or square) & size
- If it is a profiled collet -> drawing (step files/3D Models) and Keyway location (i.e. shaft or cone)
- Clamping surface design
- Slot design (e.g. S-Slot, W-Slot, Z-Slot...)
- Length of the long nose / extension
- Material to be made of or alternatively material to be processed



OVERGRIPPING COLLETS

- Clamping diameter
- Overgripping diameter
- Clamping length
- Machine type
- Stroke of the machine
- Collet type



GUIDE BUSHES

- Guide bush type (if not given: main sizes you can see in catalogue)
- ID shape (i.e. round, hex. or square) & size
- If it is a profiled guide bush drawing
- Clamping surface design
- Slot design
- Material to be made of or alternatively material to be processed



GUIDE BUSHES SDK / SZZ

- Guide bush type (if not given: main sizes you can see in catalogue)
- ID shape (i.e. round, hex. or square) & size
- Material to be made of or alternatively material to be processed



BAR FEED COLLETS

- Collet type (if not given: main sizes you can see in catalogue)
- ID shape (i.e. round, hex. or square) & size
- Fastening system (i.e. screw, pin or thread)



ROTATING INSERTS

- Rotating insert type
- Bar feed collet fastening system (i.e. screw, pin or thread)

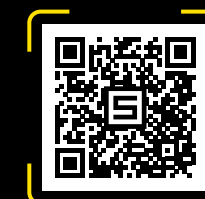
www.schlenker-spannwerkzeuge.de

INDIVIDUAL COLLETS EASILY ORDERED



DOWNLOAD ORDER FORM NOW

After filling out the form, please send it back by e-mail or fax.
info@schlenker-spannwerkzeuge.de / +49 7720 9944-27



SCAN ME

www.schlenker-spannwerkzeuge.de/en/downloads/

INDIVIDUAL COLLETS EASILY ORDERED

ORDER YOUR COLLET IN ONLY 3 STEPS

- 1 Select the required collet from the overview by clicking on it.
After selection, you will be directed to the drawing of the collet where you can fill out the dimensions.
- 2 Afterwards filling out the required dimensions, please send us the form by e-mail or fax.
e-mail: info@schlenker-spannwerkzeuge.de | fax: +49 7720 9944-27
- 3 The Schlenker team will prepare a suitable offer for you, which you will received by e-mail.
When the offer has been reviewed by you, please confirm it to us and we will immediately start with your order.



MADE IN GERMANY



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www.schlenker-spannwerkzeuge.de

GUIDE BUSHES



Adjustable Guide Bushes 92

Programmable Guide Bushes 102

SDK Guide Bushes 108

SDK-T Guide Bushes 112

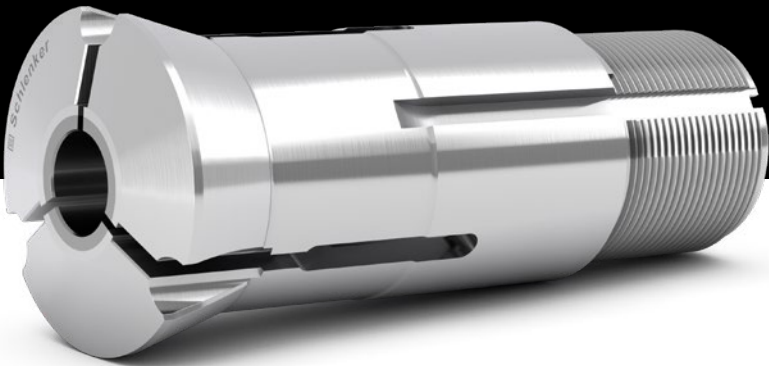
SZZ Guide Bushes 116

Alignment Mandrels 120

ADJUSTABLE GUIDE BUSHES



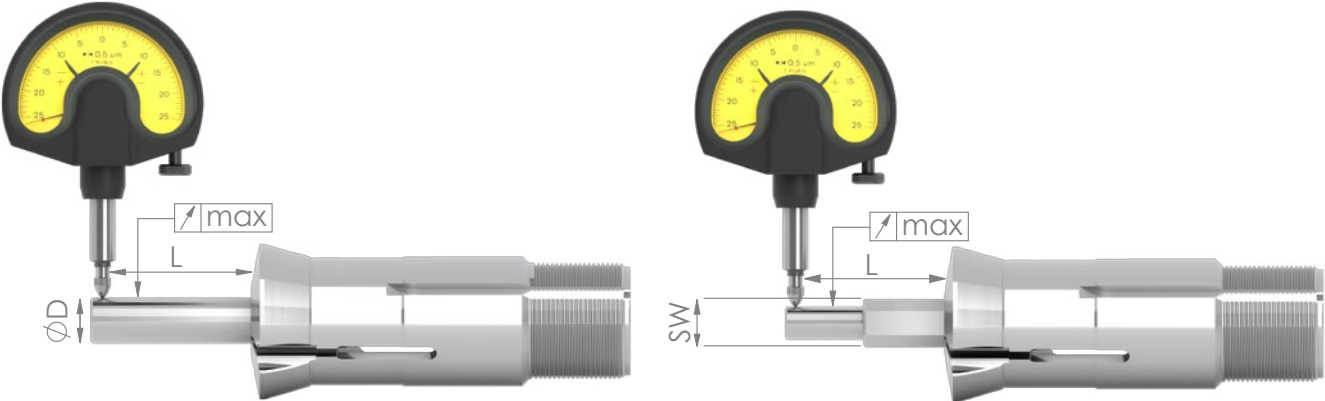
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USE OF ADJUSTABLE GUIDE BUSHES

The adjustable guide bushes are used for workpiece guidance. They are manually adjusted to the guide diameter via the adjusting nut. As standard, our guide bushes are equipped with a carbide insert, this ensures a longer service life and higher wear resistance. For special applications, they are also available with an extended guide length.

RUNOUT TOLERANCE



DIAMETER

ØD		L	Schlenker norm	
from	to		standard	UP
0.5	0.9	3	<0.01	<0.005
1.0	1.5	6	<0.01	<0.005
1.6	3.0	10	<0.015	<0.008
3.1	6.0	16	<0.015	<0.008
6.1	10.0	25	<0.015	<0.008
10.1	18.0	40	<0.02	<0.01
18.1	24.0	50	<0.02	<0.01
24.1	30.0	60	<0.02	<0.01
30.0		80	<0.03	<0.015

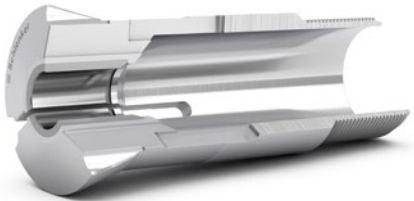
PROFILE

SW		L	standard	Schlenker norm	
from	to			standard	UP
0.5	0.9	3	0.12	<0.02	<0.01
1.0	1.5	6	0.12	<0.02	<0.01
1.6	3.0	10	0.12	<0.02	<0.01
3.1	6.0	16	0.12	<0.02	<0.01
6.1	10.0	25	0.15	<0.02	<0.01
10.1	18.0	40	0.2	<0.02	<0.01
18.1	24.0	50	0.2	<0.02	<0.01
24.1	30.0	60	0.2	<0.02	<0.01
30.0		80	0.2	<0.02	<0.01

ADJUSTABLE GUIDE BUSH OPTIONS

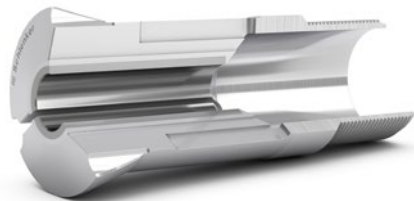
- GUIDE SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- ADDITIONAL VERSIONS
- VERSIONS

GUIDE SURFACE DESIGNS



CARBIDE INSERT – STANDARD

- High wear resistance
- Higher service life



EXTENDED CARBIDE INSERT

- Guide surface extended up to 40 mm
- Processing of a wider range of parts
- Improves the stability of the workpiece



EXTENDED CARBIDE INSERT WITH BUSH



- Suitable for extra long guidance
- Guidance possible over the entire length of the guide bush

SHAPES



SQUARE


- Suitable for square material


	HEXAGON <ul style="list-style-type: none"> • Suitable for hexagon material
	SPECIAL PROFILES <ul style="list-style-type: none"> • Various profiles possible • Profiles can be adapted individually to the workpiece

SLOT DESIGNS

	S-SLOT <ul style="list-style-type: none"> • Ideal for high-pressure flushing systems in the machine • Prevents machining chips getting in the guide bush • Improved runout properties compared to standard guide bushes • Alternatively usable for profile material
	W-SLOT <ul style="list-style-type: none"> • Ideal for high-pressure flushing systems in the machine • Prevents machining chips getting in the guide bush • Improved runout properties compared to standard guide bushes • Alternatively usable for profile material
	Z-SLOT <ul style="list-style-type: none"> • Ideal for high-pressure flushing systems in the machine • Prevents machining chips getting in the guide bush • Improved runout properties compared to standard guide bushes • Alternatively usable for profile material

WEAR REDUCTION

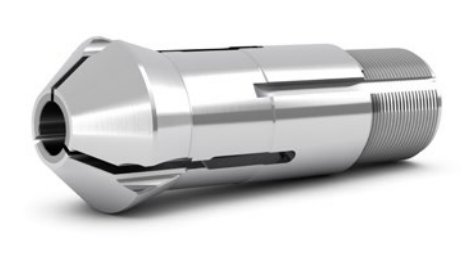
	BL COATING <ul style="list-style-type: none"> • Especially suitable for material with poor gliding properties e.g. titanium • Prevents welding of the material in the guide bush
--	---

	PREMIUM BLUE COATING <ul style="list-style-type: none"> • High wear resistance • Can also be used for special shapes
---	---

ADDITIONAL VERSIONS

	UP VERSION <ul style="list-style-type: none"> • High precision
	UUP VERSION <ul style="list-style-type: none"> • Highest precision
	SEALED <ul style="list-style-type: none"> • Prevents the entry of machining chips • The whole slot area can be sealed • Resealing possible • Not usable with high pressure flushing in the machine

VERSIONS

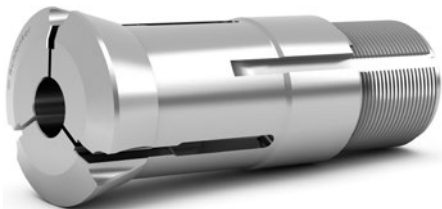
	LONG NOSE <ul style="list-style-type: none"> • Needed for special requirements where the tool has a longer distance to the guide bush carrier
---	---



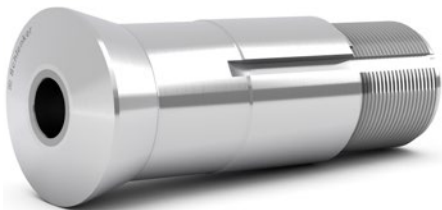
- SB DESIGN**
- Special material with very good gliding properties
 - Prevents welding of the material in the guide bush
 - Ideal for material with scratch-sensitive surface
 - Especially suitable for material with poor gliding properties e.g. titanium
 - Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter



- PERMAGLIS DESIGN**
- Special material with very good gliding properties
 - Prevents welding of the material in the guide bush
 - Especially suitable for medical steels like titanium and stainless steel
 - Alternative to SB design
 - Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter



- STEEL DESIGN**
- Mainly used for self-lubricating material e.g. brass
 - Processing of complex profiles possible



- CLOSED DESIGN**
- Are ground to the exact nominal diameter of the material to be processed
 - No adjustment of the guide bush is necessary

STANDARD CARBIDE LENGTHS

Guide surface Ø [mm]	Carbide length [mm]
2.0 – 4.4	13
4.5 – 5.9	14
6.0 – 6.9	15
7.0 – 10.4	16
10.5 – 14.4	18
14.5 – 18.9	19
19.0 – 20.9	22
21.0 – 22.4	24
22.5 – 32.0	25

STANDARD GUIDE SURFACE LENGTH SB UND PERMAGLIS DESIGN




Guide surface Ø [mm]	Guide surface length [mm]
1.0 – 4.9	16
5.0 – 6.9	18
7.0 – 9.9	20
10.0 – 14.9	22
15.0 – 18.9	24

Guide surface Ø [mm]	Guide surface length [mm]
19.0 – 21.9	26
22.0 – 26.9	28
27.0 – 31.9	30
32.0 – max.	32

ADJUSTABLE GUIDE BUSHES






d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

Article	Ø d [mm]	Ø A [mm]	L [mm]	K [degree]	G	F min. – max. [mm]		
								
I351	9	12.5	44	16	M8x0.75	0.8 – 4.5	PR	PR
I352	11	14.5	53	16	M10x0.8	1.0 – 7.0	PR	PR
F3001	11	14.5	53	16	M10x0.75	1.0 – 7.0	PR	PR
I353	16	20.5	59	16	M14x1	1.0 – 10.5	3.0 – 7.0	3.0 – 9.0
I353SR	16	20	57	16	M14x1	1.0 – 10.5	3.0 – 7.0	3.0 – 9.0
F853	18	22	60	30	M16x1	1.0 – 12.0	3.0 – 8.0	4.0 – 10.0
SD125R	18	22	60	30	M18x1	3.0 – 12.0	PR	PR
T221	21	24	57.5	12	M18x1	3.0 – 13.0	3.0 – 9.0	4.0 – 11.0
SNC15	21	24	57.5	12.5	M18x1	3.0 – 13.0	3.0 – 9.0	4.0 – 11.0
I354	22	29	68	16	M19x1	2.0 – 14.5	3.0 – 10.0	4.0 – 12.5
F391	22	29	68	16	M22x1	3.0 – 16.5	3.0 – 11.5	4.0 – 14.0
TSG20R	23	28	72	16	M22x1	3.0 – 16.0	PR	PR
F605	24	29.5	61	30	M24x1	2.0 – 17.0	3.0 – 12.0	4.0 – 14.5
TD26	26	29	77	16	M25x1	2.0 – 19.0	3.0 – 13.0	4.0 – 16.0
T223	28	34	82	16	M25x1	3.0 – 20.0	3.0 – 14.0	3.0 – 17.0
T223	28	34	82	16	M27x1	22.0		
I357	28	38	81	30	M25x1	3.0 – 20.0	3.0 – 14.0	4.0 – 17.0
I357	28	38	81	30	M27x1	22.0		



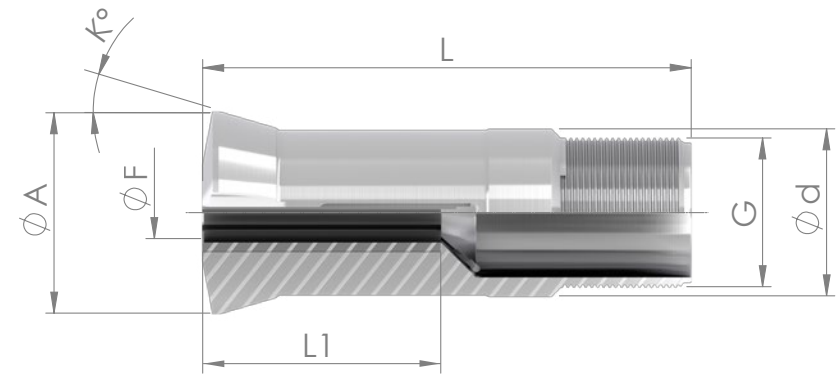
d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

Article	Ø d [mm]	Ø A [mm]	L [mm]	K [degree]	G	F min. – max. [mm]		
								
B230	30	35	59	16	M30x1	3.0 – 23.0	PR	PR
T227	34	41	87.5	10	M34x1	3.0 – 26.0	3.0 – 18.0	4.0 – 22.5
T229	42	49	82	16	M40x1	4.0 – 32.0	3.0 – 22.5	4.0 – 27.5
TD32	42	48	82	20	M40x1	4.0 – 32.0	3.0 – 22.5	4.0 – 27.5
ML36	44	51	82	16	M42x1	10.0 – 35.0	PR	PR
FST38	48	54	82	16	M46x1	10.0 – 38.0	PR	PR
FSL38	46	53	82	16	M45x1	10.0 – 38.0	PR	PR
B240	48	54	81	10	M46x1	10.0 – 38.0	PR	PR
B236	48	56	81	30	M48x1.25	10.0 – 38.0	PR	PR



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

EXTENDED GUIDE BUSHES



- d

Shaft-Ø
- A

Head-Ø
- L

Total length
- K

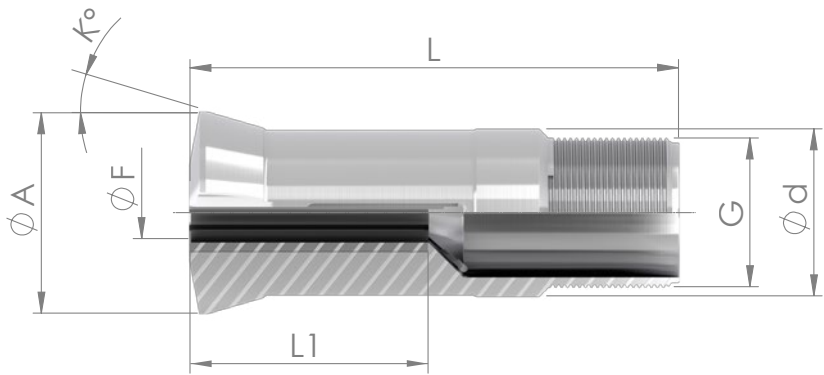
Taper angle
- G

Thread
- F

Shape
- L1

Carbide length

Article	Ø d [mm]	Ø A [mm]	L [mm]	K [Grad]	G	F min. – max. [mm]			L1 [mm]
									
I351	9	12.5	44	16	M8x0.75	0.8 – 4.5	PR	PR	20
I352	11	14.5	53	16	M10x0.8	1.0 – 7.0	PR	PR	25
F3001	11	14.5	53	16	M10x0.75	1.0 – 7.0	PR	PR	25
I353	16	20.5	59	16	M14x1	1.0 – 10.5	PR	PR	30
I353SR	16	20	57	16	M14x1	1.0 – 10.5	PR	PR	30
F853	18	22	60	30	M16x1	1.0 – 12.0	PR	PR	30
SD125R	18	22	60	30	M18x1	3.0 – 12.0	PR	PR	30
T221	21	24	57.5	12	M18x1	3.0 – 13.0	PR	PR	25
SNC15	21	24	57.5	12.5	M18x1	3.0 – 13.0	PR	PR	25
I354	22	29	68	16	M19x1	2.0 – 14.5	PR	PR	30/35
F391	22	29	68	16	M22x1	3.0 – 16.5	PR	PR	30/35
TSG20R	23	28	72	16	M22x1	3.0 – 16.0	PR	PR	30/35
F605	24	29.5	61	30	M24x1	2.0 – 17.0	PR	PR	30/35
TD26	26	29	77	16	M25x1	2.0 – 19.0	PR	PR	30/35/40
T223	28	34	82	16	M25x1	3.0 – 20.0	PR	PR	30/35/40
I357	28	38	81	30	M25x1	3.0 – 20.0	PR	PR	30/35/40
B230	30	35	59	16	M30x1	3.0 – 23.0	PR	PR	30/35/40



- d

Shaft-Ø
- A

Head-Ø
- L




Total length
- K

Taper angle
- G

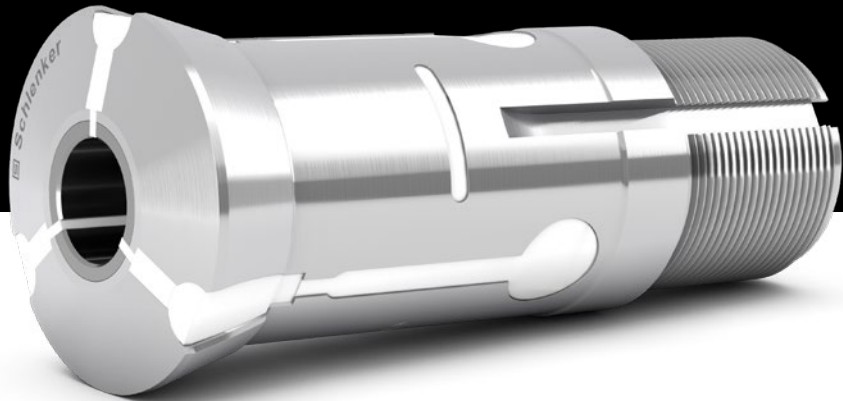
Thread
- F

Shape
- L1

Carbide length

Article	Ø d [mm]	Ø A [mm]	L [mm]	K [Grad]	G	F min. – max. [mm]			L1 [mm]
									
T227	34	41	87.5	10	M34x1	3.0 – 26.0	PR	PR	30/35/40
T229	42	49	82	16	M40x1	4.0 – 32.0	PR	PR	30/35/40
TD32	42	48	82	20	M40x1	4.0 – 32.0	PR	PR	30/35/40
ML36	44	51	82	16	M42x1	10.0 – 35.0	PR	PR	30/35/40
FST38	48	54	82	16	M46x1	10.0 – 38.0	PR	PR	30/35/40
FSL38	46	53	82	16	M45x1	10.0 – 38.0	PR	PR	30/35/40
B240	48	54	81	10	M46x1	10.0 – 38.0	PR	PR	30/35/40
B236	48	56	81	30	M48x1.25	10.0 – 38.0	PR	PR	30/35/40

PROGRAMMABLE GUIDE BUSHES



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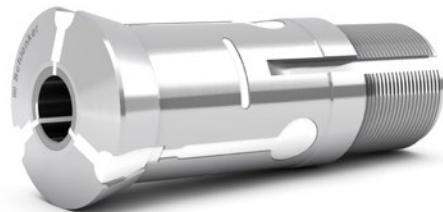
PROGRAMMIERBARE GUIDE BUSH OPTIONS

- STANDARD VERSION
- GUIDE SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- VERSIONS

USE OF PROGRAMMABLE GUIDE BUSHES

Programmable guide bushes are specially designed for INDEX/TRAUB machines. The bar or guide diameter of the guide bushing is set via the control of the lathe. Axfix guide bushes are standardly delivered in ultra precision (UP), vulcanized and equipped with a bush.

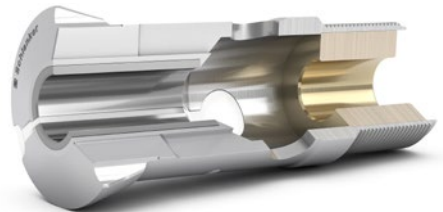
STANDARD VERSION



STANDARD

- UP version
- Chamfered
- Sealed
- With bush

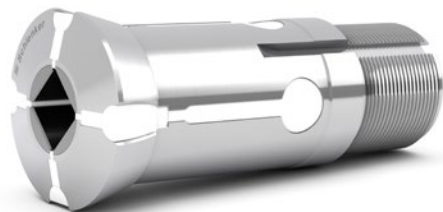
GUIDE SURFACE DESIGNS



EXTENDED CARBIDE INSERT

- Suitable for extra long guidance
- Guidance possible over the whole length of the guide bush

SHAPES



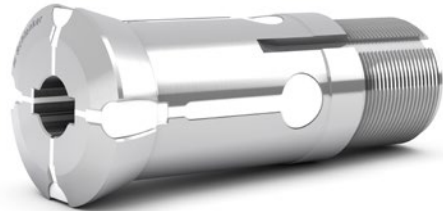
SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material




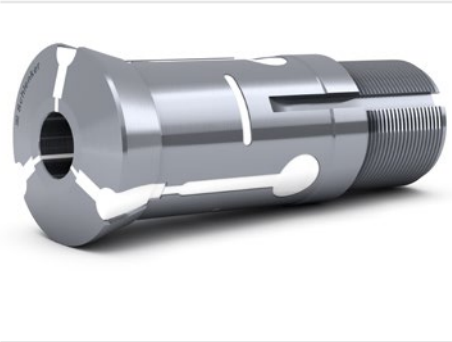
SPECIAL PROFILES

- Various profiles possible
- Profiles can be adapted individually to the workpiece



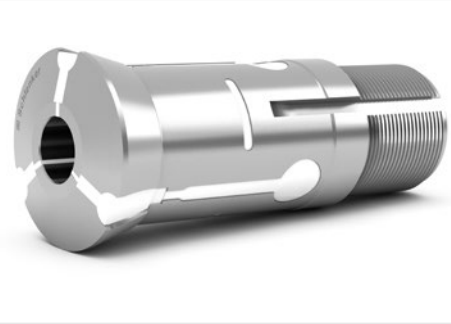

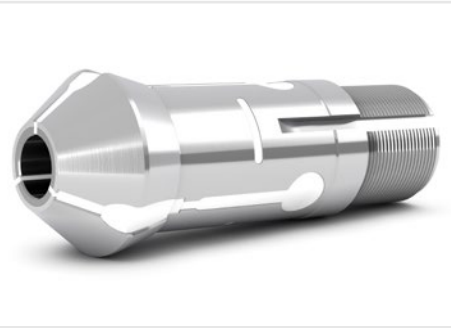
SLOT DESIGNS

	<p>S-SLOT</p> <ul style="list-style-type: none">• Ideal for high-pressure flushing systems in the machine• Prevents machining chips getting in the guide bush• Improved runout properties compared to standard guide bushes• Alternatively usable for profile material
	<p>W-SLOT</p> <ul style="list-style-type: none">• Ideal for high-pressure flushing systems in the machine• Prevents machining chips getting in the guide bush• Improved runout properties compared to standard guide bushes• Alternatively usable for profile material
	<p>Z-SLOT</p> <ul style="list-style-type: none">• Ideal for high-pressure flushing systems in the machine• Prevents machining chips getting in the guide bush• Improved runout properties compared to standard guide bushes• Alternatively usable for profile material

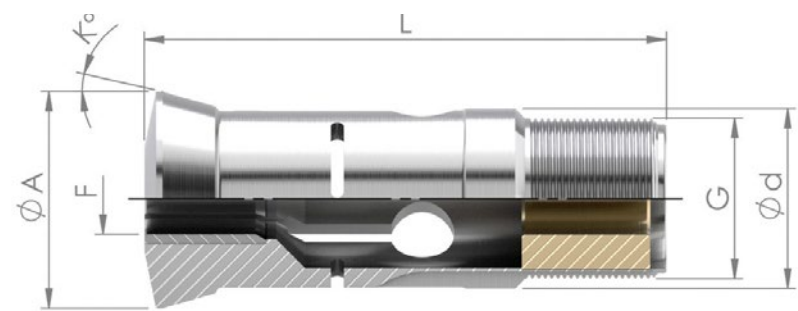
WEAR REDUCTION

	<p>BL COATING</p> <ul style="list-style-type: none">• Especially suitable for material with poor gliding properties e.g. titanium• Prevents welding of the material in the guide bush
	<p>PREMIUM BLUE COATING</p> <ul style="list-style-type: none">• High wear resistance• Can also be used for special shapes

VERSIONS

	<p>SB DESIGN</p> <ul style="list-style-type: none">• Special material with very good gliding properties• Prevents welding of the material in the guide bush• Ideal for material with scratch-sensitive surface• Especially suitable for material with poor gliding properties e.g. titanium• Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter
	<p>PERMAGLIS DESIGN</p> <ul style="list-style-type: none">• Special material with very good gliding properties• Prevents welding of the material in the guide bush• Especially suitable for medical steels like titanium and stainless steel• Alternative to SB design• Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter
	<p>STEEL DESIGN</p> <ul style="list-style-type: none">• Mainly used for self-lubricating material e.g. brass• Processing of complex profiles possible
	<p>UUP VERSION</p> <ul style="list-style-type: none">• Highest precision
	<p>LONG NOSE</p> <ul style="list-style-type: none">• Needed for special requirements where the tool has a longer distance to the guide bush carrier

PROGRAMMABLE GUIDE BUSHES



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

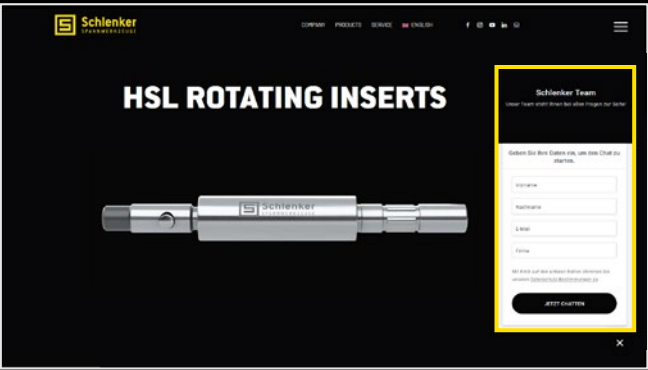
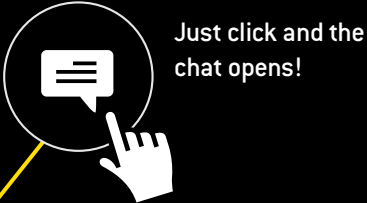
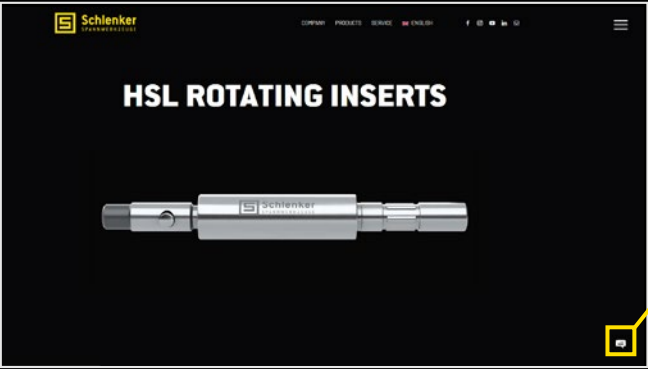
Article	Ø d [mm]	Ø A [mm]	L [mm]	K [degree]	G	F min. – max. [mm]	Traub drawing no.
FTS221	21	24	65.5	12	M18x1	1.5 – 13.0	989468
FTS3402	27	30	67.5	12	M24x1	3.0 – 16.0	989517
T223AXFIX	28	34	81	16	M25x1	3.0 – 21.0	902860
T227	34	41	87.5	10	M34x1	3.0 – 15.0	986761
T229AXFIX	42	49	81.2	16	M40x1	4.0 – 32.0	907820

CHAT-FUNCTION

OUR TEAM IS ALWAYS AVAILABLE TO SUPPORT YOU!

DO YOU HAVE ANY QUESTIONS OR NEED ASSISTANCE?

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SDK GUIDE BUSHES



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USE OF SDK GUIDE BUSHES

The SDK double cone guide bushes with integrated spring are manufactured in one piece. Due to this design, the bar material receives the maximum stability and flexibility in your application. In addition, the axial misalignment or misalignment of the bar material, is eliminated by the integrated spring. SDK double cone guide bushes are especially designed for flexible guide bush systems for example JBS.

VERSIONS



SB DESIGN – STANDARD

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Ideal for material with scratch-sensitive surfaceEspecially suitable for material with poor gliding properties e.g. titanium
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter



PERMAGLIS DESIGN

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Especially suitable for medical steels like titanium and stainless steel
- Alternative to SB design
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter

SDK GUIDE BUSH OPTIONS

- VERSIONS
- SHAPES



STEEL DESIGN WITH BL COATING

- Especially suitable for material with poor gliding properties e.g. titanium
- Processing of complex profiles possible
- Prevents welding of the material in the guide bush



CARBIDE INSERT

- High wear resistance
- Higher service life



LONG NOSE

- Needed for special requirements where the tool has a longer distance to the guide bush carrier



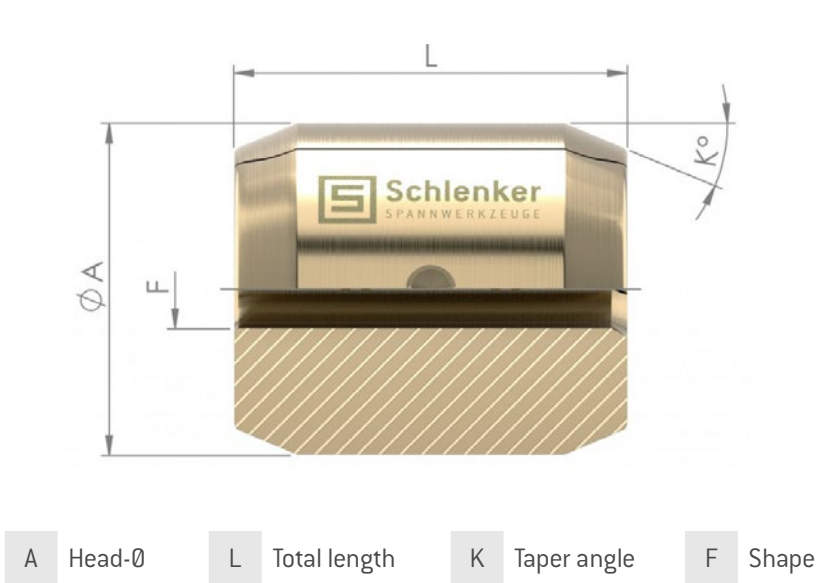
SEALING DISC


- Prevents the entry of machining chips into the spring area

SHAPES

	<p>SQUARE</p> <ul style="list-style-type: none">• Suitable for square material
	<p>HEXAGON</p> <ul style="list-style-type: none">• Suitable for hexagon material
	<p>SPECIAL PROFILES</p> <ul style="list-style-type: none">• Various profiles possible• Profiles can be adapted individually to the workpiece

SDK GUIDE BUSHES



Article	Ø A [mm]	L [mm]	K [degree]	F min. – max. [mm]
				
SDK24	24	35	22.5	3.0 – 12.0
SDK28	28	40	22.5	3.0 – 20.0
SDK33	33	40	22.5	3.0 – 23.0
SDK42	42	50	22.5	3.0 – 32.0
SDK48	48	60	22.5	3.0 – 38.0

SDK-T GUIDE BUSHES



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USE OF SDK-T GUIDE BUSHES

The SDK-T double cone guide bushes with with integrated spring are manufactured in one piece. Due to this design, the bar material receives the maximum stability and flexibility in your application. In addition, the axial misalignment or misalignment of the bar material, is eliminated by the integrated spring. SDK-T double cone guide bushes are especially designed for flexible guide bushe systems for example JBS.

VERSIONS



SB DESIGN – STANDARD

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Ideal for material with scratch-sensitive surface
- Especially suitable for material with poor gliding properties e.g. titanium
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter



PERMAGLIS DESIGN

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Especially suitable for medical steels like titanium and stainless steel
- Alternative to SB design
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter

SDK-T GUIDE BUSH OPTIONS

- VERSIONS
- SHAPES



STEEL DESIGN WITH BL COATING

- Especially suitable for material with poor gliding properties e.g. titanium
- Processing of complex profiles possible
- Prevents welding of the material in the guide bush



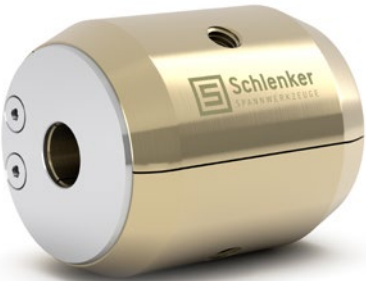
CARBIDE INSERT

- High wear resistance
- Higher service life



LONG NOSE

- Needed for special requirements where the tool has a longer distance to the guide bush carrier



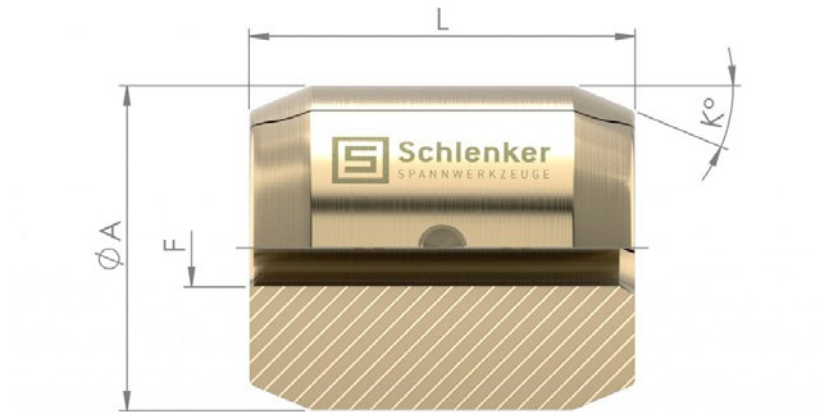
SEALING DISC

- Prevents the entry of machining chips into the spring area

SHAPES

	<p>SQUARE</p> <ul style="list-style-type: none">• Suitable for square material
	<p>HEXAGON</p> <ul style="list-style-type: none">• Suitable for hexagon material
	<p>SPECIAL PROFILES</p> <ul style="list-style-type: none">• Various profiles possible• Profiles can be adapted individually to the workpiece

SDK-T GUIDE BUSHES



A

Head-Ø

L


Total length

K

Taper angle

F

Shape

Article	Ø A [mm]	L [mm]	K [degree]	F min. – max. [mm]
				
SDK-T24	24	35	22	3.0 – 12.0
SDK-T28	28	40	22	3.0 – 20.0
SDK-T33	33	40	22	3.0 – 23.0
SDK-T42	42	50	22	3.0 – 32.0
SDK-T48	48	60	22	3.0 – 38.0
SDK-T51	51	60	22	10.0 – 38.0

SZZ GUIDE BUSHES





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USE OF SZZ GUIDE BUSHES



The SZZ guide bushes with integrated spring are manufactured in one piece. Due to this manufacturing method we do not have any axial misalignment and thus allows maximum flexibility for your application. SZZ guide bushes are especially designed for flexible guide bush systems for example JBS.

VERSIONS




	<p>SB DESIGN – STANDARD</p> <ul style="list-style-type: none">• Special material with very good gliding properties• Prevents welding of the material in the guide bush• Ideal for material with scratch-sensitive surface• Especially suitable for material with poor gliding properties e.g. titanium• Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter
	<p>PERMAGLIS DESIGN</p> <ul style="list-style-type: none">• Special material with very good gliding properties• Prevents welding of the material in the guide bush• Especially suitable for medical steels like titanium and stainless steel• Alternative to SB design• Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter

SZZ GUIDE BUSH OPTIONS

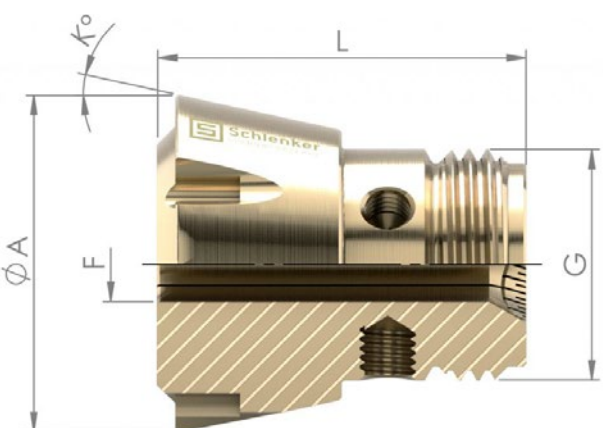
- VERSIONS
- SHAPES

	<p>STEEL DESIGN WITH BL COATING</p> <ul style="list-style-type: none">• Especially suitable for material with poor gliding properties e.g. titanium• Processing of complex profiles possible• Prevents welding of the material in the guide bush
	<p>CARBIDE INSERT</p> <ul style="list-style-type: none">• High wear resistance• Higher service life
	<p>LONG NOSE</p> <ul style="list-style-type: none">• Needed for special requirements where the tool has a longer distance to the guide bush carrier
	<p>SEALING DISC</p> <ul style="list-style-type: none">• Prevents the entry of machining chips into the spring area

SHAPES

	<p>SQUARE</p> <ul style="list-style-type: none">• Suitable for square material
	<p>HEXAGON</p> <ul style="list-style-type: none">• Suitable for hexagon material
	<p>SPECIAL PROFILES</p> <ul style="list-style-type: none">• Various profiles possible• Profiles can be adapted individually to the workpiece

SZZ GUIDE BUSHES



A

 Head-Ø

L

 Total length

K


 Taper angle

G

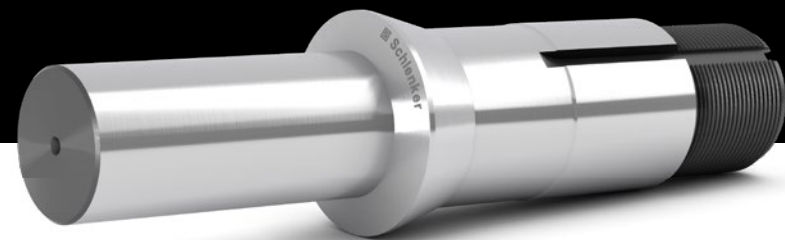
 Thread

F

 Shape

Article	Ø A [mm]	L [mm]	K [degree]	G	F min. – max. [mm]
					
SZZ26	26	35	12	M16x1.5	PR
SZZ32.5	32.5	40	12	M21.5x2	3.0 – 12.0
SZZ36.7	36.7	40	12	M25x2	3.0 – 16.0
SZZ44	44	40	12	M30x2	3.0 – 18.0
SZZ54	54	50	12	M40x1.5	10.0 – 28.0
SZZ59	59	60	12	M44x1.5	10.0 – 32.0

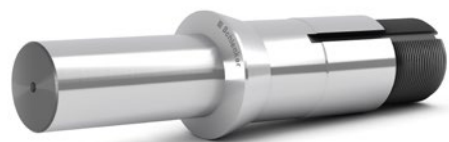
GUIDE BUSH ALIGNMENT MANDREL



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USE OF GUIDE BUSH ALIGNMENT MANDRELS

The high-precision alignment mandrels are particularly suitable for checking the axial or radial offset of machine axes or the offset of the main spindle to the sub spindle of the machine geometry. Furthermore, alignment Mandrels are used for checking the runout and tumbling on main or sub spindle.



ADJUSTABLE GUIDE BUSH ALIGNMENT MANDRELS

- Available for all adjustable guide bush types from our range



SDK ALIGNMENT MANDRELS

- Available for all SDK double cone guide bush types from our range



SDK-T ALIGNMENT MANDRELS

- Available for all SDK-T double cone guide bush types from our range



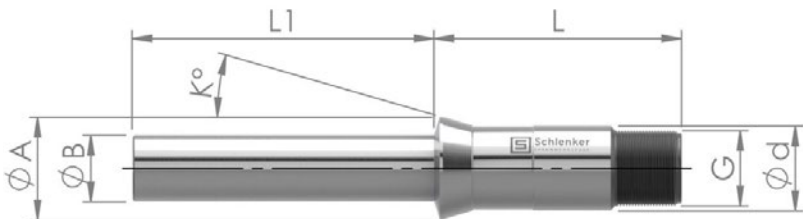
SZZ ALIGNMENT MANDRELS

- Available for all SZZ guide bush types from our range

GUIDE BUSH ALIGNMENT MANDREL VERSIONS

- ADJUSTABLE GUIDE BUSHES
- DOUBLE CONE GUIDE BUSHES SDK
- DOUBLE CONE GUIDE BUSHES SDK-T
- GUIDE BUSHES SZZ

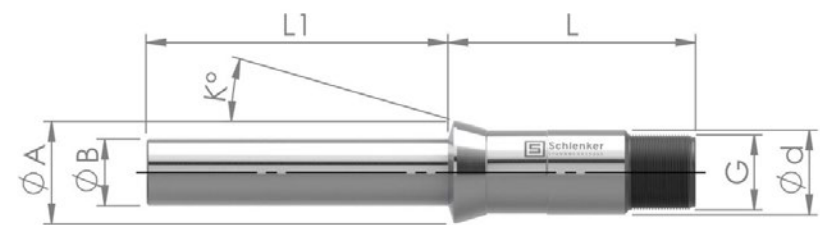
ADJUSTABLE GUIDE BUSH ALIGNMENT MANDRELS



d Shaft-Ø A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle G Thread

Article	Ø d [mm]	Ø A [mm]	Ø B [mm]	L1 [mm]	L [mm]	K [degree]	G
I351	9	12.5	8	50	44	16	M8x0.75
I352	11	14.5	10	50	53	16	M10x0.8
F3001	11	14.5	10	50	53	16	M10x0.75
I353	16	20.5	14	50	59	16	M14x1
I353SR	16	20	14	50	57	16	M14x1
F853	18	22	16	70	60	30	M16x1
SD125R	18	22	16	70	60	30	M18x1
T221	21	24	18	70	57.5	12	M18x1
SNC15	21	24	18	70	57.5	12.5	M18x1
I354	22	29	20	100	68	16	M19x1
F391	22	29	20	100	68	16	M22x1

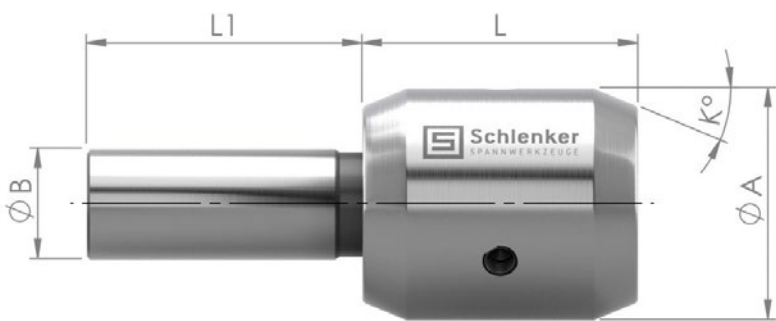
ADJUSTABLE GUIDE BUSH ALIGNMENT MANDRELS



d Shaft-Ø A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle G Thread

Article	Ø d [mm]	Ø A [mm]	Ø B [mm]	L1 [mm]	L [mm]	K [degree]	G
TSG20R	23	28	20	100	72	16	M22x1
F605	24	29.5	20	100	61	30	M24x1
TD26	26	29	20	100	77	16	M25x1
T223	28	34	22	100	82	16	M25x1
I357	28	38	22	100	81	30	M25x1
B230	30	35	22	100	59	16	M30x1
T227	34	41	25	100	87.5	10	M34x1
T229	42	49	25	100	82	16	M40x1
TD32	42	48	25	100	82	20	M40x1
ML36	44	51	30	150	82	16	M42x1
FST38	48	54	30	150	82	16	M46x1
FSL38	46	53	30	150	82	16	M45x1
B240	48	54	30	150	81	10	M46x1
B236	48	56	30	150	81	30	M48x1.25

DOUBLE CONE GUIDE BUSH SDK ALIGNMENT MANDRELS



A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle

Article	Ø A [mm]	Ø B [mm]	L1 [mm]	L [mm]	K [degree]
SDK24	24	10	80	35	22.5
SDK28	28	15	80	40	22.5
SDK33	33	20	80	40	22.5
SDK42	42	25	100	50	22.5
SDK48	48	30	100	60	22.5

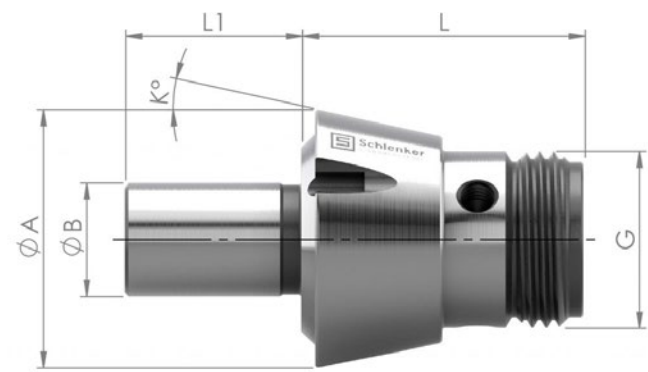
ADJUSTABLE GUIDE BUSH SDK-T ALIGNMENT MANDRELS



A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle

Article	Ø A [mm]	Ø B [mm]	L1 [mm]	L [mm]	K [degree]
SDK-T24	24	10	80	35	22
SDK-T28	28	15	80	40	22
SDK-T33	33	20	80	40	22
SDK-T42	42	25	100	50	22
SDK-T48	48	30	100	60	22
SDK-T51	51	35	100	60	22

GUIDE BUSH SZZ ALIGNMENT MANDRELS



A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle G Thread

Article	Ø A [mm]	Ø B [mm]	L1 [mm]	L [mm]	K [degree]	G
SZZ26	26	10	80	35	12	M16x1.5
SZZ32.5	32.5	15	80	40	12	M21.5x2
SZZ36.7	36.7	20	80	40	12	M25x2
SZZ44	44	25	100	40	12	M30x2
SZZ54	54	30	100	50	12	M40x1.5
SZZ59	59	35	100	60	12	M44x1.5



BAR FEED COLLETS

SHK Bar Feed Collets **128**

SHK Crown Bar Feed Collets **132**

TURBO Bar Feed Collets **136**

TURBO Crown Bar Feed Collets **140**

IEMCA Bar Feed Collets **144**

IEMCA Crown Bar Feed Collets **148**

CAV Bar Feed Collets **152**

CUCCHI Bar Feed Collets **156**

SHK Inside Clamping Sleeves **160**

TURBO Inside Clamping Sleeves **162**

Inside Clamping Sleeves INDEX MS **166**

Feeding Collets **170**

Feeding Collets Multi-Spindle **174**

Feeding Collets RS **178**

Front Ejectors VKK **180**

Front Ejectors SKK **184**

03

SHK BAR FEED COLLETS






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USE OF SHK BAR FEED COLLETS

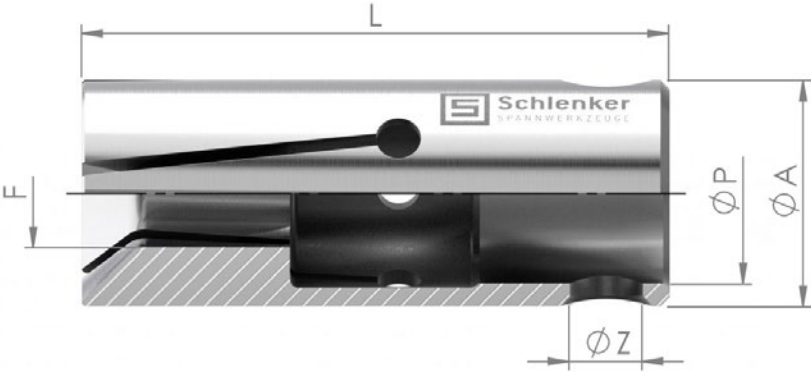
The SHK bar feed collets are mounted on the rotating inserts and secured with a cross pin.

	STANDARD ROUND <ul style="list-style-type: none">• Suitable for round material
	SQUARE <ul style="list-style-type: none">• Suitable for square material
	HEXAGON <ul style="list-style-type: none">• Suitable for hexagon material




SHK BAR FEED COLLET OPTIONS

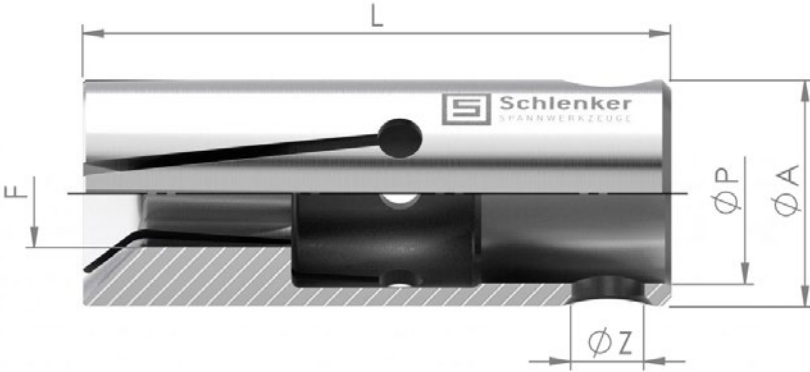
	SPECIAL PROFILES <ul style="list-style-type: none">• Various profiles can be realized by ram EDM or wire EDM• Profiles can be adapted individually to the workpiece
	TENSION <ul style="list-style-type: none">• Tension can be increased or reduced according to requirements
	CLOSED DESIGN <ul style="list-style-type: none">• Channel can be used completely

SHK BAR FEED COLLETS






A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

Article	Pusher [mm]	Ø A [mm]	Ø P [mm]	Ø Z [mm]	L [mm]	F min. – max. [mm]		
								
S5 E200	D5	5	M4		37	1.0 – 4.0		
S7 E208	D7	7	M5		37	1.0 – 6.0		
S7B BECHLER	D7	7	M4		22	1.0 – 6.0		
S10 E210	D10	10	7H7	4	40	1.0 – 8.5	3.0 – 4.0	3.0 – 6.0
S10B BECHLER	D10	10	M5		26	2.0 – 8.5		
S12 E212	D12	12	8H7	4	40	3.0 – 10.5	3.0 – 5.0	3.0 – 6.0
S13 E213	D13	13	8H7	4	40	2.0 – 11.5	3.0 – 5.0	3.0 – 6.0
S15 E203	D15	15	11H7	6	40	3.0 – 13.5	3.0 – 7.0	3.0 – 9.0
S16 SHK16	D16	16	11H7	6	40	3.0 – 14.5	3.0 – 7.0	3.0 – 9.0
S18 E218	D18	18	11H7	6	40	3.0 – 16.5	5.0 – 7.0	5.0 – 9.0
S20 E225	D20	20	14H7	8	65	4.0 – 18.5	5.0 – 9.0	5.0 – 12.0
S21 SHK21	D21	21	14H7	8	65	15.0 – 19.5	PR	PR
S22 SHK22	D22	22	14H7	8	65	4.0 – 20.5	PR	PR



A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

Article	Pusher [mm]	Ø A [mm]	Ø P [mm]	Ø Z [mm]	L [mm]	F min. – max. [mm]		
								
S23 SHK23	D23	23	14H7	8	65	5.0 – 21.5	PR	PR
S25 E222	D25	25	20H7	8	65	4.0 – 23.5	5.0 – 14.0	5.0 – 17.0
S28 E227	D28	28	20H7	8	65	3.0 – 26.0	5.0 – 14.0	5.0 – 17.0
S30 SHK30	D30	30	20H7	8	65	5.0 – 28.0	5.0 – 14.0	5.0 – 17.0
S32 SHK32	D32	32	20H7	8	65	5.0 – 30.0	5.0 – 14.0	5.0 – 17.0
S34 SHK34	D34	34	20H7	8	65	10.0 – 32.0	10.0 – 14.0	10.0 – 17.0
S36 SHK36	D36	36	20H7	8	65	8.0 – 34.0	8.0 – 14.0	8.0 – 17.0



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

SHK CROWN BAR FEED COLLETS



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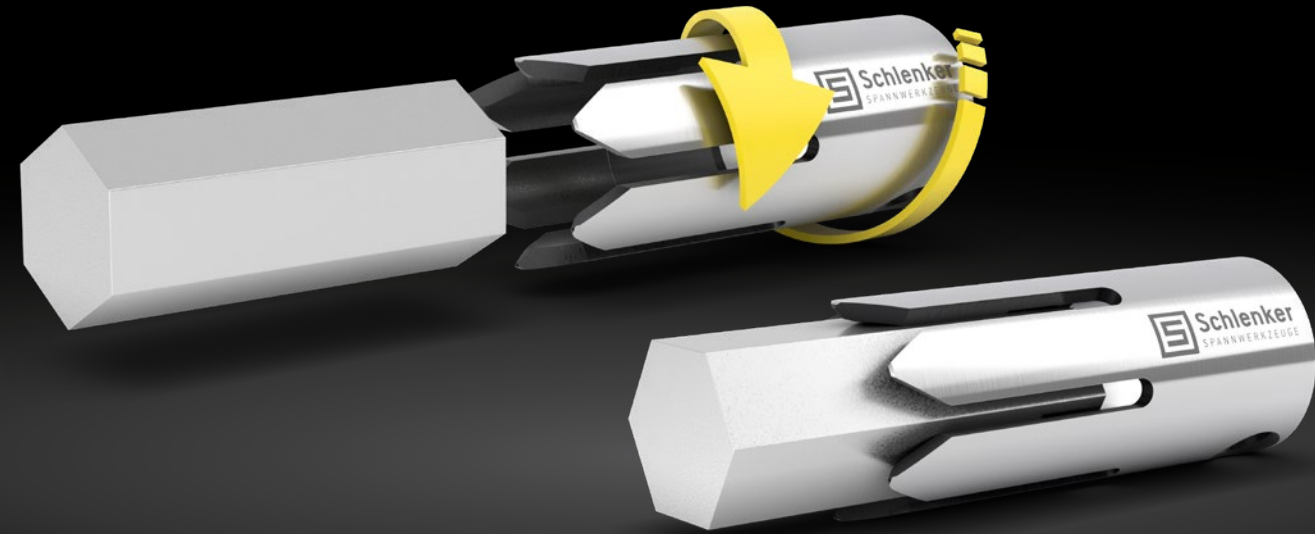


USE OF SHK CROWN BAR FEED COLLETS

The SHK crown bar feed collets owe their name to the special shape of the crown and are especially developed for profile material. This geometry simplifies the threading of the material and allows the full utilization of the channel, thus larger wrench sizes can be clamped.

PROCESS RELIABLE LOADING OF PROFILE MATERIAL

The following illustration shows how profile material can be loaded with a crown bar feed collet in a process reliable way.



WATCH NOW THE PRODUCT VIDEO
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SHK CROWN BAR FEED COLLET OPTIONS



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material



SQUARE TENSION

- Suitable for square material
- Tension can be increased or reduced according to requirements



HEXAGON TENSION

- Suitable for hexagon material
- Tension can be increased or reduced according to requirements

SHK CROWN BAR FEED COLLETS



A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

Article	Pusher [mm]	Ø A [mm]	Ø P [mm]	Ø Z [mm]	L [mm]	F min. - max. [mm]	
						■	⬡
S10K E210K	D10	10	7H7	4	40	5.0 – 7.0	7.0 – 9.0
S12K E212K	D12	12	8H7	4	40	6.0 – 8.0	7.0 – 10.0
S13K E213K	D13	13	8H7	4	40	6.0 – 9.0	7.0 – 11.0
S15K E203K	D15	15	11H7	6	40	8.0 – 11.0	10.0 – 13.0
S16K SHK16K	D16	16	11H7	6	40	8.0 – 11.0	10.0 – 14.0
S18K E218K	D18	18	11H7	6	40	8.0 – 13.0	10.0 – 16.0
S20K E225K	D20	20	14H7	8	65	10.0 – 14.0	13.0 – 17.0
S21K SHK21K	D21	21	14H7	8	65	PR	PR
S22K SHK22K	D22	22	14H7	8	65	10.0 – 16.0	13.0 – 19.0
S23K SHK23K	D23	23	14H7	8	65	10.0 – 16.0	13.0 – 20.0
S25K E222K	D25	25	20H7	8	65	15.0 – 18.0	18.0 – 22.0
S28K E227K	D28	28	20H7	8	65	15.0 – 20.0	18.0 – 24.0
S30K SHK30K	D30	30	20H7	8	65	15.0 – 21.0	18.0 – 26.0



A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

Article	Pusher [mm]	Ø A [mm]	Ø P [mm]	Ø Z [mm]	L [mm]	F min. - max. [mm]	
						■	⬡
S32K SHK32K	D32	32	20H7	8	65	15.0 – 23.0	18.0 – 28.0
S34K SHK34K	D34	34	20H7	8	65	15.0 – 24.0	18.0 – 30.0
S36K SHK36K	D36	36	20H7	8	65	15.0 – 25.0	18.0 – 30.0



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

TURBO BAR FEED COLLETS



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USE OF TURBO BAR FEED COLLETS

The TURBO bar feed collets are mounted on the rotating inserts and fastened with three set screws.



STANDARD ROUND

- Suitable for round material



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material

TURBO BAR FEED COLLET OPTIONS



SPECIAL PROFILES

- Various profiles can be realized by ram EDM or wire EDM
- Tension and shape of the bar feed collets can be exactly adapted to the material



TENSION

- Tension can be increased or reduced according to requirements



XT VERSION WITH SPRING

- Increased tension
- Emergency properties in case of breakage of the bar feed collet



FOR LOADING/UNLOADING

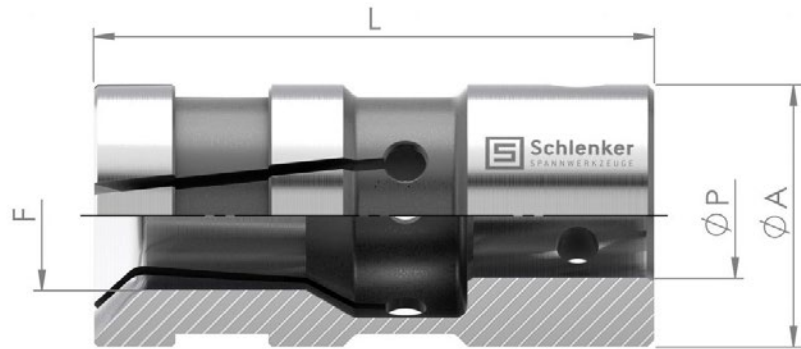
- The tension is adjusted to the workpiece
- These bar feed collets are used to load/unload blanks or workpieces






CLOSED DESIGN

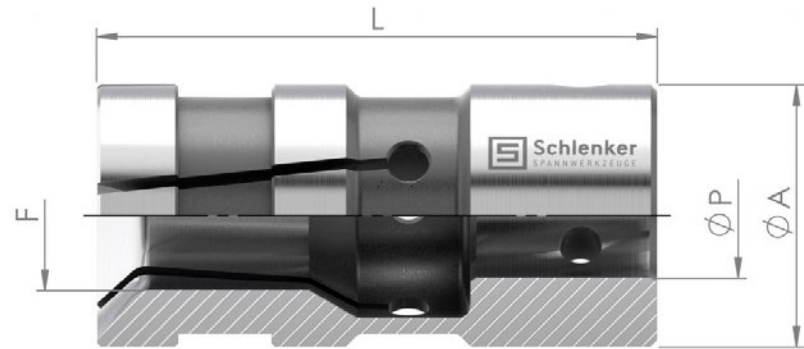
- Channel can be used completely

TURBO BAR FEED COLLETS






A Outer diameter P Fit ID L Total length F Shape

Article	Pusher [mm]	Ø A [mm]	Ø P [mm]	L [mm]	F min. – max. [mm]		
							
ST25 SHT25	D25	25	20H7	90	4.0 – 23.0	5.0 – 14.0	5.0 – 17.0
ST28 SHT28	D28	28	20H7	90	4.0 – 26.0	5.0 – 14.0	5.0 – 17.0
ST30 SHT30	D30	30	20H7	90	5.0 – 28.0	5.0 – 14.0	5.0 – 17.0
ST32 SHT32	D32	32	20H7	90	5.0 – 30.0	5.0 – 14.0	5.0 – 17.0
ST34 SHT34	D34	34	20H7	90	5.0 – 32.0	10.0 – 14.0	10.0 – 17.0
ST35 SHT35	D35	35	20H7	90	5.0 – 33.0	PR	PR
ST36 SHT36	D36	36	20H7	90	6.0 – 34.0	6.0 – 14.0	6.0 – 17.0
ST38 SHT38	D38	38	20H7	90	6.0 – 36.0	6.0 – 14.0	6.0 – 17.0
ST40 SHT40	D40	40	20H7	90	10.0 – 38.0	10.0 – 21.0	10.0 – 26.0
ST42 SHT42	D42	42	20H7	90	6.0 – 40.0	10.0 – 21.0	10.0 – 26.0
ST44 SHT44	D44	44	20H7	90	10.0 – 42.0	PR	PR
ST45 SHT45	D45	45	20H7	90	6.0 – 43.0	10.0 – 21.0	10.0 – 26.0
ST50 SHT50	D50	50	20H7	90	6.0 – 48.0	10.0 – 27.0	10.0 – 33.0



A Outer diameter P Fit ID L Total length F Shape

Article	Pusher [mm]	Ø A [mm]	Ø P [mm]	L [mm]	F min. – max. [mm]		
							
ST54 SHT54	D54	54	20H7	90	10.0 – 52.0	PR	PR
ST58 SHT58	D58	58	20H7	90	15.0 – 56.0	PR	PR
ST60 SHT60	D60	60	20H7	90	8.0 – 58.0	10.0 – 33.0	10.0 – 50.0
ST63 SHT63	D63	63	20H7	90	15.0 – 61.0	PR	PR
ST65 SHT65	D65	65	20H7	90	8.0 – 63.0	10.0 – 37.0	10.0 – 45.0
ST70 SHT70	D70	70	20H7	90	12.0 – 66.0	PR	PR
ST75 SHT75	D75	75	20H7 35H7	90	20.0 – 72.0	PR	PR
ST80 SHT80	D80	80	35H7	90	20.0 – 76.0	PR	PR
ST90 SHT90	D90	90	35H7	90	50.0 – 86.0	PR	PR
ST100 SHT100	D100	100	35H7	110	60.0 – 95.0	PR	PR



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

TURBO CROWN BAR FEED COLLETS



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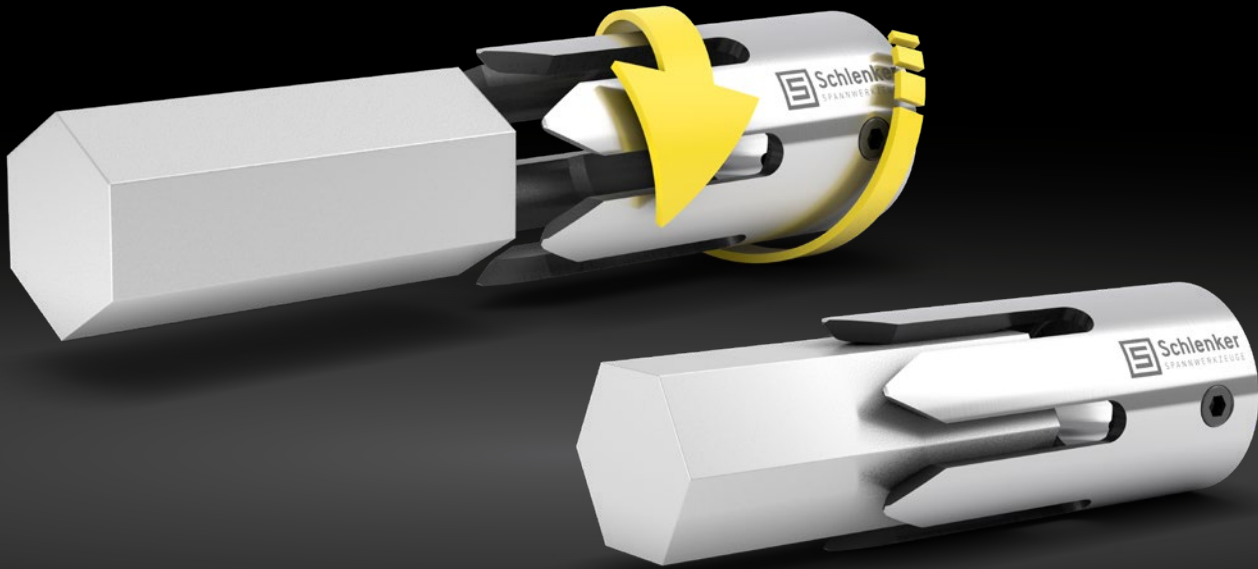


USE OF TURBO CROWN BAR FEED COLLETS

The TURBO crown bar feed collets owe their name to the special shape of the crown and are especially developed for profile material. This geometry simplifies the threading of the material and allows the full utilization of the channel, thus larger wrench sizes can be clamped.

PROCESS RELIABLE LOADING OF PROFILE MATERIAL

The following illustration shows how profile material can be loaded with a crown bar feed collet in a process reliable way.



WATCH NOW THE PRODUCT VIDEO
www.schlenker-spannwerkzeuge.de/en

TURBO CROWN BAR FEED COLLET OPTIONS



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material



SQUARE TENSION

- Suitable for square material
- Tension can be increased or reduced according to requirements





HEXAGON TENSION

- Suitable for hexagon material
- Tension can be increased or reduced according to requirements

TURBO CROWN BAR FEED COLLETS





A Outer diameter P Fit ID L Total length F Shape

Article	Pusher [mm]	Ø A [mm]	Ø P [mm]	L [mm]	F min. – max. [mm]	
						
ST25K SHT25K	D25	25	20H7	90	15.0 – 18.0	18.0 – 22.0
ST28K SHT28K	D28	28	20H7	90	15.0 – 20.0	18.0 – 24.0
ST30K SHT30K	D30	30	20H7	90	15.0 – 21.0	18.0 – 26.0
ST32K SHT32K	D32	32	20H7	90	15.0 – 23.0	18.0 – 28.0
ST34K SHT34K	D34	34	20H7	90	PR	PR
ST35K SHT35K	D35	35	20H7	90	PR	PR
ST36K SHT36K	D36	36	20H7	90	PR	21.0 – 31.0
ST38K SHT38K	D38	38	20H7	90	PR	PR
ST40K SHT40K	D40	40	20H7	90	PR	PR
ST42K SHT42K	D42	42	20H7	90	22.0 – 30.0	26.0 – 36.0
ST44K SHT44K	D44	44	20H7	90	PR	PR
ST45K SHT45K	D45	45	20H7	90	PR	PR
ST50K SHT50K	D50	50	20H7	90	28.0 – 35.0	34.0 – 43.0



A Outer diameter P Fit ID L Total length F Shape

Article	Pusher [mm]	Ø A [mm]	Ø P [mm]	L [mm]	F min. – max. [mm]	
						
ST54K SHT54K	D54	54	20H7	90	PR	PR
ST58K SHT58K	D58	58	20H7	90	PR	PR
ST60K SHT60K	D60	60	20H7	90	34.0 – 42.0	41.0 – 52.0
ST63K SHT63K	D63	63	20H7	90	PR	PR
ST65K SHT65K	D65	65	20H7	90	38.0 – 46.0	46.0 – 56.0
ST70K SHT70K	D70	70	20H7	90	PR	PR
ST75K SHT75K	D75	75	20H7 35H7	90	PR	PR
ST80K SHT80K	D80	80	35H7	90	PR	PR
ST90K SHT90K	D90	90	35H7	90	PR	PR
ST100K SHT100K	D100	100	35H7	110	PR	PR

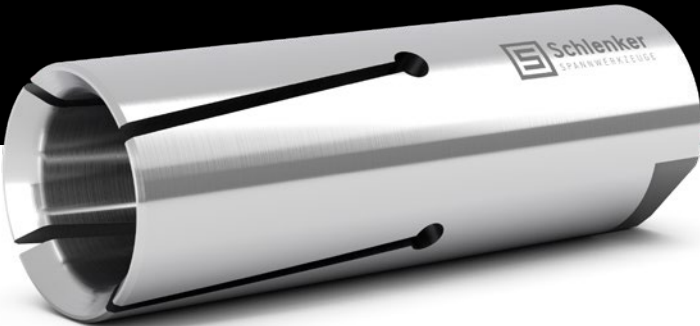


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IEMCA BAR FEED COLLETS






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USE OF IEMCA BAR FEED COLLETS

The IEMCA style bar feed collets are mounted and fixed on the rotating inserts through an internal thread.

	STANDARD ROUND <ul style="list-style-type: none">• Suitable for round material
	SQUARE <ul style="list-style-type: none">• Suitable for square material
	HEXAGON <ul style="list-style-type: none">• Suitable for hexagon material

IEMCA BAR FEED COLLET OPTIONS

	SPECIAL PROFILES <ul style="list-style-type: none">• Various profiles can be realized by ram EDM or wire EDM• Tension and shape of the bar feed collets can be exactly adapted to the material
	TENSION <ul style="list-style-type: none">• Tension can be increased or reduced according to requirements
	CLOSED DESIGN <ul style="list-style-type: none">• Channel can be used completely

IEMCA BAR FEED COLLETS



A Outer diameter
 L Total length
 G Thread
 F Shape

Article	Pusher [mm]	Ø A [mm]	L [mm]	G [mm]	F min. – max. [mm]
					●
SE7.5	D7.5	7.5	40	M5x0.5	2.0 – 6.5
SE10	D10	10	40	M6x0.75	2.0 – 8.0
SE12	D12	12	42	M7x0.75	2.0 – 10.0
SE15	D15	15	42	M8x1	4.0 – 13.0
SE16	D16	16	42	M8x1	7.0 – 14.0
SE18	D18	18	42	M8x1	12.5 – 16.0
SE20	D20	20	59	M10x1	4.0 – 18.0
SE22	D22	22	59	M10x1	14.0 – 20.0
SE23	D23	23	59	M10x1	14.0 – 21.0
SE25	D25	25	59	M10x1	17.0 – 23.0
SE27	D27	27	59	M10x1	19.0 – 25.0
SE30	D30	30	59	M10x1	3.0 – 28.0
SE32	D32	32	78	M25x1.5	25.0 – 30.0
SE34	D34	34	78	M25x1.5	8.0 – 32.0
SE35	D35	35	78	M25x1.5	20.0 – 33.0
SE37	D37	37	78	M25x1.5	31.0 – 35.0
SE38	D38	38	78	M25x1.5	31.0 – 35.0
SE40	D40	40	78	M25x1.5	20.0 – 37.0



A Outer diameter
 L Total length
 G Thread
 F Shape

Article	Pusher [mm]	Ø A [mm]	L [mm]	G [mm]	F min. – max. [mm]
					●
SE42	D42	42	78	M25x1.5	20.0 – 40.0
SE45	D45	45	80	M25x1.5	20.0 – 42.0
SE46	D46	46	80	M25x1.5	20.0 – 44.0
SE50	D50	50	80	M25x1.5	44.0 – 47.0
SE51	D51	51	80	M25x1.5	43.0 – 48.0
SE55	D55	55	80	M25x1.5	20.0 – 54.0
SE56	D56	56	80	M25x1.5	20.0 – 54.0
SE58	D58	58	80	M25x1.5	20.0 – 54.0
SE60	D60	60	80	M25x1.5	20.0 – 57.0
SE65	D65	65	80	M25x1.5	56.0 – 63.0
SE70	D70	70	80	M25x1.5	60.0 – 68.0
SE75	D75	75	80	M25x1.5	67.0 – 72.0



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IEMCA CROWN BAR FEED COLLETS



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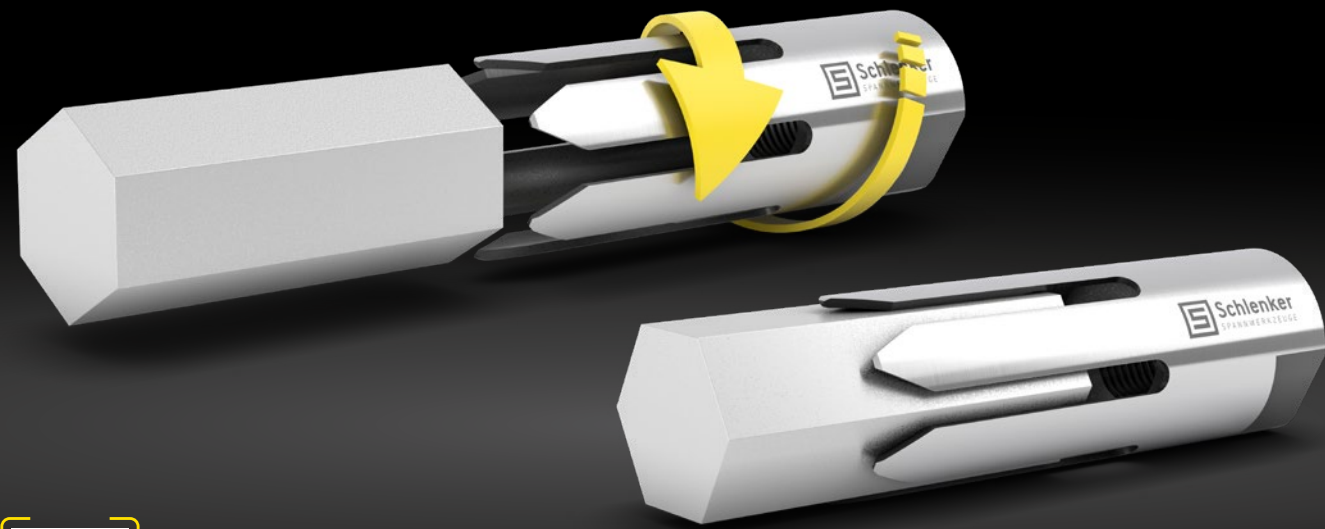


USE OF IEMCA CROWN BAR FEED COLLETS

The IEMCA style crown bar feed collets owe their name to the special shape of the crown and are especially developed for profile material. This geometry simplifies the threading of the material and allows the full utilization of the channel, thus larger wrench sizes can be clamped.

PROCESS RELIABLE LOADING OF PROFILE MATERIAL

The following illustration shows how profile material can be loaded with a crown bar feed collet in a process reliable way.



WATCH NOW THE PRODUCT VIDEO
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IEMCA CROWN BAR FEED COLLET OPTIONS



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material



SQUARE TENSION

- Suitable for square material
- Tension can be increased or reduced according to requirements



HEXAGON TENSION

- Suitable for hexagon material
- Tension can be increased or reduced according to requirements

IEMCA CROWN BAR FEED COLLETS



A Outer diameter
 L Total length
 G Thread
 F Shape

Article	Pusher [mm]	Ø A [mm]	L [mm]	G	F min. – max. [mm]	
					■	●
SE7.5K	D7.5	7.5	40	M5x0.5		
SE10K	D10	10	40	M6x0.75	5.0 – 7.0	7.0 – 9.0
SE12K	D12	12	42	M7x0.75	6.0 – 8.0	7.0 – 10.0
SE15K	D15	15	42	M8x1	8.0 – 11.0	10.0 – 13.0
SE16K	D16	16	42	M8x1	8.0 – 11.0	10.0 – 14.0
SE18K	D18	18	42	M8x1	8.0 – 13.0	10.0 – 16.0
SE20K	D20	20	59	M10x1	10.0 – 14.0	13.0 – 17.0
SE22K	D22	22	59	M10x1	11.0 – 15.0	14.0 – 19.0
SE23K	D23	23	59	M10x1	12.0 – 16.0	15.0 – 20.0
SE25K	D25	25	59	M10x1	15.0 – 18.0	18.0 – 22.0
SE27K	D27	27	59	M10x1	15.0 – 19.0	18.0 – 23.0
SE30K	D30	30	59	M10x1	15.0 – 21.0	18.0 – 26.0
SE32K	D32	32	78	M25x1.5	15.0 – 23.0	18.0 – 28.0
SE34K	D34	34	78	M25x1.5	17.0 – 24.0	20.0 – 26.0
SE35K	D35	35	78	M25x1.5	17.0 – 25.0	20.0 – 30.0
SE37K	D37	37	78	M25x1.5	17.0 – 26.0	20.0 – 32.0
SE38K	D38	38	78	M25x1.5	17.0 – 27.0	20.0 – 33.0
SE40K	D40	40	78	M25x1.5	17.0 – 28.0	20.0 – 35.0



A Outer diameter
 L Total length
 G Thread
 F Shape

Article	Pusher [mm]	Ø A [mm]	L [mm]	G	F min. – max. [mm]	
					■	●
SE42K	D42	42	78	M25x1.5	17.0 – 30.0	20.0 – 36.0
SE45K	D45	45	80	M25x1.5	17.0 – 32.0	20.0 – 39.0
SE46K	D46	46	80	M25x1.5	17.0 – 33.0	20.0 – 40.0
SE50K	D50	50	80	M25x1.5	22.0 – 35.0	26.0 – 43.0
SE51K	D51	51	80	M25x1.5	18.0 – 36.0	22.0 – 44.0
SE55K	D55	55	80	M25x1.5	17.0 – 39.0	20.0 – 48.0
SE56K	D56	56	80	M25x1.5	17.0 – 40.0	20.0 – 49.0
SE58K	D58	58	80	M25x1.5	17.0 – 41.0	20.0 – 50.0
SE60K	D60	60	80	M25x1.5	17.0 – 42.0	20.0 – 52.0
SE65K	D65	65	80	M25x1.5	17.0 – 46.0	20.0 – 56.0
SE70K	D70	70	80	M25x1.5	17.0 – 50.0	20.0 – 61.0
SE75K	D75	75	80	M25x1.5	48.0 – 53.0	59.0 – 65.0



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

CAV BAR FEED COLLETS

CAV BAR FEED COLLET OPTIONS







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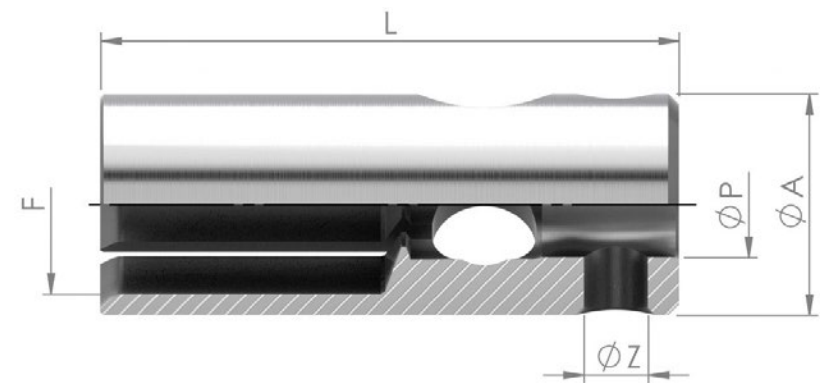
USE OF CAV BAR FEED COLLETS

The CAV bar feed collets are mounted on the rotating inserts and secured with a cross pin.

	STANDARD ROUND <ul style="list-style-type: none">• Suitable for round material
	SQUARE <ul style="list-style-type: none">• Suitable for square material
	HEXAGON <ul style="list-style-type: none">• Suitable for hexagon material

	SPECIAL PROFILES <ul style="list-style-type: none">• Various profiles can be realized by ram EDM or wire EDM• Tension and shape of the bar feed collets can be exactly adapted to the material
	CROWN DESIGN <ul style="list-style-type: none">• Channel can be used completely• Fast & easy threading of the profile material• Hexagon and square material that were previously not possible in the channel, can be loaded by the crown bar feed collet• The material does not have to be chamfered as for standard bar feed collets, it can be sharp-edged
	TENSION <ul style="list-style-type: none">• Tension can be increased or reduced according to requirements
	CLOSED DESIGN <ul style="list-style-type: none">• Channel can be used completely

CAV BAR FEED COLLETS



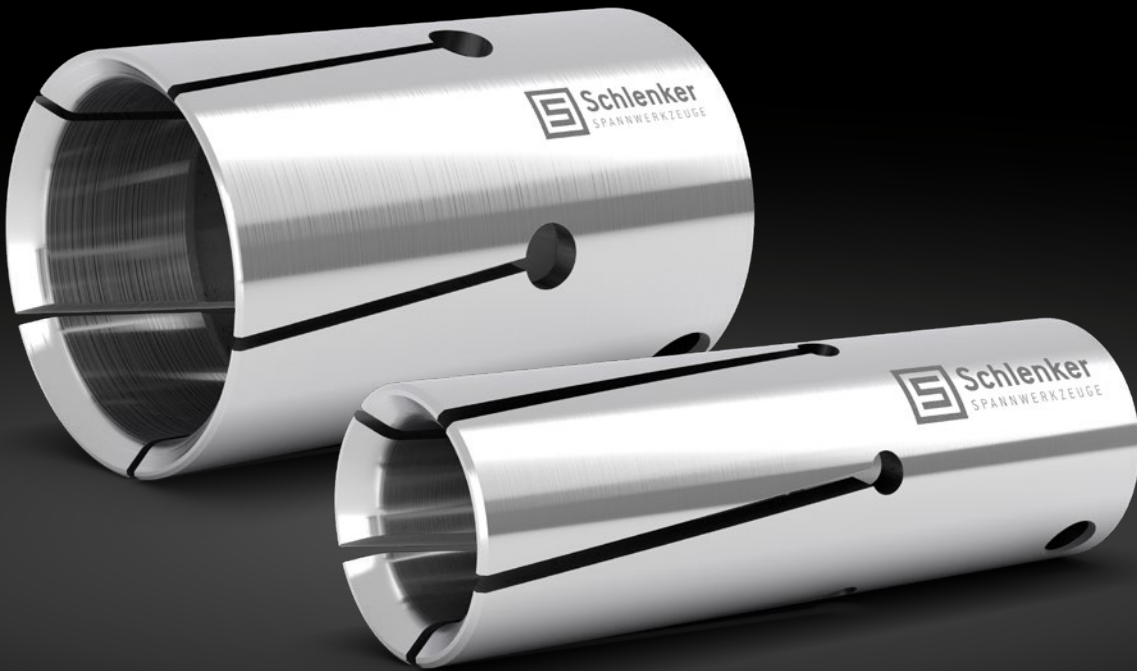
A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

Article	Pusher [mm]	Ø A [mm]	Ø P [mm]	Ø Z [mm]	L [mm]	F min. – max. [mm]
CAV7	D7	7	M6x1L		40	1.5 – 5.9
CAV10	D10	10	M6x1L		40	2.0 – 8.5
CAV12	D12	12	M6x1L		40	8.5 – 10.5
CAV15	D15	15	10	6	55	3.0 – 14.0
CAV17	D17	17	10	6	55	14.0 – 16.0
CAV19	D19	19	10	6	55	16.0 – 17.0
CAV21	D21	21	10	6	55	17.0 – 19.0
CAV25	D25	25	16	8	76	5.0 – 22.0
CAV32	D32	32	16	8	76	15.5 – 29.5
CAV34	D34	34	16	8	76	19.0 – 31.0

BAR FEED COLLETS
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CUCCHI BAR FEED COLLETS



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USE OF CUCCHI BAR FEED COLLETS

The CUCCHI bar feed collets are suitable for all CUCCHI loading magazines. The bar feed collets are mounted and fixed on the rotating inserts through an internal thread.



STANDARD ROUND

- Suitable for round material



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material

CUCCHI BAR FEED COLLET OPTIONS



SPECIAL PROFILES

- Various profiles can be realized by ram EDM or wire EDM
- Tension and shape of the bar feed collets can be exactly adapted to the material



CROWN DESIGN

- Channel can be used completely
- Fast & easy threading of the profile material
- Hexagon and square material that were previously not possible in the channel, can be loaded by the crown bar feed collet
- The material does not have to be chamfered as for standard bar feed collets, it can be sharp-edged



TENSION

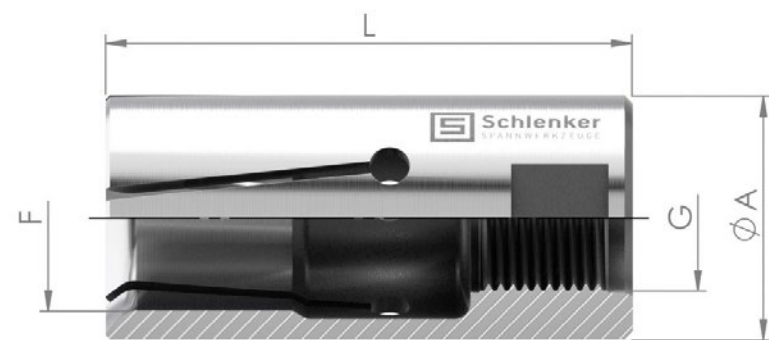
- Tension can be increased or reduced according to requirements



CLOSED DESIGN

- Channel can be used completely

CUCCHI BAR FEED COLLETS



A Outer diameter L Total length G Thread F Shape

Article	Ø A [mm]	L [mm]	G	F min. – max. [mm]
PB28	28	65	M18x1.5L	10.0 – 26.0
PB29	29	65	M18x1.5L	10.0 – 27.0
PB30	30	65	M18x1.5L	10.0 – 28.0
PB35	35	70	M18x1.5L	10.0 – 33.0
PB36	36	70	M18x1.5L	10.0 – 34.0
PB38	38	70	M25x1.5L	10.0 – 36.0
PB41	41	70	M25x1.5L	20.0 – 39.0
PB42	42	70	M25x1.5L	20.0 – 40.0
PB60	60	80	M30x1.5L	20.0 – 51.0

MISSION SUSTAINABILITY

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SCHLENKER ATTACH GREAT IMPORTANCE TO SUSTAINABILITY

We at Schlenker Spannwerkzeuge attach great importance to sustainability and a responsible approach to our environment. We conserve resources when developing new technologies and consciously face the resulting environmental as well as economic challenges. Corporate success and responsible action are not contradictory for us!

SAVE AND GENERATE ENERGY

We pay attention to a constant reduction of our energy consumption by switching to LED lighting, optimizing our production processes and sorting out obsolete machines as well as by switching to machines or assets with highly efficient motors. In addition, we place a great importance on sustainable energy production. For this reason, we produce our own electricity through a photovoltaic system on the roof. We also use our combined heat and power units to generate electricity in addition to heat, and in summer we can use them for air conditioning the building through absorption refrigeration systems. Another sustainable option for heating the production and office building is also provided by the exhaust heat from our production machines.

FOR THE LOVE OF THE ENVIRONMENT – DIGITALIZATION AT SCHLENKER

We also see the digitalization of our processes as a great opportunity to work sustainably. In this way, we offer digital and simple customer support, thus saving on travel. For the love of the environment, we also completely waived the sending of paper invoices by switching our system to e-invoices.

ECOLOGICAL WASTE MANAGEMENT AND PACKAGING MATERIALS

Waste management plays a major role in sustainability order to protect the climate and save resources. We pay close attention to consistent waste separation by qualified disposal companies. In addition, we are always reducing plastic in our shipping and packaging materials. For this reason, we only use ecologically degradable paper tape.



You can find out more about sustainability on our website.
www.schlenker-spannwerkzeuge.de/en/sustainability/

SHK INSIDE CLAMPING SLEEVES



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USE OF SHK INSIDE CLAMPING SLEEVES

The SHK inside clamping sleeves are mounted on the rotating inserts and secured with a cross pin.



STANDARD

- Suitable for tubes or drilled bar material



SEALED

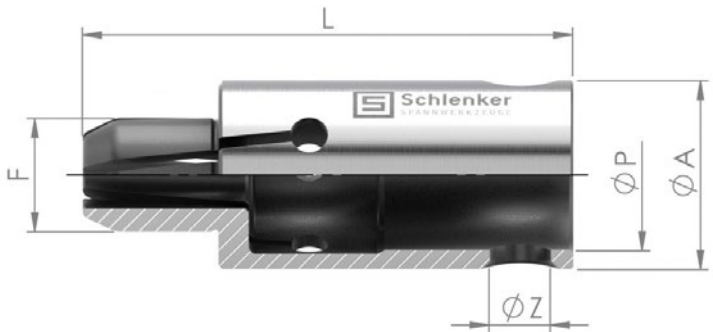
- Inside clamping sleeves are fully sealed to prevent the entry of coolants into the loading magazine



TENSION

- Tension can be increased or reduced according to requirements

SHK INSIDE CLAMPING SLEEVE OPTIONS



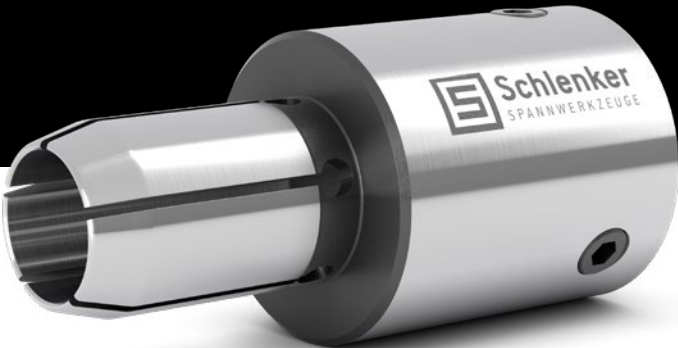
A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

Article	Pusher [mm]	Ø A [mm]	Ø P [mm]	Ø Z [mm]	L [mm]	F min. – max. [mm]
						●
SI7 SHKI7	D7	7	M5		37	3.5 – 6.0
SI10 SHKI10	D10	10	7H7	4	40	3.5 – 9.0
SI12 SHKI12	D12	12	8H7	4	40	3.5 – 11.0
SI15 SHKI15	D15	15	11H7	6	40	3.5 – 14.0
SI16 SHKI16	D16	16	11H7	6	40	3.5 – 15.0
SI18 SHKI18	D18	18	11H7	6	40	5.0 – 17.0
SI20 SHKI20	D20	20	14H7	8	65	5.0 – 19.0
SI25 SHKI25	D25	25	20H7	8	65	5.0 – 24.0
SI28 SHKI28	D28	28	20H7	8	65	6.0 – 27.0
SI30 SHKI30	D30	30	20H7	8	65	6.0 – 29.0
SI32 SHKI32	D32	32	20H7	8	65	6.0 – 31.0
SI34 SHKI34	D34	34	20H7	8	65	6.0 – 33.0
SI36 SHKI36	D36	36	20H7	8	65	10.0 – 35.0

TURBO INSIDE CLAMPING SLEEVES



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USE OF TURBO INSIDE CLAMPING SLEEVES

The TURBO inside clamping sleeves are mounted on the rotating inserts and fastened with three set screws.



A Outer diameter P Fit ID L Total length F Shape



STANDARD

- Suitable for tubes or drilled bar material



SEALED

- Inside clamping sleeves are fully sealed to prevent the entry of coolants into the loading magazine



TENSION

- Tension can be increased or reduced according to requirements

TURBO INSIDE CLAMPING SLEEVE OPTIONS

Article	Pusher [mm]	Ø A [mm]	Ø P [mm]	L [mm]	F min. – max. [mm]
					●
STI25 SHTI25	D25	25	20H7	90	6.0 – 24.0
STI28 SHTI28	D28	28	20H7	90	6.0 – 27.0
STI30 SHTI30	D30	30	20H7	90	6.0 – 29.0
STI32 SHTI32	D32	32	20H7	90	6.0 – 31.0
STI34 SHTI34	D34	34	20H7	90	6.0 – 33.0
STI35 SHTI35	D35	35	20H7	90	6.0 – 34.0
STI36 SHTI36	D36	36	20H7	90	10.0 – 35.0
STI38 SHTI38	D38	38	20H7	90	10.0 – 37.0
STI40 SHTI40	D40	40	20H7	90	10.0 – 39.0

TURBO INSIDE CLAMPING SLEEVES



A Outer diameter P Fit ID L Total length F Shape

Article	Pusher [mm]	Ø A [mm]	Ø P [mm]	L [mm]	F min. – max. [mm]
					●
STI42 SHTI42	D42	42	20H7	90	10.0 – 41.0
STI44 SHTI44	D44	44	20H7	90	10.0 – 43.0
STI45 SHTI45	D45	45	20H7	90	10.0 – 44.0
STI50 SHTI50	D50	50	20H7	90	10.0 – 49.0
STI54 SHTI54	D54	54	20		
STI58 SHTI58	D58	58	20H7	90	10.0 – 57.0
STI60 SHTI60	D60	60	20H7	90	10.0 – 59.0
STI63 SHTI63	D63	63	20H7	90	10.0 – 62.0
STI65 SHTI65	D65	65	20H7	90	10.0 – 64.0
STI70 SHTI70	D70	70	20H7	90	30.0 – 69.0
STI75 SHTI75	D75	75	20H7 35H7	90	30.0 – 74.0
STI80 SHTI80	D80	80	35H7	90	30.0 – 79.0
STI90 SHTI90	D90	90	35H7	90	40.0 – 89.0
STI100 SHTI100	D100	100	35H7	90	40.0 – 99.0

TURBO INSIDE CLAMPING SLEEVES
FOR LOADING/UNLOADING AND FOR EJECTOR CROSSES

FOR LOADING/UNLOADING

- The tension is adjusted to the workpiece
- These inside clamping sleeves are used to load/unload blanks or workpieces

FOR EJECTOR CROSS

- These inside clamping sleeves are used to unload blanks or workpieces through the ejector cross



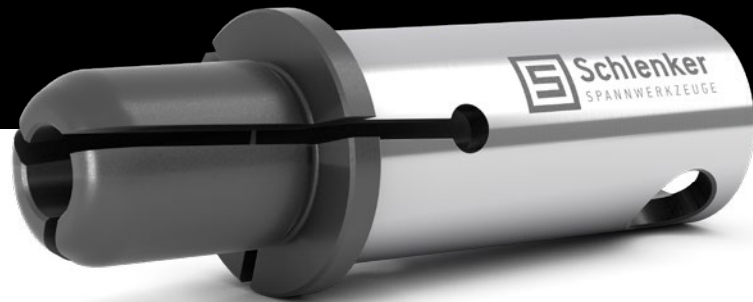
You would like to order a TURBO inside clamping sleeve?
Please contact us by phone or e-mail.
Phone: +49 7720 9944-0 | E-mail: info@schlenker-spannwerkzeuge.de

INSIDE CLAMPING SLEEVES INDEX

MULTI-SPINDLE



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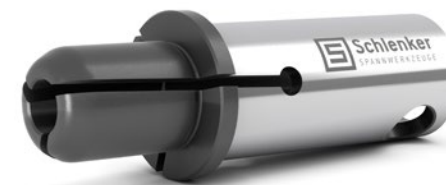


USE OF INSIDE CLAMPING SLEEVES INDEX MULTI-SPINDLE

The INDEX MS inside clamping sleeves are mounted with the outer stops on the rotating inserts and secured with a cross pin. The outer stops must be adapted to the outer diameter of the bar material.

NOTES

INSIDE CLAMPING SLEEVE INDEX MULTI-SPINDLE OPTIONS



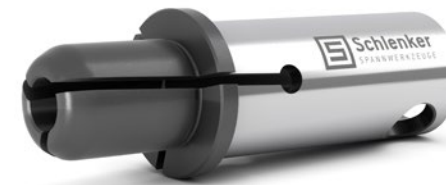
STANDARD

- Suitable for tubes or drilled bar material



SEALED

- Inside clamping sleeves are fully sealed to prevent the entry of coolants into the loading magazine



TENSION

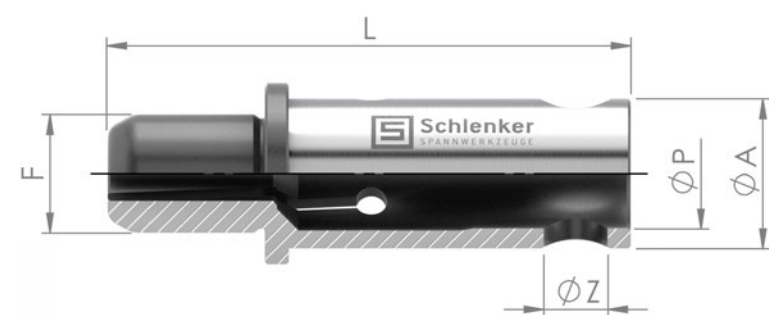
- Tension can be increased or reduced according to requirements



OUTER STOP

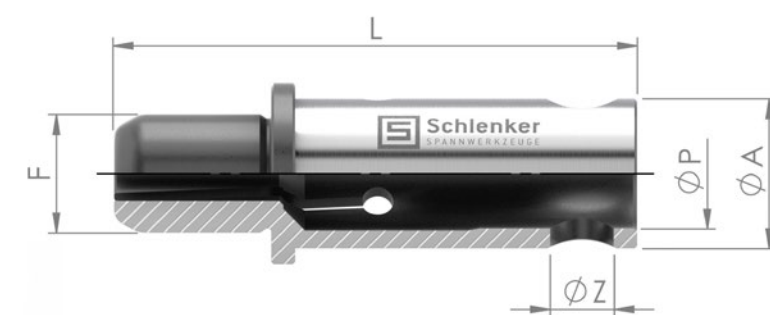
- Outer diameter of the outer stop and bar material must be the same
- Is mounted on the inside clamping sleeve and secured with a cross pin

INSIDE CLAMPING SLEEVE INDEX MULTI-SPINDLE



A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

Article		Pusher [mm]	Ø A [mm]	Ø P [mm]	Ø Z [mm]	L [mm]	F [mm]	Machine
							●	
Inside clamping sleeve	S927434.1232	D12	10.3	8H7	4	45	8.0	MS22 / MS40
Outer stop	SA927435.XX31	D12	13.0 – 23.0		4	32		
Inside clamping sleeve	S927535.1231	D12	10.3	8H7	4	45	8.0	MS32
Outer stop	SA927536.XX31	D12	13.0 – 18.0		4	32		
Inside clamping sleeve	S927434.1233	D12	10.3	8H7	4	46	8.0	MS22 / MS32 / MS40
Outer stop	SA927435.XX32	D12	13.0 – 23.0		4	26		
Inside clamping sleeve	S927535.1831	D18	16	11H7	6	45	15.0	MS22 / MS32 / MS40
Outer stop	SA927536.XX31	D18	19.0 – 25.0		6	32		
Inside clamping sleeve	S927535.1841	D18	16	11H7	6	46.5	15.0	MS22 / MS32 / MS40
Outer stop	SA927536.XX41	D18	19.0 – 25.0		6	26.5		
Inside clamping sleeve	S927934.1832	D18	18	11H7	6	45	15.0	MS52
Outer stop	SA927975.XX31	D18	22.0 – 32.0			20		
Inside clamping sleeve	S927434.2332	D23	19	14H7	8	70	15.0	MS40
Outer stop	SA927435.XX31	D23	24.0 – 32.0		8	52		



A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

Article		Pusher [mm]	Ø A [mm]	Ø P [mm]	Ø Z [mm]	L [mm]	F [mm]	Machine
							●	
Inside clamping sleeve	S927434.2333	D23	19	14H7	8	66.5	15.0	MS40
Outer stop	SA927435.XX32	D23	24.0 – 32.0			46.5		
Inside clamping sleeve	S927535.3531	D25	22	15H7	8	70	15.0	MS32
Outer stop	SA927536.XX31	D25	26.0 – 36.0			52		
Inside clamping sleeve	S927434.3232	D32	27	20H7	8	70	15.0	MS40
Outer stop	SA927435.XX31	D32	33.0 – 40.0		8	52		
Inside clamping sleeve	S927434.3233	D32	27	20H7	8	61	15.0	MS40
Outer stop	SA927435.XX32	D32	33.0 – 40.0			41		
Inside clamping sleeve	S927934.3232	D32	32	20H7	8	70	20.0	MS52
Outer stop	SA927975.XX31	D32	33.0 – 42.0			38		
Inside clamping sleeve	S927934.4232	D42	42	20H7	8	70	20.0	MS52
Outer stop	SA927975.XX31	D42	43.0 – 52.0			38		
Inside clamping sleeve	D18 IMS 52	D18	18	11H7	6	45	15.0	
Inside clamping sleeve	D32 IMS 52	D32	32	20H7	8	70	20.0	
Inside clamping sleeve	D42 IMS 52	D42	42	20H7	8	70	20.0	

FEEDING COLLETS



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USE OF FEEDING COLLETS

The task of the feeding collets are to feed the raw material from the bar loader into the machine. The material to be processed is guided and clamped by the feeding collets.

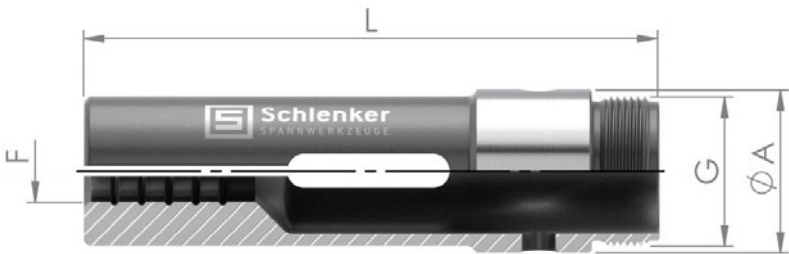
	SMOOTH <ul style="list-style-type: none">• Suitable for round material
	GROOVED <ul style="list-style-type: none">• Suitable for round material
	SQUARE <ul style="list-style-type: none">• Suitable for square material

FEEDING COLLET OPTIONS




	HEXAGON <ul style="list-style-type: none">• Suitable for hexagon material
	PEEK / PLASTIC INSERTS <ul style="list-style-type: none">• Prevents marks on the bar material• Inserts are replaceable when worn• Ideal for processing scratch-sensitive materials
	ALUMINIUM INSERTS <ul style="list-style-type: none">• Prevents marks on the bar material• Inserts are replaceable when worn• Ideal for processing scratch-sensitive materials
	BRASS INSERTS <ul style="list-style-type: none">• Prevents marks on the bar material• Inserts are replaceable when worn• Ideal for processing scratch-sensitive materials

	BRONZE INSERTS <ul style="list-style-type: none"> Prevents marks on the bar material Inserts are replaceable when worn Ideal for processing scratch-sensitive materials
	PERMAGLIS INSERTS <ul style="list-style-type: none"> Prevents marks on the bar material Inserts are replaceable when worn Ideal for processing scratch-sensitive materials
	TENSION <ul style="list-style-type: none"> Tension can be increased or reduced according to requirements

FEEDING COLLETS



A Outer diameter L Total length G Thread F Shape

Article	Ø A [mm]	L [mm]	G [mm]	F max. [mm]		
						
E207	18	70	M16x1L	12.0	9.0	11.0
E217	21	70	M20x1L	16.0	11.0	14.0
E220	24	85	M22x1L	18.0	13.0	16.0
E236	30	95	M28x1L	24.0	16.0	21.0
E237	31	90	M29x1L	25.0	18.0	22.0
E254	42	116	M40x1L	36.0	25.0	31.0
E273	60	140	M58x1L	52.0	36.0	45.0



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

FEEDING COLLETS MULTI-SPINDLE



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USE OF FEEDING COLLETS MULTI-SPINDLE

The task of the multi-spindle feeding collets are to feed the raw material from the bar loader into the machine. The material to be processed is guided and clamped by the feeding collets.

	SMOOTH <ul style="list-style-type: none">• Suitable for round material
	GROOVED <ul style="list-style-type: none">• Suitable for round material
	SQUARE <ul style="list-style-type: none">• Suitable for square material

FEEDING COLLET MULTI-SPINDLE OPTIONS




	HEXAGON <ul style="list-style-type: none">• Suitable for hexagon material
	PEEK / PLASTIC INSERTS <ul style="list-style-type: none">• Prevents marks on the bar material• Inserts are replaceable when worn• Ideal for processing scratch-sensitive materials
	ALUMINIUM INSERTS <ul style="list-style-type: none">• Prevents marks on the bar material• Inserts are replaceable when worn• Ideal for processing scratch-sensitive materials
	BRASS INSERTS <ul style="list-style-type: none">• Prevents marks on the bar material• Inserts are replaceable when worn• Ideal for processing scratch-sensitive materials

	<p>BRONZE INSERTS</p> <ul style="list-style-type: none"> • Prevents marks on the bar material • Inserts are replaceable when worn • Ideal for processing scratch-sensitive materials
	<p>PERMAGLIS INSERTS</p> <ul style="list-style-type: none"> • Prevents marks on the bar material • Inserts are replaceable when worn • Ideal for processing scratch-sensitive materials
	<p>TENSION</p> <ul style="list-style-type: none"> • Tension can be increased or reduced according to requirements

FEEDING COLLETS MULTI-SPINDLE



A Outer diameter
 L Total length
 G Thread
 F Shape

Article	Ø A [mm]	L [mm]	G [mm]	F max. [mm]		
						
E9268	22	86	M20x1	16.0	11.0	13.5
E9265	22.8	98	M20x0.75	16.0	11.0	13.5
E9255	25	88	M23x1	18.5	13.0	16.0
E9258	25	90	M24x1	20.0	14.0	17.0
E9282	34.7	118	M33x1.5	25.0	18.0	22.0
E9319	41.8	130	M38x1.5	32.0	23.0	28.0
E9372	51	154	M48x1.5	40.0	28.0	35.0



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

RS OUTER SLEEVES

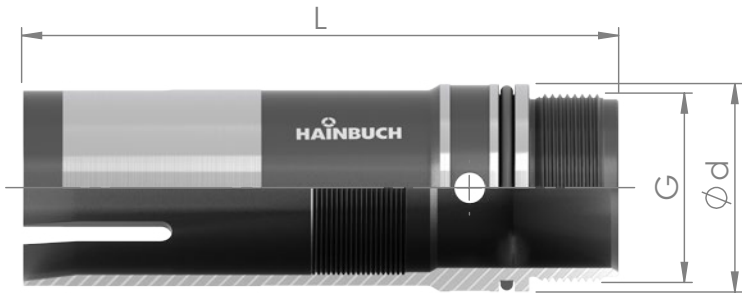


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USE OF RS FEEDING COLLETS

The task of the RS feeding collets are to feed the raw material from the bar loader into the machine. For this purpose, the inner collet is screwed into the outer sleeve with a special wrench.



d Shaft-Ø L Total length G Thread

Article	Ø d [mm]	L [mm]	G [mm]
RS16 (E9255)	25	78	M23x1
RS20 (E9258)	25.5	80	M24x1
RS24 (E9258-2)	30.5	78	M28.5x0.75
RS25 (E9282)	35	106	M33x1.5
RS32 (E9319)	41.9	120	M38x1.5
RS40 (E9372)	51	140	M48x1.5

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RS INNER COLLETS



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USE OF RS FEEDING COLLETS

The inner collet can be adjusted multiple times and has therefore a longer service life. The adjustable thrust force significantly reduces the abrasion and wear of the feeding collets.



d Shaft-Ø A Head-Ø L Total length G Thread F Shape

Article	Ø d [mm]	Ø A [mm]	L [mm]	G [mm]	F min. – max. [mm]		
					●	■	⬡
RS16	18	20.8	61	M18x1	2.5 – 16.0	4.0 – 11.0	4.0 – 13.0
RS20	20	23.8	61	M20x1	4.0 – 18.0	4.0 – 12.0	4.0 – 14.5
RS24	24	27.8	65	M24x1	4.0 – 22.0	5.0 – 15.0	5.0 – 19.0
RS25	28	31.8	72	M28x1	4.0 – 25.0	7.0 – 17.0	6.0 – 22.0
RS32	35	38.6	83	M35x1	4.0 – 32.0	7.0 – 21.0	7.0 – 27.0
RS40	44	48	90	M44x1	6.0 – 40.0	10.0 – 28.0	7.0 – 34.0

i DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

FRONT EJECTORS VKK



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USE OF FRONT EJECTORS VKK

Front ejectors, also called VKK, are mounted like the bar feed collets, on the rotating inserts, which are fixed with the feed rod. The bar material can only be pushed over the front ejectors in the machine direction. Residual piece ejection takes place in the work space. Depending on the manufacturer, the front ejectors are connected to the rotating inserts via a cross pin, three set screws or an internal thread.



- SHK**
- Suitable for round material
 - Available sizes D10 to D40



- TURBO**
- Suitable for round material
 - Available sizes D25 to D100

FRONT EJECTOR VKK VERSIONS

- SHK VKK
- TURBO VKK

SHK VKK FRONT EJECTORS



A Outer diameter P Fit ID L Total length

Article	Ø A [mm]	Ø P [mm]	L [mm]
VKK10	10.3	7H7	40
VKK12	12.3	8H7	40
VKK13	13.3	8H7	40
VKK14	14.3	8H7	40
VKK15	15.3	11H7	40
VKK16	16.3	11H7	40
VKK17	17.3	11H7	40
VKK18	18.3	11H7	40
VKK20	20.3	14H7	65
VKK22	22.3	14H7	65
VKK24	24.3	14H7	65

SHK VKK FRONT EJECTORS



A Outer diameter P Fit ID L Total length

Article	Ø A [mm]	Ø P [mm]	L [mm]
VKK25	25.3	20H7	65
VKK26	26.3	20H7	65
VKK28	28.3	20H7	65
VKK30	30.3	20H7	65
VKK31	31.3	20H7	65
VKK32	32.3	20H7	65
VKK34	34.3	20H7	65
VKK35	35.3	20H7	65
VKK36	36.3	20H7	65
VKK38	38.3	20H7	65
VKK40	40.3	20H7	65

TURBO VKK FRONT EJECTORS



A Outer diameter P Fit ID L Total length

Article	Ø A [mm]	Ø P [mm]	L [mm]
VKK25	25.3	20H7	90
VKK26	26.3	20H7	90
VKK28	28.3	20H7	90
VKK30	30.3	20H7	90
VKK31	31.3	20H7	90
VKK32	32.3	20H7	90
VKK34	34.3	20H7	90
VKK35	35.3	20H7	90
VKK36	36.3	20H7	90
VKK38	38.3	20H7	90
VKK40	40.3	20H7	90
VKK41	41.3	20H7	90
VKK42	42.3	20H7	90
VKK44	44.3	20H7	90
VKK45	45.3	20H7	90
VKK46	46.3	20H7	90
VKK50	50.3	20H7	90
VKK51	51.3	20H7	90
VKK55	55.3	20H7	90
VKK60	60.3	20H7	90
VKK65	65.3	20H7	90
VKK67 – VKK100	PR		

FRONT EJECTORS SKK



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USE OF FRONT EJECTORS SKK

Front ejectors, also called SKK, are mounted like the bar feed collets, on the rotating inserts, which are fixed with the feed rod. The tube material can only be pushed over the front ejectors in the machine direction. Residual piece ejection takes place in the work space. Depending on the manufacturer, the front ejectors are connected to the rotating inserts via a cross pin, three set screws or an internal thread.



- SHK**
- Suitable for round material
 - Available sizes D10 to D40



- TURBO**
- Suitable for round material
 - Available sizes D25 to D100

FRONT EJECTOR SKK VERSIONS

- SHK SKK
- TURBO SKK

SHK SKK FRONT EJECTORS



A Outer diameter P Fit ID L Total length

Article	Ø A [mm]	Ø P [mm]	L [mm]
SKK10	10.3	7H7	40
SKK12	12.3	8H7	40
SKK13	13.3	8H7	40
SKK14	14.3	8H7	40
SKK15	15.3	11H7	40
SKK16	16.3	11H7	40
SKK17	17.3	11H7	40
SKK18	18.3	11H7	40
SKK20	20.3	14H7	65
SKK22	22.3	14H7	65
SKK24	24.3	14H7	65
SKK25	25.3	20H7	65

SHK SKK FRONT EJECTORS



A Outer diameter P Fit ID L Total length

Article	Ø A [mm]	Ø P [mm]	L [mm]
SKK26	26.3	20H7	65
SKK28	28.3	20H7	65
SKK30	30.3	20H7	65
SKK31	31.3	20H7	65
SKK32	32.3	20H7	65
SKK34	34.3	20H7	65
SKK35	35.3	20H7	65
SKK36	36.3	20H7	65
SKK38	38.3	20H7	65
SKK40	40.3	20H7	65

TURBO SKK FRONT EJECTORS



A Outer diameter P Fit ID L Total length

Article	Ø A [mm]	Ø P [mm]	L [mm]
SKK25	25.3	20H7	90
SKK26	26.3	20H7	90
SKK28	28.3	20H7	90
SKK30	30.3	20H7	90
SKK31	31.3	20H7	90
SKK32	32.3	20H7	90
SKK34	34.3	20H7	90
SKK35	35.3	20H7	90
SKK36	36.3	20H7	90
SKK38	38.3	20H7	90
SKK40	40.3	20H7	90
SKK41	41.3	20H7	90
SKK42	42.3	20H7	90
SKK44	44.3	20H7	90
SKK45	45.3	20H7	90
SKK46	46.3	20H7	90
SKK50	50.3	20H7	90
SKK51	51.3	20H7	90
SKK55	55.3	20H7	90
SKK60	60.3	20H7	90
SKK65	65.3	20H7	90
SKK67 – SKK100	PR		

ROTATING INSERTS



HSL Roating Inserts **190**

TURBO Rotating Inserts **192**

Various Rotating Inserts **196**

HSL ROTATING INSERTS



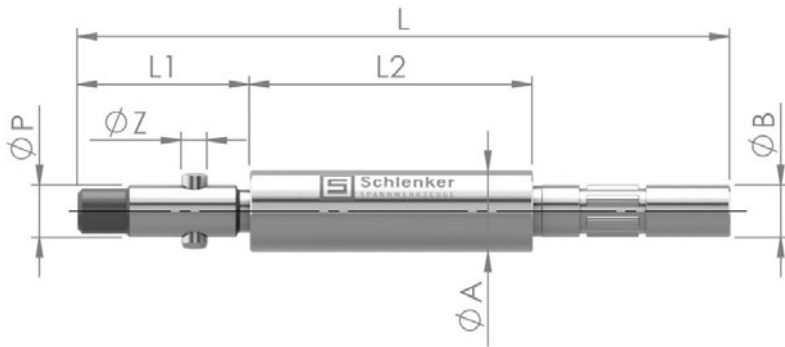
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USE OF HSL ROTATING INSERTS

HSL rotating inserts are pressed into the feed rod and additionally pinned if required. The bar feed collets are fastened to the rotating inserts via a cross pin.



- A

Outside diameter
- B

Pusher interface
- P

Fit ID
- Z

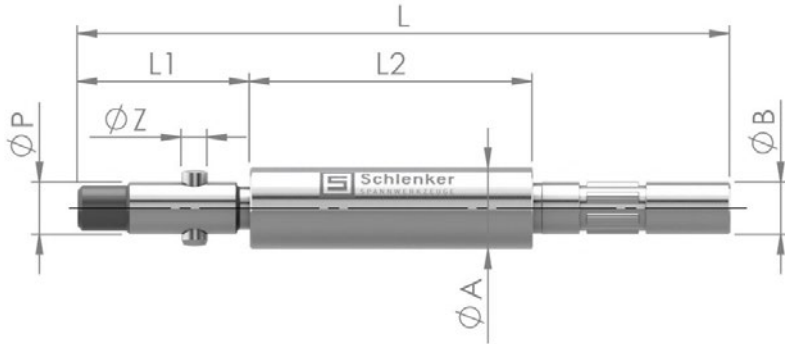
Cross bore ID
- L1

Length L1
- L2

Length L2
- L

Total length

Article	Machine manufacturer	Ø A [mm]	Ø B [mm]	Ø P [mm]	Ø Z [mm]	L1 [mm]	L2 [mm]	L [mm]
L10 HSL	FMB, IEMCA, IRCO	10.5	8	7	4	26.5	43.5	100
L12 HSL	FMB, IEMCA, IRCO	12.5	8	8	4	26.5	43.5	100
L13 HSL	FMB, IEMCA, IRCO	13.5	8	8	4	26.5	43.5	100
L15 HSL	FMB, IEMCA, IRCO, TRAUB	15	12	11	6	26.5	43.5	100
L16 HSL	FMB, IEMCA, IRCO, TRAUB	16	12	11	6	26.5	43.5	100



- A

Outside diameter
- B

Pusher interface
- P

Fit ID
- Z

Cross bore ID
- L1

Length L1
- L2

Length L2
- L

Total length

Article	Machine manufacturer	Ø A [mm]	Ø B [mm]	Ø P [mm]	Ø Z [mm]	L1 [mm]	L2 [mm]	L [mm]
L18 HSL	FMB, IEMCA, IRCO, TRAUB	18	12	11	6	26.5	43.5	100
L20 HSL	FMB, IEMCA, IRCO, TRAUB	20	17	14	8	39	47	116
L22 HSL	FMB, IEMCA, IRCO, TRAUB	22	17	14	8	39	47	116
L25 HSL	FMB, IEMCA, IRCO, TRAUB	25	20	20	8	41.5	47.5	119
L30 HSL	FMB, IEMCA, IRCO, TRAUB	30	20	20	8	41.5	47.5	119
L32 HSL	FMB, IEMCA, IRCO, TRAUB	32	20	20	8	41.5	47.5	11
L36 HSL	FMB, IEMCA, IRCO, TRAUB	36	20	20	8	41.5	47.5	119

i

DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

TURBO ROTATING INSERTS



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USE OF TURBO ROTATING INSERTS

TURBO rotating inserts are shrunk into the feed rod and additionally pinned if required. The bar feed collets are fastened to the rotating inserts via three set screws.



ROTATING INSERTS D25-D36

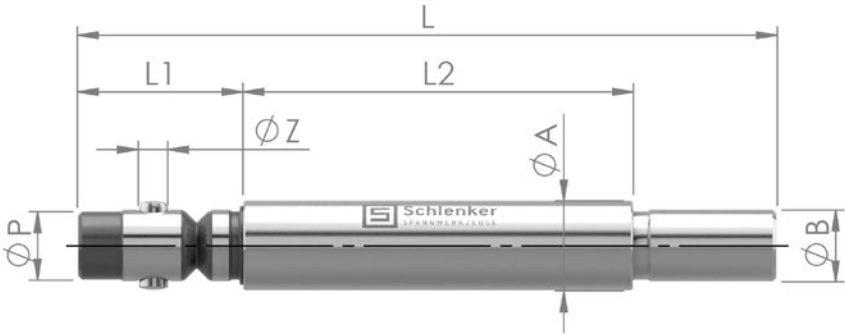
- Available sizes D25 to D36



ROTATING INSERTS D38-D100

- Available sizes D38 to D100

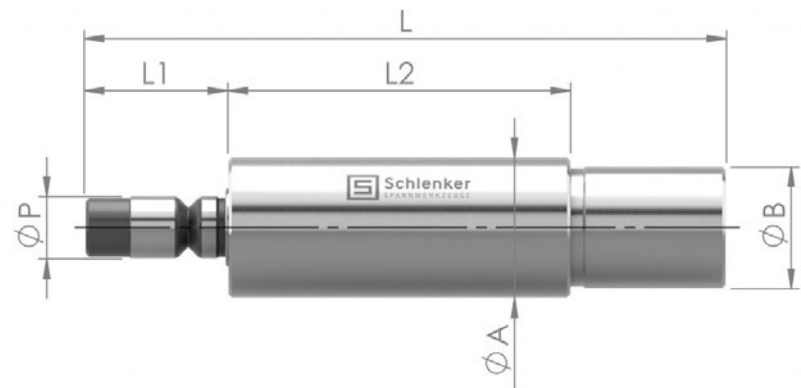
TURBO ROTATING INSERTS D25-D36



- | | | | | | | | |
|----|------------------|----|------------------|---|--------------|---|---------------|
| A | Outside diameter | B | Pusher interface | P | Fit ID | Z | Cross bore ID |
| L1 | Length L1 | L2 | Length L2 | L | Total length | | |

Article	Ø A [mm]	Ø B [mm]	Ø P [mm]	Ø Z [mm]	L1 [mm]	L2 [mm]	L [mm]
LT25 D25	25	20	20	8	46	110	196
LT30 D30	30	25	20	8	46	110	196
LT32 D32	32	25	20	8	46	110	196
LT34 D34	34	30	20	8	46	110	196
LT36 D36	36	30	20	8	46	110	196

TURBO ROTATING INSERTS D38-D100



- A

Outside diameter
- B

Pusher interface
- P

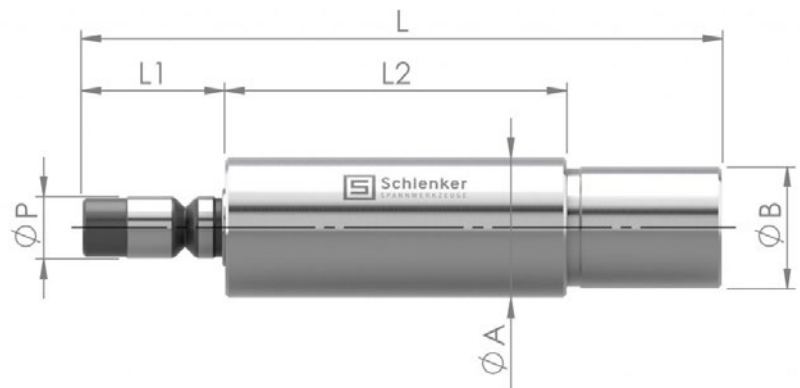
Fit ID
- L1

Length L1
- L2

Length L2
- L

Total length

Article	Ø A [mm]	Ø B [mm]	Ø P [mm]	L1 [mm]	L2 [mm]	L [mm]
LT38 D38	38	30	20	46	110	196
LT40 D40	40	33	20	46	110	206
LT42 D42	42	33	20	46	110	206
LT44 D44	44	33	20	46	110	206
LT45 D45	45	33	20	46	110	206
LT50 D50	50	42	20	46	110	206
LT54 D54	54	42	20	46	110	206
LT55 D55	55	42	20	46	110	206
LT58 D58	58	51	20	46	110	231
LT60 D60	60	51	20	46	110	231
LT63 D63	63	51	20	46	110	231
LT65 D65	65	51	20	46	110	231
LT70 D70	70	51	20	46	110	231



- A

Outside diameter
- B

Pusher interface
- P

Fit ID
- L1

Length L1
- L2

Length L2
- L

Total length

Article	Ø A [mm]	Ø B [mm]	Ø P [mm]	L1 [mm]	L2 [mm]	L [mm]
LT75 D75	75	65	20 35	46	110	231
LT80 D80	80	65	35	46	110	231
LT90 D90	90	65	35	46	110	231
LT100 D100	100	82	35	46	110	231

i

DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

VARIOUS ROTATING INSERTS

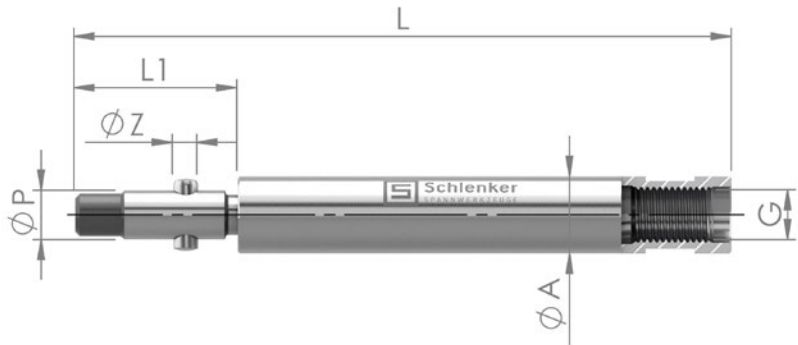


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USE OF IEMCA SIR STYLE ROTATING INSERTS

IEMCA SIR style rotating inserts are screwed onto the feed rod. The bar feed collets are fastened to the rotating inserts via a cross pin.



A Outside diameter P Fit ID Z Cross bore ID L1 Length L1 L Total length G Thread

Article	Machine manufacturer	Ø A [mm]	Ø P [mm]	Ø Z [mm]	L1 [mm]	L [mm]	G
L12 IEMCA SIR	IEMCA	12.5	8	4	26.5	107	M9x1L
L15 IEMCA SIR	IEMCA	15	11	6	26.5	127	M12x1L
L18 IEMCA SIR	IEMCA	18	11	6	26.5	127	M15x1L
L23 IEMCA SIR	IEMCA	23	14	8	43	139.5	M18x1L
L24 IEMCA SIR	IEMCA	24	14	8	43	139.5	M18x1L
L25 IEMCA SIR	IEMCA	25	20	8	42	146.5	M22x1L
L32 IEMCA SIR	IEMCA	32	20	8	41	169.5	M28x1L
L36 IEMCA SIR	IEMCA	36	20	8	41	169.5	M30x1L

VARIOUS ROTATING INSERT VERSIONS

- IEMCA SIR
- IEMCA D5
- IEMCA D7
- TORNOS ERT
- FMB-TRAUB
- TRAUB



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USE OF IEMCA STYLE D5 ROTATING INSERTS

IEMCA style D5 rotating inserts are screwed onto the feed rod. The bar feed collets are fastened to the rotating inserts via an internal thread.



- IEMCA D5**
- Available size D5




A Outside diameter L Total length G1 Thread G2 Thread

Article	Machine manufacturer	Ø A [mm]	L [mm]	G1	G2
L5 IEMCA D5	IEMCA	5.5	90	M4	M4

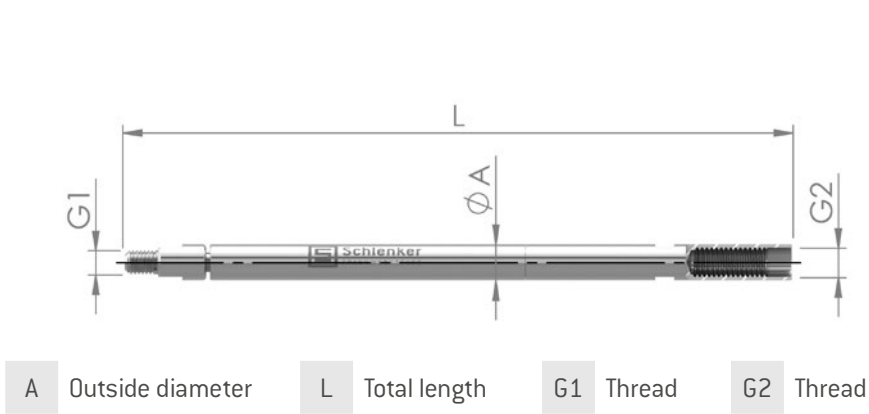
USE OF IEMCA STYLE D7 ROTATING INSERTS

IEMCA style D7 rotating inserts are screwed into the feed rod. The bar feed collets are fastened to the rotating inserts via an internal thread.



IEMCA D7


- Available size D7



Article	Machine manufacturer	Ø A [mm]	L [mm]	G1	G2
L7 IEMCA D7	IEMCA	7.5	139	M5	M6x0.75

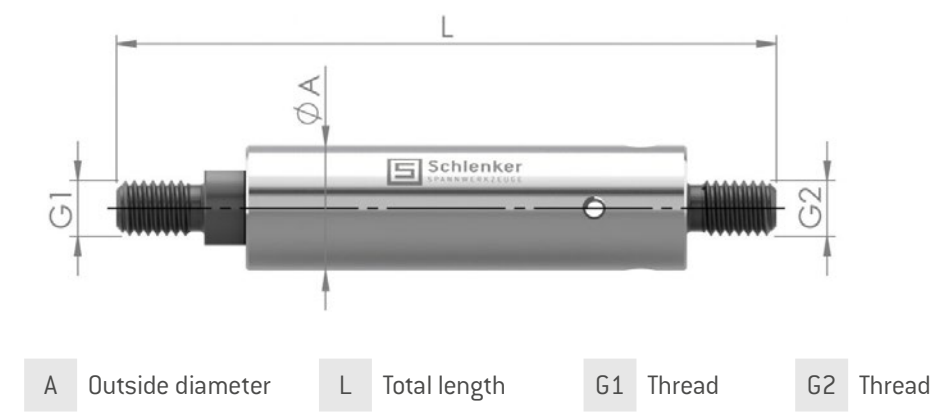
USE OF TORNOS ERT ROTATING INSERTS

TORNOS rotating inserts are screwed onto the feed rod. The bar feed collets are fastened to the rotating inserts via a cross pin.



TORNOS ERT


- Available sizes D5.5 to D13.5



Article	Machine manufacturer	Ø A [mm]	L [mm]	G1	G2
L5.5 ERT ERT 0550	TORNOS	5.5	55	M3	M3
L7 ERT ERT 0700	TORNOS	7	41.5	M4	M5
L7.5 ERT ERT 0750	TORNOS	7.5	42	M4	M5
L8.5 ERT ERT 0850	TORNOS	8.5	41.5	M5	M5
L10.5 ERT ERT 1050	TORNOS	10.5	45	M6	M6
L13.5 ERT ERT 1350	TORNOS	13.5	52	M6	M6

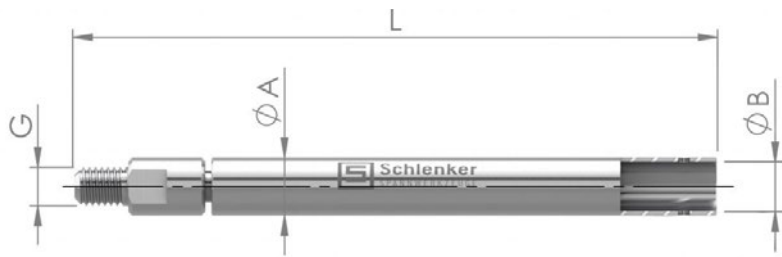
USE OF FMB-TRAUB ROTATING INSERTS

FMB-TRAUB rotating inserts are screwed into the feed rod. The bar feed collets are fastened to the rotating inserts via an internal thread.



FMB-TRAUB

- Available sizes D5 and D7




A Outside diameter B Feed rod interface G Thread L Total length

Article	Machine manufacturer	Ø A [mm]	Ø B [mm]	L [mm]	G
L5 / D5	FMB, TRAUB	5.5	4.4	82.5	M4
L7 / D7	FMB, TRAUB	7.5	6.4	83.5	M5

USE OF TRAUB ROTATING INSERTS

TRAUB rotating inserts are screwed into the feed rod. The bar feed collets are fastened to the rotating inserts via an internal thread.



TRAUB

- Available sizes D10 and D12



A Outside diameter B Feed rod interface P Fit ID Z Cross bore ID L Total length

Article	Machine manufacturer	Ø A [mm]	Ø B [mm]	Ø P [mm]	Ø Z [mm]	L [mm]
L10 TR D10 TRAUB	TRAUB	10.5	9	7	4	88
L12 TR D12 TRAUB	TRAUB	12.5	11	8	4	88



OTHER VERSIONS FOR COMMON LOADING MAGAZINES ARE AVAILABLE PER REQUEST.

OTHER SOLUTIONS

Chuck Levers	204
Reducing Tubes	205
Draw Tubes	206
Option long parts	207
Collet Sleeves	208
Pressure Sleeves	209
Collet Springs	210
Cap Nuts	211



CHUCK LEVERS

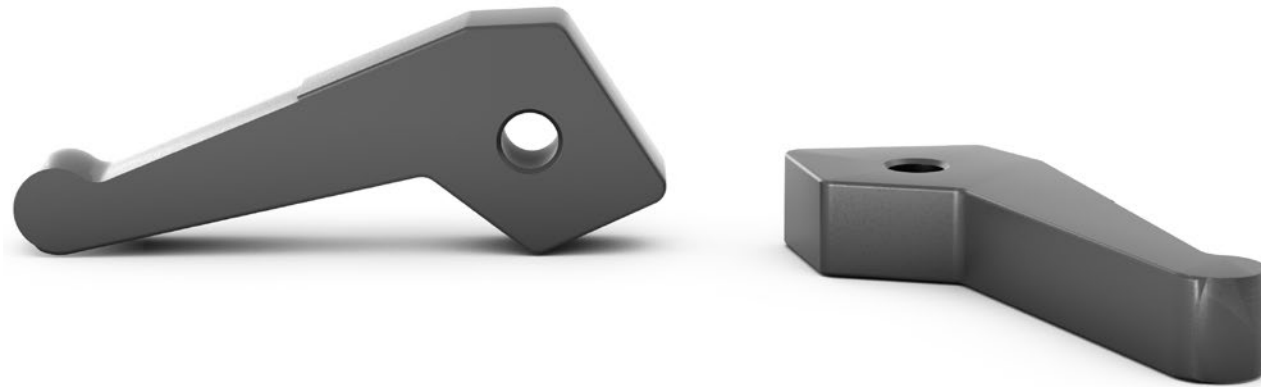


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USE OF CHUCK LEVERS

Chuck levers are available for all common automatic lathes and sliding headstock lathes with toggle clamping. They are characterized above all by their precision and durability. Test the chuck levers now, you will be convinced.



NOTES

REDUCING TUBES



USE OF REDUCING TUBES

By using reducing tubes, the spindle bore of the CNC lathe can be adapted to the material diameter. This can prevent imbalance and vibration caused by unguided bar material, which can otherwise cause dimensional inaccuracy and negative impacts on the workpiece clamping. Well-guided bar material reduces spindle bearing wear and increases the service life of the cutting tools.



NOTES

DRAW TUBES



USE OF DRAW TUBES

Draw tubes are a component of the clamping system and are installed in the spindle of the lathe. Draw-in collets are screwed with their thread into the draw tubes. The workpiece is clamped by pulling the draw-in collet into the collet sleeve. Draw tubes can be manufactured in different sizes according to customer requirements.



NOTES

OPTION LONG PARTS



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USE OF OPTION LONG PARTS

Long workpieces cannot be removed in the work space. The long parts option allows the workpieces to be removed through the sub spindle of the machine. Can be manufactured in different sizes according to customer requirements.



NOTES

COLLET SLEEVES



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USE OF COLLET SLEEVES

Collet sleeves are a part of the spindle in the machine. There are no limits to customer-specific requirements, as collet sleeves can be manufactured according to drawings as well as samples.



NOTES

PRESSURE SLEEVES



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USE OF PRESSURE SLEEVES

Pressure sleeves are an important part of the clamping system and are installed in the spindle of the CNC lathe. They can be manufactured in different versions. For overgrip collets the taper angle of the pressure sleeve can be adjusted. Used or worn pressure sleeves can be reground or reworked within shortest time. Another possibility is to reduce the pressure sleeves, so it is possible to produce on the same machine with a smaller type of collet. There are no customer-specific limits, as pressure sleeves can be manufactured according to drawings as well as samples.



NOTES

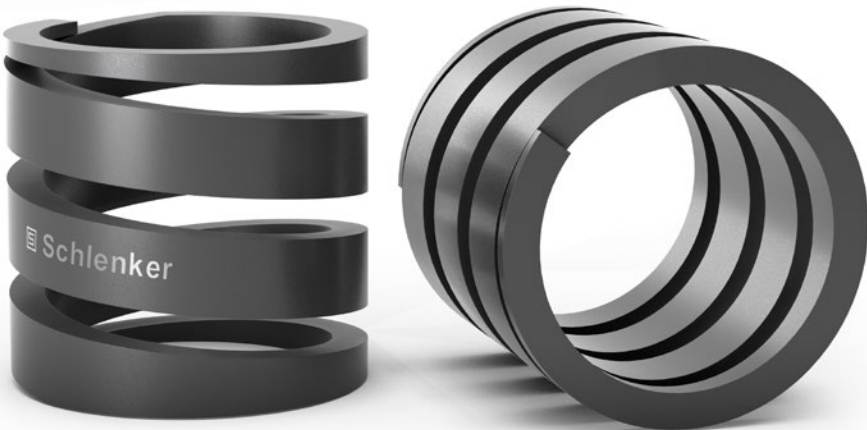
COLLET SPRINGS



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USE OF COLLET SPRINGS

Collet springs are installed in pressure sleeves and are an important part of the clamping system.



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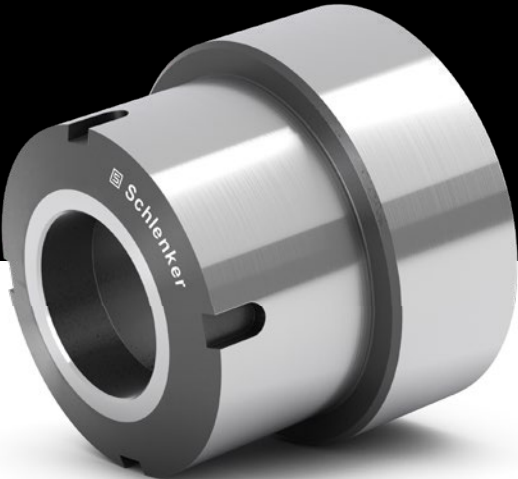
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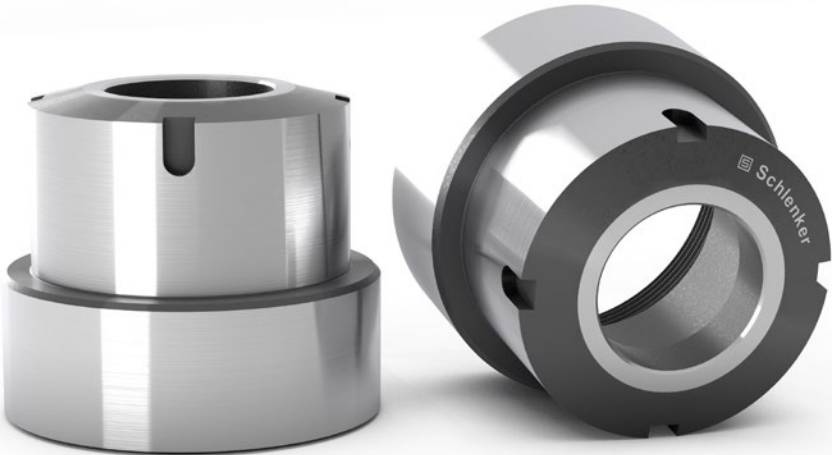
CAP NUTS



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USE OF CAP NUTS

Cap nuts are used as a stop for the collets and are screwed onto the spindle of the CNC lathe. They can be manufactured according to drawings as well as samples.



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IMPRINT

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