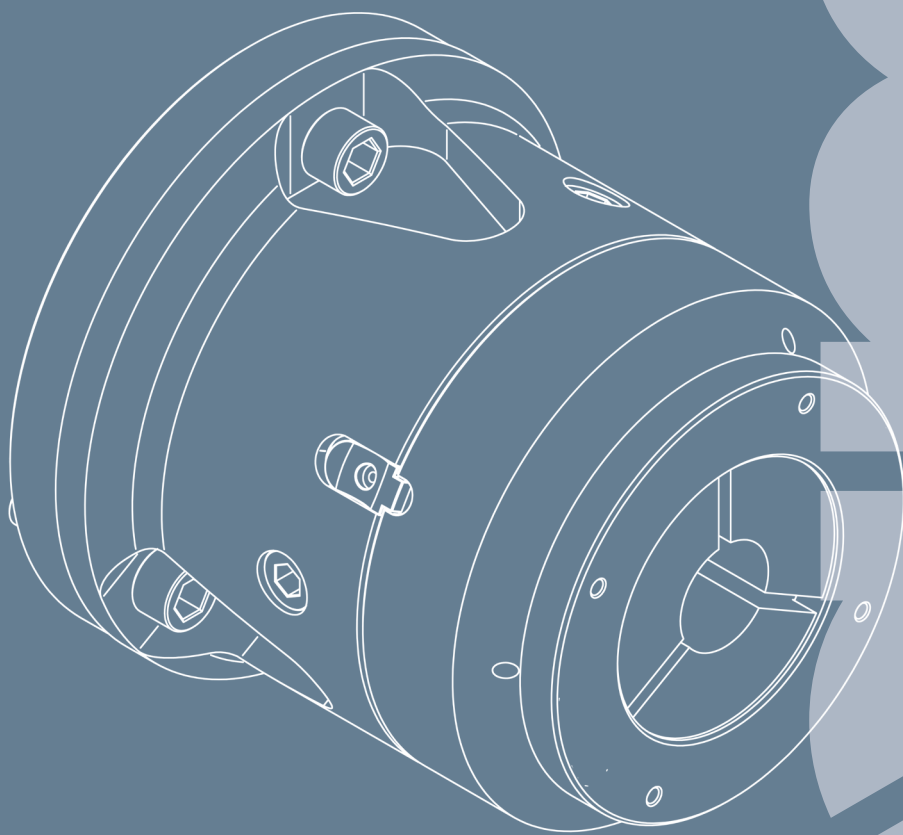


Collet Chucks

QC & C Series



Collet Chuck
QC & C Series

Quick Change Series Power Collet Chuck for Bar Machining

Two Different Systems:

Direct Mount System

- This system mounts directly to the lathe spindle to ensure a consistent mounting without the need for correction.
- Klamp QDCRL collet chucks are suitable for spring, varibore and rubberflex collets increasing its flexibility. Varibore and rubberflex collets allow rough, unfinished bar to be machined in the first operation and spring collets can be used for high accuracy in the second operation.
- Workpiece remains in a fixed position during actuation allowing for precise z-axis positioning. A tapered sleeve is pushed forward, compressing the collet and gripping the workpiece.
- All Klamp collet chucks are case hardened, optimising the rigidity, strength and durability.



Modular System

- As the direct mount system except with interchangeable adaptors enables the collet chuck to be moved from one machine spindle nose to another
- Cost-effective as only additional adaptors and connectors are required when changing different spindle/machine.
- The need for adjustment is minimal, meaning less machine downtime.



Ultra-Fast 10 Second Collet Changes



3 Different Collet Types Available



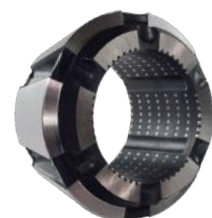
Spring Collets*

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



Varibore Collets**

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



Rubberflex Collets***

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

Quick Change Series Power Collet Chuck for Bar Machining

Bar Seals Prevent Swarf & Coolant Ingress



Remove bar seal from housing



Mark the diameter you require



Cut out the diameter



Reassemble and proceed

Adjustable Collet Mounted Workstop for Spring Collets



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



Insert collet work stopper



Lock stopper housing in position



Adjust stopper shaft position



Lock stopper shaft and install

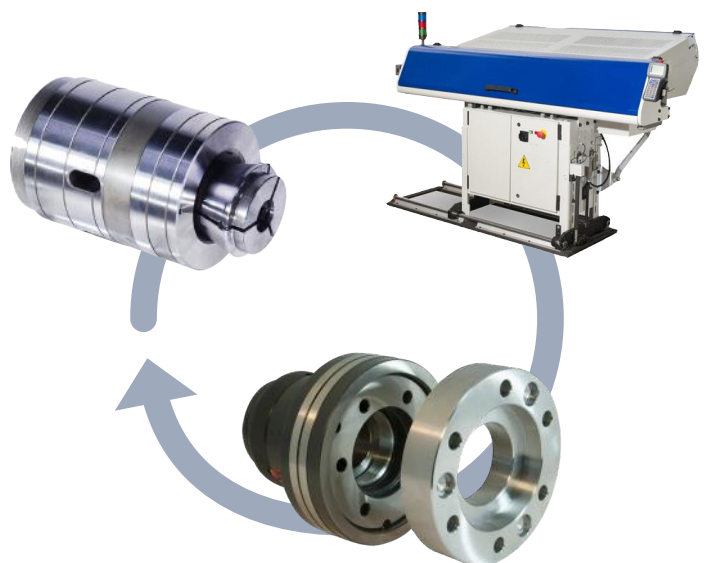
Application Advantages

- Klamp collet chucks are designed to work with bar loaders and bar feeders by not interfering with the actions of the bar feeder or loader.
- All types of QCRL42, QCRL60 & QCRL80 have interchangeable match ground reduction sleeves to allow you to use a wider range of collets on one chuck.
- Wide adaptor plates for all models available upon request.
- Clamping/unclamping of chuck during spindle rotation is possible.
- Less deformation of thin-walled components during clamping.
- High operating reliability due to a minimum number of parts.
- High axial positioning accuracy of the components by means of push type collet system.

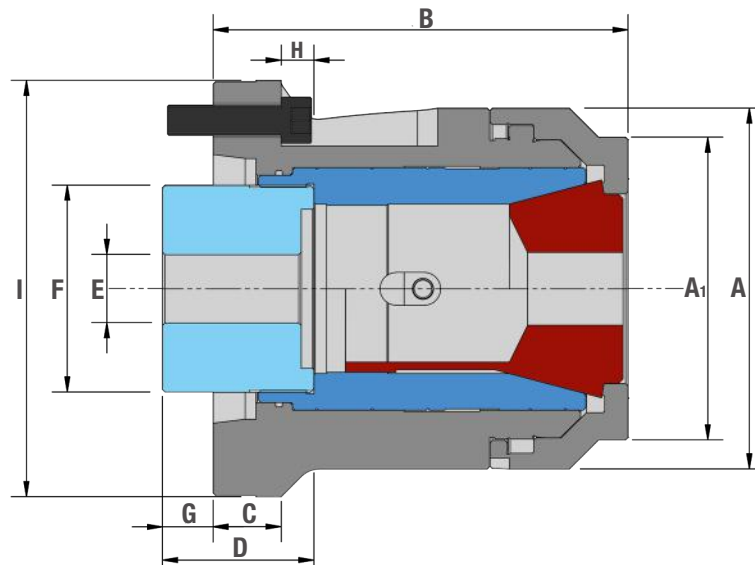
* See pages 14-18 for more Spring Collet information.

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

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

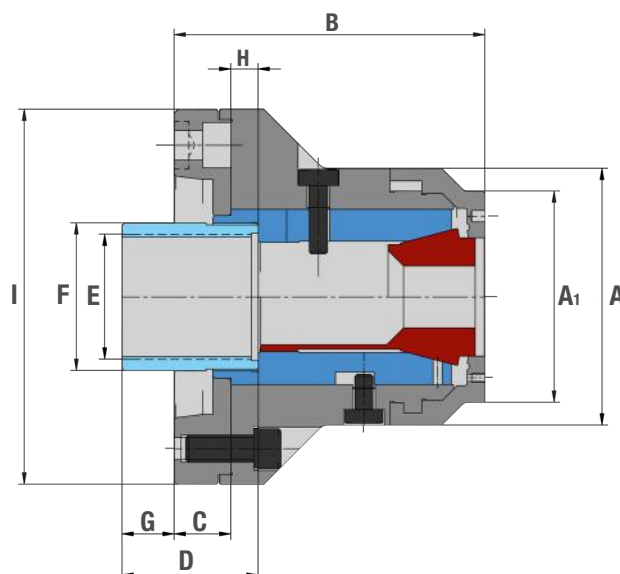


Quick Change Series Power Collet Chuck for Bar Machining



KLAMP Type		QDCRL42 DIN	QDCRL60 DIN	QCRS66 Inch		QCRS80 Inch		QCRL80 DIN	
Mounting		A5	A6	Z220	A8	Z220	A8	Z220	A8
Part Number		QDCRL42A5	QDCRL60A6	QCRS66	QCRS66A8	QCRS80	QCRS80A8	QCRL80	QCRL80A8
Spring Collet Type		D-173E	D-185E	-	-	-	-	D-193E	
Spring Collet Gripping Range	Minimum	2	3	-	-	-	-	12	
	Maximum	42	60	-	-	-	-	80	
Spring Collet Increments		0.5	0.5	-	-	-	-	0.5	
Varibore Collet Type		D-673	D-677	D-285		D-175		D-660	
Varibore Collet Gripping Range	Minimum	4	4	3		12		12	
	Maximum	42	60	66		80		80	
Varibore Collet Increments		2	2	3		3		3	
Rubberflex Collet Type		DRFC-673	DRFC-677	-		-		-	
Rubberflex Collet Gripping Range	Minimum	7*	19*	-		-		-	
	Maximum	45*	65*	-		-		-	
Rubberflex Collet Increments		2	2	-		-		-	
A		113	143	162		196		196	
A1		93	120	136		166		166	
B		136	164.5	146		164.5	162	216	209
C		N / A	N / A	N / A		N / A		N / A	
D		60	60	80		80		80	
E Maximum		M58 x 2.0	M75 x 2.0	M90 x 2.0		M90 x 2.0		M90 x 2.0	
F		65	82	100		100		100	
G Maximum		23	20	5	25	37	20	33	16
G Minimum		16	13	-5	15	25	8	25	8
H		N / A	N / A	N / A		N / A		N / A	
I		135		230	220	230	220	230	220
Sleeve stroke		7	7	10		12		8	
Max. input force	kN	25	30	38		45		45	
Max. Gripping Force	kN	55	60	84		78		78	
Max. Speed	min-1	7100	6300	4500		4500		4500	
Net Weight	kg	10	17	23.3	21.5	28.3	28.5	37	36
Matching Kitagawa Cylinders		S1246 SS1246	S1552 S1875	S1552 S1875		S2091 SS1881		S2091 SS1881	

Quick Change Series Power Collet Chuck for Bar Machining



KLAMP Type		Q-CRL42 DIN			Q-CRL54 Inch				Q-CRL60 DIN			
Mounting		Z140	A5	A6	Z170	A5	A6	A8	Z170	A5	A6	A8
Part Number		QCRL42	QCRL42A5	QCRL42A6	QCRL54	QCRL54A5	QCRL54A6	QCRL54A8	QCRL60	QCRL60A5	QCRL60A6	QCRL60A8
Spring Collet Type		D173E			D853				D185E			
Spring Collet Gripping Range	Minimum	2			1.6				3			
	Maximum	42			54				60			
Spring collet increments		0.5			0.5				0.5			
Varibore Collet Type		D673			D-120				D-677			
Varibore Collet Gripping Range	Minimum	4			3				4			
	Maximum	42			53.9				60			
Varibore Collet Increments		2			3				2			
Rubberflex Collet Type		DRFC673			-				DRFC677			
Rubberflex Collet Gripping Range	Minimum	7			-				19*			
	Maximum	45			-				65*			
Rubberflex Collet Increments		2			-				2			
A		113			143				143			
A1		93			118				118			
B		137			175	184	169	169	171	180	165	165
C		25			31.5	46.5	31.5	31.5	31.5	46.5	31.5	31.5
D		60			60				60			
E Maximum		M58 x 1.5			M75 x 1.5				M75 x 1.5			
F		65			82				82			
G Maximum		17	23	23	15	25	21	21	14	-22	21	21
G Minimum		10	16	16	5	15	11	11	7	-15	14	14
H		12			8.3				8.3			
I		165			220				220			
Sleeve stroke		7			10				7			
Max. input force	kN	25			30				30			
Max. Gripping Force	kN	55			60				60			
Max. Speed	min ⁻¹	7100			6300				6300			
Net Weight	kg	14.5	14	13.5	28.3	32	28.3	26.3	28.3	32	28.3	26.3
Matching Kitagawa Cylinders		S1246 SS1246			S1552 S1875				S1552 S1875			

Short Series Power Collet Chuck for Bar Machining

Short Body/Wide Range

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

High Speed

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

First Operation Collet Chuck

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

Fixed Length Collet

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

Problem Free Installation

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

Quick & Easy Mounting

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

Long service life

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



Designed for Bar Pushers/Barfeeders



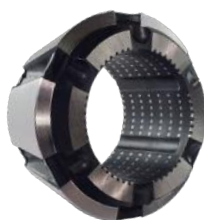
Fixed-length Klamp collet chucks are designed to work with bar loaders and bar feeders by not interfering with the process of the bar feeder action.

2 Different Collet Types Available



Varibore Collets**

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

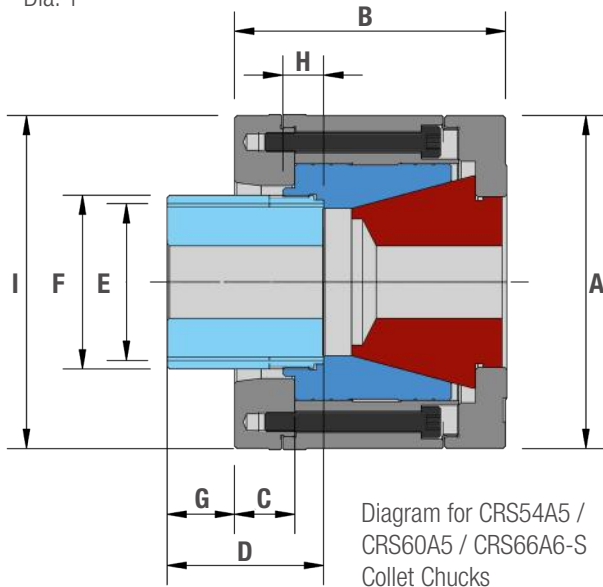


Rubberflex Collets***

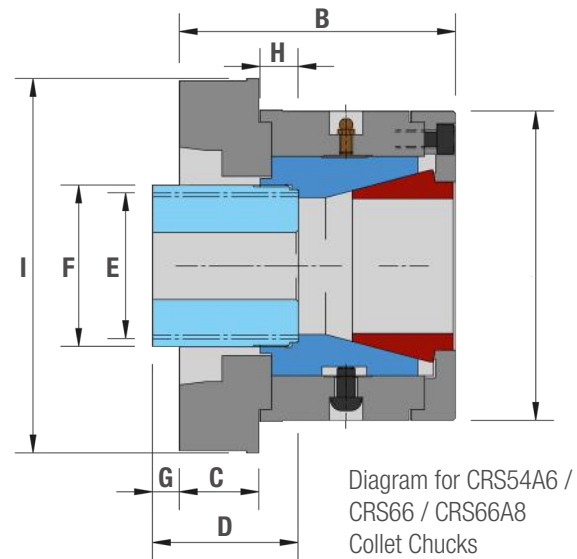
The same accuracy specification as spring collets. Elastic rubber-metal vulcanization allows a clamping range of +/- 1mm to the nominal diameter.

Short Series Power Collet Chuck for Bar Machining

Dia. 1



Dia. 2



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

* See pages 22-23 for more Varibore Collet information

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

Long Series Power Collet Chuck for Bar Machining

Long Body/Wide Range

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

High Speed

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

First & Second Operation Collet Chuck

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

Fixed Length Collet

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

Problem Free Installation

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



Quick & Easy Mounting

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

Long service life

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

Adjustable Collets Mounted Workstop for Spring Collets



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

Designed for Bar Pushers/Barfeeders



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

3 Different Collet Types Available



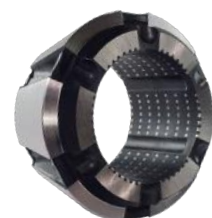
Spring Collets*

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



Varibore Collets**

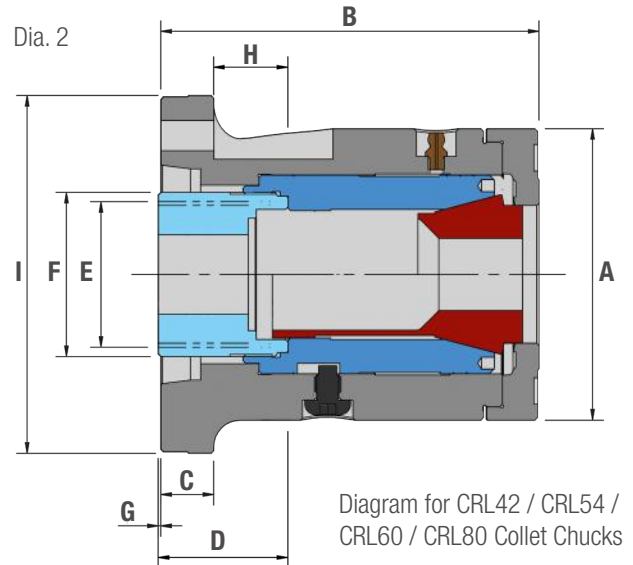
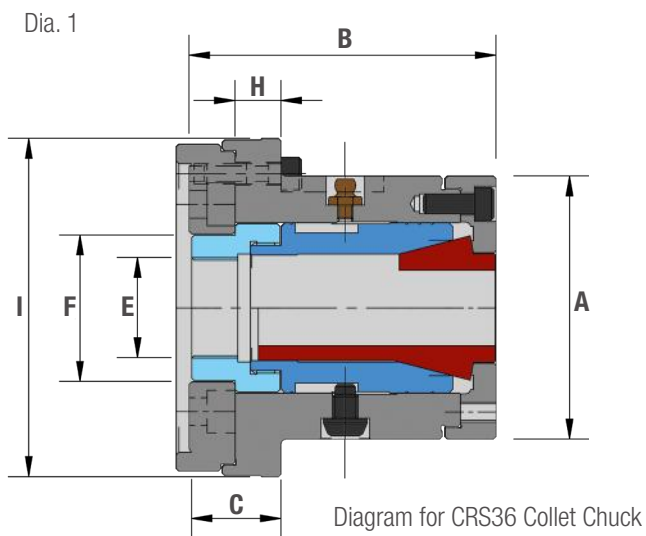
Ideal for first operation work as they have a 2-3mm gripping range enabling you to handle rough bar. Supplied either as smooth, serrated or super grip.



Rubberflex Collets***

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

Long Series Power Collet Chuck for Bar Machining



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

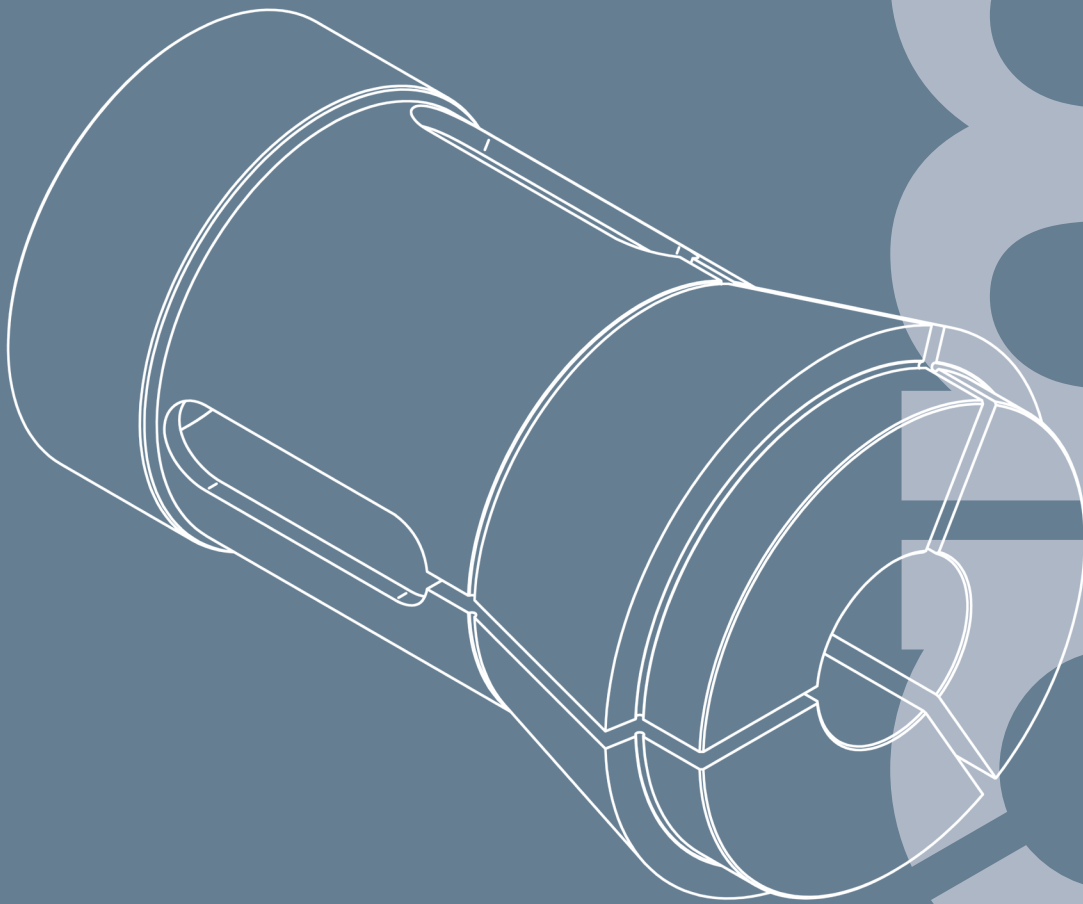
* See pages 14-18 for more Spring Collet information.

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

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

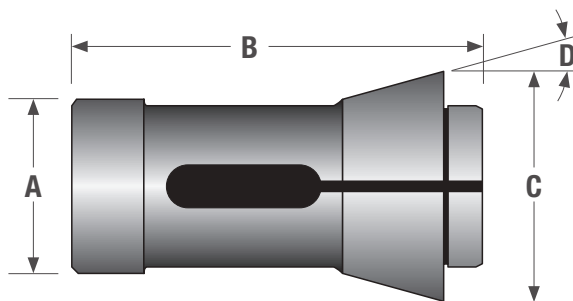
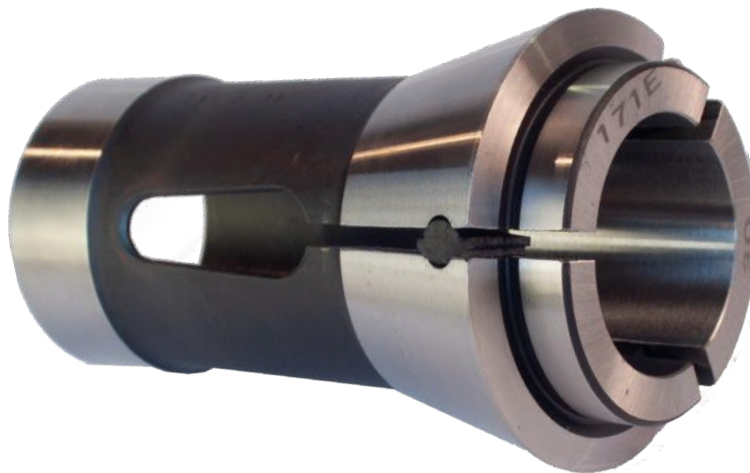
Spring Collets

to suit **QC & C Series**



Spring Collets
QC & C Series

Spring Collets for CRS36 Collet Chucks



D171E Spring Collets

- DIN 6343 Type: 8742
- Round standard shape only
- Specify which gripping surface you require Annular serrations or smooth
- 0.5mm sizes and other shapes available upon request

Dimensions (Metric)

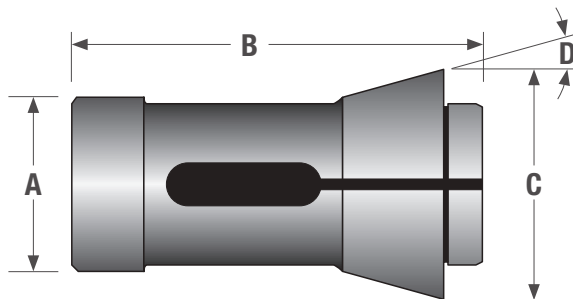
A	B	C	D
42	94	55	15°

Gripping Diameter	Round
2mm	D171E R02
3mm	D171E R03
4mm	D171E R04
5mm	D171E R05
6mm	D171E R06
7mm	D171E R07
8mm	D171E R08
9mm	D171E R09
10mm	D171E R10
11mm	D171E R11
12mm	D171E R12
13mm	D171E R13
14mm	D171E R14
15mm	D171E R15
16mm	D171E R16
17mm	D171E R17
18mm	D171E R18
19mm	D171E R19

Gripping Diameter	Round
20mm	D171E R20
21mm	D171E R21
22mm	D171E R22
23mm	D171E R23
24mm	D171E R24
25mm	D171E R25
26mm	D171E R26
27mm	D171E R27
28mm	D171E R28
29mm	D171E R29
30mm	D171E R30
31mm	D171E R31
32mm	D171E R32
33mm	D171E R33
34mm	D171E R34
35mm	D171E R35
36mm	D171E R36

Emergency Collet with soft face and pilot hole 3mm diameter is available – Part No. **D171E-EMERGENCY**

Spring Collets for CRL42 and QCRL42 Collet Chucks



D173E Spring Collets

- DIN 6343 Type: 4728 (Also known as B42)
- Round, Hexagon or Square
- Specify which gripping surface you require Annular serrations or smooth
- 0.5mm sizes and other shapes available upon request

Dimensions (Metric)

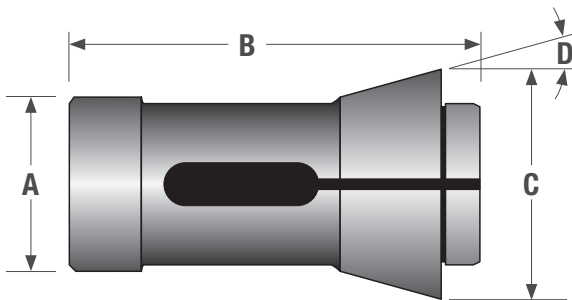
A	B	C	D
48	94	60	15°

Gripping Diameter	Round	Hexagon	Square
2mm	D173E R02	-	-
3mm	D173E R03	-	-
4mm	D173E R04	-	-
5mm	D173E R05	D173E X05	D173E S05
6mm	D173E R06	-	D173E S06
7mm	D173E R07	D173E X07	D173E S07
8mm	D173E R08	D173E X08	D173E S08
9mm	D173E R09	-	-
10mm	D173E R10	D173E X10	D173E S10
11mm	D173E R11	D173E X11	-
12mm	D173E R12	D173E X12	D173E S12
13mm	D173E R13	D173E X13	-
14mm	D173E R14	D173E X14	D173E S14
15mm	D173E R15	D173E X15	D173E S15
16mm	D173E R16	D173E X16	D173E S16
17mm	D173E R17	D173E X17	-
18mm	D173E R18	D173E X18	D173E S18
19mm	D173E R19	D173E X19	-
20mm	D173E R20	D173E X20	D173E S20
21mm	D173E R21	-	-
22mm	D173E R22	D173E X22	D173E S22

Gripping Diameter	Round	Hexagon	Square
23mm	D173E R23	-	-
24mm	D173E R24	D173E X24	-
25mm	D173E R25	D173E X25	D173E S25
26mm	D173E R26	D173E X26	-
27mm	D173E R27	D173E X27	-
28mm	D173E R28	-	D173E S28
29mm	D173E R29	-	-
30mm	D173E R30	D173E X30	-
31mm	D173E R31	-	-
32mm	D173E R32	D173E X32	-
33mm	D173E R33	-	-
34mm	D173E R34	-	-
35mm	D173E R35	D173E X35	-
36mm	D173E R36	D173E X36	-
37mm	D173E R37	-	-
38mm	D173E R38	-	-
39mm	D173E R39	-	-
40mm	D173E R40	-	-
41mm	D173E R41	-	-
42mm	D173E R42	-	-

Emergency Collet with soft face and pilot hole 3mm diameter is available – Part No. **D173E-EMERGENCY**

Spring collets for CRL60 and QCRL60 Collet Chucks



D185E Spring Collets

- DIN 6343 Type: 4291 (Also known as B60)
- Round, Hexagon or Square
- Specify which gripping surface you require Annular serrations or smooth
- 0.5mm sizes and other shapes available upon request

Dimensions (Metric)

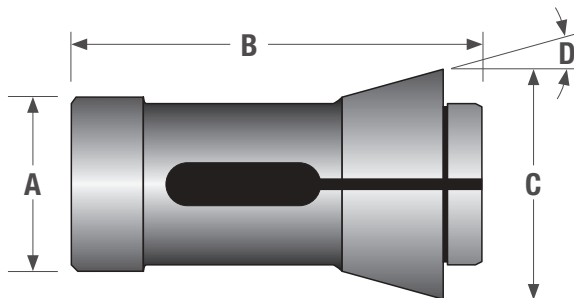
A	B	C	D
66	110	84	15°

Gripping Diameter	Round	Hexagon	Square
3mm	D185E R03	-	-
4mm	D185E R04	-	-
5mm	D185E R05	D185E X05	D185E S05
6mm	D185E R06	-	D185E S06
7mm	D185E R07	D185E X07	D185E S07
8mm	D185E R08	D185E X08	D185E S08
9mm	D185E R09	-	-
10mm	D185E R10	D185E X10	D185E S10
11mm	D185E R11	D185E X11	-
12mm	D185E R12	D185E X12	D185E S12
13mm	D185E R13	D185E X13	-
14mm	D185E R14	D185E X14	D185E S14
15mm	D185E R15	D185E X15	D185E S15
16mm	D185E R16	D185E X16	D185E S16
17mm	D185E R17	D185E X17	-
18mm	D185E R18	D185E X18	D185E S18
19mm	D185E R19	D185E X19	-
20mm	D185E R20	D185E X20	D185E S20
21mm	D185E R21	-	-
22mm	D185E R22	D185E X22	D185E S22
23mm	D185E R23	-	-
24mm	D185E R24	D185E X24	-
25mm	D185E R25	D185E X25	D185E S25
26mm	D185E R26	D185E X26	-
27mm	D185E R27	D185E X27	-
28mm	D185E R28	-	-
29mm	D185E R29	-	-
30mm	D185E R30	D185E X30	D185E S30
31mm	D185E R31	-	-

Gripping Diameter	Round	Hexagon	Square
32mm	D185E R32	D185E X32	D185E S32
33mm	D185E R33	-	-
34mm	D185E R34	-	-
35mm	D185E R35	D185E X35	D185E S35
36mm	D185E R36	D185E X36	D185E S36
37mm	D185E R37	-	-
38mm	D185E R38	-	-
39mm	D185E R39	-	-
40mm	D185E R40	-	D185E S40
41mm	D185E R41	D185E X41	-
42mm	D185E R42	-	-
43mm	D185E R43	-	-
44mm	D185E R44	-	-
45mm	D185E R45	-	-
46mm	D185E R46	-	-
47mm	D185E R47	-	-
48mm	D185E R48	-	-
49mm	D185E R49	-	-
50mm	D185E R50	D185E X50	-
51mm	D185E R51	-	-
52mm	D185E R52	-	-
53mm	D185E R53	-	-
54mm	D185E R54	-	-
55mm	D185E R55	-	-
56mm	D185E R56	-	-
57mm	D185E R57	-	-
58mm	D185E R58	-	-
59mm	D185E R59	-	-
60mm	D185E R60	-	-

Emergency Collet with soft face and pilot hole 4mm diameter is available - Part No. **D185E-EMERGENCY**

Spring Collets for CRL54 and QCRL54 Collet Chucks



D853 Spring Collets

- Type: 1503
- Round standard shape only
- Specify which gripping surface you require Annular serrations or smooth
- 0.5mm sizes and other shapes available upon request

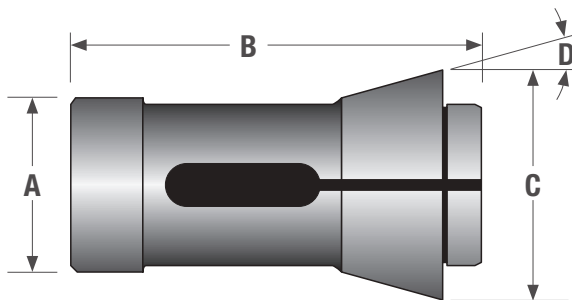
Dimensions (Metric)

A	B	C	D
60.28	125.4	88.1	15° 15'

Gripping Diameter	Round	Gripping Diameter	Round
2mm	D853E R02	29mm	D853E R29
3mm	D853E R03	30mm	D853E R30
4mm	D853E R04	31mm	D853E R31
5mm	D853E R05	32mm	D853E R32
6mm	D853E R06	33mm	D853E R33
7mm	D853E R07	34mm	D853E R34
8mm	D853E R08	35mm	D853E R35
9mm	D853E R09	36mm	D853E R36
10mm	D853E R10	37mm	D853E R37
11mm	D853E R11	38mm	D853E R38
12mm	D853E R12	39mm	D853E R39
13mm	D853E R13	40mm	D853E R40
14mm	D853E R14	41mm	D853E R41
15mm	D853E R15	42mm	D853E R42
16mm	D853E R16	43mm	D853E R43
17mm	D853E R17	44mm	D853E R44
18mm	D853E R18	45mm	D853E R45
19mm	D853E R19	46mm	D853E R46
20mm	D853E R20	47mm	D853E R47
21mm	D853E R21	48mm	D853E R48
22mm	D853E R22	49mm	D853E R49
23mm	D853E R23	50mm	D853E R50
24mm	D853E R24	51mm	D853E R51
25mm	D853E R25	52mm	D853E R52
26mm	D853E R26	53mm	D853E R53
27mm	D853E R27	54mm	D853E R54
28mm	D853E R28		

Emergency Collet with soft face and pilot hole 6mm dia. is available - Part No. **D853-EMERGENCY**

Spring Collets for CRL80 and QCRL80 Collet Chucks



D193E Spring Collets

- DIN 6343 Type: H-47
- Round standard shape only
- Specify which gripping surface you require – Annular Serrations or Smooth
- 0.5mm sizes and other shapes available upon request

Dimensions (Metric)

A	B	C	D
90	130	107	15°

Gripping Diameter	Round
12mm	D193E R12
13mm	D193E R13
14mm	D193E R14
15mm	D193E R15
16mm	D193E R16
17mm	D193E R17
18mm	D193E R18
19mm	D193E R19
20mm	D193E R20
21mm	D193E R21
22mm	D193E R22
23mm	D193E R23
24mm	D193E R24
25mm	D193E R25
26mm	D193E R26
27mm	D193E R27
28mm	D193E R28
29mm	D193E R29
30mm	D193E R30
31mm	D193E R31
32mm	D193E R32
33mm	D193E R33
34mm	D193E R34
35mm	D193E R35
36mm	D193E R36
37mm	D193E R37
38mm	D193E R38
39mm	D193E R39
40mm	D193E R40
41mm	D193E R41
42mm	D193E R42
43mm	D193E R43
44mm	D193E R44
45mm	D193E R45
46mm	D193E R46

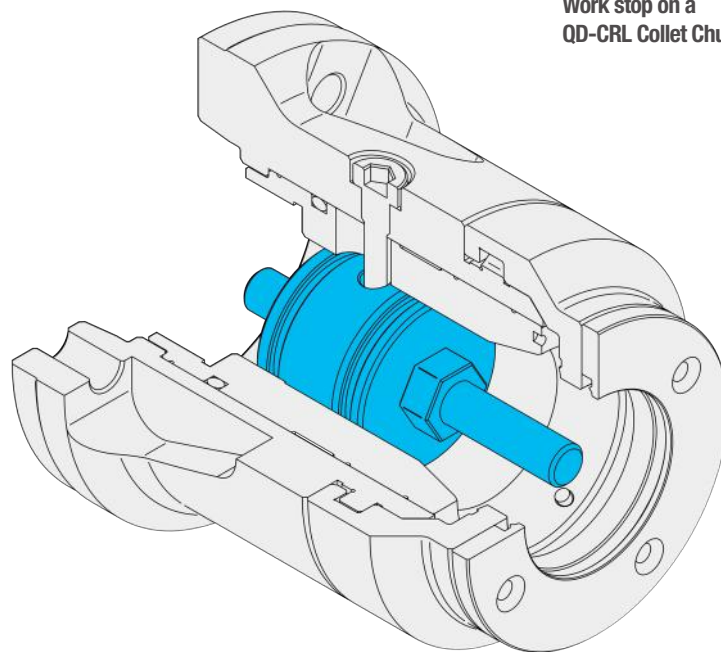
Gripping Diameter	Round
47mm	D193E R47
48mm	D193E R48
49mm	D193E R49
50mm	D193E R50
51mm	D193E R51
52mm	D193E R52
53mm	D193E R53
54mm	D193E R54
55mm	D193E R55
56mm	D193E R56
57mm	D193E R57
58mm	D193E R58
59mm	D193E R59
60mm	D193E R60
61mm	D193E R61
62mm	D193E R62
63mm	D193E R63
64mm	D193E R64
65mm	D193E R65
66mm	D193E R66
67mm	D193E R67
68mm	D193E R68
69mm	D193E R69
70mm	D193E R70
71mm	D193E R71
72mm	D193E R72
73mm	D193E R73
74mm	D193E R74
75mm	D193E R75
76mm	D193E R76
77mm	D193E R77
78mm	D193E R78
79mm	D193E R79
80mm	D193E R80

Emergency Collet with soft face and pilot hole 10mm dia. is available - Part No. **D193E-EMERGENCY**

QC & C Series Standard Accessories

Work Stops

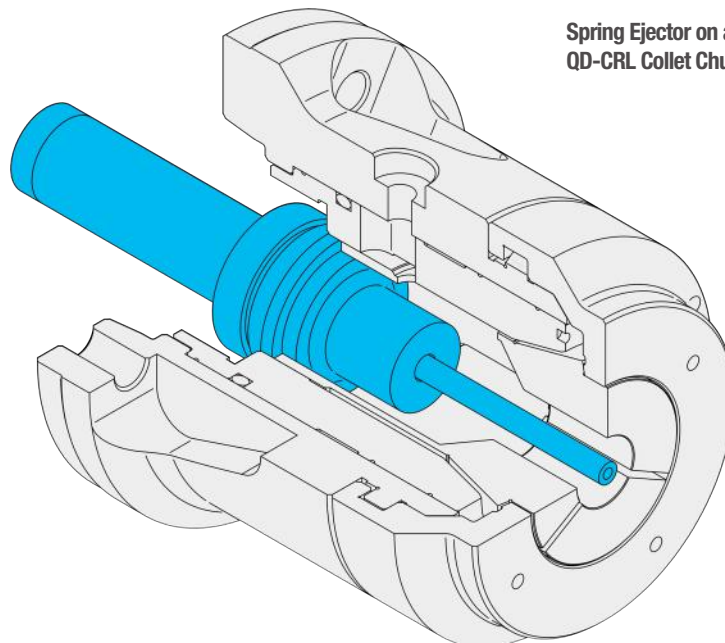
- Stops can be provided to allow for accurate z-axis positioning of short workpieces within the collet chuck.
- A threaded stud is provided for easy adjustment to suit your work piece
- All stops are easily installed from the front face utilising a side bolt to hold the stop securely in place.
- These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



Work stop on a
QD-CRL Collet Chuck

Spring Ejectors

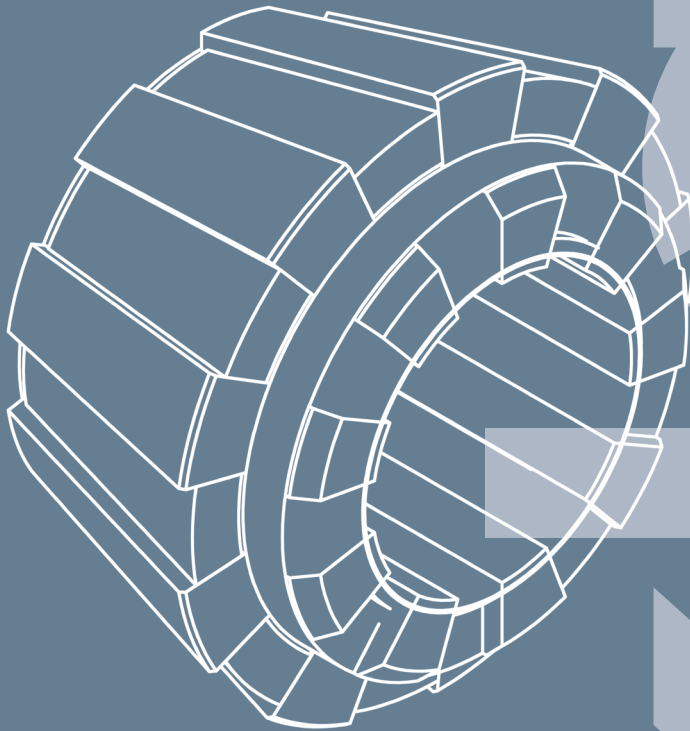
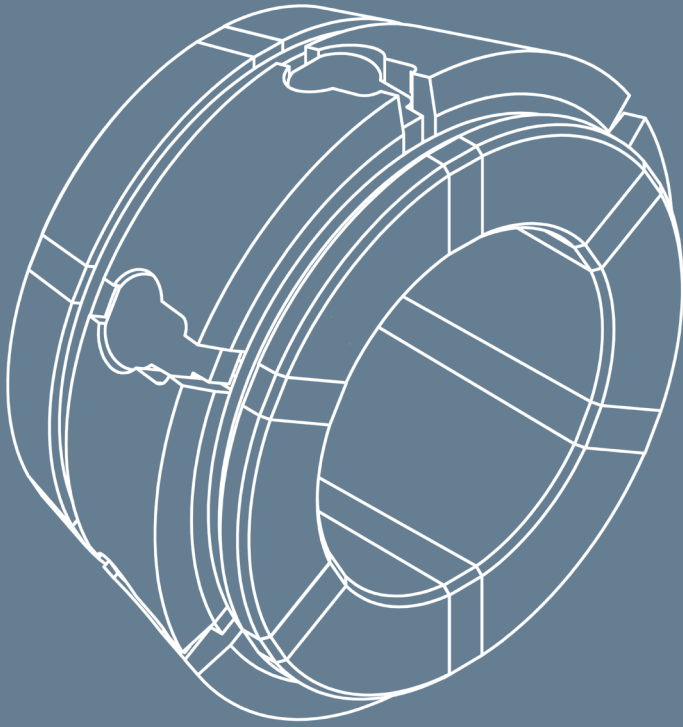
- Standard spring ejectors for QC & C series are used for second-spindle operations to expel finished workpieces into the parts catcher.
- Many variants of spring ejector are available to suit your production process.
- Spring ejectors can be installed on all QC & C series collet chucks.
- Full length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



Spring Ejector on a
QD-CRL Collet Chuck

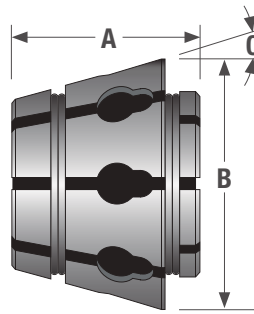
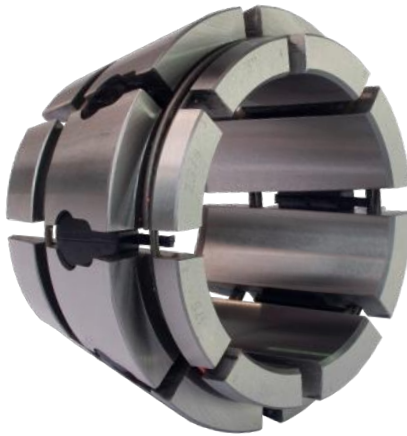
Varibore Collets

to suit **QC & C Series**



Varibore Collets
QC & C Series

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



Varibore Collets

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

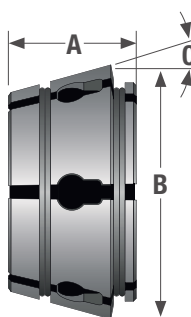
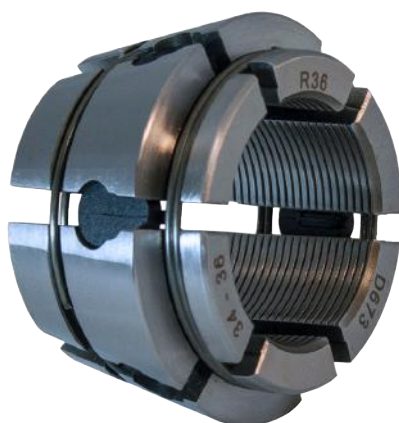
Dimensions (Metric)

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

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

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

Varibore Collets for CRS36, CRL42, QCRL42, CRL60, QCRL60, CRL80 & QCRL80 Collet Chucks



Varibore Collets - Type: DIN 6343

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

Dimensions (Metric)

Part No.	A	B	C
D671	38	56.5	14.75°
D673	39	61.5	14.75°
D677	45	85.5	14.75°
D660	48	108.5	14.75°

Gripping Range	D671 DIN for CRS36			D673 DIN for CRL42 & QCRL42			D677 DIN for CRL60 & QCRL60			D660 DIN for CRL80 & QCRL80	
mm	Round	Hexagon	Square	Round	Hexagon	Square	Round	Hexagon	Square	Round	Hexagon
4 - 6	D671-R06	D671-X06	D671-S06	D673-R06	D673-X06	D673-S06	-	-	-	-	-
6 - 8	D671-R08	D671-X08	D671-S08	D673-R08	D673-X08	D673-S08	D677-R08	D677-X08	D677-S08	-	-
8 - 10	D671-R10	D671-X10	D671-S10	D673-R10	D673-X10	D673-S10	D677-R10	D677-X10	D677-S10	-	-
10 - 12	D671-R12	D671-X12	D671-S12	D673-R12	D673-X12	D673-S12	D677-R12	D677-X12	D677-S12	-	-
12 - 14	D671-R14	D671-X14	D671-S14	D673-R14	D673-X14	D673-S14	D677-R14	D677-X14	D677-S14	D660-R14	D660-X14
14 - 16	D671-R16	D671-X16	D671-S16	D673-R16	D673-X16	D673-S16	D677-R16	D677-X16	D677-S16	D660-R16	D660-X16
16 - 18	D671-R18	D671-X18	D671-S18	D673-R18	D673-X18	D673-S18	D677-R18	D677-X18	D677-S18	D660-R18	D660-X18
18 - 20	D671-R20	D671-X20	D671-S20	D673-R20	D673-X20	D673-S20	D677-R20	D677-X20	D677-S20	D660-R20	D660-X20
20 - 22	D671-R22	D671-X22	D671-S22	D673-R22	D673-X22	D673-S22	D677-R22	D677-X22	D677-S22	D660-R22	D660-X22
22 - 24	D671-R24	D671-X24	D671-S24	D673-R24	D673-X24	D673-S24	D677-R24	D677-X24	D677-S24	D660-R24	D660-X24
24 - 26	D671-R26	D671-X26	-	D673-R26	D673-X26	D673-S26	D677-R26	D677-X26	D677-S26	D660-R26	D660-X26
26 - 28	D671-R28	D671-X28	-	D673-R28	D673-X28	D673-S28	D677-R28	D677-X28	D677-S28	D660-R28	D660-X28
28 - 30	D671-R30	-	-	D673-R30	D673-X30	D673-S30	D677-R30	D677-X30	D677-S30	D660-R30	D660-X30
30 - 32	D671-R32	-	-	D673-R32	D673-X32	-	D677-R32	D677-X32	D677-S32	D660-R32	D660-X32
32 - 34	D671-R34	-	-	D673-R34	D673-X34	-	D677-R34	D677-X34	D677-S34	D660-R34	D660-X34
34 - 36	D671-R36	-	-	D673-R36	D673-X36	-	D677-R36	D677-X36	D677-S36	D660-R36	D660-X36
36 - 38	-	-	-	D673-R38	-	-	D677-R38	D677-X38	D677-S38	D660-R38	D660-X38
38 - 40	-	-	-	D673-R40	-	-	D677-R40	D677-X40	D677-S40	D660-R40	D660-X40
40 - 42	-	-	-	D673-R42	-	-	D677-R42	D677-X42	D677-S42	D660-R42	D660-X42
42 - 44	-	-	-	-	-	-	D677-R44	D677-X44	-	D660-R44	D660-X44
44 - 46	-	-	-	-	-	-	D677-R46	D677-X46	-	D660-R46	D660-X46
46 - 48	-	-	-	-	-	-	D677-R48	D677-X48	-	D660-R48	D660-X48
48 - 50	-	-	-	-	-	-	D677-R50	D677-X50	-	D660-R50	D660-X50
50 - 52	-	-	-	-	-	-	D677-R52	D677-X52	-	D660-R52	D660-X52
52 - 54	-	-	-	-	-	-	D677-R54	-	-	D660-R54	D660-X54
54 - 56	-	-	-	-	-	-	D677-R56	-	-	D660-R56	D660-X56
56 - 58	-	-	-	-	-	-	D677-R58	-	-	D660-R58	D660-X58
58 - 60	-	-	-	-	-	-	D677-R60	-	-	D660-R60	D660-X60
60 - 62	-	-	-	-	-	-	-	-	-	D660-R62	D660-X62
62 - 64	-	-	-	-	-	-	-	-	-	D660-R64	D660-X64
64 - 66	-	-	-	-	-	-	-	-	-	D660-R66	D660-X66
66 - 68	-	-	-	-	-	-	-	-	-	D660-R68	D660-X68
68 - 70	-	-	-	-	-	-	-	-	-	D660-R70	-
70 - 72	-	-	-	-	-	-	-	-	-	D660-R72	-
72 - 74	-	-	-	-	-	-	-	-	-	D660-R74	-
74 - 76	-	-	-	-	-	-	-	-	-	D660-R76	-
76 - 78	-	-	-	-	-	-	-	-	-	D660-R78	-
78 - 80	-	-	-	-	-	-	-	-	-	D660-R80	-

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

Rubber-Flex Collets

Five spring collets into one Rubber-Flex collet

With same accuracy specification as standard spring collets, the Elastic rubber-metal vulcanization allows a clamping range of ± 1 mm to the nominal diameter. This reduces the need for numerous changeovers when

clamping different diameters, saving your time. Instead of purchasing four additional spring collets to cover the same diameter range you can save up to 50% in investment costs with one Rubber-Flex collet.



Versatile

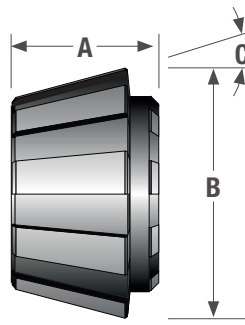
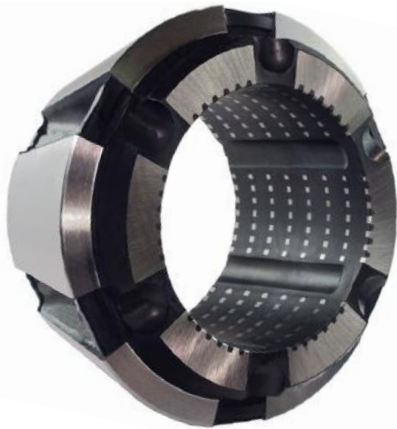
Rubber-Flex collets, type DRFC 673 (173E equivalent) and DRFC 677 (185E equivalent) are available in "Smooth" or "Full Grip" design. "Smooth" collets are ideal for 2nd Operation work or sensitive workpieces with surfaces that should not be marked. "Full Grip" collets have wider steel segments provide a higher rigidity. These double-serrated collets have an increased clamping force and are especially designed to machine bar material with wide clamping tolerances and high torque.

Due to the unique design Rubber-Flex collets also increase the diameters that your collet chuck can clamp. For example, a Q-CRL42 collet chuck can clamp up to 45mm from the standard 42mm and for a Q-CRL60 collet chuck can clamp up to 65mm from the standard 60mm using Rubber-Flex.

- Perfect sealing against coolant and swarf
- More surface area = higher torque transfer
- Coolant and temperature resistant up to 100° C
- Gentle surface clamping with parallel closing of steel segments



Rubber-Flex Collets for CRL42, QCRL42, CRS60, CRL60, QCRL60 Collet Chucks



Rubberflex Collets – Type: DIN 6343

- Round, Hexagon or Square
- Specify which gripping surface you require – Full Grip or Smooth
- Smooth Type – **DRFCXXX-RXX**
- Full Grip Type – **DRFCXXX-RXX/R**

Dimensions (Metric)

Part No.	A	B	C
DRFC673	39	61.5	14.75°
DRFC677	45	85.5	14.75°

Gripping Range	DRFC673 DIN for CRL42 & QCRL42	DRFC677 DIN for CRS60, CRL60 & QCRL60
mm	Round	Round
7 - 9	DRFC673-R09	-
9 - 11	DRFC673-R11	-
11 - 13	DRFC673-R13*	-
13 - 15	DRFC673-R15*	-
15 - 17	DRFC673-R17*	-
17 - 19	DRFC673-R19*	-
19 - 21	DRFC673-R21*	DRFC677-R21*
21 - 23	DRFC673-R23*	DRFC677-R23*
23 - 25	DRFC673-R25*	DRFC677-R25*
25 - 27	DRFC673-R27*	DRFC677-R27*
27 - 29	DRFC673-R29*	DRFC677-R29*
29 - 31	DRFC673-R31*	DRFC677-R31*
31 - 33	DRFC673-R33*	DRFC677-R33*
33 - 35	DRFC673-R35*	DRFC677-R35*
35 - 37	DRFC673-R37*	DRFC677-R37*
37 - 39	DRFC673-R39*	DRFC677-R39*
39 - 41	DRFC673-R41*	DRFC677-R41*
41 - 43	DRFC673-R43*	DRFC677-R43*
43 - 45	DRFC673-R45	DRFC677-R45*
45 - 47	-	DRFC677-R47*
47 - 49	-	DRFC677-R49*
49 - 51	-	DRFC677-R51*
51 - 53	-	DRFC677-R53*
53 - 55	-	DRFC677-R55*
55 - 57	-	DRFC677-R57*
57 - 59	-	DRFC677-R59*
59 - 61	-	DRFC677-R61*
61 - 63	-	DRFC677-R63
63 - 65	-	DRFC677-R65

*Available as full grip & smooth specification, otherwise can only be supplied in smooth specification

Data required to manufacture drawtube actuator

Check which model is required

Fig. 1

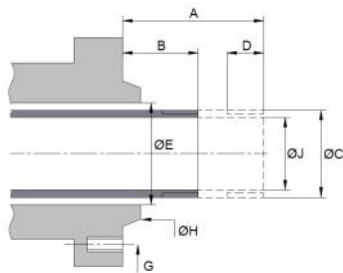

☐

Fig. 2

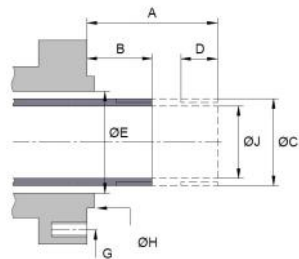

☐

Fig. 3

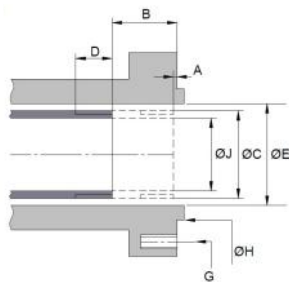
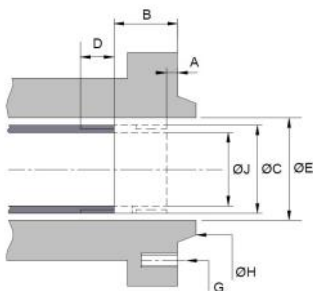

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Fig. 4


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A) Forward position of (drawtube from spindle face)

B) Backward position of (drawtube from spindle face)

C) Thread diameter form and pitch

State if RH or LH and external or internal

D) Operative length of full thread

E) Spindle bore diameter

State if taper

G) Fixing details. Thread size =

PCD = _____ QTY = _____

Spacing = _____

J) Drawtube internal diameter

American spindle mount

State type

Straight spindle mount

State diameter

Drawtube Connector / Machine Spindle Information

Machine Make:

Model:

Year:

Chuck Make:

Model:

Serial Number:

Cylinder Make:

Model:

Serial Number:

Contact Name:

Position:

Company Name:

Address:

Postal Code/ZIP:

Country:

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Email:

Website:

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