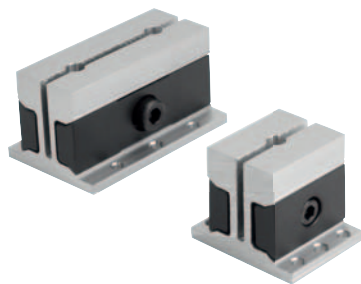


Machinable collets, square


Material:

Body EN AC-51400.

Wedges high-carbon steel.

Version:

Body natural colour anodised.

Wedges black oxidised.

Sample order:

nlm 03163-32040

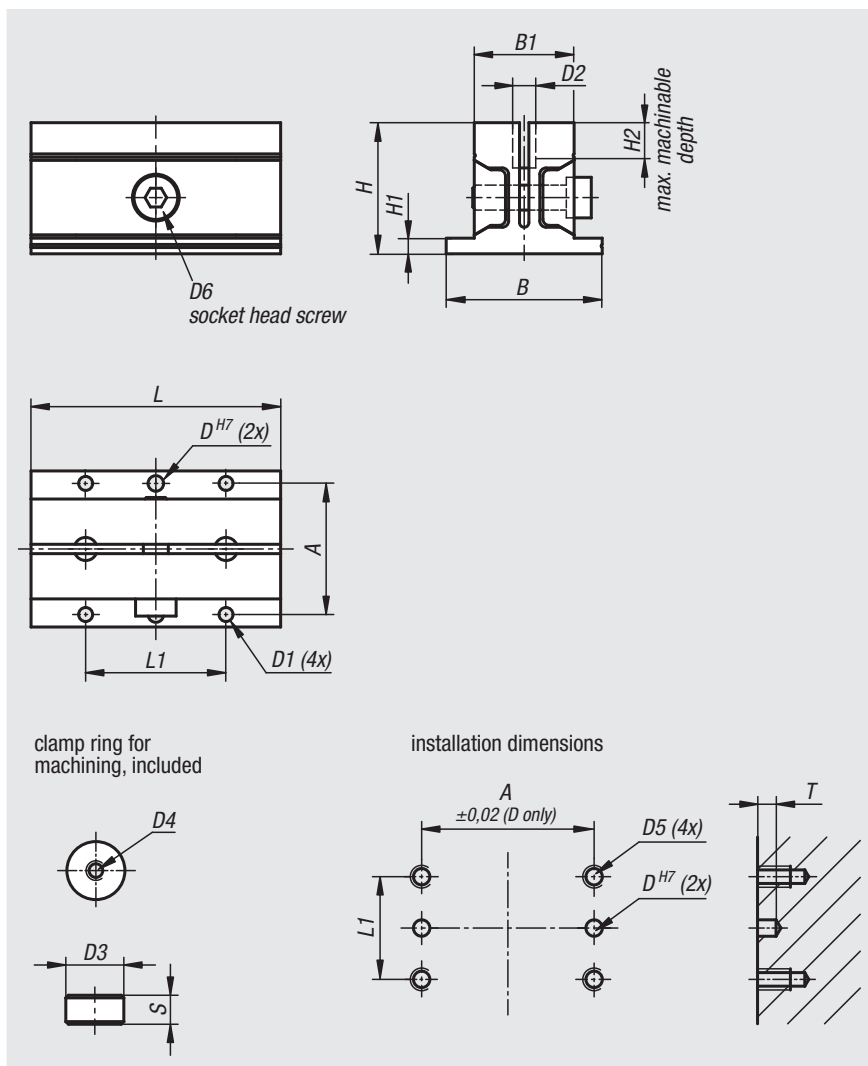
Note:

The lateral clamping screw tightens the jaws and clamps the workpiece on the circumference.

The simple and compact design allows 2 workpieces to be clamped.

The clamping travel is max. 0.5 mm.

The jaws must be pre-tensioned before machining the contour, the supplied clamping ring is used for this purpose.



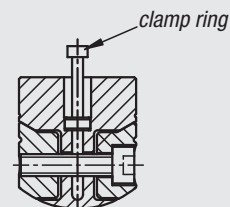
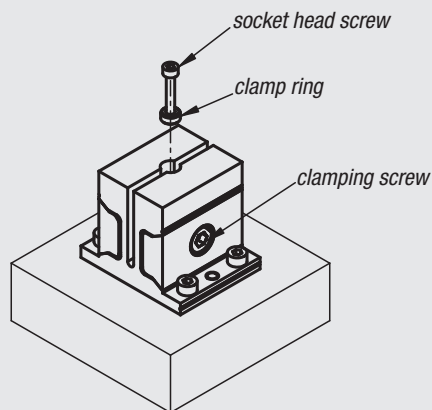
Order No.	A	B	B1	D	D1	D2	D3	D4	D5	D6	H	H1	H2	L	L1	S	T	Clamping force N	Tightening torque Nm
03163-32040	42	50	32	5	4,5	7,4	7	M3x0,5	M4x0,7	M6	42	5	10	40	25	3,5	5	2500	7,5
03163-32080	42	50	32	5	4,5	7,7	7	M3x0,5	M4x0,7	M8	42	5	10	80	45	3,5	5	2500	14
03163-50050	62	72	50	6	5,5	11,4	11	M3x0,5	M5x0,8	M10	63	7	15	50	30	5,5	8	5500	26
03163-50100	62	72	50	6	5,5	11,4	11	M3x0,5	M5x0,8	M12	63	7	15	100	58	5,5	8	5500	46

Machinable collets, square

Machining the jaws:

1. Inserting the clamp ring:

Insert the clamp ring into the bore in the centre of and between the jaws.
Tighten the clamp screw to hold the clamp ring in place.
(Use a cap screw to aid inserting the clamp ring)

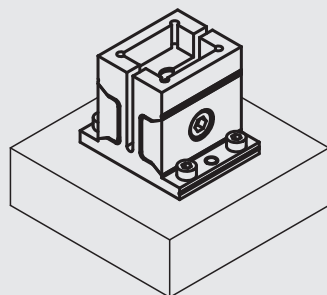


Note:

The clamp ring must be placed at the bottom of the bore.

2. Machine the jaws:

Remove the cap screw from the clamp ring.
Machine the contour of the workpiece to be held into the jaws.

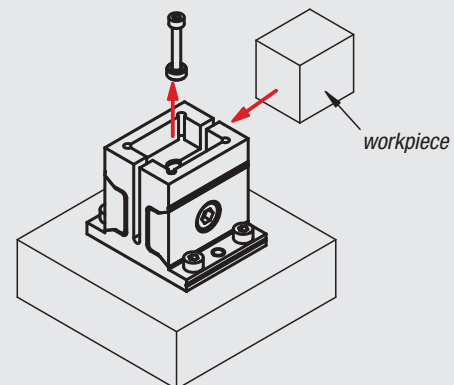


Note:

The contour should not be deeper than the max. permitted depth.

3. Mounting the workpiece:

Loosen the clamp screw and remove the clamp ring.
Place the workpiece into the contour and tighten the clamp screw.



Applications

