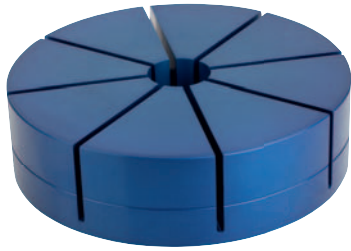


Collet

for external clamping



Material:

High-strength aluminium alloy

Version:

blue anodised.

Sample order:

nIm 03168-1065

Note:

Collets for clamping external contours.

The contour of the workpiece to be held is inserted into the collet. Free-form and asymmetrical contours can be held.

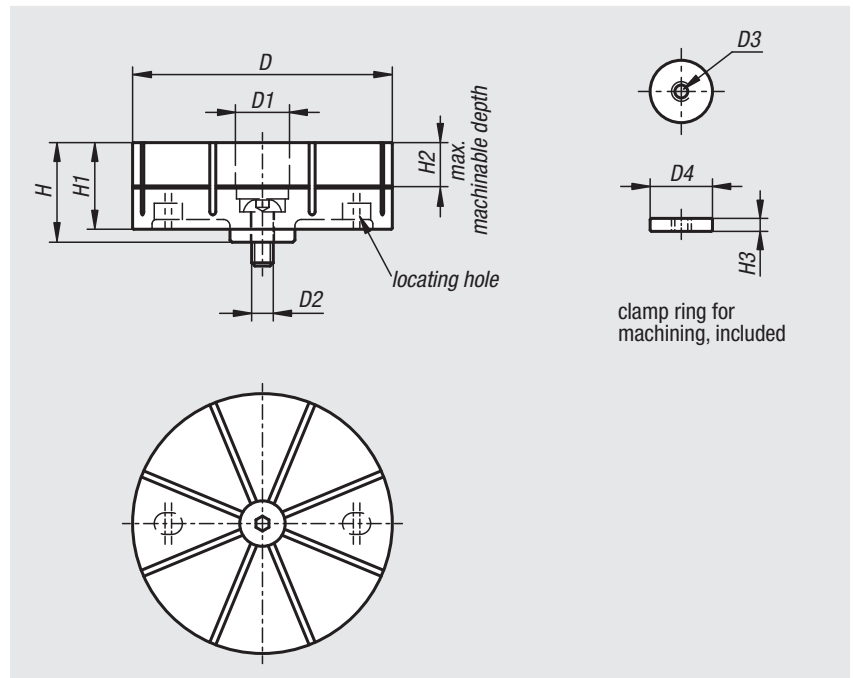
The collet mechanism enables a secure clamping of the workpiece.

Clamping travel per collet segment (8x) max. 0.15 mm.

Workpiece repeat accuracy: ± 0.03 .

Collet repeat accuracy: ± 0.02 .

Matching adaptor 03167.



Order No.	D	D1	D2	D3	D4	H	H1	H2	H3
03168-1065	65	21	M8	M5	20	29	25	10	4
03168-1090	90	25	M10	M6	24	40	35	15	5
03168-1120	120	25	M10	M6	24	46	40	20	5
03168-1160	160	29	M12	M8	28	52	45	25	6

Collet

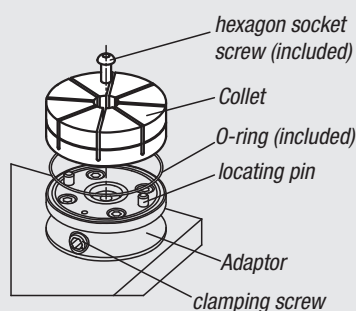
for external clamping

1. Mounting collet:

- Insert an O-ring into the groove on the top face of the clamp base.
- Set a collet on the base making sure the locating pins fit into the locating holes on the underside of the collet. Secure the collet using a buttonhead hex socket screw.

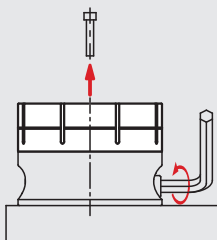
Note:

Before mounting the collet, ensure the cam cylinder is fully loosened by turning the tightening screw clockwise until it stops.



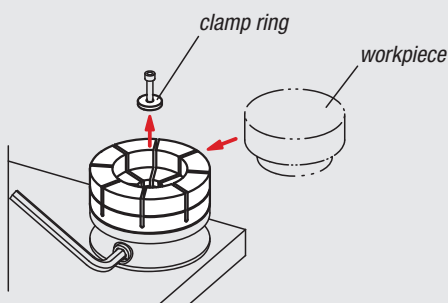
2.2

Tighten the cam cylinder to clamp the clamp ring (recommended torque: 15Nm).
Remove the screw from the clamp ring before machining.



3. Mounting workpiece:

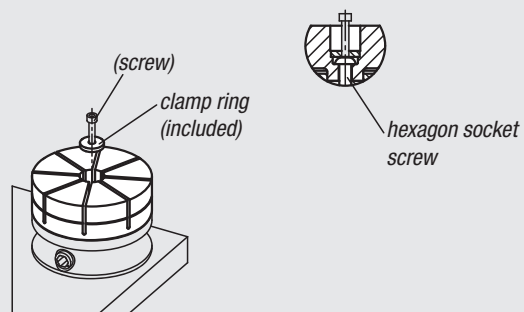
- Loosen the cam cylinder and remove the clamp ring.
- Place the workpiece in the contour and re-tighten the cam cylinder.



2. Machining collet:

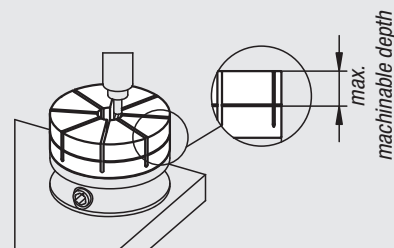
2.1

Place the clamp ring in the centre of the collet.
(Use a screw as an insertion aid)



2.3

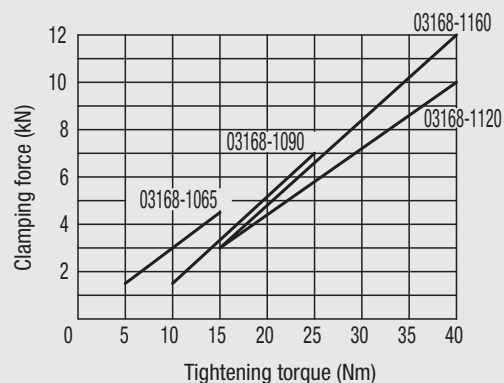
Machine the contour of the part that is to be held into the collet.



Note:

Do not machine the contour deeper than the permitted depth.

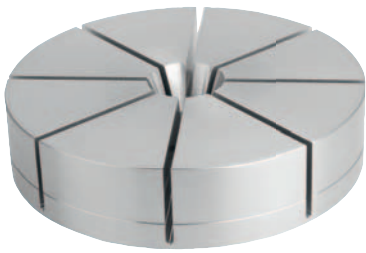
Performance curve



To avoid damaging the collet do not tighten the clamp without a workpiece or clamp ring.
Observe the maximum tightening torque in the table.

Collet

for internal clamping



Material:

High-strength aluminium alloy

Version:

natural tone anodised

Sample order:

nIm 03168-2065

Note:

Collets for clamping internal contours.

The contour of the workpiece to be held is inserted into the collet. Free-form and asymmetrical contours can be held.

The collet mechanism enables a secure clamping of the workpiece.

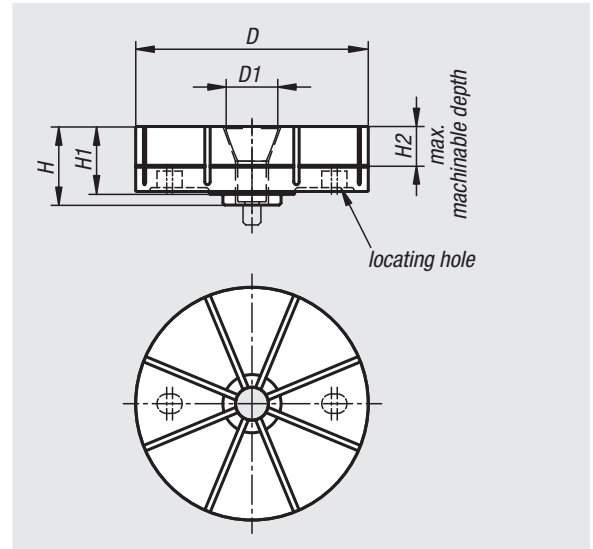
Clamping travel per collet segment (8x) max. 0.15 mm.

Workpiece repeat accuracy: ± 0.03 .

Collet repeat accuracy: ± 0.02 .

The traction cone 03169 is required when using the collet for internal clamping.

Matching adaptor 03167.



Order No.	D	D1	H	H1	H2
03168-2065	65	22,5	28,5	25	10
03168-2090	90	27	34,5	30	15
03168-2120	120	29	40,5	35	20
03168-2160	160	33	46,5	40	25

Collet

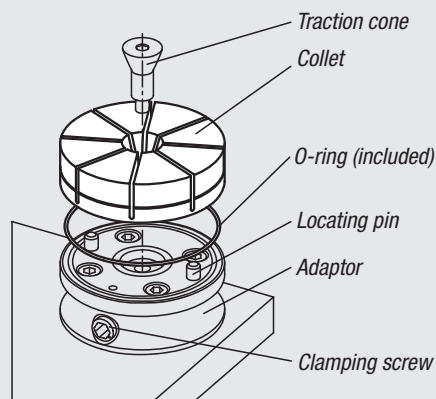
for internal clamping

1. Mounting collet:

- Insert an O-ring into the groove on the top face of the clamp base.
- Set a collet on the base making sure the locating pins fit into the locating holes on the underside of the collet.
- Secure the collet using a tapered screw.

Note:

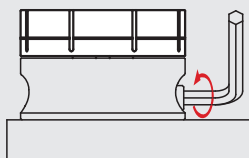
Before mounting the collet, ensure the cam cylinder is fully loosened by turning the tightening screw clockwise until it stops.



2. Machining collet:

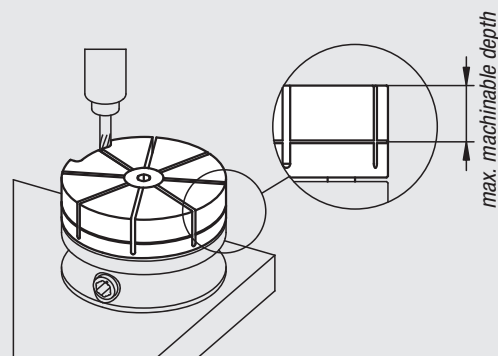
2.1

Fully loosen the cam cylinder and measure the OD of the collet. Tighten the cam cylinder until the collet OD has expanded by 0.15 mm.



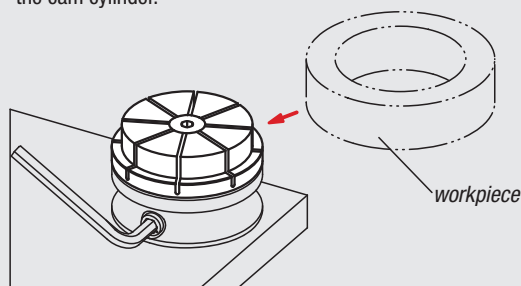
2.2

Machine the contour of the part that is to be held into the collet.

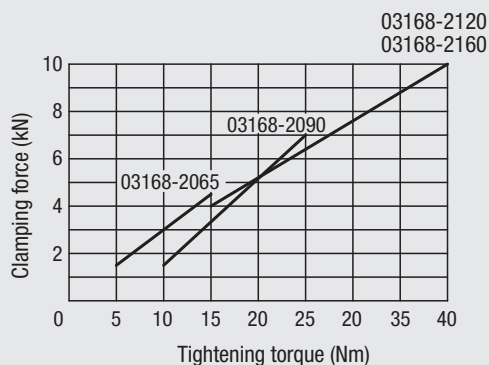


3. Mounting workpiece:

- Loosen the cam cylinder and remove the clamp ring.
- Place the workpiece in the contour and re-tighten the cam cylinder.



Performance curve



To avoid damaging the collet do not tighten the clamp without a workpiece or clamp ring. Observe the maximum tightening torque in the table.