

Collets

for internal clamping

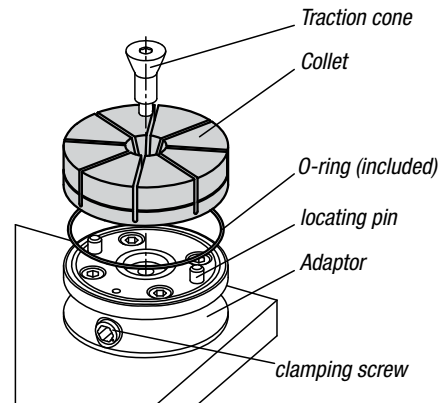


1. Mounting collet:

- 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 the tapered screw.

Note:

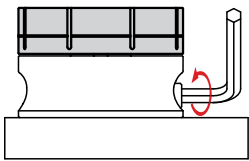
Before mounting the collet, ensure the cam cylinder is fully loosened by turning the tightening screw clockwise until it stops.



2. Machining collet:

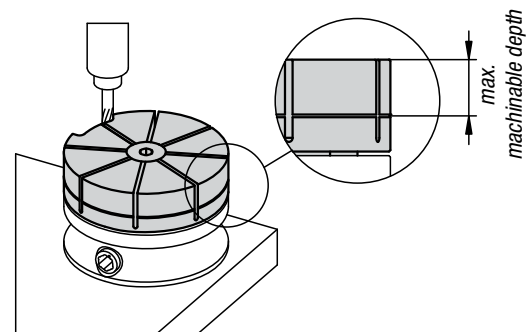
2.1

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.



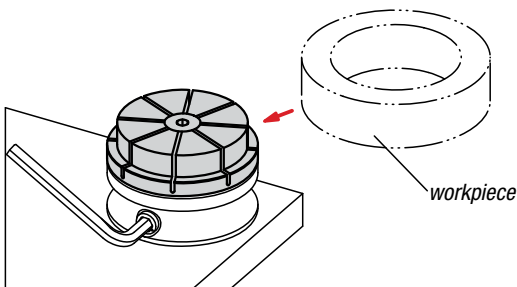
2.3

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

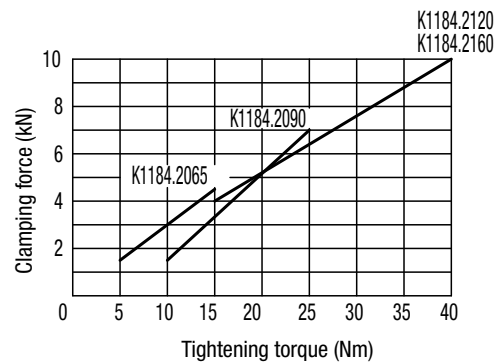


3. Mounting the workpiece:

- 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.