

COLLET FOR INSIDE AND OUTSIDE CLAMPING





No. 6375M

Mechanical collet - base element

Base element made of tempered steel, plasma-nitrided and burnished.

Order no.	Size	Clamping stroke \varnothing [mm]	Tightening torque Md max. [Nm]	SW	dia. D	H	Weight [g]
567121	10	0,3	30	10	81	40	1259
567122	20	0,3	40	13	117	56	3633

Design:

The mechanism of the body is protected against dirt and cooling water. Surrounding clamping rim for fastening onto the machine table and flat surfaces for seating in the machine vice. Provided on the underside is the holder for the AMF zero-point system size 10 and size 20 as well as grooves for positioning on AMF zero-point clamping modules for indexing. The base element is used for seating the collet attachments for inside and outside clamping.

Advantage:

- The lateral actuation makes it possible to clamp workpieces with blind holes and through-holes
- Control display clamped/released by means of dowel pin on the base element
- Flexibility through a base element for outside or inside clamping

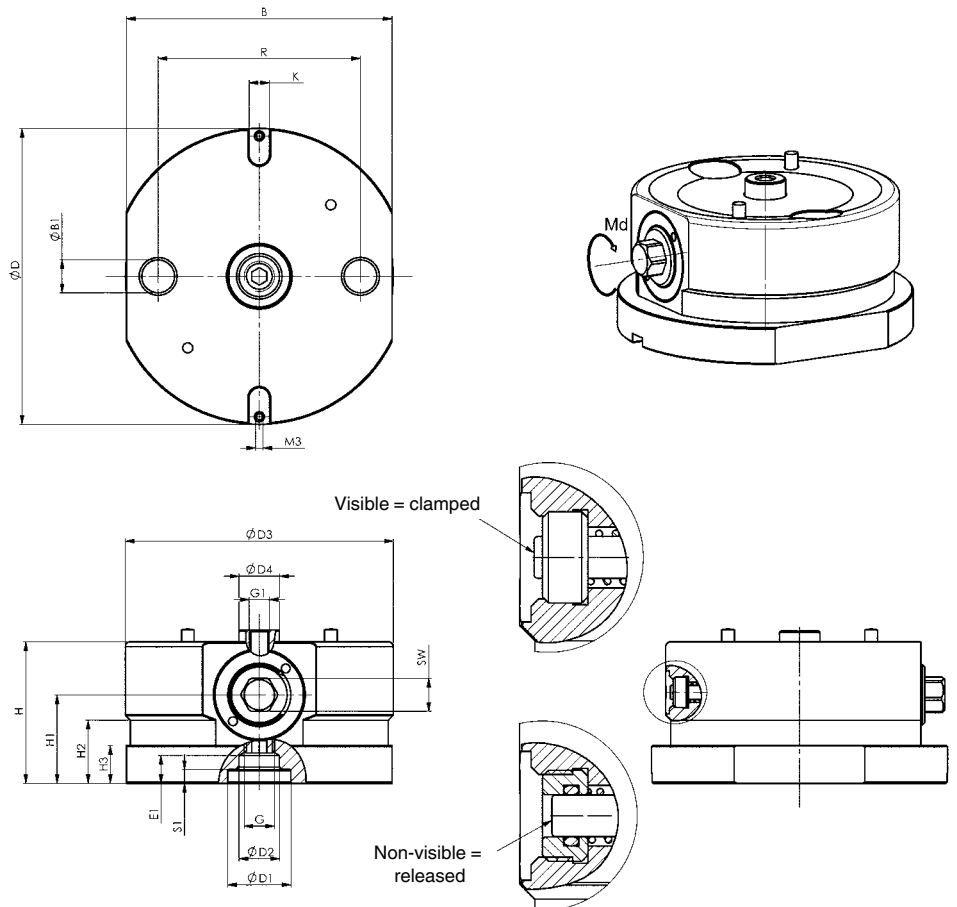
Note:

The collet attachments 6375ZA and 6375ZI must be fastened using the fastening kits 6375BA (outside clamping) or 6375BI (inside clamping).



Dimensions:

Order no.	Size	B	B1	dia. D1	dia. D2	dia. D3	dia. D4	E1	G	G1	H1	H2	H3	K	R	S1
567121	10	72	8,4	15	-	74	11	4,5	M8	M6	26	18	12	8	50	-
567122	20	105	13,0	25	16	106	16	11	M12	M8	35	25	15	8	80	5,5



No. 6375ZA

Collet attachment outside clamping

Collet attachment made of high-strength aluminium, hard anodised or polyamide.

With locking bolt made of tempered steel, burnished.

Order no.	Size	dia. D	dia. D1	dia. D2	H	H1	H2	Material	Clamping stroke \varnothing [mm]	Weight [g]
567123	10	70	61	17,7	30	15	6	EN AW 7075	0,3	274
567124	20	99	90	23,0	50	25	10	EN AW 7075	0,3	935
550278	20	99	90	23,0	50	25	10	Polyamid	1,0	360

Design:

Collet attachments are always supplied with locking bolt.

Application:

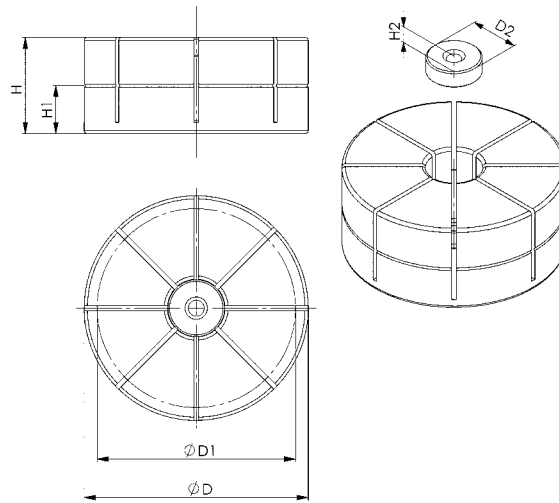
The collet attachment is fastened using fastening kit 6375BA (observe torque specifications) on the base element 6375M. To secure the workpiece contour, the collet attachment must be clamped with the locking bolt. Then the workpiece contour is milled into the collet attachment with a minimum clamping depth of 2 mm. Then the locking bolt is removed, and the workpiece can be clamped. The collet attachment can be milled off to a height of H1, allowing new workpiece contours to be introduced. The maximum workpiece diameter is specified in the table with D1.

Advantage:

- Clamping of delicate and thin-walled workpieces
- Free-form clamping
- The workpiece is clamped without distortion due to the radially even clamping force imposed on it
- Multiple insertion of different workpiece contours possible

Note:

The collet attachment must always be clamped with the workpiece or locking bolt. To remove the vertical play between the collet attachment and base element, light pretensioning must be applied by actuating the clamping stud after the workpiece is inserted.



No. 6375ZA

Collet attachment outside clamping

Collet attachment made of high-strength aluminium, hard anodised or polyamide.

With locking bolt made of tempered steel, burnished.

Order no.	Size	dia. D	dia. D1	dia. D2	H	H1	H2	H3	Material	Clamping stroke Ø [mm]	Weight [g]
428656	20	149	140	23	50	25	10	10	EN AW 7075	0,3	880

Design:

Collet attachments are always supplied with locking bolt.

Application:

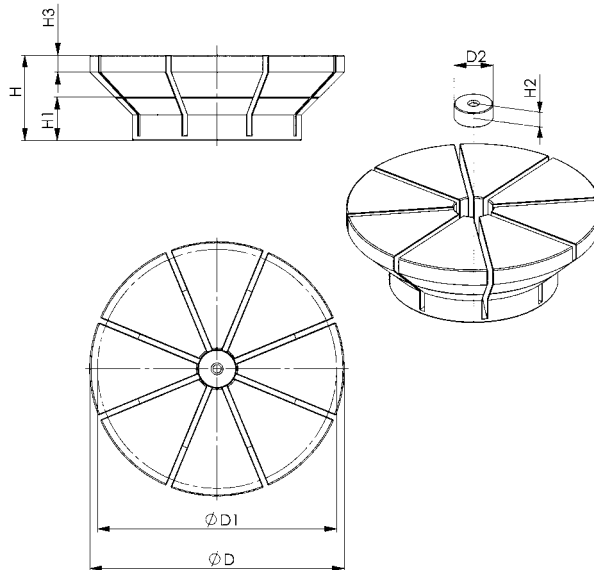
The collet attachment is fastened using fastening kit 6375BA (observe torque specifications) on the base element 6375M. To secure the workpiece contour, the collet attachment must be clamped with the locking bolt. Then the workpiece contour is milled into the collet attachment with a minimum clamping depth of 2 mm. Then the locking bolt is removed, and the workpiece can be clamped. The collet attachment can be milled off to a height of H1, allowing new workpiece contours to be introduced. The maximum workpiece diameter is specified in the table with D1.

Advantage:

- Clamping of delicate and thin-walled workpieces
- Free-form clamping
- The workpiece is clamped without distortion due to the radially even clamping force imposed on it
- Multiple insertion of different workpiece contours possible

Note:

The collet attachment must always be clamped with the workpiece or locking bolt. To remove the vertical play between the collet attachment and base element, light pretensioning must be applied by actuating the clamping stud after the workpiece is inserted.



No. 6375ZI

Collet attachment inside clamping

Collet attachment made of high-strength aluminium, hard anodised. With circlip made of tempered steel, burnished.

NEW!

Order no.	Size	dia. D	dia. D1	dia. D2	dia. D3	dia. D4	H	H1	H2	H3	H4	Clamping stroke Ø [mm]	Weight [g]
567125	10	70	32	11,2	65	32,7	41,5	10	7	14,5	9,5	0,3	327
567126	20	99	45	16,0	90	44,7	46,5	10	10	14,5	9,5	0,3	779

Design:

Collet attachments are always supplied with circlip.

Application:

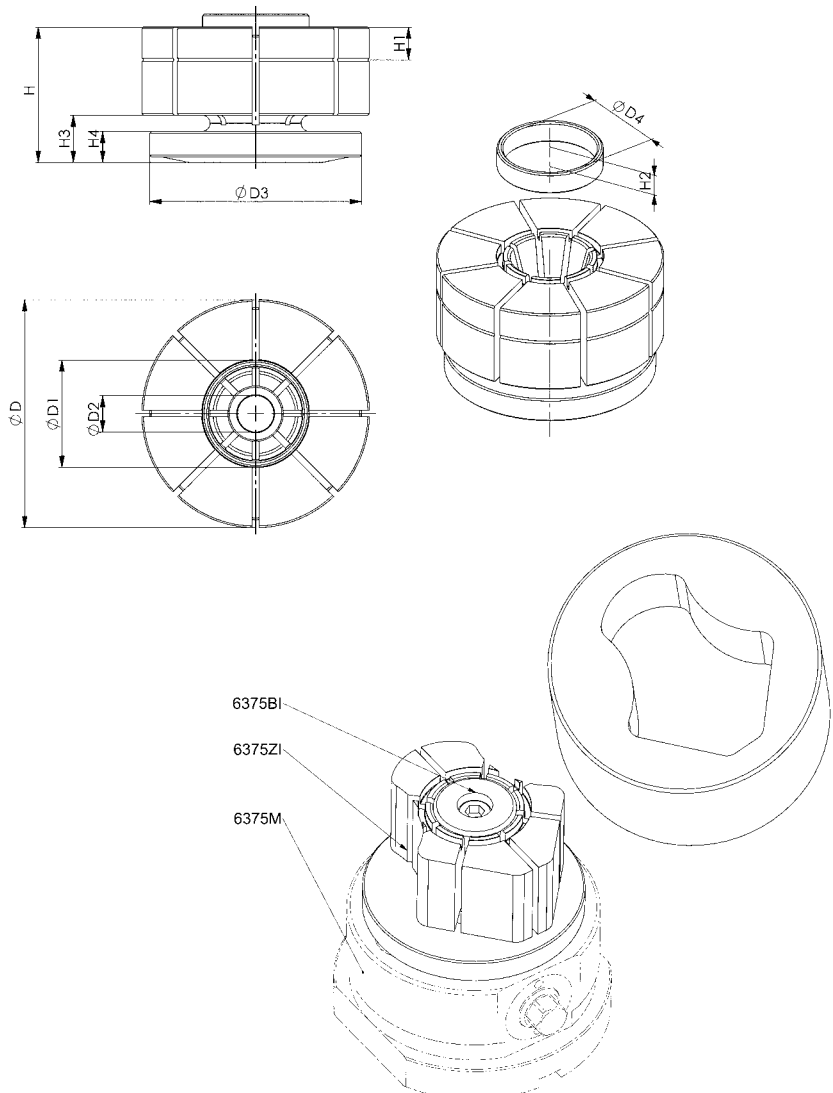
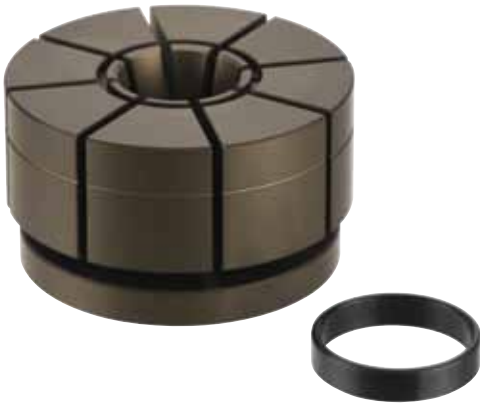
The collet attachment is fastened using fastening kit 6375BI (observe torque specifications) on the base element 6375M. To secure the workpiece contour, the collet attachment must be clamped with the circlip. Then the workpiece contour is milled into the collet attachment with a minimum clamping depth of 10 mm. Then the circlip is removed, and the workpiece can be clamped. To secure new workpiece contours, the collet attachment can be milled off up to a diameter (D1).

Advantage:

- Clamping of blind holes and through-holes
- Free-form clamping
- Clamping of delicate and thin-walled workpieces
- The workpiece is clamped without distortion due to the radially even clamping force imposed on it
- Multiple insertion of different workpiece contours possible

Note:

The collet attachment must always be clamped with the workpiece or circlip. To remove the vertical play between the collet attachment and base element, light pretensioning must be applied by actuating the clamping stud after the workpiece is inserted.



Specifications subject to change

No. 6375BI

Fastening kit for collet attachment inside clamping

With tension bolt made of tempered steel, plasma-nitrided and burnished and cylinder screw ISO4762, strength class 12.9.

NEW!



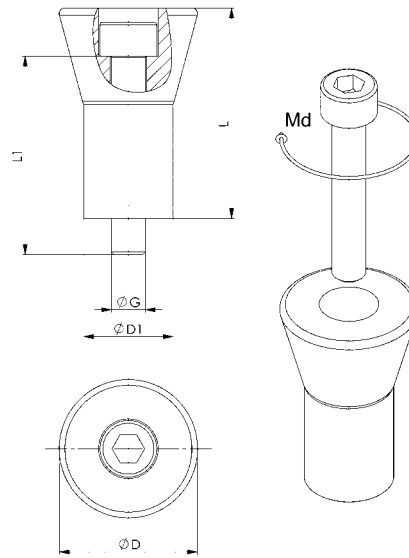
Order no.	Size	dia. D	dia. D1	G	Md [Nm]	L	L1	Weight [g]
567129	10	25	16	M6	14	37	35	73
567130	20	25	19	M8	25	42	40	93

Application:

For fastening the collet attachments to the inside clamping of workpieces.

Note:

The fastening kit must be tightened with the specified torque.



No. 6375BA

Fastening kit for collet attachment outside clamping

With disc made of tempered steel and flat-head screw ISO10642.

NEW!



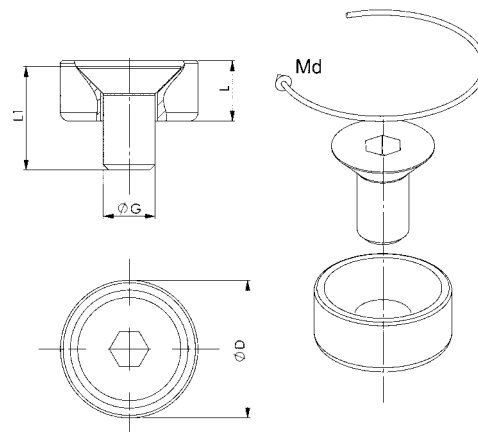
Order no.	Size	dia. D	G	Md [Nm]	L	L1	Weight [g]
567127	10	16	M6	8	7	12	11
567128	20	21	M8	10	7	16	20

Application:

For fastening the collet attachments to the outside clamping of workpieces.

Note:

The fastening kit must be tightened with the specified torque.



COLLET CATALOGUE EXTRACT 2022

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