

Pull Back Series Power Collet Chuck for Bar Machining

First Operation Collet Chuck

Klamp DHP collet chucks are suitable for collets which have a +/-0.5mm gripping range. Allowing the collet chuck to handle rough and unfinished bar, preparing it for a high accuracy second operation.

Pull Back Action

The Collet pulled into the chuck to close and pushed out to open. This action means that back stops cannot be provided and must be used where accurate axial positioning is not important.

Problem Free Installation

Klamp collet chucks are provided with mounting bolts and a 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 down-time.

Long Service Life

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

Short Body/Wide Range

DC Varibore collets allow for a compact body design maximising the lathe work envelope. Gripping capacities of the series range from 4mm to 80mm.

Low Profile

Small nose diameter to provide excellent tool clearance.

Fully Sealed

No grease required to operate the collet chuck. O-ring seals are incorporated within the design to prevent coolant and chip ingress.

High Speed

Direct mount design ensures high concentricity that is suitable for higher speed operations that are not appropriate for conventional 3-jaw chuck due to the negative effects of centrifugal force.



Suitable for DC Varibore Collet Types



Klamp DHP collet chucks accept DC Varibore Collets that have the same accuracy specification as spring collets whilst maintaining a gripping range of +/- 0.5mm. Supplied with either smooth or serrated gripping surface. Serrated collets are ideal for aggressive first operation gripping of rough bar work.

Vulcanized rubber between the hardened steel collet segments provides excellent protection against coolant and chip ingress. Counter boring and special profile shapes are available upon request.

Ultra-Fast 10 Second Collet Changes



Insert & Unlock DC Collet



Remove DC Collet

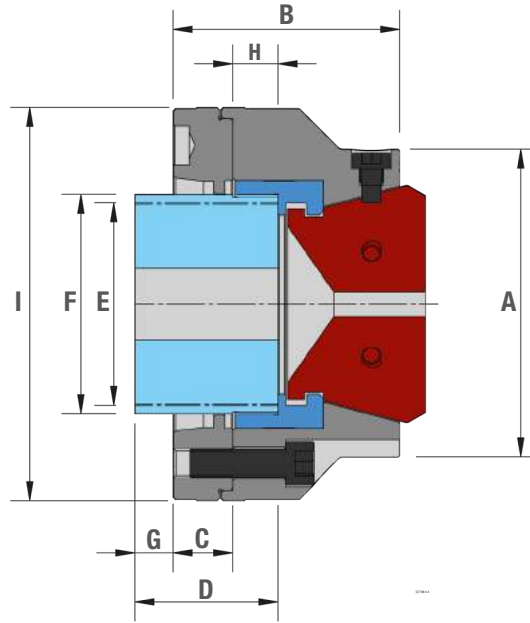


Insert DC Collet



Lock & Remove DC

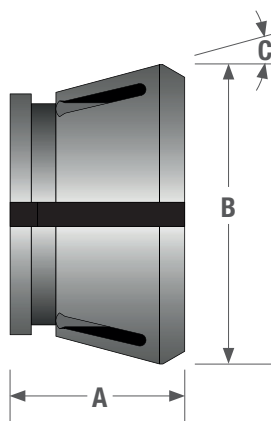
Pull Back Series Power Collet Chuck for Bar Machining



KLAMP Type	DHP42		DHP52			DHP65			DHP80					
Mounting	Z140	A5	A5	A6	A8	A5	A6	A8	Z220	A6	A8	A11		
Part Number	DHP42	DHP42A5	DHP52A5	DHP52A6	DHP52A8	DHP65A5	DHP65A6	DHP65A8	DHP80	DHP80A6	DHP80A8	DHP80A11		
Varibore Collet Type	DC42		DC52			DC65			DC80					
Varibore Collet Gripping range*	Minimum	4	4			4			7					
	Maximum	42	52			65			80					
Varibore Collet Increments	1		1			1			1					
A	100		120			130			160					
B	110		89		109	95		115	109.5	134.5	127.5	156.5		
C	15		25		45	25		45	NA	25	18	47		
D	60		60			60			70	68	70			
E Maximum	M58 x 2.0		M70 x 2.0		M85 x 2.0		M70 x 2.0		M85 x 2.0		M105 x 2.0			
F	65		79		92		79		92		115			
G Maximum	25	10	20.5	16	-4	44		-4	32	5	14	-15		
G Minimum	20.5	5.5	16	11.5	0.5	39.5		0.5	36.5	9.5	18.5	-10.5		
H	39.5		19			19			38					
I	150		165		210	165		210	230		280			
Sleeve stroke	4.5		4.5			4.5			4.5					
Max. input force	kN		35		40	45			50					
Max. Gripping Force	kN		60		94	105			115					
Max. Speed	min ⁻¹		6000		6500	6000			5500					
Net Weight	kg		8	9	11.3	11.6	16	11.6	11.8	16.3	24.6	29.6	27.5	34
Matching Kitagawa Cylinders	S1246 SS1246 SR1146		S1552 SS1452 SR1453			S1875 SS1771 SR1566			S2091 SS1881 SR1781					



DC Quick Change Collets to Suit DHP42 Collet Chucks



DC42 Varibore Collets

- Round, Hexagon, Square or Emergency types available
- Please specify which gripping surface you require – Serrated or Smooth
- Clamping tolerance of +/- 0.5mm
- Counter boring and special profile shapes are available upon request

Dimensions (Metric)

Part No.	A	B	C
DC42	42	79.3	15°

DC42 Round Collets

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
4mm	DC42-R04	DC42S-R04
5mm	DC42-R05	DC42S-R05
6mm	DC42-R06	DC42S-R06
7mm	DC42-R07	DC42S-R07
8mm	DC42-R08	DC42S-R08
9mm	DC42-R09	DC42S-R09
10mm	DC42-R10	DC42S-R10
11mm	DC42-R11	DC42S-R11
12mm	DC42-R12	DC42S-R12
13mm	DC42-R13	DC42S-R13
14mm	DC42-R14	DC42S-R14
15mm	DC42-R15	DC42S-R15
16mm	DC42-R16	DC42S-R16

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
17mm	DC42-R17	DC42S-R17
18mm	DC42-R18	DC42S-R18
19mm	DC42-R19	DC42S-R19
20mm	DC42-R20	DC42S-R20
21mm	DC42-R21	DC42S-R21
22mm	DC42-R22	DC42S-R22
23mm	DC42-R23	DC42S-R23
24mm	DC42-R24	DC42S-R24
25mm	DC42-R25	DC42S-R25
26mm	DC42-R26	DC42S-R26
27mm	DC42-R27	DC42S-R27
28mm	DC42-R28	DC42S-R28
29mm	DC42-R29	DC42S-R29

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
30mm	DC42-R30	DC42S-R30
31mm	DC42-R31	DC42S-R31
32mm	DC42-R32	DC42S-R32
33mm	DC42-R33	DC42S-R33
34mm	DC42-R34	DC42S-R34
35mm	DC42-R35	DC42S-R35
36mm	DC42-R36	DC42S-R36
37mm	DC42-R37	DC42S-R37
38mm	DC42-R38	DC42S-R38
39mm	DC42-R39	DC42S-R39
40mm	DC42-R40	DC42S-R40
41mm	DC42-R41	DC42S-R41
42mm	DC42-R42	DC42S-R42

DC42 Hexagon Collets

Available from 7mm to 36mm across flats sides of the hexagon in 1mm increments. Part number is **DC42-X****. Please state which size you require, smooth or serrated gripping surface is available.

DC42 Square Collets

Available from 7mm to 30mm across flats sides of the square in 1mm increments. Part number is **DC42-S****. Please state which size you require, smooth or serrated gripping surface is available.

DC42 Emergency Collets

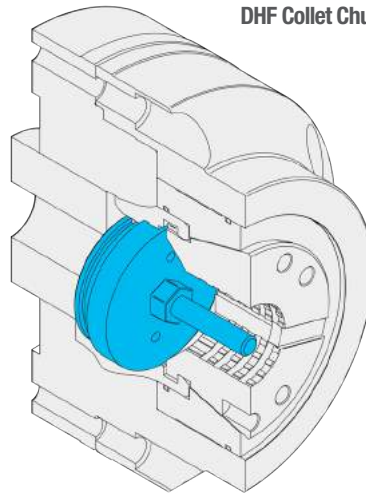
Available only with 5mm, 15mm or 32mm pilot holes. Part number is **DC42-E****. Please state which size you require.

D Series Standard Accessories

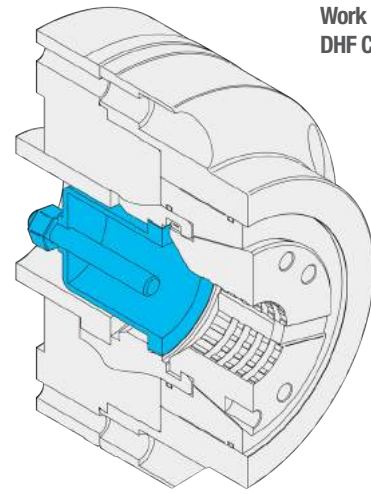
Work Stops

- 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 DHP & DHF 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 DHF Collet Chuck



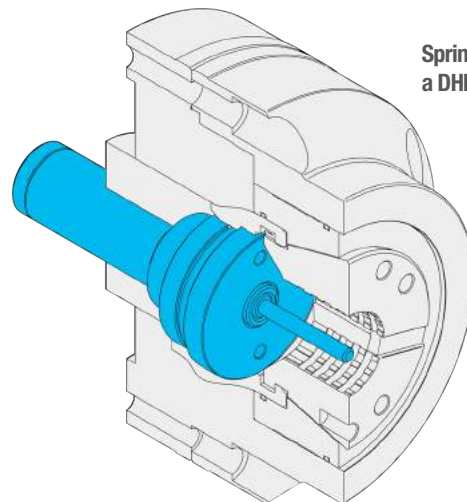
Additional Length Work Stop on a DHF Collet Chuck



Spring Ejectors DHF Series Only

- Standard spring ejectors for in the DHF series are use for second-spindle operations to expel finished workpiece into the parts catcher.
- All spring ejectors are easily installed from the front face utilising a supplied key
- Many variants of spring ejector are available to suit your production process.
- 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 DHF Collet Chuck



Collet Changing Device D Series Collet Chucks

- Easy to use device to allow DC Collets to be removed or installed.
- Simply insert the steel pins into the Collet face holes and squeeze the trigger to collapse the DC Collet.
- Available in both manual and pneumatic versions.

Part Number	To Suit		Type
	DHP Series	DHF Series	
DCD42	DHP42	-	Manual
DCD52	DHP52	-	Manual
DCD65	DHP65	DHF65	Manual
DCD80	DHP80	DHF80	Pneumatic

