

Short Series Power Collet Chuck for Bar Machining

Short Body/Wide Range

Varibore & rubber-flex collets allow for a compact body design maximising the lathe work envelope. Gripping capacities of the series range from 3 mm to 66mm

High Speed

Direct mount design ensures high concentricity suitable for higher speed operations.

First Operation Collet Chuck

Klamp CRS collet chucks are suitable for collets which have a large gripping range. Allowing the collet chuck to handle very rough and unfinished bar, preparing it for a high accuracy second operation.

Fixed Length Collet

Workpiece remains in a fixed position during actuation, allowing for precise z-axis positioning. A tapered sleeve is pushed forward, compressing the collet and gripping the workpiece.

Problem Free Installation

Klamp collet chucks are provided with mounting bolts and an optional 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 downtime.

Long service life

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



Designed for Bar Pushers/ Barfeeders



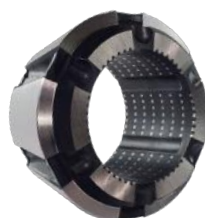
Fixed-length Klamp collet chucks are designed to work with bar loaders and bar feeders by not interfering with the process of the bar feeder action.

2 Different Collet Types Available



Varibore Collets**

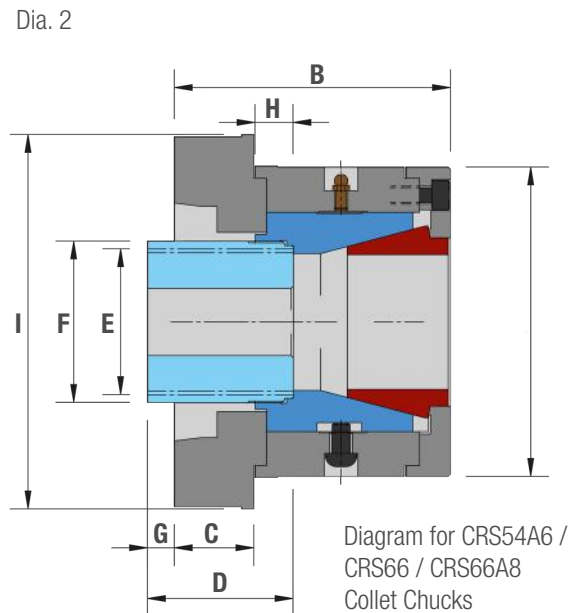
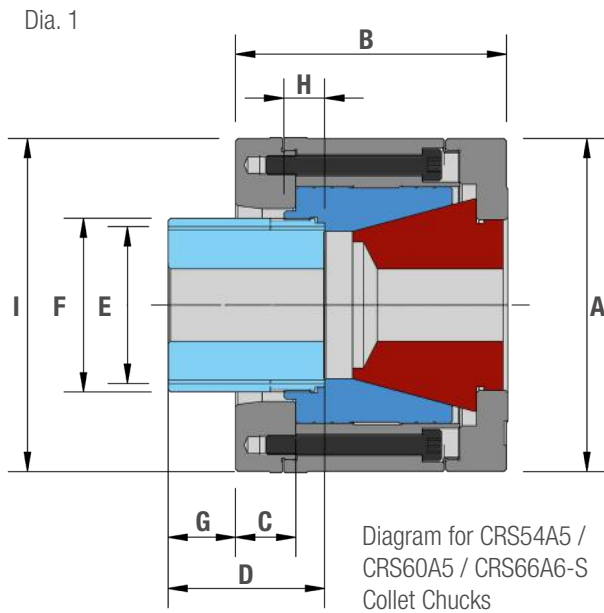
Ideal for first operation work as they have a 2-3mm gripping range enabling you to handle rough bar. Supplied either as smooth, serrated or super grip.



Rubberflex Collets***

The same accuracy specification as spring collets. Elastic rubber-metal vulcanization allows a clamping range of +/- 1mm to the nominal diameter.

Short Series Power Collet Chuck for Bar Machining



| KLAMP Type | | CRS54 | | CRS60 | CRS66 | | |
|------------------------------------|---------|------------------------|---------|-----------|-----------|-----------|---------|
| Mounting | | A5 | A6 | A5 | Z220 | A6 | A8 |
| Part number | | CRS54A5 | CRS54A6 | CRS60A5 | CRS66 | CRS66A6-S | CRS66A8 |
| Varibore Collet Type | | D-120 | | D-677 | D-285 | | |
| Varibore Collet Gripping range* | Minimum | 3 | | 4 | 3.2 | | |
| | Maximum | 53.9 | | 60 | 66.6 | | |
| Varibore Collet Increments | | 3 | | 2 | 3 | | |
| Rubberflex Collet Type | | - | | DRFC677 | - | | |
| Rubberflex Collet Gripping Range** | Minimum | - | | 19* | - | | |
| | Maximum | - | | 65* | - | | |
| Rubberflex Collet Increments | | - | | 2 | - | | |
| A | | 138 | | 138 | 150 | 165 | 150 |
| B | | 113 | 127.4 | 107.5 | 134 | 131 | 140 |
| C | | 25 | 41 | 25 | 24 | N/A | 30 |
| D | | 65 | | 65 | 80 | | |
| E Maximum | | M65 x 1.5 | | M65 x 1.5 | M80 x 2.0 | | |
| F | | 72 | | 72 | 90 | | |
| G Maximum | | 28 | 12 | 28 | 27 | 29.5 | 21 |
| G Minimum | | 18 | 2 | 21 | 17 | 19.5 | 11 |
| H | | 17 | | 17 | 24 | | |
| I | | N/A | 167 | N/A | 230 | N/A | 210 |
| Sleeve stroke | | 10 | | 7 | 10 | | |
| Max. input force | | kN 30 | | 30 | 38 | | |
| Max. Gripping Force | | kN 60 | | 60 | 84 | | |
| Max. Speed | | min ⁻¹ 6300 | | 6300 | 4500 | | |
| Net Weight | | 11 | 12.5 | 11 | 19 | | 18 |
| Matching Kitagawa Cylinders | | S1552 | | S1552 | S1875 | | |

* See pages 22-23 for more Varibore Collet information

** DRFC677 Rubber-flex collets are only suitable for the CRS60 Collet chuck and are available in smooth and full grip versions (smooth version is only available for 61 mm diameters and larger).