

**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**



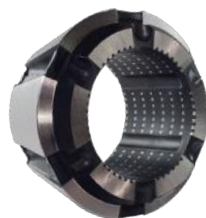
Fixed-length Klamp collet chucks are designed to work with bar loaders and bar feeders by not interfering with the process of the bar feeder action.

**2 Different Collet Types Available**



**Varibore Collets\*\***

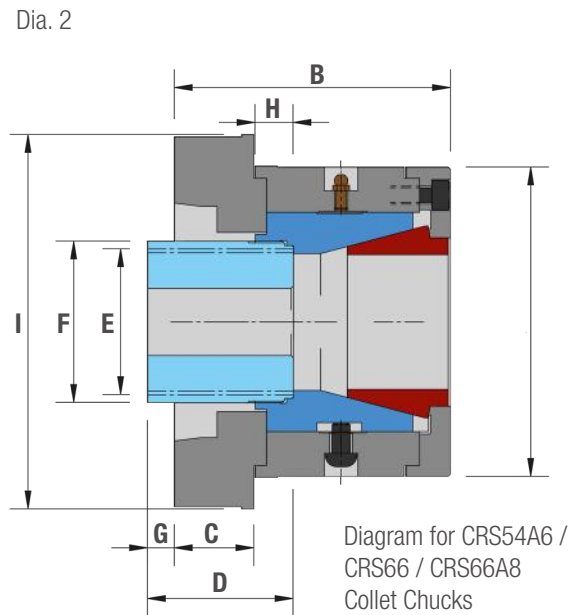
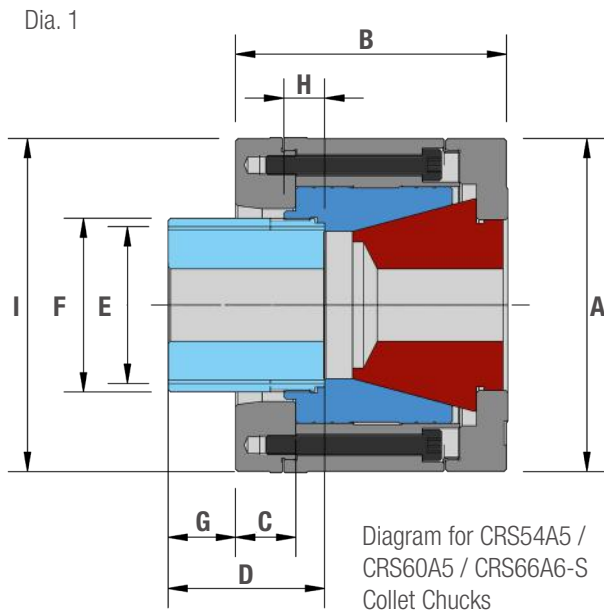
Ideal for first operation work as they have a 2-3mm gripping range enabling you to handle rough bar. Supplied either as smooth, serrated or super grip.



**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

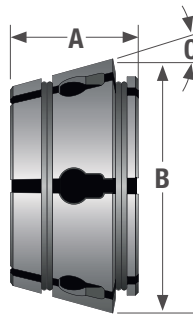


KLAMP Type		CRS54		CRS60	CRS66		
Mounting		A5	A6	A5	Z220	A6	A8
Part number		CRS54A5	CRS54A6	CRS60A5	CRS66	CRS66A6-S	CRS66A8
Varibore Collet Type		D-120		D-677	D-285		
Varibore Collet Gripping range*	Minimum	3		4	3.2		
	Maximum	53.9		60	66.6		
Varibore Collet Increments		3		2	3		
Rubberflex Collet Type		-		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 <sup>-1</sup> 6300		6300	4500		
Net Weight		kg 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).

## Varibore Collets for CRS36, CRL42, QCRL42, CRL60, QCRL60, CRL80 & QCRL80 Collet Chucks



### Varibore Collets - Type: DIN 6343

- Round, Hexagon or Square
- Specify which gripping surface you require – Supergrip Serrations (Heavy duty), Annular serrations or Smooth
- Other shapes available upon request

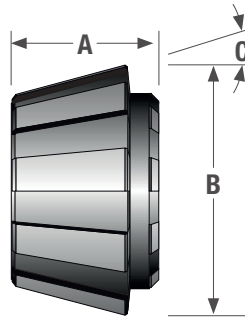
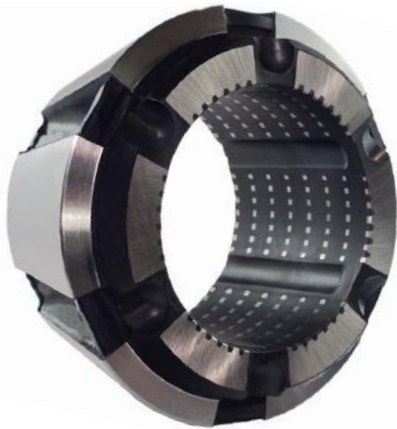
### Dimensions (Metric)

Part No.	A	B	C
D671	38	56.5	14.75°
D673	39	61.5	14.75°
D677	45	85.5	14.75°
D660	48	1087.5	14.75°

Gripping Range	D671 DIN for CRS36			D673 DIN for CRL42 & QCRL42			D677 DIN for CRL60 & QCRL60			D660 DIN for CRL80 & QCRL80		
	mm	Round	Hexagon	Square	Round	Hexagon	Square	Round	Hexagon	Square	Round	Hexagon
4 - 6	D671-R06	D671-X06	D671-S06	D673-R06	D673-X06	D673-S06	-	-	-	-	-	-
6 - 8	D671-R08	D671-X08	D671-S08	D673-R08	D673-X08	D673-S08	D677-R08	D677-X08	D677-S08	-	-	-
8 - 10	D671-R10	D671-X10	D671-S10	D673-R10	D673-X10	D673-S10	D677-R10	D677-X10	D677-S10	-	-	-
10 - 12	D671-R12	D671-X12	D671-S12	D673-R12	D673-X12	D673-S12	D677-R12	D677-X12	D677-S12	-	-	-
12 - 14	D671-R14	D671-X14	D671-S14	D673-R14	D673-X14	D673-S14	D677-R14	D677-X14	D677-S14	D660-R14	D660-X14	-
14 - 16	D671-R16	D671-X16	D671-S16	D673-R16	D673-X16	D673-S16	D677-R16	D677-X16	D677-S16	D660-R16	D660-X16	-
16 - 18	D671-R18	D671-X18	D671-S18	D673-R18	D673-X18	D673-S18	D677-R18	D677-X18	D677-S18	D660-R18	D660-X18	-
18 - 20	D671-R20	D671-X20	D671-S20	D673-R20	D673-X20	D673-S20	D677-R20	D677-X20	D677-S20	D660-R20	D660-X20	-
20 - 22	D671-R22	D671-X22	D671-S22	D673-R22	D673-X22	D673-S22	D677-R22	D677-X22	D677-S22	D660-R22	D660-X22	-
22 - 24	D671-R24	D671-X24	D671-S24	D673-R24	D673-X24	D673-S24	D677-R24	D677-X24	D677-S24	D660-R24	D660-X24	-
24 - 26	D671-R26	D671-X26	-	D673-R26	D673-X26	D673-S26	D677-R26	D677-X26	D677-S26	D660-R26	D660-X26	-
26 - 28	D671-R28	D671-X28	-	D673-R28	D673-X28	D673-S28	D677-R28	D677-X28	D677-S28	D660-R28	D660-X28	-
28 - 30	D671-R30	-	-	D673-R30	D673-X30	D673-S30	D677-R30	D677-X30	D677-S30	D660-R30	D660-X30	-
30 - 32	D671-R32	-	-	D673-R32	D673-X32	-	D677-R32	D677-X32	D677-S32	D660-R32	D660-X32	-
32 - 34	D671-R34	-	-	D673-R34	D673-X34	-	D677-R34	D677-X34	D677-S34	D660-R34	D660-X34	-
34 - 36	D671-R36	-	-	D673-R36	D673-X36	-	D677-R36	D677-X36	D677-S36	D660-R36	D660-X36	-
36 - 38	-	-	-	D673-R38	-	-	D677-R38	D677-X38	D677-S38	D660-R38	D660-X38	-
38 - 40	-	-	-	D673-R40	-	-	D677-R40	D677-X40	D677-S40	D660-R40	D660-X40	-
40 - 42	-	-	-	D673-R42	-	-	D677-R42	D677-X42	D677-S42	D660-R42	D660-X42	-
42 - 44	-	-	-	-	-	-	D677-R44	D677-X44	-	D660-R44	D660-X44	-
44 - 46	-	-	-	-	-	-	D677-R46	D677-X46	-	D660-R46	D660-X46	-
46 - 48	-	-	-	-	-	-	D677-R48	D677-X48	-	D660-R48	D660-X48	-
48 - 50	-	-	-	-	-	-	D677-R50	D677-X50	-	D660-R50	D660-X50	-
50 - 52	-	-	-	-	-	-	D677-R52	D677-X52	-	D660-R52	D660-X52	-
52 - 54	-	-	-	-	-	-	D677-R54	-	-	D660-R54	D660-X54	-
54 - 56	-	-	-	-	-	-	D677-R56	-	-	D660-R56	D660-X56	-
56 - 58	-	-	-	-	-	-	D677-R58	-	-	D660-R58	D660-X58	-
58 - 60	-	-	-	-	-	-	D677-R60	-	-	D660-R60	D660-X60	-
60 - 62	-	-	-	-	-	-	-	-	-	D660-R62	D660-X62	-
62 - 64	-	-	-	-	-	-	-	-	-	D660-R64	D660-X64	-
64 - 66	-	-	-	-	-	-	-	-	-	D660-R66	D660-X66	-
66 - 68	-	-	-	-	-	-	-	-	-	D660-R68	D660-X68	-
68 - 70	-	-	-	-	-	-	-	-	-	D660-R70	-	-
70 - 72	-	-	-	-	-	-	-	-	-	D660-R72	-	-
72 - 74	-	-	-	-	-	-	-	-	-	D660-R74	-	-
74 - 76	-	-	-	-	-	-	-	-	-	D660-R76	-	-
76 - 78	-	-	-	-	-	-	-	-	-	D660-R78	-	-
78 - 80	-	-	-	-	-	-	-	-	-	D660-R80	-	-

Emergency Collets with soft face and pilot hole is available for all types

## Rubber-Flex Collets for CRL42, QCRL42, CRS60, CRL60, QCRL60 Collet Chucks



### Rubberflex Collets – Type: DIN 6343

- Round, Hexagon or Square
- Specify which gripping surface you require – Full Grip or Smooth  
Smooth Type – **DRFCXXX-RXX**  
Full Grip Type – **DRFCXXX-RXX/R**

### Dimensions (Metric)

Part No.	A	B	C
DRFC673	39	61.5	14.75°
DRFC677	45	85.5	14.75°

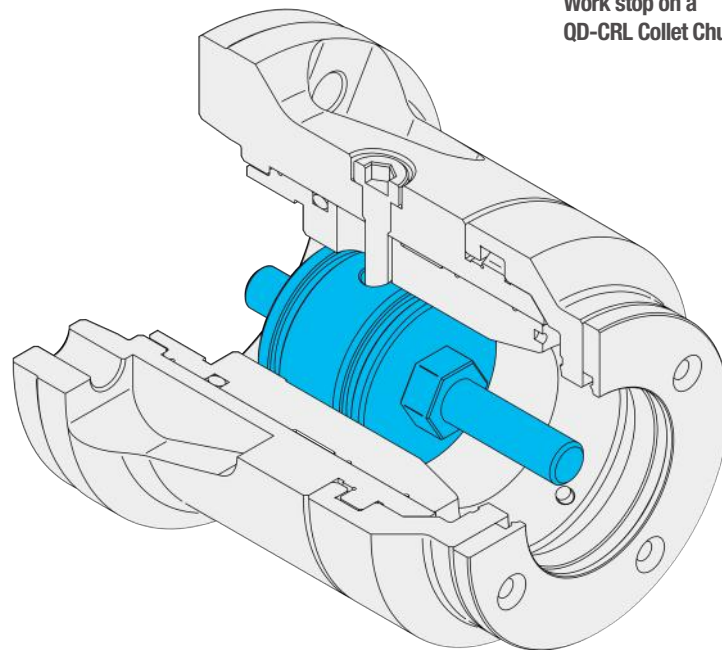
Gripping Range mm	DRFC673 DIN for CRL42 & QCRL42	DRFC677 DIN for CRS60, CRL60 & QCRL60
	Round	Round
7 - 9	DRFC673-R09	-
9 - 11	DRFC673-R11	-
11 - 13	DRFC673-R13*	-
13 - 15	DRFC673-R15*	-
15 - 17	DRFC673-R17*	-
17 - 19	DRFC673-R19*	-
19 - 21	DRFC673-R21*	DRFC677-R21*
21 - 23	DRFC673-R23*	DRFC677-R23*
23 - 25	DRFC673-R25*	DRFC677-R25*
25 - 27	DRFC673-R27*	DRFC677-R27*
27 - 29	DRFC673-R29*	DRFC677-R29*
29 - 31	DRFC673-R31*	DRFC677-R31*
31 - 33	DRFC673-R33*	DRFC677-R33*
33 - 35	DRFC673-R35*	DRFC677-R35*
35 - 37	DRFC673-R37*	DRFC677-R37*
37 - 39	DRFC673-R39*	DRFC677-R39*
39 - 41	DRFC673-R41*	DRFC677-R41*
41 - 43	DRFC673-R43*	DRFC677-R43*
43 - 45	DRFC673-R45	DRFC677-R45*
45 - 47	-	DRFC677-R47*
47 - 49	-	DRFC677-R49*
49 - 51	-	DRFC677-R51*
51 - 53	-	DRFC677-R53*
53 - 55	-	DRFC677-R55*
55 - 57	-	DRFC677-R57*
57 - 59	-	DRFC677-R59*
59 - 61	-	DRFC677-R61*
61 - 63	-	DRFC677-R63
63 - 65	-	DRFC677-R65

\*Available as full grip & smooth specification, otherwise can only be supplied in smooth specification

## QC & C Series Standard Accessories

### Work Stops

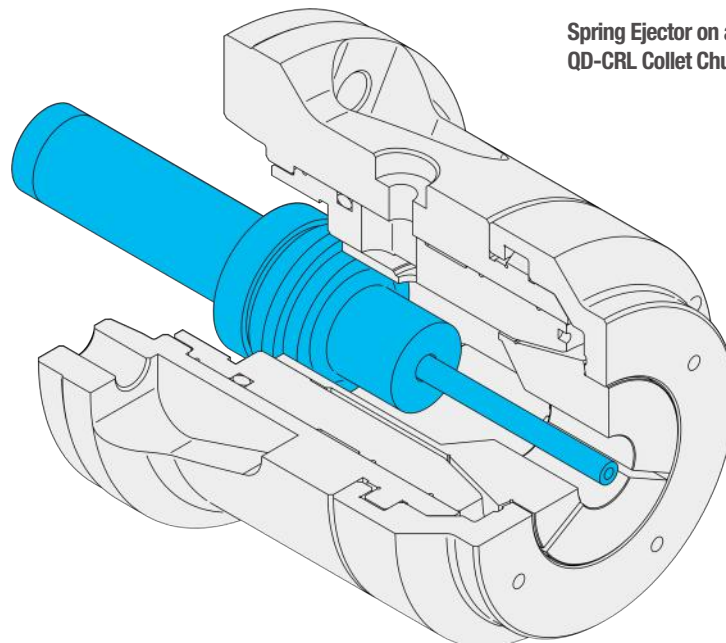
- Stops can be provided to allow for accurate z-axis positioning of short workpieces within the collet chuck.
- A threaded stud is provided for easy adjustment to suit your work piece
- All stops are easily installed from the front face utilising a side bolt to hold the stop securely in place.
- These stops can be installed on all QC & C 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 QD-CRL Collet Chuck

### Spring Ejectors

- Standard spring ejectors for QC & C series are used for second-spindle operations to expel finished workpieces into the parts catcher.
- Many variants of spring ejector are available to suit your production process.
- Spring ejectors can be installed on all QC & C series collet chucks.
- 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 QD-CRL Collet Chuck