

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



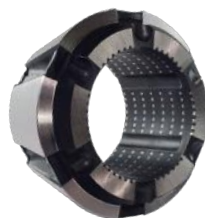
Fixed-length Klamp collet chucks are designed to work with bar loaders and bar feeders by not interfering with the process of the bar feeder action.

2 Different Collet Types Available



Varibore Collets**

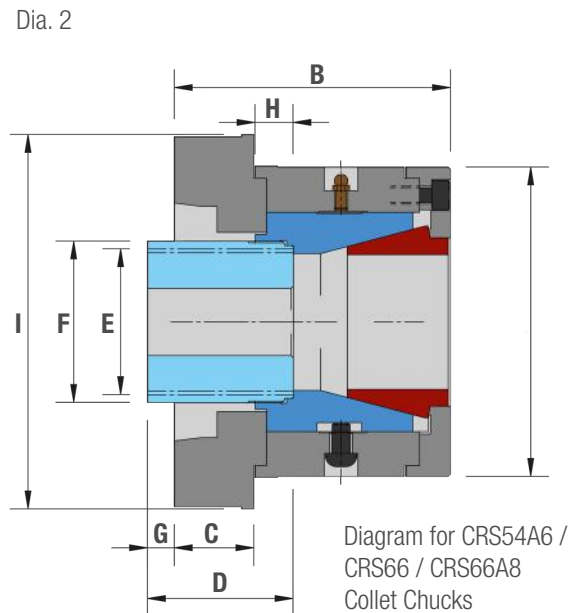
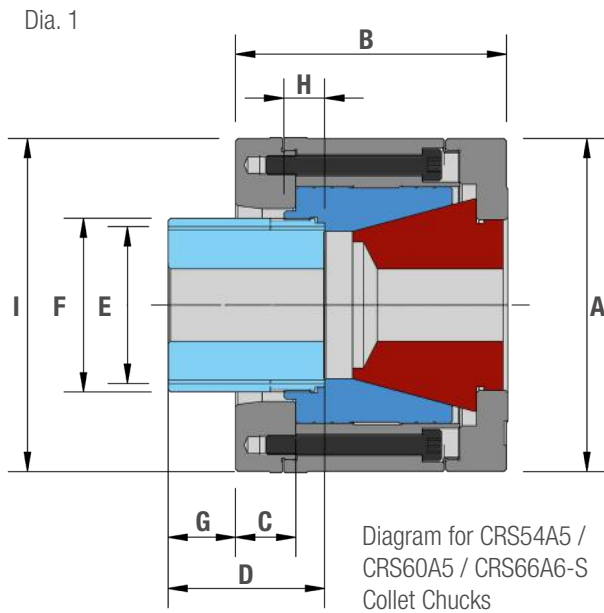
Ideal for first operation work as they have a 2-3mm gripping range enabling you to handle rough bar. Supplied either as smooth, serrated or super grip.



Rubberflex Collets***

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

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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		kg 11	12.5	11	19		18
Matching Kitagawa Cylinders		S1552		S1552	S1875		

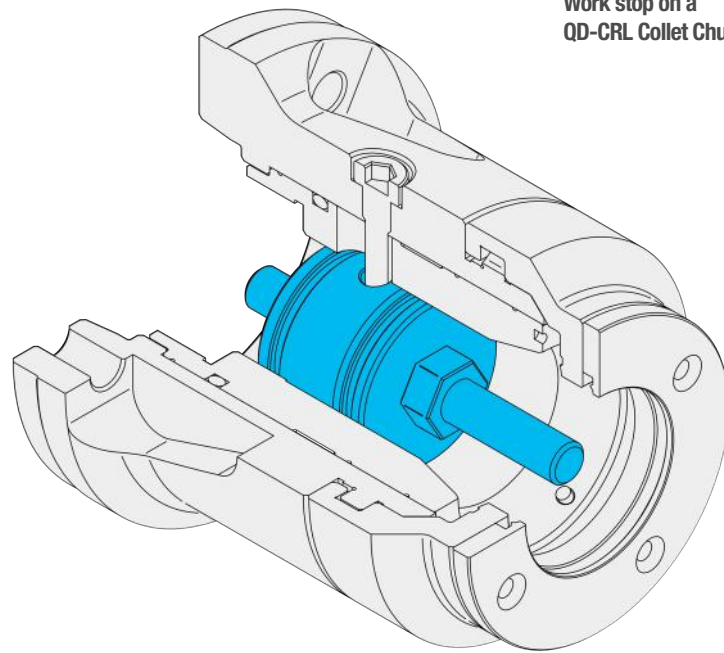
* See pages 22-23 for more Varibore Collet information

** 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).

QC & C Series Standard Accessories

Work Stops

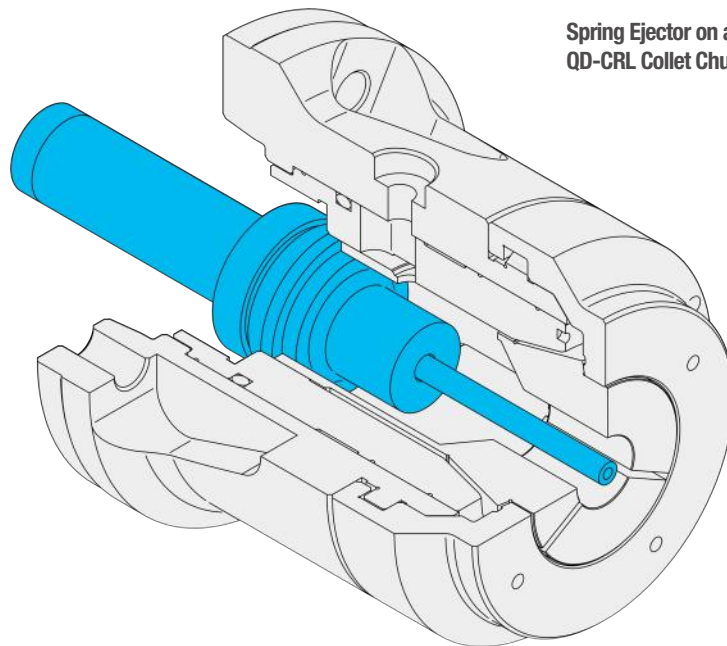
- Stops can be provided to allow for accurate z-axis positioning of short workpieces within the collet chuck.
- A threaded stud is provided for easy adjustment to suit your work piece
- All stops are easily installed from the front face utilising a side bolt to hold the stop securely in place.
- These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