

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

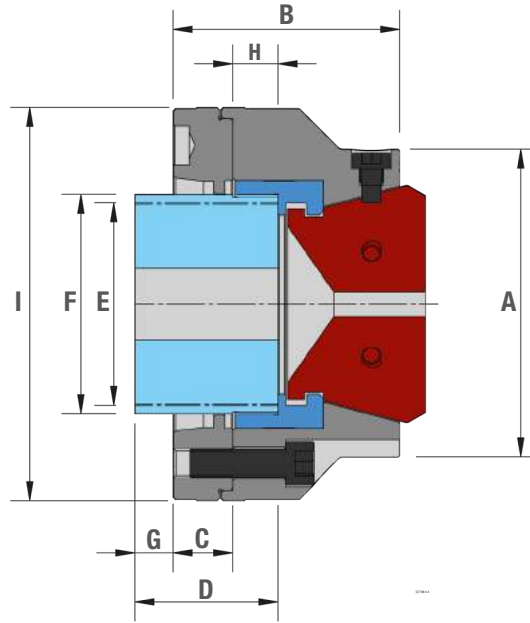


Insert DC Collet



Lock & Remove DC

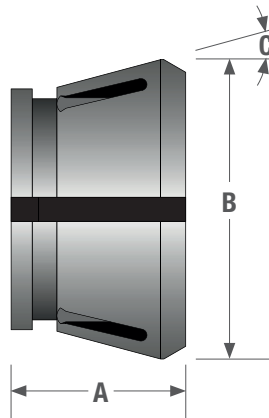
Pull Back Series Power Collet Chuck for Bar Machining



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 DHP80/DHF80/DRF80 Collet chucks



DC80 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
DC80	53	114.5	15°

DC80 Round Collets

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
7mm	DC80-R07	DC80S-R07
8mm	DC80-R08	DC80S-R08
9mm	DC80-R09	DC80S-R09
10mm	DC80-R10	DC80S-R10
11mm	DC80-R11	DC80S-R11
12mm	DC80-R12	DC80S-R12
13mm	DC80-R13	DC80S-R13
14mm	DC80-R14	DC80S-R14
15mm	DC80-R15	DC80S-R15
16mm	DC80-R16	DC80S-R16
17mm	DC80-R17	DC80S-R17
18mm	DC80-R18	DC80S-R18
19mm	DC80-R19	DC80S-R19
20mm	DC80-R20	DC80S-R20
21mm	DC80-R21	DC80S-R21
22mm	DC80-R22	DC80S-R22
23mm	DC80-R23	DC80S-R23
24mm	DC80-R24	DC80S-R24
25mm	DC80-R25	DC80S-R25
26mm	DC80-R26	DC80S-R26
27mm	DC80-R27	DC80S-R27
28mm	DC80-R28	DC80S-R28
29mm	DC80-R29	DC80S-R29
30mm	DC80-R30	DC80S-R30
31mm	DC80-R31	DC80S-R31

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
32mm	DC80-R32	DC80S-R32
33mm	DC80-R33	DC80S-R33
34mm	DC80-R34	DC80S-R34
35mm	DC80-R35	DC80S-R35
36mm	DC80-R36	DC80S-R36
37mm	DC80-R37	DC80S-R37
38mm	DC80-R38	DC80S-R38
39mm	DC80-R39	DC80S-R39
40mm	DC80-R40	DC80S-R40
41mm	DC80-R41	DC80S-R41
42mm	DC80-R42	DC80S-R42
43mm	DC80-R43	DC80S-R43
44mm	DC80-R44	DC80S-R44
45mm	DC80-R45	DC80S-R45
46mm	DC80-R46	DC80S-R46
47mm	DC80-R47	DC80S-R47
48mm	DC80-R48	DC80S-R48
49mm	DC80-R49	DC80S-R49
50mm	DC80-R50	DC80S-R50
51mm	DC80-R51	DC80S-R51
52mm	DC80-R52	DC80S-R52
53mm	DC80-R53	DC80S-R53
54mm	DC80-R54	DC80S-R54
55mm	DC80-R55	DC80S-R55
56mm	DC80-R56	DC80S-R56

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
57mm	DC80-R57	DC80S-R57
58mm	DC80-R58	DC80S-R58
59mm	DC80-R59	DC80S-R59
60mm	DC80-R60	DC80S-R60
61mm	DC80-R61	DC80S-R61
62mm	DC80-R62	DC80S-R62
63mm	DC80-R63	DC80S-R63
64mm	DC80-R64	DC80S-R64
65mm	DC80-R65	DC80S-R65
66mm	DC80-R66	DC80S-R66
67mm	DC80-R67	DC80S-R67
68mm	DC80-R68	DC80S-R68
69mm	DC80-R69	DC80S-R69
70mm	DC80-R70	DC80S-R70
71mm	DC80-R71	DC80S-R71
72mm	DC80-R72	DC80S-R72
73mm	DC80-R73	DC80S-R73
74mm	DC80-R74	DC80S-R74
75mm	DC80-R75	DC80S-R75
76mm	DC80-R76	DC80S-R76
77mm	DC80-R77	DC80S-R77
78mm	DC80-R78	DC80S-R78
79mm	DC80-R79	DC80S-R79
80mm	DC80-R80	DC80S-R80

DC80 Hexagon Collets

Available from 10mm to 70mm across flats sides of the hexagon in 1mm increments. Part number is **DC80-X****. Please state which size you require, smooth or serrated gripping surface is available.

DC80 Square Collets

Available from 10mm to 56mm across flats sides of the square in 1mm increments. Part number is **DC80-S****. Please state which size you require, smooth or serrated gripping surface is available.

DC80 Emergency Collets

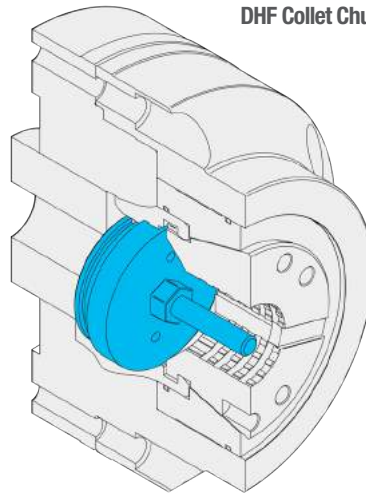
Available only with 8mm, 20mm or 40mm or 60mm pilot holes. Part number is **DC80-E****. Please state which size you require.

D Series Standard Accessories

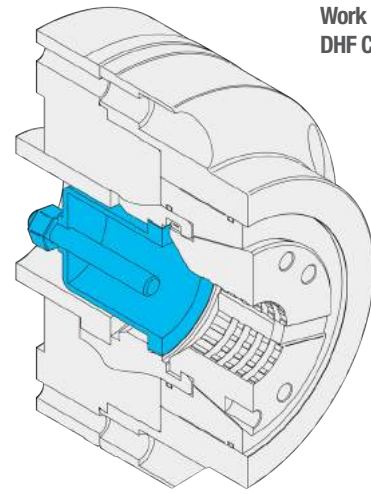
Work Stops

- 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



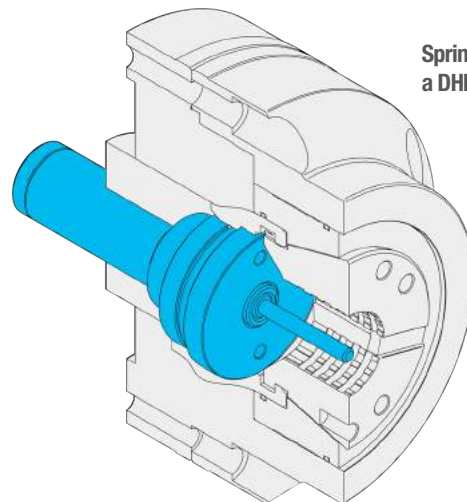
Additional Length Work Stop on a DHF Collet Chuck



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

