



MANDRELS COLLET CHUCKS

2015/2016

RÖHM
driven by technology

We work for customers who have a weakness for our strengths.

Companies intent on making a difference are obliged to develop constantly as well as deploy their strengths to the benefit of customers. At RÖHM, we have set ourselves high targets and are doing our very best to achieve them. This is why we support our customers all over the world by means of the six performance indicators so typical of RÖHM:



Dynamism

Variety

Security

Partnership

Globality

Innovation

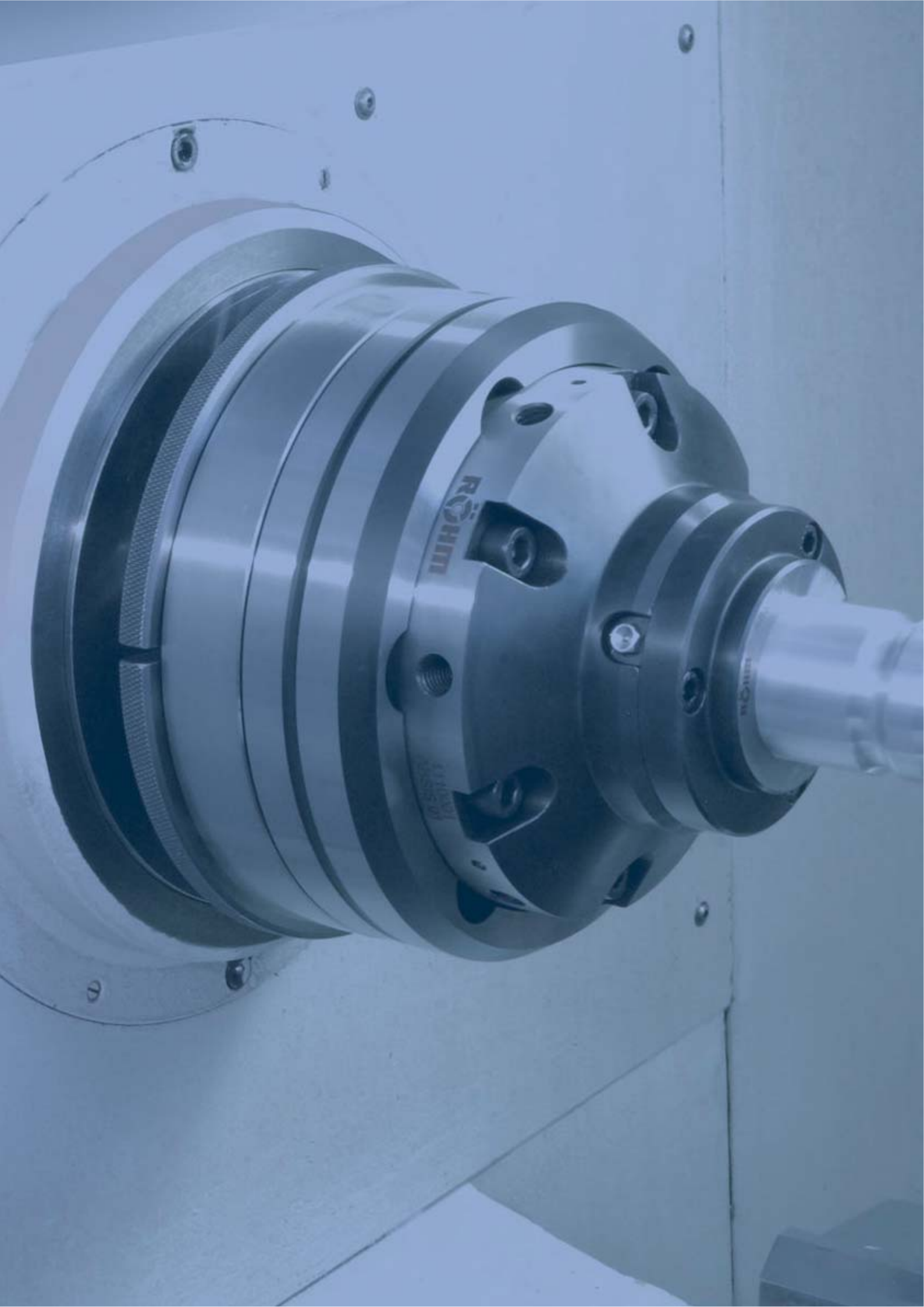


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Special solutions

7074



Orientation guide



TYPE	KFS/MFS	KFR/MFR	KFB	MZB	MZE	ABSYS	AGILIS	KFR-SE
	Cartridge mandrel					Segment clamping mandrel		
Feature	Stable clamping, suitable for long workpieces or long clamping lengths	Suitable for short clamping lengths with or without a defined axial component	Stable system with high torque transmission for working with small Ø, for short clamping lengths	Stable system with high torque transmission for working with small Ø, for short clamping lengths	Cost-effective system for measuring tasks, high accuracy	High degree of hardness of the clamping sleeve, thereby wear resistant, long service life of the clamping sleeve	Stable system with high torque transmission for working with small Ø, for short clamping lengths, high degree of hardness of the clamping sleeve	Suitable for short clamping lengths with or without a defined axial component
Application	Turning, grinding, milling, gear cutting, balancing, measuring	Turning, grinding, gear cutting, balancing, measuring	Turning, grinding, milling, gear cutting, balancing, measuring	Turning, grinding, measuring	Measuring, grinding	Turning, grinding, milling, gear cutting, balancing, measuring		Turning, grinding, milling, gear cutting, balancing, measuring
Clamping	Internal	Internal	Internal	Internal	Internal	Internal	Internal	Internal
Actuation	 	 						
Clamping surface	Smooth (optionally coated, serrated, toothed, for shape clamping)				Smooth	Smooth (optionally coated, serrated, toothed, for shape clamping)		
Axial component	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Clamping range mm	15 - 140	14,5 - 131	5,5 - 29	5,5 - 78,7	8 - 230	20 - 106	10 - 130	14,5 - 131
Workpiece stop possible	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Preparation for air sensing	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>				<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Take-up	Cylindrical take-up mount combined with Intermediate flange ISO 702-1 (DIN 55028)			Between points or cylindrical take-ups, driving at the shaft possible		Cylindrical take-up mount combined with Intermediate flange ISO 702-1 (DIN 55028)		
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Orientation guide



yes



optional



hand operated



power operated

Orientation guide

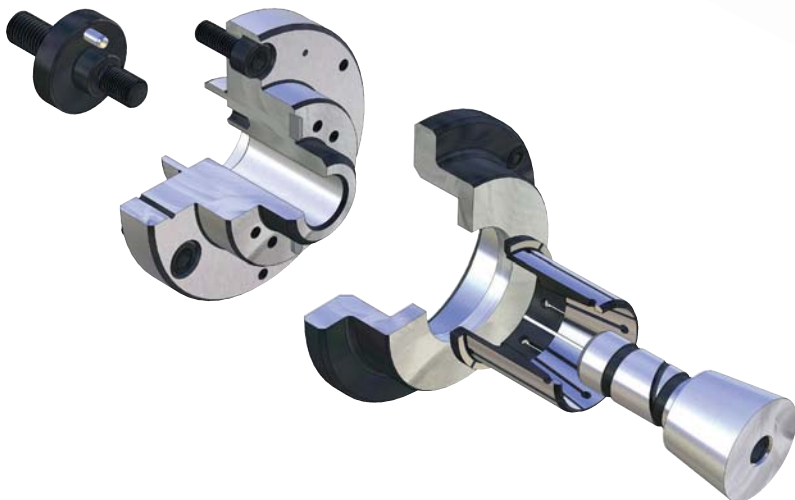


TYPE	CAPTIS-D	CAPTIS-A	CAPTIS-AF	CAPTIS-MS	ABSIS-C	KZF	KZF-S
	Collet chucks						
Feature	Full through-hole, with centering edge, draw-down	Restricted through-hole, optional fixed workpiece stop, draw-down	Restricted through-hole, fixed workpiece stop, stationary collet: without draw-down	Stationary, 3-sided clamped, manually operated	Stable system, for take-up into CAPTIS clamping system, with draw-down	Bayonet quick lock with protection against torsion	Bayonet quick lock, draw-down, actuation by clamping mandrel
Application	Turning, grinding, milling, gear cutting, balancing, measuring	Turning, grinding, milling, gear cutting, balancing, measuring	Turning, grinding, milling, gear cutting, balancing, measuring	Stationary turning, grinding, milling, drilling, measuring	Turning, grinding, milling, gear cutting, balancing, measuring	Turning, grinding, milling, measuring	Turning, grinding, milling, gear cutting
Clamping	External	External	External	External	Internal	External	External
Actuation							
Clamping surface	Longitudinal and cross grooves, cross grooves, smooth, shaped hexagon, square, special contour				Smooth (optionally coated, serrated, toothed, for shape clamping)	Smooth, hexagon, square	Optionally smooth, toothed, coated, serrated
Axial component	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>
Clamping range mm	4 - 120	4 - 120	4 - 120	4 - 120	20 - 106	2 - 80	30 - 180
Workpiece stop possible		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Preparation for air sensing							<input checked="" type="checkbox"/>
Take-up	Cylindrical take-up			Cylindrical mound, recording on the machine table, mounting via fastening thread	Take-up in CAPTIS clamp system	Cylindrical centering pick-up, short taper mount	Cylindrical take-up
Page	7062	7063	7064	7068	7069	7071	7072

We have already implemented special solutions in all clamping system areas, some of which differ significantly from the values indicated above (for example, clamping surfaces, clamping diameter or precision). Besides these standard clamping systems, we offer a number of special systems, such as HYKS, KFG, centering and face clamping systems or combination clamps. Even unusual special solutions are a part of our focus.



HIGH AXIAL RUN-OUT PRECISION; CONCENTRICITY AND REPEATABILITY



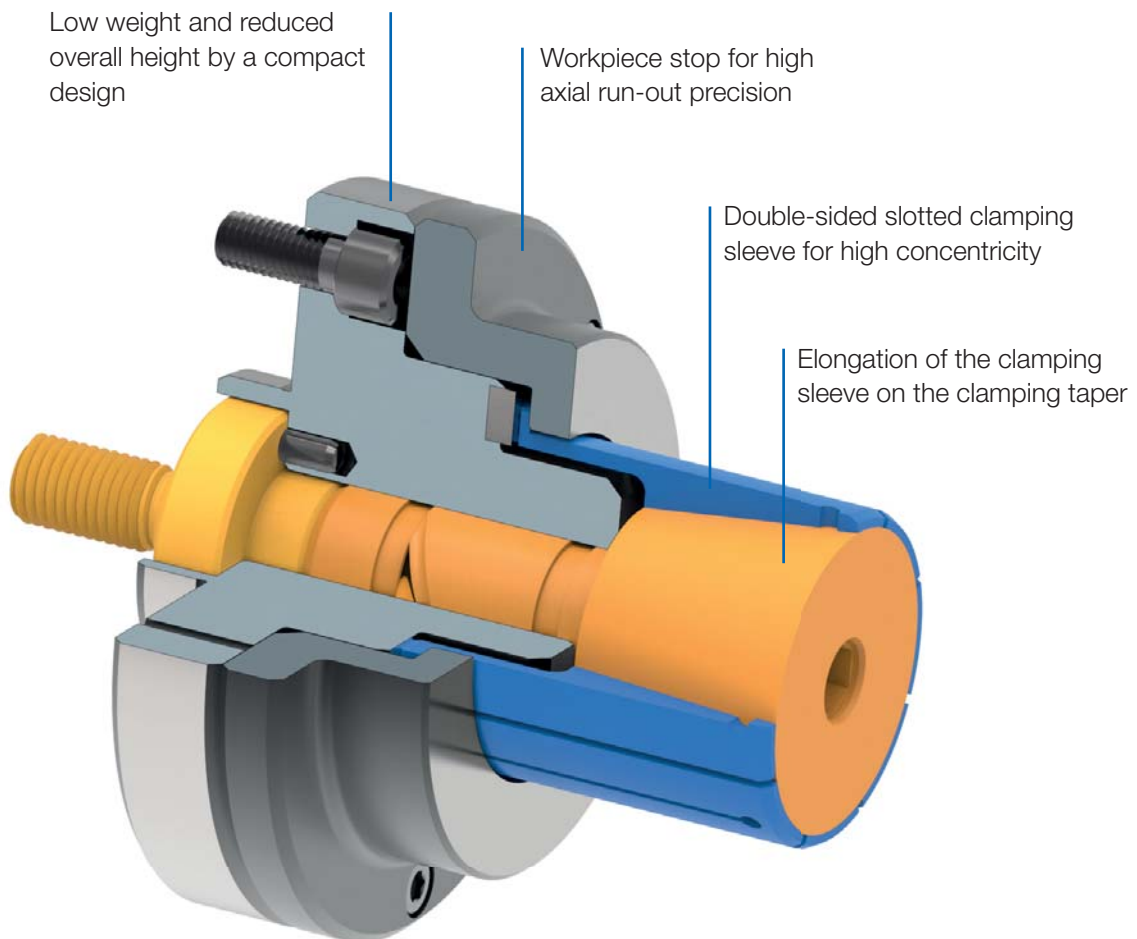
Custom-fit interaction of the individual components enables the highest degree of axial run-out precision, concentricity and repeatability.

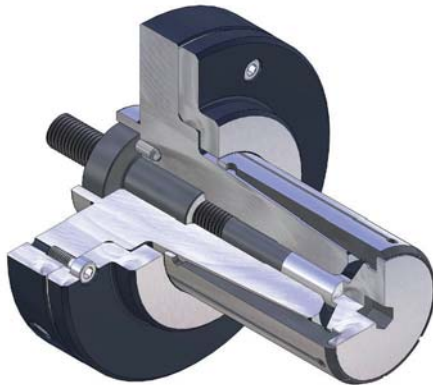
CARTRIDGE MANDRELS

The various application areas of the cartridge mandrels require a varied programme which ranges from manual or power-operated versions to versions with and without axial tension. The centric and comprehensive internal clamping of cartridge mandrels are particularly impressive for very small clamping diameters and at low overall heights.

ADVANTAGES AT A GLANCE

- ⊕ Stable clamping by axial tension against workpiece stop
- ⊕ Low weight and reduced overall height by a compact design
- ⊕ High axial run-out precision, concentricity and repeatability





APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring. Ideal for thin-walled and long workpieces or long clamping lengths.

TYPE

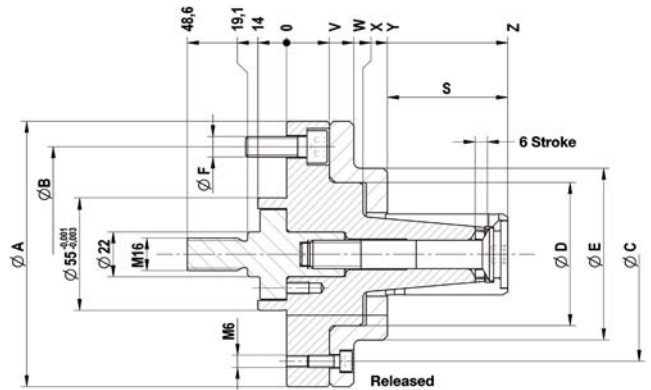
Force-actuated. Clamping sleeves optionally vulcanized. Convertible to MFS (required new intermediate piece).

CUSTOMER BENEFITS

- ③ Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- ③ High concentricity, axial run-out and repeatability
- ③ Light weight and reduced height thanks to compact design
- ③ High flexibility thanks to modular system
- ③ Fast change of clamping sleeves thanks to central clamping screw

TECHNICAL FEATURES

- Hardened, low-wear design
- Integrated lubrication
- Air sensing prepared



C18
KFS cartridge mandrel

Consisting of basic mandrel and intermediate piece

	KFS 00	KFS 01	KFS 02	KFS 03	KFS 04	KFS 05	KFS 06	KFS 07	KFS 08	KFS 09	KFS 10	KFS 11
Cartridge Mandrel	599800	599801	599802	599803	599804	599805	599806	599807	599808	599809	599810	599811
Basic mandrel	599820	599821	599822	599823	599824	599825	599826	599827	599828	599829	599830	599831
Adapter power operated	599833	599834	599980	599981	599982	599983	599984	599984	599984	315456	315456	315456
F max, in kN	7	9	12	12	15	15	20	20	25	25	25	25
Min-Ø unclamped from	14,7	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	81,7	100,7	119,7
Min-Ø unclamped to	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	81,7	100,7	119,7	139,7
Clamping-Ø max,	20,7	25,7	30,7	35,7	40,7	45,7	55,7	65,7	82,7	101,7	120,7	140,7
External-Ø A	100	100	100	100	100	130	130	130	160	160	160	160
Pitch diameter B	75	75	75	75	75	105	105	105	130	130	130	130
Pitch diameter C	75	75	75	75	75	105	105	105	130	130	130	149
Ø D mm	40	40	46	46	46	70	70	70	83	91	87	107
Ø E mm	54	54	60	60	60	84	84	84	103	160	160	160
Ø F mm	M10	M10	M10	M10	M10	M10	M10	M10	M12	M12	M12	M12
S mm	31,5	36	45	49	59	59	79	89	99	121	138,9	171
V mm	21	21	21	21	21	21	21	21	23	21	21	25
W mm	33	33	33	33	33	33	33	33	35	21	21	25
X mm	36	36	37	41	36,5	37,5	35,5	35,5	35			
Y mm	47,5	47,5	48	51,5	46	49,5	47	47	47	33	37	57
Z mm	79	83,5	93	100,5	105	108,5	126	136	146	154	176	228

Max. clamping force kN: 3,7-4,7-6,4-6,4-8,0-7,9-10,5-10,5-13,5-13,5-13,5-13,0

MFS



APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring. Ideal for thin-walled and long workpieces or long clamping lengths.

TYPE

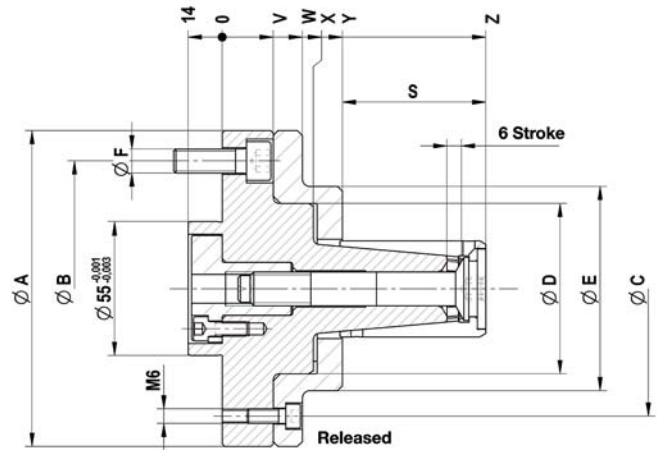
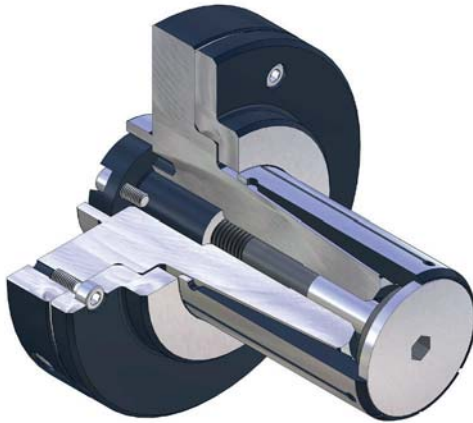
Manually actuated. Clamping sleeves optionally vulcanized. Convertible to KFS (new adapter required).

CUSTOMER BENEFITS

- ④ Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- ④ High concentricity, axial run-out and repeatability
- ④ Light weight and reduced height thanks to compact design
- ④ High flexibility thanks to modular system
- ④ Fast change of clamping sleeves thanks to central clamping screw

TECHNICAL FEATURES

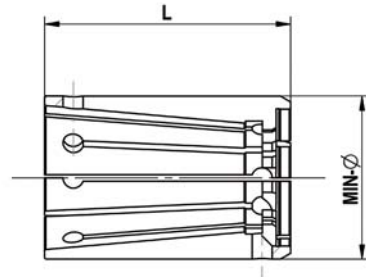
- Hardened, low-wear design
- Integrated lubrication
- Air sensing prepared



C18
MFS cartridge mandrel
Consisting of basic mandrel and intermediate piece

	MFS 00	MFS 01	MFS 02	MFS 03	MFS 04	MFS 05	MFS 06
Cartridge Mandrel	1082800	1082801	1082802	1082803	1082804	1082805	1082806
Basic mandrel	599820	599821	599822	599823	599824	599825	599826
Adapter hand-operated	599985	599986	599987	599988	599989	599990	599991
Md max, kN	7	12	20	22	30	35	45
Min-Ø unclamped from	14,7	19,7	24,7	29,7	34,7	39,7	44,7
Min-Ø unclamped to	19,7	24,7	29,7	34,7	39,7	44,7	54,7
Clamping-Ø max,	20,7	25,7	30,7	35,7	40,7	45,7	55,7
External-Ø A	100	100	100	100	100	130	130
Pitch diameter B	75	75	75	75	75	105	105
Pitch diameter C	75	75	75	75	75	105	105
Ø D mm	40	40	46	46	46	70	70
Ø E mm	54	54	60	60	60	84	84
Ø F mm	M10	M10	M10	M10	M10	M10	M10
S mm	31,5	36	45	49	59	59	79
V mm	21	21	21	21	21	21	21
W mm	33	33	33	33	33	33	33
X mm	36	36	37	41	36,5	37,5	35,5
Y mm	47,5	47,5	48	51,5	46	49,5	47
Z mm	79	83,5	93	100,5	105	108,5	126

Accessories KFS / MFS



C18
Clamping set KFS/MFS (not vulcanized), consisting of clamping sleeve and clamping screw

For size	00	01	02	03	04	05	06	07	08	09	10	11
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1
Length L mm	35	40	46	50	60	60	80	90	100	122	140	180
Min-Ø mm	14,7	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	100,7	100,7	119,7
Clamping set	1086311	1086322	1086333	1086344	1086355	1086366	1086377	1086388 ▲	1086399 ▲	1086436 ▲	1086437 ▲	1086457 ▲
Clamping sleeve	315330	315331	315332	315333	315334	315335	315336	315337 ▲	315338 ▲	650160 ▲	315340 ▲	315302 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599840	599845	599850	599855	599860	599865	599866	599992	599993 ▲	599994 ▲	599925 ▲	599997 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	15,2	20,2	25,2	30,2	35,2	40,2	45,7	55,7	65,7	81,7	101,7	120,7
Clamping set	1086312	1086323	1086334	1086345	1086356	1086367	1086378	1086389 ▲	1086400 ▲	1086417 ▲	1086438 ▲	1086458 ▲
Clamping sleeve	650021	650034	650047	650060	650073	650086	650098	650110 ▲	650123 ▲	315339 ▲	650163 ▲	650184 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599841	599846	599851	599856	599861	599866	599870	599880 ▲	599890 ▲	599995 ▲	599926 ▲	599945 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	15,7	20,7	25,7	30,7	35,7	40,7	46,7	56,7	66,7	82,7	102,7	121,7
Clamping set	1086313	1086324	1086335	1086346	1086357	1086368	1086379	1086390 ▲	1086401 ▲	1086418 ▲	1086439 ▲	1086459 ▲
Clamping sleeve	315341	315342	315343	315344	315345	315346	315347	315348 ▲	315349 ▲	650142 ▲	315351 ▲	315303 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599841	599846	599851	599856	599861	599866	599871	599881 ▲	599891 ▲	599907 ▲	599927 ▲	599946 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	16,2	21,2	26,2	31,2	36,2	41,2	47,7	57,7	67,7	83,7	103,7	122,7
Clamping set	1086314	1086325	1086336	1086347	1086358	1086369	1086380	1086391 ▲	1086402 ▲	1086419 ▲	1086440 ▲	1086460 ▲
Clamping sleeve	650023	650036	650049	650062	650075	650088	650100	650112 ▲	650125 ▲	315350 ▲	650165 ▲	650186 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599842	599847	599852	599857	599862	599867	599872	599882 ▲	599892 ▲	599908 ▲	599928 ▲	599947 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	16,7	21,7	26,7	31,7	36,7	41,7	48,7	58,7	68,7	84,7	104,7	123,7
Clamping set	1086315	1086326	1086337	1086348	1086359	1086370	1086381	1086392 ▲	1086403 ▲	1086420 ▲	1086441 ▲	1086461 ▲
Clamping sleeve	315352	315353	315354	315355	315356	315357	315358	315359 ▲	315360 ▲	650144 ▲	315362 ▲	315304 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599842	599847	599852	599857	599862	599867	599873	599883 ▲	599893 ▲	599909 ▲	599929 ▲	599948 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	17,2	22,2	27,2	32,2	37,2	42,2	49,7	59,7	69,7	85,7	105,7	124,7
Clamping set	1086316	1086327	1086338	1086349	1086360	1086371	1086382	1086393 ▲	1086404 ▲	1086421 ▲	1086442 ▲	1086462 ▲
Clamping sleeve	650025	650038	650051	650064	650077	650090	315369	315370 ▲	315371 ▲	315361 ▲	650167 ▲	650188 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599843	599848	599853	599858	599863	599868	599874	599884 ▲	599894 ▲	599910 ▲	599930 ▲	599949 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	17,7	22,7	27,7	32,7	37,7	42,7	50,7	60,7	70,7	86,7	106,7	125,7
Clamping set	1086317	1086328	1086339	1086350	1086361	1086372	1086383	1086394 ▲	1086405 ▲	1086422 ▲	1086443 ▲	1086463 ▲
Clamping sleeve	315363	315364	315365	315366	315367	315368	315380	315381 ▲	315382 ▲	650146 ▲	315373 ▲	315403 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599843	599848	599853	599858	599863	599868	599875	599885 ▲	599895 ▲	599911 ▲	599931 ▲	599950 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	18,2	23,2	28,2	33,2	38,2	43,2	51,7	61,7	71,7	87,7	107,7	126,7
Clamping set	1086318	1086329	1086340	1086351	1086362	1086373	1086384	1086395 ▲	1086406 ▲	1086423 ▲	1086444 ▲	1086464 ▲
Clamping sleeve	650027	650040	650053	650066	650079	650092	650104	650116 ▲	650129 ▲	315372 ▲	650169 ▲	650190 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599844	599849	599854	599859	599864	599869	599876	599886 ▲	599896 ▲	599912 ▲	599932 ▲	599951 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	18,7	23,7	28,7	33,7	38,7	43,7	52,7	62,7	72,7	88,7	108,7	127,7
Clamping set	1086319	1086330	1086341	1086352	1086363	1086374	1086385	1086396 ▲	1086407 ▲	1086424 ▲	1086445 ▲	1086465 ▲
Clamping sleeve	315374	315375	315376	315377	315378	315379	315385	315386 ▲	315387 ▲	650148 ▲	315384 ▲	315404 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599844	599849	599854	599859	599864	599869	599877	599887 ▲	599897 ▲	599913 ▲	599933 ▲	599952 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	19,2	24,2	29,2	34,2	39,2	44,2	53,7	63,7	73,7	89,7	109,7	128,7
Clamping set	1086320	1086331	1086342	1086353	1086364	1086375	1086386	1086397 ▲	1086408 ▲	1086425 ▲	1086446 ▲	1086466 ▲
Clamping sleeve	650029	650042	650055	650068	650081	650094	650106	650118 ▲	650131 ▲	315383 ▲	650171 ▲	650192 ▲

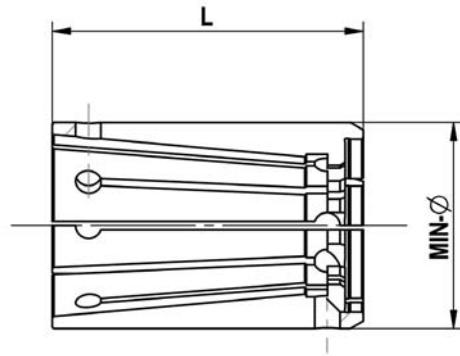
Accessories KFS / MFS

C18

Clamping set KFS/MFS (not vulcanized), consisting of clamping sleeve and clamping screw

For size	00	01	02	03	04	05	06	07	08	09	10	11
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1
Length L mm	35	40	46	50	60	60	80	90	100	122	140	180
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599966	599967	599968	599969	599970	599971	599878	599888 ▲	599898 ▲	599914 ▲	599934 ▲	599953 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	74,7	90,7	110,7	129,7
Clamping set	1086321	1086332	1086343	1086354	1086365	1086376	1086387	1086398 ▲	1086409 ▲	1086426 ▲	1086447 ▲	1086467 ▲
Clamping sleeve	650030	650043	650056	650069	650082	650095	650107	650119 ▲	315390 ▲	650150 ▲	315389 ▲	315405 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599966	599967	599968	599969	599970	599971	599879	599889 ▲	599899 ▲	599915 ▲	599935 ▲	599954 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									75,7	91,7	111,7	130,7
Clamping set									1086410 ▲	1086427 ▲	1086448 ▲	1086468 ▲
Clamping sleeve									650133 ▲	315388 ▲	650173 ▲	650194 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599900 ▲	599916 ▲	599936 ▲	599955 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									76,7	92,7	112,7	131,7
Clamping set									1086411 ▲	1086428 ▲	1086449 ▲	1086469 ▲
Clamping sleeve									315393 ▲	650152 ▲	315392 ▲	315406 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599901 ▲	599917 ▲	599937 ▲	599956 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									77,7	93,7	113,7	132,7
Clamping set									1086412 ▲	1086429 ▲	1086450 ▲	1086470 ▲
Clamping sleeve									650135 ▲	315391 ▲	650175 ▲	650196 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599902 ▲	599918 ▲	599938 ▲	599957 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									78,7	94,7	114,7	133,7
Clamping set									1086413 ▲	1086430 ▲	1086451 ▲	1086471 ▲
Clamping sleeve									315396 ▲	650154 ▲	315395 ▲	315407 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599903 ▲	599919 ▲	599939 ▲	599958 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									79,7	95,7	115,7	134,7
Clamping set									1086414 ▲	1086431 ▲	1086452 ▲	1086472 ▲
Clamping sleeve									650137 ▲	315394 ▲	650177 ▲	650198 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599904 ▲	599920 ▲	599940 ▲	599959 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									80,7	96,7	116,7	135,7
Clamping set									1086415 ▲	1086432 ▲	1086453 ▲	1086473 ▲
Clamping sleeve									315399 ▲	650156 ▲	315398 ▲	315408 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599905 ▲	599921 ▲	599941 ▲	599960 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									81,7	97,7	117,7	136,7
Clamping set									1086416 ▲	1086433 ▲	1086454 ▲	1086474 ▲
Clamping sleeve									650139 ▲	315397 ▲	650179 ▲	650200 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599906 ▲	599922 ▲	599942 ▲	599961 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm										98,7	118,7	137,7
Clamping set									1086434 ▲	1086455 ▲	1086475 ▲	
Clamping sleeve									650158 ▲	315401 ▲	315409 ▲	
Locking bolt									315478 ▲	315479 ▲	599998 ▲	
Work stop									599923 ▲	599943 ▲	599962 ▲	
Montage mandrel clamping									724185 ▲	724186 ▲	724187 ▲	
Min-Ø mm										99,7	119,7	138,7
Clamping set									1086435 ▲	1086456 ▲	1086476 ▲	
Clamping sleeve									315400 ▲	650181 ▲	650202 ▲	
Locking bolt									315478 ▲	315479 ▲	599998 ▲	
Work stop									599924 ▲	599944 ▲	599963 ▲	
Montage mandrel clamping									724185 ▲	724186 ▲	724187 ▲	
Min-Ø mm												139,7
Clamping set												1086477 ▲
Clamping sleeve												315410 ▲
Locking bolt												599998 ▲
Work stop												599964 ▲
Montage mandrel clamping												724187 ▲

Accessories KFS / MFS



C18

Clamping set KFS/MFS vulcanized, consisting of clamping sleeve and clamping screw

For size	00	01	02	03	04	05	06	07	08	09	10	11
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1
Length L mm	35	40	46	50	60	60	80	90	100	122	140	180
Min-Ø mm	14,7	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	100,7	100,7	119,7
Clamping set	1086511	1086522	1086533	1086544	1086555	1086566	1086577	1086588 ▲	1086599 ▲	1086636 ▲	1086637 ▲	1086657 ▲
Clamping sleeve vulcanized	315730	315731	315732	315733	315734	315735	315736	315737 ▲	315738 ▲	651100 ▲	315740 ▲	315702 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599840	599845	599850	599855	599860	599865	599992	599993 ▲	599994 ▲	599925 ▲	599996 ▲	599997 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	15,2	20,2	25,2	30,2	35,2	40,2	45,7	55,7	65,7	81,7	101,7	120,7
Clamping set	1086512	1086523	1086534	1086545	1086556	1086567	1086578	1086589 ▲	1086600 ▲	1086617 ▲	1086638 ▲	1086658 ▲
Clamping sleeve vulcanized	650211	650224	650239	650250	650263	650276	650288	651051 ▲	651063 ▲	315739 ▲	651103 ▲	651124 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599841	599846	599851	599856	599861	599866	599870	599880 ▲	599890 ▲	599995 ▲	599926 ▲	599945 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	15,7	20,7	25,7	30,7	35,7	40,7	46,7	56,7	66,7	82,7	102,7	121,7
Clamping set	1086513	1086524	1086535	1086546	1086557	1086568	1086579	1086590 ▲	1086601 ▲	1086618 ▲	1086639 ▲	1086659 ▲
Clamping sleeve vulcanized	315741	315742	315743	315744	315745	315746	315747	315748 ▲	315749 ▲	651082 ▲	315751 ▲	315703 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599841	599846	599851	599856	599861	599866	599871	599881 ▲	599891 ▲	599907 ▲	599927 ▲	599946 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	16,2	21,2	26,2	31,2	36,2	41,2	47,7	57,7	67,7	83,7	103,7	122,7
Clamping set	1086514	1086525	1086536	1086547	1086558	1086569	1086580	1086591 ▲	1086602 ▲	1086619 ▲	1086640 ▲	1086660 ▲
Clamping sleeve vulcanized	650213	650226	650239	650252	650265	650278	650290	651053 ▲	651065 ▲	315750 ▲	651105 ▲	651126 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599842	599847	599852	599857	599862	599867	599872	599882 ▲	599892 ▲	599908 ▲	599928 ▲	599947 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	16,7	21,7	26,7	31,7	36,7	41,7	48,7	58,7	68,7	84,7	104,7	123,7
Clamping set	1086515	1086526	1086537	1086548	1086559	1086570	1086581	1086592 ▲	1086603 ▲	1086620 ▲	1086641 ▲	1086661 ▲
Clamping sleeve vulcanized	315752	315753	315754	315755	315756	315757	315758	315759 ▲	315760 ▲	651084 ▲	315762 ▲	315704 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599842	599847	599852	599857	599862	599867	599873	599883 ▲	599893 ▲	599909 ▲	599929 ▲	599948 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	17,2	22,2	27,2	32,2	37,2	42,2	49,7	59,7	69,7	85,7	105,7	124,7
Clamping set	1086516	1086527	1086538	1086549	1086560	1086571	1086582	1086593 ▲	1086604 ▲	1086621 ▲	1086642 ▲	1086662 ▲
Clamping sleeve vulcanized	650215	650228	650241	650254	650267	650280	315769	315770 ▲	315771 ▲	315761 ▲	651107 ▲	651128 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599843	599848	599853	599858	599863	599868	599874	599884 ▲	599894 ▲	599910 ▲	599930 ▲	599949 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	17,7	22,7	27,7	32,7	37,7	42,7	50,7	60,7	70,7	86,7	106,7	125,7
Clamping set	1086517	1086528	1086539	1086550	1086561	1086572	1086583	1086594 ▲	1086605 ▲	1086622 ▲	1086643 ▲	1086663 ▲
Clamping sleeve vulcanized	315763	315764	315765	315766	315767	315768	315780	315781 ▲	315782 ▲	651086 ▲	315773 ▲	315705 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599843	599848	599853	599858	599863	599868	599875	599885 ▲	599895 ▲	599911 ▲	599931 ▲	599950 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	18,2	23,2	28,2	33,2	38,2	43,2	51,7	61,7	71,7	87,7	107,7	126,7
Clamping set	1086518	1086529	1086540	1086551	1086562	1086573	1086584	1086595 ▲	1086606 ▲	1086623 ▲	1086644 ▲	1086664 ▲
Clamping sleeve vulcanized	650217	650230	650243	650256	650269	650282	650294	651057 ▲	651069 ▲	315772 ▲	651109 ▲	651130 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599844	599849	599854	599859	599864	599869	599876	599886 ▲	599896 ▲	599912 ▲	599932 ▲	599951 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	18,7	23,7	28,7	33,7	38,7	43,7	52,7	62,7	72,7	88,7	108,7	127,7
Clamping set	1086519	1086530	1086541	1086552	1086563	1086574	1086585	1086596 ▲	1086607 ▲	1086624 ▲	1086645 ▲	1086665 ▲
Clamping sleeve vulcanized	315774	315775	315776	315777	315778	315779	315785	315786 ▲	315787 ▲	651088 ▲	315784 ▲	315706 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599844	599849	599854	599859	599864	599869	599877	599887 ▲	599897 ▲	599913 ▲	599933 ▲	599952 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	19,2	24,2	29,2	34,2	39,2	44,2	53,7	63,7	73,7	89,7	109,7	128,7
Clamping set	1086520	1086531	1086542	1086553	1086564	1086575	1086586	1086597 ▲	1086608 ▲	1086625 ▲	1086646 ▲	1086666 ▲

Accessories KFS / MFS

C18

Clamping set KFS/MFS vulcanized, consisting of clamping sleeve and clamping screw

For size	00	01	02	03	04	05	06	07	08	09	10	11
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1
Length L mm	35	40	46	50	60	60	80	90	100	122	140	180
Clamping sleeve vulcanized	650219	650232	650245	650258	650271	650284	650296	651059 ▲	651071 ▲	315783 ▲	651111 ▲	651132 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599966	599967	599968	599969	599970	599971	599978	599888 ▲	599898 ▲	599914 ▲	599934 ▲	599953 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	74,7	90,7	110,7	129,7
Clamping set	1086521	1086532	1086543	1086554	1086565	1086576	1086587	1086598 ▲	1086609 ▲	1086626	1086647 ▲	1086667 ▲
Clamping sleeve vulcanized	650220	650233	650246	650259	650272	650285	650297	651060 ▲	315790 ▲	651090	315789 ▲	315707 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476 ▲	315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop	599966	599967	599968	599969	599970	599971	599879	599889 ▲	599899 ▲	599915 ▲	599935 ▲	599954 ▲
Montage mandrel clamping	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									75,7	91,7	111,7	130,7
Clamping set									1086610 ▲	1086627	1086648 ▲	1086668 ▲
Clamping sleeve vulcanized									651073 ▲	315788	651113 ▲	651134 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599900 ▲	599916 ▲	599936 ▲	599955 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									76,7	92,7	112,7	131,7
Clamping set									1086611 ▲	1086628	1086649 ▲	1086669 ▲
Clamping sleeve vulcanized									651074 ▲	651092	651114 ▲	651135 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599901 ▲	599917 ▲	599937 ▲	599956 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									77,7	93,7	113,7	132,7
Clamping set									1086612 ▲	1086629	1086650 ▲	1086670 ▲
Clamping sleeve vulcanized									651075 ▲	651093	651115 ▲	651136 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599902 ▲	599918 ▲	599938 ▲	599957 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									78,7	94,7	114,7	133,7
Clamping set									1086613 ▲	1086630	1086651 ▲	1086671 ▲
Clamping sleeve vulcanized									315796 ▲	651094	315795 ▲	315709 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599903 ▲	599919 ▲	599939 ▲	599958 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									79,7	95,7	115,7	134,7
Clamping set									1086614 ▲	1086631	1086652 ▲	1086672 ▲
Clamping sleeve vulcanized									651077 ▲	315794	651117 ▲	651138 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599904 ▲	599920 ▲	599940 ▲	599959 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									80,7	96,7	116,7	135,7
Clamping set									1086615 ▲	1086632	1086653 ▲	1086673 ▲
Clamping sleeve vulcanized									315799 ▲	651096	315798 ▲	315710 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599905 ▲	599921 ▲	599941 ▲	599960 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									81,7	97,7	117,7	136,7
Clamping set									1086616 ▲	1086633	1086654 ▲	1086674 ▲
Clamping sleeve vulcanized									651079 ▲	315797	651119 ▲	651140 ▲
Locking bolt									315477 ▲	315478 ▲	315479 ▲	599998 ▲
Work stop									599906 ▲	599922 ▲	599942 ▲	599961 ▲
Montage mandrel clamping									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm										98,7	118,7	137,7
Clamping set									1086634	1086655 ▲	1086675 ▲	
Clamping sleeve vulcanized									651098	315801 ▲	315711 ▲	
Locking bolt									315478 ▲	315479 ▲	599998 ▲	
Work stop									599923 ▲	599943 ▲	599962 ▲	
Montage mandrel clamping									724185 ▲	724186 ▲	724187 ▲	
Min-Ø mm										99,7	119,7	138,7
Clamping set									1086635	1086656 ▲	1086676 ▲	
Clamping sleeve vulcanized									315800	651121 ▲	651142 ▲	
Locking bolt									315478 ▲	315479 ▲	599998 ▲	
Work stop									599924 ▲	599944 ▲	599963 ▲	
Montage mandrel clamping									724185 ▲	724186 ▲	724187 ▲	
Min-Ø mm												139,7
Clamping set												1086677 ▲
Clamping sleeve vulcanized												315712 ▲
Locking bolt												599998 ▲
Work stop												599964 ▲
Montage mandrel clamping												724187 ▲

Intermediate flange KFS / MFS



APPLICATION

For adaptation of cartridge mandrel KFR/MFR/KFR-SE/MFR-SE or KFS/MFS - on spindle head ISO 702-1 / ISO 702-3 (DIN 55021/55022/55026 and 55027).

TYPE

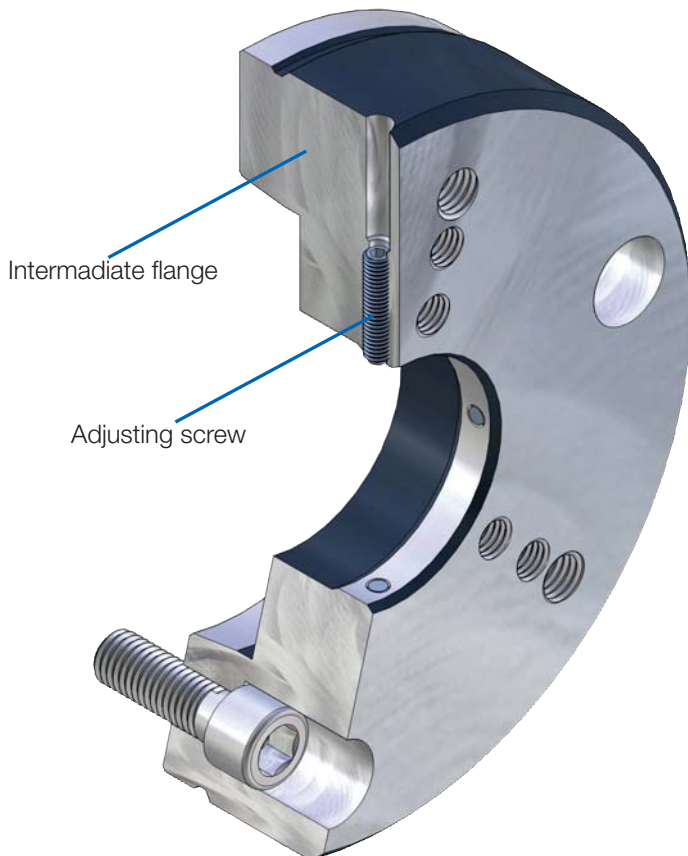
For KFR/MFR/KFR-SE/MFR-SE or KFS/MFS.

CUSTOMER BENEFITS

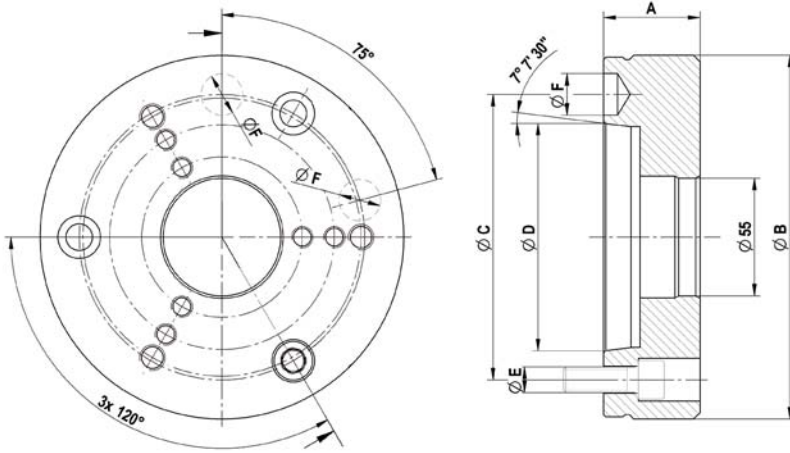
- By replacement of the intermediate flange, one cartridge mandrel can be used on different machines

TECHNICAL FEATURES

Adaptation of KFR/MFR/KFR-SE/MFR-SE cartridge mandrel or KFS/MFS on spindle head, with or without adjusting screw, with or without performing air sensing. Version acc. to ISO 702-1 (DIN 55028-A) or ISO 702-3 (DIN 55028-C), in size no. 5, no. 6, no. 8, no. 11 or no. 5, no. 6, no. 8 (A5, A6, A8, A11 or C5, C6, C8).

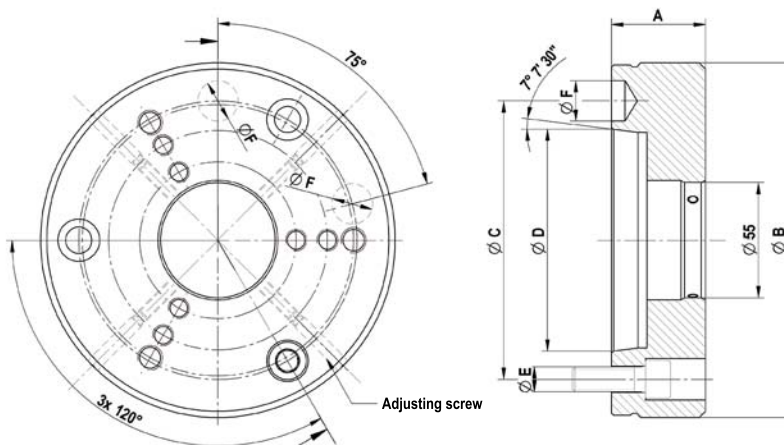


Accessories KFS / MFS



C 18
Intermediate flange ISO 702-1 (DIN 55026/55021) without adjusting screws

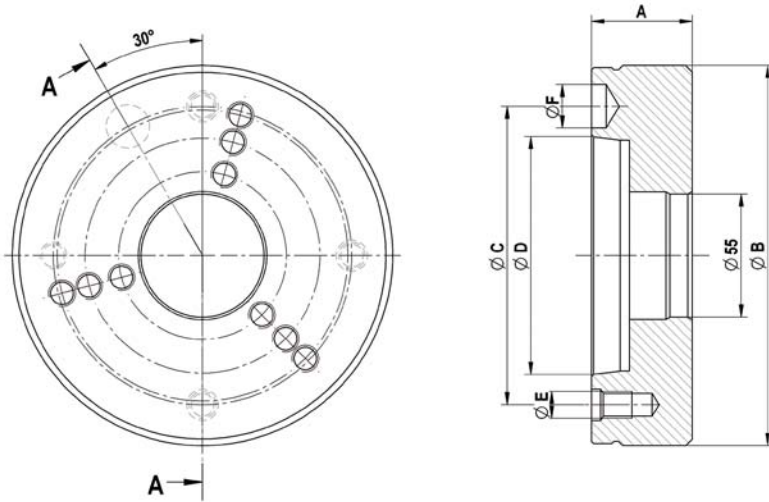
	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Intermediate flange	893975	893976	893977	893978 ▲
Design	without air-sensing	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50	50
Ø B	165	170	220	282
Ø C mm	104,8	133,4	171,4	235
Ø D mm	82,563	106,375	139,719	196,869
Ø E	M10	M12	M16	M20
Ø F mm	16,3	19,45	24,2	29,4



C 18
Intermediate flange ISO 702-1 (DIN 55028) with adjusting screw

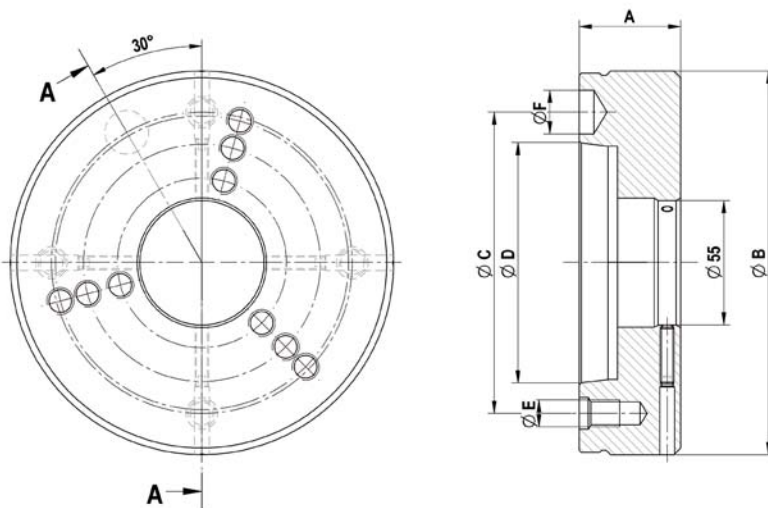
	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)
Intermediate flange	893979	893980	893981
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M10	M12	M16
Ø F mm	16,3	19,45	24,2

Accessories KFS / MFS



C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) without adjusting screws

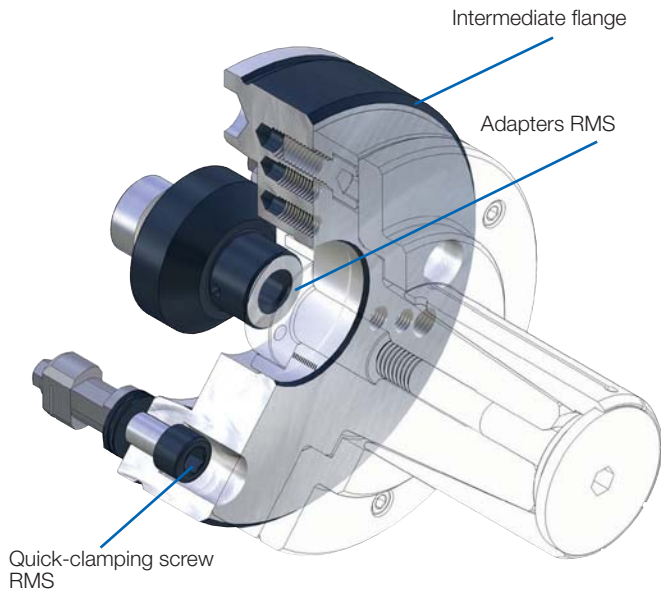
	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	893982	893983	893984
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2



C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) with adjusting screws

	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	893985	893986	893987
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2

Accessories KFS / MFS



APPLICATION

For manual clamping devices exchange in a minimum of time.

TYPE

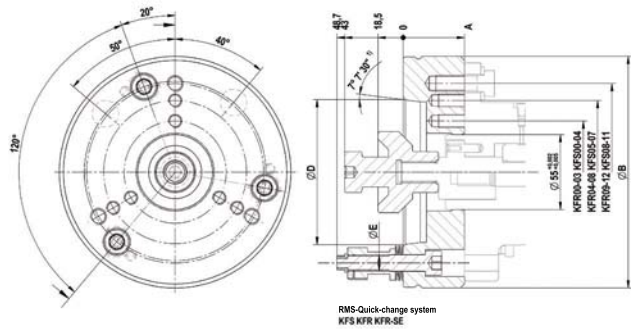
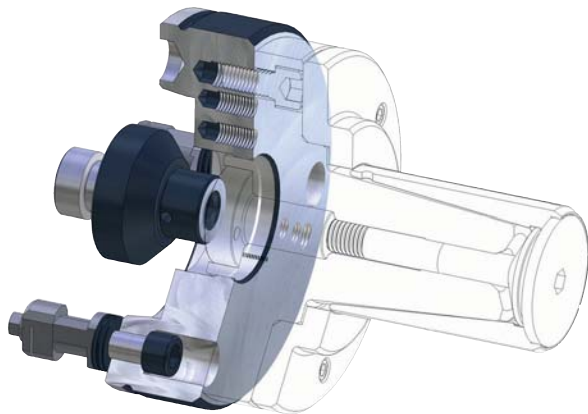
Manual quick-change system for clamping devices. Fits KFR/MFR or KFS/MFS. Central lubrication and / or air sensing control possible.

CUSTOMER BENEFITS

- ⌚ Manual clamping devices change in about 30 seconds
- ⌚ High change precision within 0.005 mm
- ⌚ Quick change of different clamping devices with short time, similar to the automatic or semiautomatic clamping devices changing systems

TECHNICAL FEATURES

- Quick-change system suitable due to recording RMS see quick-change system RMS (Product Group 6)
- Corresponds to the guidelines of the Employer's Liability Insurance Association in combination with RÖHM safety clamping cylinder OVS and LVS

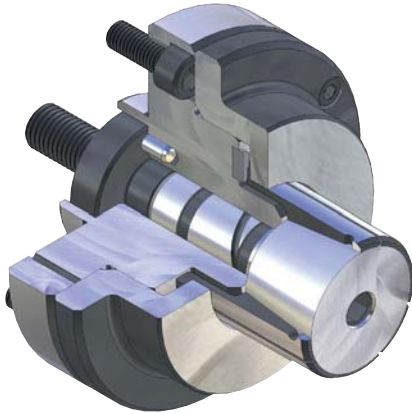


C18

RMS quick-change system, hand-operated for clamping devices

	KK 06	KK 08
RMS - complete (flange incl, quick-clamping screw)	1160026 ▲	1160027 ▲
Adapters RMS	1183310 ▲	1183311 ▲
A	45	50
Ø B	170	220
Ø C	133,4	171,4
Ø D	106,375	139,719
Ø E mm	M12	M16
Ø F mm	55 (+0,003/+0,001)	55 (+0,003/+0,001)

KFR - without axial tightening



APPLICATION

Internal clamping of round workpieces. Turning, grinding and tothing operations, as well as for balancing and measuring.
Ideal for short clamping lengths / workpieces.

TYPE

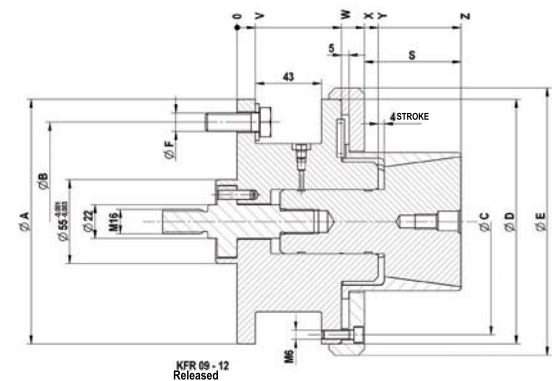
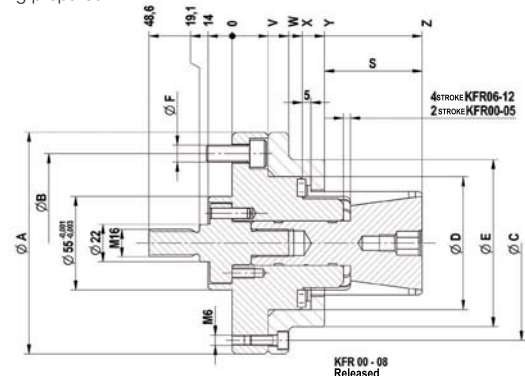
Force-actuated. Clamping sleeves optionally vulcanized.
Convertible to MFR (new intermediate piece required).

CUSTOMER BENEFITS

- ③ No workpiece tension thanks to def. axial tension against the workpiece stop
- ③ High concentricity, axial run-out and repeatability
- ③ Low-maintenance

TECHNICAL FEATURES

- Hardened, low-wear design
- Integrated lubrication
- Air sensing prepared

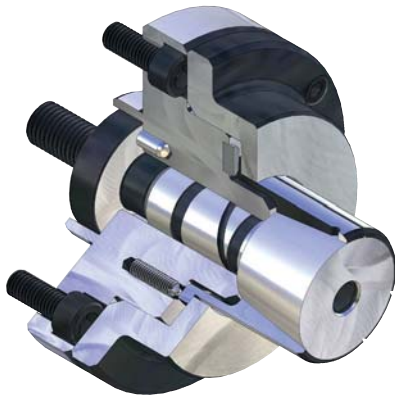


C18
KFR cartridge mandrel, power-operated with flanged seat, for internal clamping
Consisting of basic body, clamping taper, intermediate piece, nut

	KFR 00	KFR 01	KFR 02	KFR 03	KFR 04	KFR 05	KFR 06	KFR 07	KFR 08	KFR 09	KFR 10	KFR 11	KFR 12
Cartridge Mandrel	893960	893961	893962	893963	893964	893965	893966 ▲	893967 ▲	893968 ▲	893969 ▲	893970 ▲	893971 ▲	893972 ▲
Base bolt	893800	893801	893802	893803	893804	893805	893806 ▲	893807 ▲	893807 ▲	893809 ▲	893809 ▲	893809 ▲	893809 ▲
Clamping taper	650340	650341	650342	650343	650344	650345	650346 ▲	650347 ▲	650348 ▲	650349 ▲	650350 ▲	650351 ▲	650352 ▲
Adapter power operated	893816	893817	893818	893819	893820	893820	893821 ▲	893822 ▲	893822 ▲	893822 ▲	893822 ▲	893822 ▲	893822 ▲
Nut	893814	893814	893814										
F max, in kN	4,65	13,1	19,5	24,4	26,8	33	33	33	33	33	33	33	33
Max, total clamping force							140	140	140	140	140	140	140
Min-Ø unclamped from	14,2	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7	90,7	100,7	110,7	120,7
Min-Ø unclamped to	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7	90,7	100,7	110,7	120,7	130,7
Clamping-Ø max,	20,2	25,7	35,72	40,7	61,2	61,2	71,7	81,7	91,7	101,7	111,7	121,7	131,7
External-Ø A	100	100	100	100	130	130	130	160	160	160	160	160	160
Pitch diameter B	75	75	75	75	105	105	105	130	130	130	130	130	130
Pitch diameter C	85	85	85	85	114	114	114	145	145	148	148	148	148
Ø C mm							98	130	130	175	175	175	175
Ø D mm	50	50	50	50	78	78	78	100	100	160	160	160	160
Ø E mm	70	70	70	70	98	98	98	130	130	175	175	175	175
Ø F mm	M10	M10	M10	M10	M10	M10	M10	M12	M12	M12	M12	M12	M12
S mm	21	27	27	27	42	42	57	55	55	63	63	63	63
V mm	21	21	21	21	21	21	21	32	32	12	12	12	12
W mm	33	33	33	33	33	33	33	50	50	68	68	68	68
X mm	39	39	39	39	41	41	41	58	58	83	83	83	83
Y mm	50	52	52	52	54	54	54	73	73	92	92	92	92
Z mm	71	79	79	79	96	96	111	128	128	146	146	146	146

Max. clamping force kN: 1,9-5,5-8,3-10,4-11,4-14,0-14,0-14,0-14,0-14,0-14,0-14,0-14,0

KFR - with axial tightening



APPLICATION

Internal clamping of round workpieces. Turning, grinding and tothing operations, as well as for balancing and measuring. Ideal for short clamping lengths / workpieces.

TYPE

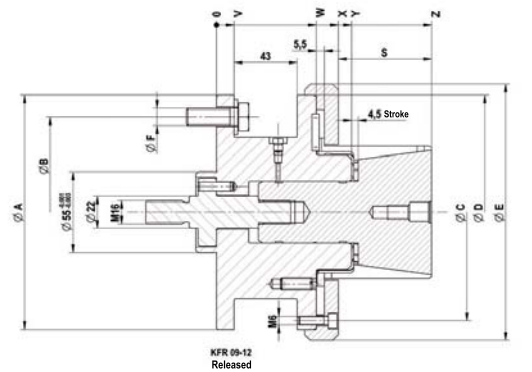
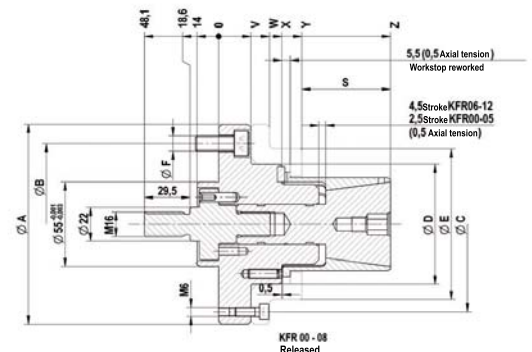
Force-actuated. Sleeve optional vulcanized. Convertible to MFR (new intermediate piece required).

CUSTOMER BENEFITS

- ① No workpiece tension thanks to def. axial tension against the workpiece stop
- ② High concentricity, axial run-out and repeatability
- ③ Low-maintenance

TECHNICAL FEATURES

- Hardened, low-wear design
- Integrated lubrication
- Air sensing φ



C18
KFR cartridge mandrel, power-operated with flanged seat, for internal clamping
Consisting of basic body, clamping taper, intermediate piece, nut

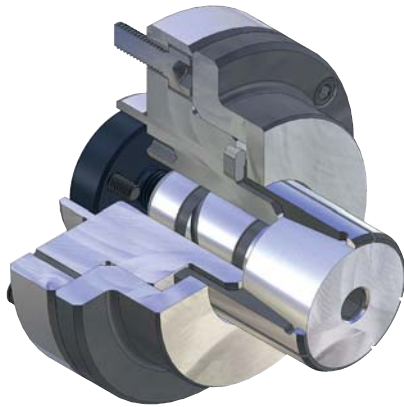
	KFR 00	KFR 01	KFR 02	KFR 03	KFR 04	KFR 05	KFR 06	KFR 07	KFR 08	KFR 09	KFR 10	KFR 11	KFR 12
Cartridge Mandrel	1077600	1077601	1077602	1077603	1077604	1077605	1077606	1077607	1077608	1077609	1077610	1077611	1077612
Base bolt	1077620	1077621	1077622	1077623	1077624	1077625	1077626	1077627	1077627	1077628	1077628	1077628	1077628
Clamping taper	650340	650341	650342	650343	650344	650345	650346 ▲	650347 ▲	650348 ▲	650349 ▲	650350 ▲	650351 ▲	650352 ▲
Adapter power operated	1061892	1061919	1077615	1061921	1050020	1050020	1050021	1077619	1077619	1077619	1077619	1077619	1077619
Nut	893814	893814	893814										
F max, in kN	4,65	13,1	19,5	24,4	26,8	33	33	33	33	33	33	33	33
Max, total clamping force approx, kN	20	56	83	104	114	140	140	140	140	140	140	140	140
Min-Ø unclamped from	14,2	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7	90,7	100,7	110,7	120,7
Min-Ø unclamped to	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7	90,7	100,7	110,7	120,7	130,7
Clamping-Ø max,	20,2	25,7	35,7	40,7	50,7	61,3	71,7	81,7	91,7	101,7	111,7	121,7	131,7
External-Ø A	100	100	100	100	130	130	130	160	160	160	160	160	160
Pitch diameter B	75	75	75	75	105	105	105	130	130	130	130	130	130
Pitch diameter C	85	85	85	85	114	114	114	145	145	148	148	148	148
Ø D mm	50	50	50	50	78	78	78	100	100	160	160	160	160
Ø E mm	70	70	70	70	98	98	98	130	130	175	175	175	175
Ø F mm	M10	M10	M10	M10	M10	M10	M10	M12	M12	M12	M12	M12	M12
S mm	21,5	27,5	27,5	27,5	42,5	42,5	57,5	55,5	55,5	63,5	63,5	63,5	63,5
V mm	21	21	21	21	21	21	21	32	32	12	12	12	12
W mm	33	33	33	33	33	33	33	50	50	68	68	68	68
X mm	39	39	39	39	41	41	41	58	58	92	92	92	92
Y mm	50	52	52	52	54	54	54	73	73	83	83	83	83
Z mm	71,5	79,5	79,5	79,5	96,5	96,5	111,5	128,5	128,5	146,5	146,5	146,5	146,5

Max. clamping force: 1,9-5,5-8,3-10,4-11,4-14,0-14,0-14,0-14,0-14,0-14,0-14,0-14,0

▲ on request

Cartridge Mandrel KFR

MFR - without axial tightening



APPLICATION

Internal clamping of round workpieces. Turning, grinding and toothing operations, as well as for balancing and measuring. Ideal for short clamping lengths / workpieces.

TYPE

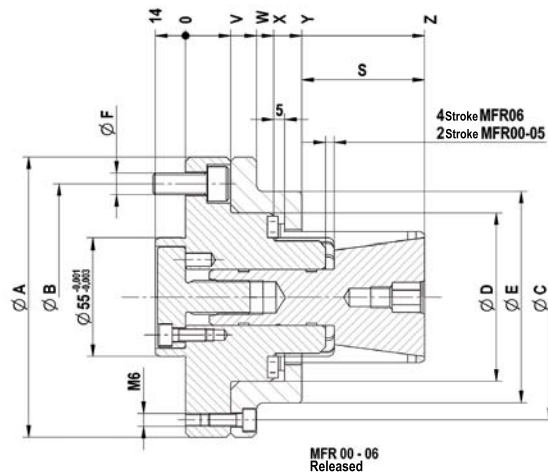
Manually actuated.
Optional vulcanized clamping sleeves/segment sleeves (segment clamping mandrel KFR-SE).

CUSTOMER BENEFITS

- ⊕ No workpiece tension thanks to def. axial tension against the workpiece stop
- ⊕ High concentricity, axial run-out and repeatability
- ⊕ Low-maintenance

TECHNICAL FEATURES

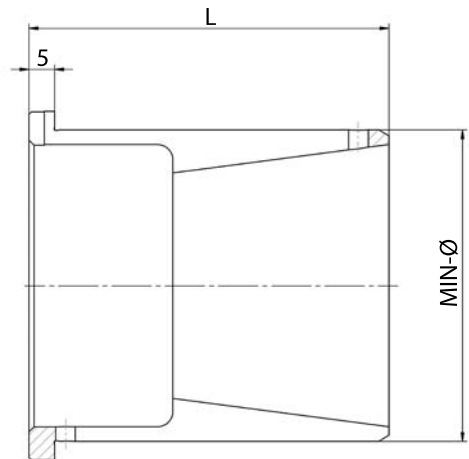
- Hardened, low-wear design
- Integrated lubrication
- Air sensing prepared



C18
MFR cartridge mandrel, hand-operated with flanged seat, for internal clamping
Consisting of basic body, clamping taper, intermediate piece

	MFR 00	MFR 01	MFR 02	MFR 03	MFR 04	MFR 05	MFR 06
Cartridge Mandrel	1077700	1077701	1077702	1077703	1077704	1077705	1077706 ▲
Base bolt	893800	893801	893802	893803	893804	893805	893806 ▲
Clamping taper	650340	650341	650342	650343	650344	650345	650346 ▲
Adapter hand-operated	893823	893824	893825	893826	893827	893827	893828 ▲
Md max, kN	4	5	40	55	60	75	85
Min-Ø unclamped from	14,2	19,7	25,2	35,2	40,2	50,2	60,7
Min-Ø unclamped to	19,7	25,2	35,2	40,2	50,2	60,7	70,7
Clamping-Ø max,	20,2	25,7	35,7	40,7	50,7	61,2	71,7
External-Ø A	100	100	100	100	130	130	130
Pitch diameter B	75	75	75	75	105	105	105
Pitch diameter C	85	85	85	85	114	114	114
Ø D mm	50	50	50	50	78	78	78
Ø E mm	70	70	70	70	98	98	98
Ø F mm	M10	M10	M10	M10	M10	M10	M10
S mm	21	27	27	27	42	42	57
V mm	21	21	21	21	21	21	21
W mm	33	33	33	33	33	33	33
X mm	39	39	39	39	41	41	41
Y mm	50	52	52	52	54	54	54
Z mm	71	79	79	79	96	96	111

Accessories KFR / MFR



C 18

Clamping sleeve Type R - standard design (not vulcanized)

For size	00	01	02	03	04	05	06	07	08	09	10	11	12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length L	32	40	40	40	55	55	70	70	70	78	78	78	78
Min-Ø mm	14,2	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7	100,7	100,7	110,7	120,7
Clamping sleeve	1015500	1015513	1015526	1015548	1015560	1015582	1015605 ▲	1015617 ▲	1015629 ▲	1015651 ▲	1015653 ▲	1015665 ▲	1015677 ▲
Work stop	893830	893836	893842	893852	893857	893867	893878	893888	893897	893916	893917	893927	893937
Min-Ø mm	14,7	20,2	25,7	35,7	40,7	50,7	61,7	71,7	81,7	90,7	101,7	111,7	121,7
Clamping sleeve	1015501	1015514	1015527	1015549	1015561	1015583	1015606 ▲	1015618 ▲	1015630 ▲	1015641 ▲	1015654 ▲	1015666 ▲	1015678 ▲
Work stop	893830	893836	893842	893852	893857	893867	893879	893889	893898	893907	893918	893928	893938
Min-Ø mm	15,2	20,7	26,2	36,2	41,2	51,2	62,7	72,7	82,7	91,7	102,7	112,7	122,7
Clamping sleeve	1015502	1015515	1015528	1015550	1015562	1015584	1015607 ▲	1015619 ▲	1015631 ▲	1015642 ▲	1015655 ▲	1015667 ▲	1015679 ▲
Work stop	893830	893837	893842	893852	893857	893867	893880	893890	893899	893908	893919	893929	893939
Min-Ø mm	15,7	21,2	26,7	36,7	41,7	51,7	63,7	73,7	83,7	92,7	103,7	113,7	123,7
Clamping sleeve	1015503	1015516	1015529	1015551	1015563	1015585	1015608 ▲	1015620 ▲	1015632 ▲	1015643 ▲	1015656 ▲	1015668 ▲	1015680 ▲
Work stop	893831	893837	893843	893853	893858	893868	893881	893891	893900	893909	893920	893930	893940
Min-Ø mm	16,2	21,7	27,2	37,2	42,2	52,2	64,7	74,7	84,7	93,7	104,7	114,7	124,7
Clamping sleeve	1015504	1015517	1015530	1015552	1015564	1015586	1015609 ▲	1015621 ▲	1015633 ▲	1015644 ▲	1015657 ▲	1015669 ▲	1015681 ▲
Work stop	893831	893838	893843	893853	893858	893868	893882	893892	893901	893910	893921	893931	893941
Min-Ø mm	16,7	22,2	27,7	37,7	42,7	52,7	65,7	75,7	85,7	94,7	105,7	115,7	125,7
Clamping sleeve	1015505	1015518	1015531	1015553	1015565	1015587	1015610 ▲	1015622 ▲	1015634 ▲	1015645 ▲	1015658 ▲	1015670 ▲	1015682 ▲
Work stop	893832	893838	893844	893854	893859	893869	893883	893893	893902	893911	893922	893932	893942
Min-Ø mm	17,2	22,7	28,2	38,2	43,2	53,2	66,7	76,7	86,7	95,7	106,7	116,7	126,7
Clamping sleeve	1015506	1015519	1015532	1015554	1015566	1015588	1015611 ▲	1015623 ▲	1015635 ▲	1015646 ▲	1015659 ▲	1015671 ▲	1015683 ▲
Work stop	893832	893839	893844	893854	893859	893869	893884	893894	893903	893912	893923	893933	893943
Min-Ø mm	17,7	23,2	28,7	38,7	43,7	53,7	67,7	77,7	87,7	96,7	107,7	117,7	127,7
Clamping sleeve	1015507	1015520	1015533	1015555	1015567	1015589	1015612 ▲	1015624 ▲	1015636 ▲	1015647 ▲	1015660 ▲	1015672 ▲	1015684 ▲
Work stop	893833	893839	893845	893855	893860	893870	893885	893895	893904	893913	893924	893934	893944
Min-Ø mm	18,2	23,7	29,2	39,2	44,2	54,2	68,7	78,7	88,7	97,7	108,7	118,7	128,7
Clamping sleeve	1015508	1015521	1015534	1015556	1015568	1015590	1015613 ▲	1015625 ▲	1015637 ▲	1015648 ▲	1015661 ▲	1015673 ▲	1015685 ▲
Work stop	893833	893840	893845	893855	893860	893870	893886	893947	893905	893914	893925	893935	893945
Min-Ø mm	18,7	24,2	29,7	39,7	44,7	54,7	69,7	79,7	89,7	98,7	109,7	119,7	129,7
Clamping sleeve	1015509	1015522	1015535	1015557	1015569	1015591	1015614 ▲	1015626 ▲	1015638 ▲	1015649 ▲	1015662 ▲	1015674 ▲	1015686 ▲
Work stop	893834	893840	893846	893856	893861	893871	893887	893896	893906	893915	893926	893936	893946
Min-Ø mm	19,2	24,7	30,2	40,2	45,2	55,2	70,7	80,7	90,7	99,7	110,7	120,7	130,7
Clamping sleeve	1015510	1015523	1015536	1015558	1015570	1015592	1015615 ▲	1015627 ▲	1015639 ▲	1015650 ▲	1015663 ▲	1015675 ▲	1015687 ▲
Work stop	893834	893841	893846	893856	893861	893871	893887	893896	893906	893916	893926	893936	893946
Min-Ø mm	19,7	25,2	30,7		45,7	55,7							
Clamping sleeve	1015511	1015524	1015537		1015571	1015593							
Work stop	893835	893841	893847		893862	893872							
Min-Ø mm			31,2		46,2	56,2							

Different chucking Ø and profiled clamping sleeves on request

Accessories KFR / MFR

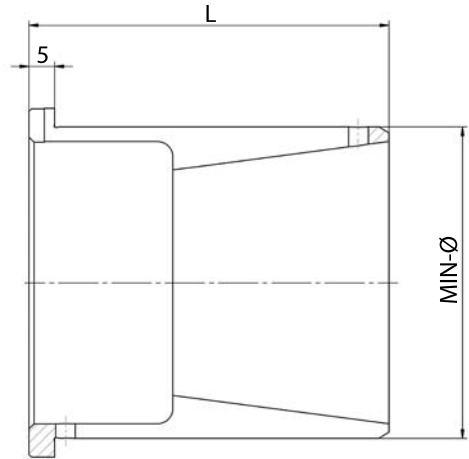
C 18

Clamping sleeve Type R - standard design (not vulcanized)

For size	00	01	02	03	04	05	06	07	08	09	10	11	12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length L	32	40	40	40	55	55	70	70	70	78	78	78	78
Clamping sleeve			1015538		1015572	1015594							
Work stop			893847		893862	893872							
Min-Ø mm			31,7		46,7	56,7							
Clamping sleeve			1015539		1015573	1015595							
Work stop			893848		893863	893873							
Min-Ø mm			32,2		47,2	57,2							
Clamping sleeve			1015540		1015574	1015596							
Work stop			893848		893863	893873							
Min-Ø mm			32,7		47,7	57,7							
Clamping sleeve			1015541		1015575	1015597							
Work stop			893849		893864	893874							
Min-Ø mm			33,2		48,2	58,2							
Clamping sleeve			1015542		1015576	1015598							
Work stop			893849		893864	893874							
Min-Ø mm			33,7		48,7	58,7							
Clamping sleeve			1015543		1015577	1015599							
Work stop			893850		893865	893875							
Min-Ø mm			34,2		49,2	59,2							
Clamping sleeve			1015544		1015578	1015600							
Work stop			893850		893865	893875							
Min-Ø mm			34,7		49,7	59,7							
Clamping sleeve			1015545		1015579	1015601							
Work stop			893851		893866	893876							
Min-Ø mm			35,2		50,2	60,2							
Clamping sleeve			1015546		1015580	1015602							
Work stop			893851		893866	893876							
Min-Ø mm						60,7							
Clamping sleeve						1015603							
Work stop						893877							

Different chucking Ø and profiled clamping sleeves on request

Accessories KFR / MFR



C 18
Clamping sleeve Type R - vulcanized

For size	00	01	02	03	04	05	06	07	08	09	10	11	12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length L	32	40	40	40	55	55	70	70	70	78	78	78	78
Min-Ø mm	14,2	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7	100,7	100,7	110,7	120,7
Clamping sleeve	1015700	1015713	1015726	1015748	1015760	1015782	1015805 ▲	1015817 ▲	1015829 ▲	1015851 ▲	1015853 ▲	1015865 ▲	1015877 ▲
Work stop	893830	893836	893842	893852	893857	893867	893878	893888	893897	893916	893917	893927	893937
Min-Ø mm	14,7	20,2	25,7	35,7	40,7	50,7	61,7	71,7	81,7	90,7	101,7	111,7	121,7
Clamping sleeve	1015701	1015714	1015727	1015749	1015761	1015783	1015806 ▲	1015818 ▲	1015830 ▲	1015841 ▲	1015854 ▲	1015866 ▲	1015878 ▲
Work stop	893830	893836	893842	893852	893857	893867	893879	893889	893898	893907	893918	893928	893938
Min-Ø mm	15,2	20,7	26,2	36,2	41,2	51,2	62,7	72,7	82,7	91,7	102,7	112,7	122,7
Clamping sleeve	1015702	1015715	1015728	1015750	1015762	1015784	1015807 ▲	1015819 ▲	1015831 ▲	1015842 ▲	1015855 ▲	1015867 ▲	1015879 ▲
Work stop	893830	893837	893842	893852	893857	893867	893880	893890	893899	893908	893919	893929	893939
Min-Ø mm	15,7	21,2	26,7	36,7	41,7	51,7	63,7	73,7	83,7	92,7	103,7	113,7	123,7
Clamping sleeve	1015703	1015716	1015729	1015751	1015763	1015785	1015808 ▲	1015820 ▲	1015832 ▲	1015843 ▲	1015856 ▲	1015868 ▲	1015880 ▲
Work stop	893831	893837	893843	893853	893858	893868	893881	893891	893900	893909	893920	893930	893940
Min-Ø mm	16,2	21,7	27,2	37,2	42,2	52,2	64,7	74,7	84,7	93,7	104,7	114,7	124,7
Clamping sleeve	1015704	1015717	1015730	1015752	1015764	1015786	1015809 ▲	1015821 ▲	1015833 ▲	1015844 ▲	1015857 ▲	1015869 ▲	1015881 ▲
Work stop	893831	893837	893843	893853	893858	893868	893882	893892	893901	893910	893921	893931	893941
Min-Ø mm	16,7	22,2	27,7	37,7	42,7	52,7	65,7	75,7	85,7	94,7	105,7	115,7	125,7
Clamping sleeve	1015705	1015718	1015731	1015753	1015765	1015787	1015810 ▲	1015822 ▲	1015834 ▲	1015845 ▲	1015858 ▲	1015870 ▲	1015882 ▲
Work stop	893832	893838	893844	893854	893859	893869	893883	893893	893902	893911	893922	893932	893942
Min-Ø mm	17,2	22,7	28,2	38,2	43,2	53,2	66,7	76,7	86,7	95,7	106,7	116,7	126,7
Clamping sleeve	1015706	1015719	1015732	1015754	1015766	1015788	1015811 ▲	1015823 ▲	1015835 ▲	1015846 ▲	1015859 ▲	1015871 ▲	1015883 ▲
Work stop	893832	893838	893844	893854	893859	893869	893884	893894	893903	893912	893923	893933	893943
Min-Ø mm	17,7	23,2	28,7	38,7	43,7	53,7	67,7	77,7	87,7	96,7	107,7	117,7	127,7
Clamping sleeve	1015707	1015720	1015733	1015755	1015767	1015789	1015812 ▲	1015824 ▲	1015836 ▲	1015847 ▲	1015860 ▲	1015872 ▲	1015884 ▲
Work stop	893833	893839	893845	893855	893860	893870	893885	893895	893904	893913	893924	893934	893944
Min-Ø mm	18,2	23,7	29,2	39,2	44,2	54,2	68,7	78,7	88,7	97,7	108,7	118,7	128,7
Clamping sleeve	1015708	1015721	1015734	1015756	1015768	1015790	1015813 ▲	1015825 ▲	1015837 ▲	1015848 ▲	1015861 ▲	1015873 ▲	1015885 ▲
Work stop	893833	893839	893845	893855	893860	893870	893886	893947	893905	893914	893925	893935	893945
Min-Ø mm	18,7	24,2	29,7	39,7	44,7	54,7	69,7	79,7	89,7	98,7	109,7	119,7	129,7
Clamping sleeve	1015709	1015722	1015735	1015757	1015769	1015791	1015814 ▲	1015826 ▲	1015838 ▲	1015849 ▲	1015862 ▲	1015874 ▲	1015886 ▲
Work stop	893834	893840	893846	893856	893861	893871	893887	893896	893906	893915	893926	893936	893946
Min-Ø mm	19,2	24,7	30,2	40,2	45,2	55,2	70,7	80,7	90,7	99,7	110,7	120,7	130,7
Clamping sleeve	1015710	1015723	1015736	1015758	1015770	1015792	1015815 ▲	1015827 ▲	1015839 ▲	1015850 ▲	1015863 ▲	1015875 ▲	1015887 ▲
Work stop	893834	893840	893846	893856	893861	893871	893887	893896	893906	893916	893926	893936	893946
Min-Ø mm	19,7	25,2	30,7		45,7	55,7							
Clamping sleeve	1015711	1015724	1015737		1015771	1015793							
Work stop	893835	893841	893847		893862	893872							
Min-Ø mm			31,2		46,2	56,2							
Clamping sleeve			1015738		1015772	1015794							
Work stop			893847		893862	893872							
Min-Ø mm			31,7		46,7	56,7							

Different chucking Ø and profiled clamping sleeves on request

Accessories KFR / MFR

C 18

Clamping sleeve Type R - vulcanized

For size	00	01	02	03	04	05	06	07	08	09	10	11	12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length L	32	40	40	40	55	55	70	70	70	78	78	78	78
Clamping sleeve			1015739		1015773	1015795							
Work stop			893848		893863	893873							
Min-Ø mm			32,2		47,2	57,2							
Clamping sleeve			1015740		1015774	1015796							
Work stop			893848		893863	893873							
Min-Ø mm			32,7		47,7	57,7							
Clamping sleeve			1015741		1015775	1015797							
Work stop			893849		893864	893874							
Min-Ø mm			33,2		48,2	58,2							
Clamping sleeve			1015742		1015776	1015798							
Work stop			893849		893864	893874							
Min-Ø mm			33,7		48,7	58,7							
Clamping sleeve			1015743		1015777	1015799							
Work stop			893850		893865	893875							
Min-Ø mm			34,2		49,2	59,2							
Clamping sleeve			1015744		1015778	1015800							
Work stop			893850		893865	893875							
Min-Ø mm			34,7		49,7	59,7							
Clamping sleeve			1015745		1015779	1015801							
Work stop			893851		893866	893876							
Min-Ø mm			35,2		50,2	60,2							
Clamping sleeve			1015746		1015780	1015802							
Work stop			893851		893866	893876							
Min-Ø mm						60,7							
Clamping sleeve						1015803							
Work stop						893877							

Different chucking Ø and profiled clamping sleeves on request

Intermediate flange KFR / MFR



APPLICATION

For adaption of cartridge mandrel KFR/MFR/KFR-SE/MFR-SE or KFS/MFS - on spindle head ISO 702-1 / ISO 702-3 (DIN 55021/55022/55026 and 55027).

TYPE

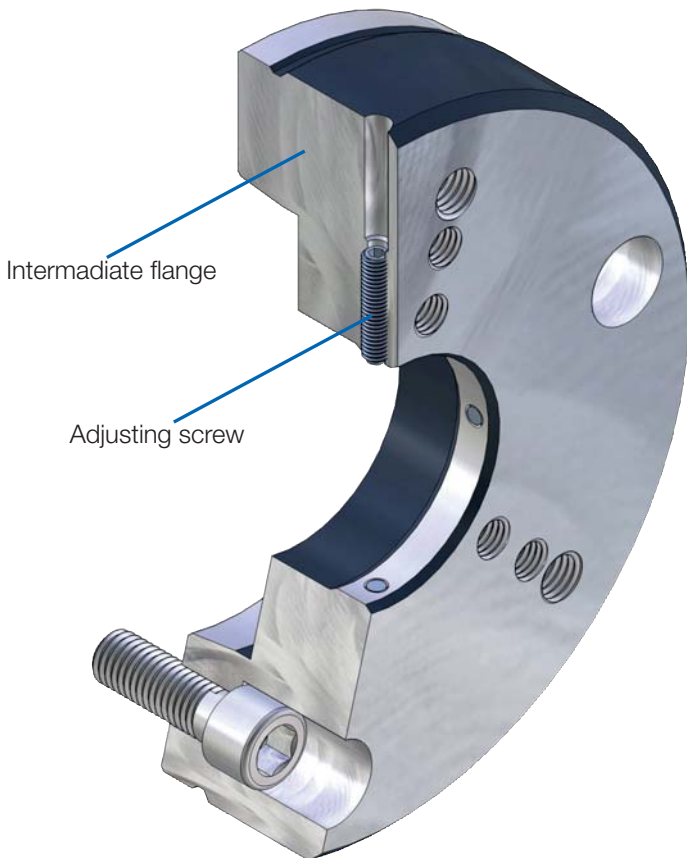
For KFR/MFR/KFR-SE/MFR-SE or KFS/MFS.

CUSTOMER BENEFITS

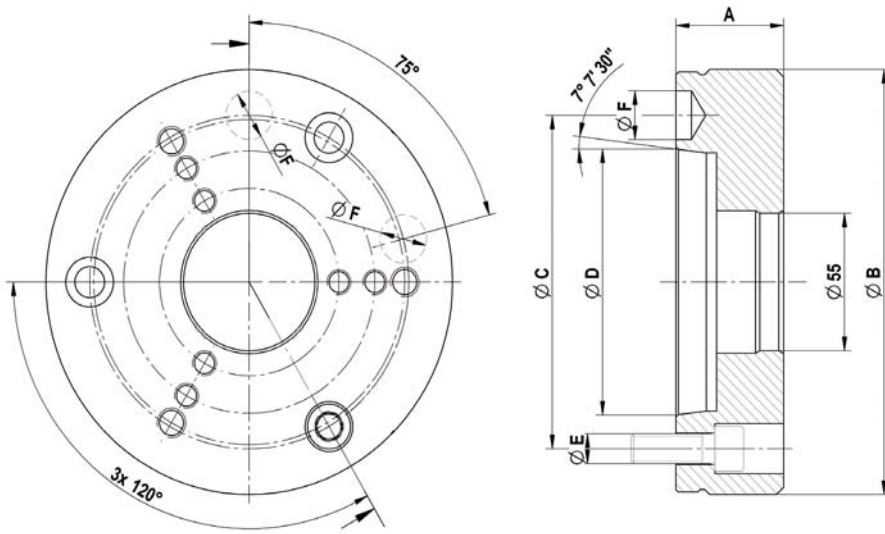
- By replacement of the Intermediate flange, one cartridge mandrel can be used on different machines

TECHNICAL FEATURES

Adaptation of mandrel KFR / MFR / KFR-SE / MFR SE or KFS / MFS on spindle head, with or without adjustment, with or without operation of air-conditioning control. Execution according to ISO 702-1 (DIN 55028-A) or ISO 702-3 (DIN 55028-C), in size no. 5, no. 6, no. 8, no. 11 or no. 5, no. 6. Nr. 8 (A5, A6, A8, A11 or C5, C6, C8).



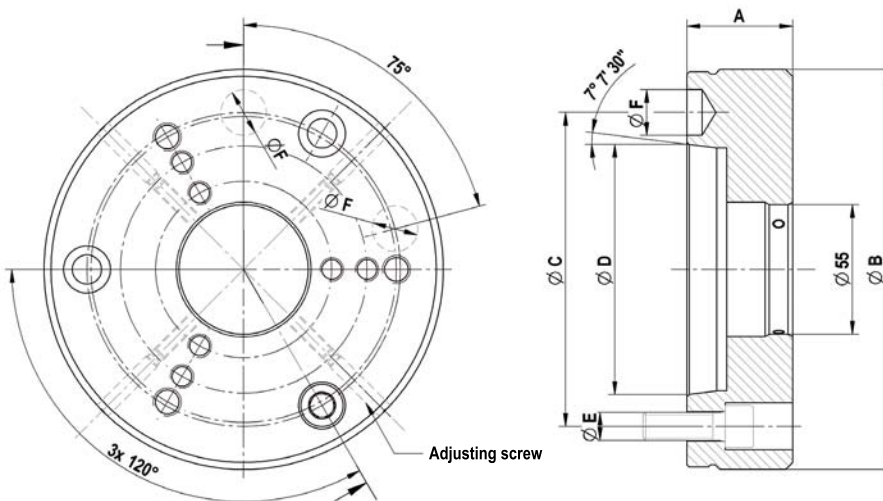
Accessories KFR / MFR



C 18

Intermediate flange ISO 702-1 (DIN 55026/55021) without adjusting screws

	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Intermediate flange	893975	893976	893977	893978 ▲
Design	without air-sensing	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50	50
Ø B	165	170	220	282
Ø C mm	104,8	133,4	171,4	235
Ø D mm	82,563	106,375	139,719	196,869
Ø E	M10	M12	M16	M20
Ø F mm	16,3	19,45	24,2	29,4

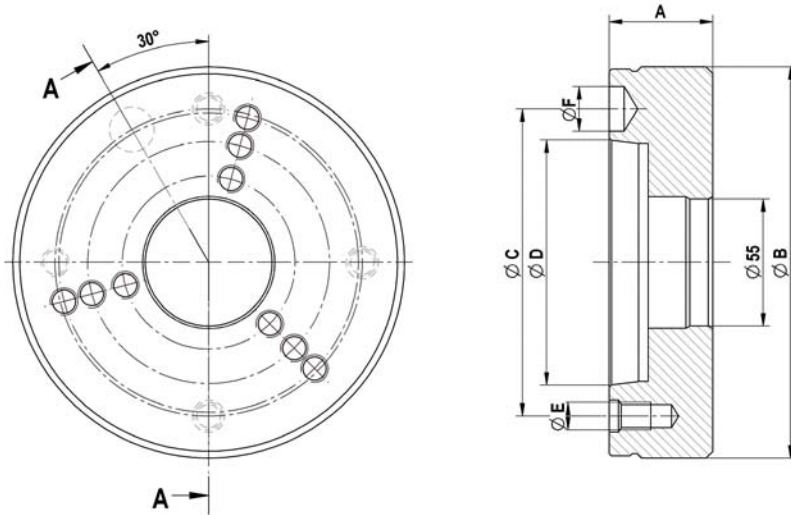


C 18

Intermediate flange ISO 702-1 (DIN 55028) with adjusting screw

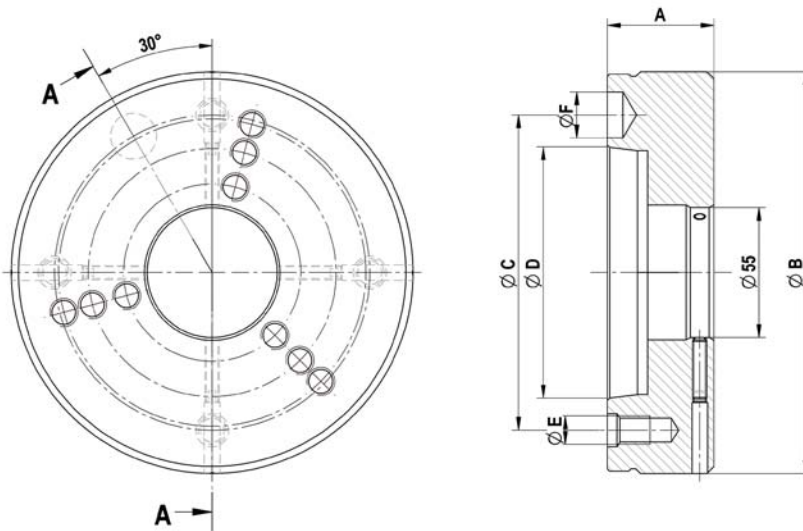
	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)
Intermediate flange	893979	893980	893981
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M10	M12	M16
Ø F mm	16,3	19,45	24,2

Accessories KFR / MFR



C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) without adjusting screws

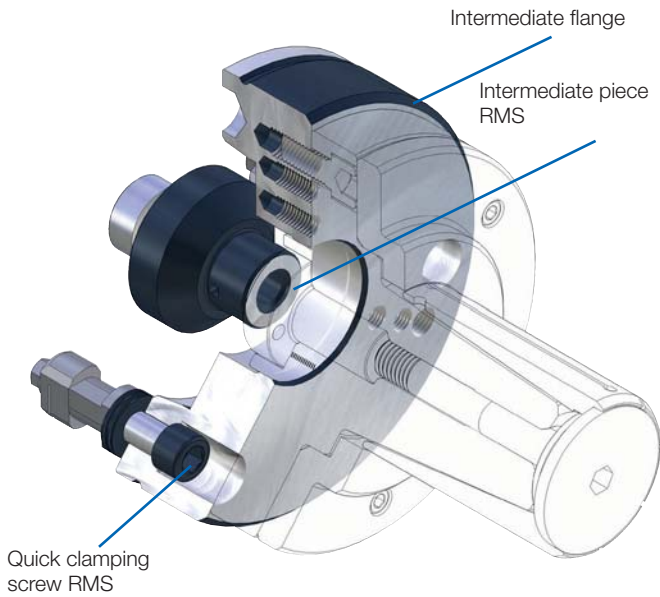
	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	893982	893983	893984
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2



C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) with adjusting screws

	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	893985	893986	893987
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2

Accessories KFR / MFR



APPLICATION

For manual clamping devices exchange in a minimum of time.

TYPE

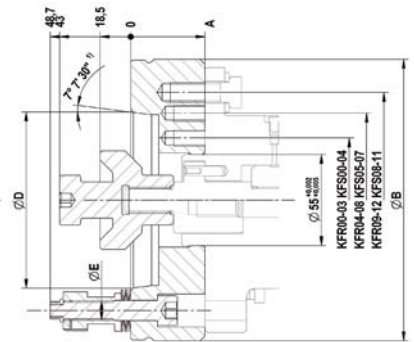
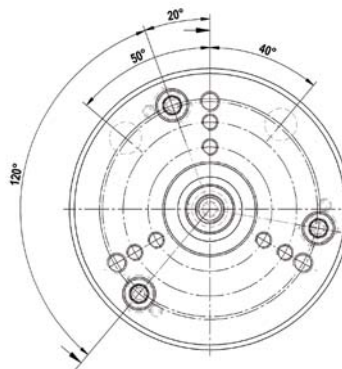
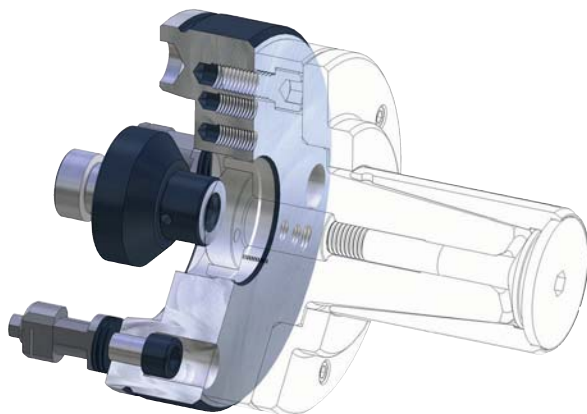
Manual quick-change system for clamping devices. Fits KFR/MFR or KFS/MFS. Central lubrication and / or air sensing control possible.

CUSTOMER BENEFITS

- ⌚ Manual clamping devices change in about 30 seconds
- ⌚ High change precision within 0.005 mm
- ⌚ Quick change of different clamping devices with short time, similar to the automatic or semiautomatic clamping devices changing systems

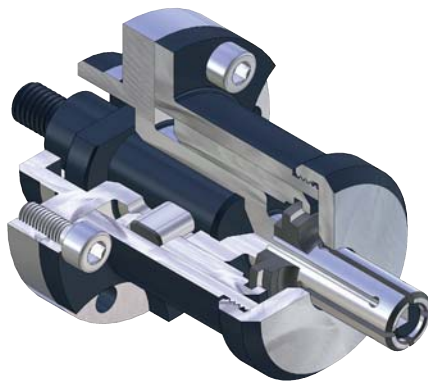
TECHNICAL FEATURES

- Quick-change system suitable due to recording RMS see quick-change system RMS (Product Group 6)
- Corresponds to the guidelines of the Employer's Liability Insurance Association in combination with ROHM safety clamping cylinder OVS and LVS



C18
RMS quick-change system, hand-operated for clamping devices

	KK 06	KK 08
RMS - complete (flange incl, quick-clamping screw)	1160026 ▲	1160027 ▲
Adapters RMS	1183310 ▲	1183311 ▲
A	45	50
Ø B	170	220
Ø C	133,4	171,4
Ø D	106,375	139,719
Ø E mm	M12	M16
Ø F mm	55 (+0,003/+0,001)	55 (+0,003/+0,001)



APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring. Ideal for very small clamping diameters starting from Ø 5.5 mm or small workpieces.

TYPE

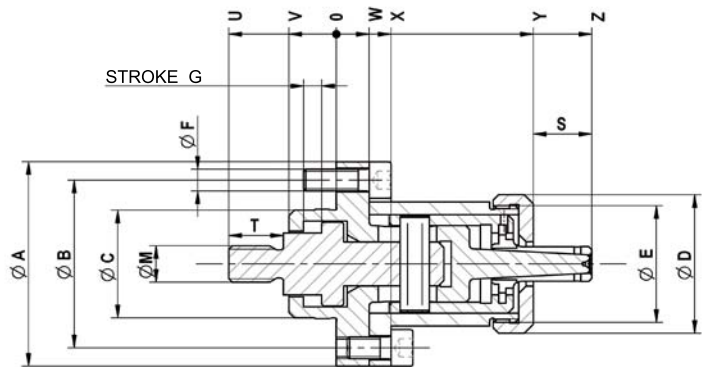
Force-actuated.
Clamping sleeves optionally vulcanized.

CUSTOMER BENEFITS

- ⊕ Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- ⊕ High concentricity, axial run-out and repeatability
- ⊕ Light weight and reduced height thanks to compact design

TECHNICAL FEATURES

- Hardened, low-wear design

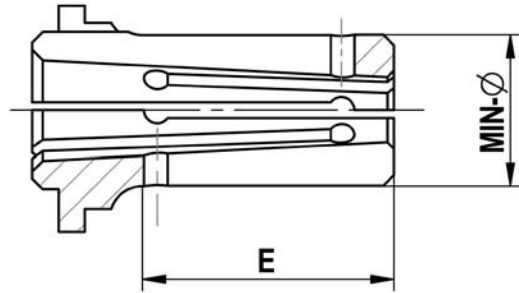


C18
KFB cartridge mandrel, power-operated with flanged seat, for internal clamping
Consisting of basic mandrel, stop sleeve, guide sleeve, cotter, draw bolt

	KFB 00	KFB 01	KFB 02	KFB 03	KFB 04	KFB 05	KFB 06	KFB 07
Cartridge Mandrel	327586	327587	327588	327589	327590	327591	327592	327593 ▲
Basic mandrel	323521	323522	323523	323524	323525	323526	323527	323528 ▲
Stop sleeve	323474	323475	323476	323477	323478	323479	323480	323481 ▲
Guide sleeve	323461	323462	323463	323464	323465	323466	323467	323468 ▲
Cotter	323508	323509	323510	323511	323512	323513	323514	323515 ▲
Draw bolt	323500	323501	323502	323502	323503	323504	323504	323505 ▲
F max, in kN	1,8	2,7	3,6	4,8	5,8	7,5	12	22
Max, total clamping force approx, kN	12	18	24	32	38	50	65	119
Min-Ø unclamped from	5,5	7,5	9,5	12	14,5	19,5	24,7	29,7
Min-Ø unclamped to	7	9	11,5	14,5	19	24,5	28,7	33,7
Clamping-Ø max,	7,5	9,5	12	15	19,5	25	29,7	34,7
External-Ø A	45	50	56	60	72	76	82	95
Pitch diameter B	36	39	46	50	60	64	70	80
Ø Ch6	25	25	30	30	40	40	40	60
Ø D mm	24	31	38	40	52	54	60	66
Ø E mm	M22x1,5	M27x1,5	M32x1,5	M36x1,5	M45x1,5	M48x1,5	M56x1,5	M60x1,5
Ø F mm	M5	M6	M6	M6	M6	M6	M6	M8
Stroke G	5	5	5	5	5	5	6	6
Ø M	M8	M8	M10	M10	M10	M12	M12	M12
S mm	9	13	15	20,5	24	30	36	40
T mm	14	14	15	15	15	18	18	18
U mm	27	27,5	29,5	29,5	30,5	33,5	33,5	36,5
V mm	11,5	12	13	13	14	14	14	17
W mm	7,5	8	9	9	10	10	10	12,5
X mm	12,5	13	15	15	16	16	16	18,5
Y mm	42	46	45	58	66	67	71	74
Z mm	51,5	58,5	70	78,5	90	97	107	114

Max. clamping force kN: 1,1-1,7-2,3-3,1-3,8-4,9-6,4-11,8

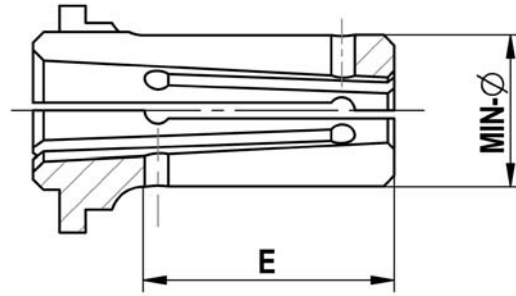
Accessories KFB



C 18
Clamping sleeve Type B - standard design (not vulcanized)

For size	KFB 00	KFB 01	KFB 02	KFB 03	KFB 04	KFB 05	KFB 06	KFB 07
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1
Total length E mm	11,5	15	19	20,5	28,5	34	40	43,5
Min-Ø mm	5,5	7,5	10	12	14,5	19,5	24,7	29,7
Clamping sleeve	315139	315140	315154	315142	315143	315144	315145	315146
Work stop	315126	315127	315128	315129	315130	323444	315132	315133
Min-Ø mm	6	8	10,5	12,5	15	20	25,7	30,7
Clamping sleeve	315152	315153	315167	315155	315156	315157	315158	315159 ▲
Work stop	323421	315127	315128	315129	323436	323445	323453	323460
Min-Ø mm	6,5	8,5	11	13	15,5	20,5	26,7	31,7
Clamping sleeve	315165	315166	315180	315168	315169	315170	315171	315172 ▲
Work stop	315126	315127	315128	315129	315130	315131	323454	315133
Min-Ø mm	7	9	11,5	13,5	16	21	27,7	32,7
Clamping sleeve	315178	315179	315191	315181	315182	315183	315184	315185 ▲
Work stop	315126	315127	315128	323433	315130	323447315131	315132	323541315133
Min-Ø mm			9,5	14	16,5	21,5	28,7	33,7
Clamping sleeve			315141	315192	315193	315194	315195	315196 ▲
Work stop			315128	315129	315130	315131	315132	323494
Min-Ø mm				14,5	17	22		
Clamping sleeve				315202	315203	315204		
Work stop				323490	315130	315131		
Min-Ø mm					17,5	22,5		
Clamping sleeve					315209	315210		
Work stop					323441	323450		
Min-Ø mm					18	23		
Clamping sleeve					315215	315216		
Work stop					315130	315131		
Min-Ø mm					18,5	23,5		
Clamping sleeve					315221	315222		
Work stop					323443	315131		
Min-Ø mm					19	24		
Clamping sleeve					315227	315228		
Work stop					315130	323458		
Min-Ø mm						24,5		
Clamping sleeve						315233		
Work stop						315131		

Accessories KFB



C 18

Clamping sleeve Type B - vulcanized (protected against chips and dirt)

For size	KFB 00	KFB 01	KFB 02	KFB 03	KFB 04	KFB 05	KFB 06	KFB 07
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1
Total length E mm	11,5	15	19	20,5	28,5	34	40	43,5
Min-Ø mm	5,5	7,5	10	12	14,5	19,5	24,7	29,7
Clamping sleeve	323739	323740	323754	323742	323743	323744	323745	323746 ▲
Work stop	323420	323423	323427	323430	323435	323444	323452	323459
Min-Ø mm	6	8	10,5	12,5	15	20	25,7	30,7
Clamping sleeve	323752	323753	323767	323755	323756	323757	323758	323759 ▲
Work stop	323421	323424	323428	323431	323436	323445	323453	323460
Min-Ø mm	6,5	8,5	11	13	15,5	20,5	26,7	31,7
Clamping sleeve	323765	323766	323780	323768	323769	323770	323771	323772 ▲
Work stop	323422	323425	323429	323432	323437	323446	323454	323540
Min-Ø mm	7	9	11,5	13,5	16	21	27,7	32,7
Clamping sleeve	323778	323779	323791	323781	323782	323783	323784	323785 ▲
Work stop	323487	323488	323489	323433	323438	323447	323455	323541
Min-Ø mm			9,5	14	16,5	21,5	28,7	33,7
Clamping sleeve			323741	323792	323793	323794	323795	323796 ▲
Work stop			323426	323434	323439	323448	323493	323494
Min-Ø mm				14,5	17	22		
Clamping sleeve				323802	323803	323804		
Work stop				323490	323440	323449		
Min-Ø mm					17,5	22,5		
Clamping sleeve					323809	323810		
Work stop					323441	323450		
Min-Ø mm					18	23		
Clamping sleeve					323815	323816		
Work stop					323442	323456		
Min-Ø mm					18,5	23,5		
Clamping sleeve					323821	323822		
Work stop					323443	323457		
Min-Ø mm					19	24		
Clamping sleeve					323827	323828		
Work stop					323491	323458		
Min-Ø mm						24,5		
Clamping sleeve						323833		
Work stop						323492		

Deviating clamping Ø as well as profiled clamping sleeves available on request



APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring. Ideal for very small clamping diameters starting from \varnothing 5.5 mm or small workpieces.

TYPE

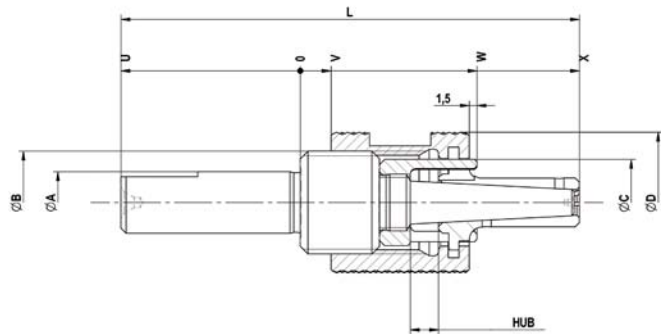
Manually actuated.
Clamping sleeves optionally vulcanized.

CUSTOMER BENEFITS

- ④ Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- ④ High concentricity and repeatability
- ④ Light weight and reduced height thanks to compact design

TECHNICAL FEATURES

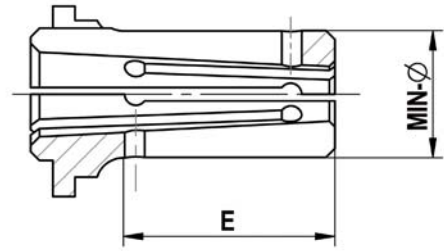
- Hardened, low-wear design



C18
MZB cartridge mandrel, hand-operated with centre hole, for internal clamping

	MZB 00	MZB 01	MZB 02	MZB 03	MZB 04	MZB 05	MZB 06	MZB 07	MZB 08	MZB 09	MZB 10	MZB 11	MZB 12
Cartridge Mandrel	1130361	1130362	1130363	1130364	1130365	1130366	1130367	1130368	1130369	1130370	1130371	1130372	1130373
Basic mandrel	315100	315101	315102	315103	315104	315105	315106	315107 ▲	315108 ▲	315109 ▲	315110 ▲	315111 ▲	315112 ▲
Nut	315113	315114	315115	315116	315117	315118	315119	315120 ▲	315121 ▲	315122 ▲	315123 ▲	315124 ▲	315125 ▲
Min- \varnothing unclamped from	5,5	7,5	9,5	12	14,5	19,5	24,7	29,7	34,7	39,7	44,7	54,7	64,7
Min- \varnothing unclamped to	7	9	11,5	14,5	19	24,5	28,7	33,7	38,7	43,7	53,7	63,7	78,7
Clamping- \varnothing max,	7,5	9,5	12	15	19,5	25	29,7	34,7	39,7	44,7	54,7	64,7	79,7
\varnothing A h6	10	12	12	14	18	20	25	30	40	40	45	50	50
\varnothing B	M14x1,5	M16x1,5	M20x1,5	M24x1,5	M30x1,5	M36x1,5	M42x1,5	M45x1,5	M52x1,5	M56x1,5	M65x1,5	M75x2	M95x2
\varnothing C mm	10,8	13	16,8	20,8	26,8	31,8	36,8	41,8	47,8	52,5	61,8	71,8	90,8
\varnothing D mm	19,5	23	28	31	38	47	54	57,5	66	74	83	93	108
Stroke G	5	5,5	5,5	5,5	5,5	6	6	6	6	6	6	6,5	7
L mm	74,5	79,5	89,5	97,5	102,5	113,5	136	144,5	156	166,5	197	208,5	221,5
U mm	30	30	35	35	35	40	45	50	55	60	67	67	67
V mm	5,5	6	6	6	6	6	7	7	7	7	7	7	7
W mm	29	33,5	34,5	36,5	37,5	37,5	48,5	48,5	48,5	48,5	53,5	56,5	58,5
X mm	44,5	48,5	53,5	61,5	66,5	72,5	89	92,5	99	104,5	128	139,5	152,5

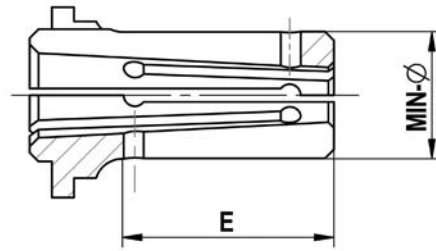
Accessories MZB



C 18
Clamping sleeve Type B - standard design (not vulcanized)

For size	MZB 00	MZB 01	MZB 02	MZB 03	MZB 04	MZB 05	MZB 06	MZB 07	MZB 08	MZB 09	MZB 10	MZB 11	MZB 12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length E mm	11,5	15	19	20,5	28,5	34	40	43,5	50	55,5	74	82,5	93,5
Min-Ø mm	5,5	7,5	10	12	14,5	19,5	24,7	29,7	34,7	39,7	44,7	54,7	64,7
Clamping sleeve	315139	315140	315154	315142	315143	315144	315145	315146	315147 ▲	315148 ▲	315149 ▲	315150 ▲	315151 ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm	6	8	10,5	12,5	15	20	25,7	30,7	35,7	40,7	45,7	55,7	65,7
Clamping sleeve	315152	315153	315167	315155	315156	315157	315158	315159 ▲	315160 ▲	315161 ▲	315162 ▲	315163 ▲	315164 ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm	6,5	8,5	11	13	15,5	20,5	26,7	31,7	36,7	41,7	46,7	56,7	66,7
Clamping sleeve	315165	315166	315180	315168	315169	315170	315171	315172 ▲	315173 ▲	315174 ▲	315175 ▲	315176 ▲	315177 ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm	7	9	11,5	13,5	16	21	27,7	32,7	37,7	42,7	47,7	57,7	67,7
Clamping sleeve	315178	315179	315191	315181	315182	315183	315184	315185 ▲	315186 ▲	315187 ▲	315188 ▲	315189 ▲	315190 ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm			9,5	14	16,5	21,5	28,7	33,7	38,7	43,7	48,7	58,7	68,7
Clamping sleeve			315141	315192	315193	315194	315195	315196 ▲	315197 ▲	315198 ▲	315199 ▲	315200 ▲	315201 ▲
Work stop			315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm				14,5	17	22					49,7	59,7	69,7
Clamping sleeve				315202	315203	315204					315205 ▲	315206 ▲	315207 ▲
Work stop				315129 ▲	315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					17,5	22,5					50,7	60,7	70,7
Clamping sleeve					315209	315210					315211 ▲	315212 ▲	315213 ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					18	23					51,7	61,7	71,7
Clamping sleeve					315215	315216					315217 ▲	315218 ▲	315219 ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					18,5	23,5					52,7	62,7	72,7
Clamping sleeve					315221	315222					315223 ▲	315224 ▲	315225 ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					19	24					53,7	63,7	73,7
Clamping sleeve					315227	315228					315229 ▲	315230 ▲	315231 ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm						24,5							74,7
Clamping sleeve						315233							315208 ▲
Work stop						315131							315138 ▲
Min-Ø mm													75,7
Clamping sleeve													315214 ▲
Work stop													315138 ▲
Min-Ø mm													76,7
Clamping sleeve													315220 ▲
Work stop													315138 ▲
Min-Ø mm													77,7
Clamping sleeve													315226 ▲
Work stop													315138 ▲
Min-Ø mm													78,7
Clamping sleeve													315232 ▲
Work stop													315138 ▲

Accessories MZB



C 18

Clamping sleeve Type B - vulcanized (protected against chips and dirt)

For size	MZB 00	MZB 01	MZB 02	MZB 03	MZB 04	MZB 05	MZB 06	MZB 07	MZB 08	MZB 09	MZB 10	MZB 11	MZB 12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length E mm	11,5	15	19	20,5	28,5	34	40	43,5	50	55,5	74	82,5	93,5
Min-Ø mm	5,5	7,5	10	12	14,5	19,5	24,7	29,7	34,7	39,7	44,7	54,7	64,7
Clamping sleeve	323739	323740	323754	323742	323743	323744	323745	323746 ▲	323747 ▲	323748 ▲	323749 ▲	323750 ▲	323751 ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm	6	8	10,5	12,5	15	20	25,7	30,7	35,7	40,7	45,7	55,7	65,7
Clamping sleeve	323752	323753	323767	323755	323756	323757	323758	323759 ▲	323760 ▲	323761 ▲	323762 ▲	323763 ▲	323764 ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm	6,5	8,5	11	13	15,5	20,5	26,7	31,7	36,7	41,7	46,7	56,7	66,7
Clamping sleeve	323765	323766	323780	323768	323769	323770	323771	323772 ▲	323773 ▲	323774 ▲	323775 ▲	323776 ▲	323777 ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm	7	9	11,5	13,5	16	21	27,7	32,7	37,7	42,7	47,7	57,7	67,7
Clamping sleeve	323778	323779	323791	323781	323782	323783	323784	323785 ▲	323786 ▲	323787 ▲	323788 ▲	323789 ▲	323790 ▲
Work stop	315126	315127	315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm			9,5	14	16,5	21,5	28,7	33,7	38,7	43,7	48,7	58,7	68,7
Clamping sleeve			323741	323792	323793	323794	323795	323796 ▲	323797 ▲	323798 ▲	323799 ▲	323800 ▲	323801 ▲
Work stop			315128	315129 ▲	315130	315131	315132	315133 ▲	315134 ▲	315135 ▲	315136 ▲	315137 ▲	315138 ▲
Min-Ø mm				14,5	17	22					49,7	59,7	69,7
Clamping sleeve				323802	323803	323804					323805 ▲	323806 ▲	323807 ▲
Work stop				315129 ▲	315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					17,5	22,5					50,7	60,7	70,7
Clamping sleeve					323809	323810					323811 ▲	323812 ▲	323813 ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					18	23					51,7	61,7	71,7
Clamping sleeve					323815	323816					323817 ▲	323818 ▲	323819 ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					18,5	23,5					52,7	62,7	72,7
Clamping sleeve					323821	323822					323823 ▲	323824 ▲	323825 ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm					19	24					53,7	63,7	73,7
Clamping sleeve					323827	323828					323829 ▲	323830 ▲	323831 ▲
Work stop					315130	315131					315136 ▲	315137 ▲	315138 ▲
Min-Ø mm						24,5							74,7
Clamping sleeve						323833							323808 ▲
Work stop						315131							315138 ▲
Min-Ø mm													75,7
Clamping sleeve													323814 ▲
Work stop													315138 ▲
Min-Ø mm													76,7
Clamping sleeve													323820 ▲
Work stop													315138 ▲
Min-Ø mm													77,7
Clamping sleeve													323826 ▲
Work stop													315138 ▲
Min-Ø mm													78,7
Clamping sleeve													323832 ▲
Work stop													315138 ▲

Deviating clamping Ø as well as profiled clamping sleeves available on request

MZE



APPLICATION

Internal clamping of round workpieces, measuring operations, light grinding operations.
Ideal for long clamping lengths / long workpieces.

TYPE

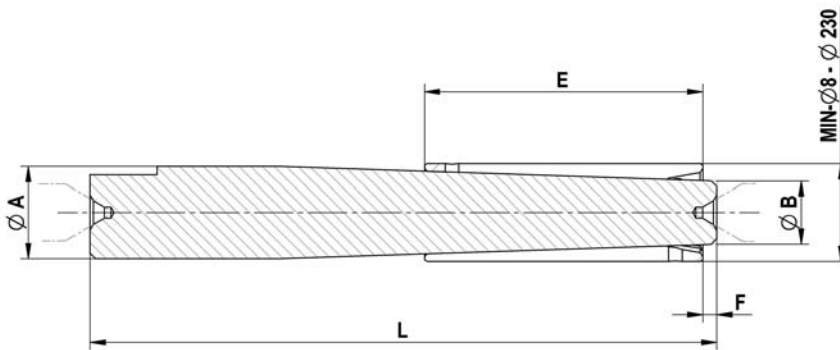
Manually actuated.
Available as clamping mandrel assortment for various clamping diameters.
Clamping sleeve separately available.

CUSTOMER BENEFITS

- ⊕ Quick change of clamping sleeve without tools
- ⊕ High concentricity and repeatability
- ⊕ High flexibility thanks to mount on the shaft or between points
- ⊕ Short retrofiting times

TECHNICAL FEATURES

- Hardened, low-wear design

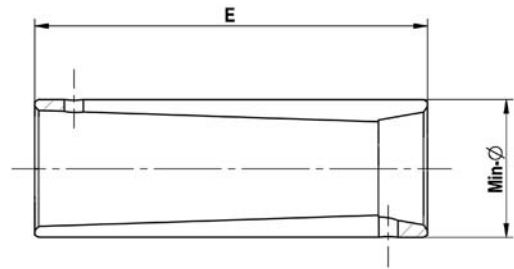


C18

MZE basic mandrel, hand-operated with centre hole, for internal clamping

	MZE 00	MZE 01	MZE 02	MZE 03	MZE 04	MZE 05	MZE 06	MZE 07	MZE 08	MZE 09	MZE 10	MZE 11	MZE 12	MZE 13	MZE 14	MZE 15
Basic mandrel	315000	315001	315002	315003	315004	315005	315006	315007	315008	315009	315010	315011	315012	315013	315014	315015
Min-Ø unclamped from	8	10	12	14	16	19	22	25	35	45	55	68	80	105	135	185
Min-Ø unclamped to	9	11	13	15	18	21	24	34	44	54	65	80	100	135	180	230
Clamping-Ø max,	10,5	12,5	15	17	20	23	26	37	47	59	70	85	105	140	185	235
Ø A	8	10	12	14	16	19	21	25	33	45	53	64	76	99	124	145,5
Ø B	4,1	5,3	5,7	6,9	8,5	10,7	12,2	14,6	22,6	31,1	38	48,2	60,9	80,4	97,4	122,4
E	40	45	60	70	70	80	80	100	100	125	135	150	150	170	180	200
F	3	3	4	4	4	4	4	4	5	5	5	5	5	5	82	63
L	75	110	125	140	150	170	175	225	225	300	330	350	350	400	442	443

Accessories MZE



C 18

Clamping sleeve Type E - for basic mandrel MZE

For size	MZE 00	MZE 01	MZE 02	MZE 03	MZE 04	MZE 05	MZE 06	MZE 07	MZE 08	MZE 09	MZE 10	MZE 11	MZE 12	MZE 13	MZE 14	MZE 15
Expansion in Ø mm	1,5	1,5	2	2	2	2	2	3	3	5	5	5	5	5	5	5
Total length E mm	40	45	60	70	70	80	80	100	100	125	135	150	150	170	180	200
Min-Ø mm	8	10	12	14	16	19	22	25	35	45	55	68	100	105	135	185
Clamping sleeve	315016	315017	315018	315019	315020	315021	315022	315023	315024	315025	315026	315027	315074	315029	315030	315031
Clamping sleeve												▲		▲	▲	▲
Min-Ø mm	9	11	13	15	17	20	23	26	36	48	58	70	80	110	140	190
Clamping sleeve	315032	315033	315034	315035	315036	315037	315038	315039	315040	315041	315042	315043	315028	315045	315046	315047
Clamping sleeve											▲			▲	▲	▲
Min-Ø mm					18	21	24	28	38	50	60	72	85	115	145	195
Clamping sleeve					315048	315049	315050	315051	315052	315053	315054	315055	315044	315057	315058	315059
Clamping sleeve											▲			▲	▲	▲
Min-Ø mm								30	40	52	62	75	90	120	150	200
Clamping sleeve								315060	315061	315062	315063	315064	315056	315066	315067	315068
Clamping sleeve											▲			▲	▲	▲
Min-Ø mm								32	42	54	65	78	95	125	155	205
Clamping sleeve								315069	315070	315071	315072	315073	315065	315075	315076	315077
Clamping sleeve											▲			▲	▲	▲
Min-Ø mm								34	44			80		130	160	210
Clamping sleeve								315078	315079			315080		315081	315082	315083
Clamping sleeve														▲	▲	▲
Min-Ø mm														135	165	215
Clamping sleeve														315084	315085	315086
Clamping sleeve														▲	▲	▲
Min-Ø mm															170	220
Clamping sleeve															315087	315088
Clamping sleeve															▲	▲
Min-Ø mm															175	225
Clamping sleeve															315089	315090
Clamping sleeve															▲	▲
Min-Ø mm															180	230
Clamping sleeve															315091	315092
Clamping sleeve															▲	▲

Deviating clamping Ø as well as profiled and vulcanized clamping sleeves available on request

Product ranges MZE cartridge mandrel



Product ranges in wooden box size 1 – ID 315093

CONTENT

Consisting of 5 basic mandrels 02 - 06 and 7 clamping sleeves in the clamping range 12-26, Ø 12-14-16-18-20-22-24 mm



Product range in wooden box size 2 – ID 315094

CONTENT

Consisting of 3 basic mandrels 07 - 09 and 6 clamping sleeves in the clamping range 25-55, Ø 25-30-35-40-45-50 mm

Special solutions KFS



Cartridge mandrel KFS clamping-Ø 22,65 mm

APPLICATION

Turning

Clamping mandrel in special version due to required freedom of the tool. The clamping is done in the root circle of the toothing using a diagonally slotted clamping sleeve. Tilting in the toothing is prevented by the angled slotting.

CUSTOMER BENEFITS

- ⊕ Optimal clamping of the toothed workpiece
- ⊕ High concentricity and run-out precision of 0.02 mm



Cartridge mandrel KFS clamping-Ø SW 27,8 mm

APPLICATION

Turning

The clamping is done using a hexagonal clamping sleeve with axial pull via the draw bar against a fixed stop. The workpiece stop is designed of a two-sided loading of the workpiece.

CUSTOMER BENEFITS

- ⊕ Clamping of special contours is possible
- ⊕ Concentricity of 0.05 mm



Cartridge mandrel KFS clamping-Ø 34,3 mm

APPLICATION

Turning / Cutting

Cartridge mandrel force-actuated with axial pull and fixed stop. Clamping sleeve profiled for cutting off of the workpieces.

CUSTOMER BENEFITS

- ⊕ Low-cost production of small parts
- ⊕ Concentricity of 0.01 mm

Special solutions KFR / MFR



Cartridge mandrel KFR clamping-Ø 45 mm

APPLICATION

Turning of a pressed part

Force-actuated cartridge mandrel actuated via draw bar. Clamping mandrel is designed for different workpieces. Fixed stop with damping ring, air sensing and ejector.

CUSTOMER BENEFITS

- ⊕ Can be easily reconfigured to other clamping diameters by changing of clamping sleeve and/or stop
- ⊕ Concentricity of 0.01 mm



Cartridge mandrel KFR clamping-Ø TK-Ø 90 mm

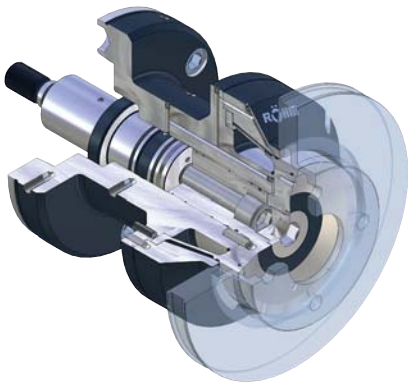
APPLICATION

Turning

Force-actuated cartridge mandrel with toothed clamping sleeve for clamping in the tooth flanks. Collet with quick change system.

CUSTOMER BENEFITS

- ⊕ Concentricity for tothing
- ⊕ Concentricity of 0.03 mm



Cartridge mandrel KFR clamping-Ø 136 mm

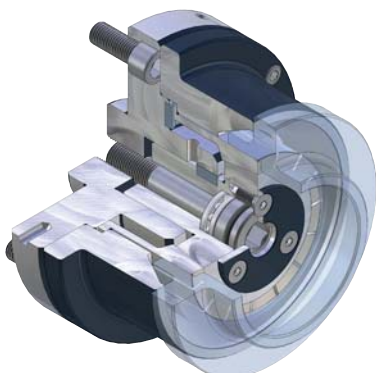
APPLICATION

Turning of brake discs

Force-actuated cartridge mandrel actuated via draw bar. Sealed against penetration of chips. Fixed stop with air sensing.

CUSTOMER BENEFITS

- ⊕ Stable version of the clamping mandrel
- ⊕ Concentricity of 0.02 mm



Cartridge mandrel MFR clamping-Ø 88 mm

APPLICATION

Milling / drilling for stationary use on clamping devices.

Cartridge mandrel in special version with manual actuation. The actuation is done via the hexagon socket.

CUSTOMER BENEFITS

- ⊕ Simple actuation by light roller bearing
- ⊕ Concentricity of 0.015 mm

Special solutions KFB



Cartridge mandrel KFB clamping-Ø 42 mm

APPLICATION

Turning

Clamping of the workpiece with axial tension against the stop. Clamping mandrel is hermetically sealed against penetration by dirt and cooling water. The stop and clamping sleeve can be replaced together using the quick change system.

CUSTOMER BENEFITS

- ⊕ Fast adjustment to different workpieces thanks to the quick change system
- ⊕ Concentricity of 0.015 mm



Cartridge mandrel KFB clamping-Ø 114 mm

APPLICATION

Turning

Clamping is done via draw bar with axial tension against the fixed stop. Idle stroke enables simpler stroke control in the clamping cylinder. The workpiece stop can be replaced quickly using the bayonet system.

CUSTOMER BENEFITS

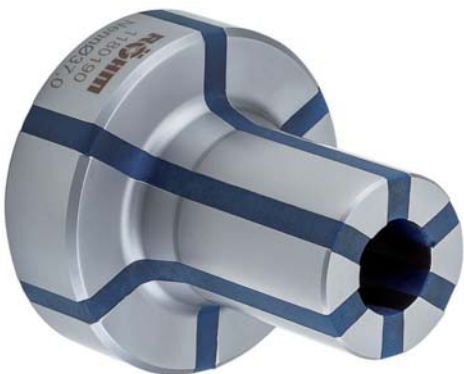
- ⊕ Simple handling
- ⊕ Stable clamping using axial pull
- ⊕ Concentricity of 0.01 mm



Notes



INNOVATIVE VULCANISATE IN THE SEGMENT CLAMPING SLEEVE



- ④ Segment clamping sleeve with innovative vulcanisate for great elongation, longest service life and vibration dampening
- ④ Hardened and ground steel segments for high resistance to wear



Video ABSIS



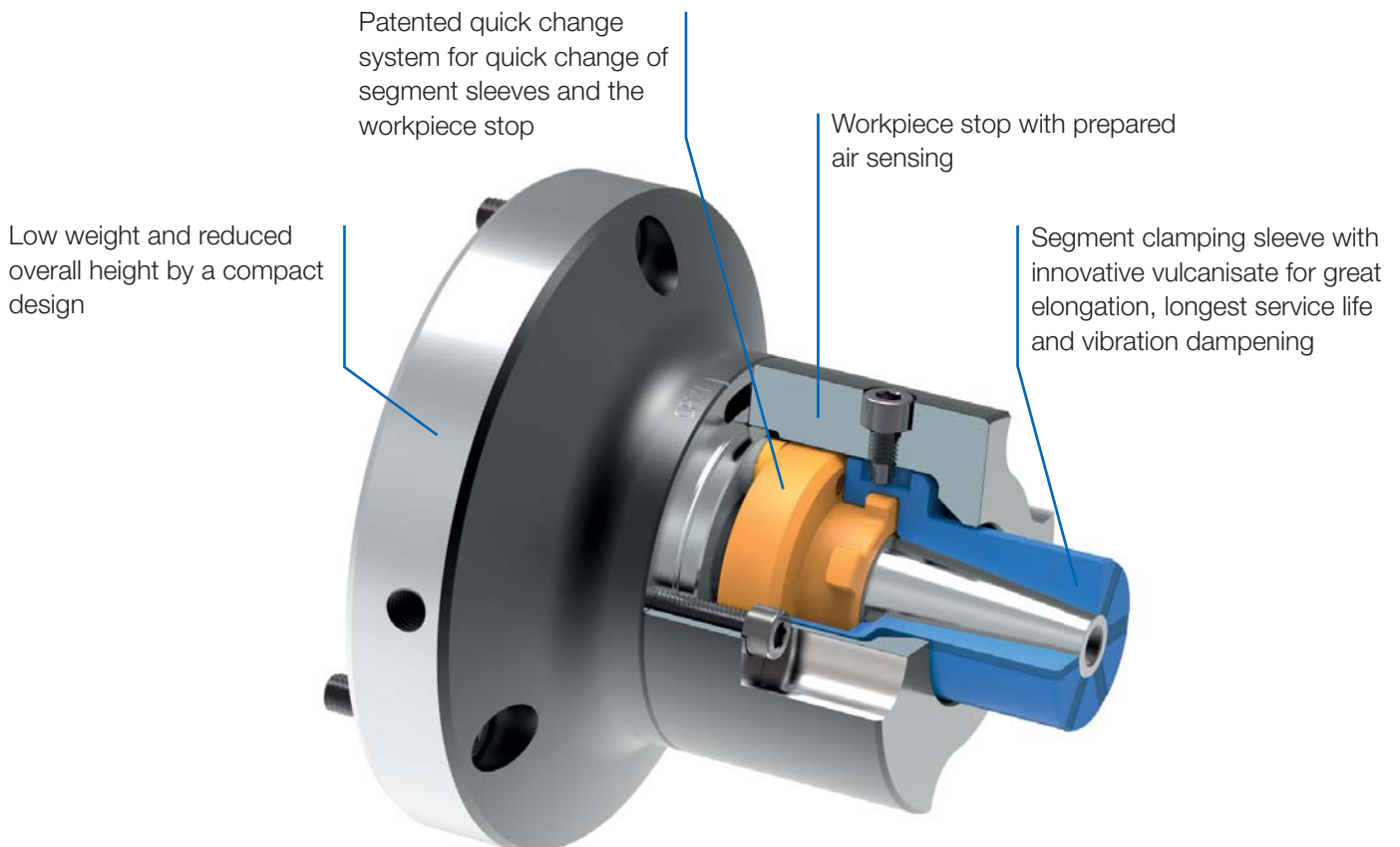
Video AGILIS

SEGMENT CLAMPING MANDREL

Modern manufacturing technology can hardly do without the use of segment clamping mandrels. In the fields of precision machining, turning, grinding, gear cutting and checking, segment clamping mandrels assume important tasks that are associated with challenging conditions. The innovative rubber segments enable a great elongation of the clamping sleeve to 1.2 mm.

ADVANTAGES AT A GLANCE

- ⊕ Short tooling and non-productive times thanks to the great elongation of the clamping sleeve up to 1.2 mm
- ⊕ Vibration dampening and long service life thanks to innovative vulcanisate of the clamping sleeves
- ⊕ Fast replacement of the clamping mandrel thanks to the patented bayonet quick change system



ABSIS



APPLICATION

Internal clamping of round workpieces. Turning, grinding and toothing operations, as well as for balancing and measuring. Ideal for clamping in through holes.

TYPE

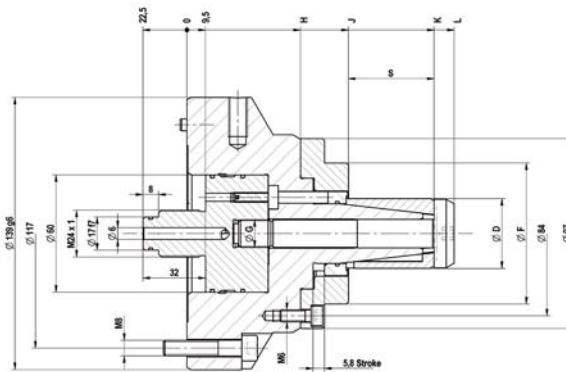
Force-actuated.

CUSTOMER BENEFITS

- ⌚ Short setup and non-productive times thanks to great expansion of the segment sleeves
- 🔊 Vibration damping due to high vulcanized rubber component of the clamping sleeves
- 🔒 Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- ⚡ Fast change of segment sleeves thanks to central clamping screw
- 🔄 High concentricity, axial run-out and repeatability

TECHNICAL FEATURES

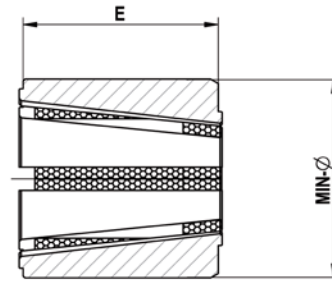
- Manual lubrication
- Air sensing prepared



C 18
ABSIS Segment clamping mandrel, power-operated with flanged seat
 Consisting of basic mandrel, adapter, ejector ring, locking belt

	ABSIS 00	ABSIS 01	ABSIS 02	ABSIS 03	ABSIS 04
Segment clamping mandrel	1110000	1110001	1110002	1110003	1110004
Basic mandrel	1110100	1110101	1110102	1110103	1110104
Adapter power operated	1110040	1110041	1110042	1110043	1110044
Ejector ring	1110020	1110021	1110022	1110023	1110024
Locking bolt	1110060	1110061	1110062	1110063	1110064
F max, in kN	7	10	20	25	30
Max, total clamping force approx, kN	32	46	92	115	138
D Min-Ø unclamped from	19,7	25,7	35,7	50,7	72,7
D Min-Ø unclamped to	27,7	38,7	54,7	81,7	105,7
Clamping-Ø max,	29	40	56	83	107
S mm	23	27	44	50	60
Ø F mm	58	58	72	90	120
Ø G	M6x0,75	M10x1	M14x1	M18x1	M20x1
H mm	55	55	58	58,5	60
J mm	75	75	82,5	84,5	86
K mm	98	102	126,3	134,5	146
L mm	103,5	108,5	136,5	146,5	160

Accessories ABSIS



C 18

Segment clamping sleeve - standard design

	ABSIS 00	ABSIS 01	ABSIS 02	ABSIS 03	ABSIS 04
Expansion in Ø mm	1,2	1,2	1,2	1,2	1,2
Total length E mm	23	27	44	50	60
Min-Ø mm	19,7	25,7	35,7	50,7	72,7
Segment sleeve	1111400	1111409	1111423	1111443	1111475
Work stop	1110070	1110071	1110072	1110073	1110074
Min-Ø mm	20,7	26,7	36,7	51,7	73,7
Segment sleeve	1111401	1111410	1111424	1111444	1111476
Work stop	1110070	1110071	1110072	1110073	1110074
Min-Ø mm	21,7	27,7	37,7	52,7	74,7
Segment sleeve	1111402	1111411	1111425	1111445	1111477
Work stop	1110070	1110071	1110072	1123341	1123372
Min-Ø mm	22,7	28,7	38,7	53,7	75,7
Segment sleeve	1111403	1111412	1111426	1111446	1111478
Work stop	1110070	1110071	1110072	1123342	1123373
Min-Ø mm	23,7	29,7	39,7	54,7	76,7
Segment sleeve	1111404	1111413	1111427	1111447	1111479
Work stop	1110070	1110071	1110072	1123343	1123374
Min-Ø mm	24,7	30,7	40,7	55,7	77,7
Segment sleeve	1111405	1111414	1111428	1111448	1111480
Work stop	1110070	1110071	1110072	1123344	1123375
Min-Ø mm	25,7	31,7	41,7	56,7	78,7
Segment sleeve	1111406	1111415	1111429	1111449	1111481
Work stop	1110070	1110071	1110072	1123345	1173376
Min-Ø mm	26,7	32,7	42,7	57,7	79,7
Segment sleeve	1111407	1111416	1111430	1111450	1111482
Work stop	1123305	1110071	1123327	1123346	1123377
Min-Ø mm	27,7	33,7	43,7	58,7	80,7
Segment sleeve	1111408	1111417	1111431	1111451	1111483
Work stop	1123306	1123315	1123328	1123347	1123378
Min-Ø mm		34,7	44,7	59,7	81,7
Segment sleeve		1111418	1111432	1111452	1111484
Work stop		1123316	1123329	1123348	1123379
Min-Ø mm		35,7	45,7	60,7	82,7
Segment sleeve		1111419	1111433	1111453	1111485
Work stop		1123317	1123330	1123349	1123380
Min-Ø mm		36,7	46,7	61,7	83,7
Segment sleeve		1111420	1111434	1111454	1111486
Work stop		1123318	1123331	1123350	1123381
Min-Ø mm		37,7	47,7	62,7	84,7
Segment sleeve		1111421	1111435	1111455	1111487
Work stop		1123319	1123332	1123351	1123382
Min-Ø mm		38,7	48,7	63,7	85,7
Segment sleeve		1111422	1111436	1111456	1111488
Work stop		1123320	1123333	1123352	1123383
Min-Ø mm			49,7	64,7	86,7
Segment sleeve			1111437	1111457	1111489
Work stop			1123334	1123353	1123384
Min-Ø mm			50,7	65,7	87,7
Segment sleeve			1111438	1111458	1111490
Work stop			1123335	1123354	1123385
Min-Ø mm			51,7	66,7	88,7
Segment sleeve			1111439	1111459	1111491
Work stop			1123336	1123355	1123386

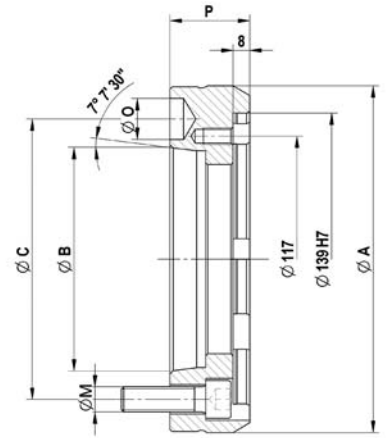
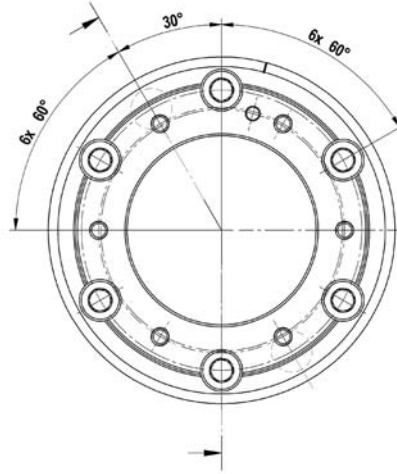
Accessories ABSIS

C 18

Segment clamping sleeve - standard design

	ABSIS 00	ABSIS 01	ABSIS 02	ABSIS 03	ABSIS 04
Expansion in Ø mm	1,2	1,2	1,2	1,2	1,2
Total length E mm	23	27	44	50	60
Min-Ø mm			52,7	67,7	89,7
Segment sleeve			1111440	1111460	1111492
Work stop			1123337	1123356	1123387
Min-Ø mm			53,7	68,7	90,7
Segment sleeve			1111441	1111461	1111493
Work stop			1123338	1123357	1123388
Min-Ø mm			54,7	69,7	91,7
Segment sleeve			1111442	1111462	1111494
Work stop			1123339	1123358	1123389
Min-Ø mm				70,7	92,7
Segment sleeve				1111463	1111495
Work stop				1123359	1123390
Min-Ø mm				71,7	93,7
Segment sleeve				1111464	1111496
Work stop				1123360	1123391
Min-Ø mm				72,7	94,7
Segment sleeve				1111465	1111497
Work stop				1123361	1123392
Min-Ø mm				73,7	95,7
Segment sleeve				1111466	1111498
Work stop				1123362	1123393
Min-Ø mm				74,7	96,7
Segment sleeve				1111467	1111499
Work stop				1123363	1123394
Min-Ø mm				75,7	97,7
Segment sleeve				1111468	1111500
Work stop				1123364	1123395
Min-Ø mm				76,7	98,7
Segment sleeve				1111469	1111501
Work stop				1123365	1123396
Min-Ø mm				77,7	99,7
Segment sleeve				1111470	1111502
Work stop				1123366	1123397
Min-Ø mm				78,7	100,7
Segment sleeve				1111471	1111503
Work stop				1123367	1123398
Min-Ø mm				79,7	101,7
Segment sleeve				1111472	1111504
Work stop				1123368	1123399
Min-Ø mm				80,7	102,7
Segment sleeve				1111473	1111505
Work stop				1123369	1123400
Min-Ø mm				81,7	103,7
Segment sleeve				1111474	1111506
Work stop				1123370	1123401
Min-Ø mm					104,7
Segment sleeve					1111507
Work stop					1123402
Min-Ø mm					105,7
Segment sleeve					1111508
Work stop					1123403

Accessories ABSIS



C 18

Intermediate flange ISO 702-1 (DIN 55028), for size 00-04

	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Intermediate flange	1110005	1110006	1110008	1110011 ▲
Ø A mm	165	170	220	282
Ø B	82,563	106,375	139,719	196,869
Ø C mm	104,8	133,4	171,4	235
Thread-Ø M	M10	M12	M16	M20
Ø O mm	16,3	19,45	24,2	29,4
P mm	36	38	45	45

Accessories ABSIS

APPLICATION

For manual clamping devices exchange in a minimum of time.

TYPE

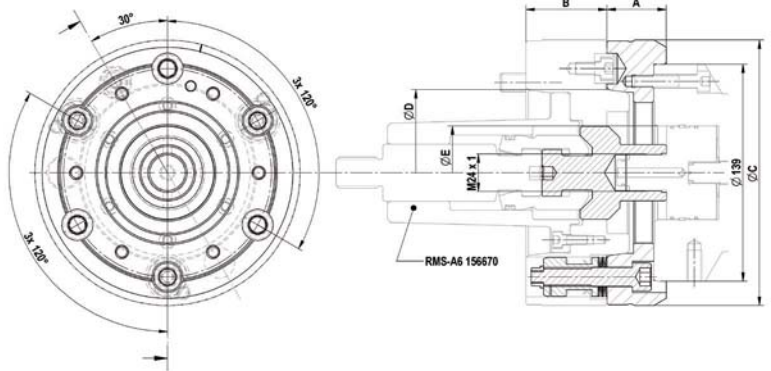
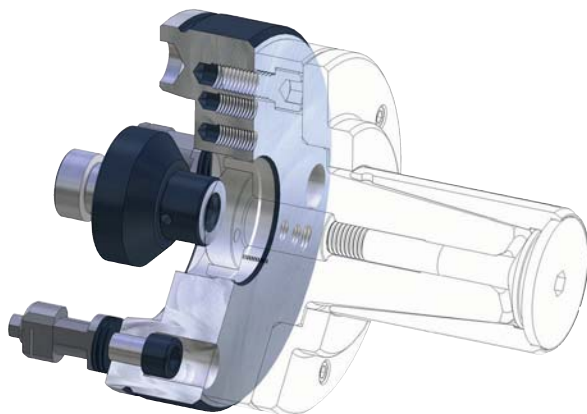
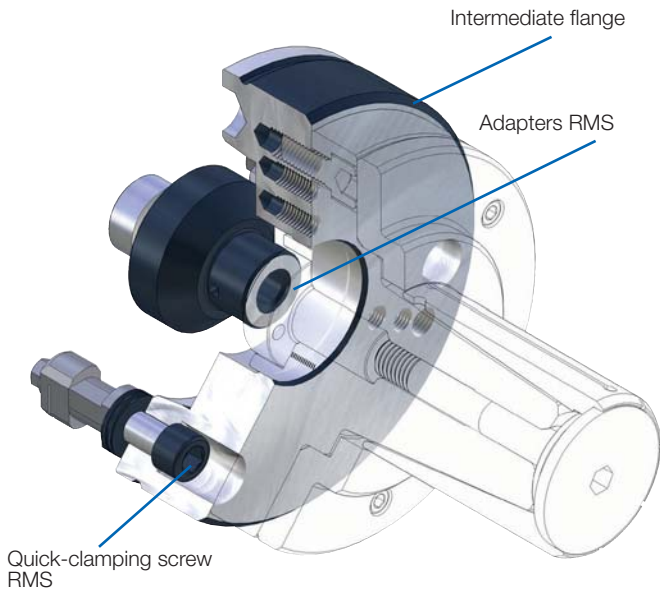
Manual quick-change system for clamping devices. Fits ABSIS (269-00), AGILIS (296-00). Central lubrication and / or air sensing control possible.

CUSTOMER BENEFITS

- ⊕ Manual clamping devices change in about 30 seconds
- ⊕ High change precision within 0.005 mm
- ⊕ Quick change of different clamping devices with short time, similar to the automatic or semiautomatic clamping devices changing systems

TECHNICAL FEATURES

- Quick-change system suitable due to recording RMS see quick-change system RMS (Product Group 6)
- Corresponds to the guidelines of the Employer's Liability Insurance Association in combination with RÖHM safety clamping cylinder OVS and LVS



C18
RMS quick-change system, hand-operated for clamping devices

	KK 06	KK 08
RMS - complete (flange incl. quick-clamping screw)	1160028 ▲	1160029 ▲
Adapters RMS	1183312 ▲	1183313 ▲
A	38	45
Ø B	170	220
Ø C	133,4	171,4
Ø D	106,375	139,719
Ø E mm	M8	M8
Ø F mm	139 H7	139 H7



APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring. Suitable for short clamping lengths and very small clamping diameters starting from 10 mm.

TYPE

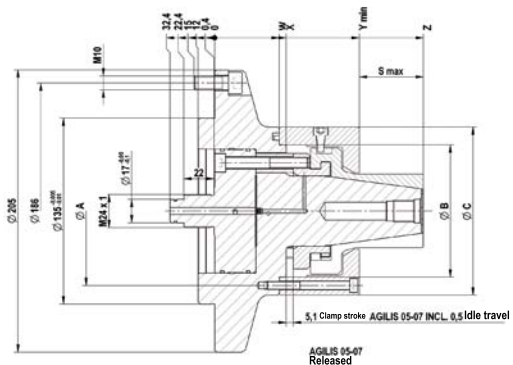
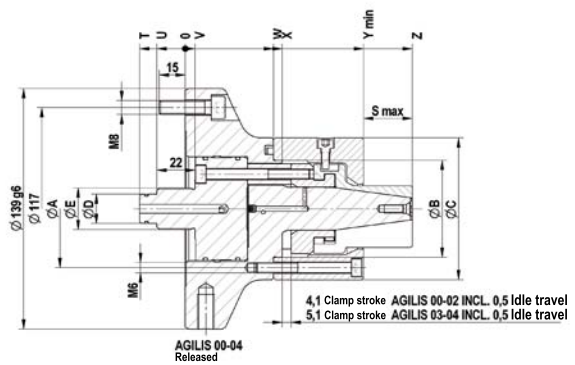
Force-actuated.

CUSTOMER BENEFITS

- ⊕ Short setup and non-productive times thanks to great expansion of segment sleeves
- ⊕ Vibration damping due to high vulcanized rubber component of clamping sleeves
- ⊕ Sturdy clamping of the workpiece thanks to axial tension against workpiece stop
- ⊕ Fast change thanks to bayonet catch
- ⊕ High concentricity, axial run-out and repeatability

TECHNICAL FEATURES

- Manual lubrication
- Air sensing prepared

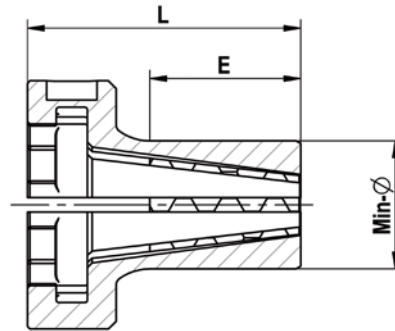
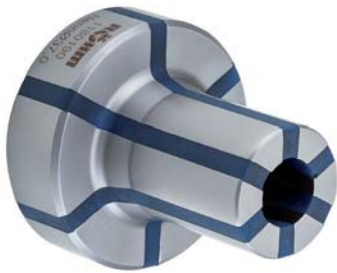


C 18

AGILIS segment clamping mandrel, **power-operated with flanged seat**, for internal clamping

	AGILIS 00	AGILIS 01	AGILIS 02	AGILIS 03	AGILIS 04	AGILIS 05	AGILIS 06	AGILIS 07
Segment clamping mandrel	1180000	1180001	1180002	1180003	1180004	1180005 ▲	1180006 ▲	1180007 ▲
Basic mandrel	1180010	1180011	1180012	1180013	1180014	1180015	1180016	1180017
Adapter power operated	1180030	1180030	1180032	1180032	1180034	1180035	1180036	1180037
Bolt spacer	1180060	1180060	1180062	1180063	1180064	1180065	1180066	1180066
Retaining ring	1180050	1180050	1180052	1180052	1180054	1180055	1180056	1180057
F max, in kN	5	7,5	15	20	25	30	35	35
Max, total clamping force approx, kN	26	39	79	85	106	127	149	149
Min-Ø unclamped from	9,7	13,7	18,7	26,7	36,7	53,7	71,7	94,7
Min-Ø unclamped to	15,7	24,7	34,7	44,7	64,7	84,7	104,7	129,7
Pitch diameter A	54	54	69	69	88	108	127	152
Guide diameter B	42	42	56	56	75	96	114	135
Ø C mm	68	68	82	82	101	122	140	169
Ø D mm	12	12	17	17	17			
Ø E mm	M 16	M 16	M 24x1	M 24x1	M 24x1			
S max, mm	16,8	18,8	23,8	28,1	42,1	46,1	57,1	67,1
T mm	27,7	27,7	25,4	26,4	26,4			
U mm	17,7	17,7	15,4	16,4	16,4			
V mm	4,3	4,3	6,6	5,6	5,6			
W mm	41,5	41,5	52	51	52	47	49	49
X mm	46,5	46,5	57,2	56	57	52	54	54
Y min,	80	80	103	103	108	105	109	109
Z mm	96,8	98,8	126,8	131,1	150,1	151,1	166,1	176,1

Accessories AGILIS



C18
Segment clamping sleeves AGILIS

	AGILIS 00	AGILIS 01	AGILIS 02	AGILIS 03	AGILIS 04	AGILIS 05	AGILIS 06	AGILIS 07
Expansion in Ø mm	0,6	0,6	0,6	1,2	1,2	1,2	1,2	1,2
Total length L	38	40	52,5	57	76	82	95	105
Min-Ø mm	9,7	13,7	18,7	26,7	36,7	53,7	71,7	94,7
Segment sleeve	1180100	1180120	1180140	1180170	1180190	1180220	1180250	1180290
Work stop	1180400 ▲	1180420 ▲	1180440 ▲	1180470 ▲	1180490 ▲	1180520 ▲	1180550 ▲	1180590 ▲
Min-Ø mm	10,2	14,2	19,2	27,7	37,7	54,7	72,7	95,7
Segment sleeve	1180101	1180121	1180141	1180171	1180191	1180221	1180251	1180291
Work stop	1180401 ▲	1180421 ▲	1180441 ▲	1180471 ▲	1180491 ▲	1180521 ▲	1180551 ▲	1180591 ▲
Min-Ø mm	10,7	14,7	19,7	28,7	38,7	55,7	73,7	96,7
Segment sleeve	1180102	1180122	1180142	1180172	1180192	1180222	1180252	1180292
Work stop	1180402 ▲	1180422 ▲	1180442 ▲	1180472 ▲	1180492 ▲	1180522 ▲	1180552 ▲	1180592 ▲
Min-Ø mm	11,2	15,2	20,2	29,7	39,7	56,7	74,7	97,7
Segment sleeve	1180103	1180123	1180143	1180173	1180193	1180223	1180253	1180293
Work stop	1180403 ▲	1180423 ▲	1180443 ▲	1180473 ▲	1180493 ▲	1180523 ▲	1180553 ▲	1180593 ▲
Min-Ø mm	11,7	15,7	20,7	30,7	40,7	57,7	75,7	98,7
Segment sleeve	1180104	1180124	1180144	1180174	1180194	1180224	1180254	1180294
Work stop	1180404 ▲	1180424 ▲	1180444 ▲	1180474 ▲	1180494 ▲	1180524 ▲	1180554 ▲	1180594 ▲
Min-Ø mm	12,2	16,2	21,2	31,7	41,7	58,7	76,7	99,7
Segment sleeve	1180105	1180125	1180145	1180175	1180195	1180225	1180255	1180295
Work stop	1180405 ▲	1180425 ▲	1180445 ▲	1180475 ▲	1180495 ▲	1180525 ▲	1180555 ▲	1180595 ▲
Min-Ø mm	12,7	16,7	21,7	32,7	42,7	59,7	77,7	100,7
Segment sleeve	1180106	1180126	1180146	1180176	1180196	1180226	1180256	1180296
Work stop	1180406 ▲	1180426 ▲	1180446 ▲	1180476 ▲	1180496 ▲	1180526 ▲	1180556 ▲	1180596 ▲
Min-Ø mm	13,2	17,2	22,2	33,7	43,7	60,7	78,7	101,7
Segment sleeve	1180107	1180127	1180147	1180177	1180197	1180227	1180257	1180297
Work stop	1180407 ▲	1180427 ▲	1180447 ▲	1180477 ▲	1180497 ▲	1180527 ▲	1180557 ▲	1180597 ▲
Min-Ø mm	13,7	17,7	22,7	34,7	44,7	61,7	79,7	102,7
Segment sleeve	1180108	1180128	1180148	1180178	1180198	1180228	1180258	1180298
Work stop	1180408 ▲	1180428 ▲	1180448 ▲	1180478 ▲	1180498 ▲	1180528 ▲	1180558 ▲	1180598 ▲
Min-Ø mm	14,2	18,2	23,2	35,7	45,7	62,7	80,7	103,7
Segment sleeve	1180109	1180129	1180149	1180179	1180199	1180229	1180259	1180299
Work stop	1180409 ▲	1180429 ▲	1180449 ▲	1180479 ▲	1180499 ▲	1180529 ▲	1180559 ▲	1180599 ▲
Min-Ø mm	14,7	18,7	23,7	36,7	46,7	63,7	81,7	104,7
Segment sleeve	1180110	1180130	1180150	1180180	1180200	1180230	1180260	1180300
Work stop	1180410 ▲	1180430 ▲	1180450 ▲	1180480 ▲	1180500 ▲	1180530 ▲	1180560 ▲	1180600 ▲
Min-Ø mm	15,2	19,2	24,2	37,7	47,7	64,7	82,7	105,7
Segment sleeve	1180111	1180131	1180151	1180181	1180201	1180231	1180261	1180301
Work stop	1180411 ▲	1180431 ▲	1180451 ▲	1180481 ▲	1180501 ▲	1180531 ▲	1180561 ▲	1180601 ▲
Min-Ø mm	15,7	19,7	24,7	38,7	48,7	65,7	83,7	106,7
Segment sleeve	1180112	1180132	1180152	1180182	1180202	1180232	1180262	1180302
Work stop	1180412 ▲	1180432 ▲	1180452 ▲	1180482 ▲	1180502 ▲	1180532 ▲	1180562 ▲	1180602 ▲
Min-Ø mm		20,2	25,2	39,7	49,7	66,7	84,7	107,7
Segment sleeve		1180133	1180153	1180183	1180203	1180233	1180263	1180303
Work stop		1180433 ▲	1180453 ▲	1180483 ▲	1180503 ▲	1180533 ▲	1180563 ▲	1180603 ▲
Min-Ø mm		20,7	25,7	40,7	50,7	67,7	85,7	108,7
Segment sleeve		1180134	1180154	1180184	1180204	1180234	1180264	1180304
Work stop		1180434 ▲	1180454 ▲	1180484 ▲	1180504 ▲	1180534 ▲	1180564 ▲	1180604 ▲
Min-Ø mm		21,2	26,2	41,7	51,7	68,7	86,7	109,7
Segment sleeve		1180135	1180155	1180185	1180205	1180235	1180265	1180305
Work stop		1180435 ▲	1180455 ▲	1180485 ▲	1180505 ▲	1180535 ▲	1180565 ▲	1180605 ▲
Min-Ø mm		21,7	26,7	42,7	52,7	69,7	87,7	110,7
Segment sleeve		1180136	1180156	1180186	1180206	1180236	1180266	1180306
Work stop		1180436 ▲	1180456 ▲	1180486 ▲	1180506 ▲	1180536 ▲	1180566 ▲	1180606 ▲

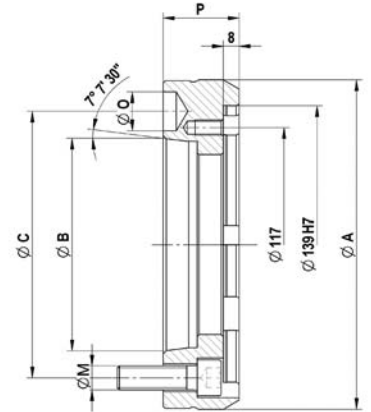
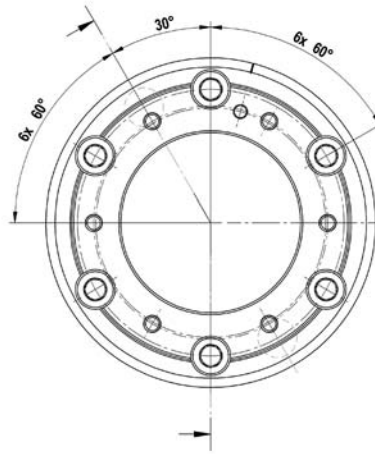
Accessories AGILIS

C18

Segment clamping sleeves AGILIS

	AGILIS 00	AGILIS 01	AGILIS 02	AGILIS 03	AGILIS 04	AGILIS 05	AGILIS 06	AGILIS 07
Expansion in Ø mm	0,6	0,6	0,6	1,2	1,2	1,2	1,2	1,2
Total length L	38	40	52,5	57	76	82	95	105
Min-Ø mm		22,2	27,2	43,7	53,7	70,7	88,7	111,7
Segment sleeve		1180137	1180157	1180187	1180207	1180237	1180267	1180307
Work stop		1180437 ▲	1180457 ▲	1180487 ▲	1180507 ▲	1180537 ▲	1180567 ▲	1180607 ▲
Min-Ø mm		22,7	27,7	44,7	54,7	71,7	89,7	112,7
Segment sleeve		1180138	1180158	1180188	1180208	1180238	1180268	1180308
Work stop		1180438 ▲	1180458 ▲	1180488 ▲	1180508 ▲	1180538 ▲	1180568 ▲	1180608 ▲
Min-Ø mm		23,2	28,2		55,7	72,7	90,7	113,7
Segment sleeve		1180139	1180159		1180209	1180239	1180269	1180309
Work stop		1180439 ▲	1180459 ▲		1180509 ▲	1180539 ▲	1180569 ▲	1180609 ▲
Min-Ø mm		23,7	28,7		56,7	73,7	91,7	114,7
Segment sleeve		1180350	1180160		1180210	1180240	1180270	1180310
Work stop		1180630 ▲	1180460 ▲		1180510 ▲	1180540 ▲	1180570 ▲	1180610 ▲
Min-Ø mm		24,2	29,2		57,7	74,7	92,7	115,7
Segment sleeve		1180351	1180161		1180211	1180241	1180271	1180311
Work stop		1180631 ▲	1180461 ▲		1180511 ▲	1180541 ▲	1180571 ▲	1180611 ▲
Min-Ø mm		24,7	29,7		58,7	75,7	93,7	116,7
Segment sleeve		1180352	1180162		1180212	1180242	1180272	1180312
Work stop		1180632 ▲	1180462 ▲		1180512 ▲	1180542 ▲	1180572 ▲	1180612 ▲
Min-Ø mm			30,2		59,7	76,7	94,7	117,7
Segment sleeve			1180163		1180213	1180243	1180273	1180313
Work stop			1180463 ▲		1180513 ▲	1180543 ▲	1180573 ▲	1180613 ▲
Min-Ø mm			30,7		60,7	77,7	95,7	118,7
Segment sleeve			1180164		1180214	1180244	1180274	1180314
Work stop			1180464 ▲		1180514 ▲	1180544 ▲	1180574 ▲	1180614 ▲
Min-Ø mm			31,2		61,7	78,7	96,7	119,7
Segment sleeve			1180165		1180215	1180245	1180275	1180315
Work stop			1180465 ▲		1180515 ▲	1180545 ▲	1180575 ▲	1180615 ▲
Min-Ø mm			31,7		62,7	79,7	97,7	120,7
Segment sleeve			1180166		1180216	1180246	1180276	1180316
Work stop			1180466 ▲		1180516 ▲	1180546 ▲	1180576 ▲	1180616 ▲
Min-Ø mm			32,2		63,7	80,7	98,7	121,7
Segment sleeve			1180167		1180217	1180247	1180277	1180317
Work stop			1180467 ▲		1180517 ▲	1180547 ▲	1180577 ▲	1180617 ▲
Min-Ø mm			32,7		64,7	81,7	99,7	122,7
Segment sleeve			1180168		1180218	1180248	1180278	1180318
Work stop			1180468 ▲		1180518 ▲	1180548 ▲	1180578 ▲	1180618 ▲
Min-Ø mm			33,2			82,7	100,7	123,7
Segment sleeve			1180169			1180249	1180279	1180319
Work stop			1180469 ▲			1180549 ▲	1180579 ▲	1180619 ▲
Min-Ø mm			33,7			83,7	101,7	124,7
Segment sleeve			1180360			1180370	1180280	1180320
Work stop			1180640 ▲			1180650 ▲	1180580 ▲	1180620 ▲
Min-Ø mm			34,2			84,7	102,7	125,7
Segment sleeve			1180361			1180371	1180281	1180321
Work stop			1180641 ▲			1180651 ▲	1180581 ▲	1180621 ▲
Min-Ø mm			34,7				103,7	126,7
Segment sleeve			1180362				1180282	1180322
Work stop			1180642 ▲				1180582 ▲	1180622 ▲
Min-Ø mm							104,7	127,7
Segment sleeve							1180283	1180323
Work stop							1180583 ▲	1180623 ▲
Min-Ø mm								128,7
Segment sleeve								1180324
Work stop								1180624 ▲
Min-Ø mm								129,7
Segment sleeve								1180325
Work stop								1180625 ▲

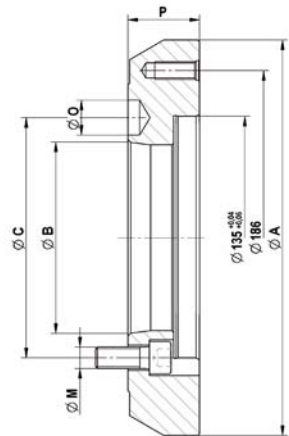
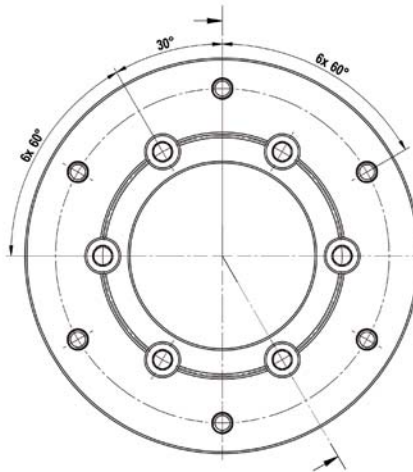
Accessories AGILIS



C 18

Intermediate flange ISO 702-1 (DIN 55028), for size 00-04

	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Intermediate flange	1110005	1110006	1110008	1110011 ▲
Ø A mm	165	170	220	282
Ø B	82,563	106,375	139,719	196,869
Ø C mm	104,8	133,4	171,4	235
Thread-Ø M	M10	M12	M16	M20
Ø O mm	16,3	19,45	24,2	29,4
P mm	36	38	45	45

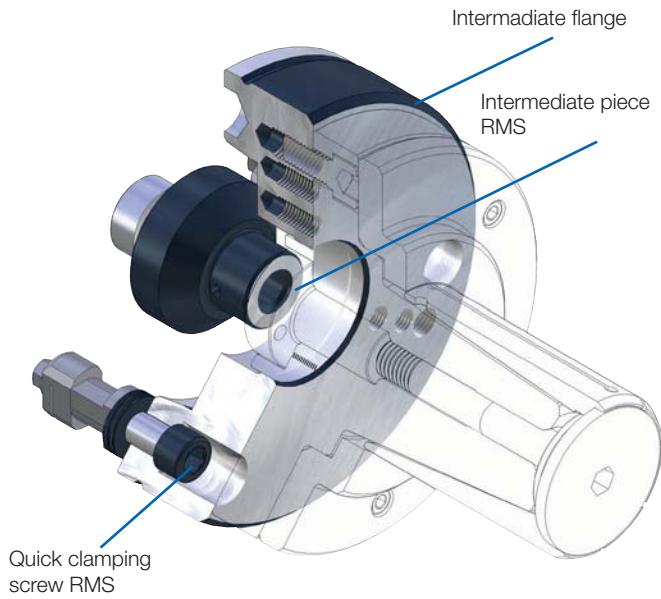


C 18

Intermediate flange ISO 702-1 (DIN 55028)

	Nr. 5 (A5)	Nr. 6 (A6)	Nr. 8 (A8)
Intermediate flange	1072115	1072117	1072119
For	KZF-S 80/AGILIS 05-07	KZF-S 120/AGILIS 05-07	KZF-S 120/AGILIS 05-07
Short-taper-Ø B	82,563	106,375	139,719
Short-taper pitch circle Ø C	104,8	133,4	171,4
Flange outer-Ø A	220	220	220
Ø D	135	135	135
Ø F mm	186	186	186
Ø O mm	16,3	19,45	24,2
Thread-Ø M	M10	M12	M16
Total length flange P	40	40	40

Accessories AGILIS



APPLICATION

For manual clamping devices exchange in a minimum of time.

TYPE

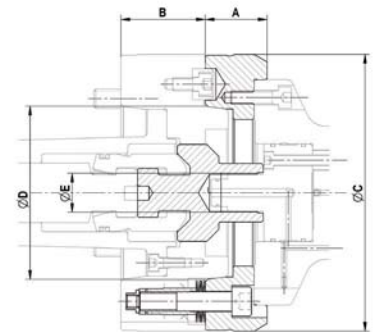
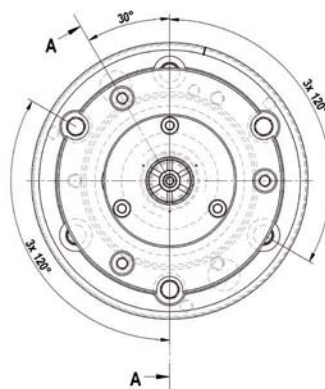
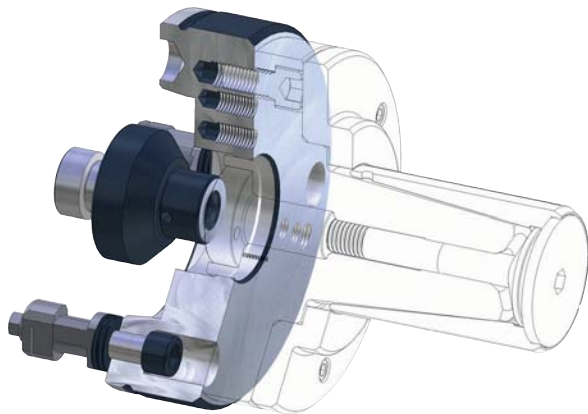
Manual quick-change system for clamping devices. Fits ABSIS (269-00), AGILIS (296-00). Central lubrication and / or air sensing control possible.

CUSTOMER BENEFITS

- ⌚ Manual clamping devices change in about 30 seconds
- ⌚ High change precision within 0.005 mm
- ⌚ Quick change of different clamping devices with short time, similar to the automatic or semiautomatic clamping devices changing systems

TECHNICAL FEATURES

- Quick-change system suitable due to recording RMS see quick-change system RMS (Product Group 6)
- Corresponds to the guidelines of the Employer's Liability Insurance Association in combination with RÖHM safety clamping cylinder OVS and LVS



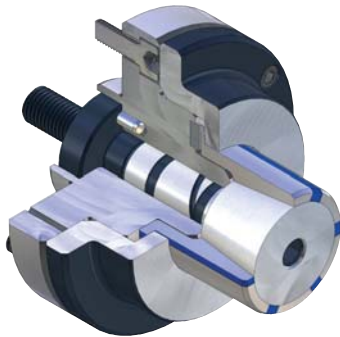
C18

RMS quick-change system, hand-operated for clamping devices

	A 06	A 08
For	AGILIS 00-04 296-00	AGILIS 00-04 296-00
RMS - complete (flange incl, quick-clamping screw)	1180340 ▲	1180342 ▲
Adapters RMS	look Type 296-00 AGILIS	look Type 296-00 AGILIS
A	38	45
Ø B	170	215
Ø C	133,4	171,4
Ø D	106,375	139,719
Ø E mm	M12	M16
Ø F mm	139 H7	139 H7

Matching intermediate pieces RMS KK6 and RMS KK8 can be found directly in the product table of the segment clamping mandrel AGILIS

KFR-SE



APPLICATION

Internal clamping of round workpieces. Turning, grinding and toothing operations, as well as for balancing and measuring.

TYPE

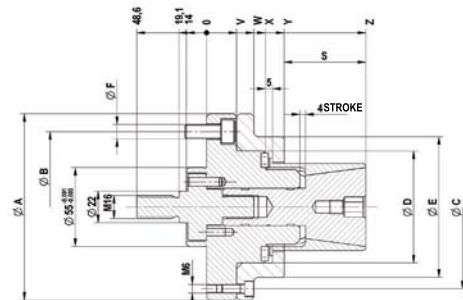
Force-actuated. Ideal for short clamping lengths / workpieces.

CUSTOMER BENEFITS

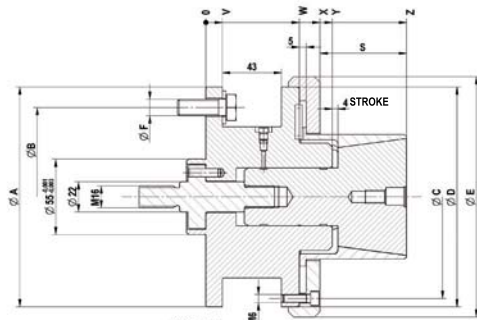
- ② Short setup and non-productive times thanks to great expansion of segment sleeves
- ② Vibration damping due to high vulcanized rubber component of the clamping sleeves
- ② No workpiece tension thanks to def. axial tension against the workpiece stop
- ② High concentricity, axial run-out and repeatability

TECHNICAL FEATURES

- Integrated lubrication
- Air sensing prepared



KFR-SE 06-08
Released



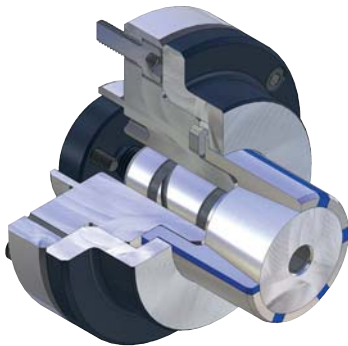
KFR-SE 06-12
Released

C18

KFR-SE segment clamping mandrel, **power-operated with flanged seat**, for internal clamping
Consisting of basic body, clamping taper, intermediate piece, nut

	KFR 00	KFR 01	KFR 02	KFR 03	KFR 04	KFR 05	KFR 06	KFR 07	KFR 08	KFR 09	KFR 10	KFR 11	KFR 12
Segment clamping mandrel	1171410	1171411	1171412	1171413	1171414	1171415	893966 ▲	893967 ▲	893968 ▲	893969 ▲	893970 ▲	893971 ▲	893972 ▲
Base bolt	893800	893801	893802	893803	893804	893805	893806 ▲	893807 ▲	893807 ▲	893809 ▲	893809 ▲	893809 ▲	893809 ▲
Clamping taper	1171436	1171437	1171438	1171439	1171440	1171441	650346 ▲	650347 ▲	650348 ▲	650349 ▲	650350 ▲	650351 ▲	650352 ▲
Adapter power operated	1199848	1199849	1199850	893819	893820	893820	893821	893822	893822	893822	893822	893822	893822
Nut	893814	893814	893814										
F max, in kN	4,65	13,1	19,5	24,4	26,8	33	33	33	33	33	33	33	33
Max, total clamping force	20	56	83	104	114	140	140	140	140	140	140	140	140
Min-Ø unclamped from	14,2	19,7	24,7	35,7	40,7	50,7	60,7	70,7	80,7	90,7	100,7	110,7	120,7
Min-Ø unclamped to	19,7	24,7	35,7	40,7	50,7	60,7	70,7	80,7	90,7	100,7	110,7	120,7	130,7
Clamping-Ø max,	20,7	25,7	36,7	41,7	51,7	61,7	71,7	81,7	91,7	101,7	111,7	121,7	131,7
External-Ø A	100	100	100	100	130	130	130	160	160	160	160	160	160
Pitch diameter B	75	75	75	75	105	105	105	130	130	130	130	130	130
Pitch diameter C	85	85	85	85	114	114	114	145	145	148	148	148	148
Ø D mm	50	50	50	50	78	78	78	100	100	160	160	160	160
Ø E mm	70	70	70	70	98	98	98	130	130	175	175	175	175
Ø F mm	M10	M10	M10	M10	M10	M10	M10	M12	M12	M12	M12	M12	M12
S mm	21	27	27	27	42	42	57	55	55	63	63	63	63
V mm	21	21	21	21	21	21	21	32	32	12	12	12	12
W mm	33	33	33	33	33	33	33	50	50	68	68	68	68
X mm	39	39	39	39	41	41	41	58	58	83	83	83	83
Y mm	50	52	52	52	54	54	54	73	73	92	92	92	92
Z mm	71	79	79	79	96	96	111	128	128	146	146	146	146

MFR-SE



APPLICATION

Internal clamping of round workpieces. Turning, grinding and tothing operations, as well as for balancing and measuring. Ideal for short clamping lengths / workpieces.

TYPE

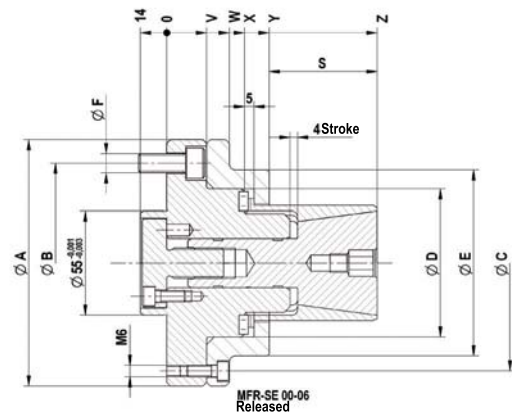
Manually actuated.
With vulcanized clamping sleeves / segment sleeves.

CUSTOMER BENEFITS

- ③ No workpiece tension thanks to def. axial tension against the workpiece stop
- ③ High concentricity, axial run-out and repeatability
- ③ Low-maintenance

TECHNICAL FEATURES

- Hardened, low-wear design
- Integrated lubrication
- Air sensing prepared

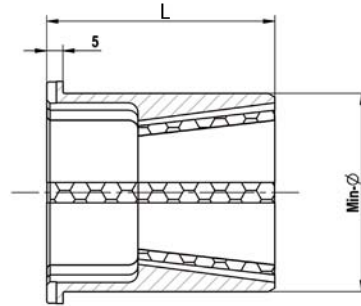


C18

MFR-SE segment clamping mandrel, **hand-operated with flanged seat**, for internal clamping
Consisting of basic body, clamping taper, intermediate piece

	MFR 00	MFR 01	MFR 02	MFR 03	MFR 04	MFR 05	MFR 06
Segment clamping mandrel	1171423	1171424	1171425	1171426	1171427	1171428	1077706 ▲
Base bolt	893800	893801	893802	893803	893804	893805	893806 ▲
Clamping taper	1171436	1171437	1171438	1171439	1171440	1171441	650346 ▲
Adapter hand-operated	893823	893824	893825	893826	893827	893827	893828
Md max, kN	4	5	20	40	55	60	85
Min-Ø unclamped from	14,7	19,7	24,7	35,7	40,7	50,7	60,7
Min-Ø unclamped to	19,7	24,7	35,7	40,7	50,7	60,7	70,7
Clamping-Ø max,	20,7	25,7	36,7	41,7	51,7	61,7	71,7
External-Ø A	100	100	100	100	130	130	130
Pitch diameter B	75	75	75	75	105	105	105
Pitch diameter C	85	85	85	85	114	114	114
Ø D mm	50	50	50	50	78	78	78
Ø E mm	70	70	70	70	98	98	98
Ø F mm	M10	M10	M10	M10	M10	M10	M10
S mm	21	27	27	27	42	42	57
V mm	21	21	21	21	21	21	21
W mm	33	33	33	33	33	33	33
X mm	39	39	39	39	41	41	41
Y mm	50	52	52	52	54	54	54
Z mm	71	79	79	79	96	96	111

Accessories KFR-SE / MFR-SE



C18
Segment sleeve KFR-SE / MFR-SE

For size	00	01	02	03	04	05	06	07	08	09	10	11	12
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1	1
Total length	32	40	40	40	55	55	70	70	70	78	78	78	78
Min-Ø mm	14,7	19,7	24,7	35,7	40,7	50,7	60,7	70,7	80,7	90,7	100,7	110,7	120,7
Segment sleeve	1171000 ▲	1171006 ▲	1171012 ▲	1171024 ▲	1171030 ▲	1171041 ▲	1171052 ▲	1171063 ▲	1171074 ▲	1171085 ▲	1171096 ▲	1171107 ▲	1171118 ▲
Work stop	893830	893836	893842	893852	893857	893867	893878	893888	893897	893907	893917	893927	893937
Min-Ø mm	15,7	20,7	25,7	36,7	41,7	51,7	61,7	71,7	81,7	91,7	101,7	111,7	121,7
Segment sleeve	1171001 ▲	1171007 ▲	1171013 ▲	1171025 ▲	1171031 ▲	1171042 ▲	1171053 ▲	1171064 ▲	1171075 ▲	1171086 ▲	1171097 ▲	1171108 ▲	1171119 ▲
Work stop	893831	893837	893842	893853	893858	893868	893879	893889	893898	893908	893918	893928	893938
Min-Ø mm	16,7	21,7	26,7	37,7	42,7	52,7	62,7	72,7	82,7	92,7	102,7	112,7	122,7
Segment sleeve	1171002 ▲	1171008 ▲	1171014 ▲	1171026 ▲	1171032 ▲	1171043 ▲	1171054 ▲	1171065 ▲	1171076 ▲	1171087 ▲	1171098 ▲	1171109 ▲	1171120 ▲
Work stop	893832	893838	893843	893854	893859	893869	893880	893890	893899	893909	893919	893929	893939
Min-Ø mm	17,7	22,7	27,7	38,7	43,7	53,7	63,7	73,7	83,7	93,7	103,7	113,7	123,7
Segment sleeve	1171003 ▲	1171009 ▲	1171015 ▲	1171027 ▲	1171033 ▲	1171044 ▲	1171055 ▲	1171066 ▲	1171077 ▲	1171088 ▲	1171099 ▲	1171110 ▲	1171121 ▲
Work stop	893833	893839	893844	893855	893860	893870	893881	893891	893900	893910	893920	893930	893940
Min-Ø mm	18,7	23,7	28,7	39,7	44,7	54,7	64,7	74,7	84,7	94,7	104,7	114,7	124,7
Segment sleeve	1171004 ▲	1171010 ▲	1171016 ▲	1171028 ▲	1171034 ▲	1171045 ▲	1171056 ▲	1171067 ▲	1171078 ▲	1171089 ▲	1171100 ▲	1171111 ▲	1171122 ▲
Work stop	893834	893840	893845	893856	893861	893871	893882	893892	893901	893911	893921	893931	893941
Min-Ø mm	19,7	24,7	29,7	40,7	45,7	55,7	65,7	75,7	85,7	95,7	105,7	115,7	125,7
Segment sleeve	1171005 ▲	1171011 ▲	1171017 ▲	1171029 ▲	1171035 ▲	1171046 ▲	1171057 ▲	1171068 ▲	1171079 ▲	1171090 ▲	1171101 ▲	1171112 ▲	1171123 ▲
Work stop	893835	893841	893846	893856	893862	893872	893883	893893	893902	893912	893922	893932	893942
Min-Ø mm			30,7		46,7	56,7	66,7	76,7	86,7	96,7	106,7	116,7	126,7
Segment sleeve			1171018 ▲		1171036 ▲	1171047 ▲	1171058 ▲	1171069 ▲	1171080 ▲	1171091 ▲	1171102 ▲	1171113 ▲	1171124 ▲
Work stop			893847		893863	893873	893884	893894	893903	893913	893923	893933	893943
Min-Ø mm			31,7		47,7	57,7	67,7	77,7	87,7	97,7	107,7	117,7	127,7
Segment sleeve			1171019 ▲		1171037 ▲	1171048 ▲	1171059 ▲	1171070 ▲	1171081 ▲	1171092 ▲	1171103 ▲	1171114 ▲	1171125 ▲
Work stop			893848		893864	893874	893885	893895	893904	893914	893924	893934	893944
Min-Ø mm			32,7		48,7	58,7	68,7	78,7	88,7	98,7	108,7	118,7	128,7
Segment sleeve			1171020 ▲		1171038 ▲	1171049 ▲	1171060 ▲	1171071 ▲	1171082 ▲	1171093 ▲	1171104 ▲	1171115 ▲	1171126 ▲
Work stop			893849		893865	893875	893886	893947	893905	893915	893925	893935	893945
Min-Ø mm			33,7		49,7	59,7	69,7	79,7	89,7	99,7	109,7	119,7	129,7
Segment sleeve			1171021 ▲		1171039 ▲	1171050 ▲	1171061 ▲	1171072 ▲	1171083 ▲	1171094 ▲	1171105 ▲	1171116 ▲	1171127 ▲
Work stop			893850		893866	893876	893887	893896	893906	893916	893926	893936	893946
Min-Ø mm			34,7		50,7	60,7	70,7	80,7	90,7	100,7	110,7	120,7	130,7
Segment sleeve			1171022 ▲		1171040 ▲	1171051 ▲	1171062 ▲	1171073 ▲	1171084 ▲	1171095 ▲	1171106 ▲	1171117 ▲	1171128 ▲
Work stop			893851		893867	893877	893887	893896	893906	893916	893926	893936	893946
Min-Ø mm			35,7										
Segment sleeve			1171023 ▲										
Work stop			893852										

Intermediate flange KFR-SE / MFR-SE



APPLICATION

For adaption of cartridge mandrel KFR/MFR/KFR-SE/MFR-SE or KFS/MFS - on spindle head ISO 702-1 / ISO 702-3 (DIN 55021/55022/55026 and 55027).

TYPE

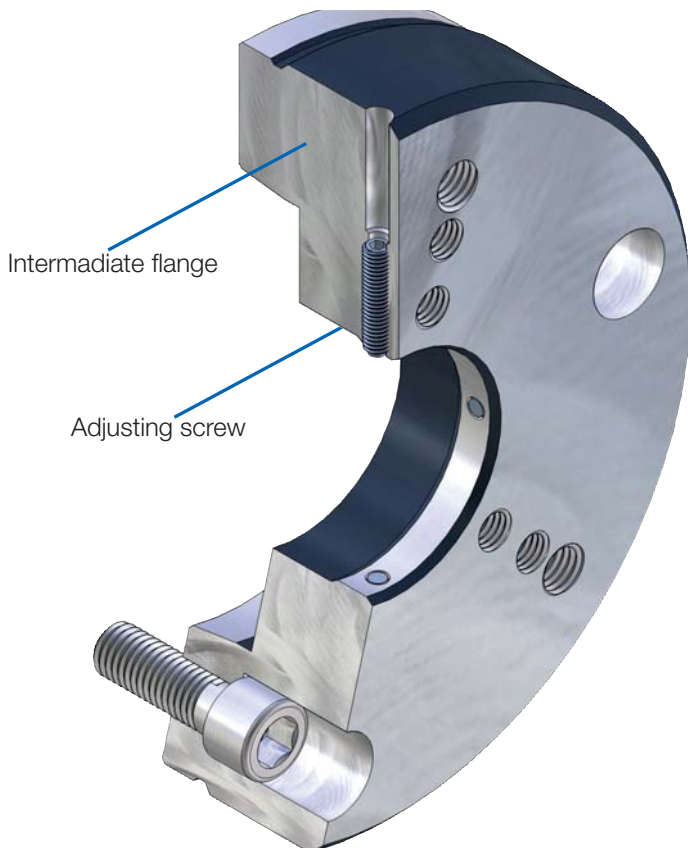
For KFR/MFR/KFR-SE/MFR-SE or KFS/MFS.

CUSTOMER BENEFITS

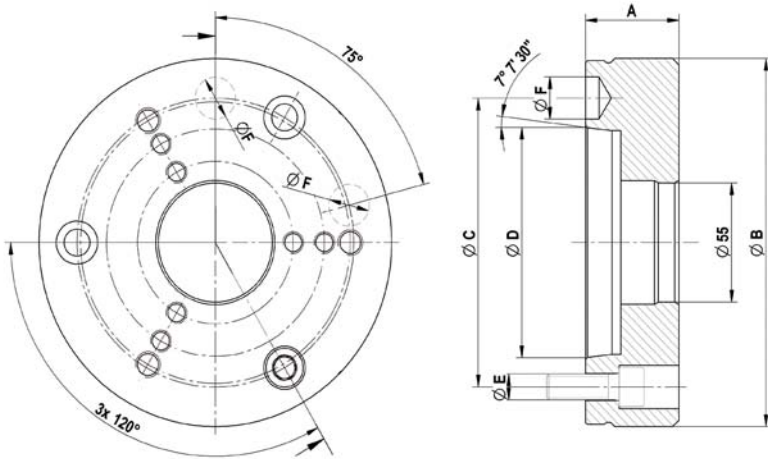
④ By replacement of the Intermediate flange, one cartridge mandrel can be used on different machines

TECHNICAL FEATURES

Adaptation of mandrel KFR / MFR / KFR-SE / MFR SE or KFS / MFS on spindle head, with or without adjustment, with or without operation of air-conditioning control. Execution according to ISO 702-1 (DIN 55028-A) or ISO 702-3 (DIN 55028-C), in size no. 5, no. 6, no. 8, no. 11 or no. 5, no. 6. Nr. 8 (A5, A6, A8, A11 or C5, C6, C8).



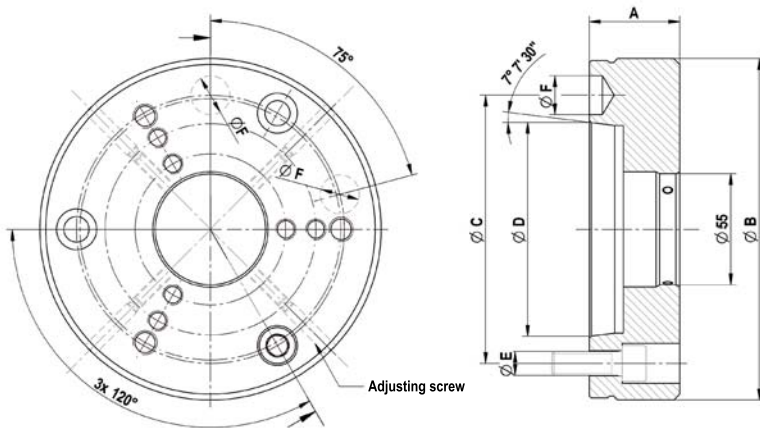
Accessories KFR-SE / MFR-SE



C 18

Intermediate flange ISO 702-1 (DIN 55026/55021) without adjusting screw

	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Intermediate flange	893975	893976	893977	893978 ▲
Design	without air-sensing	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50	50
Ø B	165	170	220	282
Ø C mm	104,8	133,4	171,4	235
Ø D mm	82,563	106,375	139,719	196,869
Ø E	M10	M12	M16	M20
Ø F mm	16,3	19,45	24,2	29,4

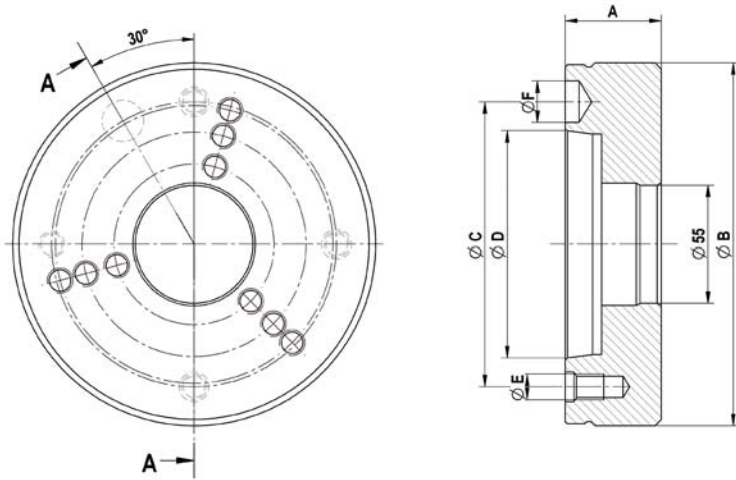


C 18

Intermediate flange ISO 702-1 (DIN 55028) with adjusting screw

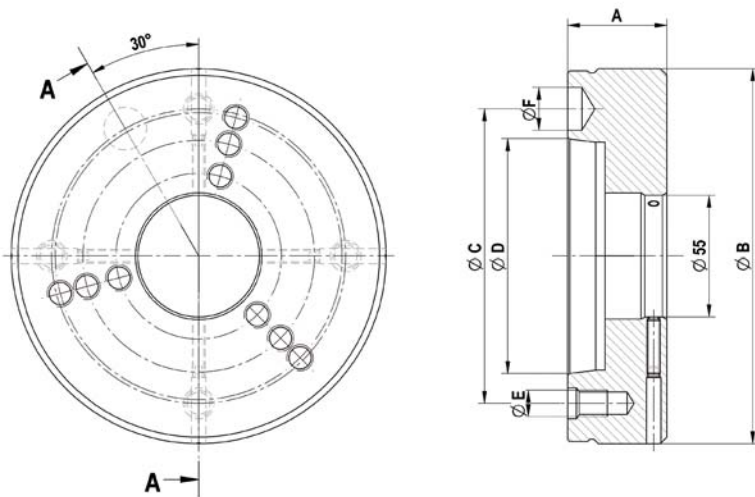
	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)
Intermediate flange	893979	893980	893981
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M10	M12	M16
Ø F mm	16,3	19,45	24,2

Accessories KFR-SE / MFR-SE



C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) without adjusting screws

	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	893982	893983	893984
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2



C 18
Intermediate flange ISO 702-3 (DIN 55027/55022) with adjusting screws

	Nr. 5 (C 05)	Nr. 6 (C 06)	Nr. 8 (C 08)
Intermediate flange	893985	893986	893987
Design	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55	+0,05/+0,04	+0,05/+0,04	+0,05/+0,04
A mm	45	45	50
Ø B	165	170	220
Ø C mm	104,8	133,4	171,4
Ø D mm	82,563	106,375	139,719
Ø E	M 10	M 12	M 16
Ø F mm	16,3	19,45	24,2

Special solutions ABSIS



ABSIS Segment clamping mandrel - nominal 38,43 mm

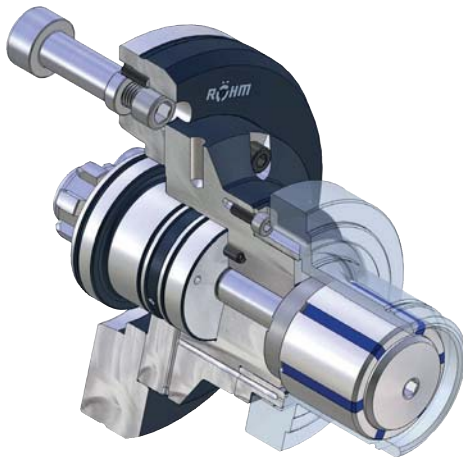
APPLICATION

Cutting, Turning

ABSIS clamping mandrel for clamping on a tothing machine. The centering is done by the segment clamping sleeve; the clamping by the pendulum bell. Clamping mandrel with quick change system on the basic take-up.

CUSTOMER BENEFITS

- Stable clamping using axial pull
- Concentricity of 0.01 mm
- A lot of freedom of the tool (milling coasting)
- Designed for wet machining



ABSIS Segment clamping mandrel - nominal 60,5 mm

APPLICATION

Turning

ABSIS clamping mandrel for clamping on a lathe. Clamping mandrel with quick change system on the basic take-up. Fixed workpiece stop with air sensing. Clamping screw sunk in the segment clamping sleeve to ensure the freedom of the tool. Different clamping mandrel sizes of clamping diameters 25 mm to diameter 105 mm (ABSIS size 00 to size 04).

CUSTOMER BENEFITS

- Stable clamping using axial pull
- Concentricity of 0.01 mm
- Simple changing of the workpiece stop as well as the clamping sleeves
- A lot of freedom of the tool

Special solutions ABSIS



ABSIS Segment clamping mandrel TK-Ø 88 mm

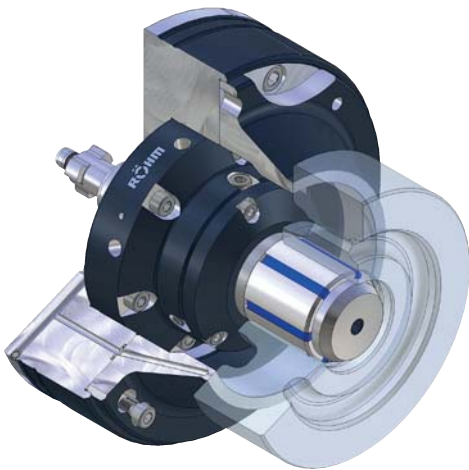
APPLICATION

Turning

ABSIS clamping mandrel for clamp in the toothing. The toothed segment clamping sleeve clamps the workpiece exactly in the tooth flanks. The centering disc helps during loading of the workpiece. Workpiece stop can be pulled back using draw bar with air sensing.

CUSTOMER BENEFITS

- ⊕ Freedom of tool by stop that can be pulled back
- ⊕ Concentricity of 0.01 mm



ABSIS Segment clamping mandrel Ø 55,33 mm

APPLICATION

Turning of a gear wheel blank

Force-actuated ABSIS standard clamping mandrel with quick change system. The stop diameter is far beyond the clamping diameter. Workpiece stop with air sensing attached on the intermediate flange.

CUSTOMER BENEFITS

- ⊕ Stable clamping using axial pull
- ⊕ Concentricity of 0.01 mm
- ⊕ Low-cost thanks to standard components



FAST CHANGING WITHIN THE MODULAR SYSTEM



As a consistent modular system, it is possible to combine the individual components such as CAPTIS collet chuck, CAPTIS collet and ABSIS-C clamping mandrel depending on use.

Collet replacing

Fast and easy collet replacement in 15 seconds reduces the set-up times.

Changing collets and clamping mandrel

Innovative and patent-pending quick changing function for fast conversion from outer to inner clamping in less than one minute.



COLLET CHUCKS

The new and modular CAPTIS clamping system is impressive in both rotary applications in lathes and in stationary use in drilling, milling and machining centres and measuring machines. The conversion from outer to inner clamping can be done in less than 1 minute with the innovative and patent-pending quick changing function. The encompassing clamping enables precise concentricity and repeatability of 0.005 mm without deforming the workpiece.

ADVANTAGES AT A GLANCE

- ⊕ Highest flexibility due to modular construction
- ⊕ Precise concentricity and repeatability of 0.005 mm
- ⊕ Compact and weight-reduced construction for a larger work area



Video CAPTIS-D



Video CAPTIS-MS

CAPTIS-D, CAPTIS-A, CAPTIS-AF

- ⊕ Modular construction for highest flexibility
- ⊕ Compact construction for more work space
- ⊕ Many combination and conversion possibilities



ABSIS-C CLAMPING MANDREL

- ⊕ Innovative and patent-pending quick changing function to convert from outer to inner clamping in less than one minute
- ⊕ Stable and precise clamping by axial tension against the workpiece stop

CAPTIS-MS

- ⊕ Simple handling: a turn of the wrench by a maximum of 180° is enough to clamp the collet or the clamping mandrel
- ⊕ Can be clamped from three sides; can be optionally fitted with a workpiece stop



CAPTIS COLLET CHUCKS

- ⊕ Replaceable rubber segments made of innovative rubber mixture for the longest service life
- ⊕ Clamping range of $\pm 0,5$ mm
- ⊕ Hardened and ground steel segments for high resistance to wear

CAPTIS-D



APPLICATION

For use on lathes.
Ideal for bars and pipe machining on the main spindle.

TYPE

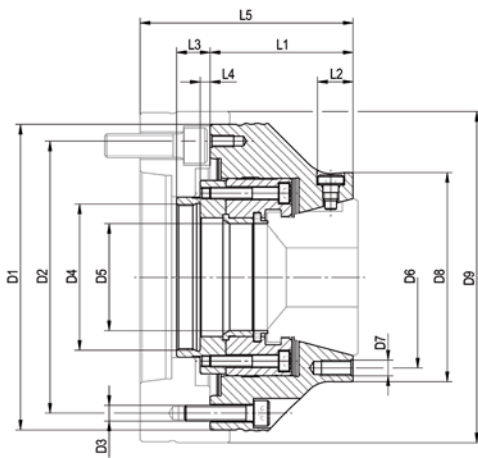
Force-actuated.
With through-hole for bar and pipe machining.
With axial tension.

CUSTOMER BENEFITS

- ④ Maximum flexibility thanks to modular design and versatile combination and retrofitting options
- ④ Low weight and low height thanks to compact design for more work area in the machine
- ④ Short setup and non-productive times thanks to fast collect chuck change as well as great expansion of the collet chucks
- ④ Fast retrofitting from external to internal clamping thanks to optionally available segment clamping mandrel ABSIS-C

TECHNICAL FEATURES

- Manual lubrication
- Collet chucks with exchangeable and oil-resistant vulcanized rubber



C 15
CAPTIS-D collet chuck - with axial pull

Size	32	42	52	65	80	100	120
Collet chucks	1283101	1283102	1283103	1283104	1283105 ▲	1283106 ▲	1283107 ▲
D1 mm	137	137	155	155	215	215	250
D2 mm	100	118	138	138	190	190	215
D3	6x M8	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12
D4 mm	M54x1,5	M54x1,5	M74x1,5	M74x1,5	M94x1,5	M120x1,5	M132x1,5
D5 mm	34	44	54	68	82	102	122
D6 mm	70	92	92	110	132	190	225
D7	3x M8	3x M8	3x M8	3x M8	3x M10	3x M12	3x M12
D8 mm	84	106	106	122	152	215	250
L1 mm	70,5	69	72,5	78	85	102	102
L2 mm	18	18	18	26	19	-	-
L3 mm	17	17	17	17	20	20	20
L4 min	1,5	1,5	1,5	1,5	-0,5	-0,5	-0,5
L4 max	7,5	7,5	7,5	7,5	5,5	5,5	5,5
Total stroke mm	6	6	6	6	6	6	6
Maximum draw bar pull kN	25	35	40	45	50	65	70
Total clamping force kN	60	70	80	90	100	130	140
Speed max, min ⁻¹	8000	7000	6500	6000	5500	5000	4000
Chucking capacity mm	4-32	4-42	4-52	4-65	5-80	42-100	62-120
Clamping device manual	1283285	1283286	1283287	1283288	-	-	-
Clamping device air operated	431955 ▲	6898 ▲	436285 ▲	6898 ▲	1124 ▲	6352 ▲	6901 ▲
Conversion kit to CAPTIS-A	1283256	1283257	1283258	1283259	1283260	1283261	1283262
Turning fixture for soft collets	1316901 ▲	1316902 ▲	1316903 ▲	1316904 ▲	1316905 ▲	1316906 ▲	1316907 ▲

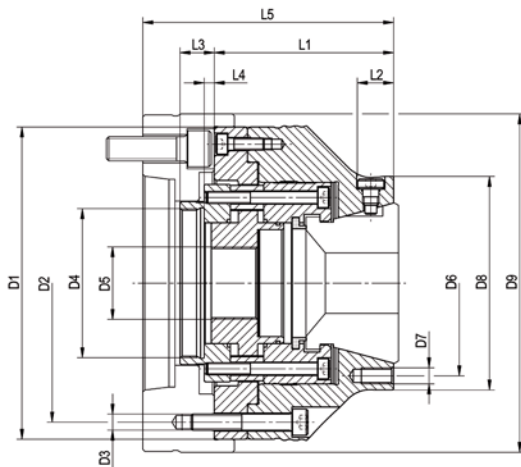
Intermediate flange ISO 702-1 (DIN 55028)

Size	32-A5	/42-A5	32-A6	42-A6	52-A5	65-A5	52-A6	65-A6	52-A8	65-A8	80-A6	100-A6	80-A8	100-A8	120-A8	120-A11	
Intermediate flange	1283194		1283195		1283198		1283199		1283200		1283203 ▲		1283204 ▲		1283207 ▲		1283209 ▲
D9	150		165		168		168		210		230		230		270		280
L5	105	103,5	106	104,5	108,5	114	108	113,5	114,5	120	132	149	125	142	157	142	

Intermediate flange cylindrical centre mount

Size	32-Z140	42-Z140	52-Z140	65-Z140	52-Z170	65-Z170	80-Z170	100-Z170	80-Z220	100-Z220	120-Z220
Intermediate flange	1283196		1283201		1283202		1283205 ▲		1283206 ▲		1283208 ▲
D9	150		168		180		230		230		270
L5	90	88,5	100	105,5	95	100,5	132	149	125	142	157

CAPTIS-A



APPLICATION

External clamping of round workpieces, as well as square and hexagon profiles. Turning, milling, grinding operations as well as for measuring. Ideal for machining insertion parts on the main spindle.

TYPE

Force-actuated.
Optional through-hole for bar machining by removing the internal workpiece stop. With axial tension against workpiece stop.

CUSTOMER BENEFITS

- ⊕ Maximum flexibility thanks to modular design and versatile combination and retrofitting options
- ⊕ Low weight and low height thanks to compact design for more work area in the machine
- ⊕ Short setup and non-productive times thanks to fast collect chuck change as well as great expansion of the collet chucks
- ⊕ Fast retrofitting from external to internal clamping thanks to optionally available segment clamping mandrel ABSIS-C
- ⊕ Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- ⊕ Prepared for internal workpiece stop and front stop

TECHNICAL FEATURES

- Manual lubrication
- Collet chucks with exchangeable and oil-resistant vulcanized rubber

C 15
CAPTIS-A collet chuck - with axial tension against workpiece stop

Size	32	42	52	65	80	100	120
Collet chucks	1283108	1283109	1283110	1283111	1283112 ▲	1283113 ▲	1283114 ▲
D1 mm	137	137	155	155	215	215	250
D2 mm	100	118	138	138	190	190	225
D3	6x M8	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12
D4 mm	M54x1,5	M54x1,5	M74x1,5	M74x1,5	M94x1,5	M120x1,5	M132x1,5
D 5 mm	M22x1,5	M30x1,5	M36x1,5	M50x1,5	M55x1,5	M85x1,5	M105x1,5
D 6 mm	70	92	92	110	132	190	225
D7	3x M8	3x M8	3x M8	3x M8	3x M10	3xM12	3x M12
D8 mm	84	106	106	122	152	215	250
L1 mm	84	82,5	89	94,5	103	122	122
L2 mm	18	18	18	26	19	-	-
L3 mm	17	17	17	17	20	20	20
L4 min mm	1,5	1,5	1,5	1,5	-0,5	-0,5	-0,5
L4 max mm	7,5	7,5	7,5	7,5	5,5	5,5	5,5
Total stroke mm	6	6	6	6	6	6	6
Maximum draw bar pull kN	25	35	40	45	50	65	70
Total clamping force kN	60	70	80	90	100	130	140
Speed max, min ⁻¹	8000	7000	6500	6000	5500	5000	4000
Chucking capacity mm	4-32	4-42	4-52	4-65	5-80	42-100	62-120
Clamping device manual	1283285	1283286	1283287	1283288	-	-	-
Clamping device air operated	431955 ▲	6898 ▲	436285 ▲	6898 ▲	1124 ▲	6352 ▲	6901 ▲
Conversion kit to CAPTIS-A	1283249	1283250	1283251	1283252	1283253	1283254	1283255
Turning fixture for soft collets	1316901 ▲	1316902 ▲	1316903 ▲	1316904 ▲	1316905 ▲	1316906 ▲	1316907 ▲

Intermediate flange ISO 702-1 (DIN 55028)

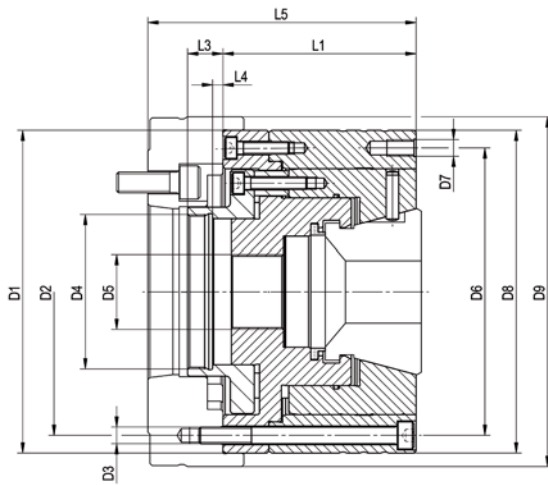
Size	32-A5	/42-A5	32-A6	42-A6	52-A5	65-A5	52-A6	65-A6	52-A8	65-A8	80-A6	100-A6	80-A8	100-A8	120-A8	120-A11
Intermediate flange	1283194		1283195		1283198		1283199		1283200		1283203 ▲		1283204 ▲		1283207 ▲	1283209 ▲
D9	150		165		168		168		210		230		230		270	280
L5	118,5	117	119,5	118	125	130,5	124,5	130	131	136,5	150	169	143	162	177	162

Intermediate flange cylindrical centre mount

Size	32-Z140	42-Z140	52-Z140	65-Z140	52-Z170	65-Z170	80-Z170	100-Z170	80-Z220	100-Z220	120-Z220
Intermediate flange	1283196		1283201		1283202		1283205		1283206 ▲		1283208 ▲
D9	150		168		180		230		230		270
L5	103,5	102	116,5	122	111,5	117	150	169	143	162	177

▲ on request

CAPTIS-AF



APPLICATION

External clamping of round workpieces, as well as square and hexagon profiles. Turning, milling, grinding operations as well as for measuring. Ideal for machining insertion parts on the main spindle.

TYPE

Force-actuated.
Optional through-hole for bar machining by removing the internal workpiece stop.
Axially stationary collect chuck, no axial tension against internal workpiece stop.

CUSTOMER BENEFITS

- ⊕ Maximum flexibility thanks to modular design and versatile combination and retrofitting options
- ⊕ Low weight and low height thanks to compact design for more work area in the machine
- ⊕ Short setup and non-productive times thanks to fast collect chuck change as well as great expansion of the collet chucks
- ⊕ No damage, impressions on workpieces due to axially stationary collect chuck
- ⊕ Prepared for internal workpiece stop and front stop

TECHNICAL FEATURES

- Manual lubrication
- Collet chucks with exchangeable and oil-resistant vulcanized rubber

C 15
CAPTIS-AF collet chuck - axially stationary collect chuck, no axial tension against internal workpiece stop

Size	32	42	52	65	80	100	120
Collet chucks	1285001	1285002	1285003	1285004	1285005 ▲	1285006 ▲	1285007 ▲
D1 mm	137	137	155	155	215	215	250
D2 mm	120	120	138	138	190	190	225
D3	6x M8	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12
D4 mm	M48x1,5	M54x1,5	M74x1,5	M74x1,5	M120x1,5	M120x1,5	M132x1,5
D5 mm	M22x1,5	M30x1,5	M36x1,5	M50x1,5	M65x1,5	M85x1,5	M105x1,5
D 6 mm	94	120	138	138	190	190	225
D7	3x M6	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8
D8 mm	105	137	155	155	215	215	250
L1 mm	80,5	81	92,5	92,5	102	102	122
L2 mm	34,7	-	-	-	-	-	-
L3 mm	15,5	16	17	17	18,5	18,5	18,5
L4 min mm	-4	-2,5	2,5	2,5	-1	-1	-1
L4 max mm	2	3,5	8,5	8,5	5	5	5
Total stroke mm	6	6	6	6	6	6	6
Maximum draw bar pull kN	25	35	40	45	50	65	70
Total clamping force kN	60	70	80	90	100	130	140
Speed max, min-1	8000	7000	6500	6000	5500	5000	4000
Chucking capacity mm	4-32	4-42	4-52	4-65	5-80	42-100	62-120
Clamping device manual	1283285	1283286	1283287	1283288	-	-	-
Clamping device air operated	431955 ▲	6898 ▲	436285 ▲	6898 ▲	1124 ▲	6352 ▲	6901 ▲
Turning fixture for soft collets	1316901 ▲	1316902 ▲	1316903 ▲	1316904 ▲	1316905 ▲	1316906 ▲	1316907 ▲

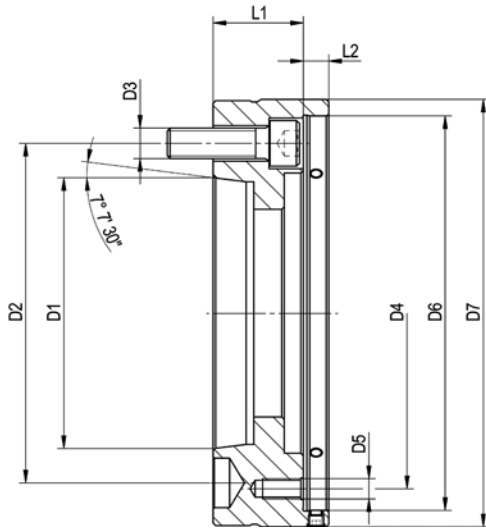
Intermediate flange ISO 702-1 (DIN 55028)

Size	32-A5	42-A5	32-A6	42-A6	52-A5	65-A5	52-A6	65-A6	52-A8	65-A8	80-A6	100-A6	80-A8	100-A8	120-A8	120-A11
Intermediate flange	1283194	1283195	1283195	1283198	1283198	1283199	1283199	1283200	1283200	1283203 ▲	1283204 ▲	1283207 ▲	1283207 ▲	1283207 ▲	1283209 ▲	1283209 ▲
D9	150	165	165	168	168	168	168	210	210	230	230	270	270	270	270	280
L5	115	115,5	116	116,5	128,5	128,5	128	128	134,5	134,5	149	149	142	142	177	162

Intermediate flange cylindrical centre mount

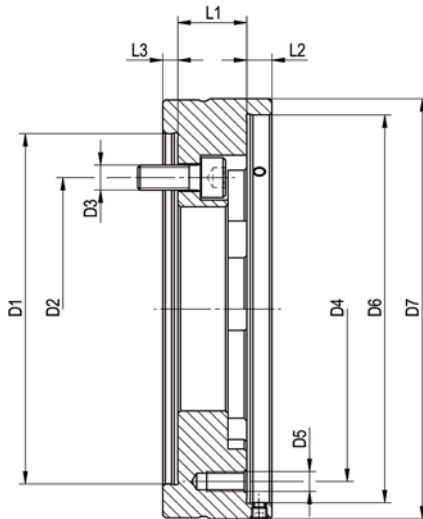
Size	32-Z140	42-Z140	52-Z140	65-Z140	52-Z170	65-Z170	80-Z170	100-Z170	80-Z220	100-Z220	120-Z220
Intermediate flange	1283196	1283201	1283201	1283202	1283202	1283205 ▲	1283206 ▲	1283208 ▲	1283206 ▲	1283206 ▲	1283208 ▲
D9	150	168	168	180	180	230	230	270	230	230	270
L5	100	100,5	120	120	115	115	149	149	142	142	177

CAPTIS intermediate flange



Intermediate flange ISO 702-1 (DIN 55028) with adjusting screw

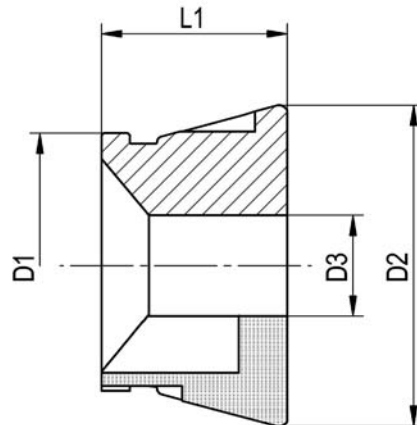
Size	32/42-A5	32/42-A6	52/65-A5	52/65-A6	52/65-A8	80/100-A6	80/100-A8	120-A8	120-A11
Intermediate flange	1283194	1283195	1283198	1283199	1283200	1283203 ▲	1283204 ▲	1283207	1283209
D1 mm	82,563	106,375	82,563	106,375	139,719	106,375	139,719	139,719	196,869
D2 mm	104,8	133,4	104,8	133,4	171,4	133,4	171,4	171,4	235
D3	6x M10	3x M12	6x M10	3x M12	3x M16	6x M12	3x M16	6x M16	3x M20
D4 mm	100/120	100/120	138	138	138	190	190	225	225
D5	6x M8	6x M8	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12	6x M12
D6	137	137	155	155	155	215	215	250	250
D7 mm	150	165	168	168	210	230	230	270	280
L1 mm	34,5	35,5	36	35,5	42	47	40	55	40
L2 mm	10	10	10	10	10	10	10	12	12



Intermediate flange cylindrical centre mount with adjusting screw

Size	32/42-Z140	52/65-Z140	52/65-Z170	80/100-Z170	80/100-Z220	120-Z220
Intermediate flange	1283196	1283201	1283202	1283205 ▲	1283206 ▲	1283208
D1 mm	140	140	170	170	220	220
D2 mm	104,8	104,8	133,4	133,4	171,4	171,4
D3	6x M10	6x M10	6x M12	6x M12	6x M16	6x M16
D4 mm	100/120	138	138	190	190	225
D5	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12
D6	137	155	155	215	215	250
D7 mm	150	168	180	230	230	270
L1 mm	19,5	27,5	22,5	47	40	55
L2 mm	10	10	10	10	10	12
L3 mm	6	6	6	6	6	6

CAPTIS collet chucks



(G): Smooth
 (LQ): Longitudinal and transverse grooves
 (Q): Transverse grooves
 (W): Soft

from 4-7 mm smooth
 from 8-10 mm with trans. grooves
 caused by production

* Please specify clamping diameters D3 in the order, valid for collet chucks type LQ + Q

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
32	46,2	57,7	47	X				8-32mm			1	CAPTIS-32-47-RLQ / D3*
32	46,2	57,7	47		X				7-27mm		1	CAPTIS-32-47-SQ / D3*
32	46,2	57,7	47		X					7-22mm	1	CAPTIS-32-47-VQ / D3*

Clamping of unmachined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
32	46,2	57,7	44			X		4-32mm			1	CAPTIS-32-44-RG / D3*
32	46,2	57,7	44				X	5,15,20mm			1	CAPTIS-32-44-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
42	54	79,5	47	X				8-42mm			0,5	CAPTIS-42-47-RLQ / D3*
42	54	79,5	47		X				7-36mm		1	CAPTIS-42-47-SQ / D3*
42	54	79,5	47		X					7-30mm	1	CAPTIS-42-47-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
42	54	79,5	42			X		4-42mm			0,5	CAPTIS-42-42-RG / D3*
42	54	79,5	42				X	8,15,30mm			0,5	CAPTIS-42-42-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
52	65,7	79,5	46	X				8-52mm			0,5	CAPTIS-52-46-RLQ / D3*
52	65,7	79,5	46		X				7-45mm		1	CAPTIS-52-46-SQ / D3*
52	65,7	79,5	46		X					8-36mm	1	CAPTIS-52-46-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
52	65,7	79,5	46			X		4-52mm			0,5	CAPTIS-52-46-RG / D3*
52	65,7	79,5	46				X	8,15,30mm			0,5	CAPTIS-52-46-WG / D3*

CAPTIS collet chucks

(G): Smooth
 (LQ): Longitudinal and transverse grooves
 (Q): Transverse grooves
 (W): Soft

from 4-7 mm smooth
 from 8-10 mm with trans. grooves
 caused by production

* Please specify clamping diameters D3 in the order, valid for collet chucks type LQ + Q

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
65	80	99,5	58	X				8-65mm			0,5	CAPTIS-65-58-RLQ / D3*
65	80	99,5	58		X				7-56mm		1	CAPTIS-65-58-SQ / D3*
65	80	99,5	58		X					7-46mm	1	CAPTIS-65-58-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
65	80	99,5	53			X		8-65mm			0,5	CAPTIS-65-53-RG / D3*
65	80	99,5	53				X	8,20,40mm			0,5	CAPTIS-65-53-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
80	94,5	114,5	53	X				8-80mm			1	CAPTIS-80-53-RLQ / D3*
80	94,5	114,5	53		X				7-68mm		1	CAPTIS-80-53-SQ / D3*
80	94,5	114,5	53		X					8-42mm	1	CAPTIS-80-53-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
80	94,5	114,5	53			X		5-80mm			1	CAPTIS-80-53-RG / D3*
80	94,5	114,5	53				X	20,30,40,60mm			1	CAPTIS-80-53-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
100	121	144,5	59	X				42-100mm			1	CAPTIS-100-59-RLQ / D3*
100	121	144,5	59		X				50-86mm		1	CAPTIS-100-59-SQ / D3*
100	121	144,5	59		X					50-70mm	1	CAPTIS-100-59-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
100	121	144,5	59			X		42-100mm			1	CAPTIS-100-59-RG / D3*
100	121	144,5	59				X	30,45,65,90mm			1	CAPTIS-100-59-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
120	141,8	180	61	X				62-120mm			1	CAPTIS-120-61-RLQ / D3*
120	141,8	180	61		X				50-104mm		1	CAPTIS-120-61-SQ / D3*
120	141,8	180	61		X					50-85mm	1	CAPTIS-120-61-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
120	141,8	180	61			X		62-120mm			1	CAPTIS-120-61-RG / D3*
120	141,8	180	61				X	65,90,110mm			1	CAPTIS-120-61-WG / D3*

CAPTIS-MS



APPLICATION

Manual/stationary external clamping of round workpieces, as well as square and hexagon profiles. Turning, milling, grinding operations as well as for measuring. Ideal for 5-sided machining.

TYPE

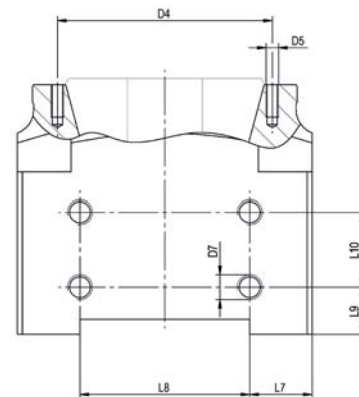
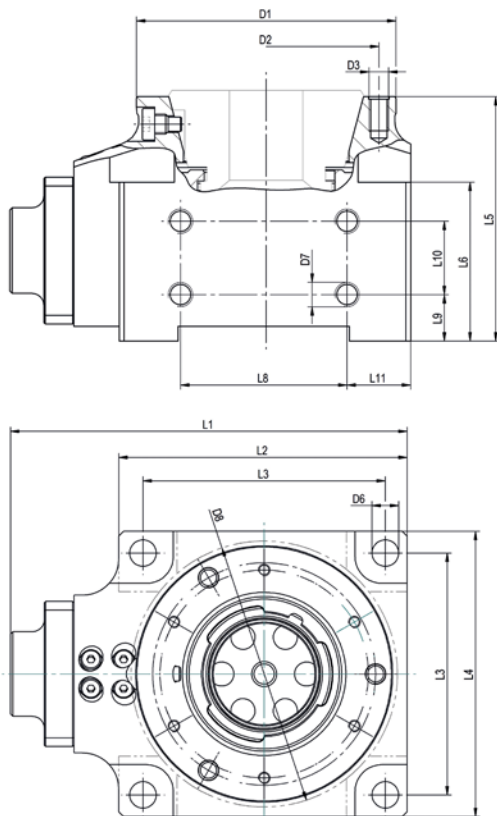
Manually actuated.
With axial tension against workpiece stop (as an option).

CUSTOMER BENEFITS

- ④ Maximum flexibility thanks to modular design and versatile combination and retrofitting options
- ④ Low weight and low height thanks to compact design for more work area in the machine
- ④ Short setup and non-productive times thanks to fast collect chuck change as well as great expansion of the collet chucks
- ④ Maximum clamping stroke/expansion by 180° rotation of the actuation key
- ④ Prepared for internal workpiece stop and front stop
- ④ Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- ④ Sensitive manual clamping with actuation key

TECHNICAL FEATURES

- Collet chucks with exchangeable and oil-resistant vulcanized rubber



C 15
CAPTIS-MS stationary power chuck

Size	32	42	52	65
Stationary power chucks	1284189	1284190	1284191	1284192
D1 mm	84	106	106	122
D2 mm	70	92	92	110
D3	M8	M8	M8	M8
D4 mm	66	86	86	107
D5	M5	M5	M5	M5
D6	11	11	11	11
L1 mm	145	162	162	176
L2 mm	105	117,5	117,5	130
L3 mm	80	100	100	112
L4 mm	100	118	118	130
L5	100	100	100	104
L6 mm	65	65	65	57

ABSIS-C



APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring.
 Rotational machining with adaptation to CAPTIS-D, CAPTIS-A.
 Stationary machining with adaptation to CAPTIS-MS.
 Ideal for clamping in through-holes.

TYPE

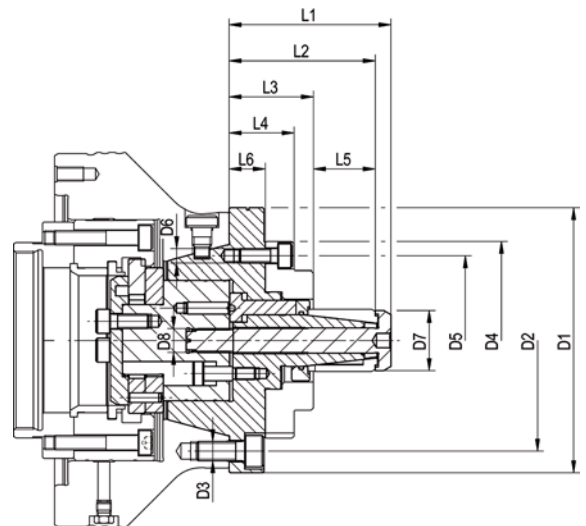
Manual with adaptation to CAPTIS-MS.
 Force-actuation with adaptation to CAPTIS-D, CAPTIS-A.

CUSTOMER BENEFITS

- ⊕ Short setup and non-productive times thanks to great expansion of the segment sleeves
- ⊕ Vibration damping due to high vulcanized rubber component of the clamping sleeves
- ⊕ Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- ⊕ Fast change of segment sleeves thanks to central clamping screw
- ⊕ High concentricity, axial run-out and repeatability
- ⊕ Innovative quick-change function for fast retrofitting from external to internal clamping

TECHNICAL FEATURES

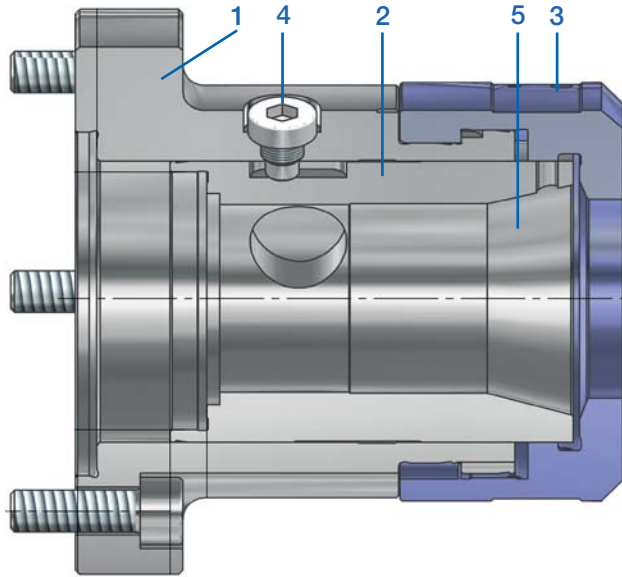
- Identical change parts as for standard segment clamping mandrel ABSIS



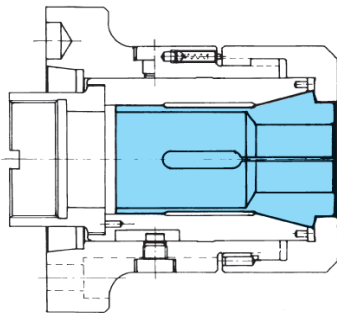
C 15
 ABSIS-C clamping mandrel

Size	ABSIS 00	ABSIS 00	ABSIS 00	ABSIS 00	ABSIS 01	ABSIS 01	ABSIS 01	ABSIS 01	ABSIS 02	ABSIS 02	ABSIS 02	ABSIS 03
Segment clamping mandrel	1286200	1286201	1286202	1286203	1286204	1286205	1286206	1286207	1286208	1286209	1286210	1286211
For	CAPTIS 32	CAPTIS 42	CAPTIS 52	CAPTIS 65	CAPTIS 32	CAPTIS 42	CAPTIS 52	CAPTIS 65	CAPTIS 42	CAPTIS 52	CAPTIS 65	CAPTIS 65
D Min-Ø unclamped from	19,7	19,7	19,7	19,7	25,7	25,7	25,7	25,7	35,7	35,7	35,7	50,7
D Min-Ø unclamped to	27,7	27,7	27,7	27,7	38,7	38,7	38,7	38,7	54,7	54,7	54,7	81,7
D1	88	108	110	128	88	108	110	128	110	110	128	128
D2	70	90	92	110	70	90	92	110	90	92	110	110
D3	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8
D4	82	82	82	82	82	82	82	82	97	97	97	102
D5	70	70	70	70	70	70	70	70	84	84	84	89
D6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6
D7	19	19	19	19	25	25	25	25	35	35	35	48
D8	M6x0,75	M6x0,75	M6x0,75	M6x0,75	M10x1	M10x1	M10x1	M10x1	M14x1	M14x1	M14x1	M18x1
L1	62,2	62,2	62,2	62,2	67,2	67,2	67,2	67,2	95,2	95,2	95,2	105,2
L2	56,7	56,7	56,7	56,7	60,7	60,7	60,7	60,7	85	85	85	93,2
L3	35	35	35	35	35	35	35	35	42,5	42,5	42,5	44,5
L4	25	25	25	25	27	27	27	27	30,25	30,25	30,25	31,5
L5	21,7	21,7	21,7	21,7	25,7	25,7	25,7	25,7	42,5	42,5	42,5	48,7
L6	15	15	15	15	15	15	15	15	18	18	18	18,5

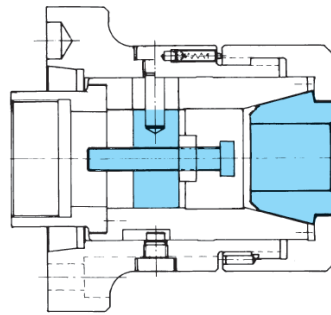
Collet chuck system
 CAPTIS



1. Body
2. Thrust sleeve for steel collets and segment collets. By replacing the thrust sleeve, duo-segment collets can be used
3. Union nut with bayonet lock
4. Protection against torsion for thrust sleeve
 - Adapter fitting must be ordered separately. Suitable for existing draw tube, glue into thrust sleeve
 - Special accessories; are not part of the scope of delivery. The workpiece stop can only be used for segment collets. Order separately: Cap screw or stud bolt with locknut acc. to DIN 55027.
5. Protection against torsion for collet



Hollow clamping with steel collet
DIN 6343



Clamping with segment collets and
workpiece stop



APPLICATION

External clamping of round workpieces, as well as square and hexagon profiles. Turning, milling, grinding operations as well as for measuring. Ideal for bars and pipe machining on the main spindle. For using standardized DIN collet chucks or segment collet chucks.

TYPE

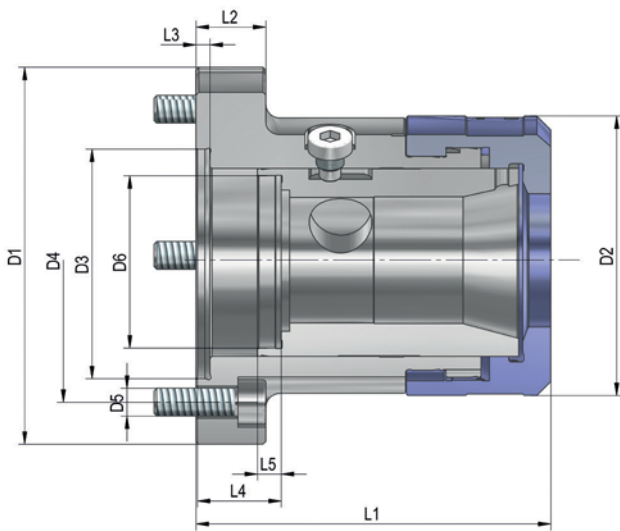
Force-actuated.
Internal workpiece stop optional in conjunction with segment collet.

CUSTOMER BENEFITS

- ⊕ Light weight and reduced height thanks to compact design
- ⊕ Short setup times thanks to quick change of collet chuck
- ⊕ High flexibility thanks to modular system
- ⊕ Quick retrofitting to other workpieces by changing the collect chuck
- ⊕ Axially stationary collect chuck, no axial tension against internal workpiece stop

TECHNICAL FEATURES

- Hardened, low-wear design
- Either DIN steel or segment collet chucks



C 15
Power-operated collet chuck KZF, with quick-acting bayonet catch, without collet
Cylindrical center mount / short taper mount - draw tube adapter available on request

Item no.	439989	439990	439991	439992	439993	439994	439995	439996	439997	439998
Size	40	40	40	40	60	60	60	60	80	80
Mount	Z-140	Z-88	KK 5	KK 6	Z-115	Z-170	KK 6	KK 8	Z-130	KK 8
D1	160	135	170	170	157	190	210	210	187	210
D2	100	100	100	100	122	122	122	122	150	150
D3	140	88	82,563	106,375	115	170	106,375	139,719	130	139,719
D4	104,8	115	104,8	133,4	136	133,4	133,4	171,4	166	171,4
D5	4xM10	6xM8	4xM10	4xM12	8xM8	6xM12	4xM12	4xM16	8xM8	4xM16
D6	M66x1,5	M66x1,5	M66x1,5	M66x1,5	M88x1,5	M88x1,5	M88x1,5	M88x1,5	M88x1,5	M114x1,5
L1	116	116	127	128	132	132	144	146	156	170
L2	25	25	25	25	25	25	25	25	30	30
L3	5	5	16	18	5	5	18	22	5	22
L4 min	16	16	32	33	16	16	33	35	17	36
L4 max	8,5	8,5	24,5	25,5	8,5	8,5	25,5	27,5	9,5	28,5
L5	8,5	8,5	8,5	8,5	8,5	8,5	8,5	8,5	12,5	12,5
Total stroke mm	7,5	7,5	7,5	7,5	7,5	7,5	7,5	7,5	7,5	7,5
Maximum draw bar pull kN	25	25	25	25	30	30	30	30	35	35
Total clamping force kN	50	50	50	50	60	60	60	60	70	70
Adm. speed min-1	8000	8000	8000	8000	5000	5000	5000	5000	4000	4000
Chucking capacity mm	2-42	2-42	2-42	2-42	4-60	4-60	4-60	4-60	20-80	20-80
Moment of inertia J kgm2	0,029	0,029	0,029	0,029	0,038	0,038	0,038	0,038	0,108	0,108
Weight without collet kg	7,1	5,3	7,5	7,5	9,2	9,2	10,2	14	17,5	18

Anti-rotation device optionally available Id.-Nr. 701331

KZF-S



APPLICATION

External clamping of round workpieces with smooth or toothed outer geometry for turning, milling, grinding and measuring operations. Optimal on the clamping device/clamping adapted to the workpiece/machining process. Ideal for short clamping lengths.

TYPE

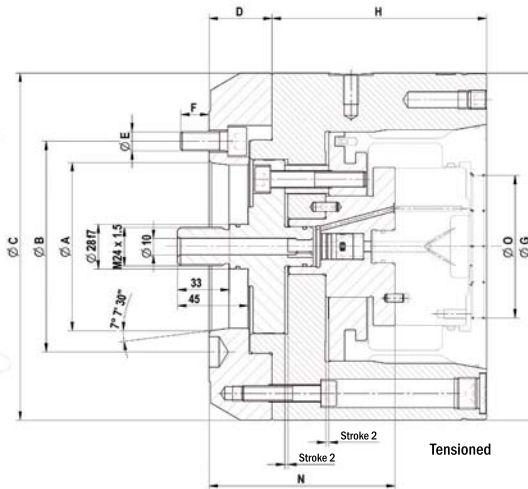
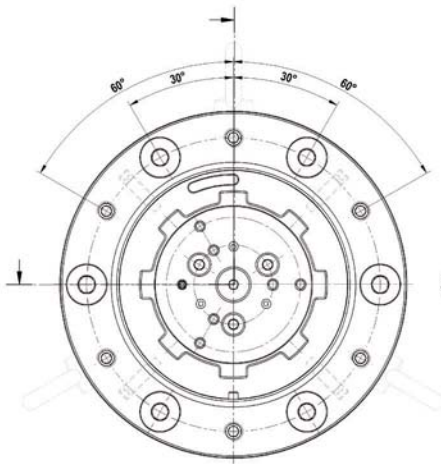
Force-actuated.

CUSTOMER BENEFITS

- ④ Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- ④ Quick change of collet chuck by bayonet lock
- ④ High concentricity, axial run-out and repeatability
- ④ High flexibility thanks to modular system

TECHNICAL FEATURES

- Manual lubrication/low-maintenance
- Prepared for internal media feed-through, e.g. air and coolant
- Prepared for internal workpiece stop
- Collet chucks can be individually adapted to the workpiece
- Sealing against chips



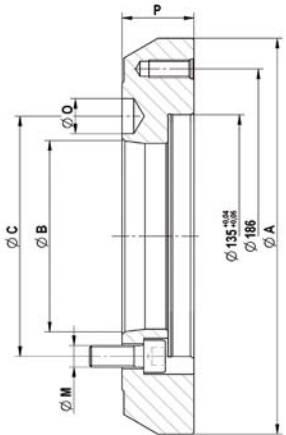
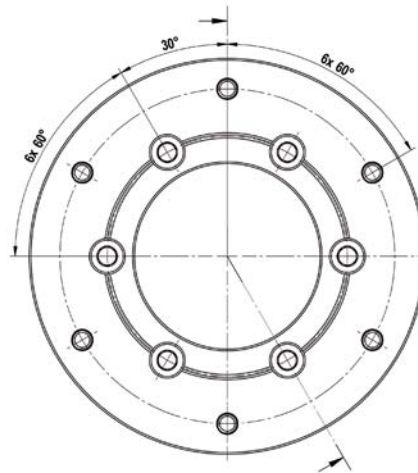
C 18

Power operated collet chuck KZF-S, for external clamping

	KZF 80	KZF 120	KZF 180
Body collet	1117832 ▲	1117830 ▲	1125403 ▲
Base bolt	1117833	1072101	1125404
Draw piece	1117837	1117827	1125408
Fastening plate	1117835	1072105	1125406
Bolt spacer	1117836	1072103	1072103
Ground stop for reverse valve cartridge	1117839	1072113	1125410
Ground stop for ermeto pipe	1117841	1117824	1125412
Reverse valve cartridge 1 Bar	756641	863134	863134
Reverse valve cartridge 3 Bar	843866	889894	889894
A	82,563	106,37	139,719
B	104,8	133,4	171,4
C/G	170	220	258
D	35	40	45
E	M10	M12	M16
F Max, in daN	30	40	40
H	125	136	136
N	103	118	123
O	30-80	60-120	100-180
Speed max, min-1	6000	5000	3500
Stroke mm	4	4	4
Clamping dia, min,	30	60	100
Clamping dia, max,	80	120	180
Expansion in Ø mm	1,4	1,4	1,4
Ø G	170	220	285
H mm	125	136	136

Info: kzf@roehm.biz

Accessories KZF-S



C 18

Intermediate flange ISO 702-1 (DIN 55028)

	A 05	Nr. 5 (A5)	A 05	Nr. 6 (A6)	A 06	A 08	Nr. 8 (A8)	A 08
Intermediate flange	1117843 ▲	1072115	1117845 ▲	1072117	1125416 ▲	1117847 ▲	1072119	1125418 ▲
For	KZF-S 80	KZF-S 80/AGILIS 05-07	KZF-S 81	KZF-S 120/AGILIS 05-07	KZF-S 180	KZF-S 82	KZF-S 120/AGILIS 05-07	KZF-S 180
Short-taper-Ø B	82,563	82,563	106,375	106,375	106,375	139,719	139,719	139,719
Short-taper pitch circle Ø C	104,8	104,8	133,4	133,4	133,4	171,4	171,4	171,4
Flange outer-Ø A	170	220	170	220	285	210	220	285
Ø D	105	135	105	135	200	105	135	200
Ø F mm	143	186	143	186	250	143	186	250
Ø O mm	16,3	16,3	19,45	19,45	19,45	24,2	24,2	24,2
Thread-Ø M	M10	M10	M12	M12	M12	M16	M16	M16
Total length flange P	35	40	35	40	45	35	40	45

Special solutions KFG



Sliding clamping mandrel KFG clamping-Ø 30 mm

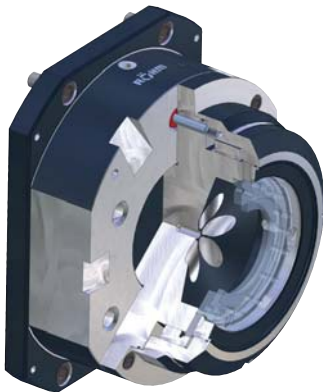
APPLICATION

Turning of a differential housing

Clamping of a differential housing in two clamping planes. Diameter difference between the clamping planes are compensated. The workpiece stop is equipped with an air sensing. The entire clamping mandrel is sealed with purge air.

CUSTOMER BENEFITS

- ⌚ Two compensating clamping planes
- ⌚ Concentricity of 0.02 mm



Sliding clamping mandrel KFG clamping-Ø 155 mm / clamping-Ø 161 mm

APPLICATION

Drilling of two workpieces with different diameters

Clamping of two clamping planes that are very close together. Clamping of both clamping planes is done using springs. Pneumatic unclamping via a cylinder in the basic take-up. Compact, space-saving construction. Drain boreholes for coolant.

CUSTOMER BENEFITS

- ⌚ Overall height less than 200 mm
- ⌚ Concentricity of 0.03 mm



Sliding clamping mandrel KFG clamping range from 98-113 mm

APPLICATION

Turning of clamping cylinder liners, raw part

Left clamping plane force-actuated by draw bar. Right clamping plane spring-actuated; to compensate for workpiece tolerances. Stop can be pulled back. Different workpiece diameters can be clamped by changing the top jaws.

CUSTOMER BENEFITS

- ⌚ Large clamping range elongation of 7 mm
- ⌚ Large torque transmission from corrugation of the top jaws

Special solutions KFG



Sliding clamping mandrel KFG with intermediate sleeves Ø 104-120 mm

APPLICATION

Turning of clamping cylinder liners, final machining

Left clamping plane force-actuated by draw bar; right clamping plane force-actuated by tailstock. Stop can be pulled by with air sensing. Different workpiece diameters can be clamped by changing the intermediate sleeve.

CUSTOMER BENEFITS

- ⌚ Intermediate sleeve can be changed
- ⌚ High concentricity of 0.015 mm



Sliding clamping mandrel KFG clamping-Ø 39 mm / clamping-Ø 40 mm

APPLICATION

Turning

The clamping in clamping zone 1 is done by the draw bar with serrated jaws for high torque transmission. Clamping zone 2 is actuated by springs and is equipped with an intermediate sleeve.

CUSTOMER BENEFITS

- ⌚ Intermediate sleeve protects the workpiece surface
- ⌚ Concentricity of 0.01 mm

Special solution HYKS



Hydraulically actuated clamping mandrel for internal and external clamping

APPLICATION

Grinding, turning, milling, measuring

The hydraulic medium is put under pressure by a piston or by system pressure. The elongation can be up to 0.3 % (up to 1 % for special materials) of the diameter of the extension sleeve. Clamping directly by extension sleeve or indirectly by a slotted intermediate sleeve.

CUSTOMER BENEFITS

- ⊕ Cylindrical and round elongation over the entire clamping range for a maximum concentricity tolerance of 0.003 mm
- ⊕ Very high clamping force in the clamping zone
- ⊕ Optimum damping, extremely quiet machining and significantly higher service life of the tool due to precisely fitted clamping sleeve

TECHNICAL FEATURES

Force-actuated or manual actuation. Wear-resistant surface. The clamping systems can be put under pressure by hydraulic or pneumatic cylinders, by the machine hydraulics directly or even manually by using a screw. Different stops (optional): fixed, withdrawable, external, oscillating, etc.

Special solutions



Special mandrels

APPLICATION

Grinding, milling

Basic take-up with different replaceable head for clamping of pistons. Face clamping using internal draw piece. Position orientation using centering forks. An insertion securing device prevents incorrect loading. The actuation is done using OVS70 RÖHM clamping cylinders. The entire external contour can be machined.

CUSTOMER BENEFITS

- ⊕ Clamping head with quick change system
- ⊕ Concentricity of 0.005 mm



Clamping fixture

APPLICATION

Milling, drilling

Clamping device with three basic units. Pneumatically release clamping via spring force. Two basic units equipped with KFR clamping mandrels. A basic unit equipped with a power chuck.

CUSTOMER BENEFITS

- ⊕ Basic units can be equipped with different clamping systems

RÖHM GmbH

Heinrich-Röhm-Straße 50

89567 Sontheim/Brenz

Germany

Tel +49 7325 16 0

Fax +49 7325 16 510

info@roehm.biz

www.roehm.biz



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