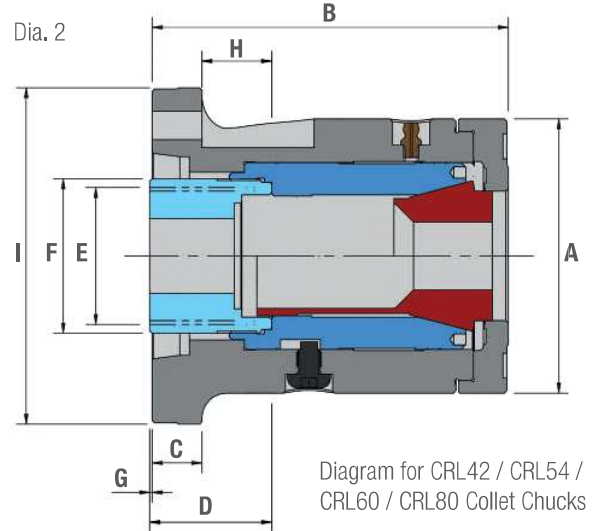
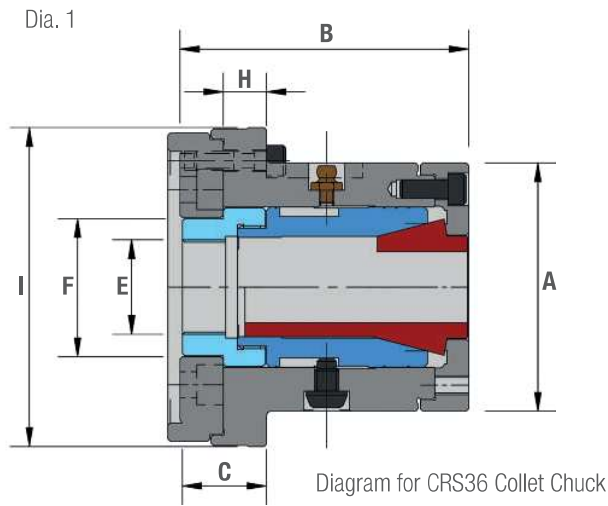


**Long Series Power Collet Chuck for Bar Machining**



| KLAMP Type                          |                   | CRS36     | CRL42     |         | CRL54     | CRL60       |       |         | CRL80     |       |         |
|-------------------------------------|-------------------|-----------|-----------|---------|-----------|-------------|-------|---------|-----------|-------|---------|
| Mounting                            |                   | Z115      | Z140      | A5      | A6        | A6          | Z170  | A6      | A8        | Z220  | A8      |
| Part Number                         |                   | CRS36     | CRL42     | CRL42A5 | CRL42A6   | CRL54A6     | CRL60 | CRL60A6 | CRL60A8   | CRL80 | CRL80A8 |
| Spring Collet Type                  |                   | D171E     | D173E     |         | D853      | D185E       |       |         | D193E     |       |         |
| Spring Collet Gripping Range *      | Minimum           | 1.6       | 2         |         | 2         | 3           |       |         | 12        |       |         |
|                                     | Maximum           | 36        | 42        |         | 54        | 60          |       |         | 80        |       |         |
| Spring Collet Increments            |                   | 0.5       | 0.5       |         | 0.5       | 0.5         |       |         | 0.5       |       |         |
| Varibore Collet Type                |                   | D671      | D673      |         | D120      | D677        |       |         | D660      |       |         |
| Varibore Collet Gripping range**    | Minimum           | 4         | 4         |         | 4         | 4           |       |         | 12        |       |         |
|                                     | Maximum           | 36        | 42        |         | 53.9      | 60          |       |         | 80        |       |         |
| Varibore Collet Increments          |                   | 2         | 2         |         | 3         | 2           |       |         | 3         |       |         |
| Rubberflex Collet Type              |                   | -         | DRFC673   |         | -         | DRFC677     |       |         | -         |       |         |
| Rubberflex Collet Gripping Range*** | Minimum           | -         | 7*        |         | -         | 19*         |       |         | -         |       |         |
|                                     | Maximum           | -         | 43*       |         | -         | 65*         |       |         | -         |       |         |
| Rubberflex Collet Increments        |                   | -         | 2         |         | -         | 2           |       |         | -         |       |         |
| A                                   |                   | 105       | 110       |         | 138       | 138         |       |         | 190       |       |         |
| B                                   |                   | 125       | 128       | 143     | 145       | 166         | 143   | 160     | 156       | 170   | 176     |
| C                                   |                   | 18        | 20        | 20      | 30        | 27          | 24    | 27      | 36        | 19    | 25      |
| D                                   |                   | 35        | 49        |         | 48        | 48          |       |         | 63        |       |         |
| E Maximum                           |                   | M50 x 1.5 | M55 x 1.5 |         | M70 x 1.5 | M70 x 1.5   |       |         | M90 x 2.0 |       |         |
| F                                   |                   | 58        | 62        |         | 80        | 80          |       |         | 100       |       |         |
| G Maximum                           |                   | -1        | 16        | 1       | -1        | -2          | 15    | -2      | 2         | 48    | 42      |
| G Minimum                           |                   | -8        | 9         | -6      | -8        | -12         | 8     | -9      | -5        | 36    | 30      |
| H                                   |                   | 18        | 18        | 28      | 19        | 23          | 14    | 23      | 9         | 13    | 13      |
| I                                   |                   | 135       | 160       | 135     | 165       | 165         | 190   | 165     | 210       | 230   | 220     |
| Sleeve stroke                       |                   | 7         | 7         |         | 10        | 7           |       |         | 12        |       |         |
| Max. input force                    | kN                | 18        | 25        |         | 30        | 30          |       |         | 45        |       |         |
| Max. Gripping Force                 | kN                | 36        | 55        |         | 60        | 60          |       |         | 78        |       |         |
| Max. Speed                          | min <sup>-1</sup> | 7000      | 7100      |         | 6300      | 6300        |       |         | 4500      |       |         |
| Net Weight                          | kg                | 8         | 9         | 9.5     | 11        | 16          | 15.2  | 16      | 19        | 30    | 30      |
| Matching Kitagawa Cylinders         |                   | S1036     | S1246     |         | S1552     | S1552/S1875 |       |         | S2091     |       |         |

\* See pages 14-18 for more Spring Collet information.

\*\* See pages 22-23 for more Varibore Collet information.

\*\*\* DRFC673 Rubber-flex collets are only suitable for the CRL42 Collet chuck and are available in smooth and full grip versions (smooth version is only available for 11mm diameters and smaller). DRFC677 Rubber-flex collets are only suitable for the CRL60 Collet chuck and are available in smooth and full grip versions (smooth version is only available for 61mm diameters and larger). See pages 24-25 for more information.