

# COLLET CHUCK

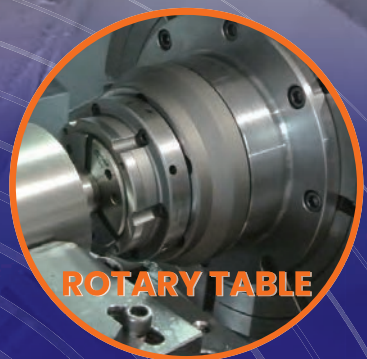
## Rubber Grip Collet



**TURNING**



**MACHINING**



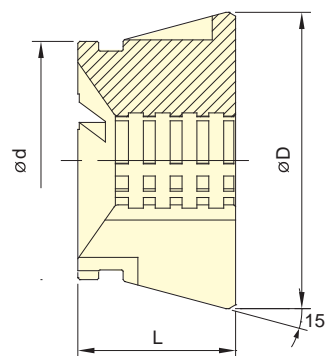
**ROTARY TABLE**

## Rubber Grip Collet: Optimized clamping solution.

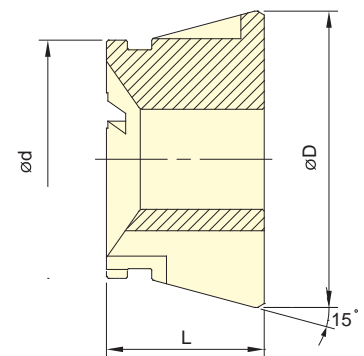


- **High precision:** Clamping repeatability are conformed to DIN 6343 Class1.
- **High gripping force:** Two times higher than standard spring collets, ideal for heavy-duty machining.
- **High rotational speed:** The gripping force is less affected by the centrifugal force, which makes machining more efficient.
- **Quick collet change:** With collet changing tools, collets (RG series) can be quickly changed within ten seconds.
- **Chip-proof design:** The rubber between the hardened steel collet segments can prevent ingress of coolant and swarf into chuck body.
- **Parallel gripping:** Providing superior accuracy and gripping force than standard spring collets.
- **Compact design:** Reducing interference between collet chucks and cutting tools, a good choice for small-sized lathes.
- **Wide gripping range:**  $\pm 0.5\text{mm}$ .

## Rubber Grip Collet



RG-RT



RG-R



MODEL	Max. Chucking Capacity (mm) Round	d	D	L	Matching Collect Chuck
RG-42R	4~42	54	79.3	42	CB-42,CBE-42
RG-42RT	4~42	54	79.3	42	CB-42,CBE-42
RG-52R	4~52	66	79.3	46	CB-52,CBD-52,CBE-52, SCB-52
RG-52RT	4~52	66	79.3	46	CB-52,CBD-52,CBE-52, SCB-52
RG-65R	4~65	80	99.5	53	CB-65,CBD-65,CBE-65, SCB-65
RG-65RT	4~65	80	99.5	53	CB-65,CBD-65,CBE-65, SCB-65



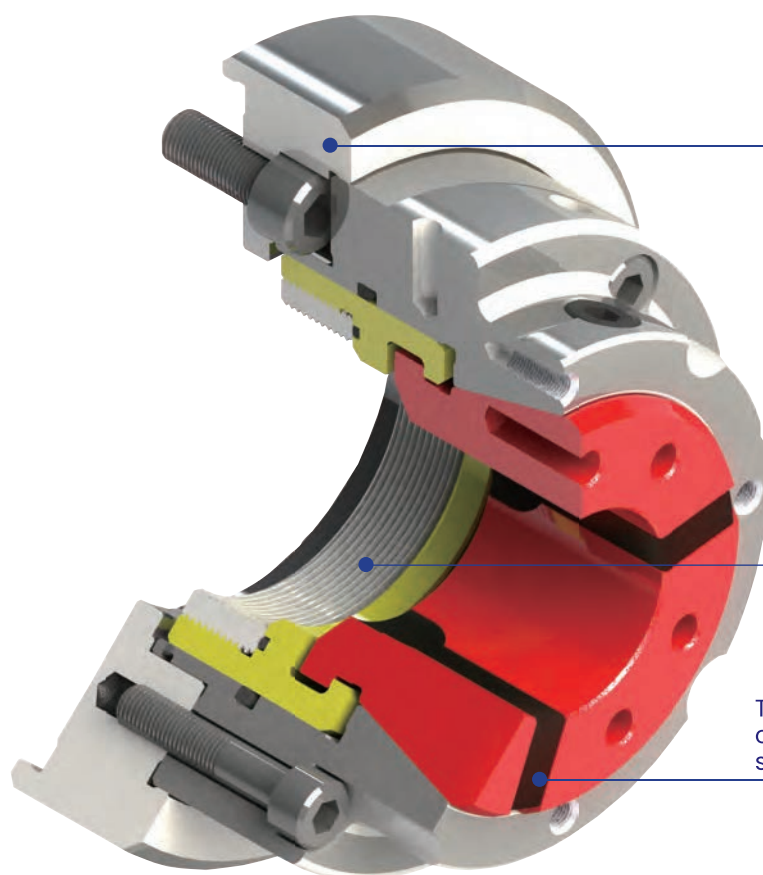
## CB/CB-A

### DRAW COLLET CHUCK

- The through-hole design is suitable for rear feeding.
- The installation is the same as 'Thru-hole power chuck' and they are compatible with each other.
- Compact design: the length is roughly 30% shorter than the standard collect chucks of the same specification.



The installation is the same as 3-jaw thru-hole power chuck.



Completely sealed design Through-hole.

The rubber between the hardened steel collet segments can prevent ingress of swarf and chips into chuck body.

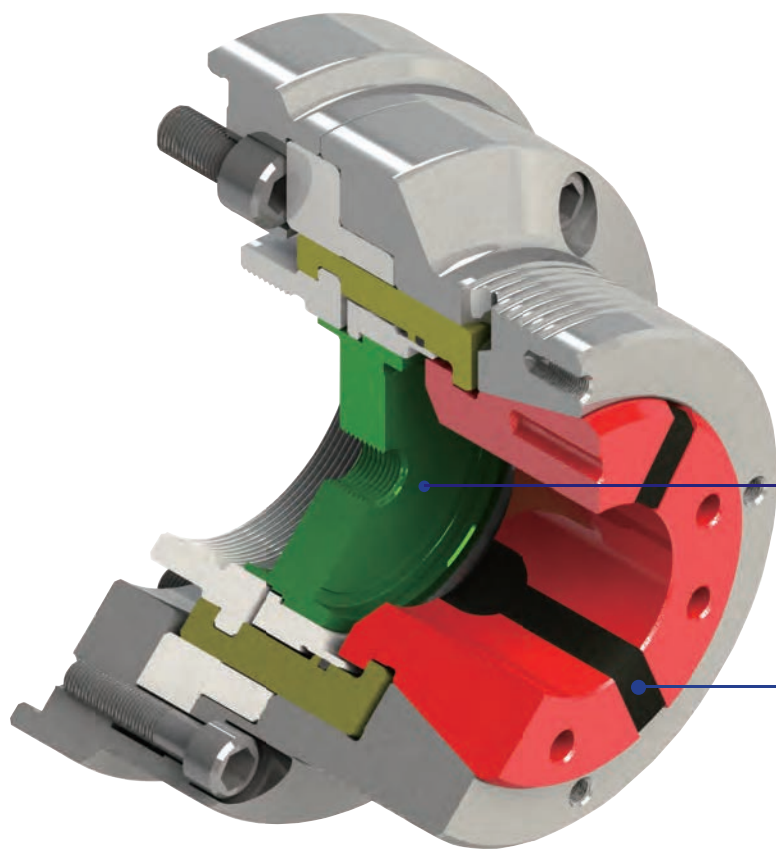
### SPECIFICATIONS

Model		Plunger stroke	Max. Chucking Capacity			Max. D.B. pull	Max. Clamping force	Max. speed	Weight	Matching steel collet	Matching Cyl.	Max. pressure
			Round	Hexagom	Square							MPa (kgf/cm²)
				mm	mm	mm	mm	kN (kgf)	kN (kgf)	min <sup>-1</sup> (r.p.m.)	(kg)	
CB-42		4.5	4~42	7~36	7~30	34.3(3500)	78.4(8000)	7000	6.5	RG-42	TK-B846	2.8(28)
CB-42	A5	4.5	4~42	7~36	7~30	34.3(3500)	78.4(8000)	7000	6.2	RG-42	TK-B846	2.8(28)
CB-42	A6	4.5	4~42	7~36	7~30	34.3(3500)	78.4(8000)	7000	7.4	RG-42	TK-B846	2.8(28)
CB-52		4.5	4~52	7~36	7~45	39.2(4000)	92.1(9400)	7000	6	RG-52	TK-A853	3.2(32)
CB-5217		4.5	4~52	7~36	7~45	39.2(4000)	92.1(9400)	7000	9.6	RG-52	TK-A853	3.2(32)
CB-52	A5	4.5	4~52	7~36	7~45	39.2(4000)	92.1(9400)	7000	6.5	RG-52	TK-A853	3.2(32)
CB-52	A6	4.5	4~52	7~36	7~45	39.2(4000)	92.1(9400)	7000	7.8	RG-52	TK-A853	3.2(32)
CB-65		4.5	4~65	8~56	8~46	44.1(4500)	103(10500)	5500	15	RG-65	TK-A1068	3.0(30)
CB-65	A6	4.5	4~65	8~56	8~46	44.1(4500)	103(10500)	5500	13.6	RG-65	TK-A1068	3.0(30)
CB-65	A8	4.5	4~65	8~56	8~46	44.1(4500)	103(10500)	5500	17.6	RG-65	TK-A1068	3.0(30)
CB-80		6	5~80	8~68	8~56	50.0(5100)	115(11730)	5500	19	RG-80	TK-A1287	2.3(23)
CB-80	A8	6	5~80	8~68	8~56	50.0(5100)	115(11730)	5500	19	RG-80	TK-A1287	2.3(23)

## CBE/CBE-A

### END STOP COLLET CHUCK

- End stop clamping.
- With backgauge block mechanism, it can be more precise to position the length of the workpiece.
- Backgauge block can be removed and replaced by dust cover. After removing backgauge block, CBE/CBE-A type can be used as Through-hole type collet chuck.



Dust cover

The rubber between the hardened steel collet segments can prevent ingress of swarf and chips into chuck body.

### SPECIFICATIONS

Model	Plunger stroke mm	Max. Chucking Capacity			Max. D.B. pull kN (kgf)	Max. clamping force kN (kgf)	Max. speed min <sup>-1</sup> (r.p.m.)	Weight (kg)	Matching steel collet	Matching Cyl.	Max. pressure MPa (kgf/cm <sup>2</sup> )
		Round mm	Hexagom mm	Square mm							
CBE-42	4.5	4~42	7~36	7~30	34.3(3500)	78.4(8000)	7000	6	RG-42	TK-B846	2.8(28)
CBE-42I2	4.5	4~42	7~36	7~30	34.3(3500)	78.4(8000)	7000	6	RG-42	TK-B846	2.8(28)
CBE-42 A5	4.5	4~42	7~36	7~30	34.3(3500)	78.4(8000)	7000	6.3	RG-42	TK-B846	2.8(28)
CBE-42 A6	4.5	4~42	7~36	7~30	34.3(3500)	78.4(8000)	7000	7.4	RG-42	TK-B846	2.8(28)
CBE-52	4.5	4~52	7~36	7~30	39.2(4000)	92.1(9400)	7000	6.9	RG-52	TK-A853	3.2(32)
CBE-52I2	4.5	4~52	7~36	7~30	39.2(4000)	92.1(9400)	7000	6.7	RG-52	TK-A853	3.2(32)
CBE-52I7	4.5	4~52	7~36	7~30	39.2(4000)	92.1(9400)	7000	8.9	RG-52	TK-A853	3.2(32)
CBE-52 A5	4.5	4~52	7~36	7~30	39.2(4000)	92.1(9400)	7000	7.8	RG-52	TK-A853	3.2(32)
CBE-52 A6	4.5	4~52	7~36	7~30	39.2(4000)	92.1(9400)	7000	8.3	RG-52	TK-A853	3.2(32)
CBE-65	4.5	4~65	8~56	8~46	44.1(4500)	103(10500)	6000	9.3	RG-65	TK-A1068	3.0(30)
CBE-65I7	4.5	4~65	8~56	8~46	44.1(4500)	103(10500)	6000	8.6	RG-65	TK-A1068	3.0(30)
CBE-65 A5	4.5	4~65	8~56	8~46	44.1(4500)	103(10500)	6000	10.8	RG-65	TK-A1068	3.0(30)
CBE-65 A6	4.5	4~65	8~56	8~46	44.1(4500)	103(10500)	6000	9.5	RG-65	TK-A1068	3.0(30)
CBE-65 A8	4.5	4~65	8~56	8~46	44.1(4500)	103(10500)	6000	9.5	RG-65	TK-A1068	3.0(30)

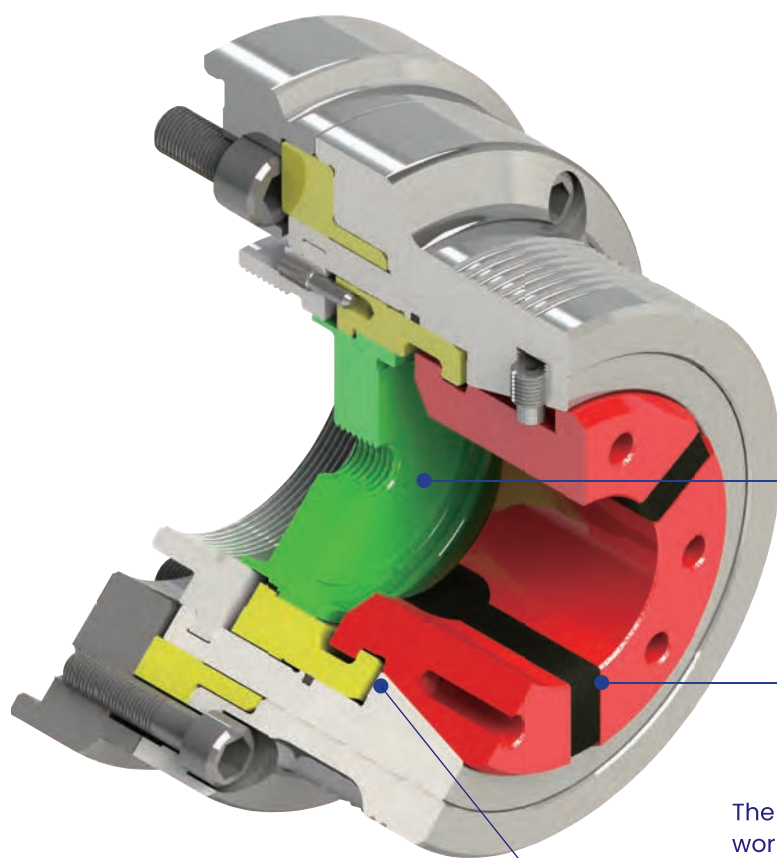
## CBD/CBD-A

### DEAD LENGTH COLLET CHUCK

- Push clamping: with backgauge block mechanism, collet will not be pushed. It can be more precise to position the length of the workpiece.
- Backgauge block can be removed and replaced by dust cover. After removing backgauge block, CBD/CBD-A type can be used as Through-hole type collet chuck.
- Ideal for gripping soft materials, preventing scratches on the surface of the workpiece which may be caused by the Draw Collet Chucks.



Note: When using the draw collet chuck, there will be a slight axial displacement of the workpiece as the rubber grip collet is pulled back by the wedge plunger. However, while dead length collet chuck clamps workpiece, the rubber grip collet is stationary and the bushing is pushed forward to clamp workpiece, so there will be no axial displacement. When you need to precisely control the axial accuracy, such as the second spindle of the turning machine, dead length collet chuck is your best choice.



Dust cover

The rubber between the hardened steel collet segments can prevent ingress of swarf and chips into chuck body.

The push type bushing can ensure the workpiece is stationary when clamping.

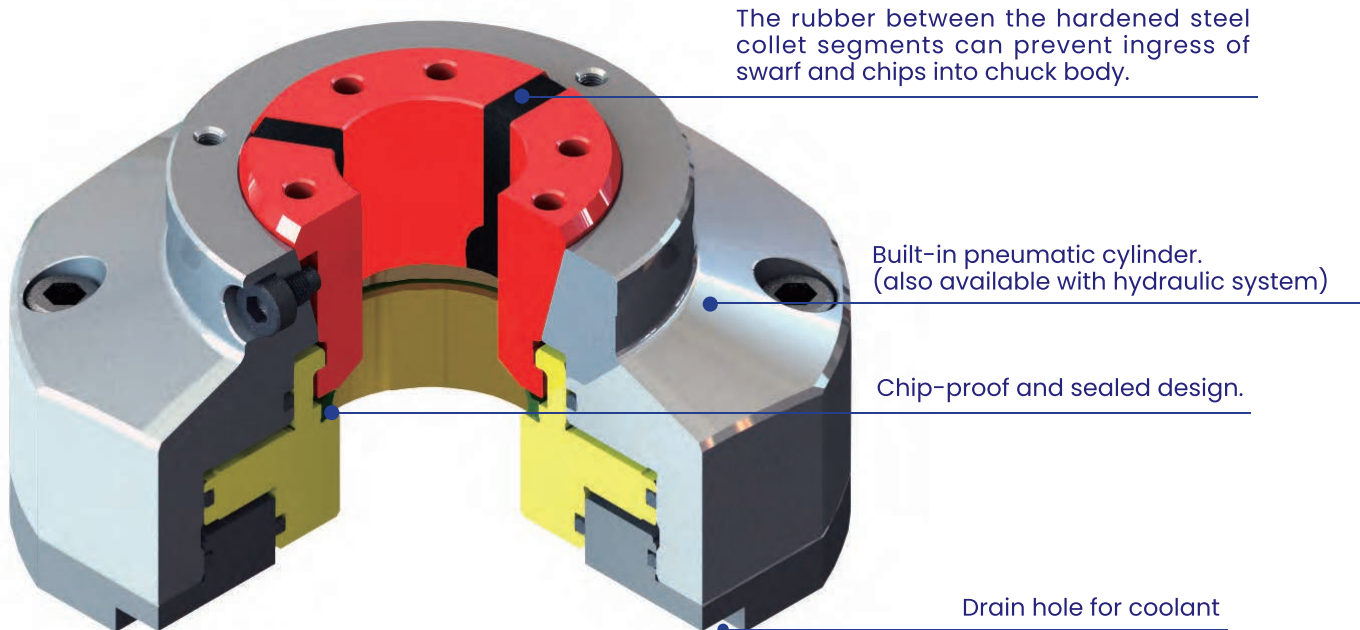
### SPECIFICATIONS

Model	Plunger stroke	Max. Chucking Capacity			Max. D.B. pull	Max. clamping force	Max. speed	Weight	Matching steel collet	Matching Cyl.	Max. pressure
		Round	Hexagom	Square							
	mm	mm	mm	mm	kN (kgf)	kN (kgf)	min <sup>-1</sup> (r.p.m.)	(kg)			MPa (kgf/cm <sup>2</sup> )
CBD-52	4.5	4~52	7~36	7~45	39.2(4000)	92.1(9400)	7000	7.3	RG-52	TK-A853	3.0(30)
CBD-52I2	4.5	4~52	7~36	7~45	39.2(4000)	92.1(9400)	7000	7.1	RG-52	TK-A853	3.0(30)
CBD-52I7	4.5	4~52	7~36	7~45	39.2(4000)	92.1(9400)	7000	10.9	RG-52	TK-A853	3.0(30)
CBD-52 A5	4.5	4~52	7~36	7~45	39.2(4000)	92.1(9400)	7000	7.8	RG-52	TK-A853	3.0(30)
CBD-52 A6	4.5	4~52	7~36	7~45	39.2(4000)	92.1(9400)	7000	9.1	RG-52	TK-A853	3.0(30)
CBD-65	4.5	4~65	8~56	8~46	44.1(4500)	103(10500)	6000	9.3	RG-65	TK-A1068	2.7(27)
CBD-65I7	4.5	4~65	8~56	8~46	44.1(4500)	103(10500)	6000	8.6	RG-65	TK-A1068	2.7(27)
CBD-65 A5	4.5	4~65	8~56	8~46	44.1(4500)	103(10500)	6000	10.8	RG-65	TK-A1068	2.7(27)
CBD-65 A6	4.5	4~65	8~56	8~46	44.1(4500)	103(10500)	6000	9.5	RG-65	TK-A1068	2.7(27)
CBD-65 A8	4.5	4~65	8~56	8~46	44.1(4500)	103(10500)	6000	9.5	RG-65	TK-A1068	2.7(27)

## SCB

### STATIONARY DRAW COLLET CHUCK

- Built-in cylinder: available when air hose is connected.  
(also available with hydraulic system)
- Ideal for drilling machines, milling machines and machining centers.
- Chip-proof design.
- Compact design.
- Two modes of air/oil supply: side-supply mode or baseplate-supply mode.



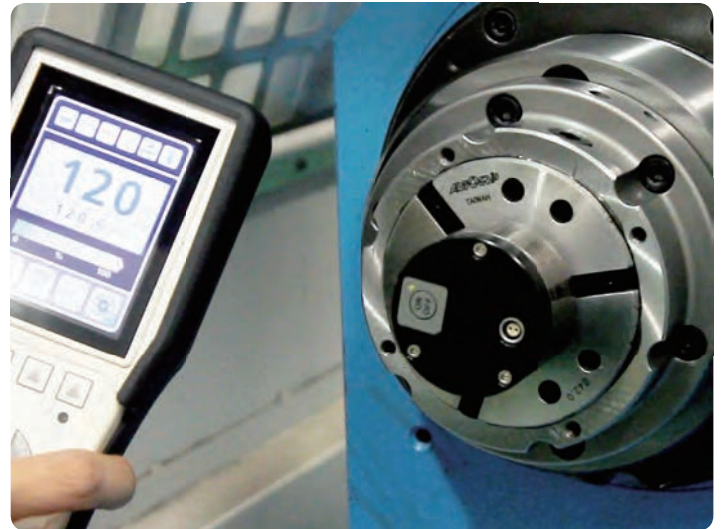
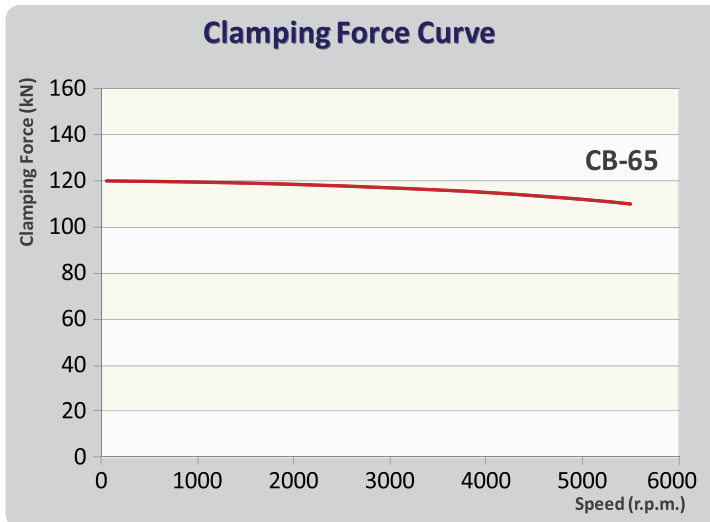
#### SPECIFICATIONS

Model	Jaw stroke(Dia.) mm	Max. Chucking Capacity			Max. clamping force kN (kgf)	Weight (kg)	Matching steel collet	Max. pressure MPa (kgf/cm <sup>2</sup> )
		Round	Hexagom	Square				
		mm	mm	mm				
SCB-52	± 0.5	4~52	7~45	7~36	80(8150)	8.6	RG-52	4.0(40)
SCB-65	± 0.5	4~65	8~56	8~46	105(10700)	10.2	RG-65	4.2(42)



## HIGH GRIPPING FORCE

- Exceptional rigidity, and the gripping force is twice higher than standard spring collets.
- The gripping force is less affected by the centrifugal force at high rotational speed.
- Greatly improve machining efficiency and stability.



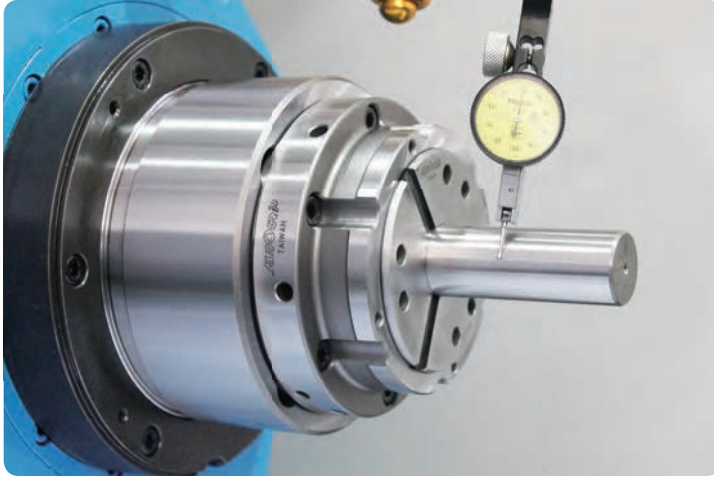
## QUICK COLLET CHANGE

- With collet changing tools, collets (RG series) can be quickly changed within ten seconds.
- Suitable for high-mix low-volume production.



**REDUCE DOWNTIME = INCREASE THROUGHPUT AND PROFITS**

## HIGH ACCURACY



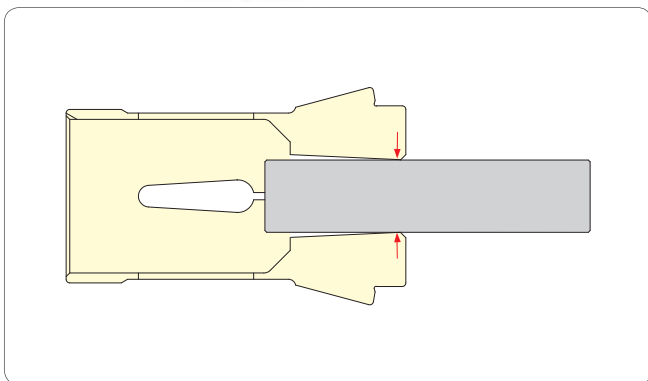
- By selecting the rubber chuck that matches the size of the workpiece, the accuracy are conformed to DIN6343 Class I.
- Carburized chuck body brings high wear resistance and durability so that clamping accuracy can last long time.

## COMPARISON BETWEEN SPRING COLLET AND AUTOGRIP'S RUBBER GRIP COLLET

### Spring Collet

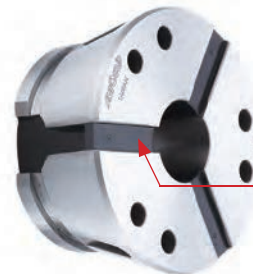


Without the rubber between the hardened steel collet segments, it is likely to increase the ingress of swarf and chips into chuck body.

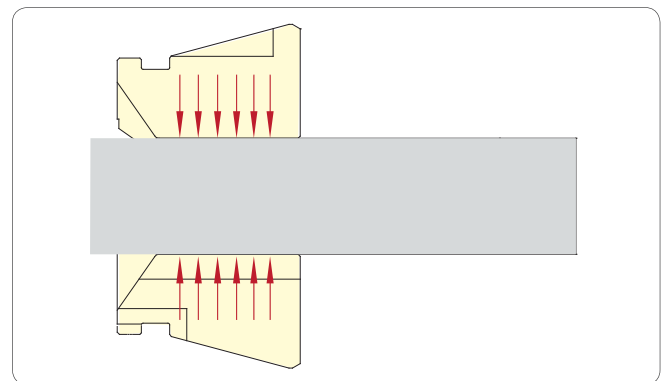


- Higher setup time.
- Point contact on the workpiece, causing low accuracy and gripping force.
- Swarf and chips easily go inside the chuck body

### AUTOGRIP'S Rubber Grip Collet



Rubber prevents the swarf and chips from entering so that reduces the risk of wear or stuck.



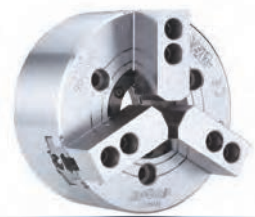
- Quick collet change – within 10 seconds.
- Parallel gripping along the entire workpiece, resulting in superior accuracy and gripping force.
- The rubber between the hardened steel collet segments can prevent ingress of swarf and chips into chuck body.



**WHEN YOU ENCOUNTERED SITUATIONS MENTIONED BELOW, A RUBBER GRIP COLLET IS A BETTER CHOICE THAN A THREE-JAW CHUCK.**

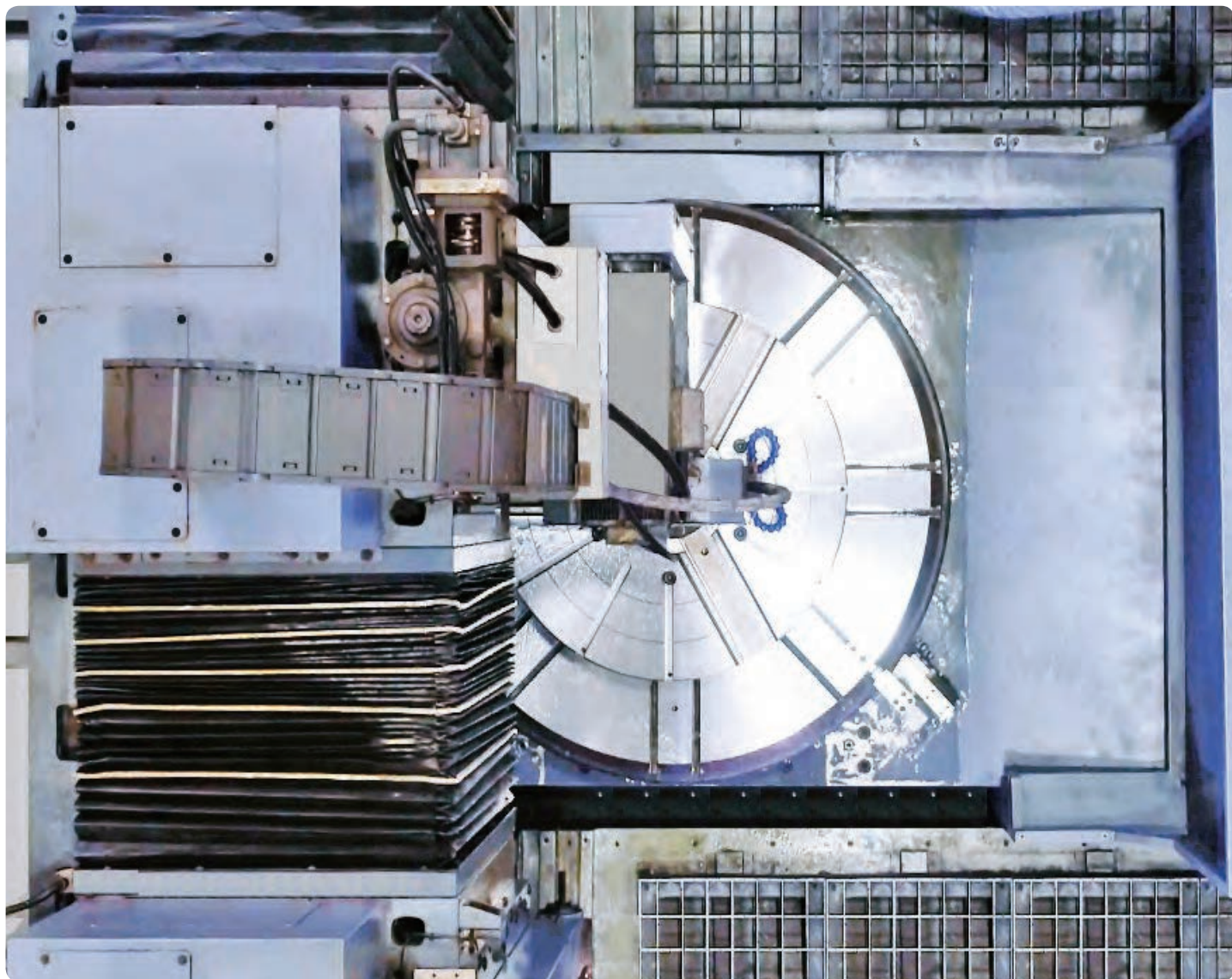


**VS**

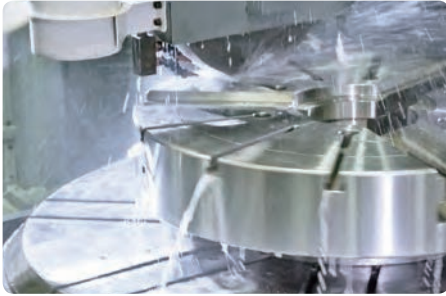


**WINNER**

- **Rear feeding** : Collet chucks clamp and unclamp faster, and additionally, offer 360° parallel gripping to make sure that the bar material maintains on centerline for accurate gripping after being fed new bar stock.
- **Small workpiece** : The gripping force and rotational speed of collet chuck are higher than three-jaw chuck, a great choice for small workpiece clamping.
- **Thin-walled workpiece** : Parallel gripping can avoid the risk of deforming the workpiece by evenly distributing the clamping force around the workpiece circumference.
- **Bar/pipe workpiece** : The compact design of collet chuck reduces interference of cutting tools, making machining operation take place closer to the chuck, which helps prevent workpiece from bending.
- **High rotational speed** : The gripping force is less affected by the centrifugal force and can still maintain consistent at a high rotational speed.
- **Save changeover time** : Quick collet change within ten seconds and there is no need to bore soft jaws. Collet chucks can also work with robotic arms for changeover.







## Why AUTOGRIP?

### 1. CUSTOM DESIGN SERVICE

Example: Solution of automatic workholding and workpiece seating confirmation, special requirement on air/hydraulic cylinder, rotary valve, rotary joint, or customized soft jaw/hard jaw.

### 2. VARIETY OF CHUCKS & CYLINDERS

Chuck: 1-jaw to 6-jaw chuck from 3" to 79", Extra long stroke, Pull back, Stationary chucks, Collet chucks and other clamping solution.

Cylinder: through-hole, Non-through hole, Stroke control, Coolant/air connection, Air cylinder, Double rod, Compact style.

### 3. FASTER DELIVERY AND SATISFIED SERVICE.





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## POWER CHUCKS    ROTARY CYLINDERS    CLAMPING SERIES



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