

Collet chucks ■ Bar pulling chucks



KSZ-MB

Collet chuck

- for bar machining
- push actuation

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KSZ-DZN

Draw collet chuck

- for bar machining
- draw actuation
- KSZ-DZN: for bars
- KSZ-AZN: for bar or shaft machining with removable workstop

KSZ-AZN

Draw collet chuck with workstop

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KSZ-NZN

Collet chuck for neutral axial positioning

- for bar or shaft machining
- to push actuation
- neutral axial position of the workpiece during clamping
- removable workstop

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KSZ-AZL

Draw collet chuck including preparation for air sensing

- for bar or shaft machining
- draw actuation
- with built-in air sensing
- removable workstop

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GF 80

INCH serration bar pulling chuck

Spring operated bar pulling chuck

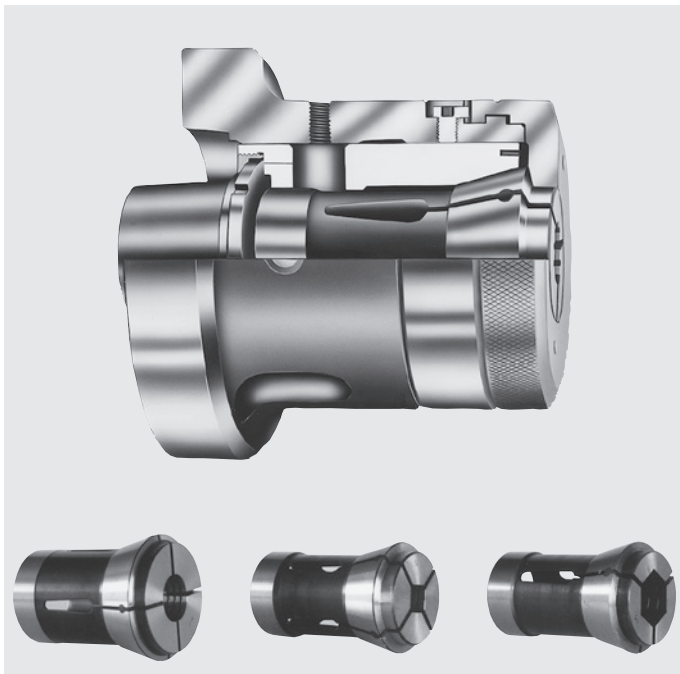
- spring actuation
- for stationary outside clamping

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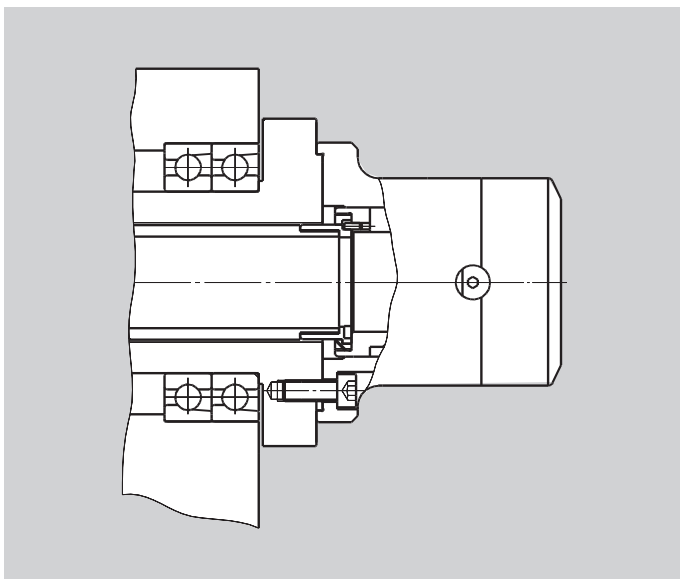
Application/customer benefits

- Efficient machining of bar material on automatic bar machines with bar feed.
- Less deformation of thin-walled components during clamping.
- Quick set-up by means of bayonet locking cap.
- For highest speeds.
- Clamping/unclamping of chuck during spindle rotation is possible.



Profitability

- Quick and simple installation to all lathes. (alternating with 3-jaw chucks)
- Round, square and hexagonal material can be clamped, by simply changing the collet.
- Cost effective by using standard collets DIN 6343 as well as standard Rubberflex and Multirange collets.
- Collets for highest concentricity for special profiles, vulcanized, coated or ground to size are available on request.

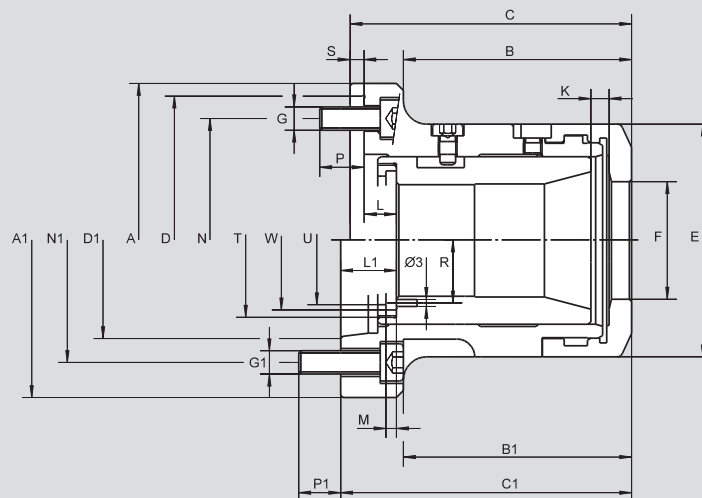


- Case hardened and ground chuck parts ensure long service life.
- Finish-machining of all parts in one set-up guarantees perfect concentricity.
- Direct mounting to the machine spindle ensures high concentricity.
- High operating reliability due to a minimum of parts.
- High axial positioning accuracy of the components by means of push type collet system.

Main dimensions and technical data

Collet chuck

Attention: Chuck position „open“ (left end position) is with end stop in actuating cylinder.
Do not actuate chuck without cap nut mounted!
Remove pin dia. 3 for rotating ring nut for direct connection in thread dimension T.



Subject to technical changes.
For more detailed information please ask for customer drawing.

SMW-AUTOBLOK Type		KSZ-MB 40			KSZ-MB 60				KSZ-MB 80
Mounting		Z140	A5	A6	Z170	Z220	A6	A8	Z/A8
Id. No.		088174	088180	088179	088175	088176	088178	088177	091209
	A h6	155	-	-	185	235	-	-	-
	A1 h6	-	135	170	-	-	170	220	220
	B	90.9	-	-	108.9	108.9	-	-	-
	B1	-	96.9	91.9	-	-	117.9	108.4	147
	C	113.9	-	-	138.9	140.9	-	-	-
	C1	-	123.9	123.9	-	-	144.9	145.9	176.5
Center mounting	D	140	-	-	170	220	-	-	-
Short taper mounting to DIN 55026	D1	-	A5	A6	-	-	A6	A8	A8
	E	102	102	102	130	130	130	130	156
	F	51	51	51	74	74	74	74	95
	G	3 x M10	-	-	6 x M12	6 x M16	-	-	-
	G1	-	4 x M10	4 x M12	-	-	4 x M12	4 x M16	6 x M16
	K _{max.}	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5
	L	8.5	-	-	14.0	16.0	-	-	-
	L1	-	24.5	24.5	-	-	26.0	27.0	30.5
	M	4.5	4.5	4.5	4.5	4.5	4.5	4.5	6.0
	N	104.8	-	-	133.4	171.4	-	-	-
	N1	-	104.8	133.4	-	-	133.4	171.4	171.4
	P	18	-	-	14	20	-	-	-
	P1	-	14	14.5	-	-	16	16	27.5
	R	28	28	28	39.5	39.5	39.5	39.5	51
	S	6	-	-	6	6	-	-	-
Pressure sleeve thread/ thread depth	T	M66 x 1.5/8			M90 x 1.5/8				M114 x 2/11
	U	54			77				99
	W	62.5			83				107
max. speed	r.p.m.	6000	6000	6000	5000	5000	5000	4000	4000
max. actuating force	daN	2500	2500	2500	3000	3000	3000	3500	3500
max. gripping force	daN	5400	5400	5400	6500	6500	6500	7300	7300
Weight without collets	kg	6.1	7.7	7.8	13.6	14.2	14.1	18.1	20.8
rec. actuating cylinders	Type	VNK-T2 102-46			VNK-T2 150-67				VNK-T2 200-86
Speed	r.p.m.	7000			5500				4000

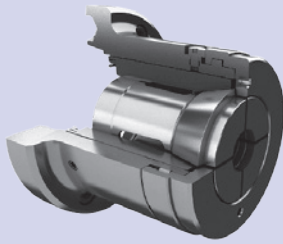


KSZ-MB

Collet chuck

Ordering review

Supply range: Chuck and mounting bolts



Size Spindle mounting	KSZ-MB 40	KSZ-MB 60	KSZ-MB 80 - 193 E
Centering rim standard	Z140 088174	Z170 088175	Z220* 091209*
Centering rim large		Z220 088176	
A 05	088180		
A 06	088179	088178	
A 08		088177	091209*

* **Attention:** KSZ-MB 80-193E with standard centering rim (Id.-No. 091209) has outside centering 220 mm (and also inside taper A8)

Accessories for KSZ-MB



Size Accessories	KSZ-MB 40	KSZ-MB 60	KSZ-MB 80
Blank adapter	0360790	0360810	
Reduction for smaller collets (comprising pressure sleeve and cap nut)	KSZ-MB size 40 to size 26 0360720/0361792	KSZ-MB size 60 to size 40 0360121/0361360	KSZ-MB size 80 to size 40 0362082/0360135
			KSZ-MB size 80 to size 60 0362081/0360134

Collets for KSZ-MB 40

Steel collets DIN 6343 series 173 E

ROUND*

Ø	3	3.5	4	4.5	5	5.5	6	6.5	7	7.5	8	8.5	9
Id. No.	012961	012962	012963	012964	012965	012966	012967	012968	012969	012970	012971	012972	012973
Ø	9.5	10	10.5	11	11.5	12	12.5	13	13.5	14	14.5	15	15.5
Id. No.	012974	012975	012976	012977	012978	012979	012980	012981	012982	012983	012984	012985	012986
Ø	16	16.5	17	17.5	18	18.5	19	19.5	20	20.5	21	21.5	22
Id. No.	012987	012988	012989	012990	012991	012992	012993	012994	012995	012996	012997	012998	012999
Ø	22.5	23	23.5	24	24.5	25	25.5	26	26.5	27	27.5	28	28.5
Id. No.	013000	013001	013002	013003	013004	013005	013006	013007	013008	013009	013010	013011	013012
Ø	29	29.5	30	30.5	31	31.5	32	32.5	33	33.5	34	34.5	35
Id. No.	013013	013014	013015	013016	013017	013018	013019	013020	013021	013022	013023	013024	013025
Ø	35.5	36	36.5	37	37.5	38	38.5	39	39.5	40	40.5	41	41.5
Id. No.	013026	013027	013028	013029	013030	013031	013032	013033	013034	013035	013036	013037	013038
Ø	42												
Id. No.	013039												

HEXAGONAL**

Hexagon	6	7	8	9	10	11	12	13	14	15	16	17	19
Id. No.	013040	013041	013042	013043	013044	013045	013046	013047	013048	013049	013050	013051	013052
Hexagon	20	21	22	24	26	27	28	30	31	32	36		
Id. No.	016428	016429	013053	013054	016430	013055	016431	013056	016432	013057	013058		

SQUARE**

Square	6	7	8	9	10	11	12	13	14	15	16	18	20
Id. No.	013059	013060	013061	013062	013063	013064	013065	013066	013067	013068	013069	013070	013071
Square	22	25	28										
Id. No.	013072	013073	013074										

Rubberflex collets series 36 (recommended for raw part clamping)

ROUND

Ø	7-9	9-11	11-13	13-15	15-17	17-19	19-21	21-23	23-25	25-27	27-29	29-31	31-33
Id. No.	013076	013077	013078	013079	013080	013081	013082	013093	013083	013084	013085	013086	013087
Ø	33-35	35-37	37-39	39-41	41-43								
Id. No.	013088	013089	013090	013091	013092								

* concentricity according to DIN 6343

** concentricity has to be agreed

Collets for KSZ-MB 60

Steel collets DIN 6343 series 185 E
ROUND*

Ø	4	5	6	7	8	9	10	11	12	13	14	15	16
Id. No.	013112	013113	013114	013115	013116	013117	013118	013119	013120	013121	013122	013123	013124
Ø	17	18	19	20	21	22	23	24	25	26	27	28	29
Id. No.	013125	013126	013127	013128	013129	013130	013131	013132	013133	016434	013134	013135	013136
Ø	30	31	32	33	34	35	36	37	38	39	40	41	42
Id. No.	013137	013138	013139	013140	013141	013142	013143	013144	016435	013145	013146	013147	013148
Ø	43	44	45	46	47	48	49	50	51	52	53	54	55
Id. No.	013149	013150	013151	013152	013153	013154	013155	013156	013157	013158	013159	013160	013161
Ø	56	57	58	59	60								
Id. No.	013162	013163	013164	013165	013166								

HEXAGONAL**

⬡	8	9	10	11	12	13	14	15	16	17	19	22	24
Id. No.	013167	013168	013169	013170	013171	013172	013173	013174	013175	013176	013177	013178	013179
⬡	27	30	32	36	41	50							
Id. No.	013180	013181	013182	013183	019312	019592							

SQUARE**

□	7	8	9	10	11	12	13	14	15	16	17	18	20
Id. No.	013184	013185	013186	013187	013188	013189	013190	013191	013192	013193	019110	013194	013195
□	22	25	28	30	32	35	36	40					
Id. No.	013196	013197	013198	013199	013200	019111	013201	017800					

Rubberflex collets series 52 (recommended for raw part clamping)
ROUND

Ø	35-37	37-39	39-41	41-43	43-45	45-47	47-49	49-51	51-53	53-55	55-57	57-59	59-61
Id. No.	013203	013204	013205	013206	013207	013208	013209	013210	013211	013212	013213	013214	013215

Collets for KSZ-MB 80

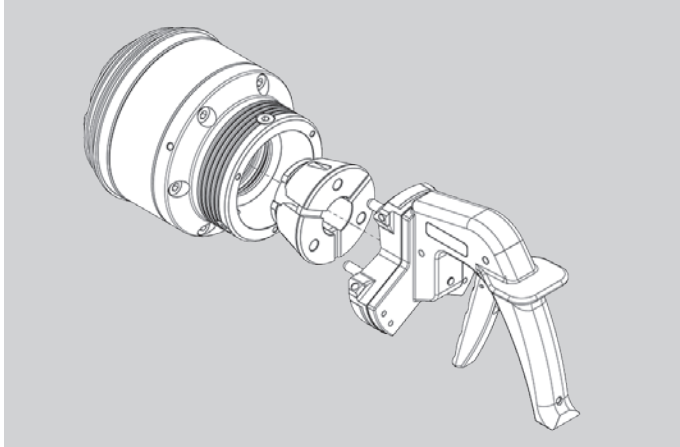
Steel collets DIN 6343 series 193 E
ROUND*

Ø	20	21	22	23	24	25	26	27	28	29	30	31	32
Id. No.	013237	013238	013239	013240	013241	013242	013243	013244	013245	013246	013247	013248	013249
Ø	33	34	35	36	37	38	39	40	41	42	43	44	45
Id. No.	013250	013251	013252	013253	013254	013255	013256	013257	013258	013259	013260	013261	013262
Ø	46	47	48	49	50	51	52	53	54	55	56	57	58
Id. No.	013263	013264	013265	013266	013267	013268	013269	013270	013271	013272	013273	013274	013275
Ø	59	60	61	62	63	64	65	66	67	68	69	70	71
Id. No.	013276	013277	013278	013279	013280	013281	013282	013283	013284	013285	013286	013287	013288
Ø	72	73	74	75	76	77	78	79	80				
Id. No.	013289	013290	013291	013292	013293	013294	013295	013296	013297				

Further collets are available on request.

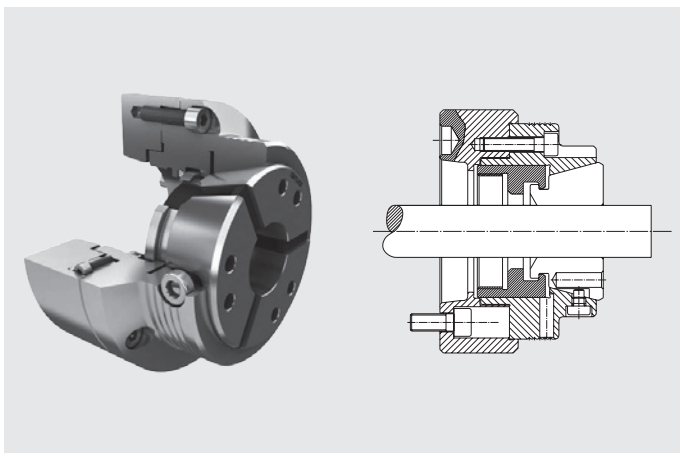
* concentricity according to DIN 6343

** concentricity has to be agreed



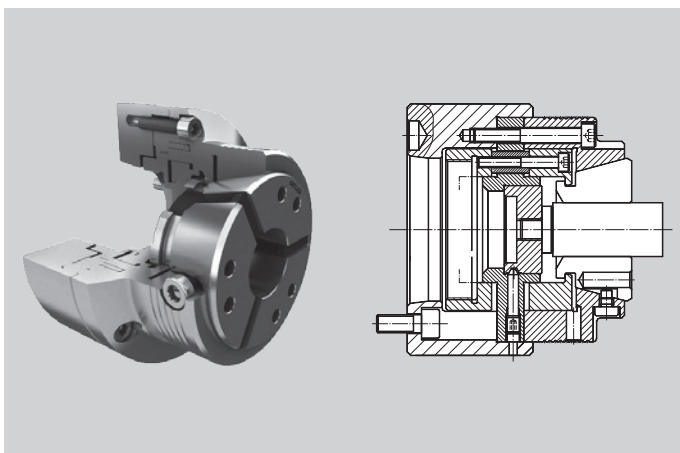
Application/customer benefits

- Safe clamping of bars and shafts.
- Quick change of collets with changing unit.
- Changing unit manual or pneumatic.
- Direct mounting of the collets into the body ensures highest concentricity.
- Collets available round, square, hexagonal or as blanks to be machined on the chuck.
- Available for stationary use.



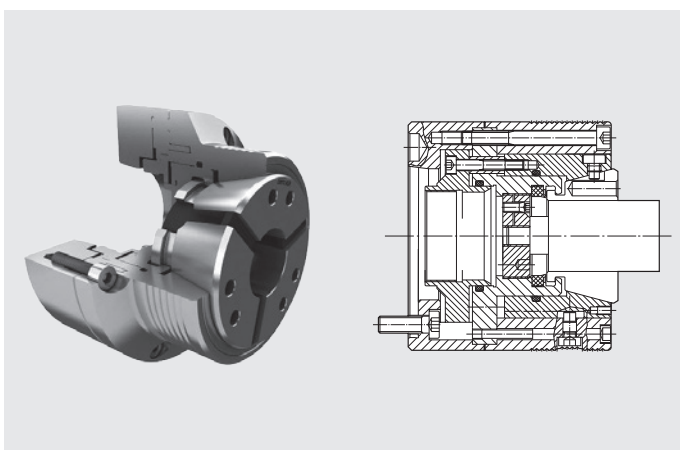
KSZ-DZN

- Safe clamping of bars.
- No push forces onto the machine spindle during clamping.
- Highest axial and radial rigidity with draw collet system.
- Parallel clamping of the collets.
- Flexible use because of large range of the collets.



KSZ-AZN

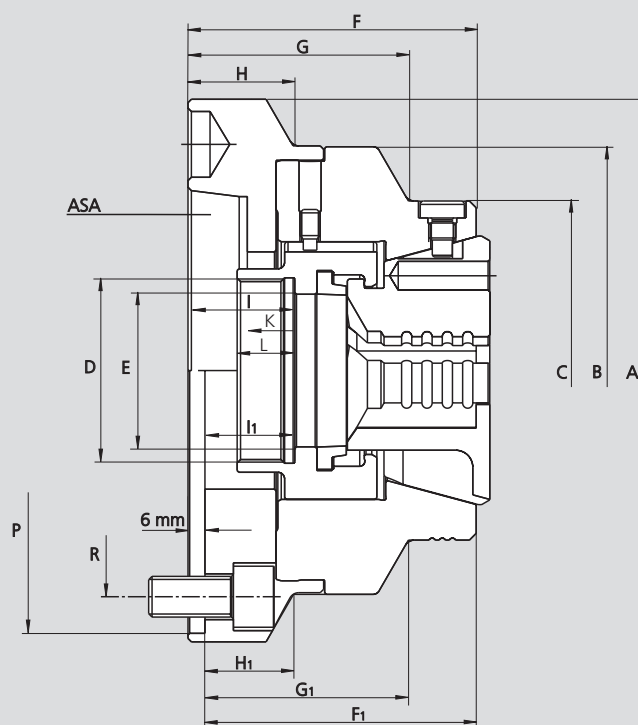
- Rigid axial workstop for shafts.
- High axial positioning accuracy of the shafts because of pull down effect onto the workstop.
- Full through hole available because of quick change of axial workstop.
- Special workstops available on request.



KSZ-NZN

- Ideal for opposed twin spindle machines.
- Collet in axial fixed position = no axial movement and axial forces when clamping.
- Rigid axial workstop for shafts.
- Full through hole available because of quick change of axial workstop.
- Special workstops available on request.

Chuck in open position =
Right end position



Subject to technical changes.
For more detailed information please ask for customer drawing.

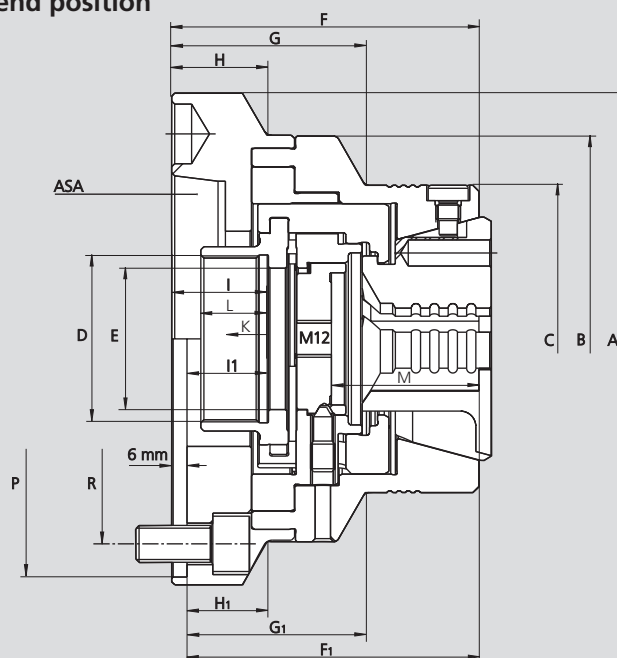
SMW-AUTOBLOK Type		KSZ-DZN 42			KSZ-DZN 65				
Mounting		Z140	A5	A6	Z140	Z170	A5	A6	A8
Id. No.		205073	201338	201339	205072	205074	201341	201342	201343
A		150	132	160	157	180	157	157	202
B		132	-	132	-	157	-	-	157
C		100	100	100	122	122	122	122	122
D		M54 x 1.5	M54 x 1.5	M54 x 1.5	M78 x 1.5	M78 x 1.5	M78 x 1.5	M78 x 1.5	M78 x 1.5
E		45	45	45	68	68	68	68	68
F		-	90	90	-	-	100	98	102
F1		75	-	-	100	98	-	-	-
G		-	70	70	-	-	70	68	72
G1		55	-	-	70	68	-	-	-
H		-	-	36	-	-	-	-	-
H1		15	-	-	-	13	-	-	-
I		-	39	39	-	-	41.5	39.5	43.5
I1		24	-	-	41.5	39.5	-	-	-
axial stroke		K	5	5	4.5	4.5	4.5	4.5	4.5
L		17	17	17	17.5	17.5	17.5	17.5	17.5
P H6		140	-	-	140	170	-	-	-
R		104.8 / M10 3x120°		133.4 / M12 4x90°	104.8 / M10 3x120°	133.4 / M12 6x60°	104.8 / M10 4x90°	133.4 / M12 4x90°	171.4 / M16 4x90°
max. speed	r.p.m.	7000	7000	7000	6000	6000	6000	6000	6000
max. actuating force	daN	3500	3500	3500	4500	4500	4500	4500	4500
max. gripping force	daN	8000	8000	8000	10500	10500	10500	10500	10500
Weight without collets	kg	5.2	5.8	6.7	8.6	8.8	8.4	7.6	9.8
rec. actuating cylinders	Type	VNK-T2 102-46			VNK-T2 150-67				
Speed	r.p.m.	8000			5500				

Changing unit

Accessories	Size	KSZ-DZN 42		KSZ-DZN 65	
	manual	196842		196844	
	pneumatic	192151		192153	



Chuck in open position = Right end position



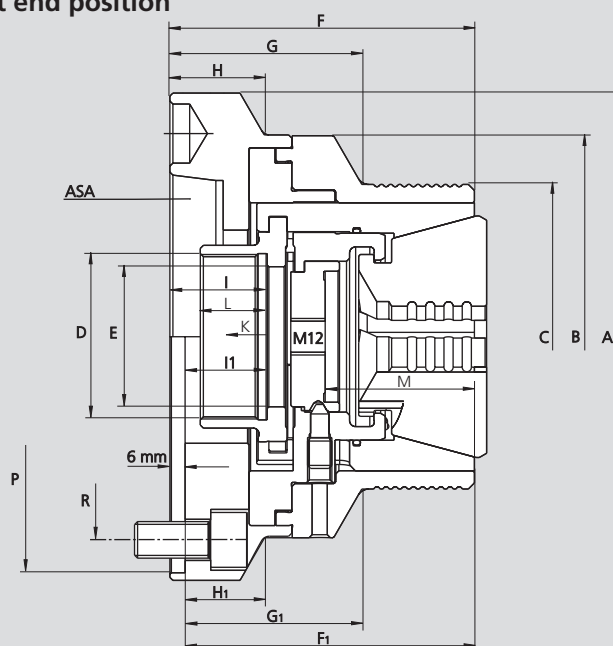
Subject to technical changes.
For more detailed information please ask for customer drawing.

SMW-AUTOBLOK Type		KSZ-AZN 42			KSZ-AZN 65				
Mounting		Z140	A5	A6	Z140	Z170	A5	A6	A8
Id. No.		205066	201346	201347	205075	205076	201349	201350	201351
A		150	132	160	157	180	157	157	202
B		132	-	132	-	157	-	-	157
C		100	100	100	122	122	122	122	122
D		M54 x 1.5	M54 x 1.5	M54 x 1.5	M78 x 1.5	M78 x 1.5	M78 x 1.5	M78 x 1.5	M78 x 1.5
E		46	46	46	68	68	68	68	68
F		-	105	105	-	-	112	110	114
F1		90	-	-	112	110	-	-	-
G		-	68	68	-	-	69	67	71
G1		53	-	-	69	67	-	-	-
H		-	-	36	-	-	-	-	47
H1		15	-	-	-	13	-	-	-
I		-	39	39	-	-	41.5	39.5	43.5
I1		24	-	-	41.5	39.5	-	-	-
axial stroke		K	4.5	4.5	4.5	4.5	4.5	4.5	4.5
L		17	17	17	17.5	17.5	17.5	17.5	17.5
M		48	48	48	54	54	54	54	54
P H6		140	-	-	140	170	-	-	-
R		104.8 / M10 3x120°		133.4 / M12 4x90°	104.8 / M10 3x120°	133.4 / M12 6x60°	104.8 / M10 4x90°	133.4 / M12 4x90°	171.4 / M16 4x90°
max. speed	r.p.m.	7000	7000	7000	6000	6000	6000	6000	6000
max. actuating force	daN	3500	3500	3500	4500	4500	4500	4500	4500
max. gripping force	daN	8000	8000	8000	10500	10500	10500	10500	10500
Weight without collets	kg	5.8	6.2	7.3	9.5	9.5	9.3	8.5	10.7
rec. actuating cylinders	Type	VNK-T2 102-46			VNK-T2 150-67				
Speed	r.p.m.	8000			5500				

Changing unit

 	Size		KSZ-AZN 42	KSZ-AZN 65
	Accessories			
	manual		196842	196844
pneumatic		192151	192153	

Chuck in open position = Left end position

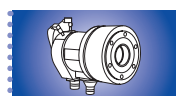


Subject to technical changes.
For more detailed information please ask for customer drawing.

SMW-AUTOBLOK Type		KSZ-NZN 42			KSZ-NZN 65				
Mounting		Z140	A5	A6	Z140	Z170	A5	A6	A8
Id. No.		205077	201354	201355	205078	205080	201357	201358	201359
	A	150	132	160	157	180	157	157	202
	B	132	-	132	-	157	-	-	157
	C	100	100	100	122	122	122	122	122
	D	M54 x 1.5	M54 x 1.5	M54 x 1.5	M78 x 1.5	M78 x 1.5	M78 x 1.5	M78 x 1.5	M78 x 1.5
	E	46	46	46	68	68	68	68	68
	F	-	105	105	-	-	112	110	114
	F1	90	-	-	112	110	-	-	-
	G	-	68	68	-	-	69	67	71
	G1	53	-	-	69	67	-	-	-
	H	-	-	36	-	-	-	-	17
	H1	15	-	-	-	13	-	-	-
	I	-	34.5	34.5	-	-	37	35	39
	I1	19.5	-	-	37	35	-	-	-
axial stroke	K	4.5	4.5	4.5	4.5	4.5	4.5	4.5	4.5
	L	17	17	17	17.5	17.5	17.5	17.5	17.5
	M	48	48	48	54	54	54	54	54
	P H6	140	-	-	140	170	-	-	-
	R	104.8 / M10 3x120°		133.4 / M12 4x90°	104.8 / M10 3x120°	133.4 / M12 6x60°	104.8 / M10 4x90°	133.4 / M12 4x90°	171.4 / M16 4x90°
max. speed	r.p.m.	7000	7000	7000	6000	6000	6000	6000	6000
max. actuating force	daN	3500	3500	3500	4500	4500	4500	4500	4500
max. gripping force	daN	8000	8000	8000	10500	10500	10500	10500	10500
Weight without collets	kg	5.9	6.3	7.4	9.6	9.6	9.4	8.6	10.8
rec. actuating cylinders	Type	VNK-T2 102-46			VNK-T2 150-67				
Speed	r.p.m.	8000			5500				

Changing unit

Accessories	Size	KSZ-NZN 42	KSZ-NZN 65
	manual	196842	196844
	pneumatic	192151	192153



Collets for KSZ-DZN 42 / KSZ-AZN 42 / KSZ-NZN 42

Steel collets with axial and radial grooves (△ smooth, △△ radial grooves)

ROUND*

Ø	4 [△]	5 [△]	6 [△]	7 [△]	8 ^{△△}	9 ^{△△}	10 ^{△△}	11	12	13	14	15	16
Id. No.	192173	192174	192175	192176	192177	192178	192179	192180	192181	192182	192183	192184	192185
Ø	17	18	19	20	21	22	23	24	25	26	27	28	29
Id. No.	192186	192187	192188	192189	192190	192191	192192	192193	192194	192195	192196	192197	192198
Ø	30	31	32	33	34	35	36	37	38	39	40	41	42
Id. No.	192199	192200	192201	192202	192203	192204	192205	192206	192207	192208	192209	192210	192211

Collets in 0.5 mm increments on request

Steel collets with smooth clamping surface

ROUND*

Ø	4	5	6	7	8	9	10	11	12	13	14	15	16
Id. No.	192173	192174	192175	192176	192135	192136	192137	192138	192139	192140	192141	192142	192143
Ø	17	18	19	20	21	22	23	24	25	26	27	28	29
Id. No.	193144	192807	193145	192808	193146	193147	193148	193149	193150	193151	193152	193153	193154
Ø	30	31	32	33	34	35	36	37	38	39	40	41	42
Id. No.	193155	193156	193083	193157	193158	193159	193160	193161	193162	193163	193164	193165	193219

Collets in 0.5 mm increments on request

SQUARE**

□	7 [△]	8 ^{△△}	9 ^{△△}	10 ^{△△}	11 ^{△△}	12 ^{△△}	13 ^{△△}	14 ^{△△}	15 ^{△△}	16 ^{△△}	17 ^{△△}	18 ^{△△}	19 ^{△△}
Id. No.	192212	192213	192214	192215	192216	192217	192218	192219	192220	192221	192222	192223	192224
□	20 ^{△△}	21 ^{△△}	22 ^{△△}	23 ^{△△}	24 ^{△△}	25 ^{△△}	26 ^{△△}	27 ^{△△}	28 ^{△△}	29 ^{△△}	30 ^{△△}		
Id. No.	192225	192226	192227	192228	192229	192230	192231	192232	192233	192234	192235		

HEXAGONAL**

⬡	7 [△]	8 ^{△△}	9 ^{△△}	10 ^{△△}	11 ^{△△}	12 ^{△△}	13 ^{△△}	14 ^{△△}	15 ^{△△}	16 ^{△△}	17 ^{△△}	18 ^{△△}	19 ^{△△}
Id. No.	192236	192237	192238	192239	192240	192241	192242	192243	192244	192245	192246	192247	192248
⬡	20 ^{△△}	21 ^{△△}	22 ^{△△}	23 ^{△△}	24 ^{△△}	25 ^{△△}	26 ^{△△}	27 ^{△△}	28 ^{△△}	29 ^{△△}	30 ^{△△}	31 ^{△△}	32 ^{△△}
Id. No.	192249	192250	192251	192252	192253	192254	192255	192256	192257	192258	192259	192260	192261

Soft steel collets (pre-bored)

ROUND

Ø	5	15	30										
Id. No.	192262	192263	192264										

Boring ring 42 for soft steel collets

Id. No.	193399												
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* concentricity similar DIN 6343

** concentricity has to be agreed

Collets for KSZ-DZN 65 / KSZ-AZN 65 / KSZ-NZN 65

Steel collets with axial and radial grooves (Δ smooth, $\Delta\Delta$ radial grooves)

ROUND*

$\emptyset$	5 Δ	6 Δ	7 Δ	8 $\Delta\Delta$	9 $\Delta\Delta$	10 $\Delta\Delta$	11	12	13	14	15	16	17
Id. No.	192265	192266	192267	192268	192269	192270	192271	192272	192273	192274	192275	192276	192277
$\emptyset$	18	19	20	21	22	23	24	25	26	27	28	29	30
Id. No.	192278	192279	192280	192281	192282	192283	192284	192285	192286	192287	192288	192289	192290
$\emptyset$	31	32	33	34	35	36	37	38	39	40	41	42	43
Id. No.	192291	192292	192293	192294	192295	192296	192297	192298	192299	192300	192301	192302	192303
$\emptyset$	44	45	46	47	48	49	50	51	52	53	54	55	56
Id. No.	192304	192305	192306	192307	192308	192309	192310	192311	192312	192313	192314	192315	192316
$\emptyset$	57	58	59	60	61	62	63	64	65				
Id. No.	192317	192318	192319	192320	192321	192322	192323	192324	192325				

Collets in 0.5 mm increments on request

Steel collets with smooth clamping surface

ROUND*

$\emptyset$	5	6	7	8	9	10	11	12	13	14	15	16	17
Id. No.	192265	192266	192267	193172	193173	192682	193174	192787	193175	193176	193177	193169	193178
$\emptyset$	18	19	20	21	22	23	24	25	26	27	28	29	30
Id. No.	193179	193180	193181	193182	192683	193183	193170	193065	193184	193066	193068	193069	193070
$\emptyset$	31	32	33	34	35	36	37	38	39	40	41	42	43
Id. No.	193185	192684	193186	193187	193188	193189	193190	193191	193192	192685	193193	193194	193171
$\emptyset$	44	45	46	47	48	49	50	51	52	53	54	55	56
Id. No.	193196	193197	193198	193199	193200	193201	193202	193203	193204	193205	193206	193207	193208
$\emptyset$	57	58	59	60	61	62	63	64	65				
Id. No.	193195	193209	193210	193211	193212	193213	193214	193215	193216				

Collets in 0.5 mm increments on request

SQUARE**

$\square$	8 $\Delta\Delta$	9 $\Delta\Delta$	10 $\Delta\Delta$	11 $\Delta\Delta$	12 $\Delta\Delta$	13 $\Delta\Delta$	14 $\Delta\Delta$	15 $\Delta\Delta$	16 $\Delta\Delta$	17 $\Delta\Delta$	18 $\Delta\Delta$	19 $\Delta\Delta$	20 $\Delta\Delta$
Id. No.	192326	192327	192328	192329	192330	192331	192332	192333	192334	192335	192336	192337	192338
$\square$	21 $\Delta\Delta$	22 $\Delta\Delta$	23 $\Delta\Delta$	24 $\Delta\Delta$	25 $\Delta\Delta$	26 $\Delta\Delta$	27 $\Delta\Delta$	28 $\Delta\Delta$	29 $\Delta\Delta$	30 $\Delta\Delta$	31 $\Delta\Delta$	32 $\Delta\Delta$	33 $\Delta\Delta$
Id. No.	192339	192340	192341	192342	192343	192344	192345	192346	192347	192348	192349	192350	192351
$\square$	34 $\Delta\Delta$	35 $\Delta\Delta$	36 $\Delta\Delta$	37 $\Delta\Delta$	38 $\Delta\Delta$	39 $\Delta\Delta$	40 $\Delta\Delta$	41 $\Delta\Delta$	42 $\Delta\Delta$	43 $\Delta\Delta$	44 $\Delta\Delta$	45 $\Delta\Delta$	46 $\Delta\Delta$
Id. No.	192352	192353	192354	192355	192356	192357	192358	192359	192360	192361	192362	192363	192364

HEXAGONAL**

$\hexagon$	10 $\Delta\Delta$	11 $\Delta\Delta$	12 $\Delta\Delta$	13 $\Delta\Delta$	14 $\Delta\Delta$	15 $\Delta\Delta$	16 $\Delta\Delta$	17 $\Delta\Delta$	18 $\Delta\Delta$	19 $\Delta\Delta$	20 $\Delta\Delta$	21 $\Delta\Delta$	22 $\Delta\Delta$
Id. No.	192365	192366	192367	192368	192369	192370	192371	192372	192373	192374	192375	192376	192377
$\hexagon$	23 $\Delta\Delta$	24 $\Delta\Delta$	25 $\Delta\Delta$	26 $\Delta\Delta$	27 $\Delta\Delta$	28 $\Delta\Delta$	29 $\Delta\Delta$	30 $\Delta\Delta$	31 $\Delta\Delta$	32 $\Delta\Delta$	33 $\Delta\Delta$	34 $\Delta\Delta$	35 $\Delta\Delta$
Id. No.	192378	192379	192380	192381	192382	192383	192384	192385	192386	192387	192388	192389	192390
$\hexagon$	36 $\Delta\Delta$	37 $\Delta\Delta$	38 $\Delta\Delta$	39 $\Delta\Delta$	40 $\Delta\Delta$	41 $\Delta\Delta$	42 $\Delta\Delta$	43 $\Delta\Delta$	44 $\Delta\Delta$	45 $\Delta\Delta$	46 $\Delta\Delta$	47 $\Delta\Delta$	48 $\Delta\Delta$
Id. No.	192391	192392	192393	192394	192395	192396	192397	192398	192399	192400	192401	192402	192403
$\hexagon$	49 $\Delta\Delta$	50 $\Delta\Delta$											
Id. No.	192404	192405											

Soft steel collets (pre-bored)

ROUND

$\emptyset$	8	20	40										
Id. No.	192406	192407	192408										

Boring ring 65 for soft steel collets

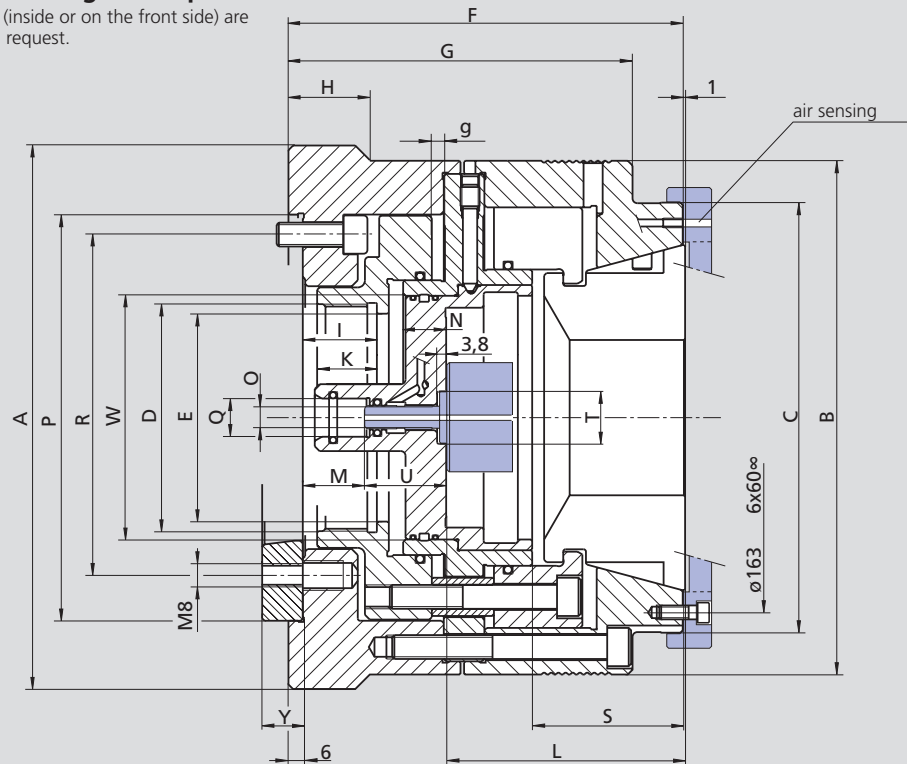
Id. No.	193400												
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* concentricity similar DIN 6343

** concentricity has to be agreed

Chuck in open position = Right end position

The workstops illustrated in blue (inside or on the front side) are optional and can be delivered on request.

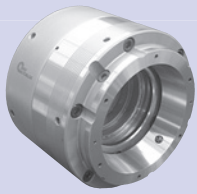


Subject to technical changes.
For more detailed information please ask for customer drawing.

SMW-AUTOBLOK Type		KSZ-AZL 100											
Mounting		Z170			Z220			A6			A8		
Id. No.		194741			195244			194783			195245		
A		215			230			215			230		
B		-			215			-			215		
C		180			180			180			180		
D		M95 x 2			M115 x 2			M95 x 2			M115 x 2		
E		87			107			87			107		
F		165			165			176			178		
G		144			144			155			157		
H		-			37			-			37		
I		36			36			36			36		
K		25			25			25			25		
L		99			99			99			99		
M		25			25			25			25		
N		17			17			17			17		
O		M12			M12			M12			M12		
P H6		170			220								
Q		16			16			16			16		
R		133.4	6 x 60°	M12	171.4	6 x 60°	M16	133.4	6 x 60°	M12	171.4	6 x 60°	M16
S		63			63			63			63		
T		22			22			22			22		
U		34.3			34.3			34.3			34.3		
V		M12			M12			M12			M12		
W		102			102			102			102		
X		111			111			111			111		
Y		-			-			17			19		
Stroke		g			9			9			9		
max. speed		r.p.m.			5000			5000			5000		
max. actuating force		daN			6500			6500			6500		
max. gripping force		daN			8500			8500			8500		
Weight without collets		kg			33			34			36		
rec. actuating cylinder		Type			VNK-T2 200-86			VNK-T2 225-95			VNK-T2 250-110		
Speed		r.p.m.			4500			4000 /3600			4500		

Ordering review

Supply range: Chuck and mounting bolts



Accessories	Size	KSZ-AZL 100
Z 170		194741
A 06		194783
Z 220		195244
A 08		195245

Changing unit



Accessories	Size	KSZ-AZL 100
pneumatic		194744

Collets for KSZ-AZL

Steel collets with axial and radial grooves ROUND*

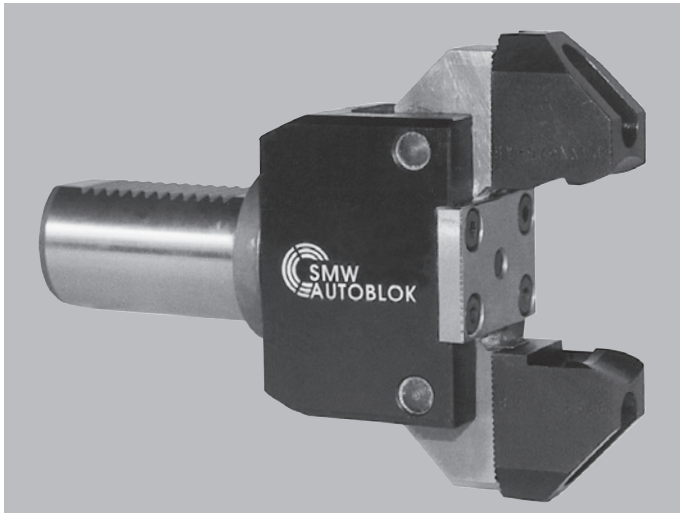
Ø	42	43	44	45	46	47	48	49	50	51	52	53	54
Id. No.	195081	195082	195083	195084	195085	195086	195087	195088	195089	195090	195091	195092	195093
Ø	55	56	57	58	59	60	61	62	63	64	65	66	67
Id. No.	195094	195095	195096	195097	195098	195099	195100	195101	195102	195103	195104	195105	195106
Ø	68	69	70	71	72	73	74	75	76	77	78	79	80
Id. No.	195107	195108	195109	195110	195111	195112	195113	195114	195115	195116	195117	195118	195119
Ø	81	82	83	84	85	86	87	88	89	90	91	92	93
Id. No.	195120	195121	195122	195123	195124	195125	195126	195127	195128	195129	195130	195131	195132
Ø	94	95	96	97	98	99	100						
Id. No.	195133	195134	195135	195136	195137	195138	194742						

Steel collets with smooth clamping surface ROUND*

Ø	42	43	44	45	46	47	48	49	50	51	52	53	54
Id. No.	195141	195142	195143	195144	195145	195146	195147	195148	195149	195150	195151	195152	195153
Ø	55	56	57	58	59	60	61	62	63	64	65	66	67
Id. No.	195154	195155	195156	195157	195158	195159	195160	195161	195162	195163	195164	195165	195166
Ø	68	69	70	71	72	73	74	75	76	77	78	79	80
Id. No.	195167	195168	195169	195170	195171	195172	195173	195174	195175	195176	195177	195178	195179
Ø	81	82	83	84	85	86	87	88	89	90	91	92	93
Id. No.	195180	195181	195182	195183	195184	195185	195186	195187	195188	194743	195189	195190	195191
Ø	94	95	96	97	98	99	100						
Id. No.	195192	195193	195194	195195	195196	195197	195198						

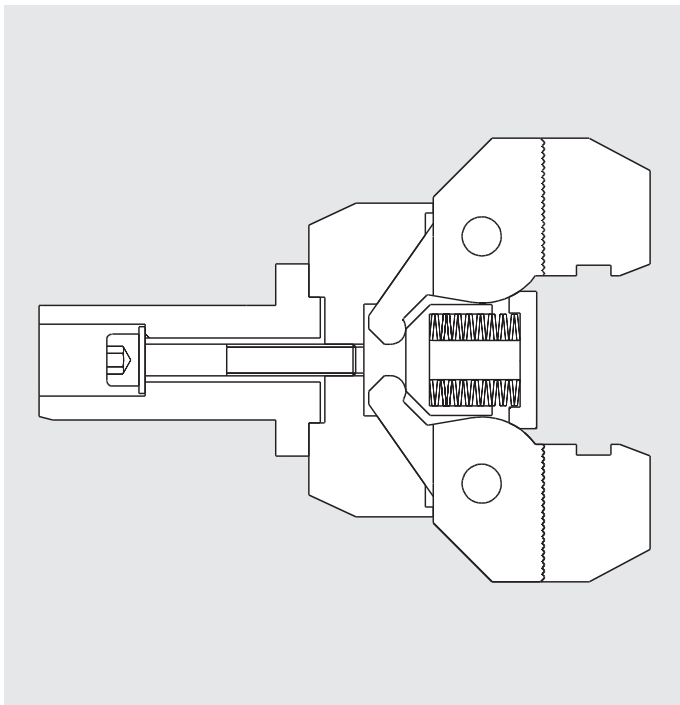
* concentricity similar DIN 6343





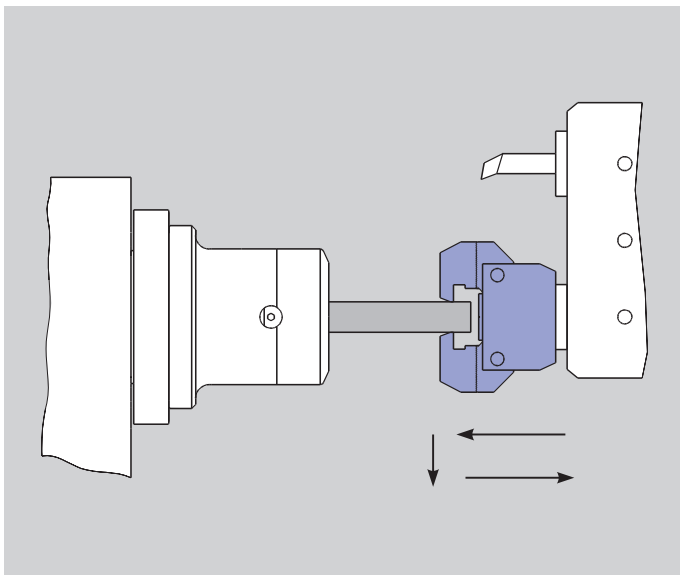
Application/customer benefits

- Clamping and positioning of short bar material.
- Positioning of shaft type components in automatic production cycle.



Profitability

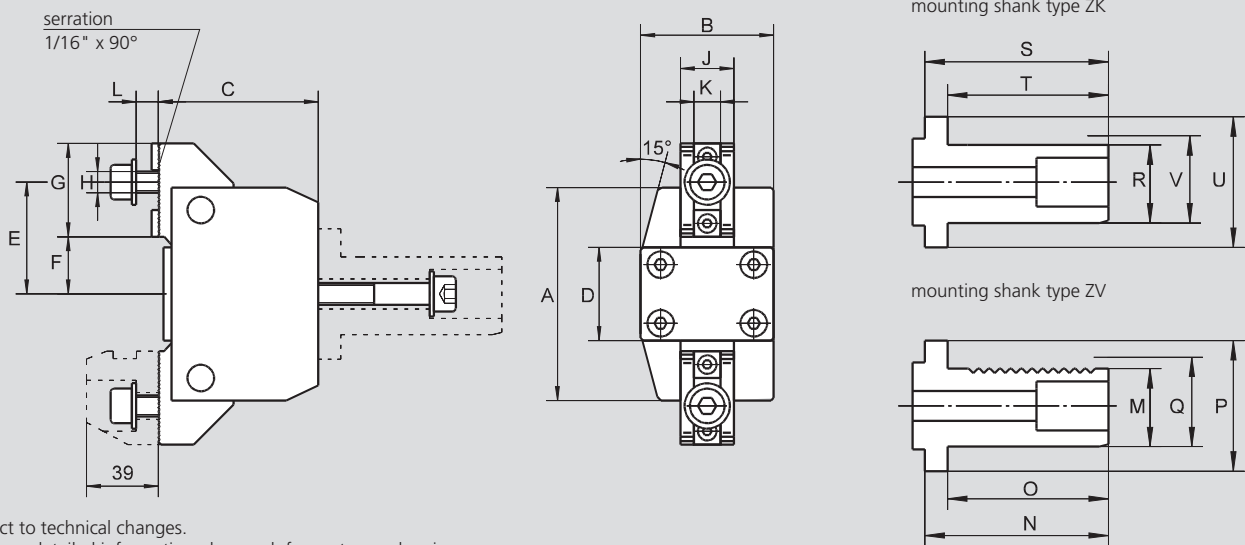
- Direct mounting to the turret of the lathe - actuation device is not necessary.
- Suitable to all tool mounting systems.
- Only one tool place of turret is required.
- Simple production of special jaws for special bar profiles.
- High flexibility at small quantities.
- Simple set-up.
- Simple, safe spring pre-loading of jaws.
- Hardened/quenched clamping arms ensure long service life.



Function

- Move bar pulling chuck GF onto the workpiece with the turret in Z-axis.
- The bar pulling chuck is clamping self acting via spring pre-loading.
- Open collet chuck.
- Move turret to position workpiece.
- Close collet chuck.
- Remove bar pulling chuck GF in Z-axis.

Main dimensions and technical data

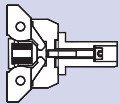


Subject to technical changes.
For more detailed information please ask for customer drawing.

Chuck type	A	B	C	D	E	F	G	H	J	K	L	Stroke per jaw	Gripping force (daN)
GF 80	80	50	60	35	42	21.5	35	M8	20	10	8	4	250
Mounting shank	M	N	O	P	Q	R	S	T	U	V			
ZV 20	18	47	35	32	20								
ZV 30	27	63	55	48	30								
ZV 40	36	71	63	48	40								
ZV 50	45	86	78	58	50								
ZK 30						26	63	55	48	30			
ZK 40						35	71	63	48	40			
ZK 50						44	86	78	58	50			

Ordering review bar pulling chuck GF 80

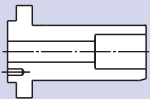
Standard supply range: Bar pulling chuck GF 80 with/without shank, mounting bolts, without jaws



Type	GF 80	GF 80-ZV 20	GF 80-ZV 30	GF 80-ZV 40	GF 80-ZV 50	GF 80-ZK 30	GF 80-ZK 40	GF 80-ZK 50
Shank	without shank	ZV 20	ZV 30	ZV 40	ZV 50	ZK 30	ZK 40	ZK 50
Id. No.	010903	089614	089615	089616	089617	089618	089619	089620

Separate mounting shanks ZV/ZK

Mounting shanks type ZV DIN 69880 (serrated) / mounting shanks type ZK (with clamping area)



Shank Type	ZV 20	ZV 30	ZV 40	ZV 50	ZK 30	ZK 40	ZK 50
Id. No.	016339	012383	012384	012385	060088	060214	012389

Top jaws type GFB

Standard supply range: 1 set (= 2 pieces) clamping jaws without mounting bolts



Type	GFB 1	GFB 2	GFB 3	GFB 4	GFB 5
Clamping range (mm)	5 - 25	25 - 45	45 - 65	65 - 80	80 - 100
Id. No.	016348	016349	016350	016351	016352

