



THINK DIFFERENT 
CREATE INNOVATIONS



THE COMPANY

SINCE 1952

For more than 70 years Schlenker Spannwerkzeuge GmbH & Co. KG dedicates all its passion and knowhow to the production of high-quality clamping tools.

In the beginning the company focused on the manufacturing of collets for manual as well as CNC lathes. When Dipl. Ing. Josef Meißner took over the company in 1986, he developed the first bar feed collet for loading lathes in close cooperation with loading magazine manufacturers. After the first sliding headstock lathes came to the market, the company expanded its product portfolio with guide bushes. These products are still essential for the company today.

Unimpressed by the first relocations of production by German companies abroad, Schlenker always stayed true to its roots and continued to produce at its home location in Villingen-Schwenningen.

Britta Hoffmann continues this tradition since 2008 as Managing Director in the second generation. The family-owned company is highly regarded by the market as a technological leader for clamping tools and is continuously expanding its business with customer-specific and innovative product solutions.

This success is driven by the company's more than 100 highly qualified and passionate employees, who form the heart of Schlenker.

„Think different, create innovations“
Always on the leading edge to give you added value.

Britta Hoffmann
CEO

WHO WE ARE

WE PRODUCE EVERYTHING 100% OURSELVES!

Since it was founded in 1952 by Hans Schlenker, the Schlenker company has specialized entirely in the manufacture of high-quality clamping tools. Anyone who decides to work with us can rely on a reliable and solution-oriented partner.



100% PRODUCTION DEPTH

Maximum flexibility. Fast and individual. All from a single source.



OEM COMPETENCE

Partnership. Technologically leading. Absolute trust.



FIRST-CLASS QUALITY

Leading Performance. Safety. No compromises.



CUSTOMER PROXIMITY

Close dialogue. Fast solution competence. Innovative strength.



INDIVIDUAL SOLUTIONS

Customized. Perfectly matched. Maximum Performance.



WELCOME TO THE TEAM

We look forward to welcoming you as a partner.



SUSTAINABILITY

Responsible. Digitalization. Resource savings.

OVERVIEW PRODUCT SOLUTIONS

SLIDING HEADSTOCK LATHE



SUB SPINDLE COLLETS



ADJUSTABLE GUIDE BUSHES



SHK BAR FEED COLLETS



HSL ROTATING INSERTS



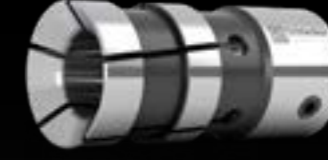
SUB SPINDLE LONG NOSE COLLETS



PROGRAMMABLE GUIDE BUSHES



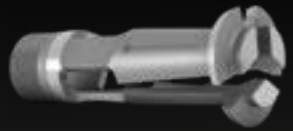
MAIN SPINDLE COLLETS



TURBO BAR FEED COLLETS



TURBO ROTATING INSERTS



MASA TOOL



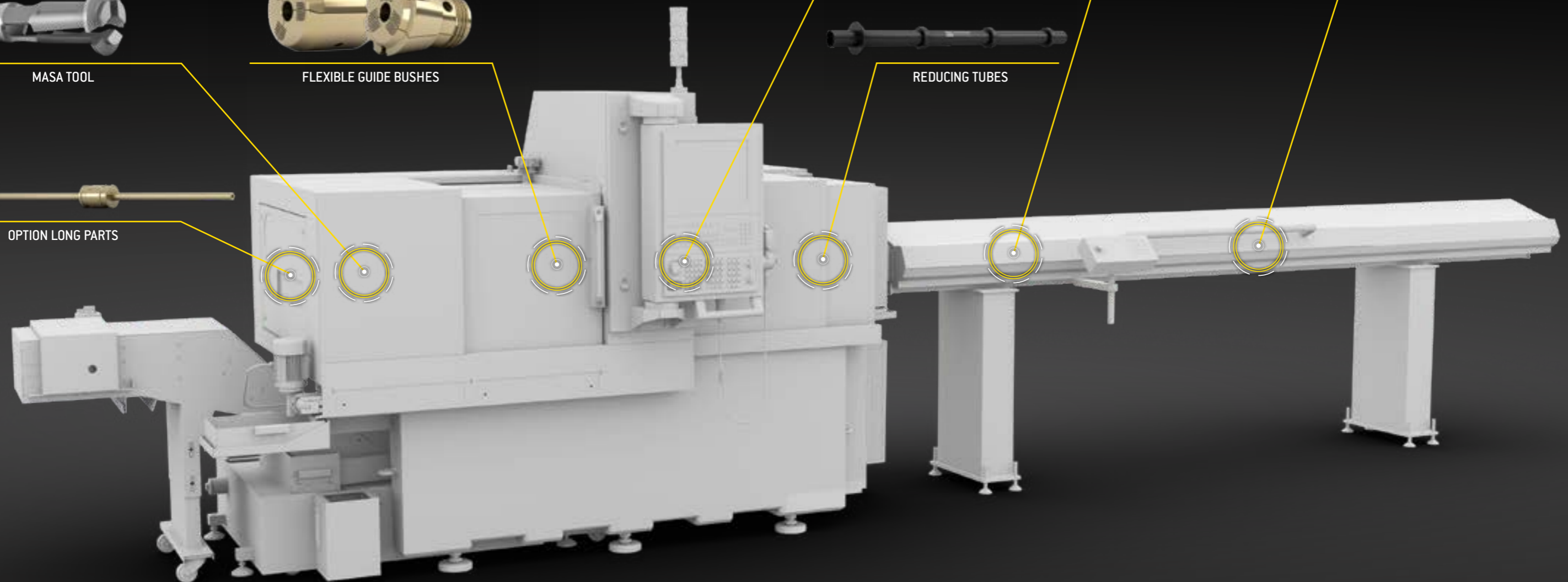
FLEXIBLE GUIDE BUSHES



REDUCING TUBES



OPTION LONG PARTS



OVERVIEW PRODUCT SOLUTIONS

MULTI-SPINDLE



OUTER STOPS



INSIDE CLAMPING SLEEVES INDEX MS



IEMCA ROTATING INSERTS



SHK BAR FEED COLLETS



CLAMPING HEADS / CLAMPING HEADS TOPLUS



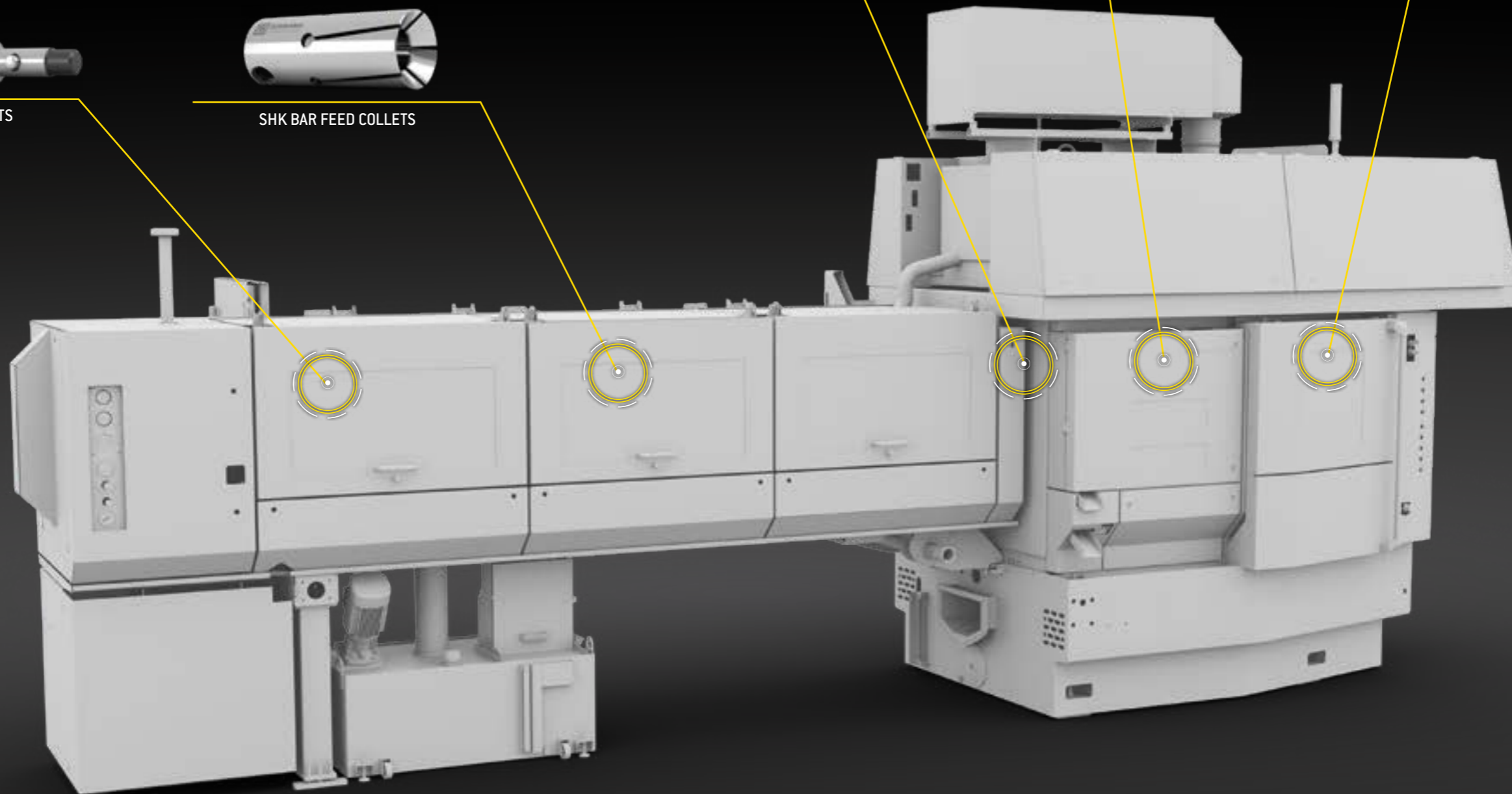
REDUCING TUBES



MULTI-SPINDLE COLLETS MSP



MULTI-SPINDLE COLLETS SSP



OVERVIEW PRODUCT SOLUTIONS

ROTARY TRANSFER



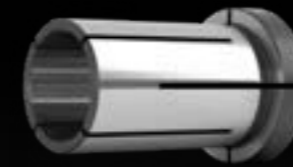
EJECTOR BAR / EJECTOR HEADS



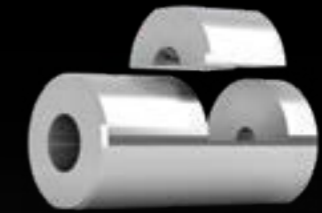
HYDROMAT COLLETS



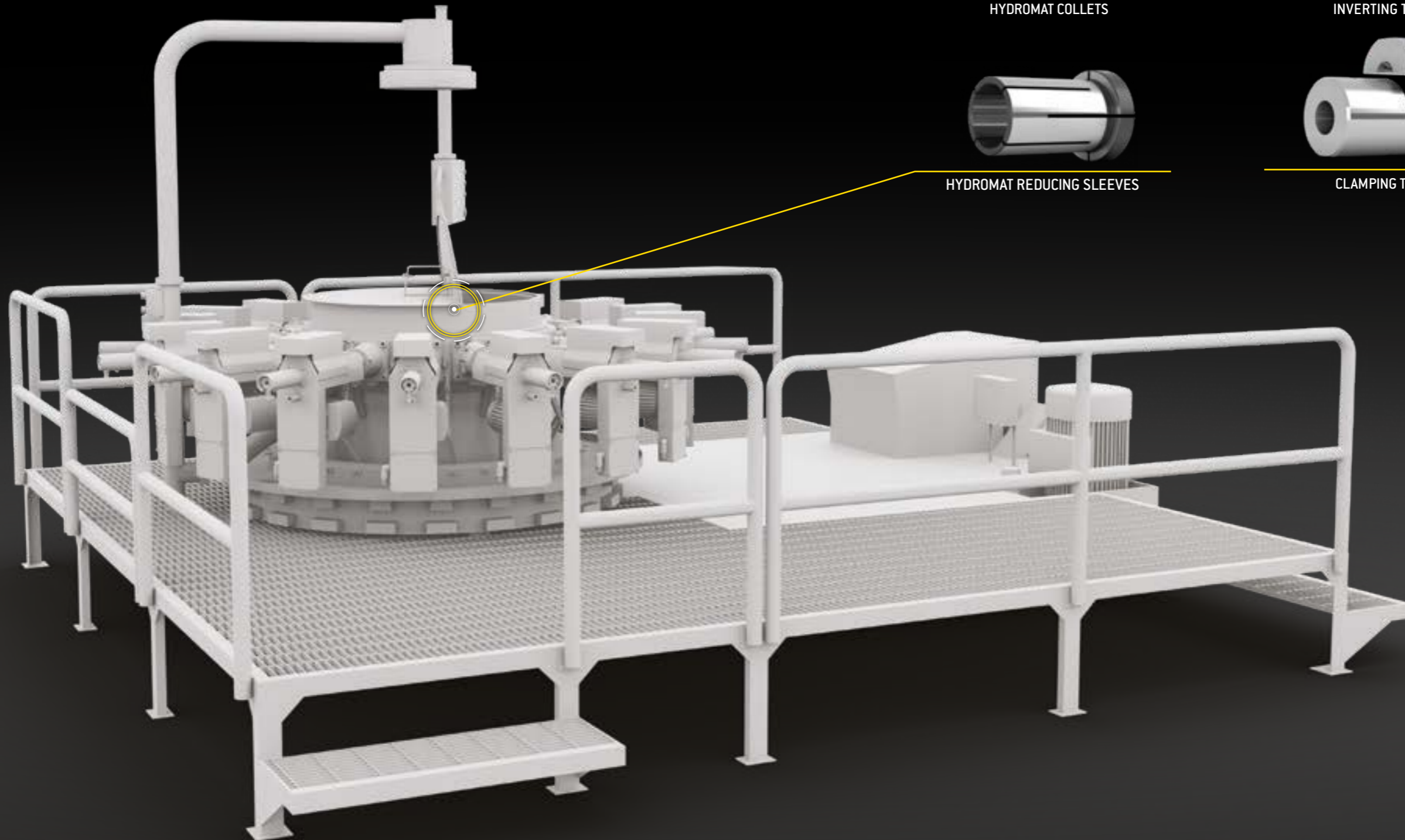
INVERTING TUBES



HYDROMAT REDUCING SLEEVES



CLAMPING TUBES



THINK DIFFERENT CREATE INNOVATIONS



COLLETS

01

MASA TOOL

02

GUIDE BUSHES

03

BAR FEED COLLETS

04

ROTATING INSERTS

05

OTHER SOLUTIONS

06

COLLETS



| | |
|------------------------------------|----|
| Dead Length Collets | 14 |
| Long Nose Collets | 26 |
| Overgrip Collets | 36 |
| Hydromat / Rotary Transfer Collets | 38 |
| Draw-in Collets | 44 |
| Draw-in Collets SW&B | 52 |
| Draw-in Long Nose Collets SW&B | 60 |
| Multi-Spindle Collets | 68 |
| Pick Up Collets | 76 |
| Synchronous Collets | 78 |
| Internal Clamping | 80 |
| Alignment Mandrels | 82 |
| Clamping Heads | 88 |
| ER Collets | 92 |

DEAD LENGTH COLLETS



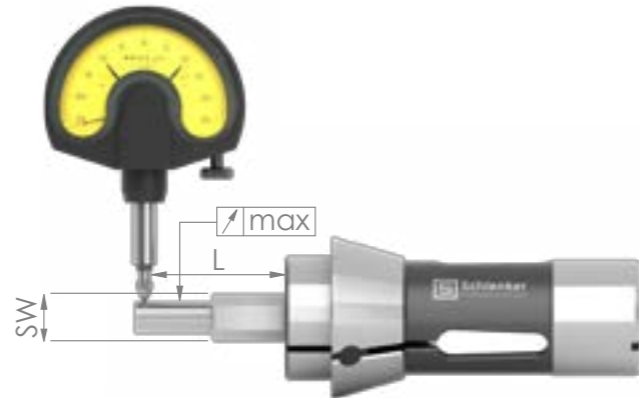
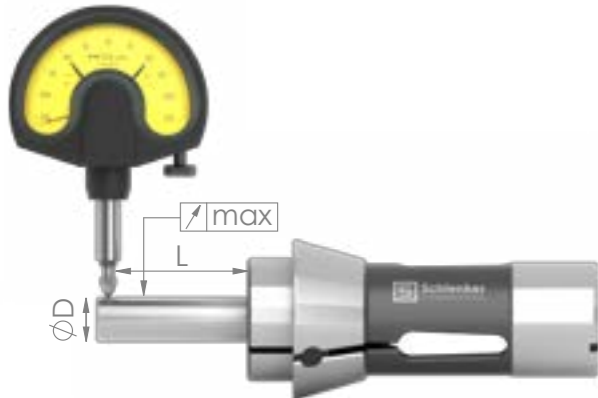
Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

USE OF DEAD LENGTH COLLETS

Dead length collets are used in the main and sub spindle. The collets can be installed in various types of machines, such as turning machines, sliding headstock automatic lathes, multi-spindle machines, conventional lathes, cam-controlled lathes and in special purpose machine constructions.

The collet is clamped via the pressure sleeve, which presses the collet in axial direction against the cap nut.

RUNOUT TOLERANCE



DIAMETER

| ØD | | L | Schlenker norm | |
|------|------|----|----------------|--------|
| from | to | | standard | UP |
| 0.5 | 0.9 | 3 | <0.01 | <0.005 |
| 1.0 | 1.5 | 6 | <0.01 | <0.005 |
| 1.6 | 3.0 | 10 | <0.015 | <0.008 |
| 3.1 | 6.0 | 16 | <0.015 | <0.008 |
| 6.1 | 10.0 | 25 | <0.015 | <0.008 |
| 10.1 | 18.0 | 40 | <0.02 | <0.01 |
| 18.1 | 24.0 | 50 | <0.02 | <0.01 |
| 24.1 | 30.0 | 60 | <0.02 | <0.01 |
| 30.0 | | 80 | <0.03 | <0.015 |

PROFILE

| SW | | L | standard | Schlenker norm | |
|------|------|----|----------|----------------|-------|
| from | to | | | standard | UP |
| 0.5 | 0.9 | 3 | 0.12 | <0.02 | <0.01 |
| 1.0 | 1.5 | 6 | 0.12 | <0.02 | <0.01 |
| 1.6 | 3.0 | 10 | 0.12 | <0.02 | <0.01 |
| 3.1 | 6.0 | 16 | 0.12 | <0.02 | <0.01 |
| 6.1 | 10.0 | 25 | 0.15 | <0.02 | <0.01 |
| 10.1 | 18.0 | 40 | 0.2 | <0.02 | <0.01 |
| 18.1 | 24.0 | 50 | 0.2 | <0.02 | <0.01 |
| 24.1 | 30.0 | 60 | 0.2 | <0.02 | <0.01 |
| 30.0 | | 80 | 0.2 | <0.02 | <0.01 |

DEAD LENGTH COLLET OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- POSITIONING
- ADDITIONAL VERSIONS
- INSERTS

CLAMPING SURFACE DESIGNS



SMOOTH

- Mainly used on the sub spindle
- Collets up to Ø5.9 mm standard smooth, collet type E177 and larger up to Ø8.9 mm standard smooth



GROOVED – STANDARD

- Standard collet
- Mainly used on the main spindle
- Collets from Ø6.0 mm standard grooved, collet type E177 and larger from Ø9.0 mm standard grooved



AXIAL & RADIAL GROOVES

- Higher clamping force compared to the grooved standard collet due to the additional axial grooves



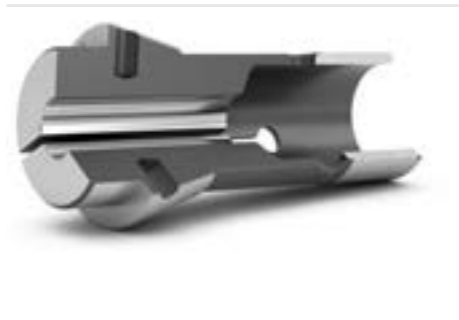

CARBIDE COATING

- Carbide coating possible for all shapes
- Higher coefficient of friction than a standard collet
- Higher clamping force
- Repeated / afterward coating possible







SUPERGRIP

- Highest clamping force at the same clamping pressure of the machine due to very closely spaced axial and radial grooves



| | |
|---|--|
|  | <p>EXTENDED CLAMPING LENGTH</p> <ul style="list-style-type: none"> • Can be used for long workpieces with multiple grooves • Higher wrap around at the workpiece perimeter, therefore more force to clamp • More stable clamping for long workpieces |
|  | <p>SHORTENED CLAMPING LENGTH</p> <ul style="list-style-type: none"> • Application for workpieces whose geometry behind the clamping diameter shouldn't be damaged • Used for short workpieces so the ejector can be lead closer to the clamping diameter |


SHAPES

| | |
|---|--|
|  | <p>SMALL BORE SIZES</p> <ul style="list-style-type: none"> • Available from $\emptyset 0.2 - 0.99$ mm |
|  | <p>SQUARE</p> <ul style="list-style-type: none"> • Square collets are supplied from SW8 with grooves as standard • Collet type E177 and larger are available from SW10 with grooves as standard |
|  | <p>HEXAGON</p> <ul style="list-style-type: none"> • Hexagon collets are supplied from SW8 with grooves as standard • Collet type E177 and larger are available from SW10 with grooves as standard |
|  | <p>SPECIAL PROFILES</p> <ul style="list-style-type: none"> • Various profiles can be realized by ram EDM or wire EDM • Profiles can be adapted individually to the workpiece |

| | |
|--|--|
|  | <p>ECCENTRIC</p> <ul style="list-style-type: none"> • Eccentric bore can be eroded individually according to application • Through hole or offset hole is possible |
|  | <p>SPECIAL CONTOURS</p> <ul style="list-style-type: none"> • Complex contours can be realized by hard milling, hard turning and grinding • Possible with smallest diameters from 0.2 mm |
|  | <p>STEPS</p> <ul style="list-style-type: none"> • Steps are suitable for simultaneous clamping of several diameters of a workpiece • Very high precision as both steps are ground in one step |
|  | <p>INNER CONICAL</p> <ul style="list-style-type: none"> • For gripping conical workpieces • The clamping angle is precisely adapted to the workpiece |

SLOT DESIGNS


| | |
|---|--|
|  | <p>S-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Gentle clamping on the material • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use |
|  | <p>L-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Gentle clamping on the material • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use • Ideal for clamping on short clamping surfaces |

| | |
|--|---|
|  | <p>W-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Gentle clamping on the material • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use |
|  | <p>Z-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Gentle clamping on the material • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use |
|  | <p>THIN SLOTTED</p> <ul style="list-style-type: none"> • More gentle clamping on the material • Prevents the entry of machining chips, as the collet closes almost completely • Recommended for small bore sizes |



WEAR REDUCTION








| | |
|---|--|
|  | <p>CARBIDE INSERT</p> <ul style="list-style-type: none"> • High wear resistance • Prevents pressure marks on the workpiece • Higher service life |
|  | <p>BL COATING</p> <ul style="list-style-type: none"> • Smooth surface • Fewer clamping marks on the material • Especially suitable for material with poor gliding properties • Prevents the welding of the material in the collet |
|  | <p>PREMIUM BLUE COATING</p> <ul style="list-style-type: none"> • Economical alternative to collets with carbide insert • High wear resistance • Can also be used for special shapes • Are completely coated on the functional surfaces like cone and shaft therefore more durable |

POSITIONING

| | |
|---|--|
|  | <p>SLOT IN CONE</p> <ul style="list-style-type: none"> • Slot is placed in the cone of the collet • Used to position the collet in the machine for special as well as square and hexagon shapes |
|  | <p>SLOT IN SHAFT</p> <ul style="list-style-type: none"> • Slot is placed in the shaft of the collet • Used to position the collet in the machine for special as well as square and hexagon shapes |
|  | <p>SLOT IN FRONT-SURFACE</p> <ul style="list-style-type: none"> • Slot is placed in the front-surface of the collet • Used to position the collet in the machine for special as well as square and hexagon shapes |
|  | <p>ALIGNMENT SURFACE</p> <ul style="list-style-type: none"> • The alignment surface on the collet is used to position complex profiles and special contours • Is only producible in combination with a slot |

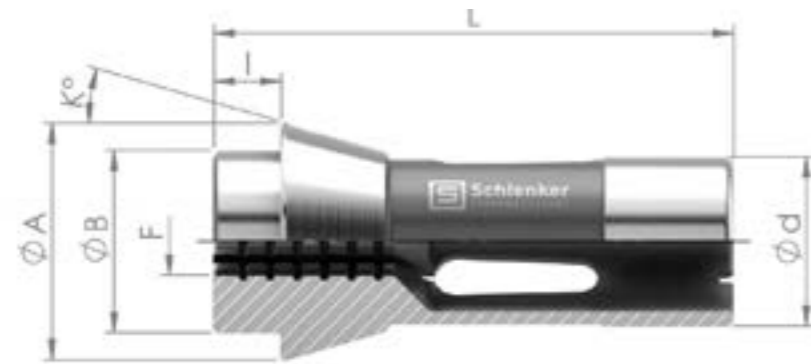
ADDITIONAL VERSIONS

| | |
|---|---|
|  | <p>EMERGENCY COLLET SOFT DESIGN</p> <ul style="list-style-type: none"> • Is not hardened • Clamping diameter can be turned out by the user himself • Used for the production of prototypes, samples and one-off productions |
|  | <p>EMERGENCY COLLET HARDENED & TEMPERED HEAD</p> <ul style="list-style-type: none"> • Is hardened, slotted and widened • Head is tempered so clamping bore can still be turned out by the user himself • Suitable for workpiece clamping in small to medium series production |

| | |
|--|--|
|  | <p>INTERNAL STOP</p> <ul style="list-style-type: none"> • Suitable for manual loading of the machine at a certain length • Prevents the displacement of the workpiece at high axial forces • Used to stabilize the workpiece when the clamping length is too short |
|  | <p>INSERT AID</p> <ul style="list-style-type: none"> • Is inserted in main spindle collets • Is mainly used for small diameters • Minimizes vibrations as the bar material is supported along its total length |
|  | <p>BUSH</p> <ul style="list-style-type: none"> • Is inserted in main spindle collets • An alternative to the insert aid • Is mainly used for small to medium diameters • Absorbs the vibrations of the bar material, supports it at the back and keeps it axially aligned |
|  | <p>SUPPORTING BUSH</p> <ul style="list-style-type: none"> • Is inserted in sub spindle collets • Minimizes vibrations as the bar material is supported along its total length and keeps it axially aligned • Ejection is made possible in a process-safe way |
|  | <p>EJECTOR & INNER COOLING</p> <ul style="list-style-type: none"> • Mechanical ejection of the workpieces • If required internal cooling of components can be integrated • For flushing the clamping surface • Simple change of the ejector within one collet type possible |
|  | <p>UP VERSION</p> <ul style="list-style-type: none"> • High precision |
|  | <p>UUP VERSION</p> <ul style="list-style-type: none"> • Highest precision |

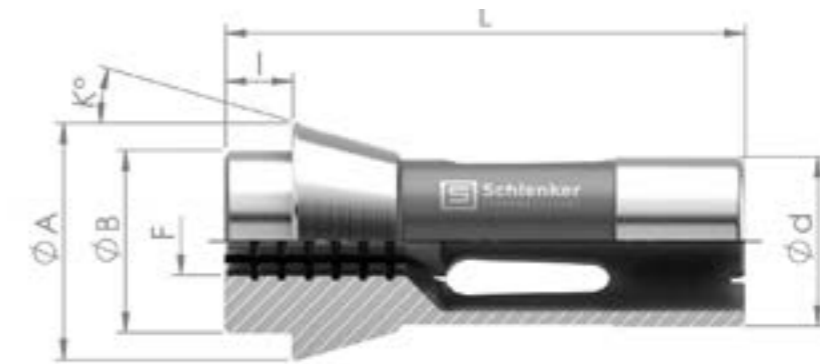
| | |
|---|--|
|  | <p>SEALED</p> <ul style="list-style-type: none"> • Prevents the entry of machining chips • The whole slot area can be sealed • Resealing possible • Not usable with high pressure flushing in the machine |
| <p>INSERTS</p> | |
|  | <p>PEEK / PLASTIC INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>ALUMINUM INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>BRASS INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>BRONZE INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>PERMAGLIS INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>INSERTS FOR SELF-TURNING</p> <ul style="list-style-type: none"> • Clamping diameter can be turned out by the user himself • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |

DEAD LENGTH COLLETS



d Shaft-Ø A Head-Ø B Nose-Ø I Nose length L Total length K Taper angle F Shape

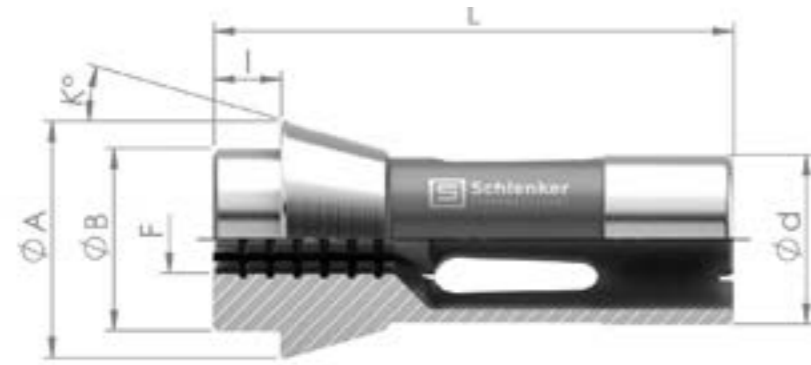
| Article | Ø d [mm] | Ø A [mm] | Ø B [mm] | I [mm] | L [mm] | K [degree] | F min. – max. [mm] | | |
|------------------------|----------|----------|----------|--------|--------|------------|--------------------|------------|------------|
| | | | | | | | ● | ■ | ⬡ |
| E101 F8-577 TF8 | 8 | 12 | 8 | 4.5 | 42 | 16 | 0.5 – 5.0 | 1.0 – 3.5 | 1.0 – 4.5 |
| E109 F10 TF10 | 10 | 16 | 10 | 5.5 | 47.5 | 20 | 0.5 – 7.0 | 1.0 – 5.0 | 1.0 – 6.5 |
| E112 | 11 | 19 | 12 | 6 | 41 | 22 | 0.5 – 7.0 | 1.0 – 5.0 | 1.0 – 6.5 |
| E116 F13 | 13 | 19 | 13 | 6 | 64 | 16 | 0.5 – 9.5 | 2.0 – 7.0 | 2.0 – 8.5 |
| E118 | 14 | 19.5 | 15 | 6 | 46 | 15 | 0.5 – 10.0 | 2.0 – 7.0 | 2.0 – 9.0 |
| E120 F15 TF15 | 15 | 21 | 15 | 6 | 64 | 16 | 0.5 – 12.0 | 2.0 – 8.5 | 2.0 – 10.5 |
| EF16 E1212 TF16 | 16 | 21 | 16 | 6 | 64 | 16 | 0.5 – 12.0 | 2.0 – 8.5 | 2.0 – 10.5 |
| SYF16 M14x0.75 | 16 | 21 | 16 | 8 | 66 | 16 | 0.5 – 12.0 | 2.0 – 8.5 | 2.0 – 10.5 |
| E127 TF18 | 18 | 25 | 18 | 6 | 67 | 16 | 0.5 – 13.0 | 2.0 – 9.5 | 2.0 – 11.5 |
| E136 F20-201 | 20 | 26 | 19 | 5 | 54 | 15 | 0.5 – 16.5 | 2.0 – 12.0 | 2.0 – 14.5 |
| E138 F20-87 TF20 | 20 | 28 | 21 | 7 | 67 | 16 | 0.5 – 16.0 | 2.0 – 11.5 | 2.0 – 14.0 |
| E140 F22 TF22 | 22 | 30 | 21 | 6 | 55 | 15 | 0.5 – 16.5 | 2.0 – 12.0 | 2.0 – 14.5 |



d Shaft-Ø A Head-Ø B Nose-Ø I Nose length L Total length K Taper angle F Shape

| Article | Ø d [mm] | Ø A [mm] | Ø B [mm] | I [mm] | L [mm] | K [degree] | F min. – max. [mm] | | |
|-----------------------|----------|----------|----------|--------|--------|------------|--------------------|------------|------------|
| | | | | | | | ● | ■ | ⬡ |
| TF24 | 23.8 | 28 | 22 | 7 | 62 | 15 | 0.5 – 18.5 | 2.0 – 13.0 | 2.0 – 16.0 |
| E144 | 25 | 34 | 25 | 6 | 65 | 15 | 0.5 – 20.0 | 2.0 – 14.5 | 2.0 – 17.0 |
| E145 F25 TF25 | 25 | 35 | 27 | 10 | 77 | 16 | 0.5 – 20.0 | 2.0 – 14.5 | 2.0 – 17.5 |
| E147 F27-22 | 27 | 38 | 30 | 8 | 72.7 | 15 | 0.5 – 23.0 | 2.0 – 16.0 | 2.0 – 20.0 |
| E148 F28 | 28 | 38 | 28 | 7 | 70 | 15 | 0.5 – 23.0 | 2.0 – 16.0 | 2.0 – 20.0 |
| BS20 | 28 | 35 | 27 | 10 | 77 | 16 | 0.5 – 23.0 | 2.0 – 16.0 | 2.0 – 20.0 |
| E157 F30 TF30 | 30 | 42 | 34 | 10 | 80 | 16 | 0.5 – 25.0 | 2.0 – 18.0 | 2.0 – 22.0 |
| EF30 E1446 | 30 | 38 | 32 | 6 | 65 | 15 | 0.5 – 26.0 | 2.0 – 18.5 | 2.0 – 22.5 |
| E161 F32 | 32 | 45 | 34 | 8 | 75 | 15 | 1.0 – 25.5 | 2.0 – 18.0 | 2.0 – 22.5 |
| O166 | 32 | 40 | 34 | 6 | 65 | 15 | 1.0 – 28.0 | 2.0 – 20.0 | 2.0 – 24.5 |
| E162 | 35 | 43 | 34 | 7 | 70 | 15 | 1.0 – 29.5 | 2.0 – 21.0 | 2.0 – 25.5 |
| E163 F35 | 35 | 48 | 38 | 8 | 80 | 15 | 1.0 – 30.5 | 2.0 – 21.5 | 2.0 – 25.5 |
| EF37 E1536 TF37 | 37 | 47 | 40 | 10 | 92 | 16 | 1.0 – 32.0 | 2.0 – 22.5 | 2.0 – 27.0 |

DEAD LENGTH COLLETS



d Shaft-Ø A Head-Ø B Nose-Ø I Nose length L Total length K Taper angle F Shape

| Article | Ø d [mm] | Ø A [mm] | Ø B [mm] | I [mm] | L [mm] | K [degree] | F min. – max. [mm] | | |
|---------------------|-------------|-------------|-------------|-----------|-----------|---------------|-----------------------|-------------|-------------|
| | | | | | | | ● | ■ | ⬡ |
| EF38 E164 | 38.08 | 49 | 38 | 9.5 | 108 | 15 | 1.0 – 32.0 | 2.0 – 22.5 | 2.0 – 28.0 |
| EF40 | 40 | 47 | 40 | 10 | 92 | 16 | 1.0 – 36.0 | 2.0 – 25.5 | 2.0 – 31.5 |
| E171 F42 | 42 | 55 | 42 | 9 | 94 | 15 | 1.0 – 37.0 | 4.0 – 26.5 | 4.0 – 32.0 |
| TF43 | 43 | 53 | 46 | 10 | 92 | 16 | 1.0 – 39.0 | 4.0 – 27.5 | 4.0 – 33.5 |
| TF44 | 44 | 52 | 44 | 10 | 92 | 16 | 1.0 – 38.0 | 4.0 – 27.0 | 4.0 – 33.0 |
| E173 F48 | 48 | 60 | 50 | 9 | 94 | 15 | 1.0 – 42.0 | 4.0 – 30.0 | 4.0 – 36.5 |
| TF48 | 48 | 60 | 50 | 9 | 94 | 15 | 1.0 – 42.0 | 4.0 – 30.0 | 4.0 – 36.5 |
| BS38 | 48 | 54 | 44 | 10 | 100 | 15 | 1.0 – 40.0 | 4.0 – 28.0 | 4.0 – 34.5 |
| E177 F58 | 58 | 70 | 60 | 9 | 94 | 15 | 3.0 – 52.0 | 4.0 – 37.0 | 4.0 – 45.0 |
| E185 F66 | 66 | 84 | 73 | 9 | 110 | 15 | 3.0 – 60.0 | 5.0 – 42.5 | 5.0 – 52.0 |
| E185 - short F66 | | 85 | 73 | 9 | 40 | 15 | 61.0 – 65.0 | | |
| E190 F88 | 88 | 106 | 94 | 10 | 115 | 15 | 60.0 – 80.0 | 20.0 – 56.0 | 20.0 – 69.0 |
| E193 F90 | 90 | 107 | 92 | 12.5 | 130 | 15 | PR | PR | PR |

i DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

CORRECT CLAMPING

EASY EXPLAINED

With the following examples, we would like to explain you how to get optimum clamping results and what should be prevented when clamping the workpieces.



Visualization of a form-fit and cylindrical clamping

If you want to clamp for example a workpiece with $\varnothing 10.0$ mm, you should use a collet with $\varnothing 10.0$ mm so the workpiece can be clamped form-fit and cylindrically as shown in our illustration.



Visualization of a punctual ring clamping in the front area of the clamping surface

In case that your workpiece has a smaller diameter than the collet, as in our example $\varnothing 9.9$ mm, a punctual ring clamping occurs in the front area of the clamping surface. This means that form-fitting and cylindrical clamping is not possible. The resulting consequences would be process uncertainties, errors in runout, tumbling or variations in the length of your workpiece.



Visualization of a punctual ring clamping in the rear area of the clamping surface

If the workpiece has a $\varnothing 10.1$ mm, the collet cannot close into its initial geometry. This results a punctual ring clamping in the rear area of the clamping surface. The consequences would also be process uncertainties, errors in runout, tumbling or variations in the length of the workpiece.

It is also important to avoid unloaded clamping of collets, as this shortens the service life of the collet enormously. Furthermore, incorrect clamping can cause damage to the collet or the workpiece.

LONG NOSE COLLETS



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

USE OF LONG NOSE COLLETS

Long nose collets are used in the sub spindle for gripping the workpiece. To prevent the long nose collets from breaking during short clamping, they are supplied with a reinforced spring area.

COLLETS WITH THREE-DIMENSIONAL PROFILES AND CONTOURS

Being 100% vertically integrated we are able to manufacture collets with complex contours by hard milling, hard turning and grinding while also complex profiles can be realized utilizing our EDM and wire EDM capabilities which for example allow us to produce collets for the easy and efficient manufacturing of dental implants (abutments) with three-dimensional contours.



Collet for dental implants with 3D profile

Workpiece e.g. abutment

LONG NOSE COLLET OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- POSITIONING
- ADDITIONAL VERSIONS
- INSERTS

CLAMPING SURFACE DESIGNS



SMOOTH – STANDARD

- Standard long nose collet
- Mainly used on the sub spindle



GROOVED

- Mainly used on the sub spindle
- With additional grooves



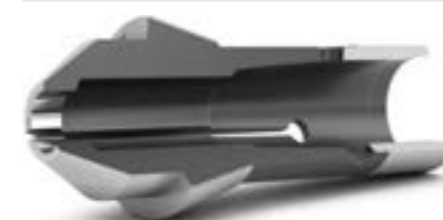
CARBIDE COATING

- Carbide coating possible for all shapes
- Higher coefficient of friction than a standard collet
- Higher clamping force
- Repeated / afterward coating possible



EXTENDED CLAMPING LENGTH

- Can be used for long workpieces with multiple grooves
- Higher wrap around at the workpiece perimeter, therefore more force to clamp
- More stable clamping for long workpieces



SHORTENED CLAMPING LENGTH

- Application for workpieces whose geometry behind the clamping diameter shouldn't be damaged
- Used for short workpieces so the ejector can be lead closer to the clamping diameter

SHAPES



SMALL BORE SIZES

- Available from $\emptyset 0.2 - 0.99$ mm



SQUARE

- Suitable for clamping square material



HEXAGON

- Suitable for clamping hexagon material



SPECIAL PROFILES

- Various profiles can be realized by ram EDM or wire EDM
- Profiles can be adapted individually to the workpiece



ECCENTRIC

- Eccentric bore can be eroded individually according to application
- Through hole or offset hole is possible



SPECIAL CONTOURS

- Complex contours can be realized by hard milling, hard turning and grinding
- Already possible with smallest diameters from 0.2 mm



STEPS

- Steps are suitable for simultaneous clamping of several diameters of a workpiece
- Very high precision as both steps are ground in one step



INNER CONICAL

- For gripping conical workpieces
- The taper angle of the collet is precisely adapted to the workpiece

SLOT DESIGNS



S-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use



L-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use
- Ideal for clamping on short clamping surfaces



W-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use



Z-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use



THIN SLOTTED

- Clamping with virtually no clamping marks
- Prevents the entry of machining chips, as the collet closes almost completely
- Recommended for small bore sizes

WEAR REDUCTION



CARBIDE INSERT

- High wear resistance
- Prevents pressure marks on the workpiece
- Higher service life



BL COATING

- Smooth surface
- Fewer clamping marks on the material
- Especially suitable for material with poor gliding properties
- Prevents the welding of the material in the collet



PREMIUM BLUE COATING

- Economical alternative to collets with carbide insert
- High wear resistance
- Can also be used for special shapes
- Are completely coated on the functional surfaces like cone and shaft therefore more durable

POSITIONING



SLOT IN CONE

- Slot is placed in the cone of the collet
- Used to position the collet in the machine for special as well as square and hexagon shapes



SLOT IN SHAFT

- Slot is placed in the shaft of the collet
- Used to position the collet in the machine for special as well as square and hexagon shapes



SLOT IN FRONT-SURFACE

- Slot is placed in the front-surface of the collet
- Used to position the collet in the machine for special as well as square and hexagon shapes



ALIGNMENT SURFACE

- The alignment surface on the collet is used to position complex profiles and special contours
- Is only producible in combination with a slot

ADDITIONAL VERSIONS



INTERNAL STOP

- Suitable for manual loading of the machine at a certain length
- Prevents the displacement of the workpiece at high axial forces
- Used to stabilize the workpiece when the clamping length is too short



BUSH

- Is inserted in sub spindle collets
- Is mainly used for small to medium diameters
- Absorbs the vibrations of the bar material, supports it at the back and keeps it axially aligned



SUPPORTING BUSH




- Is inserted in sub spindle collets
- Minimizes vibrations as the bar material is supported along its total length and keeps it axially aligned
- Ejection is made possible in a process-safe way





EJECTOR & INNER COOLING

- Mechanical ejection of the workpieces
- If required internal cooling of components can be integrated
- For flushing the clamping surface
- Simple change of the ejector within one collet type possible

| | |
|---|--|
|  | <p>UP VERSION</p> <ul style="list-style-type: none"> • High precision |
|  | <p>UUP VERSION</p> <ul style="list-style-type: none"> • Highest precision |
|  | <p>SEALED</p> <ul style="list-style-type: none"> • Prevents the entry of machining chips • The whole slot area can be sealed • Resealing possible • Not usable with high pressure flushing in the machine |

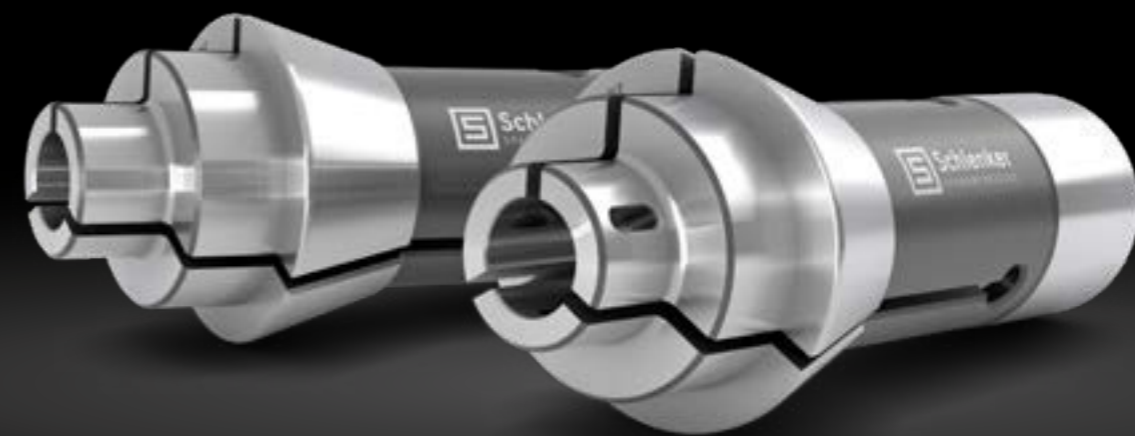
| | |
|---|--|
|  | <p>BRONZE INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>PERMAGLIS INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>INSERTS FOR SELF-TURNING</p> <ul style="list-style-type: none"> • Clamping diameter can be turned out by the user himself • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |

INSERTS

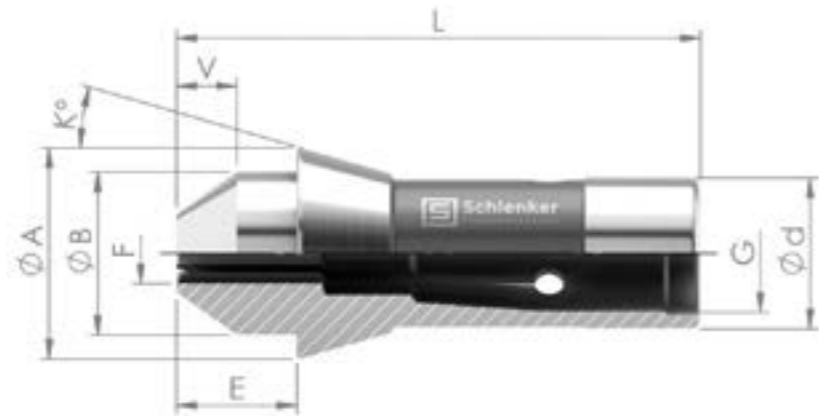
| | |
|---|---|
|  | <p>PEEK / PLASTIC INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>ALUMINIUM INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>BRASS INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |

LONG NOSE COLLETS – OFFSET AND WITH CUTOUTS

- Allows to process the workpiece through the long nose of the collet
- Individual cutouts adapted to the workpiece are possible
- Offset long nose for better accessibility of the tools

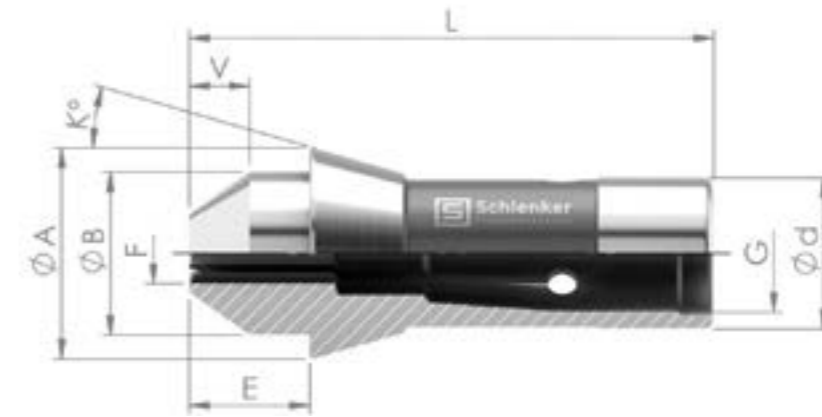


LONG NOSE COLLETS



d Shaft-Ø A Head-Ø B Nose-Ø V Long nose length E Total long nose length
 L Total length K Taper angle G Thread F Shape

| Article | Ø d [mm] | Ø A [mm] | Ø B [mm] | V [mm] | E [mm] | L [mm] | K [degree] | G | F min. – max. |
|-------------------------------|----------|----------|----------|----------|----------|----------|------------|----------|---------------|
| | | | | | | | | | ● |
| E116 VBV F13-2014 | 13 | 19 | 13 | 6 | 12 | 70 | 16 | | 0.5 – 9.5 |
| E116 VBV M11x0.75 | 13 | 19 | 13 | 6 | 12 | 70 | 16 | M11x0.75 | 0.5 – 9.5 |
| E120 VBV F15 | 15 | 21 | 15 | 7 9 | 13 15 | 71 73 | 16 | | 0.5 – 12.0 |
| E120 VBV M12x0.75 | 15 | 21 | 15 | 7 9 | 13 15 | 71 73 | 16 | M12x0.75 | 0.5 – 12.0 |
| EF16 VBV E1212 | 16 | 21 | 16 | 7 9 | 13 15 | 71 73 | 16 | | 0.5 – 12.0 |
| EF16 VBV E1212 M14x0.75 | 16 | 21 | 16 | 7 9 | 12 14 | 70 72 | 16 | M14x0.75 | 0.5 – 12.0 |
| E136 VBV F20 | 20 | 26 | 19 | 8 10 | 13 15 | 62 64 | 15 | | 0.5 – 16.0 |
| E136 VBV M18x1 | 20 | 26 | 19 | 8 10 | 13 15 | 62 64 | 15 | M18x1 | 0.5 – 16.0 |
| E138 VBV F20 | 20 | 28 | 21 | 8 13 | 15 20 | 75 80 | 16 | | 0.5 – 16.0 |
| E138 VBV M17x0.75 | 20 | 28 | 21 | 8 13 | 15 20 | 75 80 | 16 | M17x0.75 | 0.5 – 16.0 |
| E145 VBV F25 | 25 | 35 | 27 | 10 15 | 20 25 | 87 92 | 16 | | 0.5 – 20.0 |



d Shaft-Ø A Head-Ø B Nose-Ø V Long nose length E Total long nose length
 L Total length K Taper angle G Thread F Shape

| Article | Ø d [mm] | Ø A [mm] | Ø B [mm] | V [mm] | E [mm] | L [mm] | K [degree] | G | F min. – max. |
|-------------------------|----------|----------|----------|----------|----------|------------|------------|-------|---------------|
| | | | | | | | | | ● |
| E145 VBV M22x1 | 25 | 35 | 27 | 10 15 | 20 25 | 87 92 | 16 | M22x1 | 0.5 – 20.0 |
| E1446 VBV EF30-101 | 30 | 38 | 32 | 14 | 20 | 79 | 15 | | 1.0 – 26.0 |
| E161 VBV F32-221 | 32 | 45 | 34 | 15 | 23 | 90 | 15 | | 1.0 – 25.0 |
| E163 VBV F35 | 35 | 48 | 38 | 19 | 27 | 99 | 15 | | 1.0 – 30.0 |
| EF37 VBV E1536 | 37 | 47 | 40 | 10 15 | 20 25 | 102 107 | 16 | | 1.0 – 32.0 |
| E164 VBV F38-76-2004 | 38.08 | 49 | 38 | 15 | 24.5 | 123 | 15 | | 1.0 – 32.0 |
| E173 VBV F48-76-2006 | 48 | 60 | 50 | 19 | 28 | 113 | 15 | | 2.0 – 42.0 |

DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

OVERGRIP COLLETS



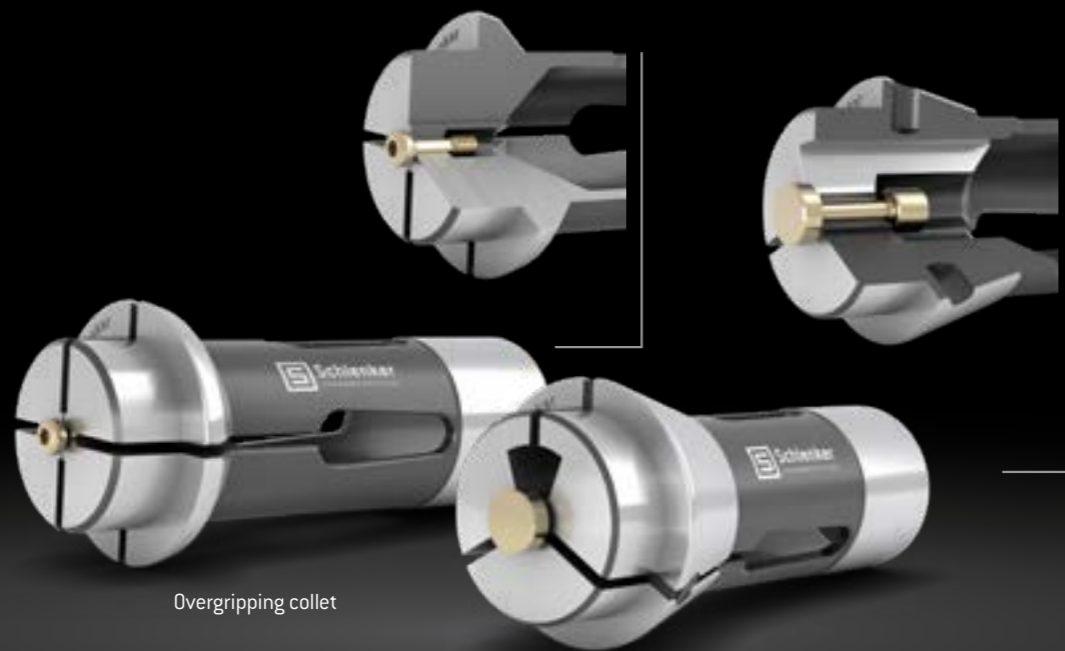
Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF OVERGRIP COLLETS

The overgrip collets are often used in production when the diameter to be clamped is smaller than the diameter to be overgripped. The maximum diameter difference to be overgripped should not be larger than 2.5mm. The decisive factors here are the stroke, the clamping length and the machine type which must be individually adapted to the workpiece.

OVERGRIPPING AND OFFSET GRIPPING COLLETS



Overgripping collet

Offset gripping collet



WATCH NOW THE PRODUCT VIDEO
www.schlenker-spannwerkzeuge.de

OVERGRIP COLLET VERSIONS



OVERGRIPPING 30°

- Taper angle of the collet is adjusted to the respective degree
- Producable with long nose
- Suitable for toggle clamping
- Taper angle of the pressure sleeve must be adapted



OVERGRIPPING 45°

- Taper angle of the collet is adjusted to the respective degree
- Producable with long nose
- Suitable for toggle clamping
- Taper angle of the pressure sleeve must be adapted



OVERGRIPPING 16 / 45°

- Taper angle of the collet is adjusted
- Producable with long nose
- Overgripping of max. 2.5 mm possible
- The clamping stroke of the pressure sleeve should be at least 2.5 mm
- Adaption of the taper angle of the pressure sleeve not required



OFFSET GRIPPING

- Are used if the diameter to be clamped is smaller than the diameter to be overgripped
- X-axis on the sub spindle is required



MASA TOOL MICROCONIC OVERGRIP COLLETS CAN BE FOUND ON PAGES 120 – 145.

HYDROMAT COLLETS



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

USE OF HYDROMAT COLLETS

Hydromat collets are used for workpiece clamping as well as in rotary transfer machines such as Eubama, Hydromat and Pfiffner (FFG). Hydromat collets are available with threaded or quick change version. They can also be supplied with a saw burr cut in the clamping area. Suitable for the Hydromat collets, Hydromat reducing sleeves, ejector bar, ejector sleeves and stop heads can be manufactured.

CLAMPING SURFACE DESIGNS

| | |
|--|--|
| | <p>SMOOTH</p> <ul style="list-style-type: none"> • Standard Hydromat collet |
| | <p>SAW BURR CUT</p> <ul style="list-style-type: none"> • Improved runout, as sawing burr can be reliably picked up in the clearance area |

HYDROMAT COLLET OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- VERSIONS
- ACCESSORIES

SHAPES

| | |
|--|--|
| | <p>SQUARE</p> <ul style="list-style-type: none"> • Suitable for clamping square material |
| | <p>HEXAGON</p> <ul style="list-style-type: none"> • Suitable for clamping hexagon material |
| | <p>SPECIAL PROFILES</p> <ul style="list-style-type: none"> • Various profiles possible • Profiles can be adapted individually to the workpiece |
| | <p>SPECIAL CONTOURS</p> <ul style="list-style-type: none"> • Complex contours can be realized by hard milling, hard turning and grinding • Already possible with smallest diameters from 0.2 mm |

SLOT DESIGNS



S-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use



L-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use
- Ideal for clamping on short clamping surfaces



W-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use



Z-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use



THIN SLOTTED

- Clamping with virtually no clamping marks
- Prevents the entry of machining chips, as the collet closes almost completely
- Recommended for small bore sizes

VERSIONS



QUICK CHANGE VERSION

- The quick change version is screwed into the collet sleeve and locks itself automatically

ACCESSORIES



HYDROMAT REDUCING SLEEVES

- Are inserted in Hydromat collets, this allows to clamp two different diameters with one collet



EJECTOR BAR / EJECTOR HEADS

- Are part of a module for Hydromat collets to eject or stop workpieces

HYDROMAT COLLETS



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

| Article | Ø d [mm] | Ø A [mm] | L [mm] | K [degree] | G | F min. – max. [mm] | | | Step bore |
|----------|----------|----------|--------|------------|-----------------------|--------------------|------------|------------|-----------|
| | | | | | | ● | ■ | ⬡ | |
| SHW20 | 20 | 26.3 | 96.5 | 15 | Ø19.7x1.666 45°/5° | 1.0 – 13.5 | 2.0 – 9.5 | 2.0 – 11.5 | |
| SHW20 | 20 | 26.3 | 96.5 | 15 | Ø19.7x1.666 45°/5° | 13.51 – 20.0 | PR | PR | PR |
| SHW25 | 25 | 33.7 | 97.6 | 15 | Ø24.7x1.693 45°/5° | 3.0 – 17.5 | 3.0 – 12.0 | 3.0 – 15.0 | |
| SHW25 | 25 | 33.7 | 97.6 | 15 | Ø24.7x1.693 45°/5° | 17.51 – 25.0 | PR | PR | PR |
| SHB32 | 32 | 40 | 106 | 15 | Ø29.7x1.693 45°/5° | 3.0 – 23.5 | 3.0 – 16.5 | 3.0 – 20.0 | |
| SHB32 | 32 | 40 | 106 | 15 | Ø29.7x1.693 45°/5° | 23.51 – 28.0 | PR | PR | PR |
| SHB32/45 | 32 | 53 | 122 | 15 | Ø29.7x1.693 45°/5° | 3.0 – 23.5 | 3.0 – 16.5 | 3.0 – 20.0 | |
| SHB32/45 | 32 | 53 | 122 | 15 | Ø29.7x1.693 45°/5° | 23.51 – 41.0 | PR | PR | PR |
| SHB45 | 45 | 53 | 115 | 15 | M42x1.5 | 3.0 – 36.0 | 3.0 – 25.0 | 3.0 – 31.0 | |
| SHB45 | 45 | 53 | 115 | 15 | M42x1.5 | 36.01 – 41.0 | PR | PR | PR |
| SHB45/60 | 45 | 68 | PR | 15 | M42x1.5 | PR | PR | PR | |
| SHB45/60 | 45 | 68 | PR | 15 | M42x1.5 | PR | PR | PR | PR |



d Shaft-Ø A Head-Ø L Total length K Taper angle G Interface F Shape

| Article | Ø d [mm] | Ø A [mm] | L [mm] | K [degree] | G | F min. – max. [mm] | | | Step bore |
|---------|----------|----------|--------|------------|--------------|--------------------|------------|------------|-----------|
| | | | | | | ● | ■ | ⬡ | |
| SHW25QC | 25 | 33.7 | 97.6 | 15 | Quick change | 3.0 – 17.5 | 3.0 – 12.0 | 3.0 – 15.0 | |
| SHW25QC | 25 | 33.7 | 97.6 | 15 | Quick change | 17.51 – 25.0 | PR | PR | PR |
| SHB32QC | 32 | 40 | 106 | 15 | Quick change | 3.0 – 23.5 | 3.0 – 16.5 | 3.0 – 20.0 | |
| SHB32QC | 32 | 40 | 106 | 15 | Quick change | 23.51 – 28.0 | PR | PR | PR |
| SHB45QC | 45 | 53 | 116.5 | 15 | Quick change | 3.0 – 36.0 | 3.0 – 25.0 | 3.0 – 31.0 | |
| SHB45QC | 45 | 53 | 116.5 | 15 | Quick change | 36.01 – 41.0 | PR | PR | PR |

DRAW-IN COLLETS



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

DRAW-IN COLLET OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- ADDITIONAL VERSIONS
- INSERTS
- VERSIONS

USE OF DRAW-IN COLLETS

Draw-in collets are used for workpiece clamping as well as in all common grinding machines, dividing heads and manual turning machines. Clamping is performed by retracting the draw-in collet into the collet sleeve.

CLAMPING SURFACE DESIGNS

| | |
|--|--|
| | <p>SMOOTH – STANDARD</p> <ul style="list-style-type: none"> • Standard draw-in collet |
| | <p>GROOVED</p> <ul style="list-style-type: none"> • With additional grooves |
| | <p>AXIAL & RADIAL GROOVES</p> <ul style="list-style-type: none"> • Higher clamping force compared to the standard grooved collet due to the additional axial grooves |

| | |
|--|--|
| | <p>CARBIDE COATING</p> <ul style="list-style-type: none"> • Carbide coating possible for all shapes • Higher coefficient of friction than a standard collet • Higher clamping force • Repeated / afterward coating possible |
| | <p>SUPERGRIP</p> <ul style="list-style-type: none"> • Highest clamping force at the same clamping pressure of the machine due to very closely spaced axial grooves |
| | <p>EXTENDED CLAMPING LENGTH</p> <ul style="list-style-type: none"> • Can be used for long workpieces with multiple grooves • Higher wrap around at the workpiece perimeter, therefore more force to clamp • More stable clamping for long workpieces |
| | <p>SHORTENED CLAMPING LENGTH</p> <ul style="list-style-type: none"> • Application for workpieces whose geometry behind the clamping diameter shouldn't be damaged • Used for short workpieces so the ejector can be lead closer to the clamping diameter |

SHAPES



SQUARE

- Suitable for clamping square material



HEXAGON

- Suitable for clamping hexagon material



SPECIAL PROFILES

- Various profiles can be realized by ram EDM or wire EDM
- Profiles can be adapted individually to the workpiece



ECCENTRIC

- Eccentric bore can be eroded individually according to application
- Through hole or offset hole is possible



SPECIAL CONTOURS

- Complex contours can be realized by hard milling, hard turning and grinding
- Already possible with smallest diameters from 0.2 mm



STEPS

- Steps are suitable for simultaneous clamping of several diameters of a workpiece
- Very high precision as both steps are ground in one step



INNER CONICAL

- For gripping conical workpieces
- The clamping angle is precisely adapted to the workpiece

SLOT DESIGNS



S-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use



L-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use
- Ideal for clamping on short clamping surfaces




W-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use





Z-SLOT


- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use

| | |
|---|---|
|  | <p>THIN SLOTTED</p> <ul style="list-style-type: none"> • Clamping with virtually no clamping marks • Prevents the entry of machining chips, as the collet closes almost completely • Recommended for small bore sizes |
|---|---|


WEAR REDUCTION

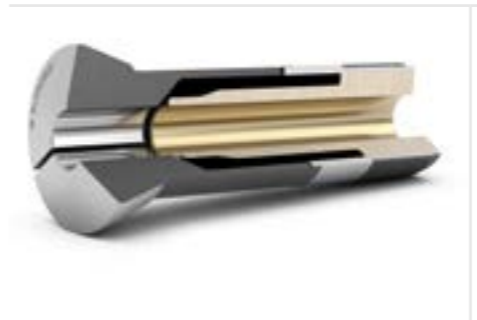
| | |
|---|--|
|  | <p>CARBIDE INSERT</p> <ul style="list-style-type: none"> • High wear resistance • Prevents pressure marks on the workpiece • Higher service life |
|---|--|


| | |
|--|--|
|  | <p>BL COATING</p> <ul style="list-style-type: none"> • Smooth surface • Fewer clamping marks on the material • Especially suitable for material with poor gliding properties • Prevents the welding of the material in the collet |
|--|--|


| | |
|---|--|
|  | <p>PREMIUM BLUE COATING</p> <ul style="list-style-type: none"> • Economical alternative to collets with carbide insert • High wear resistance • Can also be used for special shapes • Are completely coated on the functional surfaces like cone and shaft therefore more durable |
|---|--|

ADDITIONAL VERSIONS


| | |
|---|--|
|  | <p>INTERNAL STOP</p> <ul style="list-style-type: none"> • Suitable for manual loading of the machine at a certain length • Prevents the displacement of the workpiece at high axial forces • Used to stabilize the workpiece when the clamping length is too short |
|---|--|

| | |
|---|--|
|  | <p>SUPPORTING BUSH</p> <ul style="list-style-type: none"> • Minimizes vibrations as the bar material is supported along its total length and keeps it axially aligned • Ejection is made possible in a process-safe way |
|---|--|

| | |
|---|--|
|  | <p>EJECTOR & INNER COOLING</p> <ul style="list-style-type: none"> • Mechanical ejection of the workpieces • If required internal cooling of components can be integrated • For flushing the clamping surface • Simple change of the ejector within one collet type possible |
|---|--|

| | |
|---|---|
|  | <p>UP VERSION</p> <ul style="list-style-type: none"> • High precision |
|---|---|

| | |
|--|---|
|  | <p>UUP VERSION</p> <ul style="list-style-type: none"> • Highest precision |
|--|---|


| | |
|---|--|
|  | <p>SEALED</p> <ul style="list-style-type: none"> • Prevents the entry of machining chips • The whole slot area can be sealed • Resealing possible • Not usable with high pressure flushing in the machine |
|---|--|

INSERTS

| | |
|---|---|
|  | <p>PEEK / PLASTIC INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|---|---|

| | |
|---|--|
|  | <p>ALUMINIUM INSERTS</p> <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>BRASS INSERTS</p> <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>BRONZE INSERTS</p> <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>PERMAGLIS INSERTS</p> <ul style="list-style-type: none"> Prevents pressure marks on the workpiece Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>INSERTS FOR SELF-TURNING</p> <ul style="list-style-type: none"> Clamping diameter can be turned out by the user himself Inserts are replaceable when worn Ideal for scratch-sensitive materials, as well as for gentle gripping |

VERSIONS

| | |
|---|--|
|  | <p>LONG NOSE</p> <ul style="list-style-type: none"> Are used for workpiece clamping Better accessibility to the workpiece |
|---|--|

DRAW-IN COLLETS



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

| Article | Ø d [mm] | Ø A [mm] | L [mm] | K [degree] | G | F min. – max. [mm] | | |
|---------|----------|----------|--------|------------|---|--------------------|------------|------------|
| | | | | | | ● | ■ | ⬡ |
| E324 | 15 | 21.5 | 53 | 20 | M13x1 | 1.0 – 9.0 | 2.0 – 6.5 | 2.0 – 8.0 |
| E3409 | 20 | 28 | 90 | 8 | Tr.20x1.5 | 2.0 – 14.5 | PR | PR |
| E351 | 20 | 28 | 80 | 20 | Tr.20x1.5 | 1.0 – 15.0 | 2.0 – 10.5 | 2.0 – 13.0 |
| E358 | 23 | 32 | 81.5 | 20 | M21x1 | 1.0 – 16.5 | 2.0 – 11.0 | 2.0 – 14.5 |
| E359 | 23 | 32 | 89.5 | 20 | Tr.23x1.5 | 1.0 – 18.0 | 2.0 – 12.0 | 2.0 – 16.0 |
| E363 | 25 | 33.5 | 84 | 16 | M23x1 | 1.0 – 17.5 | 2.0 – 12.5 | 2.0 – 15.5 |
| E366 | 28 | 36 | 100 | 18 | Tr.27x1/20" | 1.0 – 21.0 | 2.0 – 15.0 | 2.0 – 18.0 |
| E367 | 28 | 38 | 100 | 20 | Tr.28x1.5 | 1.0 – 22.0 | 2.0 – 15.5 | 2.0 – 19.0 |
| E385 | 31.75 | 37.5 | 83 | 10 | Outside: 31.45x1/20" Inside: 26.44x1.058 | 1.0 – 25.0 | 2.0 – 17.5 | 2.0 – 21.5 |
| E386 | 32 | 45 | 110 | 20 | Tr.32x1.5 | 1.0 – 27.0 | 3.0 – 19.0 | 3.0 – 23.5 |
| E666 | 25 | 35 | 59.5 | 20 | M25x1 | 3.0 – 20.0 | PR | PR |
| K20 | 20 | 28 | 80 | 20 | Tr.20x1.5 | 1.0 – 15.0 | 2.0 – 10.5 | 2.0 – 13.0 |
| K23 | 23 | 32 | 89.5 | 20 | Tr.23x1.5 | 1.0 – 18.0 | 2.0 – 13.0 | 2.0 – 16.0 |
| K32 | 32 | 45 | 110 | 20 | Tr.32x1.5 | 1.0 – 27.0 | 4.0 – 19.0 | 3.0 – 23.5 |
| K45 | 45 | 60 | 140 | 20 | Tr.45x2 | 5.0 – 36.5 | 5.0 – 26.0 | 5.0 – 32.0 |
| KDT38 | 58 | 70.3 | 99 | 15 | M50x1.5 | 10.0 – 38.0 | 8.0 – 26.0 | 8.0 – 32.0 |



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

DRAW-IN COLLETS SW&B



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

USE OF DRAW-IN COLLETS SW&B

Draw-in collets are used for workpiece clamping as well as in all common grinding machines, dividing heads and manual turning machines. Clamping is performed by retracting the draw-in collet into the collet sleeve.

CLAMPING SURFACE DESIGNS

| | |
|--|--|
| | <p>SMOOTH – STANDARD</p> <ul style="list-style-type: none"> • Standard draw-in collet |
| | <p>GROOVED</p> <ul style="list-style-type: none"> • With additional grooves |
| | <p>AXIAL & RADIAL GROOVES</p> <ul style="list-style-type: none"> • Higher clamping force compared to the grooved standard collet due to the additional axial grooves |
| | <p>CARBIDE COATING</p> <ul style="list-style-type: none"> • Carbide coating possible for all shapes • Higher coefficient of friction than a standard collet • Higher clamping force • Repeated / afterward coating possible |

DRAW-IN COLLET SW&B OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- ADDITIONAL VERSIONS
- INSERTS


| | |
|--|--|
| | <p>SUPERGRIP</p> <ul style="list-style-type: none"> • Highest clamping force at the same clamping pressure of the machine due to very closely spaced axial grooves |
| | <p>EXTENDED CLAMPING LENGTH</p> <ul style="list-style-type: none"> • Can be used for long workpieces with multiple grooves • Higher wrap around at the workpiece perimeter, therefore more force to clamp • More stable clamping for long workpieces |
| | <p>SHORTENED CLAMPING LENGTH</p> <ul style="list-style-type: none"> • Application for workpieces whose geometry behind the clamping diameter shouldn't be damaged • Used for short workpieces so the ejector can be lead closer to the clamping diameter |





SHAPES

| | |
|--|--|
| | <p>SQUARE</p> <ul style="list-style-type: none"> • Suitable for clamping square material |
| | <p>HEXAGON</p> <ul style="list-style-type: none"> • Suitable for clamping hexagon material |



| | |
|---|--|
|  | <p>SPECIAL PROFILES</p> <ul style="list-style-type: none"> • Various profiles can be realized by ram EDM or wire EDM • Profiles can be adapted individually to the workpiece |
|  | <p>ECCENTRIC</p> <ul style="list-style-type: none"> • Eccentric bore can be eroded individually according to application • Through hole or offset hole is possible |
|  | <p>SPECIAL CONTOURS</p> <ul style="list-style-type: none"> • Complex contours can be realized by hard milling, hard turning and grinding • Already possible with smallest diameters from 0.2 mm |
|  | <p>STEPS</p> <ul style="list-style-type: none"> • Steps are suitable for simultaneous clamping of several diameters of a workpiece • Very high precision as both steps are ground in one step |
|  | <p>INNER CONICAL</p> <ul style="list-style-type: none"> • For gripping conical workpieces • The taper angle of the collet is precisely adapted to the workpiece |

SLOT DESIGNS

| | |
|---|---|
|  | <p>S-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use |
|---|---|


| | |
|---|--|
|  | <p>L-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use • Ideal for clamping on short clamping surfaces |
|  | <p>W-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use |
|  | <p>Z-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use |
|  | <p>THIN SLOTTED</p> <ul style="list-style-type: none"> • Clamping with virtually no clamping marks • Prevents the entry of machining chips, as the collet closes almost completely • Recommended for small bore sizes |


WEAR REDUCTION


| | |
|---|--|
|  | <p>CARBIDE INSERT</p> <ul style="list-style-type: none"> • High wear resistance • Prevents pressure marks on the workpiece • Higher service life |
|  | <p>BL COATING</p> <ul style="list-style-type: none"> • Smooth surface • Fewer clamping marks on the material • Especially suitable for material with poor gliding properties • Prevents the welding of the material in the collet |


| | |
|---|--|
|  | <p>PREMIUM BLUE COATING</p> <ul style="list-style-type: none"> • Economical alternative to collets with carbide insert • High wear resistance • Can also be used for special shapes • Are completely coated on the functional surfaces like cone and shaft therefore more durable |
|---|--|

ADDITIONAL VERSIONS


| | |
|---|--|
|  | <p>INTERNAL STOP</p> <ul style="list-style-type: none"> • Suitable for manual loading of the machine at a certain length • Prevents the displacement of the workpiece at high axial forces • Used to stabilize the workpiece when the clamping length is too short |
|---|--|

| | |
|--|--|
|  | <p>SUPPORTING BUSH</p> <ul style="list-style-type: none"> • Minimizes vibrations as the bar material is supported along its total length and keeps it axially aligned • Ejection is made possible in a process-safe way |
|--|--|

| | |
|---|--|
|  | <p>EJECTOR & INNER COOLING</p> <ul style="list-style-type: none"> • Mechanical ejection of the workpieces • If required internal cooling of components can be integrated • For flushing the clamping surface • Simple change of the ejector within one collet type possible |
|---|--|


| | |
|---|---|
|  | <p>UP VERSION</p> <ul style="list-style-type: none"> • High precision |
|---|---|


| | |
|---|---|
|  | <p>UUP VERSION</p> <ul style="list-style-type: none"> • Highest precision |
|---|---|


| | |
|---|--|
|  | <p>SEALED</p> <ul style="list-style-type: none"> • Prevents the entry of machining chips • The whole slot area can be sealed • Resealing possible • Not usable with high pressure flushing in the machine |
|---|--|


INSERTS


| | |
|---|---|
|  | <p>PEEK / PLASTIC INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|---|---|

| | |
|--|--|
|  | <p>ALUMINIUM INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|--|--|

| | |
|---|--|
|  | <p>BRASS INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|---|--|

| | |
|---|---|
|  | <p>BRONZE INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|---|---|

| | |
|---|--|
|  | <p>PERMAGLIS INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|---|--|

| | |
|---|--|
|  | <p>INSERTS FOR SELF-TURNING</p> <ul style="list-style-type: none"> • Clamping diameter can be turned out by the user himself • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|---|--|

DRAW-IN COLLETS SW&B



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

| Article | Ø d [mm] | Ø A [mm] | L [mm] | K [degree] | G | F min. – max. [mm] | | | Step bore |
|----------------------|----------|----------|--------|------------|-----------------------|--------------------|------------|------------|-----------|
| | | | | | | ● | ■ | ⬡ | |
| SW12 80-2 E318 | 12 | 16 | 46 | 15 | Ø11.75x1.25 45°/5° | 0.5 – 8.0 | PR | PR | |
| SW12 80-2 E318 | 12 | 16 | 46 | 15 | Ø11.75x1.25 45°/5° | 8.01 – 12.5 | PR | PR | PR |
| SW15 80-3 E321 | 15 | 20.2 | 58.3 | 15 | Ø14.75x1.25 45°/5° | 0.5 – 10.5 | PR | PR | |
| SW15 80-3 E321 | 15 | 20.2 | 58.3 | 15 | Ø14.75x1.25 45°/5° | 10.51 – 16.0 | PR | PR | PR |
| SW20 80-4 E349 | 20 | 26.3 | 73 | 15 | Ø19.7x1.666 45°/5° | 0.5 – 14.5 | 2.0 – 10.0 | 2.0 – 12.0 | |
| SW20 80-4 E349 | 20 | 26.3 | 73 | 15 | Ø19.7x1.666 45°/5° | 14.51 – 23.0 | PR | PR | PR |
| SW25 80-5 E364 | 25 | 33.7 | 97.6 | 15 | Ø24.7x1.693 45°/5° | 0.5 – 18.0 | 2.0 – 12.5 | 2.0 – 15.5 | |
| SW25 80-5 E364 | 25 | 33.7 | 97.6 | 15 | Ø24.7x1.693 45°/5° | 18.1 – 29.0 | PR | PR | PR |
| B32 72-65 | 32 | 40 | 106 | 15 | Ø29.7x1.693 45°/5° | 1.0 – 24.0 | 3.0 – 16.5 | 3.0 – 20.5 | |
| B32 72-65 | 32 | 40 | 106 | 15 | Ø29.7x1.693 45°/5° | 24.01 – 32.0 | PR | PR | PR |



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

| Article | Ø d [mm] | Ø A [mm] | L [mm] | K [degree] | G | F min. – max. [mm] | | | Step bore |
|---------------|----------|----------|--------|------------|---------|--------------------|------------|------------|-----------|
| | | | | | | ● | ■ | ⬡ | |
| B45 72-199 | 45 | 53 | 115 | 15 | M42x1.5 | 5.0 – 36.0 | 5.0 – 25.5 | 5.0 – 31.0 | |
| B45 72-199 | 45 | 53 | 115 | 15 | M42x1.5 | 36.01 – 45.0 | PR | PR | PR |



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

DRAW-IN LONG NOSE COLLETS SW&B



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



DRAW-IN LONG NOSE COLLET SW&B OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- ADDITIONAL VERSIONS
- INSERTS

USE OF DRAW-IN LONG NOSE COLLETS SW&B

Draw-in long nose collets are used for workpiece clamping as well as in all common grinding machines, dividing heads and manual turning machines. The long nose provides better accessibility to the workpiece.

CLAMPING SURFACE DESIGNS



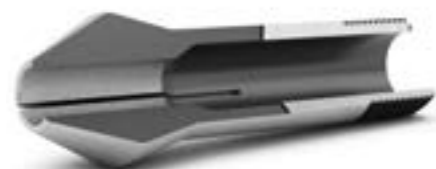
SMOOTH – STANDARD

- Standard draw-in long nose collet



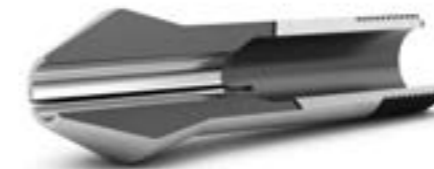
GROOVED

- With additional grooves



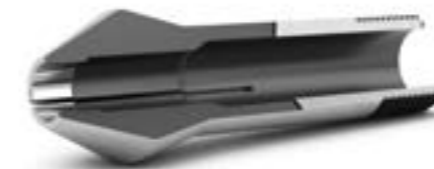
CARBIDE COATING

- Carbide coating possible for all shapes
- Higher coefficient of friction than a standard collet
- Higher clamping force
- Repeated / afterward coating possible



EXTENDED CLAMPING LENGTH

- Can be used for long workpieces with multiple grooves
- Higher wrap around at the workpiece perimeter, therefore more force to clamp
- More stable clamping for long workpieces



SHORTENED CLAMPING LENGTH

- Application for workpieces whose geometry behind the clamping diameter shouldn't be damaged
- Used for short workpieces so the ejector can be lead closer to the clamping diameter

SHAPES








SQUARE

- Suitable for clamping square material




HEXAGON

- Suitable for clamping hexagon material


| | |
|--|--|
|  | <p>SPECIAL PROFILES</p> <ul style="list-style-type: none"> • Various profiles can be realized by ram EDM or wire EDM • Profiles can be adapted individually to the workpiece |
|  | <p>ECCENTRIC</p> <ul style="list-style-type: none"> • Eccentric bore can be eroded individually according to application • Through hole or offset hole is possible |
|  | <p>SPECIAL CONTOURS</p> <ul style="list-style-type: none"> • Complex contours can be realized by hard milling, hard turning and grinding • Already possible with smallest diameters from 0.2 mm |
|  | <p>STEPS</p> <ul style="list-style-type: none"> • Steps are suitable for simultaneous clamping of several diameters of a workpiece • Very high precision as both steps are ground in one step |
|  | <p>INNER CONICAL</p> <ul style="list-style-type: none"> • For gripping conical workpieces • The taper angle of the collet is precisely adapted to the workpiece |


SLOT DESIGNS

| | |
|--|---|
|  | <p>S-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use |
|--|---|

| | |
|---|--|
|  | <p>L-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use • Ideal for clamping on short clamping surfaces |
|  | <p>W-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use |
|  | <p>Z-SLOT</p> <ul style="list-style-type: none"> • High and constant clamping force • Clamping with virtually no clamping marks • Alternatively usable for profile material (corner clamping) • Prevents the entry of machining chips, as the collet closes almost completely • Easy to clean after use |
|  | <p>THIN SLOTTED</p> <ul style="list-style-type: none"> • Clamping with virtually no clamping marks • Prevents the entry of machining chips, as the collet closes almost completely • Recommended for small bore sizes |


WEAR REDUCTION


| | |
|---|--|
|  | <p>CARBIDE INSERT</p> <ul style="list-style-type: none"> • High wear resistance • Prevents pressure marks on the workpiece • Higher service life |
|---|--|


| | |
|---|--|
|  | <p>BL COATING</p> <ul style="list-style-type: none"> • Smooth surface • Fewer clamping marks on the material • Especially suitable for material with poor gliding properties • Prevents the welding of the material in the collet |
|---|--|


| | |
|---|--|
|  | <p>PREMIUM BLUE COATING</p> <ul style="list-style-type: none"> • Economical alternative to collets with carbide insert • High wear resistance • Can also be used for special shapes • Are completely coated on the functional surfaces like cone and shaft therefore more durable |
|---|--|


ADDITIONAL VERSIONS


| | |
|--|--|
|  | <p>INTERNAL STOP</p> <ul style="list-style-type: none"> • Suitable for manual loading of the machine at a certain length • Prevents the displacement of the workpiece at high axial forces • Used to stabilize the workpiece when the clamping length is too short |
|--|--|

| | |
|---|--|
|  | <p>SUPPORTING BUSH</p> <ul style="list-style-type: none"> • Minimizes vibrations as the bar material is supported along its total length and keeps it axially aligned • Ejection is made possible in a process-safe way |
|---|--|

| | |
|---|--|
|  | <p>EJECTOR & INNER COOLING</p> <ul style="list-style-type: none"> • Mechanical ejection of the workpieces • If required internal cooling of components can be integrated • For flushing the clamping surface • Simple change of the ejector within one collet type possible |
|---|--|


| | |
|---|---|
|  | <p>UP VERSION</p> <ul style="list-style-type: none"> • High precision |
|---|---|


| | |
|---|---|
|  | <p>UUP VERSION</p> <ul style="list-style-type: none"> • Highest precision |
|---|---|




| | |
|---|--|
|  | <p>SEALED</p> <ul style="list-style-type: none"> • Prevents the entry of machining chips • The whole slot area can be sealed • Resealing possible • Not usable with high pressure flushing in the machine |
|---|--|

INSERTS

| | |
|--|---|
|  | <p>PEEK / PLASTIC INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|--|---|

| | |
|---|--|
|  | <p>ALUMINIUM INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|---|--|

| | |
|---|--|
|  | <p>BRASS INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|---|--|

| | |
|---|--|
|  | <p>BRONZE INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>PERMAGLIS INSERTS</p> <ul style="list-style-type: none"> • Prevents pressure marks on the workpiece • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |
|  | <p>INSERTS FOR SELF-TURNING</p> <ul style="list-style-type: none"> • Clamping diameter can be turned out by the user himself • Inserts are replaceable when worn • Ideal for scratch-sensitive materials, as well as for gentle gripping |

DRAW-IN LONG NOSE COLLETS SW&B



d Shaft-Ø A Head-Ø V Long nose length L Total length K Taper angle G Thread F Shape

| Article | Ø d [mm] | Ø A [mm] | V [mm] | L [mm] | K [degree] | G | F min. – max. [mm] | | | Step bore |
|-----------|----------|----------|--------|--------|------------|-----------------------|--------------------|----|----|-----------|
| | | | | | | | ● | ■ | ⬡ | |
| SW12 E318 | 12 | 16 | 8.8 | 52 | 15 | Ø11.75x1.25 45°/5° | 0.5 – 8.0 | PR | PR | |
| SW12 E318 | 12 | 16 | 8.8 | 52 | 15 | Ø11.75x1.25 45°/5° | 8.01 – 10.0 | PR | PR | PR |
| SW15 E321 | 15 | 20.2 | 12 | 67 | 15 | Ø14.75x1.25 45°/5° | 0.5 – 10.5 | PR | PR | |
| SW15 E321 | 15 | 20.2 | 12 | 67 | 15 | Ø14.75x1.25 45°/5° | 10.51 – 12.5 | PR | PR | PR |
| SW20 E349 | 20 | 26.3 | 15.5 | 84.5 | 15 | Ø19.7x1.666 45°/5° | 0.5 – 14.5 | PR | PR | |
| SW20 E349 | 20 | 26.3 | 15.5 | 84.5 | 15 | Ø19.7x1.666 45°/5° | 14.51 – 16.0 | PR | PR | PR |
| SW25 E364 | 25 | 33.7 | 19.5 | 112 | 15 | Ø24.7x1.693 45°/5° | 1.0 – 18.0 | PR | PR | |
| SW25 E364 | 25 | 33.7 | 19.5 | 112 | 15 | Ø24.7x1.693 45°/5° | 18.01 – 25.0 | PR | PR | PR |
| B32 | 32 | 40 | 24 | 124 | 15 | Ø29.7x1.693 45°/5° | 10.0 – 24.0 | PR | PR | |
| B32 | 32 | 40 | 24 | 124 | 15 | Ø29.7x1.693 45°/5° | 24.01 – 28.0 | PR | PR | PR |
| B32/45 | 32 | 53 | 32.5 | 148.5 | 15 | Ø29.7x1.693 45°/5° | 5.0 – 24.0 | PR | PR | |
| B32/45 | 32 | 53 | 32.5 | 148.5 | 15 | Ø29.7x1.693 45°/5° | 24.01 – 40.0 | PR | PR | PR |



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

MAIN SPINDLE MULTI-SPINDLE COLLETS



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

MAIN SPINDLE MULTI-SPINDLE COLLETS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- ADDITIONAL VERSIONS



USE OF MAIN SPINDLE MULTI-SPINDLE COLLETS

Multi-Spindle collets are used for workpiece clamping as well as in all common multi-spindle machines.

Figure 1

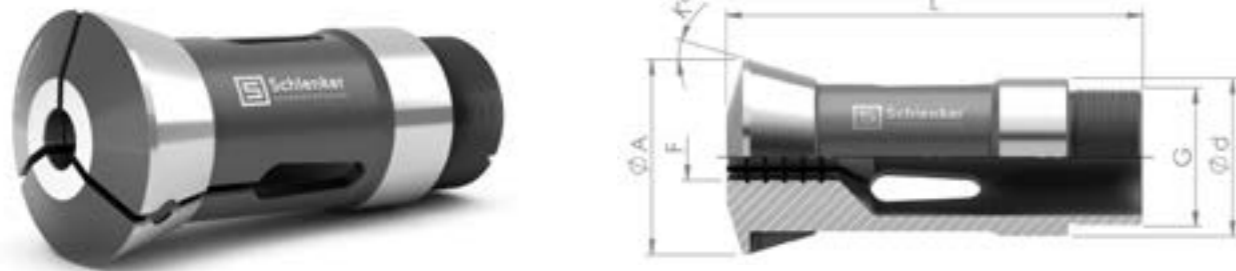


Figure 2

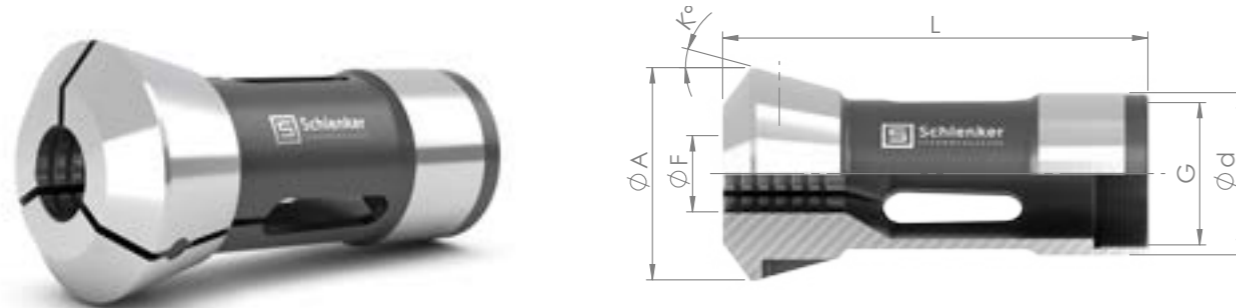
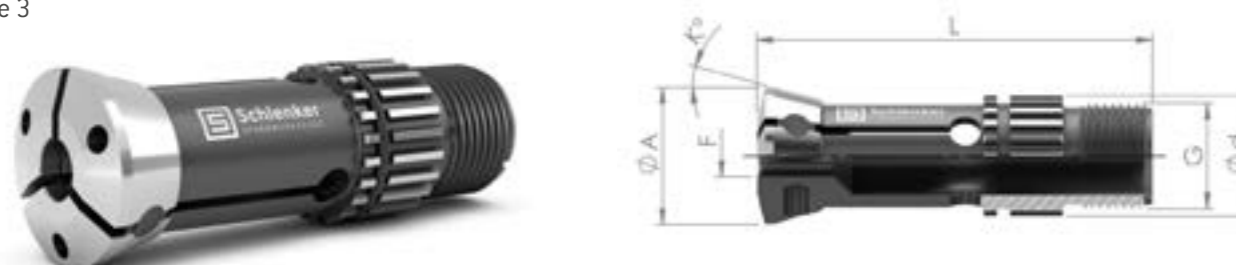


Figure 3



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

| Article | Ø d [mm] | Ø A [mm] | L [mm] | K [degree] | G | F min. – max. [mm] | | |
|----------|-------------|-------------|-----------|---------------|-----------------|-----------------------|------------|------------|
| | | | | | | ● | ■ | ⬡ |
| Figure 1 | | | | | | | | |
| E9007 | 32 | 41.5 | 79 | 15 | M28x1L | 23.5 | 16.5 | 20.0 |
| E9012 | 34 | 42 | 85 | 16 | M30x1L | 25.0 | 17.5 | 21.5 |
| E9016 | 32 | 41.5 | 79 | 15 | M30x1L | 23.5 | 16.5 | 20.0 |
| E9018 | 35 | 45 | 105 | 16 | M33x1 | 27.5 | 19.0 | 23.5 |
| E9021 | 25 | 35 | 92 | 16 | M25x1 | 20.5 | 14.5 | 17.5 |
| E9039 | 46 | 60.3 | 112 | 15 | M40x1.5L | 33.5 | 23.5 | 29.0 |
| E9049 | 46 | 60.3 | 112 | 15 | M40x1.5L | 33.5 | 23.5 | 29.0 |
| E9070 | 53 | 69.3 | 129 | 15 | M47x1.5L | 40.5 | 28.5 | 35.0 |
| E9112 | 62.9 | 78.3 | 147 | 15 | M56x1.5L | 49.5 | 35.0 | 42.5 |
| Figure 2 | | | | | | | | |
| E9001 | 25 | 35 | 73 | 15 | M22x1 | 19.5 | 13.5 | 16.5 |
| E9017 | 38 | 45.5 | 85 | 16 | M34.5x0.75L | 30.5 | 21.5 | 26.0 |
| E9020 | 36 | 45 | 105 | 16 | M33x1.25 | 27.5 | 19.0 | 23.5 |
| E9034 | 41.25 | 54.6 | 130 | 15 | 1.484" – 1/24"L | 32.5 | 23.0 | 28.0 |
| E9069 | 53 | 69.4 | 128 | 15 | M48x15L | 41.5 | 29.0 | 35.5 |
| Figure 3 | | | | | | | | |
| TW20 | 26 | 23 | 75 | 15 | M20x1 | 3.0 – 15.0 | 4.0 – 10.0 | 4.0 – 12.0 |

SUB SPINDLE MULTI-SPINDLE COLLETS



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USING SUB SPINDLE MULTI-SPINDLE COLLETS

Multi-Spindle collets are used for workpiece clamping as well as in all common multi-spindle machines.

Figure 1



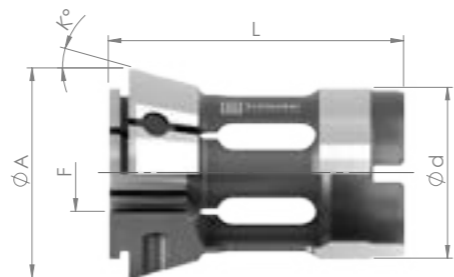
Figure 2



Figure 3



Figure 4



SUB SPINDLE MULTI-SPINDLE COLLETS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- ADDITIONAL VERSIONS

d Shaft-Ø A Head-Ø L Total length K Taper angle G Interface F Shape

| Article | Ø d [mm] | Ø A [mm] | L [mm] | K [degree] | G | F min. – max. [mm] | | |
|------------------|-------------|-------------|-----------|---------------|-----------------|-----------------------|------|------|
| | | | | | | ● | ■ | ⬡ |
| Figure 1 | | | | | | | | |
| ETPU 9012 | 28 | 32 | 73 | 8 | Bayonet inside | 24.5 | 17.0 | 21.0 |
| ETPU 9039 | 35.5 | 40 | 80 | 8 | Bayonet inside | 32.0 | 22.5 | 27.5 |
| G90699 H-G | 39 | 44 | 82 | 8 | Bayonet inside | 32.0 | 22.5 | 27.5 |
| Figure 2 | | | | | | | | |
| E3439 | 18.7 | 25 | 51.5 | 8 | Bayonet outside | 16.0 | 11.0 | 13.5 |
| G35161 | 25 | 32.1 | 91.5 | 15 | Bayonet outside | 19.5 | 13.5 | 16.5 |
| Figure 3 | | | | | | | | |
| EG9012/ E3560 | 26 | 28.5 | 80 | 6 | M21.5x0.75 | 20.0 | 14.0 | 17.0 |
| G9016 E/G | 28 | 36 | 50 | 15 | M24x1.5L | 22.5 | 15.5 | 19.0 |
| GM20 | 28 | 32 | 62 | 8 | M24 x1.5L | 20.5 | 14.5 | 17.5 |
| Figure 4 | | | | | | | | |
| G9039 E/G | 34 | 42 | 53 | 15 | | 26.0 | 18.0 | 22.5 |
| G9070 E/G | 52 | 60.6 | 60 | 15 | | 40.0 | 28.0 | 34.5 |
| G9139 E/G | 63 | 71.6 | 60 | 15 | | 51.0 | 36.0 | 44.0 |
| G91397 H/G | 59 | 67 | 76 | 16 | | 51.0 | 36.0 | 44.0 |
| G907034 H/G | 44 | 54 | 76 | 16 | | 36.0 | 25.0 | 31.0 |

DOUBLE CONE MULTI-SPINDLE COLLETS



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

DOUBLE CONE MULTI-SPINDLE COLLET OPTIONS

- CLAMPING SURFACE DESIGNS
- WEAR REDUCTION
- SLOT DESIGNS
- ADDITIONAL VERSIONS

USE OF DOUBLE CONE MULTI-SPINDLE COLLETS

Double cone multi-spindle collets are used for workpiece clamping as well as in the main spindle of Tornos multi-spindle machines.

CLAMPING SURFACE DESIGNS



SMOOTH

- Mainly used on the main spindle



GROOVED - STANDARD

- Standard double cone collet
- Mainly used on the main spindle



CARBIDE COATING

- Carbide coating possible for all shapes
- Higher coefficient of friction than a standard collet
- Higher clamping force
- Repeated / afterward coating possible



GROOVED & CARBIDE COATING

- Carbide coating possible for all shapes
- Higher coefficient of friction than a standard collet
- Higher clamping force
- Repeated / afterward coating possible

SLOT DESIGNS



S-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use



W-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use



Z-SLOT

- High and constant clamping force
- Clamping with virtually no clamping marks
- Alternatively usable for profile material (corner clamping)
- Prevents the entry of machining chips, as the collet closes almost completely
- Easy to clean after use



THIN SLOTTED

- Clamping with virtually no clamping marks
- Prevents the entry of machining chips, as the collet closes almost completely
- Recommended for small bore sizes

WEAR REDUCTION



BL COATING

- Smooth surface
- Fewer clamping marks on the material
- Especially suitable for material with poor gliding properties
- prevents the welding of the material in the collet



PREMIUM BLUE COATING

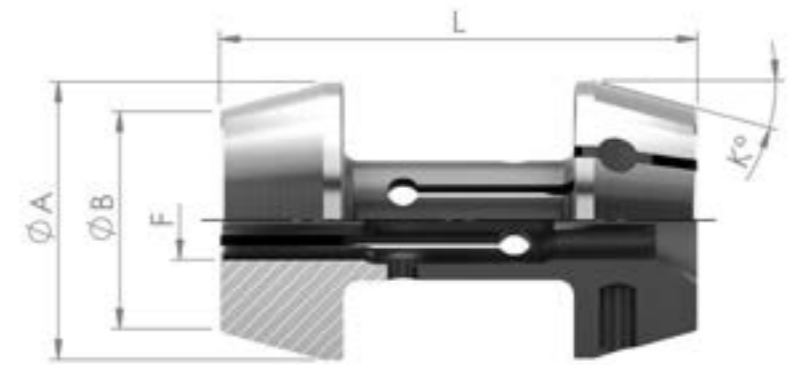
- High wear resistance
- Can also be used for special shapes
- Are completely coated on the functional surfaces like cone and shaft therefore more durable

ADDITIONAL VERSIONS



SEALED

- Prevents the entry of machining chips
- The whole slot area can be sealed
- Resealing possible
- Not usable with high pressure flushing in the machine



A Head-Ø B Nose-Ø L Total length K Taper angle F Shape

| Article | Ø A [mm] | Ø B [mm] | L [mm] | K [degree] | F min. – max. [mm] |
|---------|----------|----------|--------|------------|--------------------|
| | | | | | |
| E8731 | 35 | 28 | 60 | 15 | 8.0 – 25.0 |
| E8810 | 43 | 35 | 68 | 14 | 10.0 – 32.0 |

NOTES

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

PICK UP COLLETS



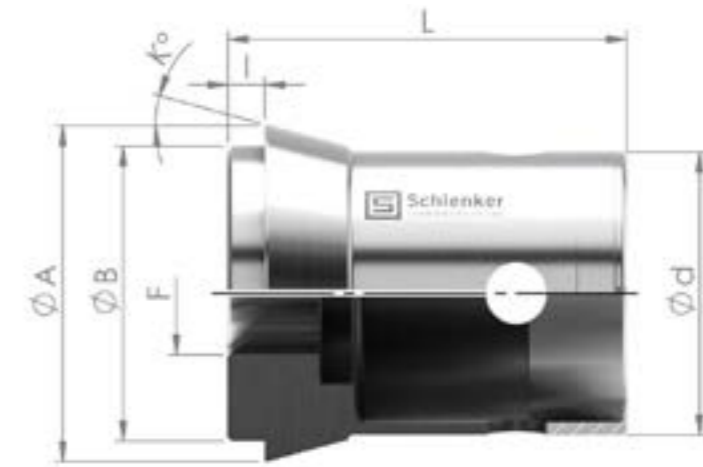
Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

USE OF PICK UP COLLETS

Pick up collets are available for all common automatic lathes.

PICK UP COLLET OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- POSITIONING
- WEAR REDUCTION
- ADDITIONAL VERSIONS
- INSERTS



d Shaft-Ø A Head-Ø B Nose-Ø I Nose length L Total length K Taper angle F Shape



SMOOTH – STANDARD

- Standard pick up collet



SQUARE

- Suitable for clamping square material



HEXAGON

- Suitable for clamping hexagon material

| Article | Ø d [mm] | Ø A [mm] | Ø B [mm] | I [mm] | L [mm] | K [degree] | Typ | F min. – max. [mm] | | |
|----------------|----------|----------|----------|----------|----------|------------|---------------|--------------------|----|----|
| | | | | | | | | ● | ■ | ⬡ |
| M105 | 12 | 14.5 | 10.5 | 6 | 21 | 16 | STROHM | 1.0 – 8.5 | PR | PR |
| M105 Long nose | 12 | 14.5 | 10.5 | variable | variable | 16 | STROHM | 3.0 – 8.0 | PR | PR |
| M125 | 15 | 17 | 13 | 2 | 17 | 16 | STROHM | 1.0 – 10.0 | PR | PR |
| M125 Long nose | 15 | 17 | 13 | variable | variable | 16 | STROHM | 1.0 – 10.0 | PR | PR |
| M205 | 24 | 28 | 22 | 6 | 36 | 16 | STROHM | 2.0 – 19.0 | PR | PR |
| M612 | 35 | 40 | 32 | 6 | 46 | 15 | TNS28 | 1.0 – 29.0 | PR | PR |
| GM612 | 35 | 40 | 32 | 6 | 46 | 15 | MANURHIN K'MX | 1.0 – 30.0 | PR | PR |
| G721 | 46 | 55 | 48 | 6 | 65 | 15 | TNS30/42 | 1.0 – 42.0 | PR | PR |
| G722 | 44.5 | 54 | 42 | 8.5 | 64 | 15 | | 3.0 – 37.0 | PR | PR |
| G952 | 61.5 | 71.5 | 62 | 6 | 65 | 15 | TNM65 | 5.0 – 59.0 | PR | PR |

SYNCHRONOUS COLLETS

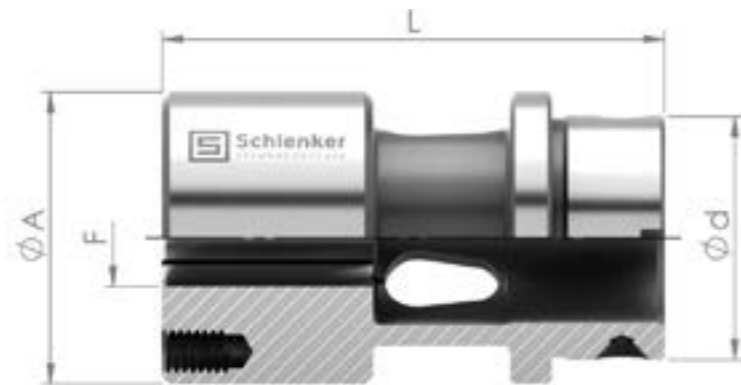


Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF SYNCHRONOUS COLLETS

Synchronous collets are available especially for the INDEX/TRAUUB automatic lathes.



d Shaft-Ø A Head-Ø L Total length F Shape

| Article | Ø d [mm] | Ø A [mm] | L [mm] | Typ | F min. – max. [mm] |
|---------|----------|----------|--------|-------------------------|--------------------|
| | | | | | ● |
| E1444 | 30 | 36 | 62 | GS30 | 4.0 – 30.0 |
| E1462 | 30 | 48 | 62 | GS42, GB42, GB65, GSC42 | 4.0 – 42.0 |
| E1465 | 30 | 62 | 94 | GS65, GSC65, GS42S | 6.0 – 56.0 |

SYNCHRONOUS COLLET OPTIONS

- CLAMPING SURFACE DESIGNS
- SHAPES

CLAMPING SURFACE DESIGNS



SMOOTH

- Mainly used on the sub spindle



CARBIDE COATING

- Carbide coating possible for all shapes
- Higher coefficient of friction than a standard collet
- Higher clamping force
- Repeated / afterward coating possible

SHAPES



SQUARE

- Suitable for clamping square material



HEXAGON

- Suitable for clamping hexagon material

COLLETS FOR INTERNAL CLAMPING



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

USE OF COLLETS FOR INTERNAL CLAMPING

Collets for internal clamping are suitable for clamping all rotationally symmetrical workpieces from the inside. Furthermore, the clamping is purely mechanical. Due to the internal clamping, the surface of the outer diameter from the workpiece won't be damaged. If inner contours deviate from the cylindrical shape, the internal clamping can be specifically adapted to the component geometry.



DEAD LENGTH COLLETS FOR INTERNAL CLAMPING

- Available for all dead length collet types from our range



DRAW-IN COLLETS FOR INTERNAL CLAMPING

- Available for all draw-in collet types from our range



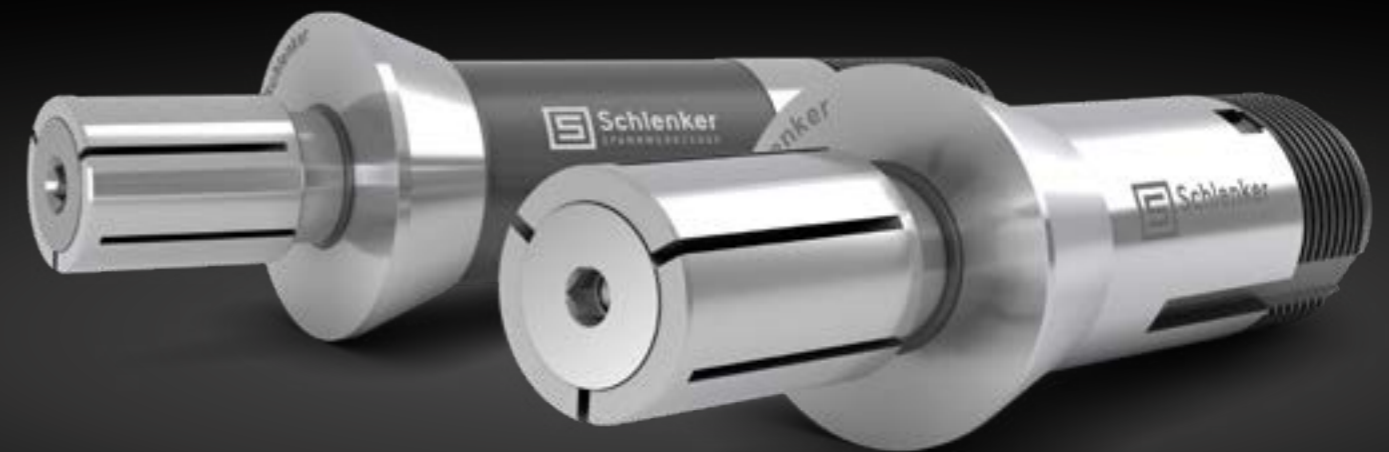
DRAW-IN COLLETS SW&B FOR INTERNAL CLAMPING

- Available for all draw-in collet types SW&B from our range

DRAW-IN COLLETS FOR INTERNAL CLAMPING WITH BUSH

Draw-in collets for internal clamping are suitable for clamping all rotationally symmetrical workpieces from the inside. Furthermore, the clamping is purely mechanical. Due to the internal clamping, the surface of the outer diameter from the workpiece won't be damaged. If inner contours deviate from the cylindrical shape, the internal clamping can be specifically adapted to the component geometry.

Due to the bush, a more form-fit clamping of the workpiece is possible. Larger diameters can also be clamped. Available for all draw-in collet types as well as SW&B from our range.



You would like to order a draw-in collet for internal clamping?
Please contact us by phone or e-mail.

Phone: +49 7720 9944-0 | E-mail: info@schlenker-spannwerkzeuge.de

COLLET ALIGNMENT MANDRELS



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



COLLET ALIGNMENT MANDREL VERSIONS

- DEAD LENGTH COLLETS
- DRAW-IN COLLETS
- DRAW-IN COLLETS SW&B

USE OF COLLET ALIGNMENT MANDRELS

The high-precision alignment mandrels are particularly suitable for checking the axial or radial offset of machine axes or the offset of the main spindle to the sub spindle of the machine geometry. Furthermore, alignment mandrels are used for checking the runout and tumbling on main or sub spindle.



DEAD LENGTH COLLET ALIGNMENT MANDRELS

- Available for all dead length collet types from our range



DRAW-IN COLLET ALIGNMENT MANDRELS

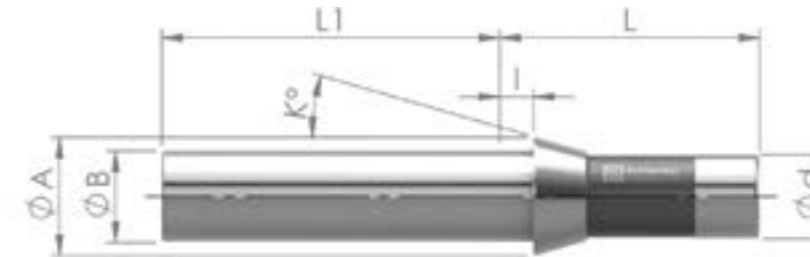
- Available for all draw-in collet types from our range



DRAW-IN COLLET SW&B ALIGNMENT MANDRELS

- Available for all draw-in collet types SW&B from our range

DEAD LENGTH COLLET ALIGNMENT MANDRELS

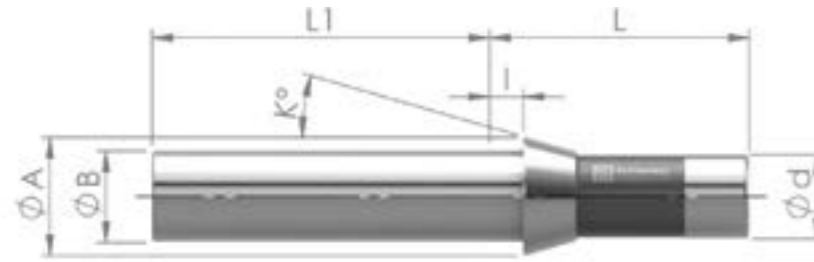


d Shaft-Ø A Head-Ø B Nose-Ø l Nose length L1 Length L1 L Total length K Taper angle

| Article | Ø d [mm] | Ø A [mm] | Ø B [mm] | l [mm] | L1 [mm] | L [mm] | K [degree] |
|-----------------------|----------|----------|----------|--------|---------|--------|------------|
| E101 F8-577 TF8 | 8 | 12 | 8 | 4.5 | 70 | 42 | 16 |
| E109 F10 TF10 | 10 | 16 | 10 | 5.5 | 70 | 47.5 | 20 |
| E112 | 11 | 19 | 12 | 6 | 70 | 41 | 22 |
| E116 F13 | 13 | 19 | 13 | 6 | 70 | 64 | 16 |
| E118 | 14 | 19.5 | 15 | 6 | 70 | 46 | 15 |
| E120 F15 TF15 | 15 | 21 | 15 | 6 | 70 | 64 | 16 |
| EF16 E1212 TF16 | 16 | 21 | 16 | 6 | 70 | 64 | 16 |
| SYF16 M14x0.75 | 16 | 21 | 16 | 8 | 70 | 66 | 16 |

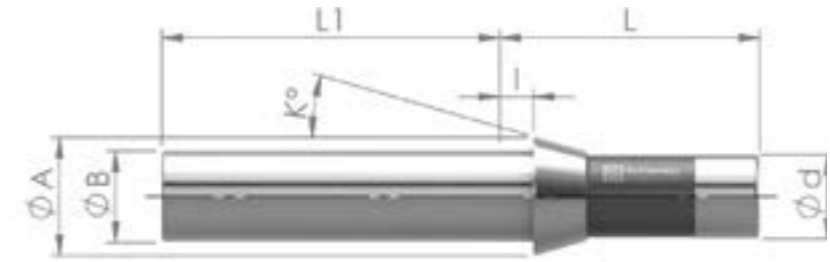
MULTI-SPINDLE ALIGNMENT MANDRELS ARE AVAILABLE FOR ALL MULTI-SPINDLE COLLET TYPES FROM OUR RANGE.

DEAD LENGTH COLLET ALIGNMENT MANDRELS



d Shaft- \emptyset A Head- \emptyset B Nose- \emptyset I Nose length L1 Length L1 L Total length K Taper angle

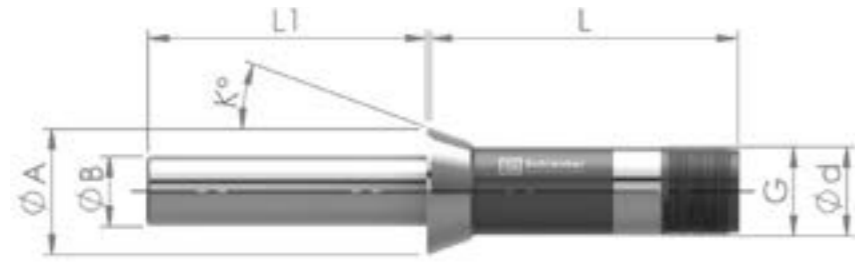
| Article | $\emptyset d$ [mm] | $\emptyset A$ [mm] | $\emptyset B$ [mm] | I [mm] | L1 [mm] | L [mm] | K [degree] |
|------------------------|-----------------------|-----------------------|-----------------------|-----------|------------|-----------|---------------|
| E127 TF18 | 18 | 25 | 18 | 6 | 70 | 67 | 16 |
| E136 F20-201 | 20 | 26 | 19 | 5 | 100 | 54 | 15 |
| E138 F20-87 TF20 | 20 | 28 | 21 | 7 | 100 | 67 | 1 |
| E140 F22 TF22 | 22 | 30 | 21 | 6 | 100 | 55 | 15 |
| TF24 | 23.8 | 28 | 22 | 7 | 100 | 62 | 15 |
| E144 | 25 | 34 | 25 | 6 | 100 | 65 | 15 |
| E145 F25 TF25 | 25 | 35 | 27 | 10 | 100 | 77 | 16 |
| E147 F27-22 | 27 | 38 | 30 | 8 | 100 | 73 | 15 |
| E148 F28 | 28 | 38 | 28 | 7 | 100 | 70 | 15 |
| BS20 | 28 | 35 | 27 | 10 | 100 | 77 | 16 |
| E157 F30 TF30 | 30 | 42 | 34 | 10 | 100 | 80 | 16 |
| EF30 E1446 | 30 | 38 | 32 | 6 | 100 | 65 | 15 |
| E161 F32 | 32 | 45 | 34 | 8 | 100 | 75 | 15 |
| O166 | 32 | 40 | 34 | 6 | 100 | 65 | 15 |
| E162 | 35 | 43 | 34 | 7 | 100 | 70 | 15 |



d Shaft- \emptyset A Head- \emptyset B Nose- \emptyset I Nose length L1 Length L1 L Total length K Taper angle

| Article | $\emptyset d$ [mm] | $\emptyset A$ [mm] | $\emptyset B$ [mm] | I [mm] | L1 [mm] | L [mm] | K [degree] |
|-----------------------|-----------------------|-----------------------|-----------------------|-----------|------------|-----------|---------------|
| E163 F35 | 35 | 48 | 38 | 8 | 100 | 80 | 15 |
| EF37 E1536 TF37 | 37 | 47 | 40 | 10 | 100 | 92 | 16 |
| EF38 E164 | 38.08 | 49 | 38 | 9.5 | 100 | 108 | 15 |
| EF40 | 40 | 47 | 40 | 10 | 100 | 92 | 16 |
| E171 F42 | 42 | 55 | 42 | 9 | 100 | 94 | 15 |
| TF43 | 43 | 53 | 46 | 10 | 100 | 92 | 16 |
| TF44 | 44 | 52 | 44 | 10 | 100 | 92 | 16 |
| E173 F48 | 48 | 60 | 50 | 9 | 100 | 94 | 15 |
| TF48 | 48 | 60 | 50 | 9 | 100 | 94 | 15 |
| BS38 | 48 | 54 | 44 | 10 | 100 | 100 | 15 |
| E177 F58 | 58 | 70 | 60 | 9 | 150 | 94 | 15 |
| E185 F66 | 66 | 84 | 73 | 9 | 150 | 110 | 15 |

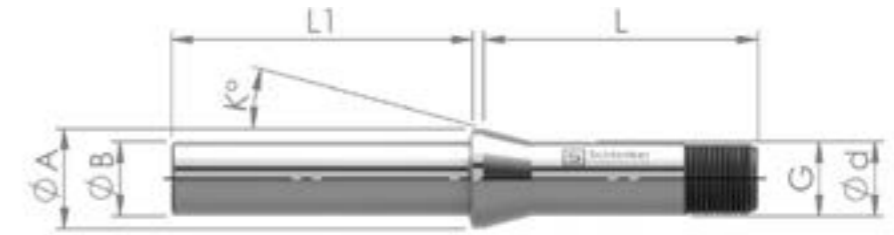
DRAW-IN COLLET ALIGNMENT MANDRELS



d Shaft-Ø A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle G Thread

| Article | Ø d [mm] | Ø A [mm] | Ø B [mm] | L1 [mm] | L [mm] | K [degree] | Thread |
|---------|----------|----------|----------|---------|--------|------------|---|
| E324 | 15 | 21.5 | 14 | 70 | 53 | 20 | M13x1 |
| E3409 | 20 | 28 | 17 | 100 | 90 | 8 | Tr.20x1.5 |
| E351 | 20 | 28 | 17 | 100 | 80 | 20 | Tr.20x1.5 |
| E358 | 23 | 32 | 20 | 100 | 81.5 | 20 | M21x1 |
| E359 | 23 | 32 | 20 | 100 | 89.5 | 20 | Tr.23x1.5 |
| E363 | 25 | 33.5 | 21 | 100 | 84 | 16 | M23x1 |
| E366 | 28 | 36 | 22 | 100 | 100 | 18 | Tr.27x1/20" |
| E367 | 28 | 38 | 22 | 100 | 100 | 20 | Tr.28x1.5 |
| E385 | 31.75 | 37.5 | 25 | 100 | 83 | 10 | Outside: 31.45x1/20" Inside: 26.44x1.058 |
| E386 | 32 | 45 | 25 | 100 | 110 | 20 | Tr.32x1.5 |
| E666 | 25 | 35 | 21 | 100 | 59.5 | 20 | M25x1 |
| K20 | 20 | 28 | 17 | 100 | 80 | 20 | Tr.20x1.5 |
| K23 | 23 | 32 | 20 | 100 | 89.5 | 20 | Tr.23x1.5 |
| K32 | 32 | 45 | 25 | 100 | 110 | 20 | Tr.32x1.5 |
| K45 | 45 | 60 | 30 | 100 | 140 | 20 | Tr.45x2 |
| KDT38 | 58 | 70.3 | 30 | 100 | 99 | 15 | M50x1.5 |

DRAW-IN COLLET SW&B ALIGNMENT MANDRELS



d Shaft-Ø A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle G Thread

| Article | Ø d [mm] | Ø A [mm] | Ø B [mm] | L1 [mm] | L [mm] | K [degree] | Thread |
|----------------------|----------|----------|----------|---------|--------|------------|--------------------|
| SW12 80-2 E318 | 12 | 16 | 10 | 70 | 46 | 15 | Ø11.75x1.25 45°/5° |
| SW15 80-3 E321 | 15 | 20.2 | 14 | 70 | 58.3 | 15 | Ø14.75x1.25 45°/5° |
| SW20 80-4 E349 | 20 | 26.3 | 17 | 100 | 73.00 | 15 | Ø19.7x1.666 45°/5° |
| SW25 80-5 E364 | 25 | 33.7 | 21 | 100 | 97.6 | 15 | Ø24.7x1.693 45°/5° |
| B32 72-65 | 32 | 40 | 25 | 100 | 106 | 15 | Ø29.7x1.693 45°/5° |
| B45 72-199 | 45 | 53 | 30 | 100 | 115 | 15 | M42x1.5 |

CLAMPING HEADS SPANNTOP



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

CLAMPING HEAD SPANNTOP OPTIONS

USE OF CLAMPING HEADS

Clamping heads are used for workpiece clamping in conventional and CNC lathes.



SMOOTH

- Clamping with virtually no clamping marks
- Clamping of previously machined contours possible



RADIAL GROOVES

- Powerful clamping with clamping marks
- Clamping of raw material



AXIAL & RADIAL GROOVES

- Powerful clamping with clamping marks
- Clamping of raw material
- Optimum power transmission, high rigidity and clamping force and low wear



SQUARE

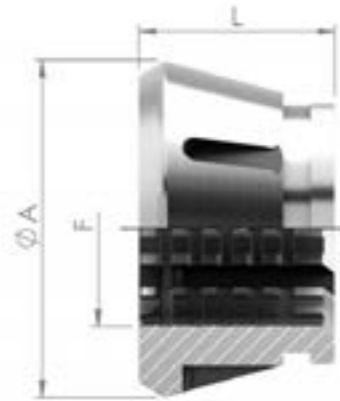
- Suitable for clamping square material



HEXAGON

- Suitable for clamping hexagon material

CLAMPING HEADS SPANNTOP



A Head-Ø L Total length F Shape

| Article | Ø A [mm] | L [mm] | Versions | | F min. – max. [mm] |
|---------|----------|--------|----------|--|--|
| | | | | | ● |
| SK32 | 57.70 | 44 | BZIG | smooth | 3.0 – 32.0 |
| | | 47 | BZI | smooth with radial grooves with axial & radial grooves | 4.0 – 7.0 8.0 – 10.0 11.0 – 32.0 |
| SK42 | 79.30 | 42 | BZIG | smooth | 3.0 – 42.0 |
| | | 47 | BZI | smooth with radial grooves with axial & radial grooves | 4.0 – 7.5 8.0 – 10.5 11.0 – 42.0 |
| SK52 | 79.30 | 46 | BZIG | smooth | 3.0 – 52.0 |
| | | 46 | BZI | smooth with radial grooves with axial & radial grooves | 4.0 – 7.5 8.0 – 10.5 11.0 – 52.0 |
| SK65 | 99.5 | 53 | BZIG | smooth | 3.0 – 65.0 |
| | | 58 | BZI | smooth with radial grooves with axial & radial grooves | 4.0 – 7.5 8.0 – 10.5 11.0 – 65.0 |
| SK80 | 114.5 | 53 | BZIG | smooth | 4.0 – 80.0 |
| | | 53 | BZI | smooth with radial grooves with axial & radial grooves | 4.0 – 7.0 8.0 – 10.0 11.0 – 80.0 |
| SK100 | 144.5 | 59 | BZG | smooth | 15.0 – 100.0 |
| | | 59 | BZ | with radial grooves with axial & radial grooves | 15.0 – 24.0 25.0 – 100.0 |

DIMENSIONS NOT LISTED AS WELL AS CLAMPING HEADS TOPLUS ARE AVAILABLE PER REQUEST.

INDIVIDUAL COLLETS EASILY ORDERED



DOWNLOAD ORDER FORM NOW

After filling out the form, please send it back by e-mail or fax.
info@schlenker-spannwerkzeuge.de / +49 7720 9944-27



SCAN ME

www.schlenker-spannwerkzeuge.de/en/downloads/

INDIVIDUAL COLLETS EASILY ORDERED
 ORDER YOUR COLLET IN ONLY 3 STEPS

- Select the required collet from the overview by clicking on it. After selection, you will be directed to the drawing of the collet where you can fill out the dimensions.
- Afterwards, filling out the required dimensions, please send us the form by e-mail or fax, e-mail: info@schlenker-spannwerkzeuge.de | fax: +49 7720 9944-27
- The Schlenker team will prepare a suitable offer for you, which you will receive by e-mail. When the offer has been reviewed by you, please confirm it to us and we will immediately start with your order.

Grid of collet options (checkboxes):

- Ø 44.00
- Ø 47.00
- Ø 47.00
- Ø 53.00
- Ø 53.00
- Ø 53.00
- Ø 59.00
- Ø 59.00
- Ø 59.00
- Ø 59.00
- Ø 59.00
- Ø 59.00

MADE IN GERMANY

Schlenker Spannwerkzeuge
 Schlenker Spannwerkzeuge GmbH & Co. KG
 77700 Lahr, Germany
 Fax: +49 7720 9944-27
info@schlenker-spannwerkzeuge.de
www.schlenker-spannwerkzeuge.de

ER COLLETS

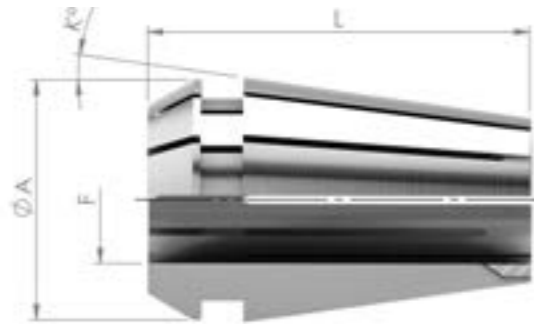


Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

ER COLLET OPTIONS

USE OF ER COLLETS

ER collets are used in the collet holders, tapping attachments or in quick-change chucks as well as in tool clamping.



A Outside diameter L Total length K Taper angle F Shape

| Article | Ø A [mm] | L [mm] | K [degree] | F min. – max. [mm] | Rise [mm] |
|---------------|----------|--------|------------|--------------------|-----------|
| ER8 E4004 | 8.5 | 13.6 | 8 | 1.0 – 5.0 | 0.5 |
| ER11 E4008 | 11.3 | 18 | 8 | 1.0 – 7.0 | 0.5 |
| ER16 E426 | 17 | 27.5 | 8 | 1.0 – 10.0 | 0.5 |
| ER20 E428 | 21 | 31.5 | 8 | 1.0 – 13.0 | 0.5 |
| ER25 E430 | 26 | 34 | 8 | 1.0 – 16.0 | 0.5 |
| ER32 E470 | 33 | 40 | 8 | 2.0 – 20.0 | 0.5 |
| ER40 E472 | 41 | 46 | 8 | 3.0 – 26.0 | 0.5 |



STANDARD VERSION

- Runout and repeatability are within 5µm
- Clamping range of 0.5 – 1.0 mm possible



UP VERSION

- Runout and repeatability are averaged at 3µm
- Clamping range of 0.5 – 1.0 mm possible



SEALED

- Are used for internal cooling for high-precision machining
- Runout and repeatability are averaged at 3µm
- Limited clamping range, only the nominal dimension can be clamped
- Shafts with lateral flat surface can be used under certain circumstances, only the flat surface must be located behind the rubber seals in order to reach a complete sealing



SEALED WITH JET HOLES

- Are used for internal cooling for high-precision machining
- Runout and repeatability are averaged at 3µm
- Limited clamping range, only the nominal dimension can be clamped
- The jet holes allows the coolant to reach the cutting tools without a coolant channel
- Shafts with lateral flat surface can be used under certain circumstances, only the flat surface must be located behind the rubber seals in order to reach a complete sealing

MASA TOOL



Cartridges **96**

Accessories **99**

Collets **100**

Overgrip Collets **120**

02

MASA TOOL MICROCONIC CARTRIDGES



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF MASA TOOL MICROCONIC CARTRIDGES

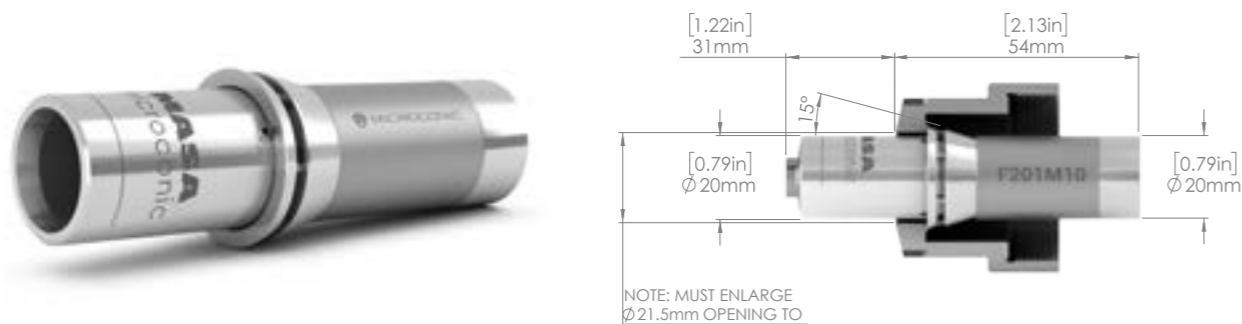
The cartridge is installed in the spindle of the CNC lathe and is used as a collet sleeve. A modification of the machine is not necessary. The robust design of the cartridge ensures reliability and longevity in the most demanding production processes, while providing the highest precision. They are supplied with a long nose as standard so that tools and coolant have easy access to the workpiece. The cartridges are available for the draw-type collet systems and push-type (dead length) systems. Each cartridge is supplied with a face dial wrench.

MASA TOOL MICROCONIC CARTRIDGE VERSIONS

MICROCONIC F201M10

Order no.
122040

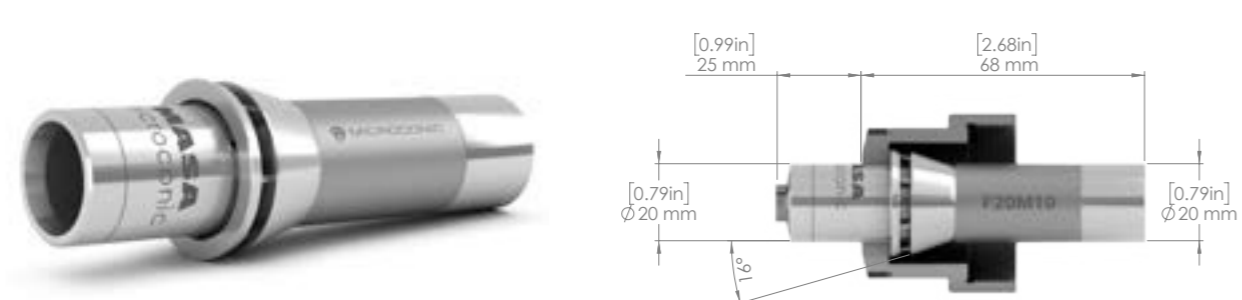
Cartridge for collet sleeve
E136



MICROCONIC F20M10

Order no.
122039

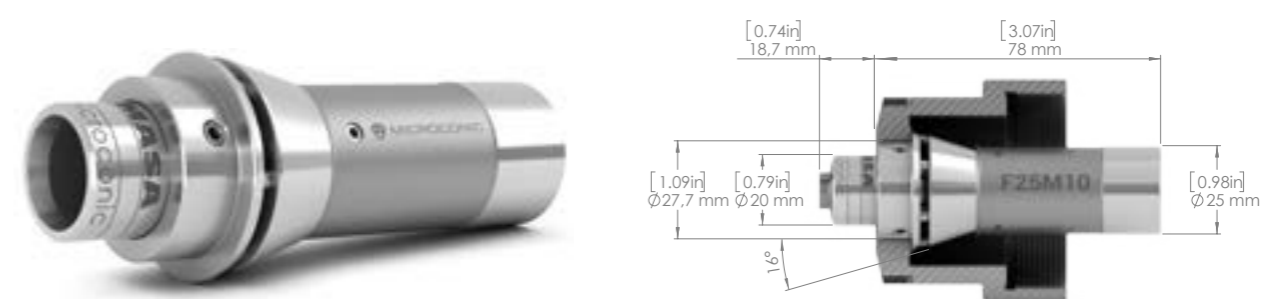
Cartridge for collet sleeve
E138



MICROCONIC F25M10

Order no.
122041

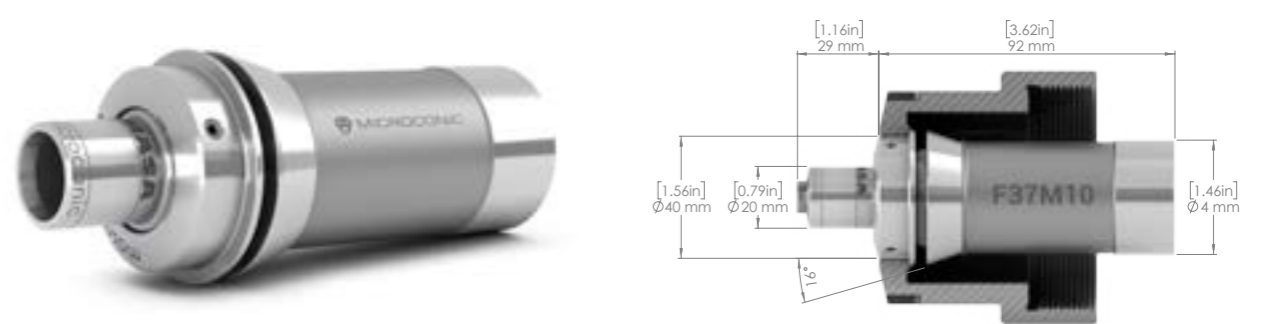
Cartridge for collet sleeve
E145



MICROCONIC F37M10

Order no.
122037

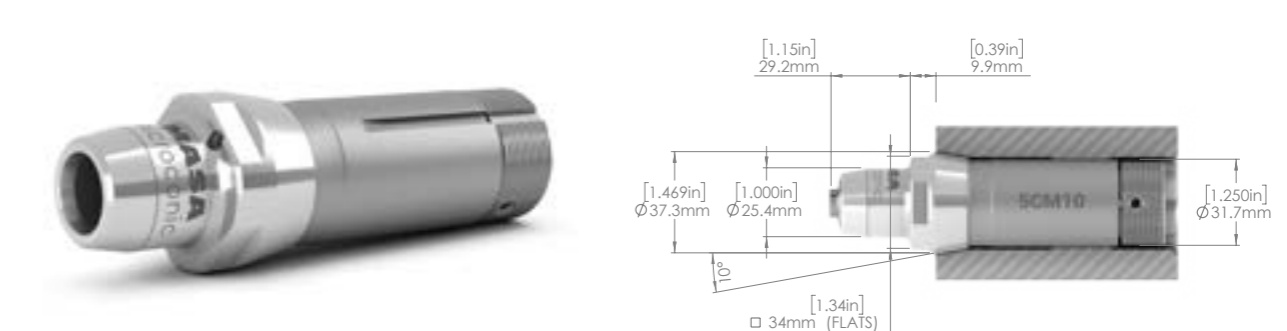
Cartridge for collet sleeve
EF37



MICROCONIC 5CM10

Order no.
122042

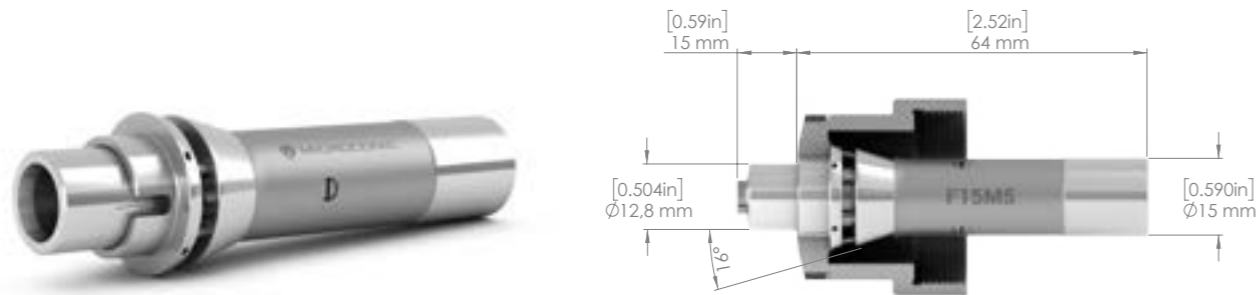
Cartridge for collet sleeve
E385



MICROCONIC F15M5

Order no.
124969

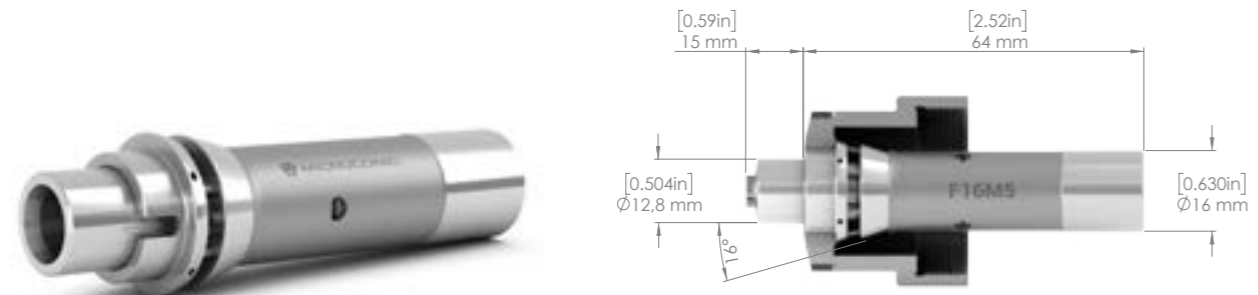
Cartridge for collet sleeve
E120



MICROCONIC F16M5

Order no.
124971

Cartridge for collet sleeve
EF16



| MACHINING CONDITION | MICROGRAD SETTING | |
|---|-------------------|---------------|
| VERY LIGHT – thin walls, micro-size parts | 0 – 0.02 mm | 0 – .001" |
| LIGHT TO MODERATE – skim cutting, facing, ID chamfer, smaller parts | 0.02 – 0.06 mm | .001 – .002" |
| MODERATE – turning, boring, small drilling, small threading | 0.04 – 0.08 mm | .0015 – .003" |
| HEAVY – turning, milling, drilling, threading, cross-drilling | 0.08 – 0.1 mm | .003 – .004" |
| EXTREME – large drilling, blind hole broaching, heavy milling | 0.1+ mm | .004"+ |

MASA TOOL ACCESSORIES



DIAL WRENCH

- Are used for precise set-up of the clamping force on the collets, as well as overgrip collets
- Clamping force can be set by metric increments of 0.02mm and imperial increments of .001" (2 – 4 graduations)



SCREWDRIVER HSD9

- The clamping force on the collets, as well as overgrip collets can be fixed with the screwdriver



SCREWDRIVER HSD15

- The clamping force on the collets, as well as overgrip collets can be fixed with the screwdriver



EJECTION GUIDE SLEEVE EGS-1

- Ejection guide sleeves are available in brass, stainless steel and plastic
- They can be adapted exactly to the workpiece by drilling or turning



EJECTION GUIDE SLEEVE EGS-12

- Ejection guide sleeves are available in brass, stainless steel and plastic
- They can be adapted exactly to the workpiece by drilling or turning



EJECTION GUIDE SLEEVE EGS-13

- Ejection guide sleeves are available in brass, stainless steel and plastic
- They can be adapted exactly to the workpiece by drilling or turning



EJECTION GUIDE SLEEVE EGS5-1

- Ejection guide sleeves are available in brass, stainless steel and plastic
- They can be adapted exactly to the workpiece by drilling or turning



EJECTION GUIDE SLEEVE EGS5-2

- Ejection guide sleeves are available in brass, stainless steel and plastic
- They can be adapted exactly to the workpiece by drilling or turning



EJECTION GUIDE SLEEVE EGS5-12

- Ejection guide sleeves are available in brass, stainless steel and plastic
- They can be adapted exactly to the workpiece by drilling or turning

MASA TOOL MICROCONIC COLLETS



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF MASA TOOL MICROCONIC COLLETS

The collets can be installed in any cartridge of the M10 series, for this reason the same collet can be used on different machines. The simple installation of the collets enables precise set-up and significantly reduces changeover times. The clamping force is set directly on the collet using the face dial wrench.



COLLETS UM10

- Fits in every cartridge of the M10 series
- Same collet can be used on different machines

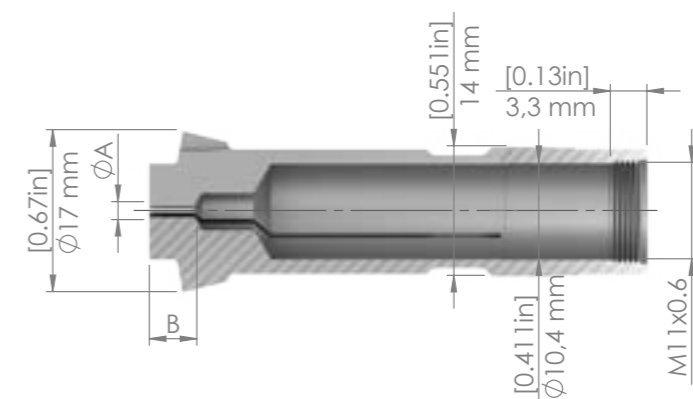


COLLETS UM5

- Fits in every cartridge of the M5 series
- Same collet can be used on different machines

MASA TOOL MICROCONIC COLLET VERSIONS

COLLETS UM10

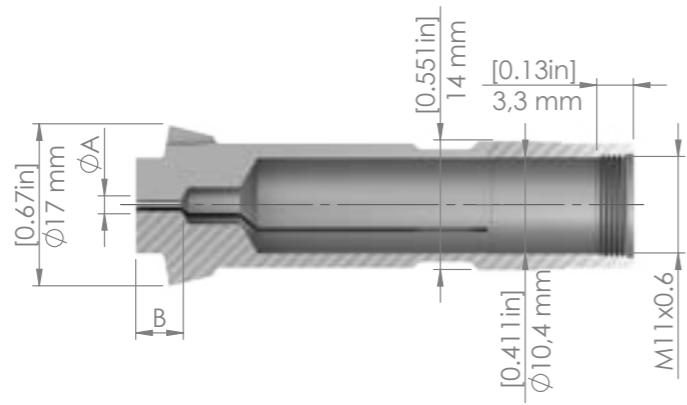


A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|-------------|-----------|---------------|--------|---------|-----|-----|
| mm | inch | | | mm | inch | | |
| 0.25 | 0.22 – 0.27 | .0098 | .0087 – .0106 | 123001 | UM10-25 | 1.6 | .07 |
| 0.28 | 0.25 – 0.30 | .0110 | .0098 – .0118 | 123002 | UM10-28 | 1.6 | .07 |
| 0.31 | 0.28 – 0.33 | .0122 | .0110 – .0130 | 123003 | UM10-31 | 1.6 | .07 |
| 0.34 | 0.31 – 0.36 | .0134 | .0122 – .0142 | 123004 | UM10-34 | 1.6 | .07 |
| 0.37 | 0.34 – 0.39 | .0146 | .0134 – .0154 | 123005 | UM10-37 | 1.8 | .08 |
| 0.4 | 0.35 – 0.43 | .0157 | .0138 – .0169 | 123006 | UM10-40 | 1.9 | .08 |
| 0.45 | 0.40 – 0.48 | .0177 | .0157 – .0189 | 123007 | UM10-45 | 1.9 | .08 |
| 0.5 | 0.45 – 0.53 | .0197 | .0177 – .0209 | 123008 | UM10-50 | 1.9 | .08 |
| 0.55 | 0.50 – 0.58 | .0217 | .0197 – .0228 | 123010 | UM10-55 | 1.9 | .08 |
| 0.6 | 0.55 – 0.63 | .0236 | .0217 – .0248 | 123012 | UM10-60 | 1.9 | .08 |
| 0.65 | 0.60 – 0.68 | .0256 | .0236 – .0268 | 123014 | UM10-65 | 1.9 | .08 |
| 0.7 | 0.65 – 0.73 | .0276 | .0256 – .0287 | 123016 | UM10-70 | 1.9 | .08 |
| 0.75 | 0.70 – 0.78 | .0295 | .0276 – .0307 | 123018 | UM10-75 | 2 | .08 |
| 0.8 | 0.75 – 0.83 | .0315 | .0295 – .0327 | 123020 | UM10-80 | 2 | .08 |
| 0.85 | 0.80 – 0.88 | .0335 | .0315 – .0346 | 123022 | UM10-85 | 2 | .08 |

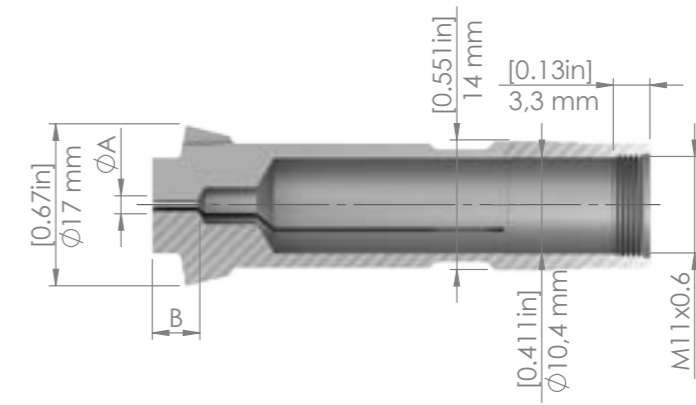
COLLETS UM10



A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|-------------|-----------|---------------|--------|----------|-----|-----|
| mm | inch | | | mm | inch | | |
| 0.9 | 0.85 – 0.93 | .0354 | .0335 – .0366 | 123024 | UM10-90 | 2.5 | .10 |
| 0.95 | 0.90 – 0.98 | .0374 | .0354 – .0386 | 123026 | UM10-95 | 2.5 | .10 |
| 1.0 | 0.95 – 1.03 | .0394 | .0374 – .0406 | 123028 | UM10-100 | 2.8 | .11 |
| 1.05 | 1.00 – 1.08 | .0413 | .0394 – .0425 | 123030 | UM10-105 | 2.8 | .12 |
| 1.1 | 1.05 – 1.13 | .0433 | .0413 – .0445 | 123032 | UM10-110 | 2.8 | .12 |
| 1.15 | 1.10 – 1.18 | .0453 | .0433 – .0465 | 123034 | UM10-115 | 2.8 | .12 |
| 1.2 | 1.15 – 1.23 | .0472 | .0453 – .0484 | 123036 | UM10-120 | 3.4 | .14 |
| 1.25 | 1.20 – 1.28 | .0492 | .0472 – .0504 | 123038 | UM10-125 | 3.4 | .14 |
| 1.3 | 1.25 – 1.33 | .0512 | .0492 – .0524 | 123040 | UM10-130 | 3.4 | .14 |
| 1.35 | 1.30 – 1.38 | .0531 | .0512 – .0543 | 123042 | UM10-135 | 3.9 | .16 |
| 1.4 | 1.35 – 1.43 | .0551 | .0531 – .0563 | 123044 | UM10-140 | 3.9 | .16 |
| 1.45 | 1.40 – 1.48 | .0571 | .0551 – .0583 | 123046 | UM10-145 | 4.5 | .18 |
| 1.5 | 1.45 – 1.53 | .0591 | .0571 – .0602 | 123048 | UM10-150 | 4.5 | .18 |
| 1.55 | 1.50 – 1.58 | .0610 | .0591 – .0622 | 123050 | UM10-155 | 4.5 | .18 |
| 1.6 | 1.55 – 1.63 | .0630 | .0610 – .0642 | 123052 | UM10-160 | 4.5 | .18 |
| 1.65 | 1.60 – 1.68 | .0650 | .0630 – .0661 | 123054 | UM10-165 | 4.8 | .19 |
| 1.7 | 1.65 – 1.73 | .0669 | .0650 – .0681 | 123056 | UM10-170 | 4.8 | .19 |
| 1.75 | 1.70 – 1.78 | .0689 | .0669 – .0701 | 123058 | UM10-175 | 4.8 | .19 |
| 1.8 | 1.75 – 1.83 | .0709 | .0689 – .0720 | 123060 | UM10-180 | 5.3 | .21 |
| 1.85 | 1.80 – 1.88 | .0728 | .0709 – .0740 | 123062 | UM10-185 | 5.3 | .21 |
| 1.9 | 1.85 – 1.93 | .0748 | .0728 – .0760 | 123064 | UM10-190 | 5.9 | .24 |
| 1.95 | 1.90 – 1.98 | .0768 | .0748 – .0780 | 123066 | UM10-195 | 5.9 | .24 |
| 2 | 1.95 – 2.03 | .0787 | .0768 – .0799 | 123068 | UM10-200 | 5.9 | .24 |

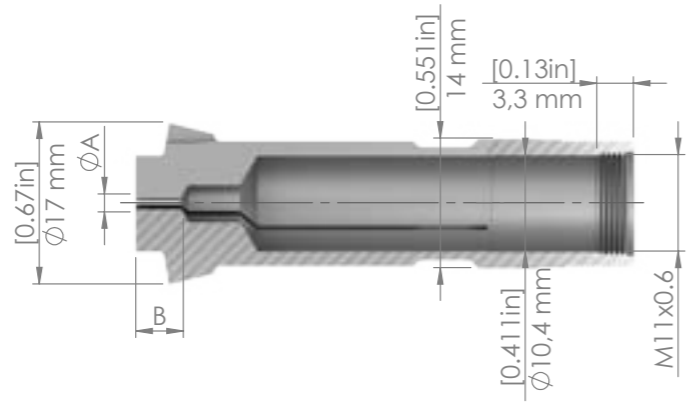


A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|-------------|-----------|---------------|--------|----------|-----|-----|
| mm | inch | | | mm | inch | | |
| 2.05 | 2.00 – 2.08 | .0807 | .0787 – .0819 | 123070 | UM10-205 | 5.9 | .24 |
| 2.1 | 2.05 – 2.13 | .0827 | .0807 – .0839 | 123072 | UM10-210 | 6.4 | .26 |
| 2.15 | 2.10 – 2.18 | .0846 | .0827 – .0858 | 123074 | UM10-215 | 6.4 | .26 |
| 2.2 | 2.15 – 2.23 | .0866 | .0846 – .0878 | 123076 | UM10-220 | 6.5 | .26 |
| 2.25 | 2.20 – 2.28 | .0886 | .0866 – .0898 | 123078 | UM10-225 | 6.7 | .27 |
| 2.3 | 2.25 – 2.33 | .0906 | .0886 – .0917 | 123080 | UM10-230 | 6.7 | .27 |
| 2.35 | 2.30 – 2.38 | .0925 | .0906 – .0937 | 123082 | UM10-235 | 6.8 | .27 |
| 2.4 | 2.35 – 2.43 | .0945 | .0925 – .0957 | 123084 | UM10-240 | 7.3 | .29 |
| 2.45 | 2.40 – 2.48 | .0965 | .0945 – .0976 | 123086 | UM10-245 | 7.3 | .29 |
| 2.5 | 2.45 – 2.53 | .0984 | .0965 – .0996 | 123088 | UM10-250 | 7.8 | .31 |
| 2.55 | 2.50 – 2.58 | .1004 | .0984 – .1016 | 123090 | UM10-255 | 7.8 | .31 |
| 2.6 | 2.55 – 2.63 | .1024 | .1004 – .1035 | 123092 | UM10-260 | 7.8 | .31 |
| 2.65 | 2.60 – 2.68 | .1043 | .1024 – .1055 | 123094 | UM10-265 | 7.9 | .31 |
| 2.7 | 2.65 – 2.73 | .1063 | .1043 – .1075 | 123096 | UM10-270 | 8.4 | .33 |
| 2.75 | 2.70 – 2.78 | .1083 | .1063 – .1094 | 123098 | UM10-275 | 8.4 | .34 |
| 2.8 | 2.75 – 2.83 | .1102 | .1083 – .1114 | 123100 | UM10-280 | 8.9 | .36 |
| 2.85 | 2.80 – 2.88 | .1122 | .1102 – .1134 | 123102 | UM10-285 | 8.9 | .36 |
| 2.9 | 2.85 – 2.93 | .1142 | .1122 – .1154 | 123104 | UM10-290 | 9 | .36 |
| 2.95 | 2.90 – 2.98 | .1161 | .1142 – .1173 | 123106 | UM10-295 | 9.2 | .37 |
| 3 | 2.95 – 3.03 | .1181 | .1161 – .1193 | 123108 | UM10-300 | 9.2 | .37 |
| 3.05 | 3.00 – 3.08 | .1201 | .1181 – .1213 | 123110 | UM10-305 | 9.3 | .37 |
| 3.1 | 3.05 – 3.13 | .1220 | .1201 – .1232 | 123112 | UM10-310 | 9.3 | .37 |
| 3.15 | 3.10 – 3.18 | .1240 | .1220 – .1252 | 123114 | UM10-315 | 9.8 | .39 |

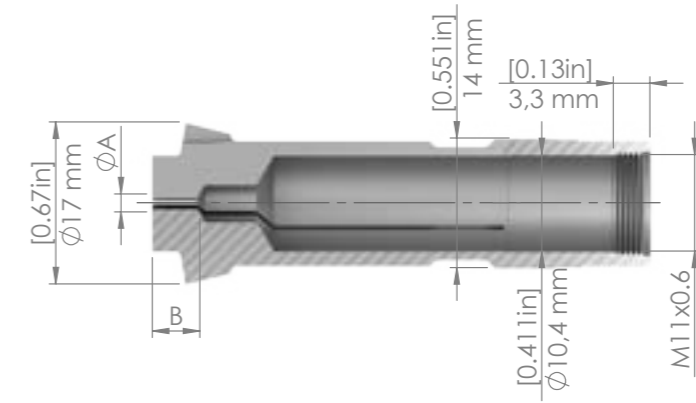
COLLETS UM10



A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|-------------|-----------|---------------|--------|----------|------|------|
| mm | inch | | | mm | inch | | |
| 3.2 | 3.15 – 3.23 | .1260 | .1240 – .1272 | 123116 | UM10-320 | 9.8 | .39 |
| 3.25 | 3.20 – 3.28 | .1280 | .1260 – .1291 | 123118 | UM10-325 | 25.8 | 1.02 |
| 3.3 | 3.25 – 3.33 | .1299 | .1280 – .1311 | 123120 | UM10-330 | 11 | .44 |
| 3.35 | 3.30 – 3.38 | .1319 | .1299 – .1331 | 123122 | UM10-335 | 11 | .44 |
| 3.4 | 3.35 – 3.43 | .1339 | .1319 – .1350 | 123124 | UM10-340 | 11 | .44 |
| 3.45 | 3.40 – 3.48 | .1358 | .1339 – .1370 | 123126 | UM10-345 | 11 | .44 |
| 3.5 | 3.45 – 3.53 | .1378 | .1358 – .1390 | 123128 | UM10-350 | 11 | .44 |
| 3.55 | 3.50 – 3.58 | .1398 | .1378 – .1409 | 123130 | UM10-355 | 11 | .44 |
| 3.6 | 3.55 – 3.63 | .1417 | .1398 – .1429 | 123132 | UM10-360 | 11.1 | .44 |
| 3.65 | 3.60 – 3.68 | .1437 | .1417 – .1449 | 123134 | UM10-365 | 11.1 | .44 |
| 3.7 | 3.65 – 3.73 | .1457 | .1437 – .1469 | 123136 | UM10-370 | 11.1 | .44 |
| 3.75 | 3.70 – 3.78 | .1476 | .1457 – .1488 | 123138 | UM10-375 | 11.1 | .44 |
| 3.8 | 3.75 – 3.83 | .1496 | .1476 – .1508 | 123140 | UM10-380 | 11.1 | .44 |
| 3.85 | 3.80 – 3.88 | .1516 | .1496 – .1528 | 123142 | UM10-385 | 11.1 | .44 |
| 3.9 | 3.85 – 3.93 | .1535 | .1516 – .1547 | 123144 | UM10-390 | 11.2 | .44 |
| 3.95 | 3.90 – 3.98 | .1555 | .1535 – .1567 | 123146 | UM10-395 | 11.2 | .44 |
| 4 | 3.95 – 4.03 | .1575 | .1555 – .1587 | 123148 | UM10-400 | 11.2 | .44 |
| 4.05 | 4.00 – 4.08 | .1594 | .1575 – .1606 | 123150 | UM10-405 | 11.2 | .45 |
| 4.1 | 4.05 – 4.13 | .1614 | .1594 – .1626 | 123152 | UM10-410 | 11.2 | .45 |
| 4.15 | 4.10 – 4.18 | .1634 | .1614 – .1646 | 123154 | UM10-415 | 11.2 | .45 |
| 4.2 | 4.15 – 4.23 | .1654 | .1634 – .1665 | 123156 | UM10-420 | 11.2 | .45 |
| 4.25 | 4.20 – 4.28 | .1673 | .1654 – .1685 | 123158 | UM10-425 | 11.3 | .45 |
| 4.3 | 4.25 – 4.33 | .1693 | .1673 – .1705 | 123160 | UM10-430 | 11.3 | .45 |

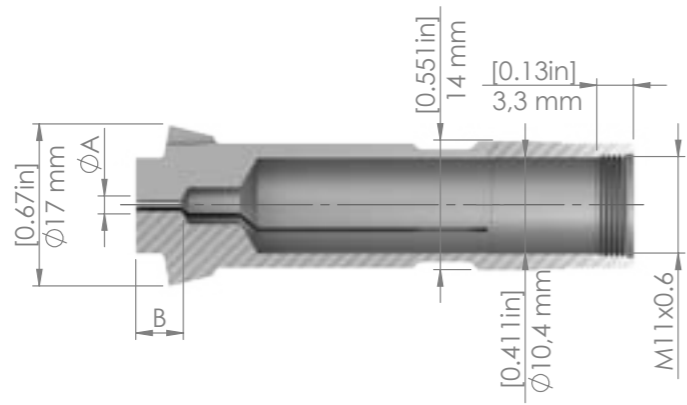


A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|-------------|-----------|---------------|--------|----------|------|-----|
| mm | inch | | | mm | inch | | |
| 4.35 | 4.30 – 4.38 | .1713 | .1693 – .1724 | 123162 | UM10-435 | 11.3 | .45 |
| 4.4 | 4.35 – 4.43 | .1732 | .1713 – .1744 | 123164 | UM10-440 | 11.3 | .45 |
| 4.45 | 4.40 – 4.48 | .1752 | .1732 – .1764 | 123166 | UM10-445 | 11.3 | .45 |
| 4.5 | 4.45 – 4.53 | .1772 | .1752 – .1783 | 123168 | UM10-450 | 11.3 | .45 |
| 4.55 | 4.50 – 4.58 | .1791 | .1772 – .1803 | 123170 | UM10-455 | 11.3 | .45 |
| 4.6 | 4.55 – 4.63 | .1811 | .1791 – .1823 | 123172 | UM10-460 | 11.4 | .45 |
| 4.65 | 4.60 – 4.68 | .1831 | .1811 – .1843 | 123174 | UM10-465 | 11.4 | .45 |
| 4.7 | 4.65 – 4.73 | .1850 | .1831 – .1862 | 123176 | UM10-470 | 11.4 | .45 |
| 4.75 | 4.70 – 4.78 | .1870 | .1850 – .1882 | 123178 | UM10-475 | 11.4 | .45 |
| 4.8 | 4.75 – 4.83 | .1890 | .1870 – .1902 | 123180 | UM10-480 | 11.4 | .45 |
| 4.85 | 4.80 – 4.88 | .1909 | .1890 – .1921 | 123182 | UM10-485 | 11.4 | .45 |
| 4.9 | 4.85 – 4.93 | .1929 | .1909 – .1941 | 123184 | UM10-490 | 11.5 | .46 |
| 4.95 | 4.90 – 4.98 | .1949 | .1929 – .1961 | 123186 | UM10-495 | 11.5 | .46 |
| 5 | 4.95 – 5.03 | .1969 | .1949 – .1980 | 123188 | UM10-500 | 11.5 | .46 |
| 5.05 | 5.00 – 5.08 | .1988 | .1969 – .2000 | 123190 | UM10-505 | 11.5 | .46 |
| 5.1 | 5.05 – 5.13 | .2008 | .1988 – .2020 | 123192 | UM10-510 | 11.5 | .46 |
| 5.15 | 5.10 – 5.18 | .2028 | .2008 – .2039 | 123194 | UM10-515 | 11.5 | .46 |
| 5.2 | 5.15 – 5.23 | .2047 | .2028 – .2059 | 123196 | UM10-520 | 11.5 | .46 |
| 5.25 | 5.20 – 5.28 | .2067 | .2047 – .2079 | 123198 | UM10-525 | 11.5 | .46 |
| 5.3 | 5.25 – 5.33 | .2087 | .2067 – .2098 | 123200 | UM10-530 | 11.6 | .46 |
| 5.35 | 5.30 – 5.38 | .2106 | .2087 – .2118 | 123202 | UM10-535 | 11.6 | .46 |
| 5.4 | 5.35 – 5.43 | .2126 | .2106 – .2138 | 123204 | UM10-540 | 11.6 | .46 |
| 5.45 | 5.40 – 5.48 | .2146 | .2126 – .2157 | 123206 | UM10-545 | 11.6 | .46 |

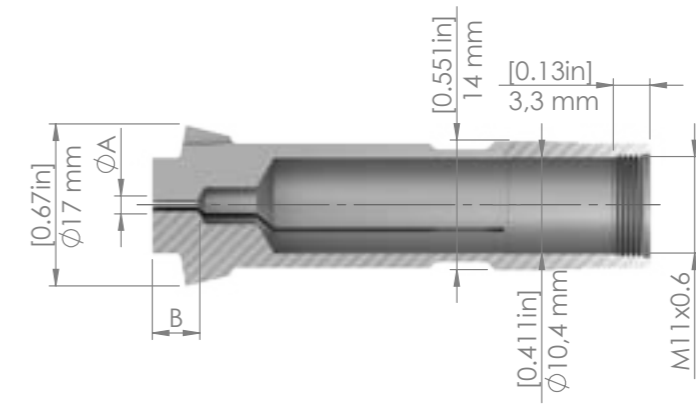
COLLETS UM10



A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|-------------|-----------|---------------|--------|----------|------|-----|
| mm | inch | | | mm | inch | | |
| 5.5 | 5.45 – 5.53 | .2165 | .2146 – .2177 | 123208 | UM10-550 | 11.6 | .46 |
| 5.55 | 5.50 – 5.58 | .2185 | .2165 – .2197 | 123210 | UM10-555 | 11.6 | .46 |
| 5.6 | 5.55 – 5.63 | .2205 | .2185 – .2217 | 123212 | UM10-560 | 11.7 | .46 |
| 5.65 | 5.60 – 5.68 | .2224 | .2205 – .2236 | 123214 | UM10-565 | 11.7 | .46 |
| 5.7 | 5.65 – 5.73 | .2244 | .2224 – .2256 | 123216 | UM10-570 | 11.7 | .46 |
| 5.75 | 5.70 – 5.78 | .2264 | .2244 – .2276 | 123218 | UM10-575 | 11.7 | .47 |
| 5.8 | 5.75 – 5.83 | .2283 | .2264 – .2295 | 123220 | UM10-580 | 11.7 | .47 |
| 5.85 | 5.80 – 5.88 | .2303 | .2283 – .2315 | 123222 | UM10-585 | 11.7 | .47 |
| 5.9 | 5.85 – 5.93 | .2323 | .2303 – .2335 | 123224 | UM10-590 | 11.8 | .47 |
| 5.95 | 5.90 – 5.98 | .2343 | .2323 – .2354 | 123226 | UM10-595 | 11.8 | .47 |
| 6 | 5.95 – 6.03 | .2362 | .2343 – .2374 | 123228 | UM10-600 | 11.8 | .47 |
| 6.05 | 6.00 – 6.08 | .2382 | .2362 – .2394 | 123230 | UM10-605 | 11.8 | .47 |
| 6.1 | 6.05 – 6.13 | .2402 | .2382 – .2413 | 123232 | UM10-610 | 11.8 | .47 |
| 6.15 | 6.10 – 6.18 | .2421 | .2402 – .2433 | 123234 | UM10-615 | 11.8 | .47 |
| 6.2 | 6.15 – 6.23 | .2441 | .2421 – .2453 | 123236 | UM10-620 | 11.8 | .47 |
| 6.25 | 6.20 – 6.28 | .2461 | .2441 – .2472 | 123238 | UM10-625 | 11.9 | .47 |
| 6.3 | 6.25 – 6.33 | .2480 | .2461 – .2492 | 123240 | UM10-630 | 11.9 | .47 |
| 6.35 | 6.30 – 6.38 | .2500 | .2480 – .2512 | 123242 | UM10-635 | 11.9 | .47 |
| 6.4 | 6.35 – 6.43 | .2520 | .2500 – .2531 | 123244 | UM10-640 | 11.9 | .47 |
| 6.45 | 6.40 – 6.48 | .2539 | .2520 – .2551 | 123246 | UM10-645 | 11.9 | .47 |
| 6.5 | 6.45 – 6.53 | .2559 | .2539 – .2571 | 123248 | UM10-650 | 11.9 | .47 |
| 6.55 | 6.50 – 6.58 | .2579 | .2559 – .2591 | 123250 | UM10-655 | 11.9 | .48 |
| 6.6 | 6.55 – 6.63 | .2598 | .2579 – .2610 | 123252 | UM10-660 | 12 | .48 |

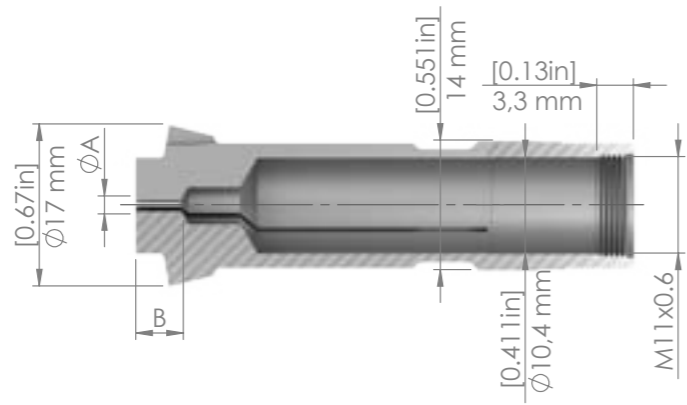


A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|-------------|-----------|---------------|--------|----------|------|-----|
| mm | inch | | | mm | inch | | |
| 6.65 | 6.60 – 6.68 | .2618 | .2598 – .2630 | 123254 | UM10-665 | 12 | .48 |
| 6.7 | 6.65 – 6.73 | .2638 | .2618 – .2650 | 123256 | UM10-670 | 12 | .48 |
| 6.75 | 6.70 – 6.78 | .2657 | .2638 – .2669 | 123258 | UM10-675 | 12 | .48 |
| 6.8 | 6.75 – 6.83 | .2677 | .2657 – .2689 | 123260 | UM10-680 | 12 | .48 |
| 6.85 | 6.80 – 6.88 | .2697 | .2677 – .2709 | 123262 | UM10-685 | 12 | .48 |
| 6.9 | 6.85 – 6.93 | .2717 | .2697 – .2728 | 123264 | UM10-690 | 12 | .48 |
| 6.95 | 6.90 – 6.98 | .2736 | .2717 – .2748 | 123266 | UM10-695 | 12.1 | .48 |
| 7 | 6.95 – 7.03 | .2756 | .2736 – .2768 | 123268 | UM10-700 | 12.1 | .48 |
| 7.05 | 7.00 – 7.08 | .2776 | .2756 – .2787 | 123270 | UM10-705 | 12.1 | .48 |
| 7.1 | 7.05 – 7.13 | .2795 | .2776 – .2807 | 123272 | UM10-710 | 12.1 | .48 |
| 7.15 | 7.10 – 7.18 | .2815 | .2795 – .2827 | 123274 | UM10-715 | 12.1 | .48 |
| 7.2 | 7.15 – 7.23 | .2835 | .2815 – .2846 | 123276 | UM10-720 | 12.1 | .48 |
| 7.25 | 7.20 – 7.28 | .2854 | .2835 – .2866 | 123278 | UM10-725 | 12.2 | .48 |
| 7.3 | 7.25 – 7.33 | .2874 | .2854 – .2886 | 123279 | UM10-730 | 12.2 | .48 |
| 7.35 | 7.30 – 7.38 | .2894 | .2874 – .2906 | 123280 | UM10-735 | 12.2 | .48 |
| 7.4 | 7.35 – 7.43 | .2913 | .2894 – .2925 | 123281 | UM10-740 | 12.2 | .49 |
| 7.45 | 7.40 – 7.48 | .2933 | .2913 – .2945 | 123282 | UM10-745 | 12.2 | .49 |
| 7.5 | 7.45 – 7.53 | .2953 | .2933 – .2965 | 123283 | UM10-750 | 12.2 | .49 |
| 7.55 | 7.50 – 7.58 | .2972 | .2953 – .2984 | 123284 | UM10-755 | 12.2 | .49 |
| 7.6 | 7.55 – 7.63 | .2992 | .2972 – .3004 | 123285 | UM10-760 | 12.3 | .49 |
| 7.65 | 7.60 – 7.68 | .3012 | .2992 – .3024 | 123286 | UM10-765 | 12.3 | .49 |
| 7.7 | 7.65 – 7.73 | .3031 | .3012 – .3043 | 123287 | UM10-770 | 12.3 | .49 |
| 7.75 | 7.70 – 7.78 | .3051 | .3031 – .3063 | 123288 | UM10-775 | 12.3 | .49 |

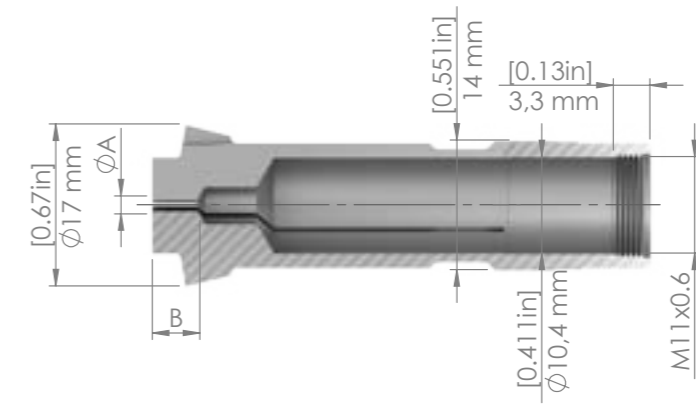
COLLETS UM10



A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|-------------|-----------|---------------|--------|----------|------|-----|
| mm | inch | | | mm | inch | | |
| 7.8 | 7.75 – 7.83 | .3071 | .3051 – .3083 | 123289 | UM10-780 | 12.3 | .49 |
| 7.85 | 7.80 – 7.88 | .3091 | .3071 – .3102 | 123290 | UM10-785 | 12.3 | .49 |
| 7.9 | 7.85 – 7.93 | .3110 | .3091 – .3122 | 123291 | UM10-790 | 12.4 | .49 |
| 7.95 | 7.90 – 7.98 | .3130 | .3110 – .3142 | 123292 | UM10-795 | 12.4 | .49 |
| 8 | 7.95 – 8.03 | .3150 | .3130 – .3161 | 123293 | UM10-800 | 12.4 | .49 |
| 8.05 | 8.00 – 8.08 | .3169 | .3150 – .3181 | 123294 | UM10-805 | 12.4 | .49 |
| 8.1 | 8.05 – 8.13 | .3189 | .3169 – .3201 | 123295 | UM10-810 | 12.4 | .49 |
| 8.15 | 8.10 – 8.18 | .3209 | .3189 – .3220 | 123296 | UM10-815 | 12.4 | .49 |
| 8.2 | 8.15 – 8.23 | .3228 | .3209 – .3240 | 123297 | UM10-820 | 12.4 | .49 |
| 8.25 | 8.20 – 8.28 | .3248 | .3228 – .3260 | 123298 | UM10-825 | 12.5 | .50 |
| 8.3 | 8.25 – 8.33 | .3268 | .3248 – .3280 | 123299 | UM10-830 | 12.5 | .50 |
| 8.35 | 8.30 – 8.38 | .3287 | .3268 – .3299 | 123300 | UM10-835 | 12.5 | .50 |
| 8.4 | 8.35 – 8.43 | .3307 | .3287 – .3319 | 123301 | UM10-840 | 12.5 | .50 |
| 8.45 | 8.40 – 8.48 | .3327 | .3307 – .3339 | 123302 | UM10-845 | 12.5 | .50 |
| 8.5 | 8.45 – 8.53 | .3346 | .3327 – .3358 | 123303 | UM10-850 | 12.5 | .50 |
| 8.55 | 8.50 – 8.58 | .3366 | .3346 – .3378 | 123304 | UM10-855 | 12.5 | .50 |
| 8.6 | 8.55 – 8.63 | .3386 | .3366 – .3398 | 123305 | UM10-860 | 12.6 | .50 |
| 8.65 | 8.60 – 8.68 | .3406 | .3386 – .3417 | 123306 | UM10-865 | 12.6 | .50 |
| 8.7 | 8.65 – 8.73 | .3425 | .3406 – .3437 | 123307 | UM10-870 | 12.6 | .50 |
| 8.75 | 8.70 – 8.78 | .3445 | .3425 – .3457 | 123308 | UM10-875 | 12.6 | .50 |
| 8.8 | 8.75 – 8.83 | .3465 | .3445 – .3476 | 123309 | UM10-880 | 12.6 | .50 |
| 8.85 | 8.80 – 8.88 | .3484 | .3465 – .3496 | 123310 | UM10-885 | 12.6 | .50 |
| 8.9 | 8.85 – 8.93 | .3504 | .3484 – .3516 | 123311 | UM10-890 | 12.7 | .50 |

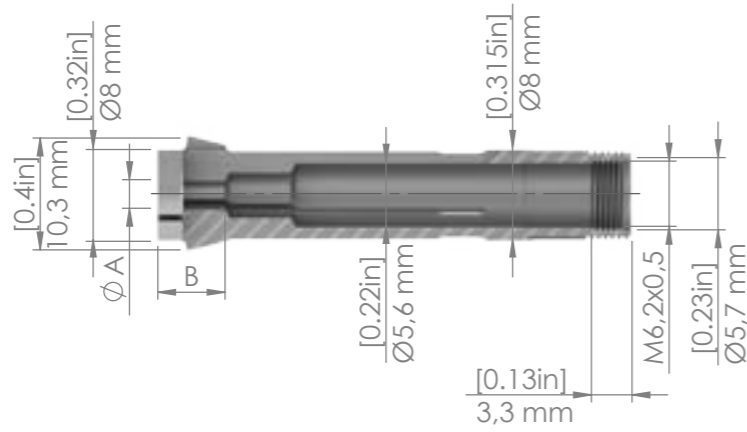


A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|-------|-------------|-----------|---------------|--------|-----------|------|-----|
| mm | inch | | | mm | inch | | |
| 8.95 | 8.90 – 8.98 | .3524 | .3504 – .3535 | 123312 | UM10-895 | 12.7 | .50 |
| 9 | 8.95 – 9.03 | .3543 | .3524 – .3555 | 123313 | UM10-900 | 12.7 | .50 |
| 9.05 | 9.00 – 9.08 | .3563 | .3543 – .3575 | 123314 | UM10-905 | 12.7 | .50 |
| 9.1 | 9.05 – 9.13 | .3583 | .3563 – .3594 | 123315 | UM10-910 | 12.7 | .51 |
| 9.15 | 9.10 – 9.18 | .3602 | .3583 – .3614 | 123316 | UM10-915 | 12.7 | .51 |
| 9.2 | 9.15 – 9.23 | .3622 | .3602 – .3634 | 123317 | UM10-920 | 12.7 | .51 |
| 9.25 | 9.20 – 9.28 | .3642 | .3622 – .3654 | 123318 | UM10-925 | 12.8 | .51 |
| 9.3 | 9.25 – 9.33 | .3661 | .3642 – .3673 | 123319 | UM10-930 | 12.8 | .51 |
| 9.35 | 9.30 – 9.38 | .3681 | .3661 – .3693 | 123320 | UM10-935 | 12.8 | .51 |
| 9.4 | 9.35 – 9.43 | .3701 | .3681 – .3713 | 123321 | UM10-940 | 12.8 | .51 |
| 9.45 | 9.40 – 9.48 | .3720 | .3701 – .3732 | 123322 | UM10-945 | 12.8 | .51 |
| 9.5 | 9.45 – 9.53 | .3740 | .3720 – .3752 | 123323 | UM10-950 | 12.8 | .51 |
| 9.55 | 9.50 – 9.58 | .3760 | .3740 – .3772 | 123324 | UM10-955 | 12.8 | .51 |
| 9.6 | 9.55 – 9.63 | .3780 | .3760 – .3791 | 123325 | UM10-960 | 12.9 | .51 |
| 9.65 | 9.60 – 9.68 | .3799 | .3780 – .3811 | 123326 | UM10-965 | 12.9 | .51 |
| 9.7 | 9.65 – 9.73 | .3819 | .3799 – .3831 | 123327 | UM10-970 | 12.9 | .51 |
| 9.75 | 9.70 – 9.78 | .3839 | .3819 – .3850 | 123328 | UM10-975 | 12.9 | .51 |
| 9.8 | 9.75 – 9.83 | .3858 | .3839 – .3870 | 123329 | UM10-980 | 12.9 | .51 |
| 9.85 | 9.80 – 9.88 | .3878 | .3858 – .3890 | 123330 | UM10-985 | 12.9 | .51 |
| 9.9 | 9.85 – 9.93 | .3898 | .3878 – .3909 | 123331 | UM10-990 | 13 | .51 |
| 9.95 | 9.90 – 9.98 | .3917 | .3898 – .3929 | 123332 | UM10-995 | 13 | .52 |
| 10 | 9.95 – 0.03 | .3937 | .3917 – .3949 | 123333 | UM10-1000 | 13 | .52 |
| 10.15 | 1.10 – 1.18 | .3996 | .3976 – .4008 | 123663 | UM10-1015 | 13 | .52 |

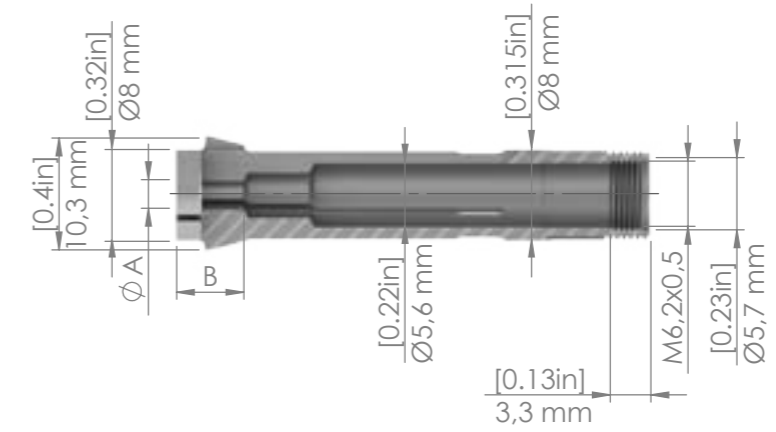
COLLETS UM5



A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | | Item | | B | |
|------|---------------|-----------|---------------|--------|--------|-----|------|
| mm | inch | | | | | mm | inch |
| 0.2 | 0.175 – 0.215 | .0079 | .0069 – .0085 | 124343 | UM5-20 | 1.5 | .07 |
| 0.23 | 0.20 – 0.24 | .0089 | .0079 – .0094 | 124344 | UM5-22 | 1.5 | .07 |
| 0.25 | 0.225 – 0.265 | .0098 | .0089 – .0104 | 124345 | UM5-25 | 1.6 | .07 |
| 0.28 | 0.25 – 0.29 | .0108 | .0098 – .0114 | 124346 | UM5-27 | 1.6 | .07 |
| 0.3 | 0.275 – 0.315 | .0118 | .0108 – .0124 | 124347 | UM5-30 | 1.6 | .07 |
| 0.33 | 0.30 – 0.34 | .0128 | .0118 – .0134 | 124348 | UM5-32 | 1.6 | .07 |
| 0.35 | 0.325 – 0.365 | .0138 | .0128 – .0144 | 124349 | UM5-35 | 1.6 | .07 |
| 0.38 | 0.35 – 0.39 | .0148 | .0138 – .0154 | 124350 | UM5-37 | 2.9 | .12 |
| 0.4 | 0.375 – 0.415 | .0157 | .0148 – .0163 | 124351 | UM5-40 | 2.9 | .12 |
| 0.43 | 0.40 – 0.44 | .0167 | .0157 – .0173 | 124352 | UM5-42 | 2.9 | .12 |
| 0.45 | 0.425 – 0.465 | .0177 | .0167 – .0183 | 124353 | UM5-45 | 2.9 | .12 |
| 0.48 | 0.45 – 0.49 | .0187 | .0177 – .0193 | 124354 | UM5-47 | 2.9 | .12 |
| 0.5 | 0.475 – 0.515 | .0197 | .0187 – .0203 | 124355 | UM5-50 | 2.9 | .12 |
| 0.53 | 0.50 – 0.54 | .0207 | .0197 – .0213 | 124356 | UM5-52 | 2.9 | .12 |
| 0.55 | 0.525 – 0.565 | .0217 | .0207 – .0222 | 124357 | UM5-55 | 2.9 | .12 |
| 0.57 | 0.55 – 0.59 | .0226 | .0217 – .0232 | 124358 | UM5-57 | 2.9 | .12 |
| 0.6 | 0.575 – 0.615 | .0236 | .0226 – .0242 | 124359 | UM5-60 | 2.9 | .12 |
| 0.63 | 0.60 – 0.64 | .0246 | .0236 – .0252 | 124360 | UM5-62 | 2.9 | .12 |
| 0.65 | 0.625 – 0.665 | .0256 | .0246 – .0262 | 124361 | UM5-65 | 2.9 | .12 |
| 0.68 | 0.65 – 0.69 | .0266 | .0256 – .0272 | 124362 | UM5-67 | 2.9 | .12 |
| 0.7 | 0.675 – 0.715 | .0276 | .0266 – .0281 | 124363 | UM5-70 | 2.9 | .12 |
| 0.73 | 0.70 – 0.74 | .0285 | .0276 – .0291 | 124364 | UM5-72 | 3 | .12 |
| 0.75 | 0.725 – 0.765 | .0295 | .0285 – .0301 | 124365 | UM5-75 | 3 | .12 |

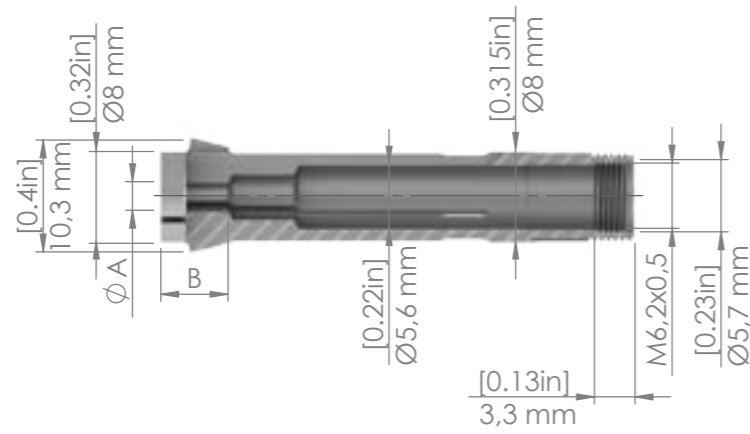


A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | | Item | | B | |
|------|---------------|-----------|---------------|--------|---------|-----|------|
| mm | inch | | | | | mm | inch |
| 0.78 | 0.74 – 0.80 | .0305 | .0291 – .0315 | 124366 | UM5-77 | 3 | .12 |
| 0.8 | 0.765 – 0.825 | .0315 | .0301 – .0325 | 124367 | UM5-80 | 3 | .12 |
| 0.83 | 0.79 – 0.85 | .0325 | .0311 – .0335 | 124368 | UM5-82 | 3 | .12 |
| 0.85 | 0.815 – 0.875 | .0335 | .0321 – .0344 | 124369 | UM5-85 | 3 | .12 |
| 0.88 | 0.84 – 0.90 | .0344 | .0331 – .0354 | 124370 | UM5-87 | 3.3 | .13 |
| 0.9 | 0.865 – 0.925 | .0354 | .0341 – .0364 | 124371 | UM5-90 | 3.3 | .13 |
| 0.93 | 0.89 – 0.95 | .0364 | .0350 – .0374 | 124372 | UM5-92 | 3.3 | .13 |
| 0.95 | 0.915 – 0.975 | .0374 | .0360 – .0384 | 124373 | UM5-95 | 3.3 | .13 |
| 0.98 | 0.94 – 1.00 | .0384 | .0370 – .0394 | 124374 | UM5-97 | 3.3 | .13 |
| 1 | 0.965 – 1.025 | .0394 | .0380 – .0404 | 124375 | UM5-100 | 3.8 | .15 |
| 1.02 | 0.99 – 1.05 | .0404 | .0390 – .0413 | 124376 | UM5-102 | 3.8 | .15 |
| 1.05 | 1.015 – 1.075 | .0413 | .0400 – .0423 | 124377 | UM5-105 | 3.8 | .16 |
| 1.08 | 1.04 – 1.10 | .0423 | .0409 – .0433 | 124378 | UM5-107 | 3.8 | .16 |
| 1.1 | 1.065 – 1.125 | .0433 | .0419 – .0443 | 124379 | UM5-110 | 3.8 | .16 |
| 1.13 | 1.09 – 1.15 | .0443 | .0429 – .0453 | 124380 | UM5-112 | 3.8 | .16 |
| 1.15 | 1.115 – 1.175 | .0453 | .0439 – .0463 | 124381 | UM5-115 | 3.9 | .16 |
| 1.18 | 1.14 – 1.20 | .0463 | .0449 – .0472 | 124382 | UM5-117 | 4.4 | .18 |
| 1.2 | 1.165 – 1.225 | .0472 | .0459 – .0482 | 124383 | UM5-120 | 4.4 | .18 |
| 1.23 | 1.19 – 1.25 | .0482 | .0469 – .0492 | 124384 | UM5-122 | 4.4 | .18 |
| 1.25 | 1.215 – 1.275 | .0492 | .0478 – .0502 | 124385 | UM5-125 | 4.4 | .18 |
| 1.27 | 1.24 – 1.30 | .0502 | .0488 – .0512 | 124386 | UM5-127 | 4.4 | .18 |
| 1.3 | 1.265 – 1.325 | .0512 | .0498 – .0522 | 124387 | UM5-130 | 4.4 | .18 |
| 1.33 | 1.29 – 1.35 | .0522 | .0508 – .0531 | 124388 | UM5-132 | 4.7 | .19 |

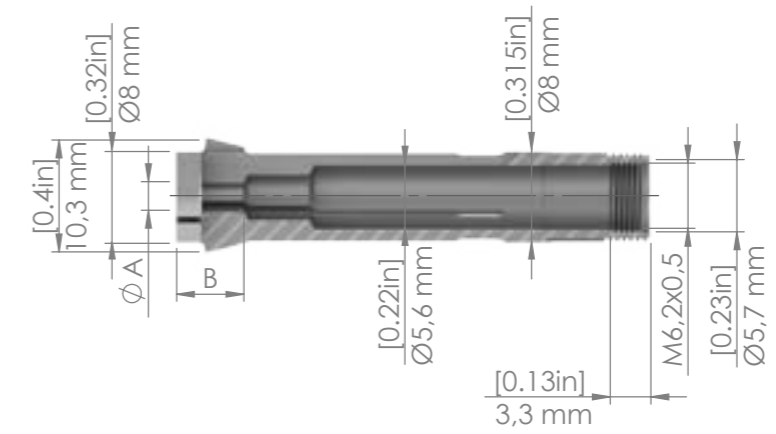
COLLETS UM5



A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|---------------|-----------|---------------|--------|---------|-----|-----|
| mm | inch | | | mm | inch | | |
| 1.35 | 1.315 – 1.375 | .0531 | .0518 – .0541 | 124389 | UM5-135 | 4.7 | .19 |
| 1.38 | 1.34 – 1.40 | .0541 | .0528 – .0551 | 124390 | UM5-137 | 4.7 | .19 |
| 1.4 | 1.365 – 1.425 | .0551 | .0537 – .0561 | 124391 | UM5-140 | 4.7 | .19 |
| 1.43 | 1.39 – 1.45 | .0561 | .0547 – .0571 | 124392 | UM5-142 | 4.7 | .19 |
| 1.45 | 1.415 – 1.475 | .0571 | .0557 – .0581 | 124393 | UM5-145 | 5.3 | .21 |
| 1.48 | 1.44 – 1.50 | .0581 | .0567 – .0591 | 124394 | UM5-147 | 5.3 | .21 |
| 1.5 | 1.465 – 1.525 | .0591 | .0577 – .0600 | 124395 | UM5-150 | 5.3 | .21 |
| 1.53 | 1.49 – 1.55 | .0600 | .0587 – .0610 | 124396 | UM5-152 | 5.3 | .21 |
| 1.55 | 1.515 – 1.575 | .0610 | .0596 – .0620 | 124397 | UM5-155 | 5.3 | .21 |
| 1.58 | 1.54 – 1.60 | .0620 | .0606 – .0630 | 124398 | UM5-157 | 5.3 | .21 |
| 1.6 | 1.565 – 1.625 | .0630 | .0616 – .0640 | 124399 | UM5-160 | 5.3 | .21 |
| 1.63 | 1.59 – 1.65 | .0640 | .0626 – .0650 | 124400 | UM5-162 | 5.5 | .22 |
| 1.65 | 1.615 – 1.675 | .0650 | .0636 – .0659 | 124401 | UM5-165 | 5.5 | .22 |
| 1.68 | 1.64 – 1.70 | .0659 | .0646 – .0669 | 124402 | UM5-167 | 5.5 | .22 |
| 1.7 | 1.665 – 1.725 | .0669 | .0656 – .0679 | 124403 | UM5-170 | 5.5 | .22 |
| 1.73 | 1.69 – 1.75 | .0679 | .0665 – .0689 | 124404 | UM5-172 | 5.6 | .22 |
| 1.75 | 1.715 – 1.775 | .0689 | .0675 – .0699 | 124405 | UM5-175 | 5.6 | .22 |
| 1.78 | 1.74 – 1.80 | .0699 | .0685 – .0709 | 124406 | UM5-177 | 6.1 | .24 |
| 1.8 | 1.765 – 1.825 | .0709 | .0695 – .0719 | 124407 | UM5-180 | 6.1 | .24 |
| 1.83 | 1.79 – 1.85 | .0719 | .0705 – .0728 | 124408 | UM5-182 | 6.1 | .24 |
| 1.85 | 1.815 – 1.875 | .0728 | .0715 – .0738 | 124409 | UM5-185 | 6.1 | .24 |
| 1.88 | 1.84 – 1.90 | .0738 | .0724 – .0748 | 124410 | UM5-187 | 6.4 | .26 |
| 1.9 | 1.865 – 1.925 | .0748 | .0734 – .0758 | 124411 | UM5-190 | 6.4 | .26 |

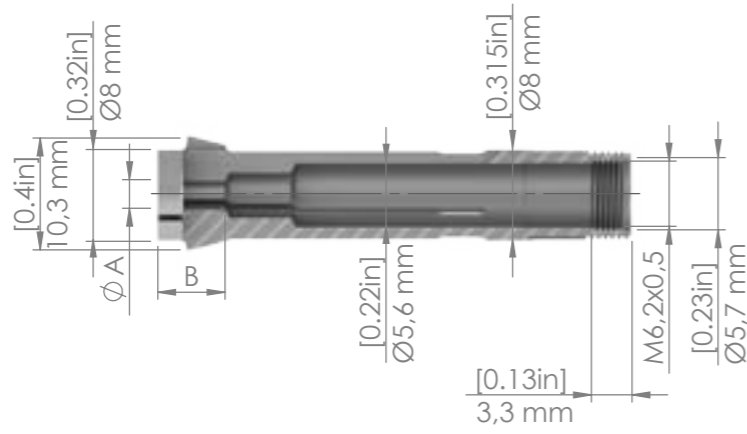


A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|---------------|-----------|---------------|--------|---------|-----|-----|
| mm | inch | | | mm | inch | | |
| 1.93 | 1.89 – 1.95 | .0758 | .0744 – .0768 | 124412 | UM5-192 | 6.4 | .26 |
| 1.95 | 1.915 – 1.975 | .0768 | .0754 – .0778 | 124413 | UM5-195 | 6.4 | .26 |
| 1.98 | 1.94 – 2.00 | .0778 | .0764 – .0787 | 124414 | UM5-197 | 6.4 | .26 |
| 2 | 1.965 – 2.025 | .0787 | .0774 – .0797 | 124415 | UM5-200 | 6.4 | .26 |
| 2.03 | 1.99 – 2.05 | .0797 | .0783 – .0807 | 124416 | UM5-202 | 6.4 | .26 |
| 2.05 | 2.015 – 2.075 | .0807 | .0793 – .0817 | 124417 | UM5-205 | 6.4 | .26 |
| 2.08 | 2.04 – 2.10 | .0817 | .0803 – .0827 | 124418 | UM5-207 | 6.9 | .28 |
| 2.1 | 2.065 – 2.125 | .0827 | .0813 – .0837 | 124419 | UM5-210 | 6.9 | .28 |
| 2.13 | 2.09 – 2.15 | .0837 | .0823 – .0846 | 124420 | UM5-212 | 6.9 | .28 |
| 2.15 | 2.115 – 2.175 | .0846 | .0833 – .0856 | 124421 | UM5-215 | 7 | .28 |
| 2.17 | 2.14 – 2.20 | .0856 | .0843 – .0866 | 124422 | UM5-217 | 7 | .28 |
| 2.2 | 2.165 – 2.225 | .0866 | .0852 – .0876 | 124423 | UM5-220 | 7 | .28 |
| 2.23 | 2.19 – 2.25 | .0876 | .0862 – .0886 | 124424 | UM5-222 | 7.5 | .30 |
| 2.25 | 2.215 – 2.275 | .0886 | .0872 – .0896 | 124425 | UM5-225 | 7.5 | .30 |
| 2.28 | 2.24 – 2.30 | .0896 | .0882 – .0906 | 124426 | UM5-227 | 7.5 | .30 |
| 2.3 | 2.265 – 2.325 | .0906 | .0892 – .0915 | 124427 | UM5-230 | 7.5 | .30 |
| 2.33 | 2.29 – 2.35 | .0915 | .0902 – .0925 | 124428 | UM5-232 | 7.5 | .30 |
| 2.35 | 2.315 – 2.375 | .0925 | .0911 – .0935 | 124429 | UM5-235 | 7.5 | .30 |
| 2.38 | 2.34 – 2.40 | .0935 | .0921 – .0945 | 124430 | UM5-237 | 7.8 | .31 |
| 2.4 | 2.365 – 2.425 | .0945 | .0931 – .0955 | 124431 | UM5-240 | 7.8 | .31 |
| 2.42 | 2.39 – 2.45 | .0955 | .0941 – .0965 | 124432 | UM5-242 | 7.8 | .31 |
| 2.45 | 2.415 – 2.475 | .0965 | .0951 – .0974 | 124433 | UM5-245 | 7.8 | .31 |
| 2.48 | 2.44 – 2.50 | .0974 | .0961 – .0984 | 124434 | UM5-247 | 7.8 | .31 |

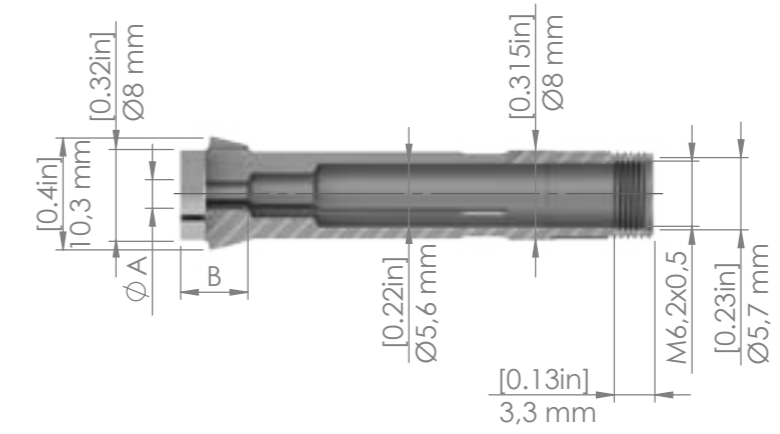
COLLETS UM5



A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|---------------|-----------|---------------|--------|---------|-----|-----|
| mm | inch | | | mm | inch | | |
| 2.5 | 2.465 – 2.525 | .0984 | .0970 – .0994 | 124435 | UM5-250 | 8.3 | .33 |
| 2.53 | 2.49 – 2.55 | .0994 | .0980 – .1004 | 124436 | UM5-252 | 8.3 | .33 |
| 2.55 | 2.515 – 2.575 | .1004 | .0990 – .1014 | 124437 | UM5-255 | 8.3 | .33 |
| 2.58 | 2.54 – 2.60 | .1014 | .1000 – .1024 | 124438 | UM5-257 | 8.3 | .33 |
| 2.6 | 2.565 – 2.625 | .1024 | .1010 – .1033 | 124439 | UM5-260 | 8.4 | .33 |
| 2.63 | 2.59 – 2.65 | .1033 | .1020 – .1043 | 124440 | UM5-262 | 8.4 | .33 |
| 2.65 | 2.615 – 2.675 | .1043 | .1030 – .1053 | 124441 | UM5-265 | 8.4 | .33 |
| 2.68 | 2.64 – 2.70 | .1053 | .1039 – .1063 | 124442 | UM5-267 | 8.9 | .35 |
| 2.7 | 2.665 – 2.725 | .1063 | .1049 – .1073 | 124443 | UM5-270 | 8.9 | .35 |
| 2.73 | 2.69 – 2.75 | .1073 | .1059 – .1083 | 124444 | UM5-272 | 8.9 | .36 |
| 2.75 | 2.715 – 2.775 | .1083 | .1069 – .1093 | 124445 | UM5-275 | 8.9 | .36 |
| 2.78 | 2.74 – 2.80 | .1093 | .1079 – .1102 | 124446 | UM5-277 | 9.2 | .37 |
| 2.8 | 2.765 – 2.825 | .1102 | .1089 – .1112 | 124447 | UM5-280 | 9.2 | .37 |
| 2.83 | 2.79 – 2.85 | .1112 | .1098 – .1122 | 124448 | UM5-282 | 9.2 | .37 |
| 2.85 | 2.815 – 2.875 | .1122 | .1108 – .1132 | 124449 | UM5-285 | 9.2 | .37 |
| 2.88 | 2.84 – 2.90 | .1132 | .1118 – .1142 | 124450 | UM5-287 | 9.2 | .37 |
| 2.9 | 2.865 – 2.925 | .1142 | .1128 – .1152 | 124451 | UM5-290 | 9.2 | .37 |
| 2.93 | 2.89 – 2.95 | .1152 | .1138 – .1161 | 124452 | UM5-292 | 9.5 | .38 |
| 2.95 | 2.915 – 2.975 | .1161 | .1148 – .1171 | 124453 | UM5-295 | 9.5 | .38 |
| 2.98 | 2.94 – 3.00 | .1171 | .1157 – .1181 | 124454 | UM5-297 | 9.5 | .38 |
| 3 | 2.965 – 3.025 | .1181 | .1167 – .1191 | 124455 | UM5-300 | 9.5 | .38 |
| 3.03 | 2.99 – 3.05 | .1191 | .1177 – .1201 | 124456 | UM5-302 | 9.5 | .38 |
| 3.05 | 3.015 – 3.075 | .1201 | .1187 – .1211 | 124457 | UM5-305 | 9.5 | .38 |

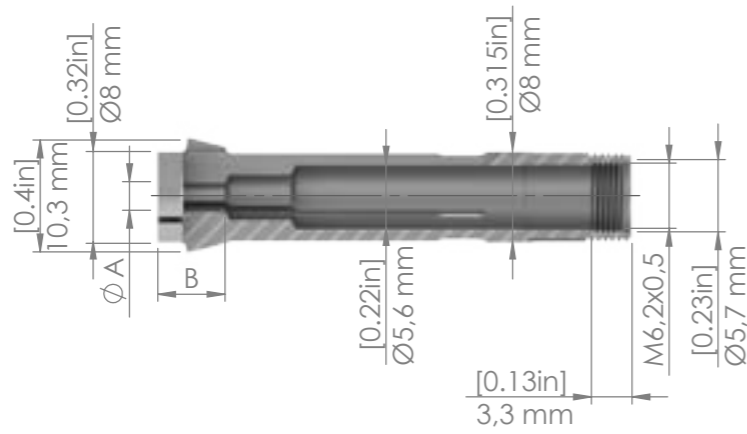


A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|---------------|-----------|---------------|--------|---------|------|-----|
| mm | inch | | | mm | inch | | |
| 3.08 | 3.04 – 3.10 | .1211 | .1197 – .1220 | 124458 | UM5-307 | 9.5 | .38 |
| 3.1 | 3.065 – 3.125 | .1220 | .1207 – .1230 | 124459 | UM5-310 | 9.5 | .38 |
| 3.13 | 3.09 – 3.15 | .1230 | .1217 – .1240 | 124460 | UM5-312 | 10 | .40 |
| 3.15 | 3.115 – 3.175 | .1240 | .1226 – .1250 | 124461 | UM5-315 | 10 | .40 |
| 3.18 | 3.14 – 3.20 | .1250 | .1236 – .1260 | 124462 | UM5-317 | 10 | .40 |
| 3.2 | 3.165 – 3.225 | .1260 | .1246 – .1270 | 124463 | UM5-320 | 10.1 | .40 |
| 3.23 | 3.19 – 3.25 | .1270 | .1256 – .1280 | 124464 | UM5-322 | 10.1 | .40 |
| 3.25 | 3.215 – 3.275 | .1280 | .1266 – .1289 | 124465 | UM5-325 | 10.6 | .42 |
| 3.28 | 3.24 – 3.30 | .1289 | .1276 – .1299 | 124466 | UM5-327 | 10.6 | .42 |
| 3.3 | 3.265 – 3.325 | .1299 | .1285 – .1309 | 124467 | UM5-330 | 10.6 | .42 |
| 3.33 | 3.29 – 3.35 | .1309 | .1295 – .1319 | 124468 | UM5-332 | 10.6 | .42 |
| 3.35 | 3.315 – 3.375 | .1319 | .1305 – .1329 | 124469 | UM5-335 | 10.6 | .42 |
| 3.38 | 3.34 – 3.40 | .1329 | .1315 – .1339 | 124470 | UM5-337 | 10.6 | .42 |
| 3.4 | 3.365 – 3.425 | .1339 | .1325 – .1348 | 124471 | UM5-340 | 10.6 | .42 |
| 3.43 | 3.39 – 3.45 | .1348 | .1335 – .1358 | 124472 | UM5-342 | 10.9 | .43 |
| 3.45 | 3.415 – 3.475 | .1358 | .1344 – .1368 | 124473 | UM5-345 | 10.9 | .43 |
| 3.48 | 3.44 – 3.50 | .1368 | .1354 – .1378 | 124474 | UM5-347 | 10.9 | .43 |
| 3.5 | 3.465 – 3.525 | .1378 | .1364 – .1388 | 124475 | UM5-350 | 10.9 | .43 |
| 3.53 | 3.49 – 3.55 | .1388 | .1374 – .1398 | 124476 | UM5-352 | 10.9 | .43 |
| 3.55 | 3.515 – 3.575 | .1398 | .1384 – .1407 | 124477 | UM5-355 | 10.9 | .43 |
| 3.58 | 3.54 – 3.60 | .1407 | .1394 – .1417 | 124478 | UM5-357 | 10.9 | .44 |
| 3.6 | 3.565 – 3.625 | .1417 | .1404 – .1427 | 124479 | UM5-360 | 11.5 | .46 |
| 3.63 | 3.59 – 3.65 | .1427 | .1413 – .1437 | 124480 | UM5-362 | 11.5 | .46 |

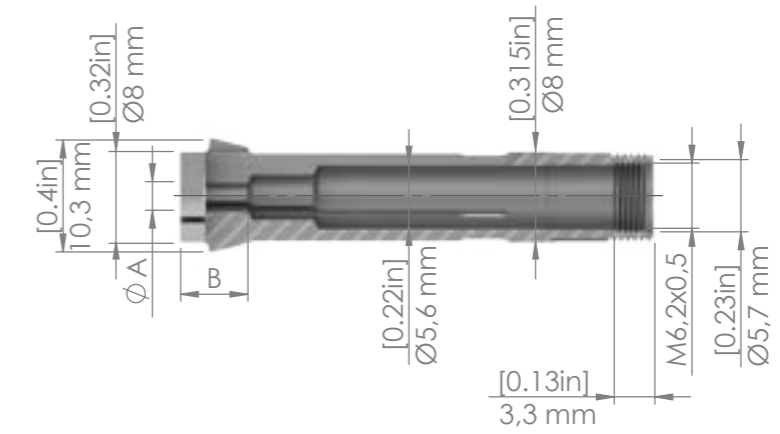
COLLETS UM5



A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | | Item | | B | |
|------|---------------|-----------|---------------|--------|---------|------|------|
| mm | inch | | | | | mm | inch |
| 3.65 | 3.615 – 3.675 | .1437 | .1423 – .1447 | 124481 | UM5-365 | 11.5 | .46 |
| 3.68 | 3.64 – 3.70 | .1447 | .1433 – .1457 | 124482 | UM5-367 | 11.5 | .46 |
| 3.7 | 3.665 – 3.725 | .1457 | .1443 – .1467 | 124483 | UM5-370 | 11.5 | .46 |
| 3.73 | 3.69 – 3.75 | .1467 | .1453 – .1476 | 124484 | UM5-372 | 12 | .48 |
| 3.75 | 3.715 – 3.775 | .1476 | .1463 – .1486 | 124485 | UM5-375 | 12.1 | .48 |
| 3.78 | 3.74 – 3.80 | .1486 | .1472 – .1496 | 124486 | UM5-377 | 12.1 | .48 |
| 3.8 | 3.765 – 3.825 | .1496 | .1482 – .1506 | 124487 | UM5-380 | 12.1 | .48 |
| 3.83 | 3.79 – 3.85 | .1506 | .1492 – .1516 | 124488 | UM5-382 | 12.1 | .48 |
| 3.85 | 3.815 – 3.875 | .1516 | .1502 – .1526 | 124489 | UM5-385 | 12.1 | .48 |
| 3.88 | 3.84 – 3.90 | .1526 | .1512 – .1535 | 124490 | UM5-387 | 12.1 | .48 |
| 3.9 | 3.865 – 3.925 | .1535 | .1522 – .1545 | 124491 | UM5-390 | 12.4 | .49 |
| 3.93 | 3.89 – 3.95 | .1545 | .1531 – .1555 | 124492 | UM5-392 | 12.4 | .49 |
| 3.95 | 3.915 – 3.975 | .1555 | .1541 – .1565 | 124493 | UM5-395 | 12.4 | .49 |
| 3.98 | 3.94 – 4.00 | .1565 | .1551 – .1575 | 124494 | UM5-397 | 12.4 | .49 |
| 4 | 3.965 – 4.025 | .1575 | .1561 – .1585 | 124495 | UM5-400 | 12.4 | .49 |
| 4.03 | 3.99 – 4.05 | .1585 | .1571 – .1594 | 124496 | UM5-402 | 12.4 | .49 |
| 4.05 | 4.015 – 4.075 | .1594 | .1581 – .1604 | 124497 | UM5-405 | 12.9 | .51 |
| 4.08 | 4.04 – 4.10 | .1604 | .1591 – .1614 | 124498 | UM5-407 | 12.9 | .51 |
| 4.1 | 4.065 – 4.125 | .1614 | .1600 – .1624 | 124499 | UM5-410 | 12.9 | .51 |
| 4.13 | 4.09 – 4.15 | .1624 | .1610 – .1634 | 124500 | UM5-412 | 12.9 | .51 |
| 4.15 | 4.115 – 4.175 | .1634 | .1620 – .1644 | 124501 | UM5-415 | 12.9 | .51 |
| 4.18 | 4.14 – 4.20 | .1644 | .1630 – .1654 | 124502 | UM5-417 | 13.2 | .52 |
| 4.2 | 4.165 – 4.225 | .1654 | .1640 – .1663 | 124503 | UM5-420 | 13.2 | .52 |

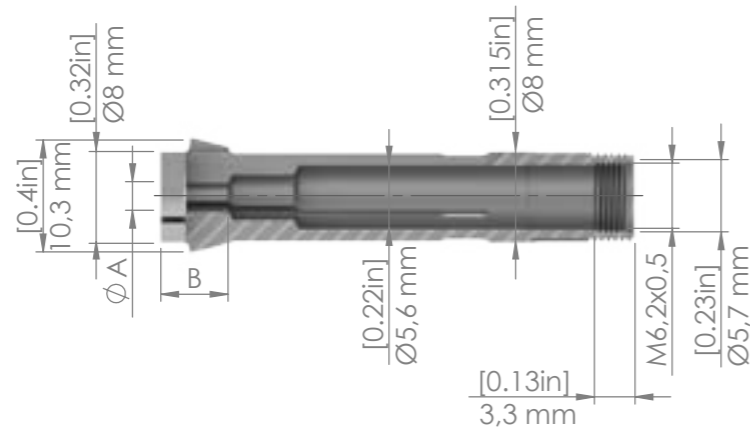


A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | | Item | | B | |
|------|---------------|-----------|---------------|--------|---------|------|------|
| mm | inch | | | | | mm | inch |
| 4.22 | 4.19 – 4.25 | .1663 | .1650 – .1673 | 124504 | UM5-422 | 13.2 | .53 |
| 4.25 | 4.215 – 4.275 | .1673 | .1659 – .1683 | 124505 | UM5-425 | 13.2 | .53 |
| 4.28 | 4.24 – 4.30 | .1683 | .1669 – .1693 | 124506 | UM5-427 | 13.2 | .53 |
| 4.3 | 4.265 – 4.325 | .1693 | .1679 – .1703 | 124507 | UM5-430 | 13.8 | .55 |
| 4.33 | 4.29 – 4.35 | .1703 | .1689 – .1713 | 124508 | UM5-432 | 13.8 | .55 |
| 4.35 | 4.315 – 4.375 | .1713 | .1699 – .1722 | 124509 | UM5-435 | 13.8 | .55 |
| 4.38 | 4.34 – 4.40 | .1722 | .1709 – .1732 | 124510 | UM5-437 | 13.8 | .55 |
| 4.4 | 4.365 – 4.425 | .1732 | .1719 – .1742 | 124511 | UM5-440 | 13.8 | .55 |
| 4.43 | 4.39 – 4.45 | .1742 | .1728 – .1752 | 124512 | UM5-442 | 13.8 | .55 |
| 4.45 | 4.415 – 4.475 | .1752 | .1738 – .1762 | 124513 | UM5-445 | 13.8 | .55 |
| 4.47 | 4.44 – 4.50 | .1762 | .1748 – .1772 | 124514 | UM5-447 | 14.3 | .57 |
| 4.5 | 4.465 – 4.525 | .1772 | .1758 – .1781 | 124515 | UM5-450 | 14.3 | .57 |
| 4.53 | 4.49 – 4.55 | .1781 | .1768 – .1791 | 124516 | UM5-452 | 14.3 | .57 |
| 4.55 | 4.515 – 4.575 | .1791 | .1778 – .1801 | 124517 | UM5-455 | 14.3 | .57 |
| 4.58 | 4.54 – 4.60 | .1801 | .1787 – .1811 | 124518 | UM5-457 | 14.3 | .57 |
| 4.6 | 4.565 – 4.625 | .1811 | .1797 – .1821 | 124519 | UM5-460 | 14.3 | .57 |
| 4.63 | 4.59 – 4.65 | .1821 | .1807 – .1831 | 124520 | UM5-462 | 14.4 | .57 |
| 4.65 | 4.615 – 4.675 | .1831 | .1817 – .1841 | 124521 | UM5-465 | 14.9 | .59 |
| 4.68 | 4.64 – 4.70 | .1841 | .1827 – .1850 | 124522 | UM5-467 | 14.9 | .59 |
| 4.7 | 4.665 – 4.725 | .1850 | .1837 – .1860 | 124523 | UM5-470 | 14.9 | .59 |
| 4.72 | 4.69 – 4.75 | .1860 | .1846 – .1870 | 124524 | UM5-472 | 14.9 | .59 |
| 4.75 | 4.715 – 4.775 | .1870 | .1856 – .1880 | 124525 | UM5-475 | 14.9 | .59 |
| 4.78 | 4.74 – 4.80 | .1880 | .1866 – .1890 | 124526 | UM5-477 | 14.9 | .59 |

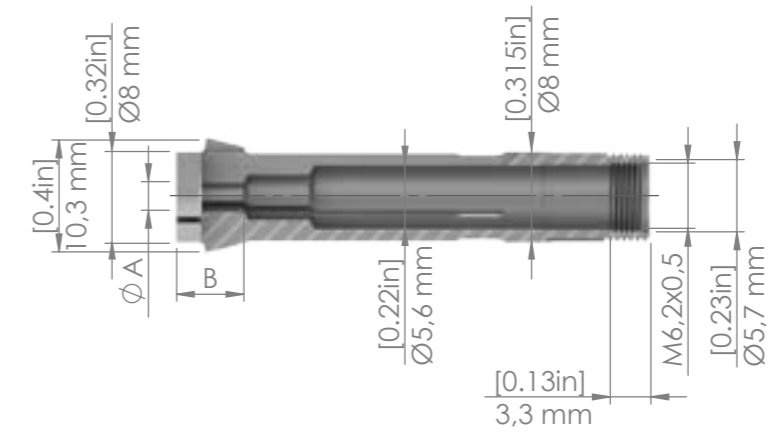
COLLETS UM5



A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|---------------|-----------|---------------|--------|---------|------|-----|
| mm | inch | | | mm | inch | | |
| 4.8 | 4.765 – 4.825 | .1890 | .1876 – .1900 | 124527 | UM5-480 | 14.9 | .59 |
| 4.83 | 4.79 – 4.85 | .1900 | .1886 – .1909 | 124528 | UM5-482 | 14.9 | .59 |
| 4.85 | 4.815 – 4.875 | .1909 | .1896 – .1919 | 124529 | UM5-485 | 14.9 | .59 |
| 4.88 | 4.84 – 4.90 | .1919 | .1906 – .1929 | 124530 | UM5-487 | 14.9 | .59 |
| 4.9 | 4.865 – 4.925 | .1929 | .1915 – .1939 | 124531 | UM5-490 | 15.5 | .61 |
| 4.93 | 4.89 – 4.95 | .1939 | .1925 – .1949 | 124532 | UM5-492 | 15.5 | .61 |
| 4.95 | 4.915 – 4.975 | .1949 | .1935 – .1959 | 124533 | UM5-495 | 15.5 | .61 |
| 4.97 | 4.94 – 5.00 | .1959 | .1945 – .1969 | 124534 | UM5-497 | 15.5 | .61 |
| 5 | 4.965 – 5.025 | .1969 | .1955 – .1978 | 124535 | UM5-500 | 15.5 | .61 |
| 5.03 | 4.99 – 5.05 | .1978 | .1965 – .1988 | 124536 | UM5-502 | 15.5 | .61 |
| 5.05 | 5.015 – 5.075 | .1988 | .1974 – .1998 | 124537 | UM5-505 | 15.5 | .61 |
| 5.08 | 5.04 – 5.10 | .1998 | .1984 – .2008 | 124538 | UM5-507 | 15.5 | .62 |
| 5.1 | 5.065 – 5.125 | .2008 | .1994 – .2018 | 124539 | UM5-510 | 16 | .64 |
| 5.13 | 5.09 – 5.15 | .2018 | .2004 – .2028 | 124540 | UM5-512 | 16 | .64 |
| 5.15 | 5.115 – 5.175 | .2028 | .2014 – .2037 | 124541 | UM5-515 | 16 | .64 |
| 5.18 | 5.14 – 5.20 | .2037 | .2024 – .2047 | 124542 | UM5-517 | 16 | .64 |
| 5.2 | 5.165 – 5.225 | .2047 | .2033 – .2057 | 124543 | UM5-520 | 16.1 | .64 |
| 5.23 | 5.19 – 5.25 | .2057 | .2043 – .2067 | 124544 | UM5-522 | 16.1 | .64 |
| 5.25 | 5.215 – 5.275 | .2067 | .2053 – .2077 | 124545 | UM5-525 | 16.1 | .64 |
| 5.28 | 5.24 – 5.30 | .2077 | .2063 – .2087 | 124546 | UM5-527 | 16.1 | .64 |
| 5.3 | 5.265 – 5.325 | .2087 | .2073 – .2096 | 124547 | UM5-530 | 16.1 | .64 |
| 5.33 | 5.29 – 5.35 | .2096 | .2083 – .2106 | 124548 | UM5-532 | 16.1 | .64 |
| 5.35 | 5.315 – 5.375 | .2106 | .2093 – .2116 | 124549 | UM5-535 | 16.6 | .66 |



A Part Size Range-Ø

B Clamping surface length

| Ø A | | Order no. | Item | B | | | |
|------|---------------|-----------|---------------|--------|---------|------|------|
| mm | inch | | | mm | inch | | |
| 5.38 | 5.34 – 5.40 | .2116 | .2102 – .2126 | 124550 | UM5-537 | 16.6 | .66 |
| 5.4 | 5.365 – 5.425 | .2126 | .2112 – .2136 | 124551 | UM5-540 | 16.6 | .66 |
| 5.43 | 5.39 – 5.45 | .2136 | .2122 – .2146 | 124552 | UM5-542 | 16.6 | .66 |
| 5.45 | 5.415 – 5.475 | .2146 | .2132 – .2156 | 124553 | UM5-545 | 16.6 | .66 |
| 5.48 | 5.44 – 5.50 | .2156 | .2142 – .2165 | 124554 | UM5-547 | 25.5 | 1.01 |
| 5.5 | 5.465 – 5.525 | .2165 | .2152 – .2175 | 124555 | UM5-550 | 25.5 | 1.01 |

MASA TOOL MICROCONIC OVERGRIP COLLETS



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF MASA TOOL MICROCONIC OVERGRIP COLLETS

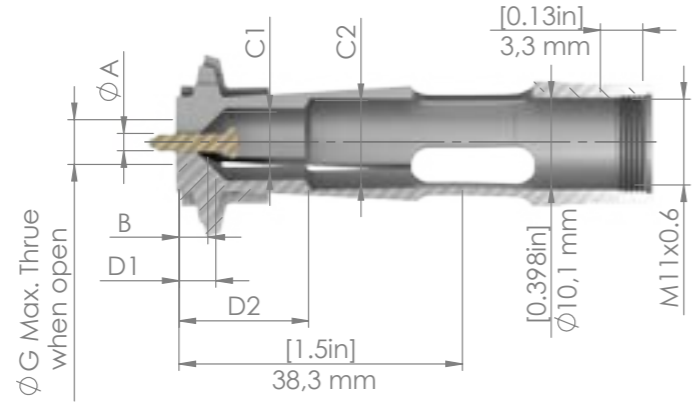
The overgrip collets are used in the sub spindle when the diameter to be clamped is smaller than the diameter to be overgripped. With the overgrip collets, a diameter difference of up to 4 mm can be overgripped, thus reduces cycle time. As standard, they have a runout of less than 5µ and are always supplied with an ejection guide sleeve.

| | |
|--|--|
| | <p>OVERGRIP COLLET UM10 W-TYPE</p> <ul style="list-style-type: none"> • Available from Ø0.45 – 7.2 mm • Diameter difference of approx. 4 mm can be overgripped • Clamping surface length of approx. 1x D • Compatible with all M10 cartridges |
| | <p>OVERGRIP COLLET UM10 T-TYPE</p> <ul style="list-style-type: none"> • Available from Ø1.55 – 7.2 mm • Clamping surface length of approx. 2x – 3x D • Compatible with all M10 cartridges |
| | <p>OVERGRIP COLLET UM10 V-TYPE</p> <ul style="list-style-type: none"> • Available from Ø4.2 – 8.2 mm • Ideal for workpieces with larger diameter • Compatible with all M10 cartridges |

MASA TOOL MICROCONIC OVERGRIP COLLET VERSIONS

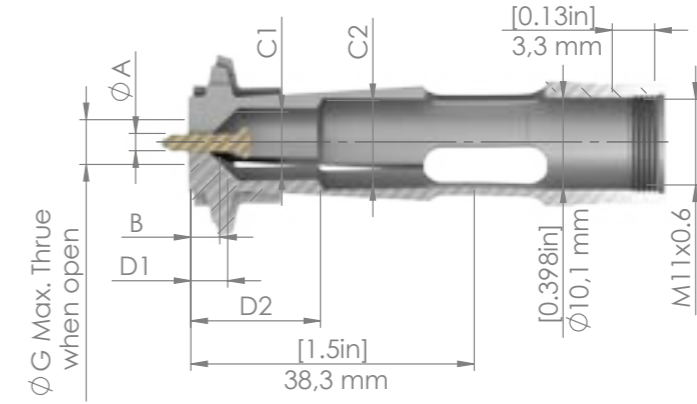
| | |
|--|---|
| | <p>OVERGRIP COLLET UM5 W-TYPE</p> <ul style="list-style-type: none"> • Available from Ø0.2 – 3.95 mm • Compatible with M5 cartridges |
| | <p>OVERGRIP COLLET UM5 T-TYPE</p> <ul style="list-style-type: none"> • Available from Ø0.9 – 3.95 mm • Compatible with M5 cartridges |
| | <p>OVERGRIP COLLET UM5 V-TYPE</p> <ul style="list-style-type: none"> • Available from Ø1.7 – 4.95 mm • Compatible with M5 cartridges |

OVERGRIP COLLETS UM10



- A Part Size Range-Ø G Overgrip-Ø B Clamping surface length C1 Thru bore-1-Ø
 D1 Clamping surface length+chamfer C2 Thru bore-2-Ø D2 Thru length C2

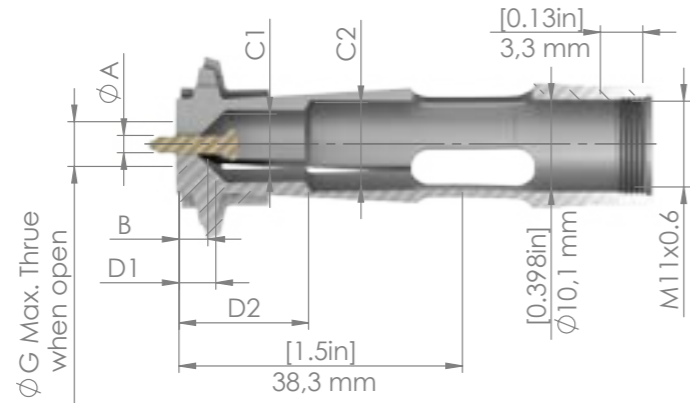
| Ø A | | Order no. | Item | Ø G max | | B | | Ø C1 | | D1 | | Ø C2 | | D2 | |
|------|-------------|-----------|---------------|------------------|------------------------|------------|------------|------------|------------|------------|------------|------------|------------|-------------|------------|
| mm | inch | | | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch |
| 2.3 | 2.25 – 2.33 | .0906 | .0886 – .0917 | 123081 123353 | UM10W-230 UM10T-230 | 3 6.5 | .12 .26 | 7.2 6.9 | .28 .27 | 7.4 7.5 | .29 .29 | 5.6 7.6 | .22 .39 | 9.9 17.1 | .38 .68 |
| 2.35 | 2.30 – 2.38 | .0925 | .0906 – .0937 | 123083 123354 | UM10W-235 UM10T-235 | 3.1 6.5 | .13 .26 | 7.3 7 | .28 .27 | 7.4 7.5 | .29 .29 | 5.6 7.6 | .22 .30 | 9.9 9.9 | .38 .39 |
| 2.4 | 2.35 – 2.43 | .0945 | .0925 – .0957 | 123085 123355 | UM10W-240 UM10T-240 | 3.1 6.5 | .13 .26 | 7.3 7 | .28 .27 | 7.4 7.5 | .29 .29 | 5.6 7.6 | .22 .30 | 9.9 9.9 | .38 .38 |
| 2.45 | 2.40 – 2.48 | .0965 | .0945 – .0976 | 123087 123356 | UM10W-245 UM10T-245 | 3.1 7.1 | .13 .29 | 7.4 7 | .28 .27 | 7.4 7.5 | .29 .29 | 5.6 8.2 | .22 .32 | 9.9 9.9 | .38 .38 |
| 2.5 | 2.45 – 2.53 | .0984 | .0965 – .0996 | 123089 123357 | UM10W-250 UM10T-250 | 3.2 7.1 | .13 .29 | 7.4 7 | .29 .27 | 7.4 7.5 | .29 .29 | 5.6 8.2 | .22 .32 | 9.9 9.9 | .38 .38 |
| 2.55 | 2.50 – 2.58 | .1004 | .0984 – .1016 | 123091 123358 | UM10W-255 UM10T-255 | 3.2 7.1 | .13 .29 | 7.4 7 | .29 .27 | 7.4 7.5 | .29 .29 | 5.6 8.2 | .22 .32 | 9.9 9.9 | .38 .39 |
| 2.6 | 2.55 – 2.63 | .1024 | .1004 – .1035 | 123093 123359 | UM10W-260 UM10T-260 | 3.2 7.2 | .13 .29 | 7.4 7 | .29 .27 | 7.4 7.5 | .29 .29 | 5.6 8.2 | .22 .32 | 9.9 9.9 | .38 .39 |
| 2.65 | 2.60 – 2.68 | .1043 | .1024 – .1055 | 123095 123360 | UM10W-265 UM10T-265 | 3.2 7.2 | .13 .29 | 7.5 7 | .29 .28 | 7.4 7.5 | .29 .29 | 5.6 8.2 | .22 .32 | 9.9 9.9 | .38 .39 |
| 2.7 | 2.65 – 2.73 | .1063 | .1043 – .1075 | 123097 123361 | UM10W-270 UM10T-270 | 3.2 7.2 | .13 .29 | 7.5 7.2 | .29 .28 | 7.4 7.5 | .29 .29 | 5.6 8.2 | .22 .32 | 9.9 9.9 | .38 .39 |
| 2.75 | 2.70 – 2.78 | .1083 | .1063 – .1094 | 123099 123362 | UM10W-275 UM10T-275 | 3.3 7.7 | .13 .31 | 7.6 7.1 | .29 .27 | 7.4 7.5 | .29 .29 | 5.6 8.7 | .22 .34 | 9.9 9.9 | .38 .38 |
| 2.8 | 2.75 – 2.83 | .1102 | .1083 – .1114 | 123101 123363 | UM10W-280 UM10T-280 | 3.3 7.7 | .13 .31 | 7.6 7.1 | .29 .28 | 7.4 7.5 | .29 .29 | 5.6 8.7 | .22 .34 | 9.9 9.9 | .38 .38 |
| 2.85 | 2.80 – 2.88 | .1122 | .1102 – .1134 | 123103 123364 | UM10W-285 UM10T-285 | 3.3 7.7 | .14 .31 | 7.6 7.2 | .30 .28 | 7.4 7.5 | .29 .29 | 5.6 8.7 | .22 .34 | 9.9 9.9 | .38 .39 |
| 2.9 | 2.85 – 2.93 | .1142 | .1122 – .1154 | 123105 123365 | UM10W-290 UM10T-290 | 3.3 7.8 | .14 .31 | 7.7 7.2 | .30 .28 | 7.4 7.5 | .29 .29 | 5.6 8.7 | .22 .34 | 9.9 9.9 | .38 .39 |
| 2.95 | 2.90 – 2.98 | .1161 | .1142 – .1173 | 123107 123366 | UM10W-295 UM10T-295 | 3.4 7.8 | .14 .31 | 7.7 7.3 | .30 .28 | 7.4 7.5 | .29 .29 | 5.6 8.7 | .22 .34 | 9.9 9.9 | .38 .39 |
| 3 | 2.95 – 3.03 | .1181 | .1161 – .1193 | 123109 123367 | UM10W-300 UM10T-300 | 3.4 8.3 | .14 .33 | 7.7 7.2 | .30 .28 | 7.4 7.5 | .29 .29 | 5.6 9.2 | .22 .36 | 9.9 9.9 | .38 .38 |
| 3.05 | 3.00 – 3.08 | .1201 | .1181 – .1213 | 123111 123368 | UM10W-305 UM10T-305 | 3.4 8.3 | .14 .33 | 7.8 7.3 | .30 .28 | 7.4 7.5 | .29 .29 | 5.6 9.2 | .22 .36 | 9.9 9.9 | .38 .38 |



- A Part Size Range-Ø G Overgrip-Ø B Clamping surface length C1 Thru bore-1-Ø
 D1 Clamping surface length+chamfer C2 Thru bore-2-Ø D2 Thru length C2

| Ø A | | Order no. | Item | Ø G max | | B | | Ø C1 | | D1 | | Ø C2 | | D2 | |
|------|-------------|-----------|---------------|------------------|------------------------|------------|------------|------------|------------|------------|------------|-------------|------------|------------|------------|
| mm | inch | | | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch |
| 3.1 | 3.05 – 3.13 | .1220 | .1201 – .1232 | 123113 123369 | UM10W-310 UM10T-310 | 3.5 8.3 | .14 .33 | 7.8 7.3 | .30 .28 | 7.4 7.5 | .29 .29 | 5.6 9.2 | .22 .36 | 9.9 9.9 | .38 .38 |
| 3.15 | 3.10 – 3.18 | .1240 | .1220 – .1252 | 123115 123370 | UM10W-315 UM10T-315 | 3.5 8.3 | .14 .33 | 7.9 7.3 | .30 .28 | 7.4 7.5 | .29 .29 | 5.6 9.2 | .22 .36 | 9.9 9.9 | .38 .38 |
| 3.2 | 3.15 – 3.23 | .1260 | .1240 – .1272 | 123117 123371 | UM10W-320 UM10T-320 | 3.5 8.3 | .14 .33 | 7.9 7.4 | .30 .29 | 7.4 7.5 | .29 .29 | 5.6 9.2 | .22 .36 | 9.9 9.9 | .38 .39 |
| 3.25 | 3.20 – 3.28 | .1280 | .1260 – .1291 | 123119 123372 | UM10W-325 UM10T-325 | 3.5 8.3 | .14 .33 | 7.9 7.4 | .30 .29 | 7.4 7.5 | .29 .29 | 5.6 9.2 | .22 .36 | 9.9 9.9 | .38 .39 |
| 3.3 | 3.25 – 3.33 | .1299 | .1280 – .1311 | 123121 123373 | UM10W-330 UM10T-330 | 3.6 8.9 | .14 .35 | 8 7.4 | .31 .29 | 7.4 7.5 | .29 .29 | 5.6 9.7 | .22 .38 | 9.9 9.9 | .38 .38 |
| 3.35 | 3.30 – 3.38 | .1319 | .1299 – .1331 | 123123 123374 | UM10W-335 UM10T-335 | 3.6 8.9 | .15 .35 | 8 7.4 | .31 .29 | 7.4 7.5 | .29 .29 | 5.6 9.7 | .22 .38 | 9.9 9.9 | .38 .38 |
| 3.4 | 3.35 – 3.43 | .1339 | .1319 – .1350 | 123125 123375 | UM10W-340 UM10T-340 | 3.6 8.9 | .15 .35 | 8 7.5 | .31 .29 | 7.4 7.5 | .29 .29 | 5.6 9.7 | .22 .38 | 9.9 9.9 | .38 .38 |
| 3.45 | 3.40 – 3.48 | .1358 | .1339 – .1370 | 123127 123376 | UM10W-345 UM10T-345 | 3.6 8.9 | .15 .35 | 8.1 7.5 | .31 .29 | 7.4 7.5 | .29 .29 | 5.6 9.7 | .22 .38 | 9.9 9.9 | .38 .38 |
| 3.5 | 3.45 – 3.53 | .1378 | .1358 – .1390 | 123129 123377 | UM10W-350 UM10T-350 | 3.6 8.9 | .15 .35 | 8.1 7.5 | .31 .29 | 7.4 7.5 | .29 .29 | 5.6 9.7 | .22 .38 | 9.9 9.9 | .38 .39 |
| 3.55 | 3.50 – 3.58 | .1398 | .1378 – .1409 | 123131 123378 | UM10W-355 UM10T-355 | 3.7 8.9 | .15 .36 | 8.1 7.6 | .32 .29 | 7.4 7.5 | .29 .29 | 5.6 9.7 | .22 .38 | 9.9 9.9 | .38 .39 |
| 3.6 | 3.55 – 3.63 | .1417 | .1398 – .1429 | 123133 123379 | UM10W-360 UM10T-360 | 3.7 8.9 | .15 .36 | 8.2 7.6 | .32 .29 | 7.4 7.5 | .29 .29 | 5.6 9.7 | .22 .38 | 9.9 9.9 | .38 .39 |
| 3.65 | 3.60 – 3.68 | .1437 | .1417 – .1449 | 123135 123380 | UM10W-365 UM10T-365 | 3.7 9.5 | .15 .38 | 8.2 7.5 | .32 .29 | 7.4 7.5 | .29 .29 | 5.6 10.3 | .22 .41 | 9.9 9.9 | .38 .39 |
| 3.7 | 3.65 – 3.73 | .1457 | .1437 – .1469 | 123137 123381 | UM10W-370 UM10T-370 | 3.7 9.5 | .15 .38 | 8.3 7.6 | .32 .29 | 7.4 7.5 | .29 .29 | 5.6 10.3 | .22 .41 | 9.9 9.9 | .38 .39 |
| 3.75 | 3.70 – 3.78 | .1476 | .1457 – .1488 | 123139 123382 | UM10W-375 UM10T-375 | 3.8 9.5 | .15 .38 | 8.3 7.6 | .32 .30 | 7.4 7.5 | .29 .29 | 5.6 10.3 | .22 .41 | 9.9 9.9 | .38 .39 |
| 3.8 | 3.75 – 3.83 | .1496 | .1476 – .1508 | 123141 123383 | UM10W-380 UM10T-380 | 3.8 9.6 | .15 .38 | 8.3 7.7 | .32 .30 | 7.4 7.5 | .29 .29 | 5.6 10.3 | .22 .41 | 9.9 9.9 | .38 .39 |
| 3.85 | 3.80 – 3.88 | .1516 | .1496 – .1528 | 123143 123384 | UM10W-385 UM10T-385 | 3.8 9.6 | .15 .38 | 8.4 7.7 | .32 .30 | 7.4 7.5 | .29 .29 | 5.6 10.3 | .22 .41 | 9.9 9.9 | .38 .39 |

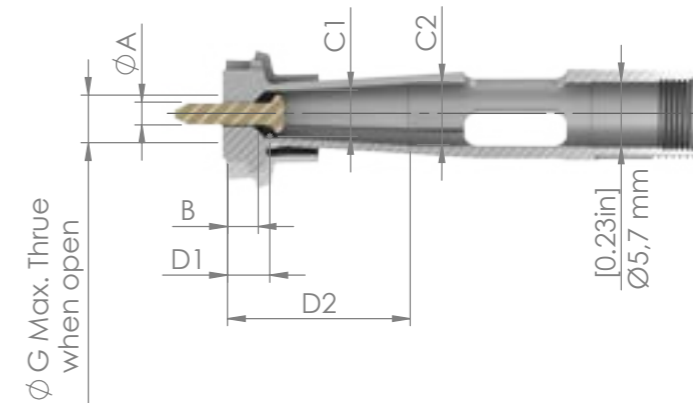
OVERGRIP COLLETS UM10



- A Part Size Range-Ø
- G Overgrip-Ø
- B Clamping surface length
- C1 Thru bore-1-Ø
- D1 Clamping surface length+chamfer
- C2 Thru bore-2-Ø
- D2 Thru length C2

| Ø A | | Order no. | Item | Ø G max | | B | | Ø C1 | | D1 | | Ø C2 | | D2 | | | |
|------|-------------|-----------|---------------|---------|-----------|-----|------|------|------|-----|------|------|------|-----|------|------|------|
| mm | inch | | | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | | |
| 7.8 | 7.75 – 7.83 | .3071 | .3051 – .3083 | 123500 | UM10V-780 | 5.8 | .23 | 10.1 | .39 | 9.2 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 7.85 | 7.80 – 7.88 | .3091 | .3071 – .3102 | 123501 | UM10V-785 | 5.8 | .23 | 10.1 | .39 | 9.2 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 7.9 | 7.85 – 7.93 | .3110 | .3091 – .3122 | 123502 | UM10V-790 | 5.8 | .23 | 10.2 | .40 | 9.2 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 7.95 | 7.90 – 7.98 | .3130 | .3110 – .3142 | 123503 | UM10V-795 | 5.9 | .23 | 10.2 | .40 | 9.2 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8 | 7.95 – 8.03 | .3150 | .3130 – .3161 | 123504 | UM10V-800 | 5.9 | .24 | 10.3 | .40 | 9.2 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8.1 | 8.00 – 8.08 | .3169 | .3150 – .3181 | 123505 | UM10V-805 | 5.9 | .24 | 10.3 | .40 | 9.3 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8.15 | 8.05 – 8.13 | .3189 | .3169 – .3201 | 123506 | UM10V-810 | 5.9 | .24 | 10.4 | .40 | 9.3 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8.2 | 8.10 – 8.18 | .3209 | .3189 – .3220 | 123507 | UM10V-815 | 5.9 | .24 | 10.4 | .40 | 9.3 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8.25 | 8.15 – 8.23 | .3228 | .3209 – .3240 | 123508 | UM10V-820 | 6 | .24 | 10.5 | .41 | 9.3 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8.3 | 8.20 – 8.28 | .3248 | .3228 – .3260 | 123534 | UM10V-825 | 6 | .24 | 10.5 | .41 | 9.2 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8.35 | 8.25 – 8.33 | .3268 | .3248 – .3280 | 123535 | UM10V-830 | 6 | .24 | 10.6 | .41 | 9.2 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8.4 | 8.30 – 8.38 | .3287 | .3268 – .3299 | 123536 | UM10V-835 | 6.1 | .24 | 10.6 | .41 | 9.2 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8.45 | 8.40 – 8.48 | .3327 | .3307 – .3339 | 123538 | UM10V-845 | 6.1 | .24 | 10.7 | .42 | 9.2 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8.5 | 8.45 – 8.53 | .3346 | .3327 – .3358 | 123539 | UM10V-850 | 6.1 | .25 | 10.7 | .42 | 9.3 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8.55 | 8.50 – 8.58 | .3366 | .3346 – .3378 | 123540 | UM10V-850 | 6.1 | .25 | 10.8 | .42 | 9.3 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8.6 | 8.55 – 8.63 | .3386 | .3366 – .3398 | 123541 | UM10V-860 | 6.2 | .25 | 10.8 | .42 | 9.3 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8.65 | 8.60 – 8.68 | .3406 | .3386 – .3417 | 123542 | UM10V-865 | 6.2 | .25 | 10.9 | .42 | 9.3 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 8.75 | 8.70 – 8.78 | .3445 | .3425 – .3457 | 123653 | UM10V-875 | 6.3 | .25 | 11 | .43 | 9.2 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 9 | 8.95 – 9.03 | .3543 | .3524 – .3555 | 123557 | UM10V-900 | 6.4 | .26 | 11.2 | .44 | 9.2 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |
| 9.05 | 9.00 – 9.08 | .3563 | .3543 – .3575 | 123558 | UM10V-905 | 6.4 | .26 | 11.2 | .44 | 9.2 | .36 | 6.5 | .26 | 9.9 | .39 | 25.7 | 1.01 |

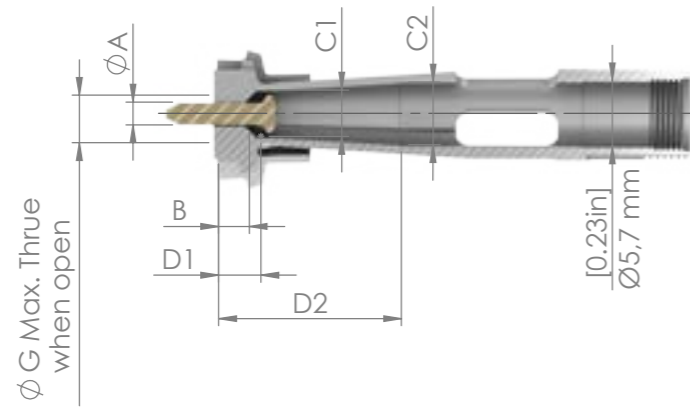
OVERGRIP COLLETS UM5



- A Part Size Range-Ø
- G Overgrip-Ø
- B Clamping surface length
- C1 Thru bore-1-Ø
- D1 Clamping surface length+chamfer
- C2 Thru bore-2-Ø
- D2 Thru length C2

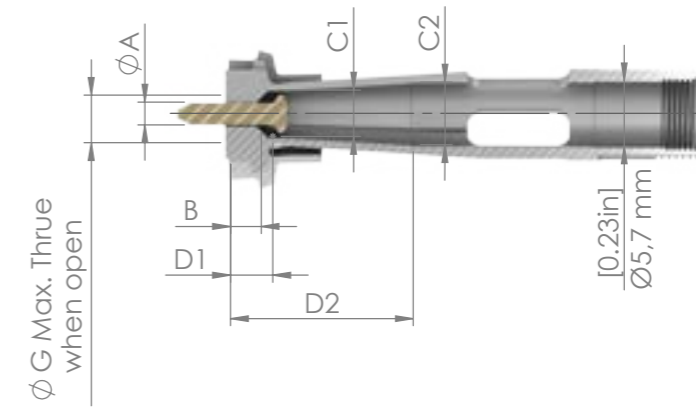
| Ø A | | Order no. | Item | Ø G max | | B | | Ø C1 | | D1 | | Ø C2 | | D2 | | | |
|------|---------------|-----------|---------------|---------|---------|-----|------|------|------|-----|------|------|------|-----|------|------|-----|
| mm | inch | | | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | | |
| 0.2 | 0.175 – 0.215 | .0079 | .0069 – .0085 | 124558 | UM5W-20 | 2.1 | .09 | 4 | .15 | 3.8 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.23 | 0.20 – 0.24 | .0089 | .0079 – .0094 | 124559 | UM5W-22 | 2.1 | .09 | 4 | .15 | 3.8 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.25 | 0.225 – 0.265 | .0098 | .0089 – .0104 | 124560 | UM5W-25 | 2.1 | .09 | 4 | .15 | 3.8 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.28 | 0.25 – 0.29 | .0108 | .0098 – .0114 | 124561 | UM5W-27 | 2.1 | .09 | 4 | .15 | 3.8 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.3 | 0.275 – 0.315 | .0118 | .0108 – .0124 | 124562 | UM5W-30 | 2.1 | .09 | 4 | .15 | 3.8 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.33 | 0.30 – 0.34 | .0128 | .0118 – .0134 | 124563 | UM5W-32 | 2.1 | .09 | 4 | .15 | 3.8 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.35 | 0.325 – 0.365 | .0138 | .0128 – .0144 | 124564 | UM5W-35 | 2.1 | .09 | 4.1 | .15 | 3.8 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.38 | 0.35 – 0.39 | .0148 | .0138 – .0154 | 124565 | UM5W-37 | 2.1 | .09 | 4 | .15 | 3.9 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.4 | 0.375 – 0.415 | .0157 | .0148 – .0163 | 124566 | UM5W-40 | 2.1 | .09 | 4.1 | .15 | 3.9 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.43 | 0.40 – 0.44 | .0167 | .0157 – .0173 | 124567 | UM5W-42 | 2.2 | .09 | 4.1 | .16 | 3.9 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.45 | 0.425 – 0.465 | .0177 | .0167 – .0183 | 124568 | UM5W-45 | 2.2 | .09 | 4.1 | .16 | 3.9 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.48 | 0.45 – 0.49 | .0187 | .0177 – .0193 | 124569 | UM5W-47 | 2.2 | .09 | 4.1 | .16 | 3.9 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.5 | 0.475 – 0.515 | .0197 | .0187 – .0203 | 124570 | UM5W-50 | 2.2 | .09 | 4.1 | .16 | 3.9 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.53 | 0.50 – 0.54 | .0207 | .0197 – .0213 | 124571 | UM5W-52 | 2.2 | .09 | 4.1 | .16 | 3.9 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.55 | 0.525 – 0.565 | .0217 | .0207 – .0222 | 124572 | UM5W-55 | 2.2 | .09 | 4.1 | .16 | 3.9 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.57 | 0.55 – 0.59 | .0226 | .0217 – .0232 | 124573 | UM5W-57 | 2.2 | .09 | 4.2 | .16 | 3.9 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.6 | 0.575 – 0.615 | .0236 | .0226 – .0242 | 124574 | UM5W-60 | 2.2 | .09 | 4.2 | .16 | 3.9 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.63 | 0.60 – 0.64 | .0246 | .0236 – .0252 | 124575 | UM5W-62 | 2.3 | .09 | 4.2 | .16 | 3.9 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.65 | 0.625 – 0.665 | .0256 | .0246 – .0262 | 124576 | UM5W-65 | 2.3 | .09 | 4.2 | .16 | 3.9 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |
| 0.68 | 0.65 – 0.69 | .0266 | .0256 – .0272 | 124577 | UM5W-67 | 2.3 | .09 | 4.2 | .16 | 3.9 | .15 | 3.9 | .15 | 5.3 | .21 | 16.2 | .64 |

OVERGRIP COLLETS UM5



- A Part Size Range-Ø
- G Overgrip-Ø
- B Clamping surface length
- C1 Thru bore-1-Ø
- D1 Clamping surface length+chamfer
- C2 Thru bore-2-Ø
- D2 Thru length C2

| Ø A | | Order no. | Item | Ø G max | | B | | Ø C1 | | D1 | | Ø C2 | | D2 | | | |
|------|---------------|-----------|---------------|---------|----------|-----|------|------|------|-----|------|------|------|-----|------|------|-----|
| mm | inch | | | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | | |
| 4.08 | 4.04 – 4.10 | .1604 | .1591 – .1614 | 124927 | UM5V-407 | 3.9 | .16 | 5.9 | .23 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.1 | 4.065 – 4.125 | .1614 | .1600 – .1624 | 124928 | UM5V-410 | 3.9 | .16 | 5.9 | .23 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.13 | 4.09 – 4.15 | .1624 | .1610 – .1634 | 124929 | UM5V-412 | 3.9 | .16 | 6 | .23 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.15 | 4.115 – 4.175 | .1634 | .1620 – .1644 | 124930 | UM5V-415 | 4 | .16 | 6 | .23 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.18 | 4.14 – 4.20 | .1644 | .1630 – .1654 | 124931 | UM5V-417 | 4 | .16 | 6 | .23 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.2 | 4.165 – 4.225 | .1654 | .1640 – .1663 | 124932 | UM5V-420 | 4 | .16 | 6 | .23 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.22 | 4.19 – 4.25 | .1663 | .1650 – .1673 | 124933 | UM5V-422 | 4 | .16 | 6.1 | .23 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.25 | 4.215 – 4.275 | .1673 | .1659 – .1683 | 124934 | UM5V-425 | 4 | .16 | 6.1 | .23 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.28 | 4.24 – 4.30 | .1683 | .1669 – .1693 | 124935 | UM5V-427 | 4 | .16 | 6.1 | .24 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.3 | 4.265 – 4.325 | .1693 | .1679 – .1703 | 124936 | UM5V-430 | 4.1 | .16 | 6.2 | .24 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.33 | 4.29 – 4.35 | .1703 | .1689 – .1713 | 124937 | UM5V-432 | 4.1 | .16 | 6.2 | .24 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.35 | 4.315 – 4.375 | .1713 | .1699 – .1722 | 124938 | UM5V-435 | 4.1 | .17 | 6.2 | .24 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.38 | 4.34 – 4.40 | .1722 | .1709 – .1732 | 124939 | UM5V-437 | 4.1 | .17 | 6.2 | .24 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.4 | 4.365 – 4.425 | .1732 | .1719 – .1742 | 124940 | UM5V-440 | 4.1 | .17 | 6.2 | .24 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.43 | 4.39 – 4.45 | .1742 | .1728 – .1752 | 124941 | UM5V-442 | 4.1 | .17 | 6.3 | .24 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.45 | 4.415 – 4.475 | .1752 | .1738 – .1762 | 124942 | UM5V-445 | 4.1 | .17 | 6.3 | .24 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.47 | 4.44 – 4.50 | .1762 | .1748 – .1772 | 124943 | UM5V-447 | 4.1 | .17 | 6.3 | .24 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.5 | 4.465 – 4.525 | .1772 | .1758 – .1781 | 124944 | UM5V-450 | 4.1 | .17 | 6.3 | .24 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.53 | 4.49 – 4.55 | .1781 | .1768 – .1791 | 124945 | UM5V-452 | 4.2 | .17 | 6.4 | .25 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.55 | 4.515 – 4.575 | .1791 | .1778 – .1801 | 124946 | UM5V-455 | 4.2 | .17 | 6.4 | .25 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |



- A Part Size Range-Ø
- G Overgrip-Ø
- B Clamping surface length
- C1 Thru bore-1-Ø
- D1 Clamping surface length+chamfer
- C2 Thru bore-2-Ø
- D2 Thru length C2

| Ø A | | Order no. | Item | Ø G max | | B | | Ø C1 | | D1 | | Ø C2 | | D2 | | | |
|------|---------------|-----------|---------------|---------|----------|-----|------|------|------|-----|------|------|------|-----|------|------|-----|
| mm | inch | | | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | | |
| 4.58 | 4.54 – 4.60 | .1801 | .1787 – .1811 | 124947 | UM5V-457 | 4.2 | .17 | 6.4 | .25 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.6 | 4.565 – 4.625 | .1811 | .1797 – .1821 | 124948 | UM5V-460 | 4.2 | .17 | 6.4 | .25 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.63 | 4.59 – 4.65 | .1821 | .1807 – .1831 | 124949 | UM5V-462 | 4.2 | .17 | 6.4 | .25 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.65 | 4.615 – 4.675 | .1831 | .1817 – .1841 | 124950 | UM5V-465 | 4.2 | .17 | 6.4 | .25 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.68 | 4.64 – 4.70 | .1841 | .1827 – .1850 | 124951 | UM5V-467 | 4.2 | .17 | 6.5 | .25 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.7 | 4.665 – 4.725 | .1850 | .1837 – .1860 | 124952 | UM5V-470 | 4.2 | .17 | 6.5 | .25 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.72 | 4.69 – 4.75 | .1860 | .1846 – .1870 | 124953 | UM5V-472 | 4.2 | .17 | 6.5 | .25 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.75 | 4.715 – 4.775 | .1870 | .1856 – .1880 | 124954 | UM5V-475 | 4.3 | .17 | 6.5 | .25 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.78 | 4.74 – 4.80 | .1880 | .1866 – .1890 | 124955 | UM5V-477 | 4.3 | .17 | 6.5 | .25 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.8 | 4.765 – 4.825 | .1890 | .1876 – .1900 | 124956 | UM5V-480 | 4.3 | .17 | 6.6 | .25 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.83 | 4.79 – 4.85 | .1900 | .1886 – .1909 | 124957 | UM5V-482 | 4.3 | .17 | 6.6 | .25 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.85 | 4.815 – 4.875 | .1909 | .1896 – .1919 | 124958 | UM5V-485 | 4.3 | .17 | 6.6 | .26 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.88 | 4.84 – 4.90 | .1919 | .1906 – .1929 | 124959 | UM5V-487 | 4.3 | .17 | 6.6 | .26 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.9 | 4.865 – 4.925 | .1929 | .1915 – .1939 | 124960 | UM5V-490 | 4.4 | .18 | 6.7 | .26 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.93 | 4.89 – 4.95 | .1939 | .1925 – .1949 | 124961 | UM5V-492 | 4.4 | .18 | 6.7 | .26 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |
| 4.95 | 4.915 – 4.975 | .1949 | .1935 – .1959 | 124962 | UM5V-495 | 4.4 | .18 | 6.7 | .26 | 4.9 | .19 | 4.3 | .17 | 5.3 | .21 | 16.2 | .64 |

GUIDE BUSHES



Adjustable Guide Bushes **148**

Programmable Guide Bushes **158**

SDK Guide Bushes **164**

SDK-T Guide Bushes **168**

SZZ Guide Bushes **172**

Alignment Mandrels **176**

03

ADJUSTABLE GUIDE BUSHES



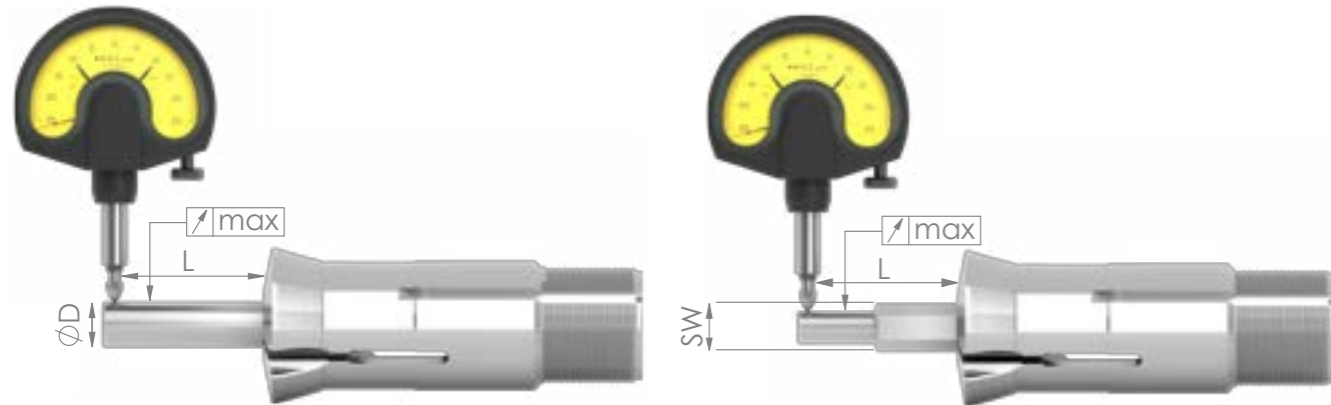
Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF ADJUSTABLE GUIDE BUSHES

The adjustable guide bushes are used for workpiece guidance. They are manually adjusted to the guide diameter via the adjusting nut. As standard, our guide bushes are equipped with a carbide insert, this ensures a longer service life and higher wear resistance. For special applications, they are also available with an extended guide length.

RUNOUT TOLERANCE



DIAMETER

| ØD | | L | Schlenker norm | |
|------|------|----|----------------|--------|
| from | to | | standard | UP |
| 0.5 | 0.9 | 3 | <0.01 | <0.005 |
| 1.0 | 1.5 | 6 | <0.01 | <0.005 |
| 1.6 | 3.0 | 10 | <0.015 | <0.008 |
| 3.1 | 6.0 | 16 | <0.015 | <0.008 |
| 6.1 | 10.0 | 25 | <0.015 | <0.008 |
| 10.1 | 18.0 | 40 | <0.02 | <0.01 |
| 18.1 | 24.0 | 50 | <0.02 | <0.01 |
| 24.1 | 30.0 | 60 | <0.02 | <0.01 |
| 30.0 | | 80 | <0.03 | <0.015 |

PROFILE

| SW | | L | standard | Schlenker norm | |
|------|------|----|----------|----------------|-------|
| from | to | | | standard | UP |
| 0.5 | 0.9 | 3 | 0.12 | <0.02 | <0.01 |
| 1.0 | 1.5 | 6 | 0.12 | <0.02 | <0.01 |
| 1.6 | 3.0 | 10 | 0.12 | <0.02 | <0.01 |
| 3.1 | 6.0 | 16 | 0.12 | <0.02 | <0.01 |
| 6.1 | 10.0 | 25 | 0.15 | <0.02 | <0.01 |
| 10.1 | 18.0 | 40 | 0.2 | <0.02 | <0.01 |
| 18.1 | 24.0 | 50 | 0.2 | <0.02 | <0.01 |
| 24.1 | 30.0 | 60 | 0.2 | <0.02 | <0.01 |
| 30.0 | | 80 | 0.2 | <0.02 | <0.01 |

ADJUSTABLE GUIDE BUSH OPTIONS

- GUIDE SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- ADDITIONAL VERSIONS
- VERSIONS

GUIDE SURFACE DESIGNS



CARBIDE INSERT – STANDARD

- High wear resistance
- Higher service life



EXTENDED CARBIDE INSERT

- Guide surface extended up to 40 mm
- Processing of a wider range of parts
- Improves the stability of the workpiece



EXTENDED CARBIDE INSERT WITH BUSH


- Suitable for extra long guidance
- Guidance possible over the entire length of the guide bush


SHAPES




SQUARE


- Suitable for square material


| | |
|---|---|
|  | <p>HEXAGON</p> <ul style="list-style-type: none"> • Suitable for hexagon material |
|---|---|

| | |
|---|---|
|  | <p>SPECIAL PROFILES</p> <ul style="list-style-type: none"> • Various profiles possible • Profiles can be adapted individually to the workpiece |
|---|---|


SLOT DESIGNS


| | |
|--|---|
|  | <p>S-SLOT</p> <ul style="list-style-type: none"> • Ideal for high-pressure flushing systems in the machine • Prevents machining chips getting in the guide bush • Improved runout properties compared to standard guide bushes • Alternatively usable for profile material |
|--|---|

| | |
|---|---|
|  | <p>W-SLOT</p> <ul style="list-style-type: none"> • Ideal for high-pressure flushing systems in the machine • Prevents machining chips getting in the guide bush • Improved runout properties compared to standard guide bushes • Alternatively usable for profile material |
|---|---|

| | |
|---|---|
|  | <p>Z-SLOT</p> <ul style="list-style-type: none"> • Ideal for high-pressure flushing systems in the machine • Prevents machining chips getting in the guide bush • Improved runout properties compared to standard guide bushes • Alternatively usable for profile material |
|---|---|


WEAR REDUCTION


| | |
|---|--|
|  | <p>BL COATING</p> <ul style="list-style-type: none"> • Especially suitable for material with poor gliding properties e.g. titanium • Prevents welding of the material in the guide bush |
|---|--|

| | |
|---|--|
|  | <p>PREMIUM BLUE COATING</p> <ul style="list-style-type: none"> • High wear resistance • Can also be used for special shapes |
|---|--|


ADDITIONAL VERSIONS

| | |
|---|---|
|  | <p>UP VERSION</p> <ul style="list-style-type: none"> • High precision |
|---|---|

| | |
|--|---|
|  | <p>UUP VERSION</p> <ul style="list-style-type: none"> • Highest precision |
|--|---|

| | |
|---|--|
|  | <p>SEALED</p> <ul style="list-style-type: none"> • Prevents the entry of machining chips • The whole slot area can be sealed • Resealing possible • Not usable with high pressure flushing in the machine |
|---|--|

VERSIONS

| | |
|---|--|
|  | <p>LONG NOSE</p> <ul style="list-style-type: none"> • Needed for special requirements where the tool has a longer distance to the guide bush carrier |
|---|--|



SB DESIGN

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Ideal for material with scratch-sensitive surface
- Especially suitable for material with poor gliding properties e.g. titanium
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter



PERMAGLIS DESIGN

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Especially suitable for medical steels like titanium and stainless steel
- Alternative to SB design
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter



STEEL DESIGN

- Mainly used for self-lubricating material e.g. brass
- Processing of complex profiles possible



CLOSED DESIGN

- Are ground to the exact nominal diameter of the material to be processed
- No adjustment of the guide bush is necessary

STANDARD CARBIDE LENGTHS

| Guide surface Ø [mm] | Carbide length [mm] |
|----------------------|---------------------|
| 2.0 – 4.4 | 13 |
| 4.5 – 5.9 | 14 |
| 6.0 – 6.9 | 15 |
| 7.0 – 10.4 | 16 |
| 10.5 – 14.4 | 18 |
| 14.5 – 18.9 | 19 |
| 19.0 – 20.9 | 22 |
| 21.0 – 22.4 | 24 |
| 22.5 – 32.0 | 25 |

STANDARD GUIDE SURFACE LENGTH SB UND PERMAGLIS DESIGN

| Guide surface Ø [mm] | Guide surface length [mm] |
|----------------------|---------------------------|
| 1.0 – 4.9 | 16 |
| 5.0 – 6.9 | 18 |
| 7.0 – 9.9 | 20 |
| 10.0 – 14.9 | 22 |
| 15.0 – 18.9 | 24 |

| Guide surface Ø [mm] | Guide surface length [mm] |
|----------------------|---------------------------|
| 19.0 – 21.9 | 26 |
| 22.0 – 26.9 | 28 |
| 27.0 – 31.9 | 30 |
| 32.0 – max. | 32 |

ADJUSTABLE GUIDE BUSHES



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

| Article | Ø d [mm] | Ø A [mm] | L [mm] | K [degree] | G | F min. – max. [mm] | | |
|---------|----------|----------|--------|------------|----------|--------------------|------------|------------|
| | | | | | | ● | ■ | ⬡ |
| I351 | 9 | 12.5 | 44 | 16 | M8x0.75 | 0.8 – 4.5 | PR | PR |
| I352 | 11 | 14.5 | 53 | 16 | M10x0.8 | 1.0 – 7.0 | PR | PR |
| F3001 | 11 | 14.5 | 53 | 16 | M10x0.75 | 1.0 – 7.0 | PR | a. A |
| I353 | 16 | 20.5 | 59 | 16 | M14x1 | 1.0 – 10.5 | 3.0 – 7.0 | 3.0 – 9.0 |
| I353SR | 16 | 20 | 57 | 16 | M14x1 | 1.0 – 10.5 | 3.0 – 7.0 | 3.0 – 9.0 |
| F853 | 18 | 22 | 60 | 30 | M16x1 | 1.0 – 12.0 | 3.0 – 8.0 | 4.0 – 10.0 |
| SD125R | 18 | 22 | 60 | 30 | M18x1 | 3.0 – 12.0 | PR | PR |
| T221 | 21 | 24 | 57.5 | 12 | M18x1 | 3.0 – 13.0 | 3.0 – 9.0 | 4.0 – 11.0 |
| SNC15 | 21 | 24 | 57.5 | 12.5 | M18x1 | 3.0 – 13.0 | 3.0 – 9.0 | 4.0 – 11.0 |
| I354 | 22 | 29 | 68 | 16 | M19x1 | 2.0 – 14.5 | 3.0 – 10.0 | 4.0 – 12.5 |
| F391 | 22 | 29 | 68 | 16 | M22x1 | 3.0 – 16.5 | 3.0 – 11.5 | 4.0 – 14.0 |
| TSG20R | 23 | 28 | 72 | 16 | M22x1 | 3.0 – 16.0 | PR | PR |
| F605 | 24 | 29.5 | 61 | 30 | M24x1 | 2.0 – 17.0 | 3.0 – 12.0 | 4.0 – 14.5 |
| TD26 | 26 | 29 | 77 | 16 | M25x1 | 2.0 – 19.0 | 3.0 – 13.0 | 4.0 – 16.0 |
| T223 | 28 | 34 | 82 | 16 | M25x1 | 3.0 – 20.0 | 3.0 – 14.0 | 3.0 – 17.0 |
| T223 | 28 | 34 | 82 | 16 | M27x1 | 22.0 | | |
| I357 | 28 | 38 | 81 | 30 | M25x1 | 3.0 – 20.0 | 3.0 – 14.0 | 4.0 – 17.0 |
| I357 | 28 | 38 | 81 | 30 | M27x1 | 22.0 | | |



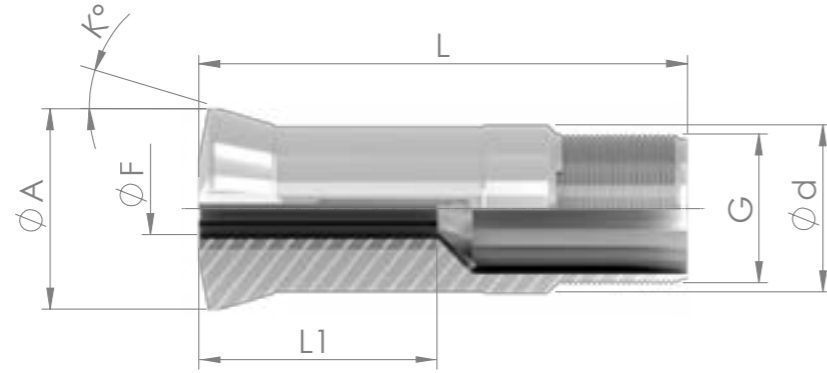
d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

| Article | Ø d [mm] | Ø A [mm] | L [mm] | K [degree] | G | F min. – max. [mm] | | |
|---------|----------|----------|--------|------------|----------|--------------------|------------|------------|
| | | | | | | ● | ■ | ⬡ |
| B230 | 30 | 35 | 59 | 16 | M30x1 | 3.0 – 23.0 | PR | PR |
| T227 | 34 | 41 | 87.5 | 10 | M34x1 | 3.0 – 26.0 | 3.0 – 18.0 | 4.0 – 22.5 |
| T229 | 42 | 49 | 82 | 16 | M40x1 | 4.0 – 32.0 | 3.0 – 22.5 | 4.0 – 27.5 |
| TD32 | 42 | 48 | 82 | 20 | M40x1 | 4.0 – 32.0 | 3.0 – 22.5 | 4.0 – 27.5 |
| ML36 | 44 | 51 | 82 | 16 | M42x1 | 10.0 – 35.0 | PR | PR |
| FST38 | 48 | 54 | 82 | 16 | M46x1 | 10.0 – 38.0 | PR | PR |
| FSL38 | 46 | 53 | 82 | 16 | M45x1 | 10.0 – 38.0 | PR | PR |
| B240 | 48 | 54 | 81 | 10 | M46x1 | 10.0 – 38.0 | PR | PR |
| B236 | 48 | 56 | 81 | 30 | M48x1.25 | 10.0 – 38.0 | PR | PR |



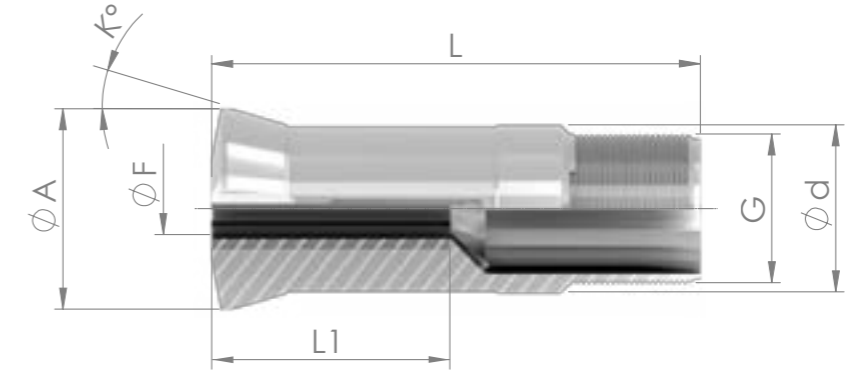
DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

EXTENDED GUIDE BUSHES



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

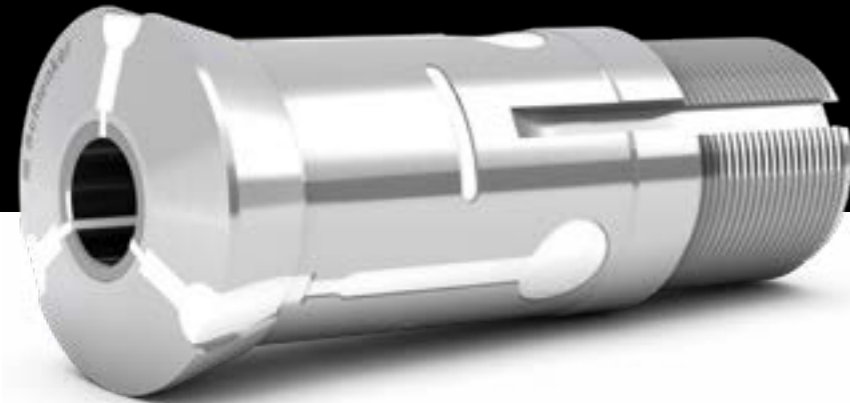
| Artikel | Ø d [mm] | Ø A [mm] | L [mm] | K [Grad] | G | F min. – max. [mm] | | | Hartmetalllänge L1 |
|---------|----------|----------|--------|----------|----------|--------------------|----|----|--------------------|
| | | | | | | ● | ■ | ⬡ | |
| I351 | 9 | 12.5 | 44 | 16 | M8x0.75 | 0.8 – 4.5 | PR | PR | 20mm |
| I352 | 11 | 14.5 | 53 | 16 | M10x0.8 | 1.0 – 7.0 | PR | PR | 25mm |
| F3001 | 11 | 14.5 | 53 | 16 | M10x0.75 | 1.0 – 7.0 | PR | PR | 25mm |
| I353 | 16 | 20.5 | 59 | 16 | M14x1 | 1.0 – 10.5 | PR | PR | 30mm |
| I353SR | 16 | 20 | 57 | 16 | M14x1 | 1.0 – 10.5 | PR | PR | 30mm |
| F853 | 18 | 22 | 60 | 30 | M16x1 | 1.0 – 12.0 | PR | PR | 30mm |
| SD125R | 18 | 22 | 60 | 30 | M18x1 | 3.0 – 12.0 | PR | PR | 30mm |
| T221 | 21 | 24 | 57.5 | 12 | M18x1 | 3.0 – 13.0 | PR | PR | 25mm |
| SNC15 | 21 | 24 | 57.5 | 12.5 | M18x1 | 3.0 – 13.0 | PR | PR | 25mm |
| I354 | 22 | 29 | 68 | 16 | M19x1 | 2.0 – 14.5 | PR | PR | 30/35mm |
| F391 | 22 | 29 | 68 | 16 | M22x1 | 3.0 – 16.5 | PR | PR | 30/35mm |
| TSG20R | 23 | 28 | 72 | 16 | M22x1 | 3.0 – 16.0 | PR | PR | 30/35mm |
| F605 | 24 | 29.5 | 61 | 30 | M24x1 | 2.0 – 17.0 | PR | PR | 30/35mm |
| TD26 | 26 | 29 | 77 | 16 | M25x1 | 2.0 – 19.0 | PR | PR | 30/35/40mm |
| T223 | 28 | 34 | 82 | 16 | M25x1 | 3.0 – 20.0 | PR | PR | 30/35/40mm |
| I357 | 28 | 38 | 81 | 30 | M25x1 | 3.0 – 20.0 | PR | PR | 30/35/40mm |
| B230 | 30 | 35 | 59 | 16 | M30x1 | 3.0 – 23.0 | PR | PR | 30/35/40mm |
| T227 | 34 | 41 | 87.5 | 10 | M34x1 | 3.0 – 26.0 | PR | PR | 30/35/40mm |



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

| Artikel | Ø d [mm] | Ø A [mm] | L [mm] | K [Grad] | G | F min. – max. [mm] | | | Hartmetalllänge L1 |
|---------|----------|----------|--------|----------|----------|--------------------|----|----|--------------------|
| | | | | | | ● | ■ | ⬡ | |
| T229 | 42 | 49 | 82 | 16 | M40x1 | 4.0 – 32.0 | PR | PR | 30/35/40mm |
| TD32 | 42 | 48 | 82 | 20 | M40x1 | 4.0 – 32.0 | PR | PR | 30/35/40mm |
| ML36 | 44 | 51 | 82 | 16 | M42x1 | 10.0 – 35.0 | PR | PR | 30/35/40mm |
| FST38 | 48 | 54 | 82 | 16 | M46x1 | 10.0 – 38.0 | PR | PR | 30/35/40mm |
| FSL38 | 46 | 53 | 82 | 16 | M45x1 | 10.0 – 38.0 | PR | PR | 30/35/40mm |
| B240 | 48 | 54 | 81 | 10 | M46x1 | 10.0 – 38.0 | PR | PR | 30/35/40mm |
| B236 | 48 | 56 | 81 | 30 | M48x1.25 | 10.0 – 38.0 | PR | PR | 30/35/40mm |

PROGRAMMABLE GUIDE BUSHES



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

PROGRAMMIERBARE GUIDE BUSH OPTIONS

- STANDARD VERSION
- GUIDE SURFACE DESIGNS
- SHAPES
- SLOT DESIGNS
- WEAR REDUCTION
- VERSIONS

USE OF PROGRAMMABLE GUIDE BUSHES

Programmable guide bushes are specially designed for INDEX/TRAUUB machines. The bar or guide diameter of the guide bushing is set via the control of the lathe. Axfix guide bushes are standardly delivered in ultra precision (UP), vulcanized and equipped with a bush.

STANDARD VERSION



STANDARD

- UP version
- Chamfered
- Sealed
- With bush

GUIDE SURFACE DESIGNS



EXTENDED CARBIDE INSERT

- Suitable for extra long guidance
- Guidance possible over the whole length of the guide bush

SHAPES



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material



SPECIAL PROFILES

- Various profiles possible
- Profiles can be adapted individually to the workpiece

SLOT DESIGNS



S-SLOT

- Ideal for high-pressure flushing systems in the machine
- Prevents machining chips getting in the guide bush
- Improved runout properties compared to standard guide bushes
- Alternatively usable for profile material



W-SLOT

- Ideal for high-pressure flushing systems in the machine
- Prevents machining chips getting in the guide bush
- Improved runout properties compared to standard guide bushes
- Alternatively usable for profile material



Z-SLOT

- Ideal for high-pressure flushing systems in the machine
- Prevents machining chips getting in the guide bush
- Improved runout properties compared to standard guide bushes
- Alternatively usable for profile material

WEAR REDUCTION



BL COATING

- Especially suitable for material with poor gliding properties e.g. titanium
- Prevents welding of the material in the guide bush



PREMIUM BLUE COATING

- High wear resistance
- Can also be used for special shapes

VERSIONS



SB DESIGN

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Ideal for material with scratch-sensitive surface
- Especially suitable for material with poor gliding properties e.g. titanium
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter



PERMAGLIS DESIGN

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Especially suitable for medical steels like titanium and stainless steel
- Alternative to SB design
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter



STEEL DESIGN

- Mainly used for self-lubricating material e.g. brass
- Processing of complex profiles possible



UUP VERSION

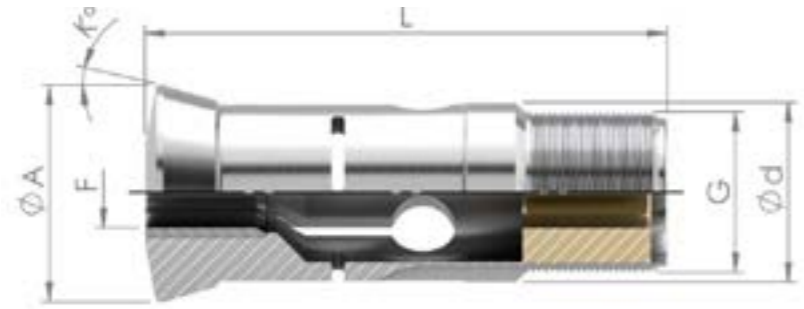
- Highest precision



LONG NOSE

- Needed for special requirements where the tool has a longer distance to the guide bush carrier

PROGRAMMABLE GUIDE BUSHES



d Shaft-Ø A Head-Ø L Total length K Taper angle G Thread F Shape

| Article | Ø d [mm] | Ø A [mm] | L [mm] | K [degree] | G | F min. – max. [mm] | Traub drawing no. |
|-----------|----------|----------|--------|------------|-------|--------------------|-------------------|
| | | | | | | ● | |
| FTS221 | 21 | 24 | 65.5 | 12 | M18x1 | 1.5 – 13.0 | 989468 |
| FTS3402 | 27 | 30 | 67.5 | 12 | M24x1 | 3.0 – 16.0 | 989517 |
| T223AXFIX | 28 | 34 | 81 | 16 | M25x1 | 3.0 – 21.0 | 902860 |
| T227 | 34 | 41 | 87.5 | 10 | M34x1 | 3.0 – 15.0 | 986761 |
| T229AXFIX | 42 | 49 | 81.2 | 16 | M40x1 | 4.0 – 32.0 | 907820 |

CHAT-FUNCTION

OUR TEAM IS ALWAYS AVAILABLE TO SUPPORT YOU!

DO YOU HAVE ANY QUESTIONS OR NEED ASSISTANCE?

Use the chat function on our website to get in touch with our Schlenker team quickly and easily. You will find the chat button on the right bottom of our website



TO OUR WEBSITE
www.schlenker-spannwerkzeuge.de/en



Just click and the chat opens!



Schlenker Team
 We are an experienced team that provides fast and accurate answers to your questions.

Enter your data to start the chat.

First name

Last name

Email

Company

By clicking the button below, you agree to our Privacy Policy.

CHAT NOW



Fill out and let's go!

SDK GUIDE BUSHES



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

USE OF SDK GUIDE BUSHES

The SDK double cone guide bushes with integrated spring are manufactured in one piece. Due to this design, the bar material receives the maximum stability and flexibility in your application. In addition, the axial misalignment or misalignment of the bar material, is eliminated by the integrated spring. SDK double cone guide bushes are especially designed for flexible guide bush systems for example JBS.

VERSIONS



SB DESIGN – STANDARD

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Ideal for material with scratch-sensitive surface Especially suitable for material with poor gliding properties e.g. titanium
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter



PERMAGLIS DESIGN

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Especially suitable for medical steels like titanium and stainless steel
- Alternative to SB design
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter

SDK GUIDE BUSH OPTIONS

- VERSIONS
- SHAPES



STEEL DESIGN WITH BL COATING

- Especially suitable for material with poor gliding properties e.g. titanium
- Processing of complex profiles possible
- Prevents welding of the material in the guide bush



CARBIDE INSERT

- High wear resistance
- Higher service life



LONG NOSE

- Needed for special requirements where the tool has a longer distance to the guide bush carrier



SEALING DISC

- Prevents the entry of machining chips into the spring area

SHAPES



SQUARE

- Suitable for square material



HEXAGON

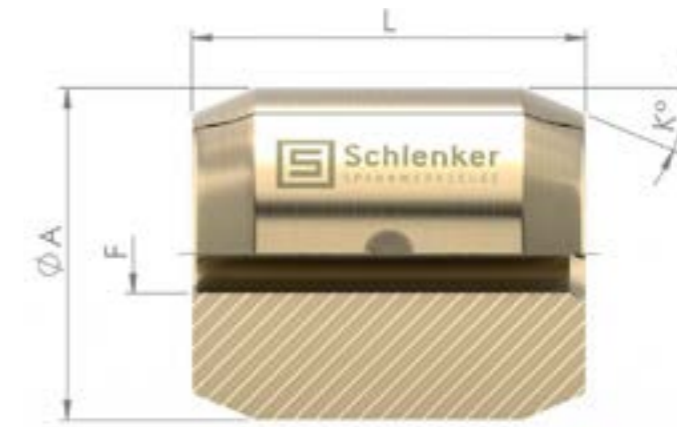
- Suitable for hexagon material



SPECIAL PROFILES

- Various profiles possible
- Profiles can be adapted individually to the workpiece

SDK GUIDE BUSHES



A Head-Ø L Total length K Taper angle F Shape

| Article | Ø A [mm] | L [mm] | K [degree] | F min. – max. [mm] |
|---------|----------|--------|------------|--------------------|
| | | | | ● |
| SDK24 | 24 | 35 | 22.5 | 3.0 – 12.0 |
| SDK28 | 28 | 40 | 22.5 | 3.0 – 20.0 |
| SDK33 | 33 | 40 | 22.5 | 3.0 – 23.0 |
| SDK42 | 42 | 50 | 22.5 | 3.0 – 32.0 |
| SDK48 | 48 | 60 | 22.5 | 3.0 – 38.0 |

SDK-T GUIDE BUSHES



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

USE OF SDK-T GUIDE BUSHES

The SDK-T double cone guide bushes with with integrated spring are manufactured in one piece. Due to this design, the bar material receives the maximum stability and flexibility in your application. In addition, the axial misalignment or misalignment of the bar material, is eliminated by the integrated spring. SDK-T double cone guide bushes are especially designed for flexible guide bush systems for example JBS.

VERSIONS



SB DESIGN – STANDARD

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Ideal for material with scratch-sensitive surface
- Especially suitable for material with poor gliding properties e.g. titanium
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter



PERMAGLIS DESIGN

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Especially suitable for medical steels like titanium and stainless steel
- Alternative to SB design
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter

SDK-T GUIDE BUSH OPTIONS

- VERSIONS
- SHAPES



STEEL DESIGN WITH BL COATING

- Especially suitable for material with poor gliding properties e.g. titanium
- Processing of complex profiles possible
- Prevents welding of the material in the guide bush



CARBIDE INSERT

- High wear resistance
- Higher service life



LONG NOSE

- Needed for special requirements where the tool has a longer distance to the guide bush carrier



SEALING DISC

- Prevents the entry of machining chips into the spring area

SHAPES



SQUARE

- Suitable for square material



HEXAGON

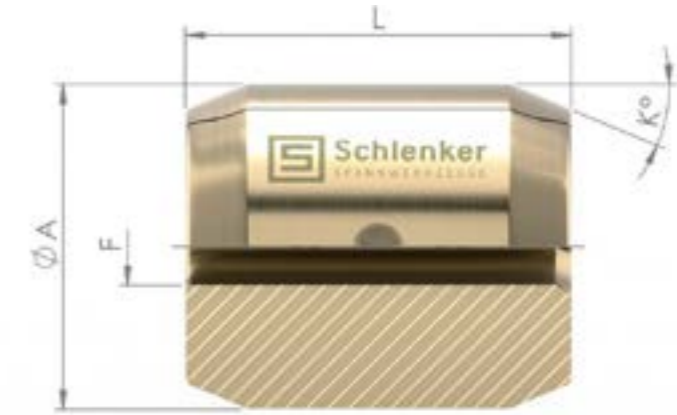
- Suitable for hexagon material



SPECIAL PROFILES

- Various profiles possible
- Profiles can be adapted individually to the workpiece

SDK-T GUIDE BUSHES



A Head-Ø L Total length K Taper angle F Shape

| Article | Ø A [mm] | L [mm] | K [degree] | F min. – max. [mm] |
|---------|----------|--------|------------|--------------------|
| | | | | ● |
| SDK-T24 | 24 | 35 | 22 | 3.0 – 12.0 |
| SDK-T28 | 28 | 40 | 22 | 3.0 – 20.0 |
| SDK-T33 | 33 | 40 | 22 | 3.0 – 23.0 |
| SDK-T42 | 42 | 50 | 22 | 3.0 – 32.0 |
| SDK-T48 | 48 | 60 | 22 | 3.0 – 38.0 |
| SDK-T51 | 51 | 60 | 22 | 10.0 – 38.0 |

SZZ GUIDE BUSHES



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

SZZ GUIDE BUSH OPTIONS

- VERSIONS
- SHAPES

USE OF SZZ GUIDE BUSHES

The SZZ guide bushes with integrated spring are manufactured in one piece. Due to this manufacturing method we do not have any axial misalignment and thus allows maximum flexibility for your application. SZZ guide bushes are especially designed for flexible guide bush systems for example JBS.

VERSIONS



SB DESIGN – STANDARD

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Ideal for material with scratch-sensitive surface
- Especially suitable for material with poor gliding properties e.g. titanium
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter



PERMAGLIS DESIGN

- Special material with very good gliding properties
- Prevents welding of the material in the guide bush
- Especially suitable for medical steels like titanium and stainless steel
- Alternative to SB design
- Guide bush is made out of one material, so it can be reground several times after wear up to the maximum material clearance diameter



STEEL DESIGN WITH BL COATING

- Especially suitable for material with poor gliding properties e.g. titanium
- Processing of complex profiles possible
- Prevents welding of the material in the guide bush



CARBIDE INSERT

- High wear resistance
- Higher service life



LONG NOSE

- Needed for special requirements where the tool has a longer distance to the guide bush carrier



SEALING DISC

- Prevents the entry of machining chips into the spring area

SHAPES



SQUARE

- Suitable for square material



HEXAGON

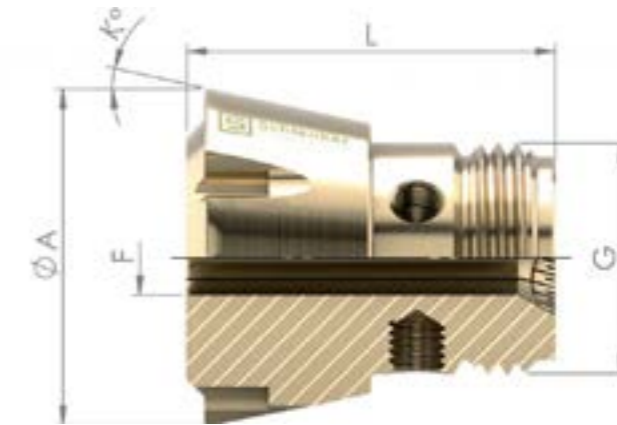
- Suitable for hexagon material



SPECIAL PROFILES

- Various profiles possible
- Profiles can be adapted individually to the workpiece

SZZ GUIDE BUSHES



A Head-Ø L Total length K Taper angle G Thread F Shape

| Article | Ø A [mm] | L [mm] | K [degree] | G | F min. – max. [mm] |
|---------|----------|--------|------------|---------|--------------------|
| | | | | | ● |
| SZZ26 | 26 | 35 | 12 | M16x1.5 | PR |
| SZZ32.5 | 32.5 | 40 | 12 | M21.5x2 | 3.0 – 12.0 |
| SZZ36.7 | 36.7 | 40 | 12 | M25x2 | 3.0 – 16.0 |
| SZZ44 | 44 | 40 | 12 | M30x2 | 3.0 – 18.0 |
| SZZ54 | 54 | 50 | 12 | M40x1.5 | 10.0 – 28.0 |
| SZZ59 | 59 | 60 | 12 | M44x1.5 | 10.0 – 32.0 |

GUIDE BUSH ALIGNMENT MANDREL



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



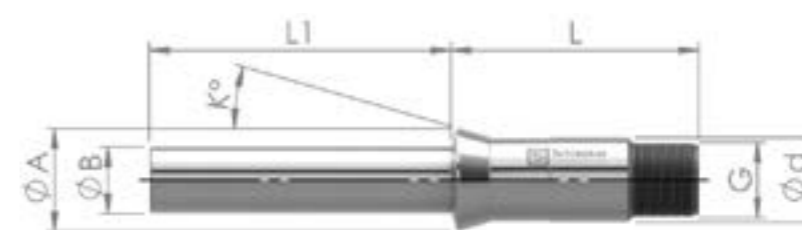
GUIDE BUSH ALIGNMENT MANDREL VERSIONS

- ADJUSTABLE GUIDE BUSHES
- DOUBLE CONE GUIDE BUSHES SDK
- DOUBLE CONE GUIDE BUSHES SDK-T
- GUIDE BUSHES SZZ

USE OF GUIDE BUSH ALIGNMENT MANDRELS

The high-precision alignment mandrels are particularly suitable for checking the axial or radial offset of machine axes or the offset of the main spindle to the sub spindle of the machine geometry. Furthermore, alignment Mandrels are used for checking the runout and tumbling on main or sub spindle.

ADJUSTABLE GUIDE BUSH ALIGNMENT MANDRELS



ADJUSTABLE GUIDE BUSH ALIGNMENT MANDRELS

- Available for all adjustable guide bush types from our range



SDK ALIGNMENT MANDRELS

- Available for all SDK double cone guide bush types from our range



SDK-T ALIGNMENT MANDRELS

- Available for all SDK-T double cone guide bush types from our range



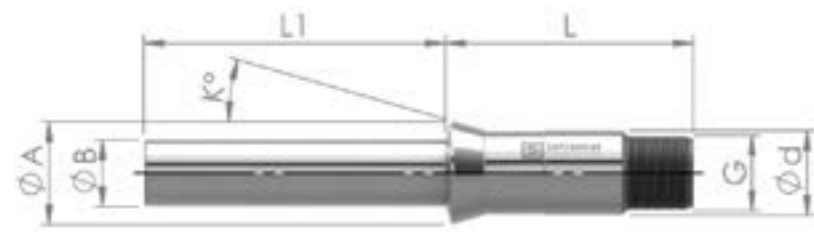
SZZ ALIGNMENT MANDRELS

- Available for all SZZ guide bush types from our range

d Shaft-Ø A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle G Thread

| Article | Ø d [mm] | Ø A [mm] | Ø B [mm] | L1 [mm] | L [mm] | K [degree] | G |
|---------|----------|----------|----------|---------|--------|------------|----------|
| I351 | 9 | 12.5 | 8 | 50 | 44 | 16 | M8x0.75 |
| I352 | 11 | 14.5 | 10 | 50 | 53 | 16 | M10x0.8 |
| F3001 | 11 | 14.5 | 10 | 50 | 53 | 16 | M10x0.75 |
| I353 | 16 | 20.5 | 14 | 50 | 59 | 16 | M14x1 |
| I353SR | 16 | 20 | 14 | 50 | 57 | 16 | M14x1 |
| F853 | 18 | 22 | 16 | 70 | 60 | 30 | M16x1 |
| SD125R | 18 | 22 | 16 | 70 | 60 | 30 | M18x1 |
| T221 | 21 | 24 | 18 | 70 | 57.5 | 12 | M18x1 |
| SNC15 | 21 | 24 | 18 | 70 | 57.5 | 12.5 | M18x1 |
| I354 | 22 | 29 | 20 | 100 | 68 | 16 | M19x1 |
| F391 | 22 | 29 | 20 | 100 | 68 | 16 | M22x1 |

ADJUSTABLE GUIDE BUSH ALIGNMENT MANDRELS



d Shaft-Ø A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle G Thread

| Article | Ø d [mm] | Ø A [mm] | Ø B [mm] | L1 [mm] | L [mm] | K [degree] | G |
|---------|----------|----------|----------|---------|--------|------------|----------|
| TSG20R | 23 | 28 | 20 | 100 | 72 | 16 | M22x1 |
| F605 | 24 | 29.5 | 20 | 100 | 61 | 30 | M24x1 |
| TD26 | 26 | 29 | 20 | 100 | 77 | 16 | M25x1 |
| T223 | 28 | 34 | 22 | 100 | 82 | 16 | M25x1 |
| I357 | 28 | 38 | 22 | 100 | 81 | 30 | M25x1 |
| B230 | 30 | 35 | 22 | 100 | 59 | 16 | M30x1 |
| T227 | 34 | 41 | 25 | 100 | 87.5 | 10 | M34x1 |
| T229 | 42 | 49 | 25 | 100 | 82 | 16 | M40x1 |
| TD32 | 42 | 48 | 25 | 100 | 82 | 20 | M40x1 |
| ML36 | 44 | 51 | 30 | 150 | 82 | 16 | M42x1 |
| FST38 | 48 | 54 | 30 | 150 | 82 | 16 | M46x1 |
| FSL38 | 46 | 53 | 30 | 150 | 82 | 16 | M45x1 |
| B240 | 48 | 54 | 30 | 150 | 81 | 10 | M46x1 |
| B236 | 48 | 56 | 30 | 150 | 81 | 30 | M48x1.25 |

DOUBLE CONE GUIDE BUSH SDK ALIGNMENT MANDRELS



A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle

| Article | Ø A [mm] | Ø B [mm] | L1 [mm] | L [mm] | K [degree] |
|---------|----------|----------|---------|--------|------------|
| SDK24 | 24 | 10 | 80 | 35 | 22.5 |
| SDK28 | 28 | 15 | 80 | 40 | 22.5 |
| SDK33 | 33 | 20 | 80 | 40 | 22.5 |
| SDK42 | 42 | 25 | 100 | 50 | 22.5 |
| SDK48 | 48 | 30 | 100 | 60 | 22.5 |

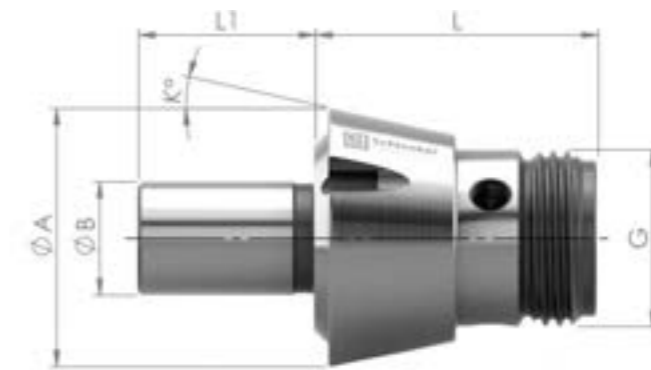
ADJUSTABLE GUIDE BUSH SDK-T ALIGNMENT MANDRELS



A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle

| Article | Ø A [mm] | Ø B [mm] | L1 [mm] | L [mm] | K [degree] |
|---------|----------|----------|---------|--------|------------|
| SDK-T24 | 24 | 10 | 80 | 35 | 22 |
| SDK-T28 | 28 | 15 | 80 | 40 | 22 |
| SDK-T33 | 33 | 20 | 80 | 40 | 22 |
| SDK-T42 | 42 | 25 | 100 | 50 | 22 |
| SDK-T48 | 48 | 30 | 100 | 60 | 22 |
| SDK-T51 | 51 | 35 | 100 | 60 | 22 |

GUIDE BUSH SZZ ALIGNMENT MANDRELS



A Head-Ø B Nose-Ø L1 Length L1 L Total length K Taper angle G Thread

| Article | Ø A [mm] | Ø B [mm] | L1 [mm] | L [mm] | K [degree] | G |
|---------|----------|----------|---------|--------|------------|---------|
| SZZ26 | 26 | 10 | 80 | 35 | 12 | M16x1.5 |
| SZZ32.5 | 32.5 | 15 | 80 | 40 | 12 | M21.5x2 |
| SZZ36.7 | 36.7 | 20 | 80 | 40 | 12 | M25x2 |
| SZZ44 | 44 | 25 | 100 | 40 | 12 | M30x2 |
| SZZ54 | 54 | 30 | 100 | 50 | 12 | M40x1.5 |
| SZZ59 | 59 | 35 | 100 | 60 | 12 | M44x1.5 |

BAR FEED COLLETS



SHK Bar Feed Collets **184**

SHK Crown Bar Feed Collets **188**

TURBO Bar Feed Collets **192**

TURBO Crown Bar Feed Collets **196**

IEMCA Bar Feed Collets **200**

IEMCA Crown Bar Feed Collets **204**

CAV Bar Feed Collets **208**

CUCCHI Bar Feed Collets **212**

SHK Inside Clamping Sleeves **216**

TURBO Inside Clamping Sleeves **218**

Inside Clamping Sleeves INDEX MS **222**

Feeding Collets **226**

Feeding Collets Multi-Spindle **230**

Feeding Collets RS **234**

Front Ejectors VKK **236**

Front Ejectors SKK **240**

04

SHK BAR FEED COLLETS



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF SHK BAR FEED COLLETS

The SHK bar feed collets are mounted on the rotating inserts and secured with a cross pin.



STANDARD ROUND

- Suitable for round material



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material

SHK BAR FEED COLLET OPTIONS



SPECIAL PROFILES

- Various profiles can be realized by ram EDM or wire EDM
- Profiles can be adapted individually to the workpiece



TENSION

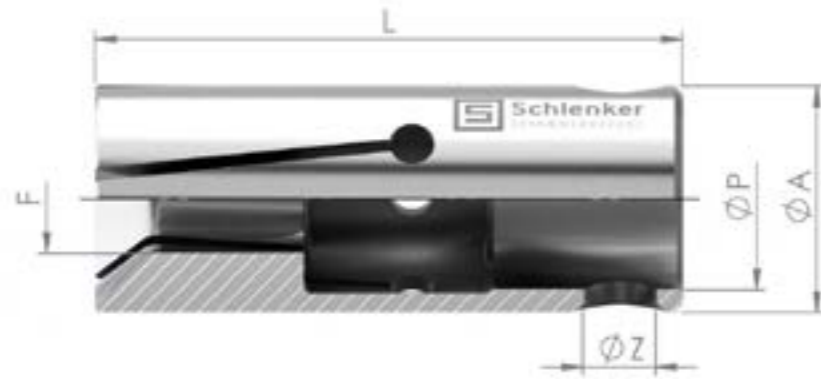
- Tension can be increased or reduced according to requirements



CLOSED DESIGN

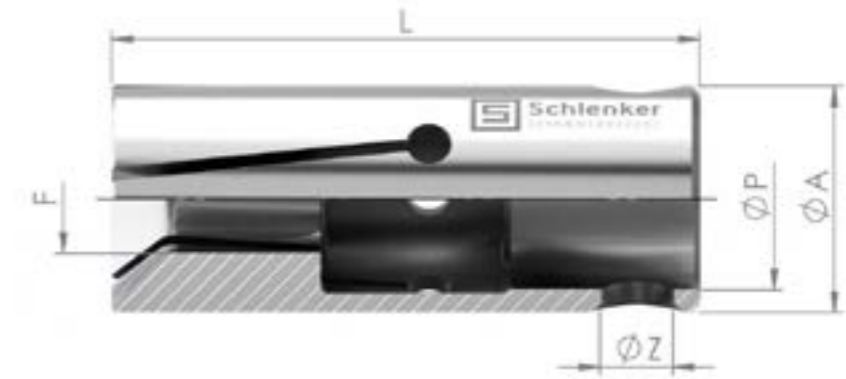
- Channel can be used completely

SHK BAR FEED COLLETS



A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | Ø Z [mm] | L [mm] | F min. – max. [mm] | | |
|--------------|-------------|----------|----------|----------|--------|--------------------|-----------|------------|
| | | | | | | ● | ■ | ⬡ |
| S5 E200 | D5 | 5 | M4 | | 37 | 1.0 – 4.0 | | |
| S7 E208 | D7 | 7 | M5 | | 37 | 1.0 – 6.0 | | |
| S7B BECHLER | D7 | 7 | M4 | | 22 | 1.0 – 6.0 | | |
| S10 E210 | D10 | 10 | 7H7 | 4 | 40 | 1.0 – 8.5 | 3.0 – 4.0 | 3.0 – 6.0 |
| S10B BECHLER | D10 | 10 | M5 | | 26 | 2.0 – 8.5 | | |
| S12 E212 | D12 | 12 | 8H7 | 4 | 40 | 3.0 – 10.5 | 3.0 – 5.0 | 3.0 – 6.0 |
| S13 E213 | D13 | 13 | 8H7 | 4 | 40 | 2.0 – 11.5 | 3.0 – 5.0 | 3.0 – 6.0 |
| S15 E203 | D15 | 15 | 11H7 | 6 | 40 | 3.0 – 13.5 | 3.0 – 7.0 | 3.0 – 9.0 |
| S16 SHK16 | D16 | 16 | 11H7 | 6 | 40 | 3.0 – 14.5 | 3.0 – 7.0 | 3.0 – 9.0 |
| S18 E218 | D18 | 18 | 11H7 | 6 | 40 | 3.0 – 16.5 | 5.0 – 7.0 | 5.0 – 9.0 |
| S20 E225 | D20 | 20 | 14H7 | 8 | 65 | 4.0 – 18.5 | 5.0 – 9.0 | 5.0 – 12.0 |
| S21 SHK21 | D21 | 21 | 14H7 | 8 | 65 | 15.0 – 19.5 | PR | PR |
| S22 SHK22 | D22 | 22 | 14H7 | 8 | 65 | 4.0 – 20.5 | PR | PR |



A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | Ø Z [mm] | L [mm] | F min. – max. [mm] | | |
|-----------|-------------|----------|----------|----------|--------|--------------------|-------------|-------------|
| | | | | | | ● | ■ | ⬡ |
| S23 SHK23 | D23 | 23 | 14H7 | 8 | 65 | 5.0 – 21.5 | PR | PR |
| S25 E222 | D25 | 25 | 20H7 | 8 | 65 | 4.0 – 23.5 | 5.0 – 14.0 | 5.0 – 17.0 |
| S28 E227 | D28 | 28 | 20H7 | 8 | 65 | 3.0 – 26.0 | 5.0 – 14.0 | 5.0 – 17.0 |
| S30 SHK30 | D30 | 30 | 20H7 | 8 | 65 | 5.0 – 28.0 | 5.0 – 14.0 | 5.0 – 17.0 |
| S32 SHK32 | D32 | 32 | 20H7 | 8 | 65 | 5.0 – 30.0 | 5.0 – 14.0 | 5.0 – 17.0 |
| S34 SHK34 | D34 | 34 | 20H7 | 8 | 65 | 10.0 – 32.0 | 10.0 – 14.0 | 10.0 – 17.0 |
| S36 SHK36 | D36 | 36 | 20H7 | 8 | 65 | 8.0 – 34.0 | 8.0 – 14.0 | 8.0 – 17.0 |



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

SHK CROWN BAR FEED COLLETS



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

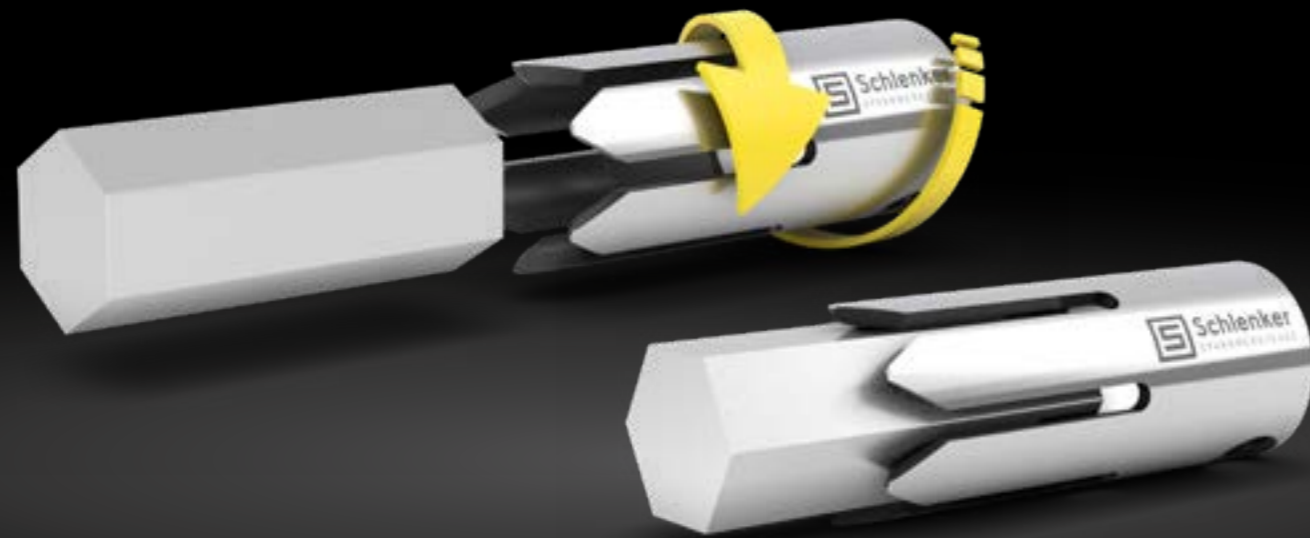


USE OF SHK CROWN BAR FEED COLLETS

The SHK crown bar feed collets owe their name to the special shape of the crown and are especially developed for profile material. This geometry simplifies the threading of the material and allows the full utilization of the channel, thus larger wrench sizes can be clamped.

PROCESS RELIABLE LOADING OF PROFILE MATERIAL

The following illustration shows how profile material can be loaded with a crown bar feed collet in a process reliable way.



WATCH NOW THE PRODUCT VIDEO
www.schlenker-spannwerkzeuge.de/en

SHK CROWN BAR FEED COLLET OPTIONS



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material



SQUARE TENSION

- Suitable for square material
- Tension can be increased or reduced according to requirements



HEXAGON TENSION

- Suitable for hexagon material
- Tension can be increased or reduced according to requirements

SHK CROWN BAR FEED COLLETS



A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | Ø Z [mm] | L [mm] | F min. - max. [mm] | |
|----------------|-------------|----------|----------|----------|--------|--------------------|-------------|
| | | | | | | ■ | ⬡ |
| S10K E210K | D10 | 10 | 7H7 | 4 | 40 | 5.0 – 7.0 | 7.0 – 9.0 |
| S12K E212K | D12 | 12 | 8H7 | 4 | 40 | 6.0 – 8.0 | 7.0 – 10.0 |
| S13K E213K | D13 | 13 | 8H7 | 4 | 40 | 6.0 – 9.0 | 7.0 – 11.0 |
| S15K E203K | D15 | 15 | 11H7 | 6 | 40 | 8.0 – 11.0 | 10.0 – 13.0 |
| S16K SHK16K | D16 | 16 | 11H7 | 6 | 40 | 8.0 – 11.0 | 10.0 – 14.0 |
| S18K E218K | D18 | 18 | 11H7 | 6 | 40 | 8.0 – 13.0 | 10.0 – 16.0 |
| S20K E225K | D20 | 20 | 14H7 | 8 | 65 | 10.0 – 14.0 | 13.0 – 17.0 |
| S21K SHK21K | D21 | 21 | 14H7 | 8 | 65 | PR | PR |
| S22K SHK22K | D22 | 22 | 14H7 | 8 | 65 | 10.0 – 16.0 | 13.0 – 19.0 |
| S23K SHK23K | D23 | 23 | 14H7 | 8 | 65 | 10.0 – 16.0 | 13.0 – 20.0 |
| S25K E222K | D25 | 25 | 20H7 | 8 | 65 | 15.0 – 18.0 | 18.0 – 22.0 |
| S28K E227K | D28 | 28 | 20H7 | 8 | 65 | 15.0 – 20.0 | 18.0 – 24.0 |
| S30K SHK30K | D30 | 30 | 20H7 | 8 | 65 | 15.0 – 21.0 | 18.0 – 26.0 |



A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | Ø Z [mm] | L [mm] | F min. - max. [mm] | |
|----------------|-------------|----------|----------|----------|--------|--------------------|-------------|
| | | | | | | ■ | ⬡ |
| S32K SHK32K | D32 | 32 | 20H7 | 8 | 65 | 15.0 – 23.0 | 18.0 – 28.0 |
| S34K SHK34K | D34 | 34 | 20H7 | 8 | 65 | 15.0 – 24.0 | 18.0 – 30.0 |
| S36K SHK36K | D36 | 36 | 20H7 | 8 | 65 | 15.0 – 25.0 | 18.0 – 30.0 |



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

TURBO BAR FEED COLLETS



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF TURBO BAR FEED COLLETS

The TURBO bar feed collets are mounted on the rotating inserts and fastened with three set screws.



STANDARD ROUND

- Suitable for round material



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material

TURBO BAR FEED COLLET OPTIONS



SPECIAL PROFILES

- Various profiles can be realized by ram EDM or wire EDM
- Tension and shape of the bar feed collets can be exactly adapted to the material



TENSION

- Tension can be increased or reduced according to requirements



XT VERSION WITH SPRING

- Increased tension
- Emergency properties in case of breakage of the bar feed collet



FOR LOADING/UNLOADING

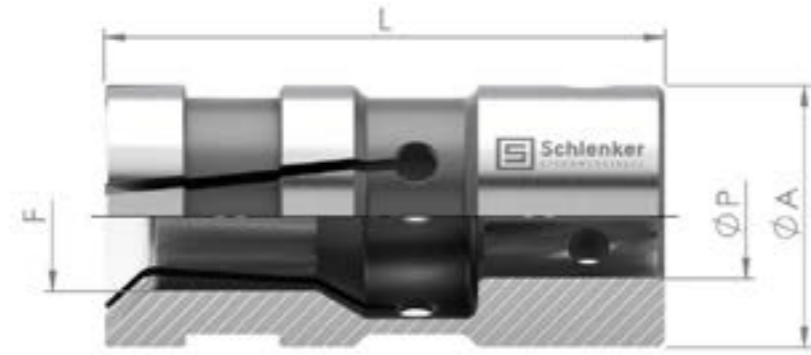
- The tension is adjusted to the workpiece
- These bar feed collets are used to load/unload blanks or workpieces



CLOSED DESIGN

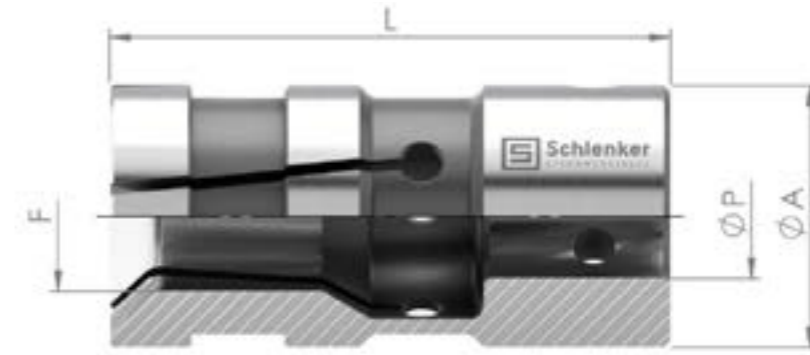
- Channel can be used completely

TURBO BAR FEED COLLETS



A Outer diameter P Fit ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | L [mm] | F min. – max. [mm] | | |
|---------------|-------------|----------|----------|--------|--------------------|-------------|-------------|
| | | | | | ● | ■ | ⬡ |
| ST25 SHT25 | D25 | 25 | 20H7 | 90 | 4.0 – 23.0 | 5.0 – 14.0 | 5.0 – 17.0 |
| ST28 SHT28 | D28 | 28 | 20H7 | 90 | 4.0 – 26.0 | 5.0 – 14.0 | 5.0 – 17.0 |
| ST30 SHT30 | D30 | 30 | 20H7 | 90 | 5.0 – 28.0 | 5.0 – 14.0 | 5.0 – 17.0 |
| ST32 SHT32 | D32 | 32 | 20H7 | 90 | 5.0 – 30.0 | 5.0 – 14.0 | 5.0 – 17.0 |
| ST34 SHT34 | D34 | 34 | 20H7 | 90 | 5.0 – 32.0 | 10.0 – 14.0 | 10.0 – 17.0 |
| ST35 SHT35 | D35 | 35 | 20H7 | 90 | 5.0 – 33.0 | PR | PR |
| ST36 SHT36 | D36 | 36 | 20H7 | 90 | 6.0 – 34.0 | 6.0 – 14.0 | 6.0 – 17.0 |
| ST38 SHT38 | D38 | 38 | 20H7 | 90 | 6.0 – 36.0 | 6.0 – 14.0 | 6.0 – 17.0 |
| ST40 SHT40 | D40 | 40 | 20H7 | 90 | 10.0 – 38.0 | 10.0 – 21.0 | 10.0 – 26.0 |
| ST42 SHT42 | D42 | 42 | 20H7 | 90 | 6.0 – 40.0 | 10.0 – 21.0 | 10.0 – 26.0 |
| ST44 SHT44 | D44 | 44 | 20H7 | 90 | 10.0 – 42.0 | PR | PR |
| ST45 SHT45 | D45 | 45 | 20H7 | 90 | 6.0 – 43.0 | 10.0 – 21.0 | 10.0 – 26.0 |
| ST50 SHT50 | D50 | 50 | 20H7 | 90 | 6.0 – 48.0 | 10.0 – 27.0 | 10.0 – 33.0 |



A Outer diameter P Fit ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | L [mm] | F min. – max. [mm] | | |
|-----------------|-------------|----------|--------------|--------|--------------------|-------------|-------------|
| | | | | | ● | ■ | ⬡ |
| ST54 SHT54 | D54 | 54 | 20H7 | 90 | 10.0 – 52.0 | PR | PR |
| ST58 SHT58 | D58 | 58 | 20H7 | 90 | 15.0 – 56.0 | PR | PR |
| ST60 SHT60 | D60 | 60 | 20H7 | 90 | 8.0 – 58.0 | 10.0 – 33.0 | 10.0 – 50.0 |
| ST63 SHT63 | D63 | 63 | 20H7 | 90 | 15.0 – 61.0 | PR | PR |
| ST65 SHT65 | D65 | 65 | 20H7 | 90 | 8.0 – 63.0 | 10.0 – 37.0 | 10.0 – 45.0 |
| ST70 SHT70 | D70 | 70 | 20H7 | 90 | 12.0 – 66.0 | PR | PR |
| ST75 SHT75 | D75 | 75 | 20H7 35H7 | 90 | 20.0 – 72.0 | PR | PR |
| ST80 SHT80 | D80 | 80 | 35H7 | 90 | 20.0 – 76.0 | PR | PR |
| ST90 SHT90 | D90 | 90 | 35H7 | 90 | 50.0 – 86.0 | PR | PR |
| ST100 SHT100 | D100 | 100 | 35H7 | 110 | 60.0 – 95.0 | PR | PR |



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

TURBO CROWN BAR FEED COLLETS



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

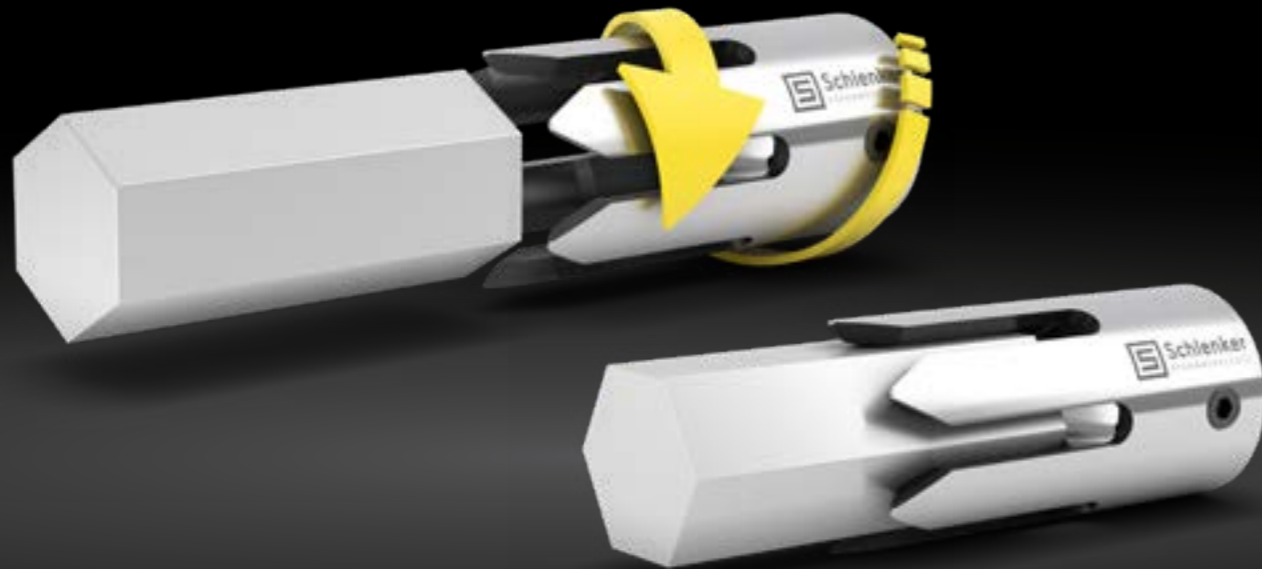


USE OF TURBO CROWN BAR FEED COLLETS

The TURBO crown bar feed collets owe their name to the special shape of the crown and are especially developed for profile material. This geometry simplifies the threading of the material and allows the full utilization of the channel, thus larger wrench sizes can be clamped.

PROCESS RELIABLE LOADING OF PROFILE MATERIAL

The following illustration shows how profile material can be loaded with a crown bar feed collet in a process reliable way.



WATCH NOW THE PRODUCT VIDEO
www.schlenker-spannwerkzeuge.de/en

TURBO CROWN BAR FEED COLLET OPTIONS



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material



SQUARE TENSION

- Suitable for square material
- Tension can be increased or reduced according to requirements



HEXAGON TENSION

- Suitable for hexagon material
- Tension can be increased or reduced according to requirements

TURBO CROWN BAR FEED COLLETS



A Outer diameter P Fit ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | L [mm] | F min. – max. [mm] | |
|-----------------|-------------|----------|----------|--------|--------------------|-------------|
| | | | | | ■ | ⬡ |
| ST25K SHT25K | D25 | 25 | 20H7 | 90 | 15.0 – 18.0 | 18.0 – 22.0 |
| ST28K SHT28K | D28 | 28 | 20H7 | 90 | 15.0 – 20.0 | 18.0 – 24.0 |
| ST30K SHT30K | D30 | 30 | 20H7 | 90 | 15.0 – 21.0 | 18.0 – 26.0 |
| ST32K SHT32K | D32 | 32 | 20H7 | 90 | 15.0 – 23.0 | 18.0 – 28.0 |
| ST34K SHT34K | D34 | 34 | 20H7 | 90 | PR | PR |
| ST35K SHT35K | D35 | 35 | 20H7 | 90 | PR | PR |
| ST36K SHT36K | D36 | 36 | 20H7 | 90 | PR | 21.0 – 31.0 |
| ST38K SHT38K | D38 | 38 | 20H7 | 90 | PR | PR |
| ST40K SHT40K | D40 | 40 | 20H7 | 90 | PR | PR |
| ST42K SHT42K | D42 | 42 | 20H7 | 90 | 22.0 – 30.0 | 26.0 – 36.0 |
| ST44K SHT44K | D44 | 44 | 20H7 | 90 | PR | PR |
| ST45K SHT45K | D45 | 45 | 20H7 | 90 | PR | PR |
| ST50K SHT50K | D50 | 50 | 20H7 | 90 | 28.0 – 35.0 | 34.0 – 43.0 |



A Outer diameter P Fit ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | L [mm] | F min. – max. [mm] | |
|-------------------|-------------|----------|--------------|--------|--------------------|-------------|
| | | | | | ■ | ⬡ |
| ST54K SHT54K | D54 | 54 | 20H7 | 90 | PR | PR |
| ST58K SHT58K | D58 | 58 | 20H7 | 90 | PR | PR |
| ST60K SHT60K | D60 | 60 | 20H7 | 90 | 34.0 – 42.0 | 41.0 – 52.0 |
| ST63K SHT63K | D63 | 63 | 20H7 | 90 | PR | PR |
| ST65K SHT65K | D65 | 65 | 20H7 | 90 | 38.0 – 46.0 | 46.0 – 56.0 |
| ST70K SHT70K | D70 | 70 | 20H7 | 90 | PR | PR |
| ST75K SHT75K | D75 | 75 | 20H7 35H7 | 90 | PR | PR |
| ST80K SHT80K | D80 | 80 | 35H7 | 90 | PR | PR |
| ST90K SHT90K | D90 | 90 | 35H7 | 90 | PR | PR |
| ST100K SHT100K | D100 | 100 | 35H7 | 110 | PR | PR |



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

IEMCA BAR FEED COLLETS



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF IEMCA BAR FEED COLLETS

The IEMCA style bar feed collets are mounted and fixed on the rotating inserts through an internal thread.



STANDARD ROUND

- Suitable for round material



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material

IEMCA BAR FEED COLLET OPTIONS



SPECIAL PROFILES

- Various profiles can be realized by ram EDM or wire EDM
- Tension and shape of the bar feed collets can be exactly adapted to the material



TENSION

- Tension can be increased or reduced according to requirements



CLOSED DESIGN

- Channel can be used completely

IEMCA BAR FEED COLLETS



A Outer diameter L Total length G Thread F Shape

| Article | Pusher [mm] | Ø A [mm] | L [mm] | G [mm] | F min. – max. [mm] |
|---------|-------------|----------|--------|---------|--------------------|
| | | | | | ● |
| SE7.5 | D7.5 | 7.5 | 40 | M5x0.5 | 2.0 – 6.5 |
| SE10 | D10 | 10 | 40 | M6x0.75 | 2.0 – 8.0 |
| SE12 | D12 | 12 | 42 | M7x0.75 | 2.0 – 10.0 |
| SE15 | D15 | 15 | 42 | M8x1 | 4.0 – 13.0 |
| SE16 | D16 | 16 | 42 | M8x1 | 7.0 – 14.0 |
| SE18 | D18 | 18 | 42 | M8x1 | 12.5 – 16.0 |
| SE20 | D20 | 20 | 59 | M10x1 | 4.0 – 18.0 |
| SE22 | D22 | 22 | 59 | M10x1 | 14.0 – 20.0 |
| SE23 | D23 | 23 | 59 | M10x1 | 14.0 – 21.0 |
| SE25 | D25 | 25 | 59 | M10x1 | 17.0 – 23.0 |
| SE27 | D27 | 27 | 59 | M10x1 | 19.0 – 25.0 |
| SE30 | D30 | 30 | 59 | M10x1 | 3.0 – 28.0 |
| SE32 | D32 | 32 | 78 | M25x1.5 | 25.0 – 30.0 |
| SE34 | D34 | 34 | 78 | M25x1.5 | 8.0 – 32.0 |
| SE35 | D35 | 35 | 78 | M25x1.5 | 20.0 – 33.0 |
| SE37 | D37 | 37 | 78 | M25x1.5 | 31.0 – 35.0 |
| SE38 | D38 | 38 | 78 | M25x1.5 | 31.0 – 35.0 |
| SE40 | D40 | 40 | 78 | M25x1.5 | 20.0 – 37.0 |



A Outer diameter L Total length G Thread F Shape

| Article | Pusher [mm] | Ø A [mm] | L [mm] | G [mm] | F min. – max. [mm] |
|---------|-------------|----------|--------|---------|--------------------|
| | | | | | ● |
| SE42 | D42 | 42 | 78 | M25x1.5 | 20.0 – 40.0 |
| SE45 | D45 | 45 | 80 | M25x1.5 | 20.0 – 42.0 |
| SE46 | D46 | 46 | 80 | M25x1.5 | 20.0 – 44.0 |
| SE50 | D50 | 50 | 80 | M25x1.5 | 44.0 – 47.0 |
| SE51 | D51 | 51 | 80 | M25x1.5 | 43.0 – 48.0 |
| SE55 | D55 | 55 | 80 | M25x1.5 | 20.0 – 54.0 |
| SE56 | D56 | 56 | 80 | M25x1.5 | 20.0 – 54.0 |
| SE58 | D58 | 58 | 80 | M25x1.5 | 20.0 – 54.0 |
| SE60 | D60 | 60 | 80 | M25x1.5 | 20.0 – 57.0 |
| SE65 | D65 | 65 | 80 | M25x1.5 | 56.0 – 63.0 |
| SE70 | D70 | 70 | 80 | M25x1.5 | 60.0 – 68.0 |
| SE75 | D75 | 75 | 80 | M25x1.5 | 67.0 – 72.0 |

i DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

IEMCA CROWN BAR FEED COLLETS



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

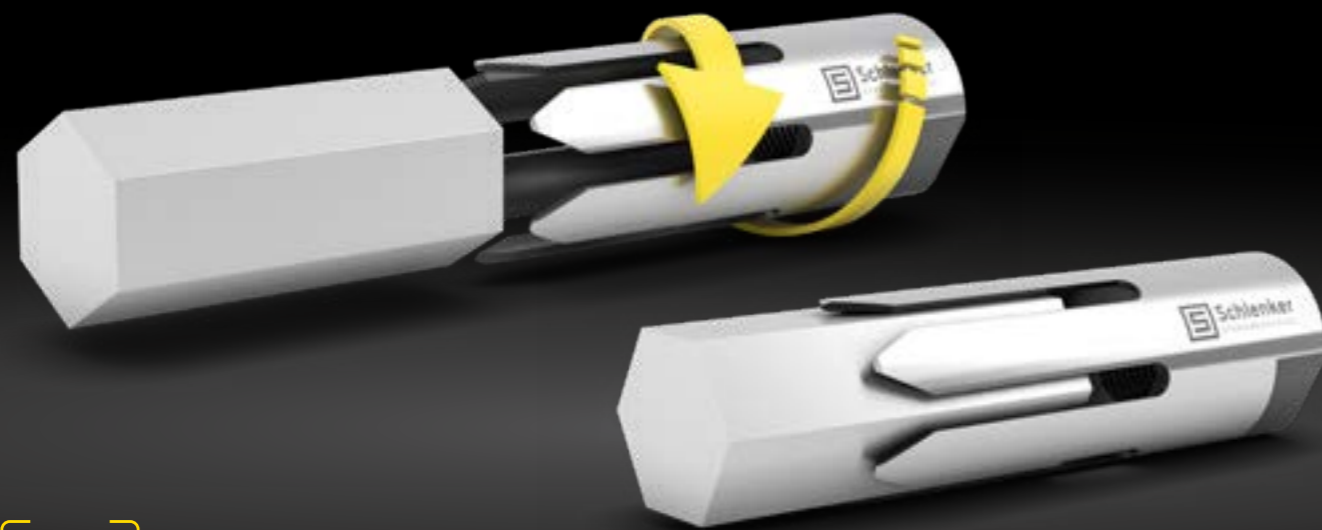


USE OF IEMCA CROWN BAR FEED COLLETS

The IEMCA style crown bar feed collets owe their name to the special shape of the crown and are especially developed for profile material. This geometry simplifies the threading of the material and allows the full utilization of the channel, thus larger wrench sizes can be clamped.

PROCESS RELIABLE LOADING OF PROFILE MATERIAL

The following illustration shows how profile material can be loaded with a crown bar feed collet in a process reliable way.



WATCH NOW THE PRODUCT VIDEO
www.schlenker-spannwerkzeuge.de/en

IEMCA CROWN BAR FEED COLLET OPTIONS



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material



SQUARE TENSION

- Suitable for square material
- Tension can be increased or reduced according to requirements



HEXAGON TENSION

- Suitable for hexagon material
- Tension can be increased or reduced according to requirements

IEMCA CROWN BAR FEED COLLETS



A Outer diameter L Total length G Thread F Shape

| Article | Pusher [mm] | Ø A [mm] | L [mm] | G | F min. – max. [mm] | |
|---------|-------------|----------|--------|---------|--------------------|-------------|
| | | | | | ■ | ⬡ |
| SE7.5K | D7.5 | 7.5 | 40 | M5x0.5 | | |
| SE10K | D10 | 10 | 40 | M6x0.75 | 5.0 – 7.0 | 7.0 – 9.0 |
| SE12K | D12 | 12 | 42 | M7x0.75 | 6.0 – 8.0 | 7.0 – 10.0 |
| SE15K | D15 | 15 | 42 | M8x1 | 8.0 – 11.0 | 10.0 – 13.0 |
| SE16K | D16 | 16 | 42 | M8x1 | 8.0 – 11.0 | 10.0 – 14.0 |
| SE18K | D18 | 18 | 42 | M8x1 | 8.0 – 13.0 | 10.0 – 16.0 |
| SE20K | D20 | 20 | 59 | M10x1 | 10.0 – 14.0 | 13.0 – 17.0 |
| SE22K | D22 | 22 | 59 | M10x1 | 11.0 – 15.0 | 14.0 – 19.0 |
| SE23K | D23 | 23 | 59 | M10x1 | 12.0 – 16.0 | 15.0 – 20.0 |
| SE25K | D25 | 25 | 59 | M10x1 | 15.0 – 18.0 | 18.0 – 22.0 |
| SE27K | D27 | 27 | 59 | M10x1 | 15.0 – 19.0 | 18.0 – 23.0 |
| SE30K | D30 | 30 | 59 | M10x1 | 15.0 – 21.0 | 18.0 – 26.0 |
| SE32K | D32 | 32 | 78 | M25x1.5 | 15.0 – 23.0 | 18.0 – 28.0 |
| SE34K | D34 | 34 | 78 | M25x1.5 | 17.0 – 24.0 | 20.0 – 26.0 |
| SE35K | D35 | 35 | 78 | M25x1.5 | 17.0 – 25.0 | 20.0 – 30.0 |
| SE37K | D37 | 37 | 78 | M25x1.5 | 17.0 – 26.0 | 20.0 – 32.0 |
| SE38K | D38 | 38 | 78 | M25x1.5 | 17.0 – 27.0 | 20.0 – 33.0 |
| SE40K | D40 | 40 | 78 | M25x1.5 | 17.0 – 28.0 | 20.0 – 35.0 |



A Outer diameter L Total length G Thread F Shape

| Article | Pusher [mm] | Ø A [mm] | L [mm] | G | F min. – max. [mm] | |
|---------|-------------|----------|--------|---------|--------------------|-------------|
| | | | | | ■ | ⬡ |
| SE42K | D42 | 42 | 78 | M25x1.5 | 17.0 – 30.0 | 20.0 – 36.0 |
| SE45K | D45 | 45 | 80 | M25x1.5 | 17.0 – 32.0 | 20.0 – 39.0 |
| SE46K | D46 | 46 | 80 | M25x1.5 | 17.0 – 33.0 | 20.0 – 40.0 |
| SE50K | D50 | 50 | 80 | M25x1.5 | 22.0 – 35.0 | 26.0 – 43.0 |
| SE51K | D51 | 51 | 80 | M25x1.5 | 18.0 – 36.0 | 22.0 – 44.0 |
| SE55K | D55 | 55 | 80 | M25x1.5 | 17.0 – 39.0 | 20.0 – 48.0 |
| SE56K | D56 | 56 | 80 | M25x1.5 | 17.0 – 40.0 | 20.0 – 49.0 |
| SE58K | D58 | 58 | 80 | M25x1.5 | 17.0 – 41.0 | 20.0 – 50.0 |
| SE60K | D60 | 60 | 80 | M25x1.5 | 17.0 – 42.0 | 20.0 – 52.0 |
| SE65K | D65 | 65 | 80 | M25x1.5 | 17.0 – 46.0 | 20.0 – 56.0 |
| SE70K | D70 | 70 | 80 | M25x1.5 | 17.0 – 50.0 | 20.0 – 61.0 |
| SE75K | D75 | 75 | 80 | M25x1.5 | 48.0 – 53.0 | 59.0 – 65.0 |

DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

CAV BAR FEED COLLETS



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

CAV BAR FEED COLLET OPTIONS

USE OF CAV BAR FEED COLLETS

The CAV bar feed collets are mounted on the rotating inserts and secured with a cross pin.



STANDARD ROUND

- Suitable for round material



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material



SPECIAL PROFILES

- Various profiles can be realized by ram EDM or wire EDM
- Tension and shape of the bar feed collets can be exactly adapted to the material



CROWN DESIGN

- Channel can be used completely
- Fast & easy threading of the profile material
- Hexagon and square material that were previously not possible in the channel, can be loaded by the crown bar feed collet
- The material does not have to be chamfered as for standard bar feed collets, it can be sharp-edged



TENSION

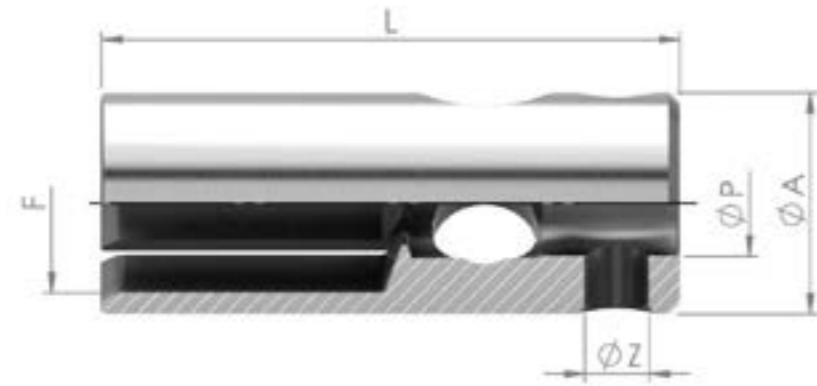
- Tension can be increased or reduced according to requirements



CLOSED DESIGN

- Channel can be used completely

CAV BAR FEED COLLETS



A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | Ø Z [mm] | L [mm] | F min. – max. [mm] |
|---------|-------------|----------|----------|----------|--------|--------------------|
| CAV7 | D7 | 7 | M6x1L | | 40 | 1.5 – 5.9 |
| CAV10 | D10 | 10 | M6x1L | | 40 | 2.0 – 8.5 |
| CAV12 | D12 | 12 | M6x1L | | 40 | 8.5 – 10.5 |
| CAV15 | D15 | 15 | 10 | 6 | 55 | 3.0 – 14.0 |
| CAV17 | D17 | 17 | 10 | 6 | 55 | 14.0 – 16.0 |
| CAV19 | D19 | 19 | 10 | 6 | 55 | 16.0 – 17.0 |
| CAV21 | D21 | 21 | 10 | 6 | 55 | 17.0 – 19.0 |
| CAV25 | D25 | 25 | 16 | 8 | 76 | 5.0 – 22.0 |
| CAV32 | D32 | 32 | 16 | 8 | 76 | 15.5 – 29.5 |
| CAV34 | D34 | 34 | 16 | 8 | 76 | 19.0 – 31.0 |

BAR FEED COLLETS

TOP AUTOMAZIONI

DO YOU ALREADY KNOW THE SCHLENKER TOP BAR FEED COLLETS?

For the TOP Automazioni loading magazines, we can supply you bar feed collets in various sizes. All you need to do is sending us a request.



You would like to order a TOP bar feed collet?

Please contact us by phone or e-mail.

Phone: +49 7720 9944-0 | E-mail: info@schlenker-spannwerkzeuge.de

CUCCHI BAR FEED COLLETS

CUCCHI BAR FEED COLLET OPTIONS









Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



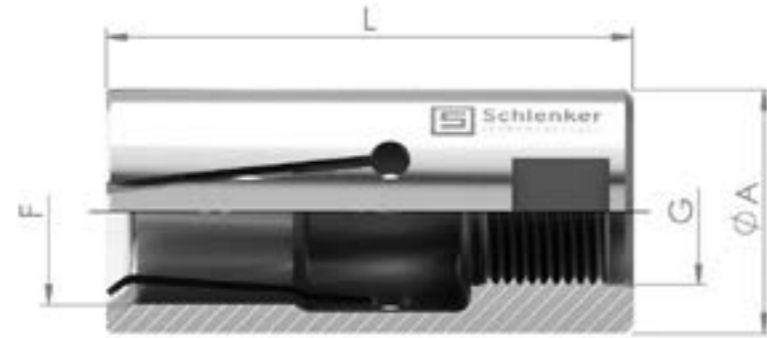
USE OF CUCCHI BAR FEED COLLETS

The CUCCHI bar feed collets are suitable for all CUCCHI loading magazines. The bar feed collets are mounted and fixed on the rotating inserts through an internal thread.

| | |
|---|--|
|  | <p>STANDARD ROUND</p> <ul style="list-style-type: none"> • Suitable for round material |
|  | <p>SQUARE</p> <ul style="list-style-type: none"> • Suitable for square material |
|  | <p>HEXAGON</p> <ul style="list-style-type: none"> • Suitable for hexagon material |

| | |
|---|--|
|  | <p>SPECIAL PROFILES</p> <ul style="list-style-type: none"> • Various profiles can be realized by ram EDM or wire EDM • Tension and shape of the bar feed collets can be exactly adapted to the material |
|  | <p>CROWN DESIGN</p> <ul style="list-style-type: none"> • Channel can be used completely • Fast & easy threading of the profile material • Hexagon and square material that were previously not possible in the channel, can be loaded by the crown bar feed collet • The material does not have to be chamfered as for standard bar feed collets, it can be sharp-edged |
|  | <p>TENSION</p> <ul style="list-style-type: none"> • Tension can be increased or reduced according to requirements |
|  | <p>CLOSED DESIGN</p> <ul style="list-style-type: none"> • Channel can be used completely |

CUCCHI BAR FEED COLLETS



A Outer diameter L Total length G Thread F Shape

| Article | Ø A [mm] | L [mm] | G | F min. – max. [mm] |
|---------|----------|--------|----------|--------------------|
| | | | | ● |
| PB28 | 28 | 65 | M18x1.5L | 10.0 – 26.0 |
| PB29 | 29 | 65 | M18x1.5L | 10.0 – 27.0 |
| PB30 | 30 | 65 | M18x1.5L | 10.0 – 28.0 |
| PB35 | 35 | 70 | M18x1.5L | 10.0 – 33.0 |
| PB36 | 36 | 70 | M18x1.5L | 10.0 – 34.0 |
| PB38 | 38 | 70 | M25x1.5L | 10.0 – 36.0 |
| PB41 | 41 | 70 | M25x1.5L | 20.0 – 39.0 |
| PB42 | 42 | 70 | M25x1.5L | 20.0 – 40.0 |
| PB60 | 60 | 80 | M30x1.5L | 20.0 – 51.0 |

MISSION SUSTAINABILITY THINK DIFFERENT, GO ECO

SCHLENKER ATTACH GREAT IMPORTANCE TO SUSTAINABILITY

We at Schlenker Spannwerkzeuge attach great importance to sustainability and a responsible approach to our environment. We conserve resources when developing new technologies and consciously face the resulting environmental as well as economic challenges. Corporate success and responsible action are not contradictory for us!

SAVE AND GENERATE ENERGY

We pay attention to a constant reduction of our energy consumption by switching to LED lighting, optimizing our production processes and sorting out obsolete machines as well as by switching to machines or assets with highly efficient motors. In addition, we place a great importance on sustainable energy production. For this reason, we produce our own electricity through a photovoltaic system on the roof. We also use our combined heat and power units to generate electricity in addition to heat, and in summer we can use them for air conditioning the building through absorption refrigeration systems. Another sustainable option for heating the production and office building is also provided by the exhaust heat from our production machines.

FOR THE LOVE OF THE ENVIRONMENT – DIGITALIZATION AT SCHLENKER

We also see the digitalization of our processes as a great opportunity to work sustainably. In this way, we offer digital and simple customer support, thus saving on travel. For the love of the environment, we also completely waived the sending of paper invoices by switching our system to e-invoices.

ECOLOGICAL WASTE MANAGEMENT AND PACKAGING MATERIALS

Waste management plays a major role in sustainability order to protect the climate and save resources. We pay close attention to consistent waste separation by qualified disposal companies. In addition, we are always reducing plastic in our shipping and packaging materials. For this reason, we only use ecologically degradable paper tape.



You can find out more about sustainability on our website.
www.schlenker-spannwerkzeuge.de/en/sustainability/

SHK INSIDE CLAMPING SLEEVES



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF SHK INSIDE CLAMPING SLEEVES

The SHK inside clamping sleeves are mounted on the rotating inserts and secured with a cross pin.



STANDARD

- Suitable for tubes or drilled bar material



SEALED

- Inside clamping sleeves are fully sealed to prevent the entry of coolants into the loading magazine



TENSION

- Tension can be increased or reduced according to requirements

SHK INSIDE CLAMPING SLEEVE OPTIONS



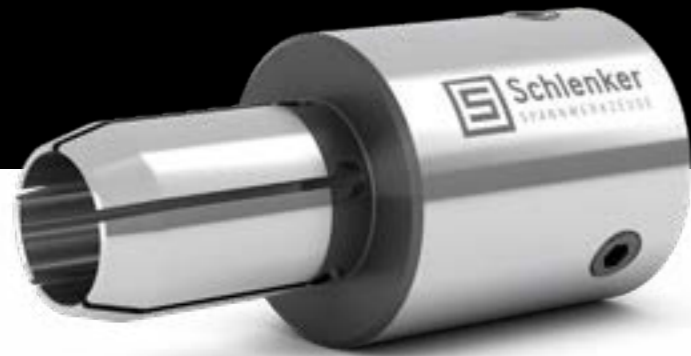
A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | Ø Z [mm] | L [mm] | F min. – max. [mm] |
|----------------|-------------|----------|----------|----------|--------|--------------------|
| | | | | | | ● |
| SI7 SHKI7 | D7 | 7 | M5 | | 37 | 3.5 – 6.0 |
| SI10 SHKI10 | D10 | 10 | 7H7 | 4 | 40 | 3.5 – 9.0 |
| SI12 SHKI12 | D12 | 12 | 8H7 | 4 | 40 | 3.5 – 11.0 |
| SI15 SHKI15 | D15 | 15 | 11H7 | 6 | 40 | 3.5 – 14.0 |
| SI16 SHKI16 | D16 | 16 | 11H7 | 6 | 40 | 3.5 – 15.0 |
| SI18 SHKI18 | D18 | 18 | 11H7 | 6 | 40 | 5.0 – 17.0 |
| SI20 SHKI20 | D20 | 20 | 14H7 | 8 | 65 | 5.0 – 19.0 |
| SI25 SHKI25 | D25 | 25 | 20H7 | 8 | 65 | 5.0 – 24.0 |
| SI28 SHKI28 | D28 | 28 | 20H7 | 8 | 65 | 6.0 – 27.0 |
| SI30 SHKI30 | D30 | 30 | 20H7 | 8 | 65 | 6.0 – 29.0 |
| SI32 SHKI32 | D32 | 32 | 20H7 | 8 | 65 | 6.0 – 31.0 |
| SI34 SHKI34 | D34 | 34 | 20H7 | 8 | 65 | 6.0 – 33.0 |
| SI36 SHKI36 | D36 | 36 | 20H7 | 8 | 65 | 10.0 – 35.0 |

TURBO INSIDE CLAMPING SLEEVES



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF TURBO INSIDE CLAMPING SLEEVES

The TURBO inside clamping sleeves are mounted on the rotating inserts and fastened with three set screws.



STANDARD

- Suitable for tubes or drilled bar material



SEALED

- Inside clamping sleeves are fully sealed to prevent the entry of coolants into the loading magazine



TENSION

- Tension can be increased or reduced according to requirements

TURBO INSIDE CLAMPING SLEEVE OPTIONS



A Outer diameter P Fit ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | L [mm] | F min. – max. [mm] |
|-----------------|-------------|----------|----------|--------|--------------------|
| | | | | | ● |
| STI25 SHTI25 | D25 | 25 | 20H7 | 90 | 6.0 – 24.0 |
| STI28 SHTI28 | D28 | 28 | 20H7 | 90 | 6.0 – 27.0 |
| STI30 SHTI30 | D30 | 30 | 20H7 | 90 | 6.0 – 29.0 |
| STI32 SHTI32 | D32 | 32 | 20H7 | 90 | 6.0 – 31.0 |
| STI34 SHTI34 | D34 | 34 | 20H7 | 90 | 6.0 – 33.0 |
| STI35 SHTI35 | D35 | 35 | 20H7 | 90 | 6.0 – 34.0 |
| STI36 SHTI36 | D36 | 36 | 20H7 | 90 | 10.0 – 35.0 |
| STI38 SHTI38 | D38 | 38 | 20H7 | 90 | 10.0 – 37.0 |
| STI40 SHTI40 | D40 | 40 | 20H7 | 90 | 10.0 – 39.0 |

TURBO INSIDE CLAMPING SLEEVES



A Outer diameter P Fit ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | L [mm] | F min. – max. [mm] |
|-------------------|----------------|-------------|--------------|-----------|-----------------------|
| | | | | | ● |
| STI42 SHTI42 | D42 | 42 | 20H7 | 90 | 10.0 – 41.0 |
| STI44 SHTI44 | D44 | 44 | 20H7 | 90 | 10.0 – 43.0 |
| STI45 SHTI45 | D45 | 45 | 20H7 | 90 | 10.0 – 44.0 |
| STI50 SHTI50 | D50 | 50 | 20H7 | 90 | 10.0 – 49.0 |
| STI54 SHTI54 | D54 | 54 | 20 | | |
| STI58 SHTI58 | D58 | 58 | 20H7 | 90 | 10.0 – 57.0 |
| STI60 SHTI60 | D60 | 60 | 20H7 | 90 | 10.0 – 59.0 |
| STI63 SHTI63 | D63 | 63 | 20H7 | 90 | 10.0 – 62.0 |
| STI65 SHTI65 | D65 | 65 | 20H7 | 90 | 10.0 – 64.0 |
| STI70 SHTI70 | D70 | 70 | 20H7 | 90 | 30.0 – 69.0 |
| STI75 SHTI75 | D75 | 75 | 20H7 35H7 | 90 | 30.0 – 74.0 |
| STI80 SHTI80 | D80 | 80 | 35H7 | 90 | 30.0 – 79.0 |
| STI90 SHTI90 | D90 | 90 | 35H7 | 90 | 40.0 – 89.0 |
| STI100 SHTI100 | D100 | 100 | 35H7 | 90 | 40.0 – 99.0 |

TURBO INSIDE CLAMPING SLEEVES FOR LOADING/UNLOADING AND FOR EJECTOR CROSSES

FOR LOADING/UNLOADING

- The tension is adjusted to the workpiece
- These inside clamping sleeves are used to load/unload blanks or workpieces

FOR EJECTOR CROSS

- These inside clamping sleeves are used to unload blanks or workpieces through the ejector cross



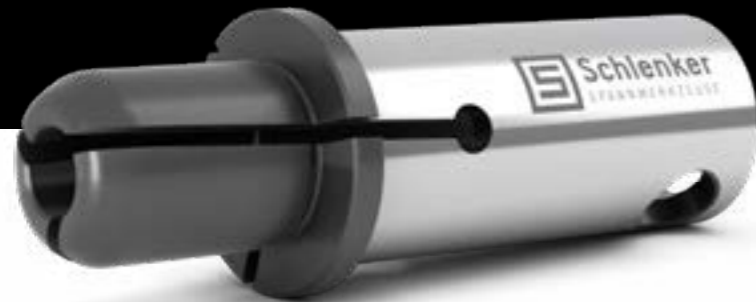
You would like to order a TURBO inside clamping sleeve?
Please contact us by phone or e-mail.

Phone: +49 7720 9944-0 | E-mail: info@schlenker-spannwerkzeuge.de

INSIDE CLAMPING SLEEVES INDEX MULTI-SPINDLE



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF INSIDE CLAMPING SLEEVES INDEX MULTI-SPINDLE

The INDEX MS inside clamping sleeves are mounted with the outer stops on the rotating inserts and secured with a cross pin. The outer stops must be adapted to the outer diameter of the bar material.

NOTES

A large area with a dotted grid pattern for taking notes.

INSIDE CLAMPING SLEEVE INDEX MULTI-SPINDLE OPTIONS



STANDARD

- Suitable for tubes or drilled bar material



SEALED

- Inside clamping sleeves are fully sealed to prevent the entry of coolants into the loading magazine



TENSION

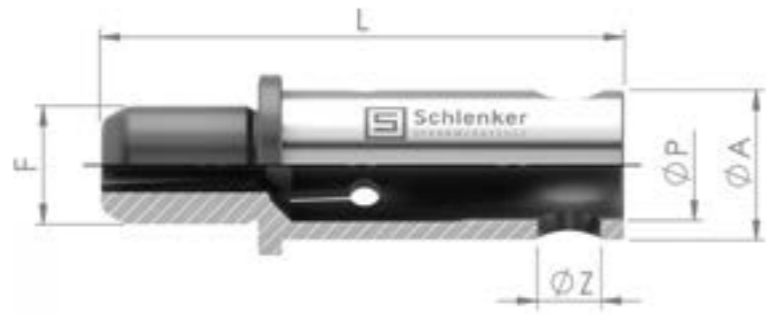
- Tension can be increased or reduced according to requirements



OUTER STOP

- Outer diameter of the outer stop and bar material must be the same
- Is mounted on the inside clamping sleeve and secured with a cross pin

INSIDE CLAMPING SLEEVE INDEX MULTI-SPINDLE



A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | Ø Z [mm] | L [mm] | F [mm] | Machine | |
|------------------------|---------------|----------|-------------|----------|--------|--------|---------|--------------------|
| | | | | | | ● | | |
| Inside clamping sleeve | S927434.1232 | D12 | 10.3 | 8H7 | 4 | 45 | 8.0 | MS22 / MS40 |
| Outer stop | SA927435.XX31 | D12 | 13.0 – 23.0 | | 4 | 32 | | |
| Inside clamping sleeve | S927535.1231 | D12 | 10.3 | 8H7 | 4 | 45 | 8.0 | MS32 |
| Outer stop | SA927536.XX31 | D12 | 13.0 – 18.0 | | 4 | 32 | | |
| Inside clamping sleeve | S927434.1233 | D12 | 10.3 | 8H7 | 4 | 46 | 8.0 | MS22 / MS32 / MS40 |
| Outer stop | SA927435.XX32 | D12 | 13.0 – 23.0 | | 4 | 26 | | |
| Inside clamping sleeve | S927535.1831 | D18 | 16 | 11H7 | 6 | 45 | 15.0 | MS22 / MS32 / MS40 |
| Outer stop | SA927536.XX31 | D18 | 19.0 – 25.0 | | 6 | 32 | | |
| Inside clamping sleeve | S927535.1841 | D18 | 16 | 11H7 | 6 | 46.5 | 15.0 | MS22 / MS32 / MS40 |
| Outer stop | SA927536.XX41 | D18 | 19.0 – 25.0 | | 6 | 26.5 | | |
| Inside clamping sleeve | S927934.1832 | D18 | 18 | 11H7 | 6 | 45 | 15.0 | MS52 |
| Outer stop | SA927975.XX31 | D18 | 22.0 – 32.0 | | | 20 | | |
| Inside clamping sleeve | S927434.2332 | D23 | 19 | 14H7 | 8 | 70 | 15.0 | MS40 |
| Outer stop | SA927435.XX31 | D23 | 24.0 – 32.0 | | 8 | 52 | | |



A Outer diameter P Fit ID Z Cross bore ID L Total length F Shape

| Article | Pusher [mm] | Ø A [mm] | Ø P [mm] | Ø Z [mm] | L [mm] | F [mm] | Machine | |
|------------------------|---------------|----------|-------------|----------|--------|--------|---------|------|
| | | | | | | ● | | |
| Inside clamping sleeve | S927434.2333 | D23 | 19 | 14H7 | 8 | 66.5 | 15.0 | MS40 |
| Outer stop | SA927435.XX32 | D23 | 24.0 – 32.0 | | | 46.5 | | |
| Inside clamping sleeve | S927535.3531 | D25 | 22 | 15H7 | 8 | 70 | 15.0 | MS32 |
| Outer stop | SA927536.XX31 | D25 | 26.0 – 36.0 | | | 52 | | |
| Inside clamping sleeve | S927434.3232 | D32 | 27 | 20H7 | 8 | 70 | 15.0 | MS40 |
| Outer stop | SA927435.XX31 | D32 | 33.0 – 40.0 | | 8 | 52 | | |
| Inside clamping sleeve | S927434.3233 | D32 | 27 | 20H7 | 8 | 61 | 15.0 | MS40 |
| Outer stop | SA927435.XX32 | D32 | 33.0 – 40.0 | | | 41 | | |
| Inside clamping sleeve | S927934.3232 | D32 | 32 | 20H7 | 8 | 70 | 20.0 | MS52 |
| Outer stop | SA927975.XX31 | D32 | 33.0 – 42.0 | | | 38 | | |
| Inside clamping sleeve | S927934.4232 | D42 | 42 | 20H7 | 8 | 70 | 20.0 | MS52 |
| Outer stop | SA927975.XX31 | D42 | 43.0 – 52.0 | | | 38 | | |
| Inside clamping sleeve | D18 IMS 52 | D18 | 18 | 11H7 | 6 | 45 | 15.0 | |
| Inside clamping sleeve | D32 IMS 52 | D32 | 32 | 20H7 | 8 | 70 | 20.0 | |
| Inside clamping sleeve | D42 IMS 52 | D42 | 42 | 20H7 | 8 | 70 | 20.0 | |

FEEDING COLLETS



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

FEEDING COLLET OPTIONS

USE OF FEEDING COLLETS

The task of the feeding collets are to feed the raw material from the bar loader into the machine. The material to be processed is guided and clamped by the feeding collets.



SMOOTH

- Suitable for round material



GROOVED

- Suitable for round material



SQUARE

- Suitable for square material



HEXAGON

- Suitable for hexagon material



PEEK / PLASTIC INSERTS

- Prevents marks on the bar material
- Inserts are replaceable when worn
- Ideal for processing scratch-sensitive materials



ALUMINIUM INSERTS

- Prevents marks on the bar material
- Inserts are replaceable when worn
- Ideal for processing scratch-sensitive materials

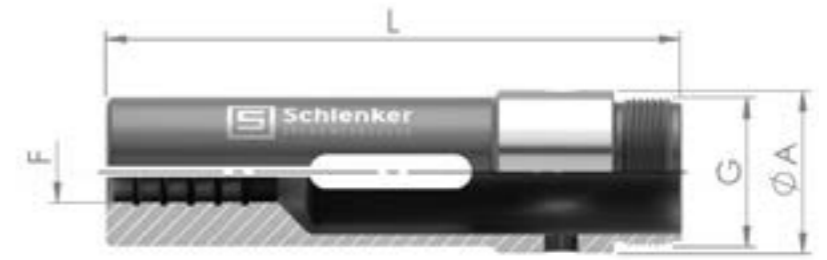


BRASS INSERTS

- Prevents marks on the bar material
- Inserts are replaceable when worn
- Ideal for processing scratch-sensitive materials

| | |
|--|---|
|  | <p>BRONZE INSERTS</p> <ul style="list-style-type: none"> • Prevents marks on the bar material • Inserts are replaceable when worn • Ideal for processing scratch-sensitive materials |
|  | <p>PERMAGLIS INSERTS</p> <ul style="list-style-type: none"> • Prevents marks on the bar material • Inserts are replaceable when worn • Ideal for processing scratch-sensitive materials |
|  | <p>TENSION</p> <ul style="list-style-type: none"> • Tension can be increased or reduced according to requirements |

FEEDING COLLETS



A Outer diameter L Total length G Thread F Shape

| Article | Ø A [mm] | L [mm] | G [mm] | F max. [mm] | | |
|---------|----------|--------|--------|-------------|------|------|
| | | | | ● | ■ | ⬡ |
| E207 | 18 | 70 | M16x1L | 12.0 | 9.0 | 11.0 |
| E217 | 21 | 70 | M20x1L | 16.0 | 11.0 | 14.0 |
| E220 | 24 | 85 | M22x1L | 18.0 | 13.0 | 16.0 |
| E236 | 30 | 95 | M28x1L | 24.0 | 16.0 | 21.0 |
| E237 | 31 | 90 | M29x1L | 25.0 | 18.0 | 22.0 |
| E254 | 42 | 116 | M40x1L | 36.0 | 25.0 | 31.0 |
| E273 | 60 | 140 | M58x1L | 52.0 | 36.0 | 45.0 |

i DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

FEEDING COLLETS MULTI-SPINDLE



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF FEEDING COLLETS MULTI-SPINDLE

The task of the multi-spindle feeding collets are to feed the raw material from the bar loader into the machine. The material to be processed is guided and clamped by the feeding collets.



SMOOTH

- Suitable for round material



GROOVED

- Suitable for round material



SQUARE

- Suitable for square material

FEEDING COLLET MULTI-SPINDLE OPTIONS



HEXAGON

- Suitable for hexagon material



PEEK / PLASTIC INSERTS

- Prevents marks on the bar material
- Inserts are replaceable when worn
- Ideal for processing scratch-sensitive materials



ALUMINIUM INSERTS

- Prevents marks on the bar material
- Inserts are replaceable when worn
- Ideal for processing scratch-sensitive materials



BRASS INSERTS

- Prevents marks on the bar material
- Inserts are replaceable when worn
- Ideal for processing scratch-sensitive materials



BRONZE INSERTS

- Prevents marks on the bar material
- Inserts are replaceable when worn
- Ideal for processing scratch-sensitive materials



PERMAGLIS INSERTS

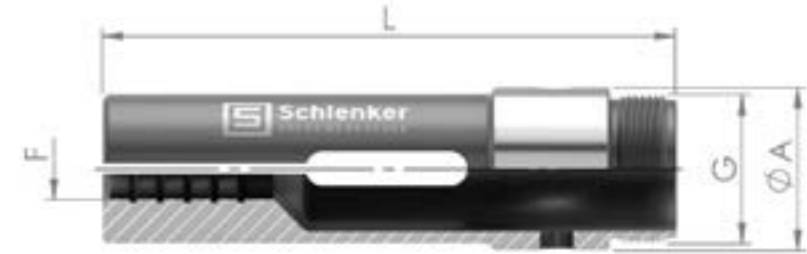
- Prevents marks on the bar material
- Inserts are replaceable when worn
- Ideal for processing scratch-sensitive materials



TENSION

- Tension can be increased or reduced according to requirements

FEEDING COLLETS MULTI-SPINDLE



A Outer diameter L Total length G Thread F Shape

| Article | Ø A [mm] | L [mm] | G [mm] | F max. [mm] | | |
|---------|----------|--------|----------|-------------|------|------|
| | | | | ● | ■ | ⬡ |
| E9268 | 22 | 86 | M20x1 | 16.0 | 11.0 | 13.5 |
| E9265 | 22.8 | 98 | M20x0.75 | 16.0 | 11.0 | 13.5 |
| E9255 | 25 | 88 | M23x1 | 18.5 | 13.0 | 16.0 |
| E9258 | 25 | 90 | M24x1 | 20.0 | 14.0 | 17.0 |
| E9282 | 34.7 | 118 | M33x1.5 | 25.0 | 18.0 | 22.0 |
| E9319 | 41.8 | 130 | M38x1.5 | 32.0 | 23.0 | 28.0 |
| E9372 | 51 | 154 | M48x1.5 | 40.0 | 28.0 | 35.0 |



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

RS OUTER SLEEVES



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



RS INNER COLLETS



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF RS FEEDING COLLETS

The task of the RS feeding collets are to feed the raw material from the bar loader into the machine. For this purpose, the inner collet is screwed into the outer sleeve with a special wrench.



d Shaft-Ø L Total length G Thread

| Article | Ø d [mm] | L [mm] | G [mm] |
|----------------|----------|--------|------------|
| RS16 (E9255) | 25 | 78 | M23x1 |
| RS20 (E9258) | 25.5 | 80 | M24x1 |
| RS24 (E9258-2) | 30.5 | 78 | M28.5x0.75 |
| RS25 (E9282) | 35 | 106 | M33x1.5 |
| RS32 (E9319) | 41.9 | 120 | M38x1.5 |
| RS40 (E9372) | 51 | 140 | M48x1.5 |

i DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

USE OF RS FEEDING COLLETS

The inner collet can be adjusted multiple times and has therefore a longer service life. The adjustable thrust force significantly reduces the abrasion and wear of the feeding collets.



d Shaft-Ø A Head-Ø L Total length G Thread F Shape

| Article | Ø d [mm] | Ø A [mm] | L [mm] | G [mm] | F min. – max. [mm] | | |
|---------|----------|----------|--------|--------|--------------------|-------------|------------|
| | | | | | ● | ■ | ⬡ |
| RS16 | 18 | 20.8 | 61 | M18x1 | 2.5 – 16.0 | 4.0 – 11.0 | 4.0 – 13.0 |
| RS20 | 20 | 23.8 | 61 | M20x1 | 4.0 – 18.0 | 4.0 – 12.0 | 4.0 – 14.5 |
| RS24 | 24 | 27.8 | 65 | M24x1 | 4.0 – 22.0 | 5.0 – 15.0 | 5.0 – 19.0 |
| RS25 | 28 | 31.8 | 72 | M28x1 | 4.0 – 25.0 | 7.0 – 17.0 | 6.0 – 22.0 |
| RS32 | 35 | 38.6 | 83 | M35x1 | 4.0 – 32.0 | 7.0 – 21.0 | 7.0 – 27.0 |
| RS40 | 44 | 48 | 90 | M44x1 | 6.0 – 40.0 | 10.0 – 28.0 | 7.0 – 34.0 |

i DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

FRONT EJECTORS VKK



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF FRONT EJECTORS VKK

Front ejectors, also called VKK, are mounted like the bar feed collets, on the rotating inserts, which are fixed with the feed rod. The bar material can only be pushed over the front ejectors in the machine direction. Residual piece ejection takes place in the work space. Depending on the manufacturer, the front ejectors are connected to the rotating inserts via a cross pin, three set screws or an internal thread.



SHK

- Suitable for round material
- Available sizes D10 to D40



TURBO

- Suitable for round material
- Available sizes D25 to D100

FRONT EJECTOR VKK VERSIONS

- SHK VKK
- TURBO VKK

SHK VKK FRONT EJECTORS



A Outer diameter P Fit ID L Total length

| Article | Ø A [mm] | Ø P [mm] | L [mm] |
|---------|----------|----------|--------|
| VKK10 | 10.3 | 7H7 | 40 |
| VKK12 | 12.3 | 8H7 | 40 |
| VKK13 | 13.3 | 8H7 | 40 |
| VKK14 | 14.3 | 8H7 | 40 |
| VKK15 | 15.3 | 11H7 | 40 |
| VKK16 | 16.3 | 11H7 | 40 |
| VKK17 | 17.3 | 11H7 | 40 |
| VKK18 | 18.3 | 11H7 | 40 |
| VKK20 | 20.3 | 14H7 | 65 |
| VKK22 | 22.3 | 14H7 | 65 |
| VKK24 | 24.3 | 14H7 | 65 |

SHK VKK FRONT EJECTORS



A Outer diameter P Fit ID L Total length

| Article | Ø A [mm] | Ø P [mm] | L [mm] |
|---------|----------|----------|--------|
| VKK25 | 25.3 | 20H7 | 65 |
| VKK26 | 26.3 | 20H7 | 65 |
| VKK28 | 28.3 | 20H7 | 65 |
| VKK30 | 30.3 | 20H7 | 65 |
| VKK31 | 31.3 | 20H7 | 65 |
| VKK32 | 32.3 | 20H7 | 65 |
| VKK34 | 34.3 | 20H7 | 65 |
| VKK35 | 35.3 | 20H7 | 65 |
| VKK36 | 36.3 | 20H7 | 65 |
| VKK38 | 38.3 | 20H7 | 65 |
| VKK40 | 40.3 | 20H7 | 65 |

TURBO VKK FRONT EJECTORS



A Outer diameter P Fit ID L Total length

| Article | Ø A [mm] | Ø P [mm] | L [mm] |
|----------------|----------|----------|--------|
| VKK25 | 25.3 | 20H7 | 90 |
| VKK26 | 26.3 | 20H7 | 90 |
| VKK28 | 28.3 | 20H7 | 90 |
| VKK30 | 30.3 | 20H7 | 90 |
| VKK31 | 31.3 | 20H7 | 90 |
| VKK32 | 32.3 | 20H7 | 90 |
| VKK34 | 34.3 | 20H7 | 90 |
| VKK35 | 35.3 | 20H7 | 90 |
| VKK36 | 36.3 | 20H7 | 90 |
| VKK38 | 38.3 | 20H7 | 90 |
| VKK40 | 40.3 | 20H7 | 90 |
| VKK41 | 41.3 | 20H7 | 90 |
| VKK42 | 42.3 | 20H7 | 90 |
| VKK44 | 44.3 | 20H7 | 90 |
| VKK45 | 45.3 | 20H7 | 90 |
| VKK46 | 46.3 | 20H7 | 90 |
| VKK50 | 50.3 | 20H7 | 90 |
| VKK51 | 51.3 | 20H7 | 90 |
| VKK55 | 55.3 | 20H7 | 90 |
| VKK60 | 60.3 | 20H7 | 90 |
| VKK65 | 65.3 | 20H7 | 90 |
| VKK67 – VKK100 | | PR | |

FRONT EJECTORS SKK



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF FRONT EJECTORS SKK

Front ejectors, also called SKK, are mounted like the bar feed collets, on the rotating inserts, which are fixed with the feed rod. The tube material can only be pushed over the front ejectors in the machine direction. Residual piece ejection takes place in the work space. Depending on the manufacturer, the front ejectors are connected to the rotating inserts via a cross pin, three set screws or an internal thread.



SHK

- Suitable for round material
- Available sizes D10 to D40



TURBO

- Suitable for round material
- Available sizes D25 to D100

FRONT EJECTOR SKK VERSIONS

- SHK SKK
- TURBO SKK

SHK SKK FRONT EJECTORS



A Outer diameter P Fit ID L Total length

| Article | Ø A [mm] | Ø P [mm] | L [mm] |
|---------|----------|----------|--------|
| SKK10 | 10.3 | 7H7 | 40 |
| SKK12 | 12.3 | 8H7 | 40 |
| SKK13 | 13.3 | 8H7 | 40 |
| SKK14 | 14.3 | 8H7 | 40 |
| SKK15 | 15.3 | 11H7 | 40 |
| SKK16 | 16.3 | 11H7 | 40 |
| SKK17 | 17.3 | 11H7 | 40 |
| SKK18 | 18.3 | 11H7 | 40 |
| SKK20 | 20.3 | 14H7 | 65 |
| SKK22 | 22.3 | 14H7 | 65 |
| SKK24 | 24.3 | 14H7 | 65 |
| SKK25 | 25.3 | 20H7 | 65 |

SHK SKK FRONT EJECTORS



A Outer diameter P Fit ID L Total length

| Article | Ø A [mm] | Ø P [mm] | L [mm] |
|---------|----------|----------|--------|
| SKK26 | 26.3 | 20H7 | 65 |
| SKK28 | 28.3 | 20H7 | 65 |
| SKK30 | 30.3 | 20H7 | 65 |
| SKK31 | 31.3 | 20H7 | 65 |
| SKK32 | 32.3 | 20H7 | 65 |
| SKK34 | 34.3 | 20H7 | 65 |
| SKK35 | 35.3 | 20H7 | 65 |
| SKK36 | 36.3 | 20H7 | 65 |
| SKK38 | 38.3 | 20H7 | 65 |
| SKK40 | 40.3 | 20H7 | 65 |

TURBO SKK FRONT EJECTORS



A Outer diameter P Fit ID L Total length

| Article | Ø A [mm] | Ø P [mm] | L [mm] |
|----------------|----------|----------|--------|
| SKK25 | 25.3 | 20H7 | 90 |
| SKK26 | 26.3 | 20H7 | 90 |
| SKK28 | 28.3 | 20H7 | 90 |
| SKK30 | 30.3 | 20H7 | 90 |
| SKK31 | 31.3 | 20H7 | 90 |
| SKK32 | 32.3 | 20H7 | 90 |
| SKK34 | 34.3 | 20H7 | 90 |
| SKK35 | 35.3 | 20H7 | 90 |
| SKK36 | 36.3 | 20H7 | 90 |
| SKK38 | 38.3 | 20H7 | 90 |
| SKK40 | 40.3 | 20H7 | 90 |
| SKK41 | 41.3 | 20H7 | 90 |
| SKK42 | 42.3 | 20H7 | 90 |
| SKK44 | 44.3 | 20H7 | 90 |
| SKK45 | 45.3 | 20H7 | 90 |
| SKK46 | 46.3 | 20H7 | 90 |
| SKK50 | 50.3 | 20H7 | 90 |
| SKK51 | 51.3 | 20H7 | 90 |
| SKK55 | 55.3 | 20H7 | 90 |
| SKK60 | 60.3 | 20H7 | 90 |
| SKK65 | 65.3 | 20H7 | 90 |
| SKK67 – SKK100 | | PR | |

ROTATING INSERTS



HSL Roating Inserts **246**

TURBO Rotating Inserts **248**

Various Rotating Inserts **252**

HSL ROTATING INSERTS



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

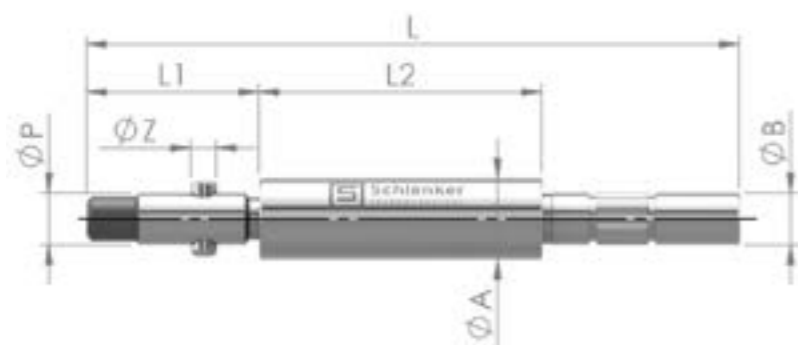


WATCH NOW THE PRODUCT VIDEO
www.schlenker-spannwerkzeuge.de/en



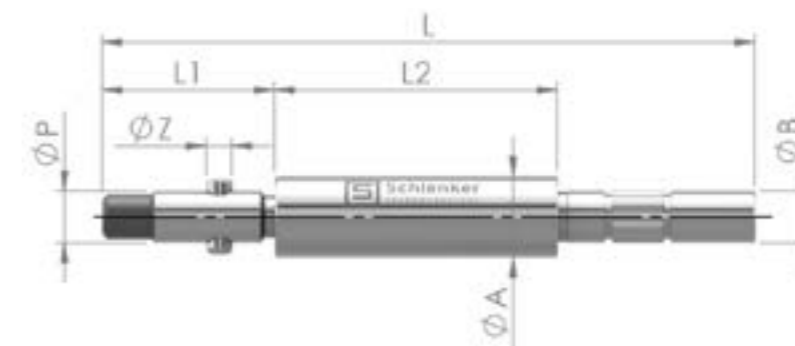
USE OF HSL ROTATING INSERTS

HSL rotating inserts are pressed into the feed rod and additionally pinned if required. The bar feed collets are fastened to the rotating inserts via a cross pin.



- A Outside diameter
- B Pusher interface
- P Fit ID
- Z Cross bore ID
- L1 Length L1
- L2 Length L2
- L Total length

| Article | Machine manufacturer | Ø A [mm] | Ø B [mm] | Ø P [mm] | Ø Z [mm] | L1 [mm] | L2 [mm] | L [mm] |
|---------|-------------------------|----------|----------|----------|----------|---------|---------|--------|
| L10 HSL | FMB, IEMCA, IRCO | 10.5 | 8 | 7 | 4 | 26.5 | 43.5 | 100 |
| L12 HSL | FMB, IEMCA, IRCO | 12.5 | 8 | 8 | 4 | 26.5 | 43.5 | 100 |
| L13 HSL | FMB, IEMCA, IRCO | 13.5 | 8 | 8 | 4 | 26.5 | 43.5 | 100 |
| L15 HSL | FMB, IEMCA, IRCO, TRAUB | 15 | 12 | 11 | 6 | 26.5 | 43.5 | 100 |
| L16 HSL | FMB, IEMCA, IRCO, TRAUB | 16 | 12 | 11 | 6 | 26.5 | 43.5 | 100 |



- A Outside diameter
- B Pusher interface
- P Fit ID
- Z Cross bore ID
- L1 Length L1
- L2 Length L2
- L Total length

| Article | Machine manufacturer | Ø A [mm] | Ø B [mm] | Ø P [mm] | Ø Z [mm] | L1 [mm] | L2 [mm] | L [mm] |
|---------|-------------------------|----------|----------|----------|----------|---------|---------|--------|
| L18 HSL | FMB, IEMCA, IRCO, TRAUB | 18 | 12 | 11 | 6 | 26.5 | 43.5 | 100 |
| L20 HSL | FMB, IEMCA, IRCO, TRAUB | 20 | 17 | 14 | 8 | 39 | 47 | 116 |
| L22 HSL | FMB, IEMCA, IRCO, TRAUB | 22 | 17 | 14 | 8 | 39 | 47 | 116 |
| L25 HSL | FMB, IEMCA, IRCO, TRAUB | 25 | 20 | 20 | 8 | 41.5 | 47.5 | 119 |
| L30 HSL | FMB, IEMCA, IRCO, TRAUB | 30 | 20 | 20 | 8 | 41.5 | 47.5 | 119 |
| L32 HSL | FMB, IEMCA, IRCO, TRAUB | 32 | 20 | 20 | 8 | 41.5 | 47.5 | 11 |
| L36 HSL | FMB, IEMCA, IRCO, TRAUB | 36 | 20 | 20 | 8 | 41.5 | 47.5 | 119 |

i DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

TURBO ROTATING INSERTS



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF TURBO ROTATING INSERTS

TURBO rotating inserts are shrunk into the feed rod and additionally pinned if required. The bar feed collets are fastened to the rotating inserts via three set screws.



ROTATING INSERTS D25-D36

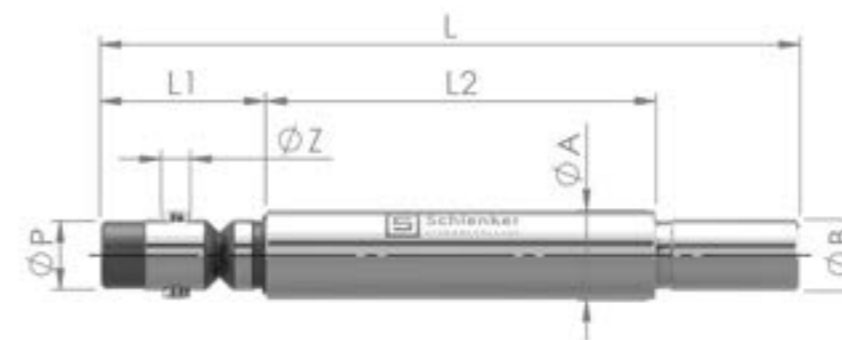
- Available sizes D25 to D36



ROTATING INSERTS D38-D100

- Available sizes D38 to D100

TURBO ROTATING INSERTS D25-D36



- A Outside diameter
- B Pusher interface
- P Fit ID
- Z Cross bore ID
- L1 Length L1
- L2 Length L2
- L Total length

| Article | Ø A [mm] | Ø B [mm] | Ø P [mm] | Ø Z [mm] | L1 [mm] | L2 [mm] | L [mm] |
|----------|----------|----------|----------|----------|---------|---------|--------|
| LT25 D25 | 20 | 20 | 20 | 8 | 46 | 110 | 196 |
| LT30 D30 | 30 | 25 | 20 | 8 | 46 | 110 | 196 |
| LT32 D32 | 32 | 25 | 20 | 8 | 46 | 110 | 196 |
| LT34 D34 | 34 | 30 | 20 | 8 | 46 | 110 | 196 |
| LT36 D36 | 36 | 30 | 20 | 8 | 46 | 110 | 196 |

TURBO ROTATING INSERTS D38-D100



A Outside diameter B Pusher interface P Fit ID L1 Length L1
L2 Length L2 L Total length

| Article | Ø A [mm] | Ø B [mm] | Ø P [mm] | L1 [mm] | L2 [mm] | L [mm] |
|----------|----------|----------|----------|---------|---------|--------|
| LT38 D38 | 38 | 30 | 20 | 46 | 110 | 196 |
| LT40 D40 | 40 | 33 | 20 | 46 | 110 | 206 |
| LT42 D42 | 42 | 33 | 20 | 46 | 110 | 206 |
| LT44 D44 | 44 | 33 | 20 | 46 | 110 | 206 |
| LT45 D45 | 45 | 33 | 20 | 46 | 110 | 206 |
| LT50 D50 | 50 | 42 | 20 | 46 | 110 | 206 |
| LT54 D54 | 54 | 42 | 20 | 46 | 110 | 206 |
| LT55 D55 | 55 | 42 | 20 | 46 | 110 | 206 |
| LT58 D58 | 58 | 51 | 20 | 46 | 110 | 231 |
| LT60 D60 | 60 | 51 | 20 | 46 | 110 | 231 |
| LT63 D63 | 63 | 51 | 20 | 46 | 110 | 231 |
| LT65 D65 | 65 | 51 | 20 | 46 | 110 | 231 |
| LT70 D70 | 70 | 51 | 20 | 46 | 110 | 231 |



A Outside diameter B Pusher interface P Fit ID L1 Length L1
L2 Length L2 L Total length

| Article | Ø A [mm] | Ø B [mm] | Ø P [mm] | L1 [mm] | L2 [mm] | L [mm] |
|------------|----------|----------|----------|---------|---------|--------|
| LT75 D75 | 75 | 65 | 20 35 | 46 | 110 | 231 |
| LT80 D80 | 80 | 65 | 35 | 46 | 110 | 231 |
| LT90 D90 | 90 | 65 | 35 | 46 | 110 | 231 |
| LT100 D100 | 100 | 82 | 35 | 46 | 110 | 231 |



DIMENSIONS NOT LISTED ARE AVAILABLE PER REQUEST.

VARIOUS ROTATING INSERTS

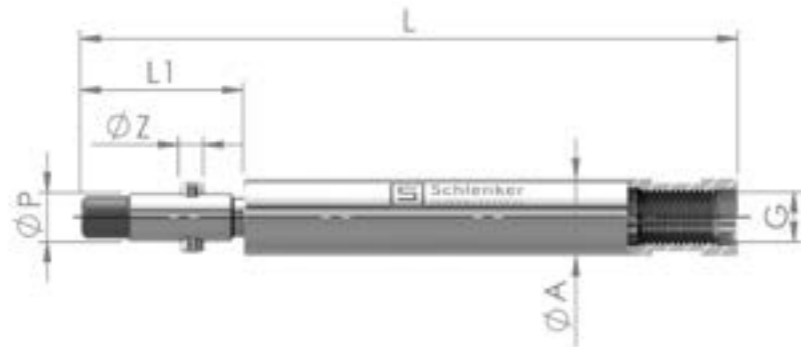


Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF IEMCA SIR STYLE ROTATING INSERTS

IEMCA SIR style rotating inserts are screwed onto the feed rod. The bar feed collets are fastened to the rotating inserts via a cross pin.



A Outside diameter **P** Fit ID **Z** Cross bore ID **L1** Length L1 **L** Total length **G** Thread

| Article | Machine manufacturer | Ø A [mm] | Ø P [mm] | Ø Z [mm] | L1 [mm] | L [mm] | G |
|---------------|----------------------|----------|----------|----------|---------|--------|--------|
| L12 IEMCA SIR | IEMCA | 12.5 | 8 | 4 | 26.5 | 107 | M9x1L |
| L15 IEMCA SIR | IEMCA | 15 | 11 | 6 | 26.5 | 127 | M12x1L |
| L18 IEMCA SIR | IEMCA | 18 | 11 | 6 | 26.5 | 127 | M15x1L |
| L23 IEMCA SIR | IEMCA | 23 | 14 | 8 | 43 | 139.5 | M18x1L |
| L24 IEMCA SIR | IEMCA | 24 | 14 | 8 | 43 | 139.5 | M18x1L |
| L25 IEMCA SIR | IEMCA | 25 | 20 | 8 | 42 | 146.5 | M22x1L |
| L32 IEMCA SIR | IEMCA | 32 | 20 | 8 | 41 | 169.5 | M28x1L |
| L36 IEMCA SIR | IEMCA | 36 | 20 | 8 | 41 | 169.5 | M30x1L |

VARIOUS ROTATING INSERT VERSIONS



Product details on our website!
www.schlenker-spannwerkzeuge.de/en

- IEMCA SIR
- IEMCA D5
- IEMCA D7
- TORNOS ERT
- FMB-TRAUB
- TRAUB

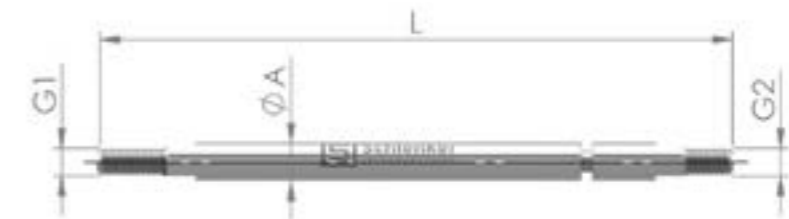
USE OF IEMCA STYLE D5 ROTATING INSERTS

IEMCA style D5 rotating inserts are screwed onto the feed rod. The bar feed collets are fastened to the rotating inserts via an internal thread.



IEMCA D5

- Available size D5



A Outside diameter **L** Total length **G1** Thread **G2** Thread

| Article | Machine manufacturer | Ø A [mm] | L [mm] | G1 | G2 |
|-------------|----------------------|----------|--------|----|----|
| L5 IEMCA D5 | IEMCA | 5.5 | 90 | M4 | M4 |

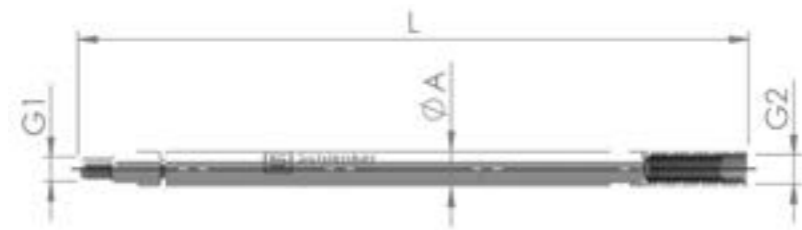
USE OF IEMCA STYLE D7 ROTATING INSERTS

IEMCA style D7 rotating inserts are screwed into the feed rod. The bar feed collets are fastened to the rotating inserts via an internal thread.



IEMCA D7

- Available size D7



A Outside diameter L Total length G1 Thread G2 Thread

| Article | Machine manufacturer | Ø A [mm] | L [mm] | G1 | G2 |
|-------------|----------------------|----------|--------|----|---------|
| L7 IEMCA D7 | IEMCA | 7.5 | 139 | M5 | M6x0.75 |

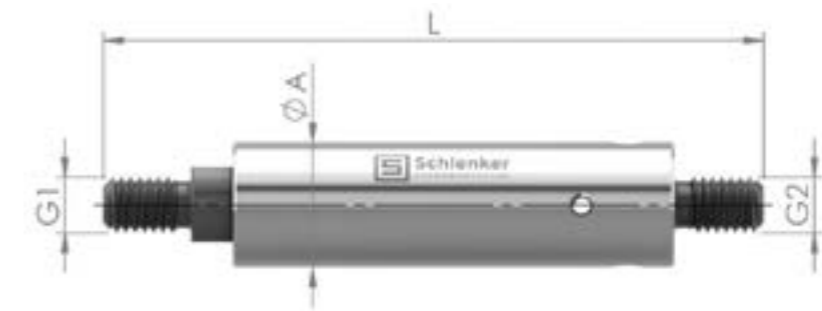
USE OF TORNOS ERT ROTATING INSERTS

TORNOS rotating inserts are screwed onto the feed rod. The bar feed collets are fastened to the rotating inserts via a cross pin.



TORNOS ERT

- Available sizes D5.5 to D13.5

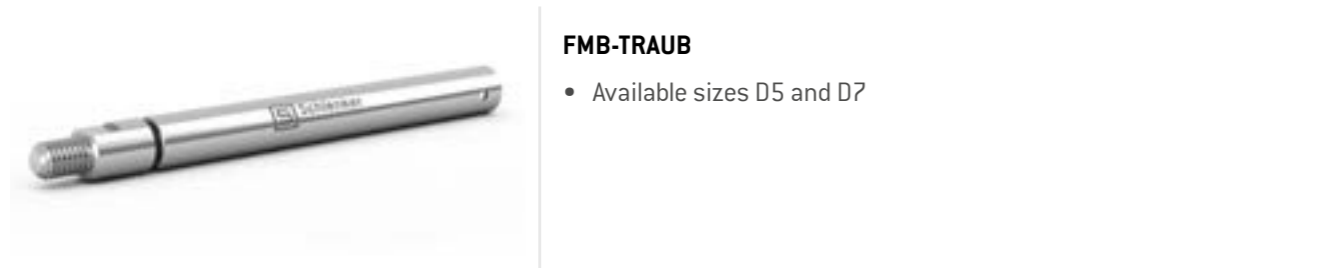


A Outside diameter L Total length G1 Thread G2 Thread

| Article | Machine manufacturer | Ø A [mm] | L [mm] | G1 | G2 |
|--------------------|----------------------|----------|--------|----|----|
| L5.5 ERT ERT 0550 | TORNOS | 5.5 | 55 | M3 | M3 |
| L7 ERT ERT 0700 | TORNOS | 7 | 41.5 | M4 | M5 |
| L7.5 ERT ERT 0750 | TORNOS | 7.5 | 42 | M4 | M5 |
| L8.5 ERT ERT 0850 | TORNOS | 8.5 | 41.5 | M5 | M5 |
| L10.5 ERT ERT 1050 | TORNOS | 10.5 | 45 | M6 | M6 |
| L13.5 ERT ERT 1350 | TORNOS | 13.5 | 52 | M6 | M6 |

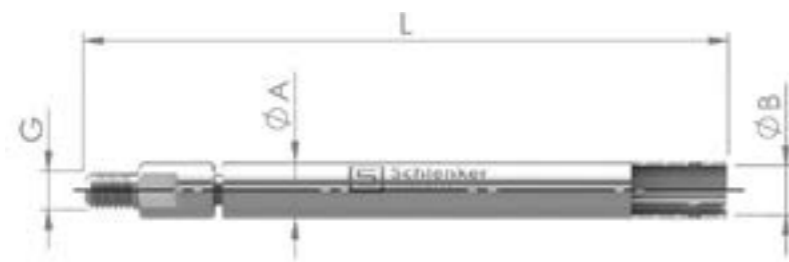
USE OF FMB-TRAUB ROTATING INSERTS

FMB-TRAUB rotating inserts are screwed into the feed rod. The bar feed collets are fastened to the rotating inserts via an internal thread.



FMB-TRAUB

- Available sizes D5 and D7



A Outside diameter B Feed rod interface G Thread L Total length

| Article | Machine manufacturer | Ø A [mm] | Ø B [mm] | L [mm] | G |
|---------|----------------------|----------|----------|--------|----|
| L5 / D5 | FMB, TRAUB | 5.5 | 4.4 | 82.5 | M4 |
| L7 / D7 | FMB, TRAUB | 7.5 | 6.4 | 83.5 | M5 |

USE OF TRAUB ROTATING INSERTS

TRAUB rotating inserts are screwed into the feed rod. The bar feed collets are fastened to the rotating inserts via an internal thread.



TRAUB

- Available sizes D10 and D12



A Outside diameter B Feed rod interface P Fit ID Z Cross bore ID L Total length

| Article | Machine manufacturer | Ø A [mm] | Ø B [mm] | Ø P [mm] | Ø Z [mm] | L [mm] |
|---------------------|----------------------|----------|----------|----------|----------|--------|
| L10 TR D10 TRAUB | TRAUB | 10.5 | 9 | 7 | 4 | 88 |
| L12 TR D12 TRAUB | TRAUB | 12.5 | 11 | 8 | 4 | 88 |



OTHER VERSIONS FOR COMMON LOADING MAGAZINES ARE AVAILABLE PER REQUEST.

OTHER SOLUTIONS



| | |
|-------------------|-----|
| Chuck Levers | 260 |
| Reducing Tubes | 261 |
| Draw Tubes | 262 |
| Option long parts | 263 |
| Collet Sleeves | 264 |
| Pressure Sleeves | 265 |
| Collet Springs | 266 |
| Cap Nuts | 267 |

CHUCK LEVERS



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF CHUCK LEVERS

Chuck levers are available for all common automatic lathes and sliding headstock lathes with toggle clamping. They are characterized above all by their precision and durability. Test the chuck levers now, you will be convinced.



NOTES

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

REDUCING TUBES



USE OF REDUCING TUBES

By using reducing tubes, the spindle bore of the CNC lathe can be adapted to the material diameter. This can prevent imbalance and vibration caused by unguided bar material, which can otherwise cause dimensional inaccuracy and negative impacts on the workpiece clamping. Well-guided bar material reduces spindle bearing wear and increases the service life of the cutting tools.



NOTES

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

DRAW TUBES



USE OF DRAW TUBES

Draw tubes are a component of the clamping system and are installed in the spindle of the lathe. Draw-in collets are screwed with their thread into the draw tubes. The workpiece is clamped by pulling the draw-in collet into the collet sleeve. Draw tubes can be manufactured in different sizes according to customer requirements.



NOTES

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

OPTION LONG PARTS



Experience our products in a 360° view with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en



USE OF OPTION LONG PARTS

Long workpieces cannot be removed in the work space. The long parts option allows the workpieces to be removed through the sub spindle of the machine. Can be manufactured in different sizes according to customer requirements.



NOTES

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

COLLET SLEEVES



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

USE OF COLLET SLEEVES

Collet sleeves are a part of the spindle in the machine. There are no limits to customer-specific requirements, as collet sleeves can be manufactured according to drawings as well as samples.



NOTES

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

PRESSURE SLEEVES



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

USE OF PRESSURE SLEEVES

Pressure sleeves are an important part of the clamping system and are installed in the spindle of the CNC lathe. They can be manufactured in different versions. For overgrip collets the taper angle of the pressure sleeve can be adjusted. Used or worn pressure sleeves can be reground or reworked within shortest time. Another possibility is to reduce the pressure sleeves, so it is possible to produce on the same machine with a smaller type of collet. There are no customer-specific limits, as pressure sleeves can be manufactured according to drawings as well as samples.



NOTES

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....

COLLET SPRINGS



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

USE OF COLLET SPRINGS

Collet springs are installed in pressure sleeves and are an important part of the clamping system.



NOTES

.....

.....

.....

.....

.....

.....

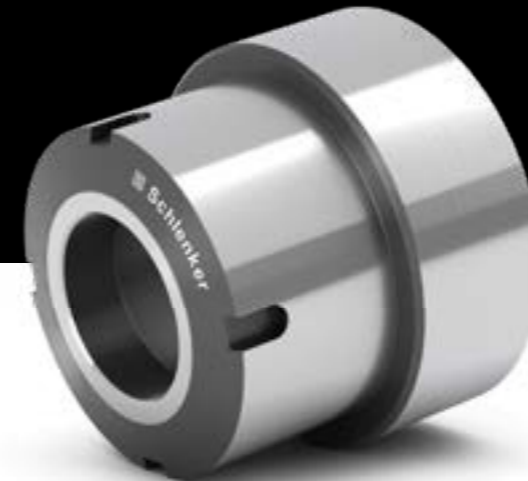
.....

.....

.....

.....

CAP NUTS



Experience our products in a 360° view
with inner details – only on our website!
www.schlenker-spannwerkzeuge.de/en

USE OF CAP NUTS

Cap nuts are used as a stop for the collets and are screwed onto the spindle of the CNC lathe. They can be manufactured according to drawings as well as samples.



NOTES

.....

.....

.....

.....

.....

.....

.....

.....

.....

.....



IMPRINT

Schlenker Spannwerkzeuge GmbH & Co. KG

In der Lache 20

D-78056 VS-Schwenningen

Tel. +49 7720 9944-0

Fax +49 7720 9944-27

info@schlenker-spannwerkzeuge.de

www.schlenker-spannwerkzeuge.de



Our general terms and conditions are available on our website.

www.schlenker-spannwerkzeuge.de/en/terms-and-conditions/

FOLLOW US

