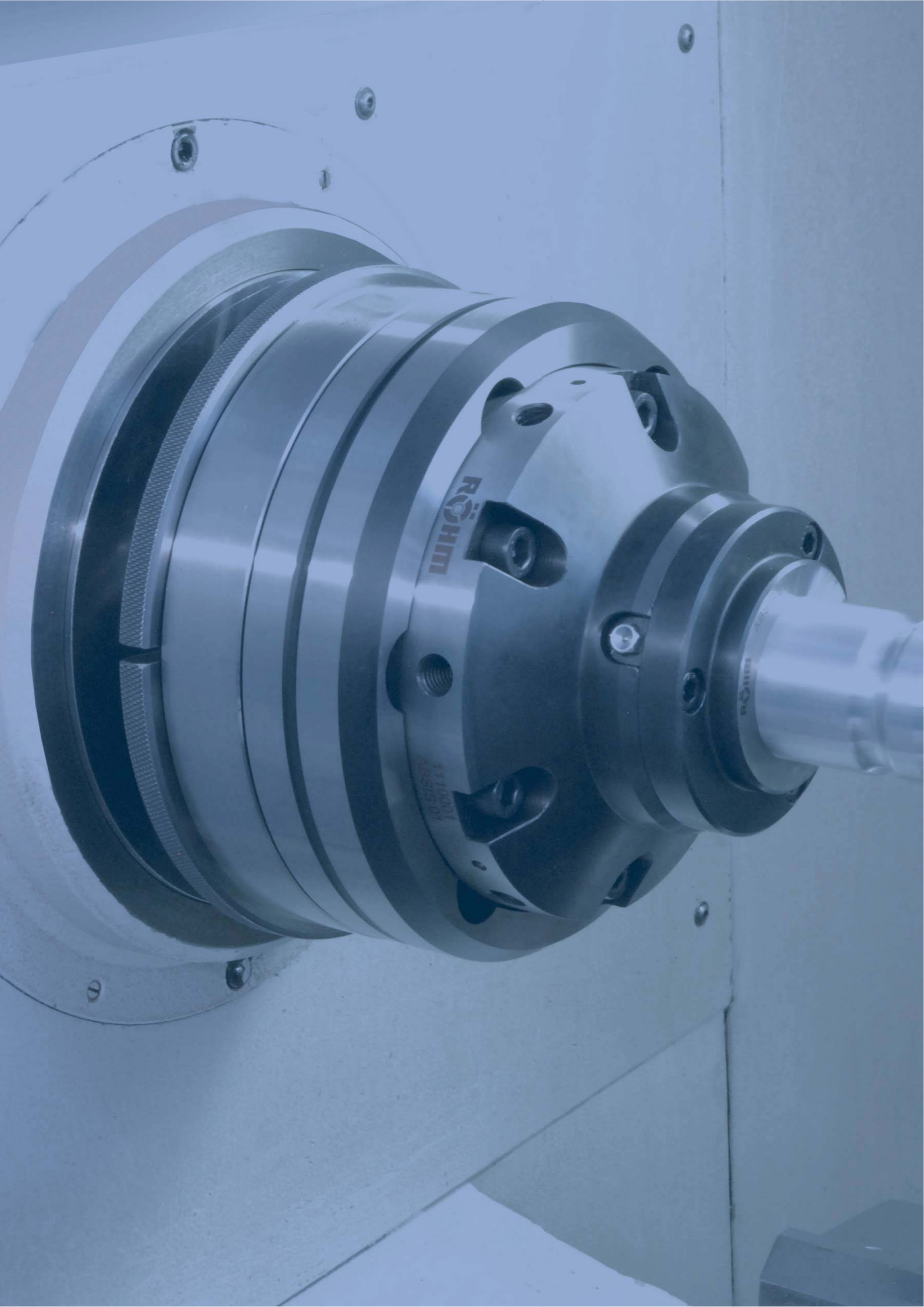




MANDRELS COLLET CHUCKS

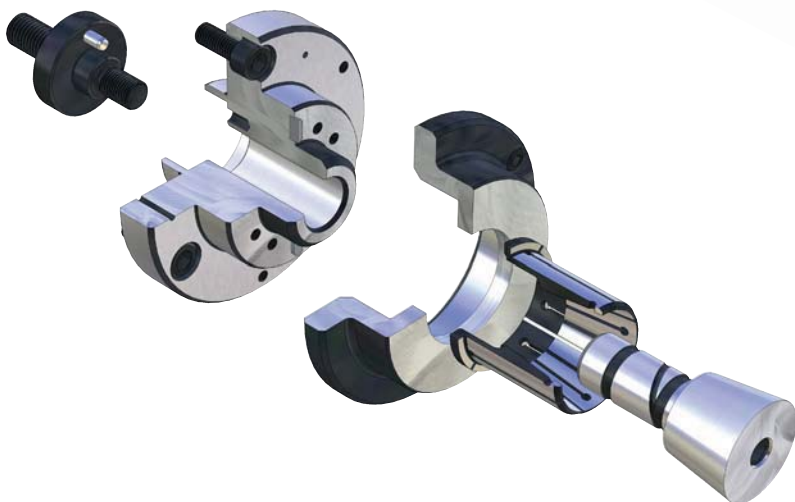
EDITION 8

RÖHM
driven by technology





HIGH AXIAL RUN-OUT PRECISION, CONCENTRICITY AND REPEATABILITY



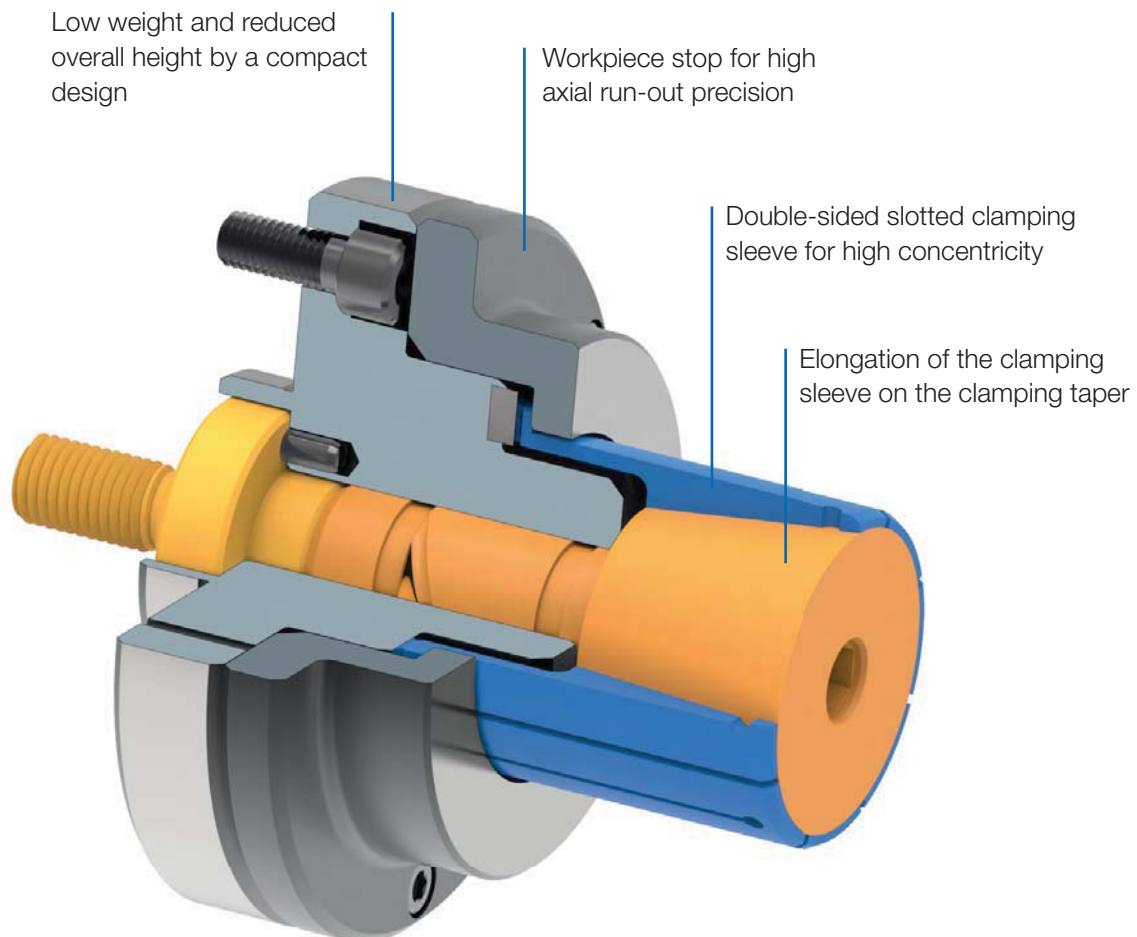
Custom-fit interaction of the individual components enables the highest degree of axial run-out precision, concentricity and repeatability.

CARTRIDGE MANDRELS

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

ADVANTAGES AT A GLANCE

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



KFS - with axial tightening, force-actuated

APPLICATION

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

TYPE

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

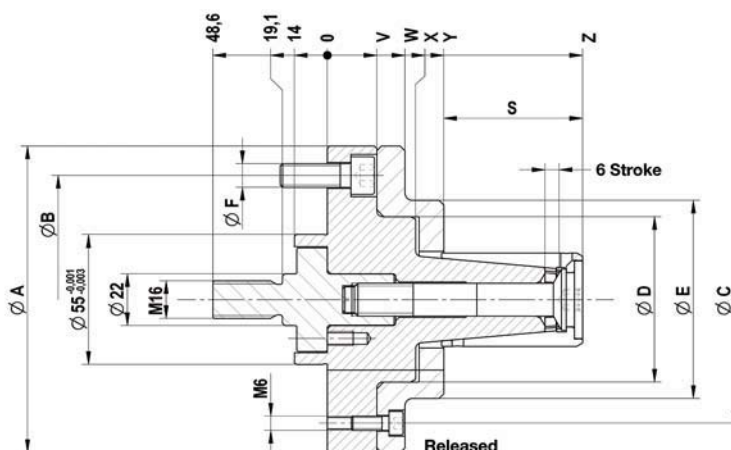
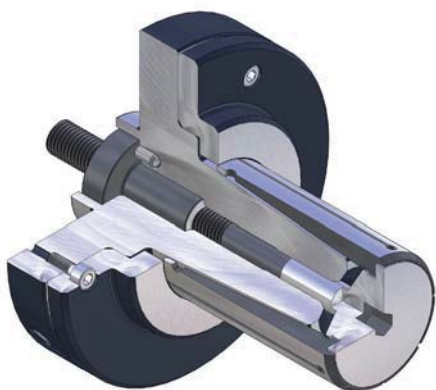
CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

KFS = force-actuated, flange, S-type



C18

KFS cartridge mandrel, **power-operated with flanged seat**, for internal clamping

Consisting of basic mandrel and intermediate piece

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

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

MFS - with axial tightening, manually actuated

APPLICATION

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

TYPE

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

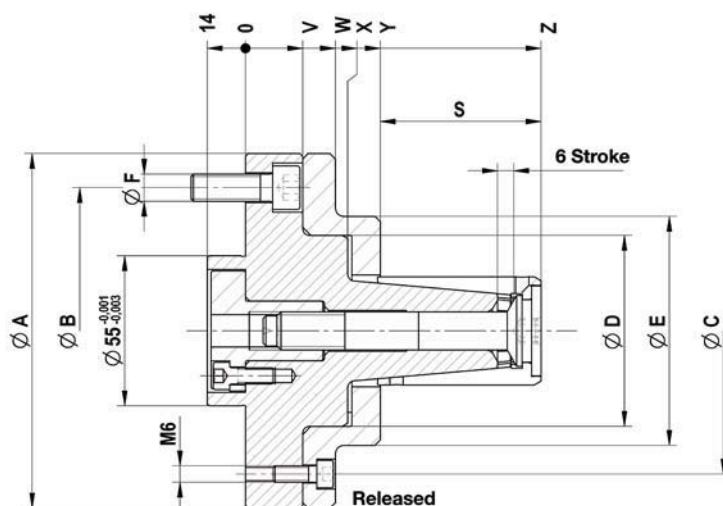
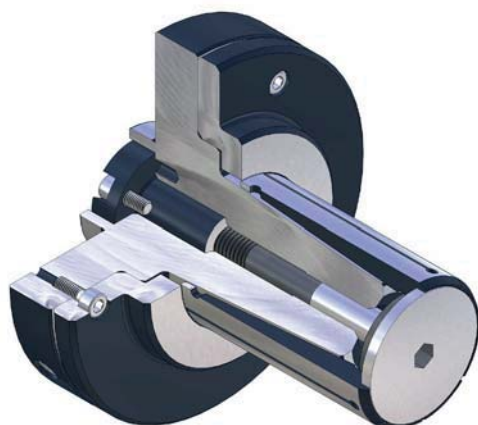
CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

MFS = manually actuated, flange, S-type



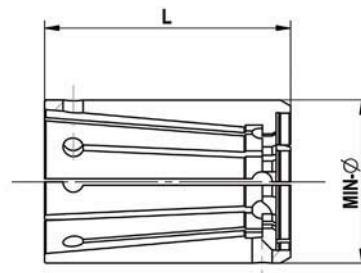
C18

MFS cartridge mandrel, **hand-operated with flanged seat**, for internal clamping

Consisting of basic mandrel and intermediate piece

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

Accessories KFS / MFS



C18

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

For size	00	01	02	03	04	05	06	07	08	09	10	11
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1
Length L mm	35	40	46	50	60	60	80	90	100	122	140	180
Min-Ø mm	14,7	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7		100,7	119,7
Clamping set	1086311	1086322	1086333	1086344	1086355	1086366	1086377	1086388	1086399		1086437 ▲	1086457 ▲
Clamping sleeve	315330	315331	315332	315333	315334	315335	315336	315337	315338		315340 ▲	315302 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477		315479	599998 ▲
Work stop	599840	599845	599850	599855	599860	599865	599992	599993 ▲	599994 ▲		599996 ▲	599997 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲		724186 ▲	724187 ▲
Min-Ø mm	15,2	20,2	25,2	30,2	35,2	40,2	45,7	55,7	65,7	81,7	101,7	120,7
Clamping set	1086312	1086323	1086334	1086345	1086356	1086367	1086378	1086389	1086400 ▲	1086417 ▲	1086438 ▲	1086458 ▲
Clamping sleeve	650021	650034	650047	650060	650073	650086	650098	650110	650123 ▲	315339 ▲	650163 ▲	650184 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599841	599846	599851	599856	599861	599866	599870	599880 ▲	599890 ▲	599995 ▲	599926 ▲	599945 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	15,7	20,7	25,7	30,7	35,7	40,7	46,7	56,7	66,7	82,7	102,7	121,7
Clamping set	1086313	1086324	1086335	1086346	1086357	1086368	1086379	1086390	1086401	1086418	1086439	1086459 ▲
Clamping sleeve	315341	315342	315343	315344	315345	315346	315347	315348 ▲	315349 ▲	650142 ▲	315351 ▲	315303 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599841	599846	599851	599856	599861	599866	599871	599881 ▲	599891 ▲	599907 ▲	599927 ▲	599946 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	16,2	21,2	26,2	31,2	36,2	41,2	47,7	57,7	67,7	83,7	103,7	122,7
Clamping set	1086314	1086325	1086336	1086347	1086358	1086369	1086380	1086391 ▲	1086402 ▲	1086419 ▲	1086440 ▲	1086460 ▲
Clamping sleeve	650023	650036	650049	650062	650075	650088	650100	650112 ▲	650125 ▲	315350 ▲	650165 ▲	650186 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599842	599847	599852	599857	599862	599867	599872	599882 ▲	599892 ▲	599908 ▲	599928 ▲	599947 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	16,7	21,7	26,7	31,7	36,7	41,7	48,7	58,7	68,7	84,7	104,7	123,7
Clamping set	1086315	1086326	1086337	1086348	1086359	1086370	1086381	1086392	1086403	1086420	1086441	1086461 ▲
Clamping sleeve	315352	315353	315354	315355	315356	315357	315358	315359	315360 ▲	650144 ▲	315362 ▲	315304 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599842	599847	599852	599857	599862	599867	599873	599883 ▲	599893 ▲	599909 ▲	599929 ▲	599948 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	17,2	22,2	27,2	32,2	37,2	42,2	49,7	59,7	69,7	85,7	105,7	124,7
Clamping set	1086316	1086327	1086338	1086349	1086360	1086371	1086382	1086393	1086404	1086421	1086442	1086462 ▲
Clamping sleeve	650025	650038	650051	650064	650077	650090	315369	315370	315371	315361 ▲	650167 ▲	650188 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599843	599848	599853	599858	599863	599868	599874	599884 ▲	599894 ▲	599910 ▲	599930 ▲	599949 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	17,7	22,7	27,7	32,7	37,7	42,7	50,7	60,7	70,7	86,7	106,7	125,7
Clamping set	1086317	1086328	1086339	1086350	1086361	1086372	1086383	1086394	1086405	1086422	1086443	1086463 ▲
Clamping sleeve	315363	315364	315365	315366	315367	315368	315380	315381	315382	650146 ▲	315373 ▲	315403 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599843	599848	599853	599858	599863	599868	599875	599885 ▲	599895 ▲	599911 ▲	599931 ▲	599950 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	18,2	23,2	28,2	33,2	38,2	43,2	51,7	61,7	71,7	87,7	107,7	126,7
Clamping set	1086318	1086329	1086340	1086351	1086362	1086373	1086384	1086395	1086406	1086423	1086444	1086464 ▲
Clamping sleeve	650027	650040	650053	650066	650079	650092	650104	650116	650129 ▲	315372 ▲	650169 ▲	650190 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599844	599849	599854	599859	599864	599869	599876	599886 ▲	599896 ▲	599912 ▲	599932 ▲	599951 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	18,7	23,7	28,7	33,7	38,7	43,7	52,7	62,7	72,7	88,7	108,7	127,7
Clamping set	1086319	1086330	1086341	1086352	1086363	1086374	1086385	1086396	1086407	1086424	1086445	1086465 ▲
Clamping sleeve	315374	315375	315376	315377	315378	315379	315385	315386	315387	650148	315384	315404 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599844	599849	599854	599859	599864	599869	599877	599887 ▲	599897 ▲	599913 ▲	599933 ▲	599952 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	19,2	24,2	29,2	34,2	39,2	44,2	53,7	63,7	73,7	89,7	109,7	128,7
Clamping set	1086320	1086331	1086342	1086353	1086364	1086375	1086386	1086397	1086408	1086425	1086446	1086466 ▲
Clamping sleeve	650029	650042	650055	650068	650081	650094	650106	650118	650131	315383 ▲	650171	650192 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599966	599967	599968	599969	599970	599971	599978	599888 ▲	599898 ▲	599914 ▲	599934 ▲	599953 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲

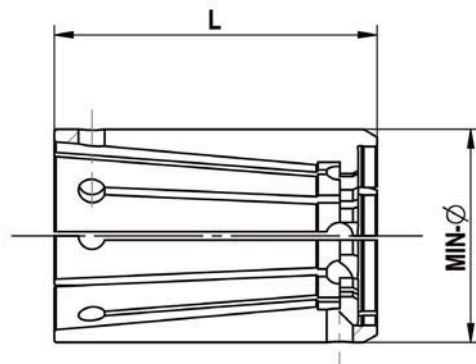
Accessories KFS / MFS

C18

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

For size	00	01	02	03	04	05	06	07	08	09	10	11
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1
Length L mm	35	40	46	50	60	60	80	90	100	122	140	180
Min-Ø mm	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	74,7	90,7	110,7	129,7
Clamping set	1086321	1086332	1086343	1086354	1086365	1086376	1086387	1086398 ▲	1086409	1086426	1086447 ▲	1086467 ▲
Clamping sleeve	650030	650043	650056	650069	650082	650095	650107	650119 ▲	315390	650150	315389 ▲	315405 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599966	599967	599968	599969	599970	599971	599879	599889	599899 ▲	599915 ▲	599935 ▲	599954 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									75,7	91,7	111,7	130,7
Clamping set									1086410 ▲	1086427 ▲	1086448 ▲	1086468 ▲
Clamping sleeve									650133	315388 ▲	650173 ▲	650194 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599900 ▲	599916 ▲	599936 ▲	599955 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									76,7	92,7	112,7	131,7
Clamping set									1086411 ▲	1086428 ▲	1086449 ▲	1086469 ▲
Clamping sleeve									315393 ▲	650152 ▲	315392 ▲	315406 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599901 ▲	599917 ▲	599937 ▲	599956 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									77,7	93,7	113,7	132,7
Clamping set									1086412 ▲	1086429 ▲	1086450 ▲	1086470 ▲
Clamping sleeve									650135 ▲	315391 ▲	650175 ▲	650196 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599902 ▲	599918 ▲	599938 ▲	599957 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									78,7	94,7	114,7	133,7
Clamping set									1086413 ▲	1086430 ▲	1086451 ▲	1086471 ▲
Clamping sleeve									315396 ▲	650154 ▲	315395 ▲	315407 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599903 ▲	599919 ▲	599939 ▲	599958 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									79,7	95,7	115,7	134,7
Clamping set									1086414	1086431 ▲	1086452 ▲	1086472 ▲
Clamping sleeve									650137	315394 ▲	650177 ▲	650198 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599904 ▲	599920 ▲	599940 ▲	599959 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									80,7	96,7	116,7	135,7
Clamping set									1086415 ▲	1086432 ▲	1086453 ▲	1086473 ▲
Clamping sleeve									315399 ▲	650156 ▲	315398 ▲	315408 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599905 ▲	599921 ▲	599941 ▲	599960 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									81,7	97,7	117,7	136,7
Clamping set									1086416 ▲	1086433 ▲	1086454 ▲	1086474 ▲
Clamping sleeve									650139 ▲	315397 ▲	650179 ▲	650200 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599906 ▲	599922 ▲	599942 ▲	599961 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm										98,7	118,7	137,7
Clamping set										1086434 ▲	1086455 ▲	1086475 ▲
Clamping sleeve										650158 ▲	315401 ▲	315409 ▲
Locking bolt										315478	315479	599998 ▲
Work stop										599923 ▲	599943 ▲	599962 ▲
Montage mandrel clamping sets										724185 ▲	724186 ▲	724187 ▲
Min-Ø mm										99,7	119,7	138,7
Clamping set										1086435 ▲	1086456 ▲	1086476 ▲
Clamping sleeve										315400 ▲	650181 ▲	650202 ▲
Locking bolt										315478	315479	599998 ▲
Work stop										599924 ▲	599944 ▲	599963 ▲
Montage mandrel clamping sets										724185 ▲	724186 ▲	724187 ▲
Min-Ø mm										100,7		139,7
Clamping set										1086436 ▲		1086477 ▲
Clamping sleeve										650160 ▲		315410 ▲
Locking bolt										315478		599998 ▲
Work stop										599925 ▲		599964 ▲
Montage mandrel clamping sets										724185 ▲		724187 ▲

Accessories KFS / MFS



C18

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

For size	00	01	02	03	04	05	06	07	08	09	10	11
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1
Length L mm	35	40	46	50	60	60	80	90	100	122	140	180
Min-Ø mm	14,7	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7		100,7	119,7
Clamping set	1086511	1086522	1086533	1086544	1086555	1086566	1086577	1086588	1086599 ▲		1086637 ▲	1086657 ▲
Clamping sleeve vulcanized	315730 ▲	315731 ▲	315732 ▲	315733	315734	315735	315736	315737	315738 ▲		315740 ▲	315702 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477		315479	599998 ▲
Work stop	599840	599845	599850	599855	599860	599865	599992	599993 ▲	599994 ▲		599996 ▲	599997 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲		724186 ▲	724187 ▲
Min-Ø mm	15,2	20,2	25,2	30,2	35,2	40,2	45,7	55,7	65,7	81,7	101,7	120,7
Clamping set	1086512	1086523	1086534	1086545	1086556	1086567	1086578	1086589	1086600 ▲	1086617 ▲	1086638 ▲	1086658 ▲
Clamping sleeve vulcanized	650211	650224	650237	650250	650263	650276	650288	651051	651063 ▲	315739 ▲	651103 ▲	651124 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599841	599846	599851	599856	599861	599866	599870	599880 ▲	599890 ▲	599995 ▲	599926 ▲	599945 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	15,7	20,7	25,7	30,7	35,7	40,7	46,7	56,7	66,7	82,7	102,7	121,7
Clamping set	1086513	1086524	1086535	1086546	1086557	1086568	1086579	1086590 ▲	1086601 ▲	1086618 ▲	1086639 ▲	1086659 ▲
Clamping sleeve vulcanized	315741 ▲	315742 ▲	315743	315744	315745	315746	315747	315748 ▲	315749 ▲	651082 ▲	315751 ▲	315703 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599841	599846	599851	599856	599861	599866	599871	599881 ▲	599891 ▲	599907 ▲	599927 ▲	599946 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	16,2	21,2	26,2	31,2	36,2	41,2	47,7	57,7	67,7	83,7	103,7	122,7
Clamping set	1086514	1086525	1086536	1086547	1086558	1086569	1086580	1086591 ▲	1086602 ▲	1086619 ▲	1086640 ▲	1086660 ▲
Clamping sleeve vulcanized	650213	650226	650239	650252	650265	650278	650290	651053 ▲	651065 ▲	315750 ▲	651105 ▲	651126 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599842	599847	599852	599857	599862	599867	599872	599882 ▲	599892 ▲	599908 ▲	599928 ▲	599947 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	16,7	21,7	26,7	31,7	36,7	41,7	48,7	58,7	68,7	84,7	104,7	123,7
Clamping set	1086515	1086526	1086537	1086548	1086559	1086570	1086581	1086592 ▲	1086603 ▲	1086620 ▲	1086641 ▲	1086661 ▲
Clamping sleeve vulcanized	315752	315753	315754	315755	315756	315757	315758	315759 ▲	315760 ▲	651084 ▲	315762 ▲	315704 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599842	599847	599852	599857	599862	599867	599873	599883 ▲	599893 ▲	599909 ▲	599929 ▲	599948 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	17,2	22,2	27,2	32,2	37,2	42,2	49,7	59,7	69,7	85,7	105,7	124,7
Clamping set	1086516	1086527	1086538	1086549	1086560	1086571	1086582	1086593 ▲	1086604 ▲	1086621 ▲	1086642 ▲	1086662 ▲
Clamping sleeve vulcanized	650215	650228	650241	650254	650267	650280	315769	315770 ▲	315771 ▲	315761 ▲	651107 ▲	651128 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599843	599848	599853	599858	599863	599868	599874	599884 ▲	599894 ▲	599910 ▲	599930 ▲	599949 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	17,7	22,7	27,7	32,7	37,7	42,7	50,7	60,7	70,7	86,7	106,7	125,7
Clamping set	1086517	1086528	1086539	1086550	1086561	1086572	1086583	1086594 ▲	1086605 ▲	1086622 ▲	1086643 ▲	1086663 ▲
Clamping sleeve vulcanized	315763	315764	315765	315766	315767	315768	315780	315781 ▲	315782 ▲	651086 ▲	315773 ▲	315705 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599843	599848	599853	599858	599863	599868	599875	599885 ▲	599895 ▲	599911 ▲	599931 ▲	599950 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	18,2	23,2	28,2	33,2	38,2	43,2	51,7	61,7	71,7	87,7	107,7	126,7
Clamping set	1086518	1086529	1086540	1086551	1086562	1086573	1086584	1086595	1086606 ▲	1086623 ▲	1086644 ▲	1086664 ▲
Clamping sleeve vulcanized	650217	650230 ▲	650243	650256 ▲	650269	650282	650294	651057	651069 ▲	315772 ▲	651109 ▲	651130 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599844	599849	599854	599859	599864	599869	599876	599886 ▲	599896 ▲	599912 ▲	599932 ▲	599951 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	18,7	23,7	28,7	33,7	38,7	43,7	52,7	62,7	72,7	88,7	108,7	127,7
Clamping set	1086519	1086530	1086541	1086552	1086563	1086574	1086585	1086596	1086607 ▲	1086624 ▲	1086645 ▲	1086665 ▲
Clamping sleeve vulcanized	315774	315775	315776	315777	315778	315779	315785	315786	315787 ▲	651088 ▲	315784 ▲	315706 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599844	599849	599854	599859	599864	599869	599877	599887 ▲	599897 ▲	599913 ▲	599933 ▲	599952 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	19,2	24,2	29,2	34,2	39,2	44,2	53,7	63,7	73,7	89,7	109,7	128,7
Clamping set	1086520	1086531	1086542	1086553	1086564	1086575	1086586	1086597 ▲	1086608 ▲	1086625 ▲	1086646 ▲	1086666 ▲
Clamping sleeve vulcanized	650219 ▲	650232	650245	650258	650271 ▲	650284 ▲	650296	651059 ▲	651071 ▲	315783 ▲	651111 ▲	651132 ▲

Accessories KFS / MFS

C18

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

For size	00	01	02	03	04	05	06	07	08	09	10	11
Expansion in Ø mm	1	1	1	1	1	1	1	1	1	1	1	1
Length L mm	35	40	46	50	60	60	80	90	100	122	140	180
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599966	599967	599968	599969	599970	599971	599878	599888 ▲	599898 ▲	599914 ▲	599934 ▲	599953 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm	19,7	24,7	29,7	34,7	39,7	44,7	54,7	64,7	74,7	90,7	110,7	129,7
Clamping set	1086521	1086532	1086543	1086554	1086565	1086576	1086587	1086598 ▲	1086609 ▲	1086626 ▲	1086647 ▲	1086667 ▲
Clamping sleeve vulcanized	650220	650233	650246 ▲	650259 ▲	650272	650285	650297	651060 ▲	651090 ▲	651090 ▲	651090 ▲	651090 ▲
Locking bolt	315469	315470	315471	315472	315473	315474	315475	315476	315477	315478	315479	599998 ▲
Work stop	599966	599967	599968	599969	599970	599971	599879	599889 ▲	599899 ▲	599915 ▲	599935 ▲	599954 ▲
Montage mandrel clamping sets	724176 ▲	724177 ▲	724178 ▲	724179 ▲	724180 ▲	724181 ▲	724182 ▲	724183 ▲	724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									75,7	91,7	111,7	130,7
Clamping set									1086610	1086627 ▲	1086648 ▲	1086668 ▲
Clamping sleeve vulcanized									651073	315788 ▲	651113 ▲	651134 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599900 ▲	599916 ▲	599936 ▲	599955 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									76,7	92,7	112,7	131,7
Clamping set									1086611 ▲	1086628 ▲	1086649 ▲	1086669 ▲
Clamping sleeve vulcanized									651074	651092	651114	651135 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599901	599917 ▲	599937 ▲	599956 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									77,7	93,7	113,7	132,7
Clamping set									1086612 ▲	1086629 ▲	1086650 ▲	1086670 ▲
Clamping sleeve vulcanized									651075	651093	651115	651136 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599902	599918 ▲	599938 ▲	599957 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									78,7	94,7	114,7	133,7
Clamping set									1086613 ▲	1086630 ▲	1086651 ▲	1086671 ▲
Clamping sleeve vulcanized									315796	651094	315795	315709 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599903	599919	599939 ▲	599958 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									79,7	95,7	115,7	134,7
Clamping set									1086614 ▲	1086631 ▲	1086652 ▲	1086672 ▲
Clamping sleeve vulcanized									651077 ▲	315794	651117	651138 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599904	599920 ▲	599940 ▲	599959 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									80,7	96,7	116,7	135,7
Clamping set									1086615 ▲	1086632 ▲	1086653 ▲	1086673 ▲
Clamping sleeve vulcanized									315799	651096	315798	315710 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599905	599921 ▲	599941	599960 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm									81,7	97,7	117,7	136,7
Clamping set									1086616 ▲	1086633 ▲	1086654 ▲	1086674 ▲
Clamping sleeve vulcanized									651079	315797	651119	651140 ▲
Locking bolt									315477	315478	315479	599998 ▲
Work stop									599906	599922 ▲	599942 ▲	599961 ▲
Montage mandrel clamping sets									724184 ▲	724185 ▲	724186 ▲	724187 ▲
Min-Ø mm										98,7	118,7	137,7
Clamping set										1086634 ▲	1086655 ▲	1086675 ▲
Clamping sleeve vulcanized									651098	315801	315711	315711 ▲
Locking bolt									315478	315479	599998	599998 ▲
Work stop									599923	599943	599962	599962 ▲
Montage mandrel clamping sets									724185 ▲	724186 ▲	724187	724187 ▲
Min-Ø mm										99,7	119,7	138,7
Clamping set										1086635 ▲	1086656 ▲	1086676 ▲
Clamping sleeve vulcanized									315800	651121	651142	651142 ▲
Locking bolt									315478	315479	599998	599998 ▲
Work stop									599924	599944	599963	599963 ▲
Montage mandrel clamping sets									724185	724186	724187	724187 ▲
Min-Ø mm										100,7		139,7
Clamping set										1086636 ▲		1086677 ▲
Clamping sleeve vulcanized									651100			315712
Locking bolt									315478			599998
Work stop									599925			599964
Montage mandrel clamping sets									724185			724187

Intermediate flange KFS / MFS



APPLICATION

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

TYPE

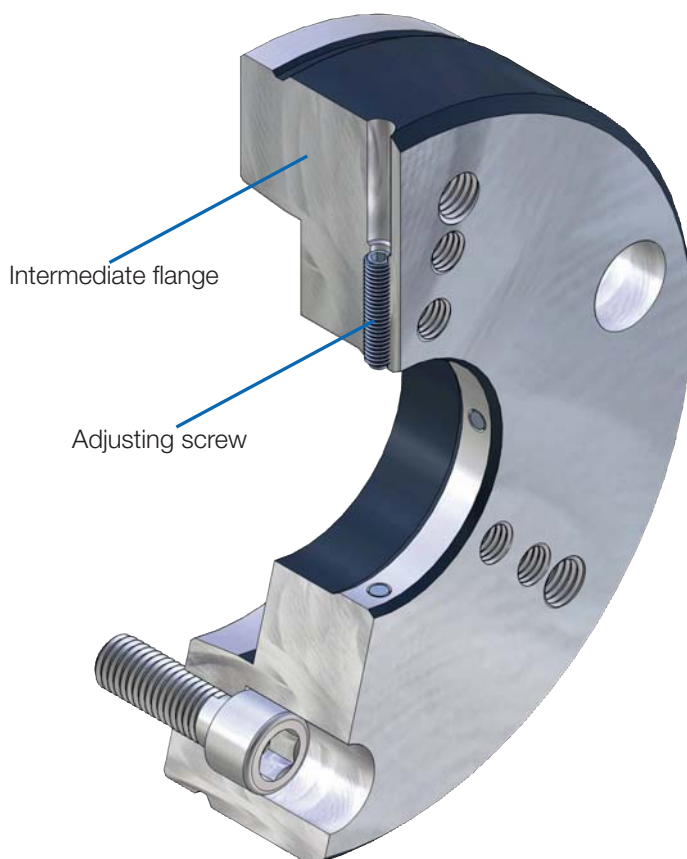
For KFR/MFR/KFR-SE/MFR-SE or KFS/MFS.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

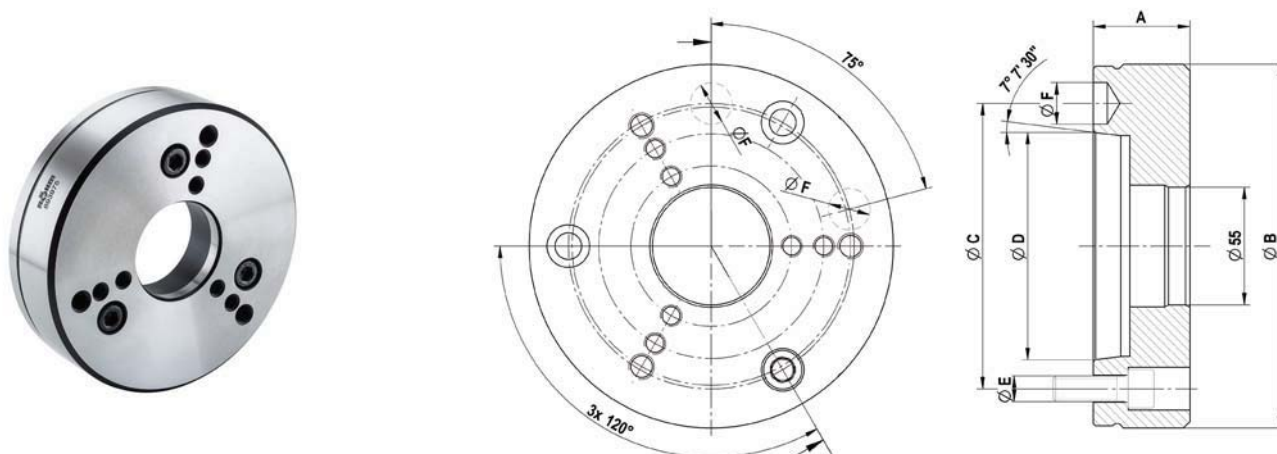
Adaptation of KFR/MFR/KFR-SE/MFR-SE cartridge mandrel or KFS/MFS on spindle head, with or without adjusting screw, with or without performing air sensing. Version acc. to ISO 702-1 (DIN 55028-A) or ISO 702-3 (DIN 55028-C), in size no. 5, no. 6, no. 8, no. 11 or no. 5, no. 6, no. 8 (A5, A6, A8, A11 or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



Intermediate flange

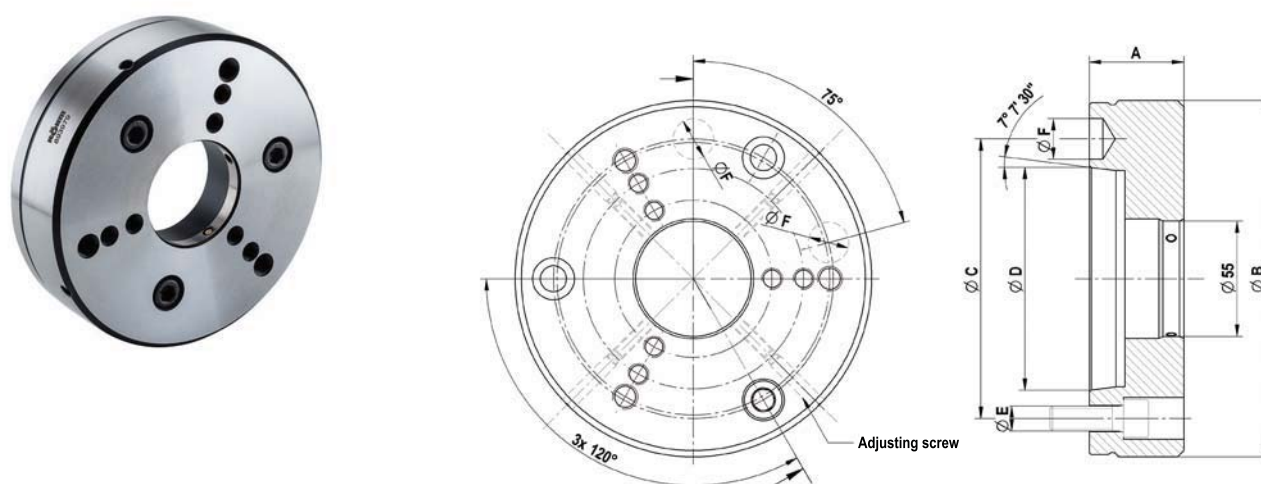
Adjusting screw

Accessories KFS / MFS



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

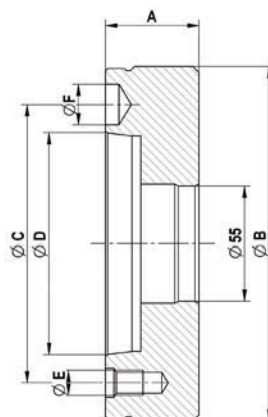
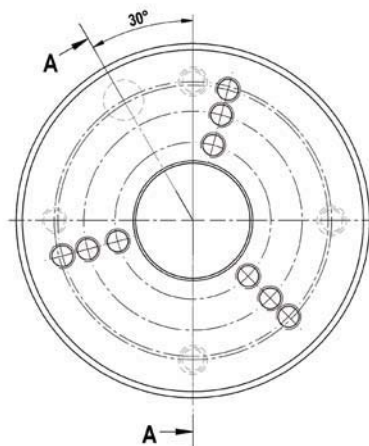
Intermediate flange	Nr. 5 (A 05)	Nr. 6 (A 06)	Nr. 8 (A 08)	Nr. 11 (A 11)
Design	893975	893976	893977	893978 ▲
without air-sensing	without air-sensing	without air-sensing	without air-sensing	without air-sensing
Mount-Ø 55 mm	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001	+0,003/+0,001
A mm	45	45	50	50
Ø B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



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

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

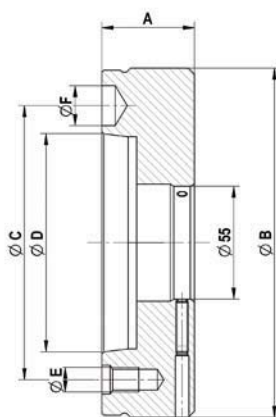
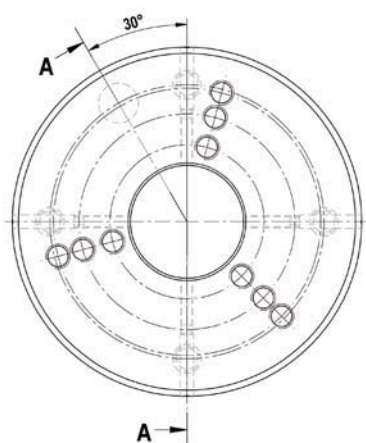
Accessories KFS / MFS



C 18

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

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

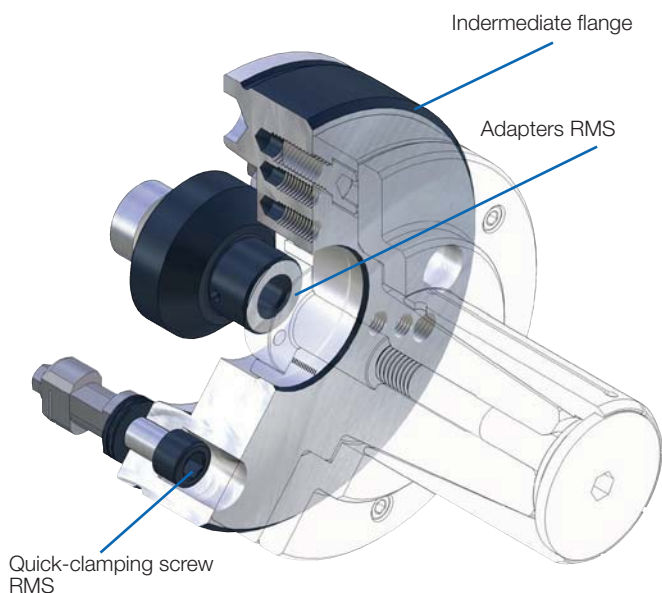


C 18

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

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

Accessories KFS / MFS



APPLICATION

For manual clamping device exchange in a minimum of time.

TYPE

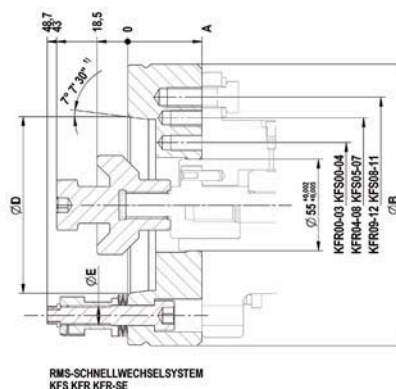
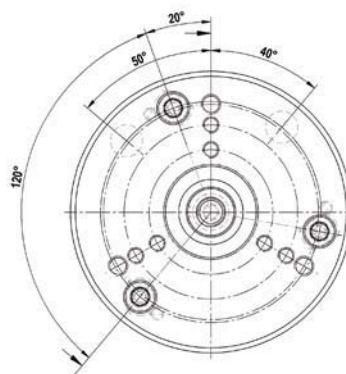
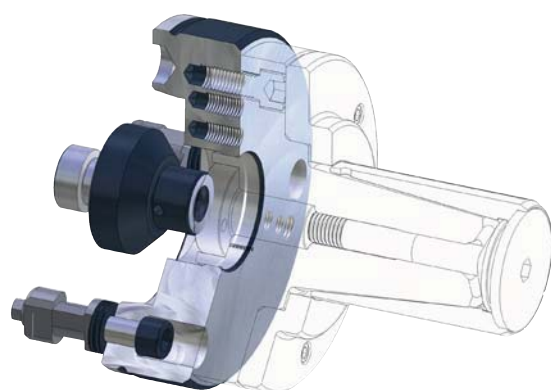
Manual quick-change system for clamping devices.
Fits for KFR/MFR or KFS/MFS.
Central lubrication and/or air sensing control possible.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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



RMS-SCHNELLWECHSELSYSTEM
KFS KFR KFR-SE

C18

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

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

KFR - force-actuated

APPLICATION

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

TYPE

Force-actuated. Without axial tightening. Clamping sleeves optionally vulcanized.
Convertible to MFR (required new intermediate piece).

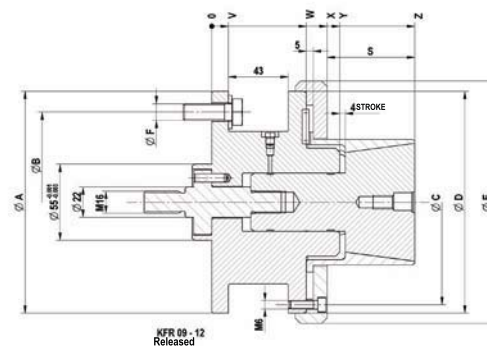
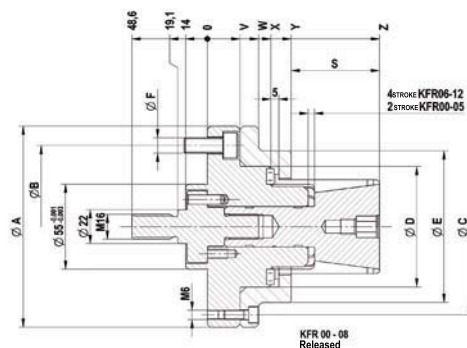
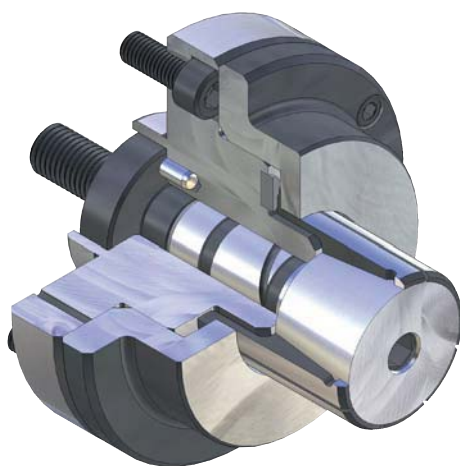
CUSTOMER BENEFITS

- ④ No workpiece tension thanks to def. axial tension against the workpiece stop
- ④ High concentricity, axial run-out and repeatability
- ④ Low-maintenance

TECHNICAL FEATURES

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

KFR = force-actuated, flange, R-type



C18

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

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

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

MFR - without axial tightening, manually actuated

APPLICATION

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

TYPE

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

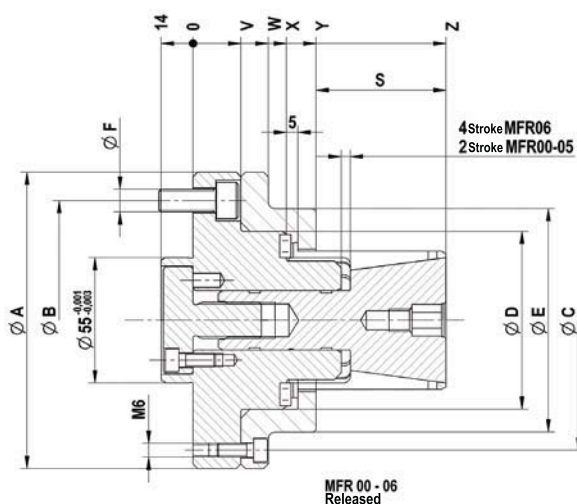
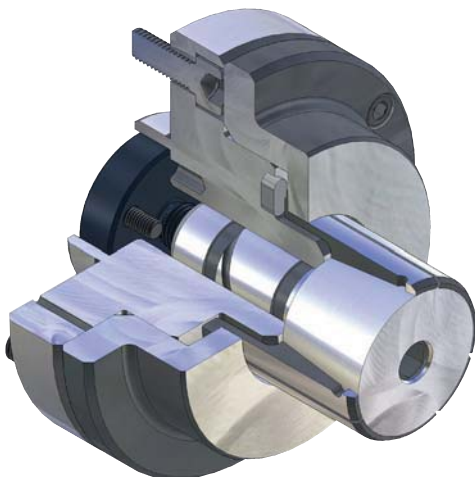
CUSTOMER BENEFITS

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

TECHNICAL FEATURES

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

MFR = manually actuated, flange, R-type



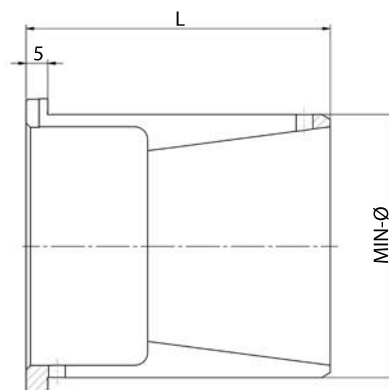
C18

MFR cartridge mandrel, **hand-operated with flanged seat**, for internal clamping

Consisting of basic body, clamping taper, intermediate piece

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

Accessories KFR / MFR



C 18

Clamping sleeve Type R - standard design, (not vulcanized)

For size	00	01	02	03	04	05	06	07	08	09	10	11	12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length L	32	40	40	40	55	55	70	70	70	78	78	78	78
Min-Ø mm	14,2	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7		100,7	110,7	120,7
Clamping sleeve	1015500 ▲	1015513 ▲	1015526 ▲	1015548 ▲	1015560 ▲	1015582 ▲	1015605 ▲	1015617 ▲	1015629 ▲		1015653 ▲	1015665 ▲	1015677 ▲
Work stop	893830	893836	893842	893852	893857	893867	893878	893888	893897		893917	893927	893937
Min-Ø mm	14,7	20,2	25,7	35,7	40,7	50,7	61,7	71,7	81,7	90,7	101,7	111,7	121,7
Clamping sleeve	1015501 ▲	1015514 ▲	1015527 ▲	1015549 ▲	1015561 ▲	1015583 ▲	1015606 ▲	1015618 ▲	1015630 ▲	1015641 ▲	1015654 ▲	1015666 ▲	1015678 ▲
Work stop	893830	893836	893842	893852	893857	893867	893879	893889	893898	893907	893918	893928	893938
Min-Ø mm	15,2	20,7	26,2	36,2	41,2	51,2	62,7	72,7	82,7	91,7	102,7	112,7	122,7
Clamping sleeve	1015502 ▲	1015515 ▲	1015528 ▲	1015550 ▲	1015562 ▲	1015584 ▲	1015607 ▲	1015619 ▲	1015631 ▲	1015642 ▲	1015655 ▲	1015667 ▲	1015679 ▲
Work stop	893830	893837	893842	893852	893857	893867	893880	893890	893899	893908	893919	893929	893939
Min-Ø mm	15,7	21,2	26,7	36,7	41,7	51,7	63,7	73,7	83,7	92,7	103,7	113,7	123,7
Clamping sleeve	1015503 ▲	1015516 ▲	1015529 ▲	1015551 ▲	1015563 ▲	1015585 ▲	1015608 ▲	1015620 ▲	1015632 ▲	1015643 ▲	1015656 ▲	1015668 ▲	1015680 ▲
Work stop	893831	893837	893843	893853	893858	893868	893881	893891	893900	893909	893920	893930	893940
Min-Ø mm	16,2	21,7	27,2	37,2	42,2	52,2	64,7	74,7	84,7	93,7	104,7	114,7	124,7
Clamping sleeve	1015504 ▲	1015517 ▲	1015530 ▲	1015552 ▲	1015564 ▲	1015586 ▲	1015609 ▲	1015621 ▲	1015633 ▲	1015644 ▲	1015657 ▲	1015669 ▲	1015681 ▲
Work stop	893831	893838	893843	893853	893858	893868	893882	893892	893901	893910	893921	893931	893941
Min-Ø mm	16,7	22,2	27,7	37,7	42,7	52,7	65,7	75,7	85,7	94,7	105,7	115,7	125,7
Clamping sleeve	1015505 ▲	1015518 ▲	1015531 ▲	1015553 ▲	1015565 ▲	1015587 ▲	1015610 ▲	1015622 ▲	1015634 ▲	1015645 ▲	1015658 ▲	1015670 ▲	1015682 ▲
Work stop	893832	893838	893844	893854	893859	893869	893883	893893	893902	893911	893922	893932	893942
Min-Ø mm	17,2	22,7	28,2	38,2	43,2	53,2	66,7	76,7	86,7	95,7	106,7	116,7	126,7
Clamping sleeve	1015506 ▲	1015519 ▲	1015532 ▲	1015554 ▲	1015566 ▲	1015588 ▲	1015611 ▲	1015623 ▲	1015635 ▲	1015646 ▲	1015659 ▲	1015671 ▲	1015683 ▲
Work stop	893832	893839	893844	893854	893859	893869	893884	893894	893903	893912	893923	893933	893943
Min-Ø mm	17,7	23,2	28,7	38,7	43,7	53,7	67,7	77,7	87,7	96,7	107,7	117,7	127,7
Clamping sleeve	1015507 ▲	1015520 ▲	1015533 ▲	1015555 ▲	1015567 ▲	1015589 ▲	1015612 ▲	1015624 ▲	1015636 ▲	1015647 ▲	1015660 ▲	1015672 ▲	1015684 ▲
Work stop	893833	893839	893845 ▲	893855	893860	893870	893885	893895	893904	893913	893924	893934	893944
Min-Ø mm	18,2	23,7	29,2	39,2	44,2	54,2	68,7	78,7	88,7	97,7	108,7	118,7	128,7
Clamping sleeve	1015508 ▲	1015521 ▲	1015534 ▲	1015556 ▲	1015568 ▲	1015590 ▲	1015613 ▲	1015625 ▲	1015637 ▲	1015648 ▲	1015661 ▲	1015673 ▲	1015685 ▲
Work stop	893833	893840	893845 ▲	893855	893860	893870	893886	893947	893905	893914	893925	893935	893945
Min-Ø mm	18,7	24,2	29,7	39,7	44,7	54,7	69,7	79,7	89,7	98,7	109,7	119,7	129,7
Clamping sleeve	1015509 ▲	1015522 ▲	1015535 ▲	1015557 ▲	1015569 ▲	1015591 ▲	1015614 ▲	1015626 ▲	1015638 ▲	1015649 ▲	1015662 ▲	1015674 ▲	1015686 ▲
Work stop	893834	893840	893846	893856	893861	893871	893887	893896	893906	893915	893926	893936	893946
Min-Ø mm	19,2	24,7	30,2	40,2	45,2	55,2	70,7	80,7	90,7	99,7	110,7	120,7	130,7
Clamping sleeve	1015510 ▲	1015523 ▲	1015536 ▲	1015558 ▲	1015570 ▲	1015592 ▲	1015615 ▲	1015627 ▲	1015639 ▲	1015650 ▲	1015663 ▲	1015675 ▲	1015687 ▲
Work stop	893834	893841	893846	893856	893861	893871	893887	893896	893906	893916	893926	893936	893946
Min-Ø mm	19,7	25,2	30,7		45,7	55,7				100,7			
Clamping sleeve	1015511 ▲	1015524 ▲	1015537 ▲		1015571 ▲	1015593 ▲				1015651 ▲			
Work stop	893835	893841	893847		893862	893872				893916			
Min-Ø mm			31,2		46,2	56,2							
Clamping sleeve			1015538 ▲		1015572 ▲	1015594 ▲							
Work stop			893847		893862	893872							
Min-Ø mm			31,7		46,7	56,7							
Clamping sleeve			1015539 ▲		1015573 ▲	1015595 ▲							
Work stop			893848		893863	893873							

Different chucking Ø and profiled clamping sleeves on request

Accessories KFR / MFR

C 18

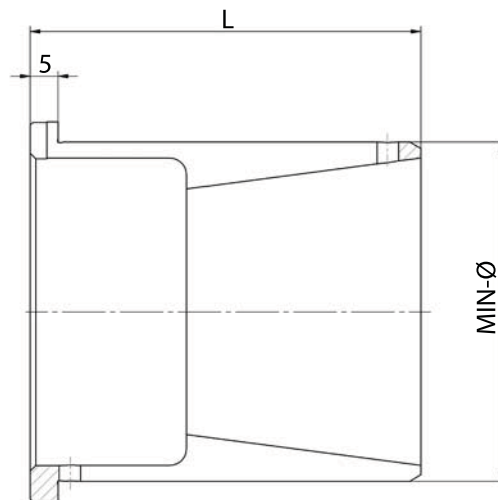
Clamping sleeve Type R - **standard design**, (not vulcanized)

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

Different chucking Ø and profiled clamping sleeves on request

,

Accessories KFR / MFR



C 18

Clamping sleeve Type R - vulcanized

For size	00	01	02	03	04	05	06	07	08	09	10	11	12
Expansion in Ø mm	0,5	0,5	0,5	0,5	0,5	0,5	1	1	1	1	1	1	1
Total length L	32	40	40	40	55	55	70	70	70	78	78	78	78
Min-Ø mm	14,2	19,7	25,2	35,2	40,2	50,2	60,7	70,7	80,7		100,7	110,7	120,7
Clamping sleeve	1015700	1015713	1015726	1015748	1015760	1015782	1015805 ▲	1015817 ▲	1015829 ▲		1015853 ▲	1015865 ▲	1015877 ▲
Work stop	893830	893836	893842	893852	893857	893867	893878	893888	893897		893917	893927	893937
Min-Ø mm	14,7	20,2	25,7	35,7	40,7	50,7	61,7	71,7	81,7	90,7	101,7	111,7	121,7
Clamping sleeve	1015701	1015714	1015727	1015749	1015761	1015783	1015806 ▲	1015818 ▲	1015830 ▲	1015841 ▲	1015854 ▲	1015866 ▲	1015878 ▲
Work stop	893830	893836	893842	893852	893857	893867	893879	893889	893898	893907	893918	893928	893938
Min-Ø mm	15,2	20,7	26,2	36,2	41,2	51,2	62,7	72,7	82,7	91,7	102,7	112,7	122,7
Clamping sleeve	1015702	1015715	1015728	1015750	1015762	1015784	1015807 ▲	1015819 ▲	1015831 ▲	1015842 ▲	1015855 ▲	1015867 ▲	1015879 ▲
Work stop	893830	893837	893842	893852	893857	893867	893880	893890	893899	893908	893919	893929	893939
Min-Ø mm	15,7	21,2	26,7	36,7	41,7	51,7	63,7	73,7	83,7	92,7	103,7	113,7	123,7
Clamping sleeve	1015703	1015716	1015729	1015751	1015763	1015785	1015808 ▲	1015820 ▲	1015832 ▲	1015843 ▲	1015856 ▲	1015868 ▲	1015880 ▲
Work stop	893831	893837	893843	893853	893858	893868	893881	893891	893900	893909	893920	893930	893940
Min-Ø mm	16,2	21,7	27,2	37,2	42,2	52,2	64,7	74,7	84,7	93,7	104,7	114,7	124,7
Clamping sleeve	1015704	1015717	1015730	1015752	1015764	1015786	1015809 ▲	1015821 ▲	1015833 ▲	1015844 ▲	1015857 ▲	1015869 ▲	1015881 ▲
Work stop	893831	893837	893843	893853	893858	893868	893882	893892	893901	893910	893921	893931	893941
Min-Ø mm	16,7	22,2	27,7	37,7	42,7	52,7	65,7	75,7	85,7	94,7	105,7	115,7	125,7
Clamping sleeve	1015705	1015718	1015731	1015753	1015765	1015787	1015810 ▲	1015822 ▲	1015834 ▲	1015845 ▲	1015858 ▲	1015870 ▲	1015882 ▲
Work stop	893832	893838	893844	893854	893859	893869	893883	893893	893902	893911	893922	893932	893942
Min-Ø mm	17,2	22,7	28,2	38,2	43,2	53,2	66,7	76,7	86,7	95,7	106,7	116,7	126,7
Clamping sleeve	1015706	1015719	1015732	1015754	1015766	1015788	1015811 ▲	1015823 ▲	1015835 ▲	1015846 ▲	1015859 ▲	1015871 ▲	1015883 ▲
Work stop	893832	893838	893844	893854	893859	893869	893884	893894	893903	893912	893923	893933	893943
Min-Ø mm	17,7	23,2	28,7	38,7	43,7	53,7	67,7	77,7	87,7	96,7	107,7	117,7	127,7
Clamping sleeve	1015707 ▲	1015720	1015733	1015755	1015767	1015789	1015812 ▲	1015824 ▲	1015836 ▲	1015847 ▲	1015860 ▲	1015872 ▲	1015884 ▲
Work stop	893833	893839	893845 ▲	893855	893860	893870	893885	893895	893904	893913	893924	893934	893944
Min-Ø mm	18,2	23,7	29,2	39,2	44,2	54,2	68,7	78,7	88,7	97,7	108,7	118,7	128,7
Clamping sleeve	1015708	1015721	1015734	1015756	1015768	1015790	1015813 ▲	1015825 ▲	1015837 ▲	1015848 ▲	1015861 ▲	1015873 ▲	1015885 ▲
Work stop	893833	893839	893845 ▲	893855	893860	893870	893886	893947	893905	893914	893925	893935	893945
Min-Ø mm	18,7	24,2	29,7	39,7	44,7	54,7	69,7	79,7	89,7	98,7	109,7	119,7	129,7
Clamping sleeve	1015709	1015722	1015735	1015757	1015769	1015791	1015814 ▲	1015826 ▲	1015838 ▲	1015849 ▲	1015862 ▲	1015874 ▲	1015886 ▲
Work stop	893834	893840	893846	893856	893861	893871	893887	893896	893906	893915	893926	893936	893946
Min-Ø mm	19,2	24,7	30,2	40,2	45,2	55,2	70,7	80,7	90,7	99,7	110,7	120,7	130,7
Clamping sleeve	1015710	1015723	1015736	1015758	1015770	1015792	1015815 ▲	1015827 ▲	1015839 ▲	1015850 ▲	1015863 ▲	1015875 ▲	1015887 ▲
Work stop	893834	893840	893846	893856	893861	893871	893887	893896	893906	893916	893926	893936	893946
Min-Ø mm	19,7	25,2	30,7		45,7	55,7				100,7			
Clamping sleeve	1015711	1015724	1015737		1015771	1015793				1015851 ▲			
Work stop	893835	893841	893847		893862	893872				893916			
Min-Ø mm			31,2		46,2	56,2							
Clamping sleeve			1015738		1015772	1015794							
Work stop			893847		893862	893872							
Min-Ø mm			31,7		46,7	56,7							
Clamping sleeve			1015739		1015773	1015795							
Work stop			893848		893863	893873							

Different chucking Ø and profiled clamping sleeves on request

Accessories KFR / MFR

C 18

Clamping sleeve Type R - vulcanized

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

Different chucking Ø and profiled clamping sleeves on request

Intermediate flange KFR / MFR



APPLICATION

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

TYPE

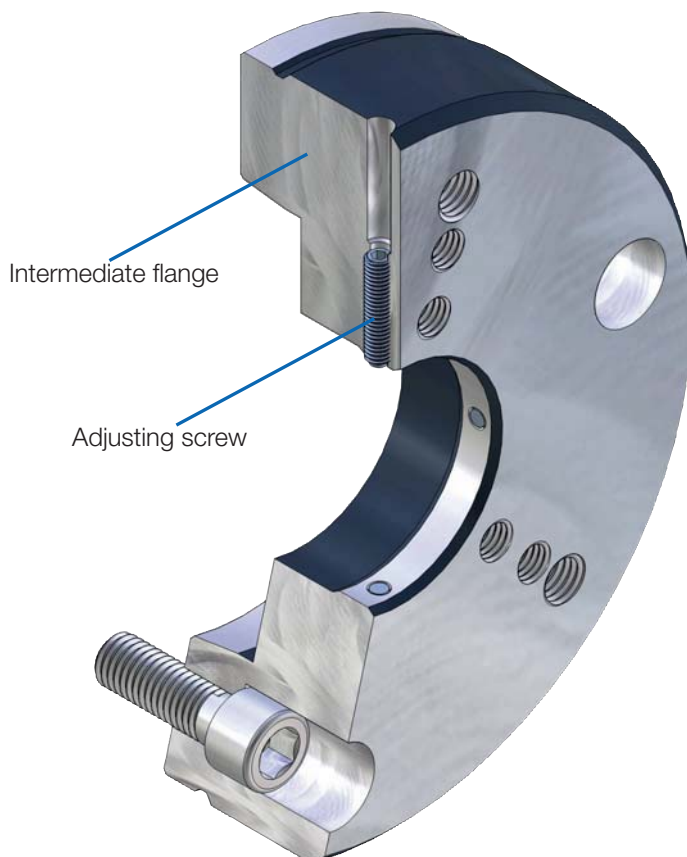
For KFR/MFR/KFR-SE/MFR-SE or KFS/MFS.

CUSTOMER BENEFITS

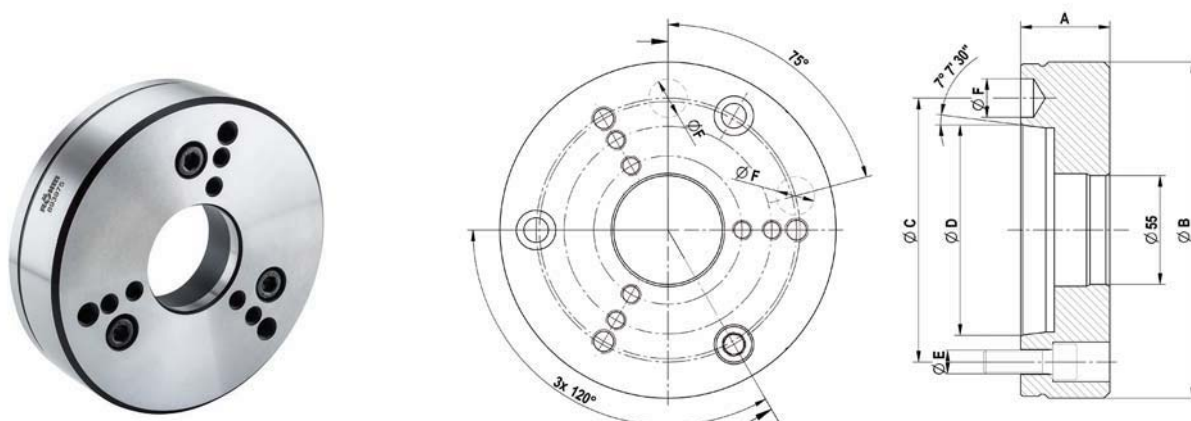
- By replacement of the intermediate flange, one cartridge mandrel can be used on different machines

TECHNICAL FEATURES

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



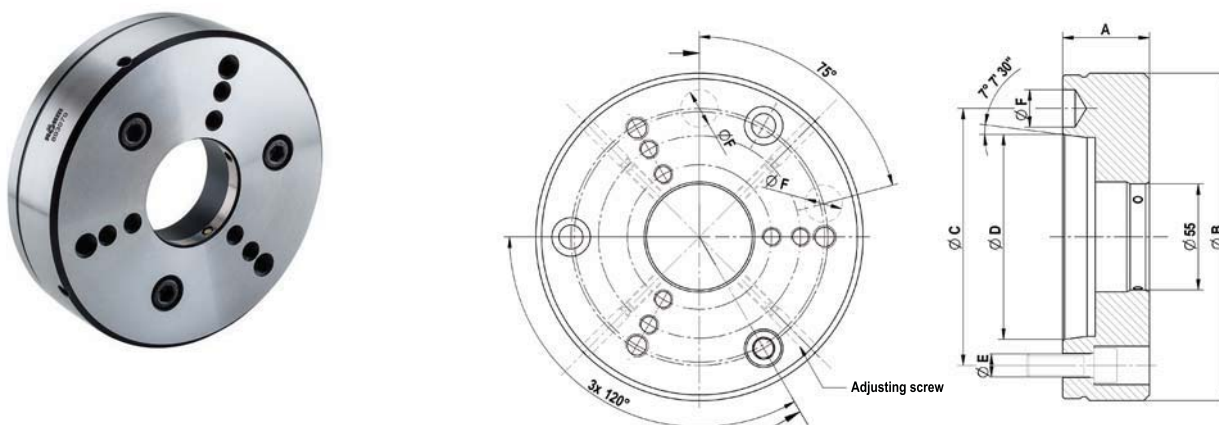
Accessories KFR / MFR



C 18

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

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

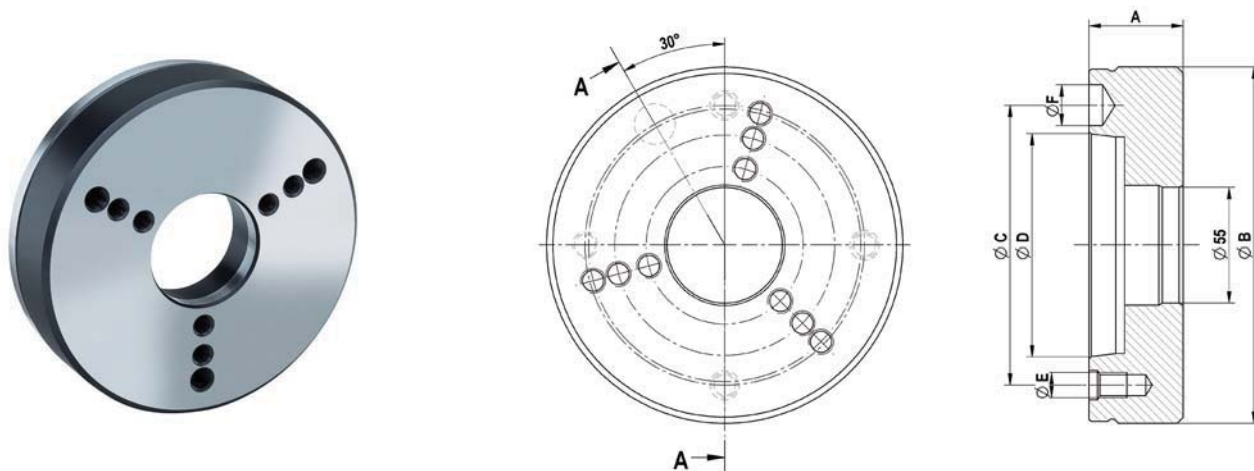


C 18

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

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

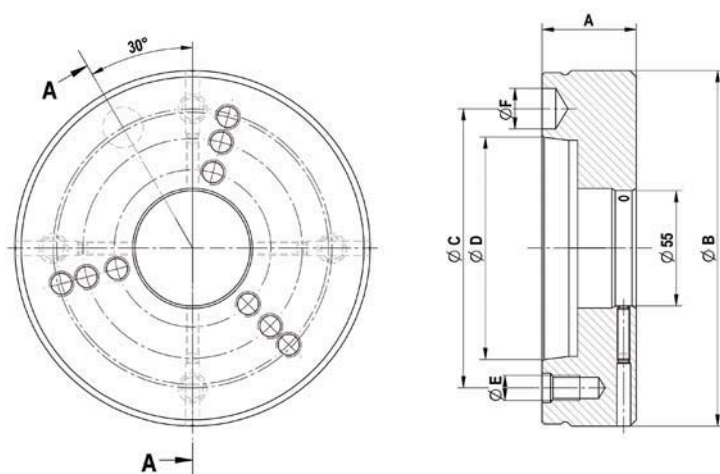
Accessories KFR / MFR



C 18

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

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

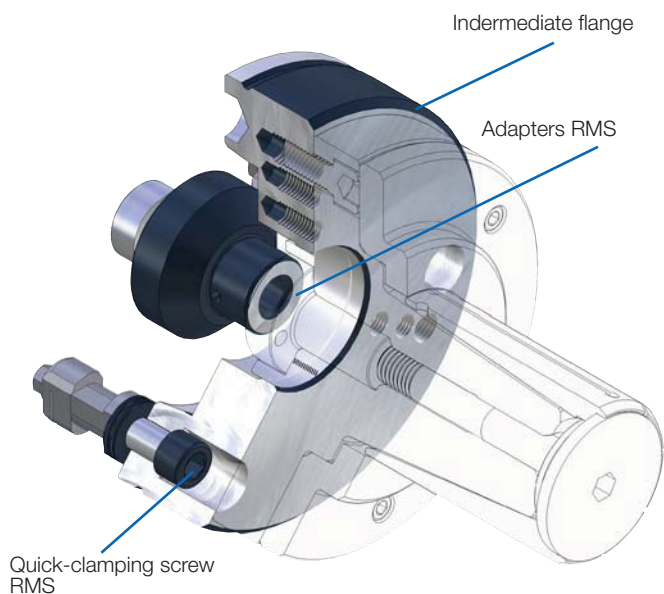


C 18

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

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

Accessories KFR / MFR



APPLICATION

For manual clamping device exchange in a minimum of time.

TYPE

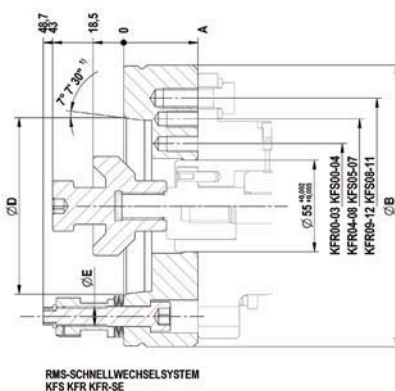
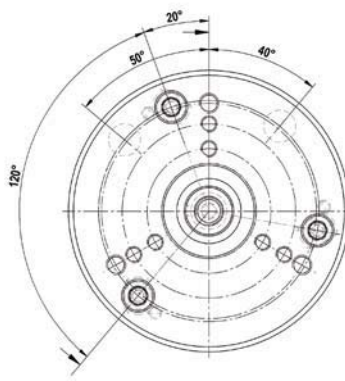
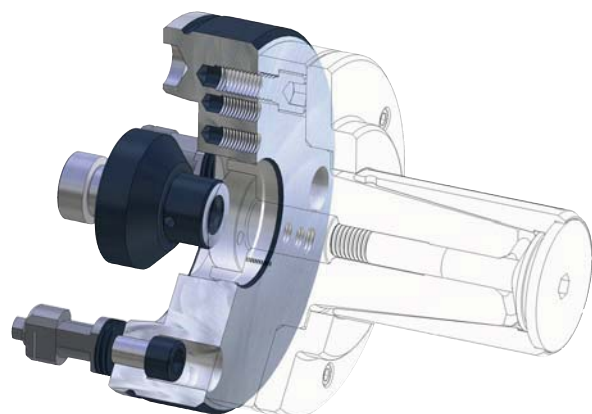
Manual quick-change system for clamping devices.
Fits KFR (255-00), KFS (253-00).
Central lubrication and/or air sensing control possible.

CUSTOMER BENEFITS

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

TECHNICAL FEATURES

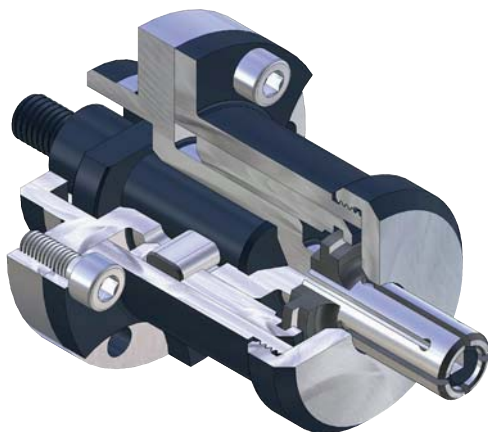
- Quick-change system suitable due to recording RMS see quick-change system RMS (Product Group 6)
- Corresponds to the guidelines of the Employer's Liability Insurance Association in combination with RÖHM safety clamping cylinder OVS and LVS



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

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

KFB - with axial tightening, force-actuated



APPLICATION

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

TYPE

Force-actuated. Clamping sleeves optionally vulcanized.

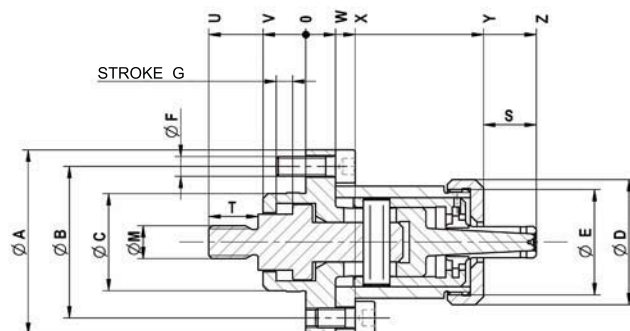
CUSTOMER BENEFITS

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

TECHNICAL FEATURES

- Hardened, low-wear design

KFB = force-actuated, flange, B-type



C18

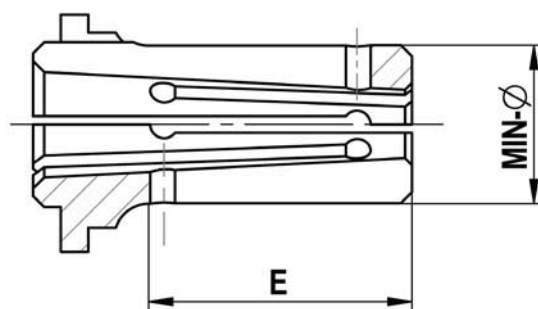
KFB cartridge mandrel, **power-operated with flanged seat**, for internal clamping

Consisting of basic mandrel, stop sleeve, guide sleeve, cotter, draw bolt

	KFB 00	KFB 01	KFB 02	KFB 03	KFB 04	KFB 05	KFB 06	KFB 07
Cartridge Mandrel	327586	327587	327588	327589	327590	327591	327592	327593 ▲
Basic mandrel	323521	323522	323523	323524	323525	323526	323527	323528 ▲
Stop sleeve	323474	323475	323476	323477	323478	323479	323480	323481 ▲
Guide sleeve	323461	323462	323463	323464	323465	323466	323467	323468 ▲
Cotter	323508	323509	323510	323511	323512	323513	323514	323515 ▲
Draw bolt	323500	323501	323502	323502	323503	323504	323504	323505 ▲
F max, in kN	1,8	2,7	3,6	4,8	5,8	7,5	12	22
Max, total clamping force approx, kN	12	18	24	32	38	50	65	119
Min- $\varnothing$ unclamped from mm	5,5	7,5	9,5	12	14,5	19,5	24,7	29,7
Min- $\varnothing$ unclamped to mm	7	9	11,5	14,5	19	24,5	28,7	33,7
Clamping- $\varnothing$ max, mm	7,5	9,5	12	15	19,5	25	29,7	34,7
External- $\varnothing$ A mm	45	50	56	60	72	76	82	95
Pitch diameter B mm	36	39	46	50	60	64	70	80
$\varnothing$ C h6	25	25	30	30	40	40	40	60
$\varnothing$ D mm	24	31	38	40	52	54	60	66
$\varnothing$ E mm	M22x1,5	M27x1,5	M32x1,5	M36x1,5	M45x1,5	M48x1,5	M56x1,5	M60x1,5
$\varnothing$ F mm	M5	M6	M6	M6	M6	M6	M6	M8
Stroke G mm	5	5	5	5	5	5	6	6
$\varnothing$ M	M8	M8	M10	M10	M10	M12	M12	M12
S mm	9	13	15	20,5	24	30	36	40
T mm	14	14	15	15	15	18	18	18
U mm	27	27,5	29,5	29,5	30,5	33,5	33,5	36,5
V mm	11,5	12	13	13	14	14	14	17
W mm	7,5	8	9	9	10	10	10	12,5
X mm	12,5	13	15	15	16	16	16	18,5
Y mm	42	46	45	58	66	67	71	74
Z mm	51,5	58,5	70	78,5	90	97	107	114

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

Accessories KFB

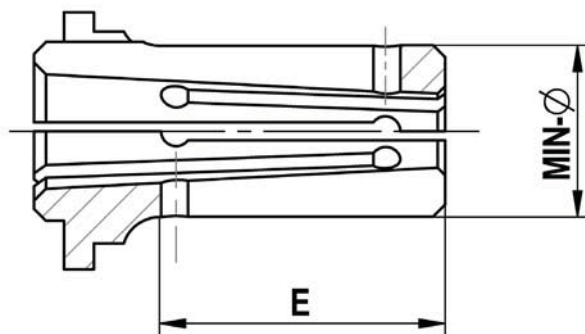


C 18

Clamping sleeve Type B - standard design (not vulcanized)

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

Accessories KFB



C 18

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

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

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

MZB - with axial tightening, manually actuated

APPLICATION

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

TYPE

Manually actuated. Clamping sleeves optionally vulcanized.

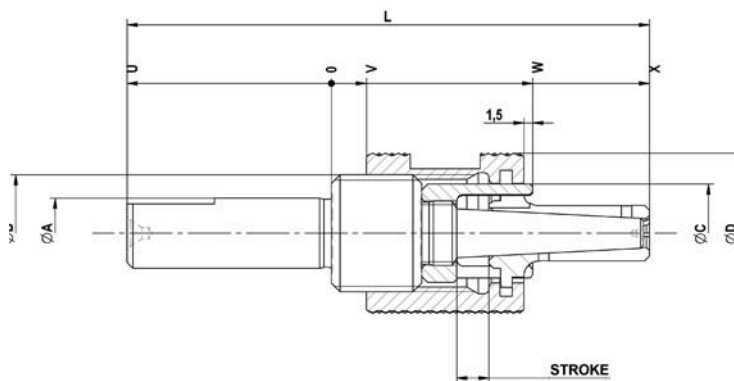
CUSTOMER BENEFITS

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

TECHNICAL FEATURES

- Hardened, low-wear design

MZB = manually actuated, centre hole, B-type

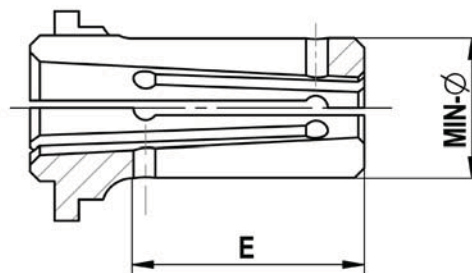


C18

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

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

Accessories MZB

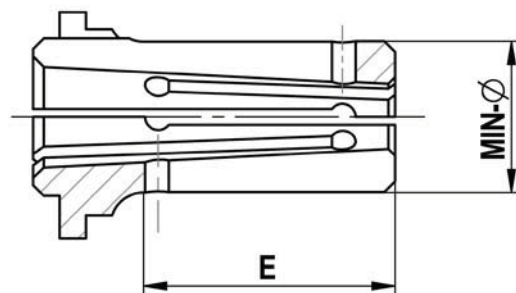


C 18

Clamping sleeve Type B - standard design (not vulcanized)

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

Accessories MZB



C 18

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

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

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

MZE - for long clamping lengths, manually actuated

APPLICATION

Internal clamping of round workpieces. Measuring operations and light grinding operations.
Ideal for long clamping lengths / long workpieces.

TYPE

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

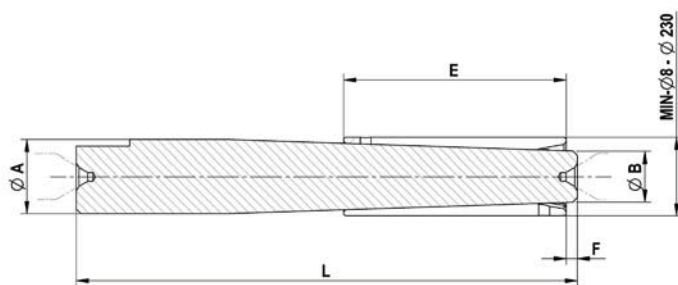
CUSTOMER BENEFITS

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

TECHNICAL FEATURES

- Hardened, low-wear design

MZE = manually actuated, centre hole, E-type

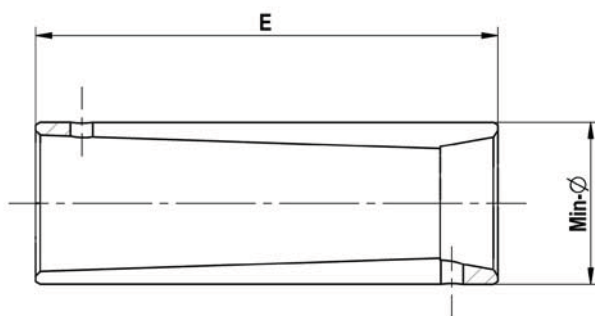


C18

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

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

Accessories MZE



C 18

Clamping sleeve Type E - for basic mandrel MZE

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

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

Product ranges MZE cartridge mandrel



Product ranges in wooden box size 1 – ID 315093

CONTENT

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



Product range in wooden box size 2 – ID 315094

CONTENT

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

Special solutions KFS



Cartridge mandrel KFS clamping-Ø 22.65 mm

APPLICATION

Turning

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

CUSTOMER BENEFITS

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



Cartridge mandrel KFS clamping-Ø SW 27.8 mm

APPLICATION

Turning

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

CUSTOMER BENEFITS

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



Cartridge mandrel KFS clamping-Ø 34.3 mm

APPLICATION

Turning / Cutting

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

CUSTOMER BENEFITS

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

Special solutions KFR / MFR



Cartridge mandrel KFR clamping-Ø 45 mm

APPLICATION

Turning of a pressed part

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

CUSTOMER BENEFITS

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



Cartridge mandrel KFR clamping-Ø TK-Ø 90 mm

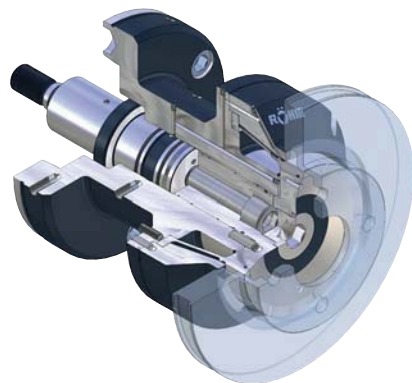
APPLICATION

Turning

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

CUSTOMER BENEFITS

- Concentricity for tooththing
- Concentricity of 0.03 mm



Cartridge mandrel KFR clamping-Ø 136 mm

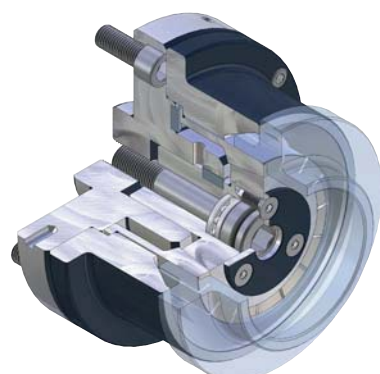
APPLICATION

Turning of brake discs

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

CUSTOMER BENEFITS

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



Cartridge mandrel MFR clamping-Ø 88 mm

APPLICATION

Milling / drilling for stationary use on clamping devices

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

CUSTOMER BENEFITS

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

Special solutions KFB



Cartridge mandrel KFB clamping-Ø 42 mm

APPLICATION

Turning

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

CUSTOMER BENEFITS

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



Cartridge mandrel KFB clamping-Ø 114 mm

APPLICATION

Turning

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

CUSTOMER BENEFITS

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