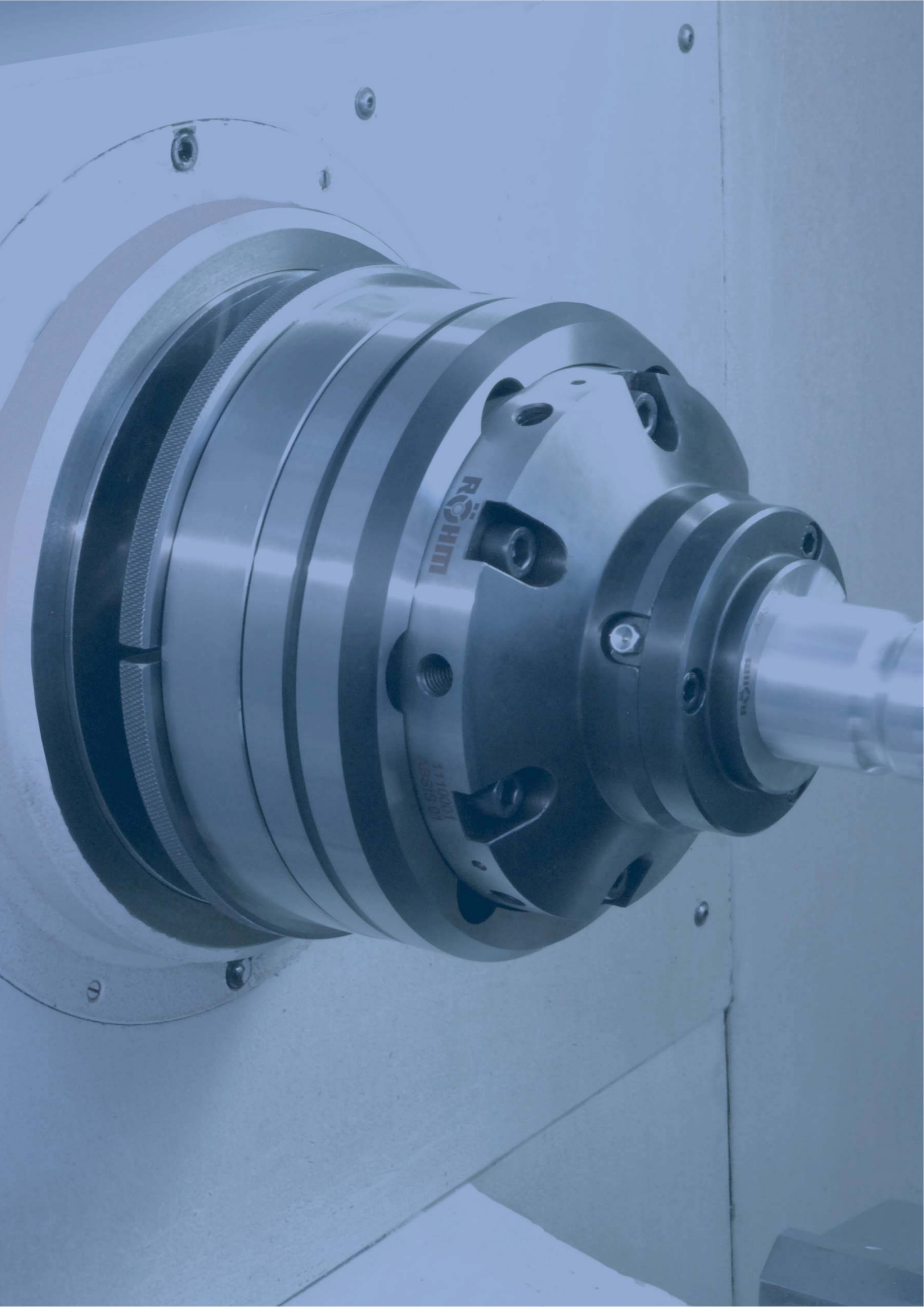




MANDRELS COLLET CHUCKS

EDITION 8

RÖHM
driven by technology





FAST CHANGING WITHIN THE MODULAR SYSTEM



As a consistent modular system, it is possible to combine the individual components such as CAPTIS collet chuck, CAPTIS collet and ABSIS-C clamping mandrel depending on use.

Collet replacing

Fast and easy collet replacement in 15 seconds reduces the set-up times.

Changing collets and clamping mandrel

Innovative and patent-pending quick changing function for fast conversion from outer to inner clamping in less than one minute.



COLLET CHUCKS

The new and modular CAPTIS clamping system is impressive in both rotary applications in lathes and in stationary use in drilling, milling and machining centres and measuring machines. The conversion from outer to inner clamping can be done in less than 1 minute with the innovative and patent-pending quick changing function. The encompassing clamping enables precise concentricity and repeatability of 0.005 mm without deforming the workpiece.

ADVANTAGES AT A GLANCE

- ⌚ Highest flexibility due to modular construction
- ⌚ Precise concentricity and repeatability of 0.005 mm
- ⌚ Compact and weight-reduced construction for a larger work area



Video CAPTIS-D



CAPTIS-D, CAPTIS-A, CAPTIS-AF

- ⌚ Modular construction for highest flexibility
- ⌚ Compact construction for more work space
- ⌚ Many combination and conversion possibilities

CAPTIS-M

- ⌚ Compact design with reduced interfering contours for optimum workpiece accessibility and enlarged working space
- ⌚ Modular conversion option for internal and external workpiece stop



ABSIS-C CLAMPING MANDREL

- ⌚ Innovative and patent-pending quick changing function to convert from outer to inner clamping in less than one minute
- ⌚ Stable and precise clamping by axial tension against the workpiece stop



CAPTIS COLLET CHUCKS

- ⌚ Replaceable rubber segments made of innovative rubber mixture for the longest service life
- ⌚ Clamping range of $\pm 0,5$ mm
- ⌚ Hardened and ground steel segments for high resistance to wear
- ⌚ Collet chuck hot vulcanized on request

CAPTIS-D - with through-hole



APPLICATION

For use on lathes.
Ideal for bars and pipe machining on the main spindle.

TYPE

Force-actuated.
With through-hole for bar and pipe machining.
With axial tension.

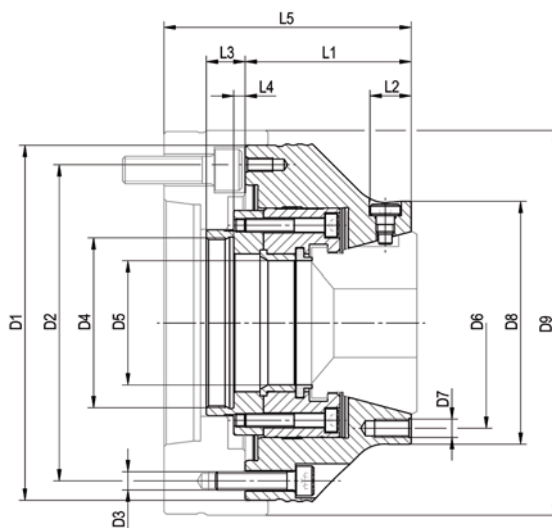
CUSTOMER BENEFITS

- Maximum flexibility thanks to modular design and versatile combination and retrofitting options
- Low weight and low height thanks to compact design for more work area in the machine
- Short setup and non-productive times thanks to fast collect chuck change as well as great expansion of the collet chucks
- Fast retrofitting from external to internal clamping thanks to optionally available segment clamping mandrel ABSIS-C

TECHNICAL FEATURES

- Manual lubrication
- Collet chucks with exchangeable and oil-resistant vulcanized rubber

CAPTIS-D = in Latin: hold, through-hole



CAPTIS-D collet chucks - with axial pull

Size	32	42	52	65	80	100	120
Collet chucks	1283101	1283102	1283103	1283104	1283105	1283106 ▲	1283107 ▲
D1 mm	137	137	155	155	215	215	250
D2 mm	100	118	138	138	190	190	215
D3	6x M8	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12
D4 mm	M54x1,5	M54x1,5	M74x1,5	M74x1,5	M94x1,5	M120x1,5	M132x1,5
D5	34	44	54	68	82	102	122
D6	70	92	92	110	132	190	225
D7	3x M8	3x M8	3x M8	3x M8	3x M10	3x M12	3x M12
D8	84	106	106	122	152	215	250
L1 mm	70,5	69	72,5	78	85	102	102
L2 mm	18	18	18	26	19	-	-
L3 mm	17	17	17	17	20	20	20
L4 min mm	1,5	1,5	1,5	1,5	-0,5	-0,5	-0,5
L4 max mm	7,5	7,5	7,5	7,5	5,5	5,5	5,5
Total stroke mm	6	6	6	6	6	6	6
Maximum draw bar pull kN	25	35	40	45	50	65	70
Total clamping force kN	60	70	80	90	100	130	140
Speed max, min ⁻¹	8000	7000	6500	6000	5500	5000	4000
Chucking capacity mm	4-32	4-42	4-52	4-65	5-80	42-100	62-120
Clamping device manual	1283285	1283286	1283287	1283288	1283289	-	-
Clamping device pneumatic	-	-	-	-	1362635	1362636	1362637
Conversion kit to CAPTIS-A	1283256	1283257	1283258	1283259	1283260	1283261	1283262
Turning fixture for soft collets	1316901	1316902	1316903	1316904	1316905	1316906	1316907

CAPTIS-A - prepared for internal workpiece stop



APPLICATION

External clamping of round workpieces, as well as square and hexagon profiles. Turning, milling, grinding operations as well as for measuring. Ideal for machining insertion parts on the main spindle.

TYPE

Force-actuated.
Optional through-hole for bar machining by removing the internal workpiece stop.
With axial tension against workpiece stop.

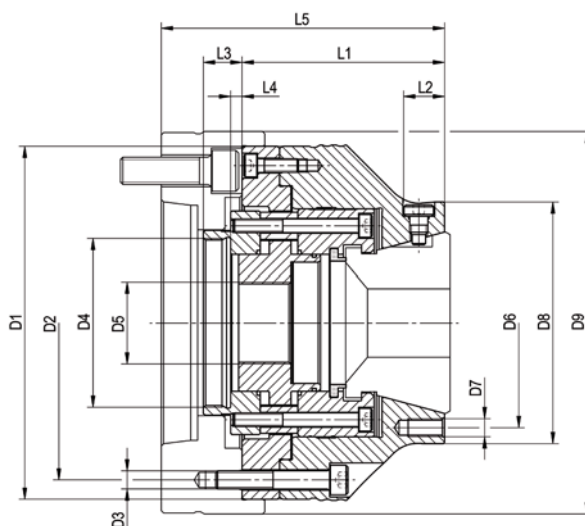
CUSTOMER BENEFITS

- Maximum flexibility thanks to modular design and versatile combination and retrofitting options
- Low weight and low height thanks to compact design for more work area in the machine
- Short setup and non-productive times thanks to fast collect chuck change as well as great expansion of the collet chucks
- Fast retrofitting from external to internal clamping thanks to optionally available segment clamping mandrel ABSIS-C
- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- Prepared for internal workpiece stop and front stop

TECHNICAL FEATURES

- Manual lubrication
- Collet chucks with exchangeable and oil-resistant vulcanized rubber

CAPTIS-A = in Latin: hold, workpiece stop



CAPTIS-A collet chuck - with axial tension against workpiece stop

Size	32	42	52	65	80	100	120
Collet chucks	1283108	1283109	1283110	1283111	1283112 ▲	1283113 ▲	1283114 ▲
D1 mm	137	137	155	155	215	215	250
D2 mm	100	118	138	138	190	190	225
D3	6x M8	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12
D4 mm	M54x1,5	M54x1,5	M74x1,5	M74x1,5	M94x1,5	M120x1,5	M132x1,5
D5 mm	M22x1,5	M30x1,5	M36x1,5	M50x1,5	M55x1,5	M85x1,5	M105x1,5
D6	70	92	92	110	132	190	225
D7	3x M8	3x M8	3x M8	3x M8	3x M10	3xM12	3x M12
D8	84	106	106	122	152	215	250
L1 mm	84	82,5	89	94,5	103	122	122
L2 mm	18	18	18	26	19	-	-
L3 mm	17	17	17	17	20	20	20
L4 min mm	1,5	1,5	1,5	1,5	-0,5	-0,5	-0,5
L4 max mm	7,5	7,5	7,5	7,5	5,5	5,5	5,5
Total stroke mm	6	6	6	6	6	6	6
Maximum draw bar pull kN	25	35	40	45	50	65	70
Total clamping force kN	60	70	80	90	100	130	140
Speed max, min ⁻¹	8000	7000	6500	6000	5500	5000	4000
Chucking capacity mm	4-32	4-42	4-52	4-65	5-80	42-100	62-120
Clamping device manual	1283285	1283286	1283287	1283288	1283289	-	-
Clamping device pneumatic	-	-	-	-	1362635	1362636	1362637
Conversion kit to CAPTIS-D	1283249	1283250	1283251	1283252	1283253	1283254	1283255
Turning fixture for soft collets	1316901	1316902	1316903	1316904	1316905	1316906	1316907

CAPTIS-AF - axially fixed collet chuck



APPLICATION

External clamping of round workpieces, as well as square and hexagon profiles. Turning, milling, grinding operations as well as for measuring. Ideal for delicate workpieces, short clamping lengths and for use in opposed spindles or counter spindles.

TYPE

Force-actuated.
Optional through-hole for bar machining by removing the internal workpiece stop.
Axially fixed collect chuck, no axial tension against internal workpiece stop.

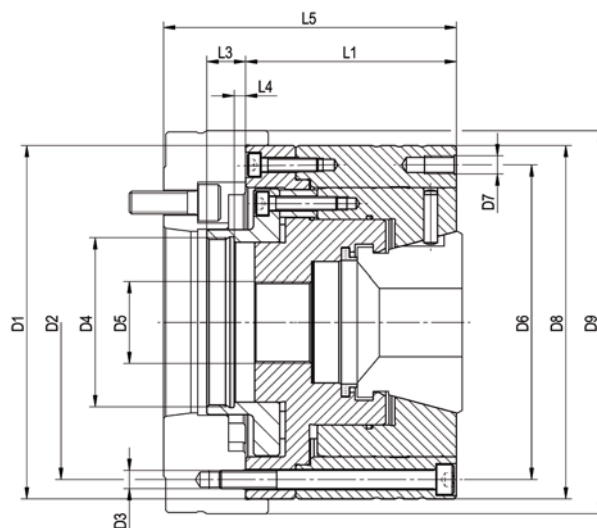
CUSTOMER BENEFITS

- Maximum flexibility thanks to modular design and versatile combination and retrofitting options
- Low weight and low height thanks to compact design for more work area in the machine
- Short setup and non-productive times thanks to fast collect chuck change as well as great expansion of the collet chucks
- No damage, impressions on workpieces due to axially fixed collect chuck
- Prepared for internal workpiece stop and front stop

TECHNICAL FEATURES

- Manual lubrication
- Collet chucks with exchangeable and oil-resistant vulcanized rubber

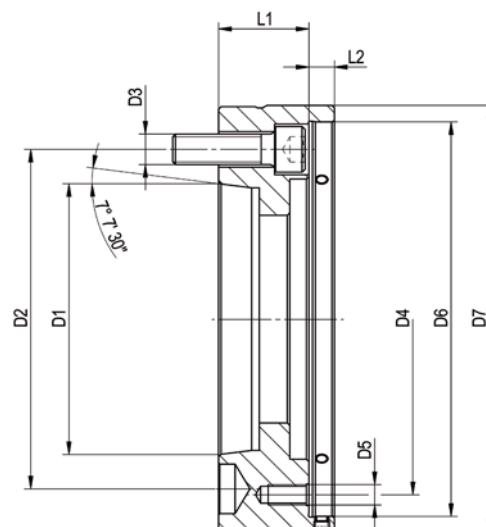
CAPTIS-AF = in Latin: hold, axially fixed collet chuck



CAPTIS-AF collet chuck - axially fixed collet chuck, no axial tension against internal workpiece stop

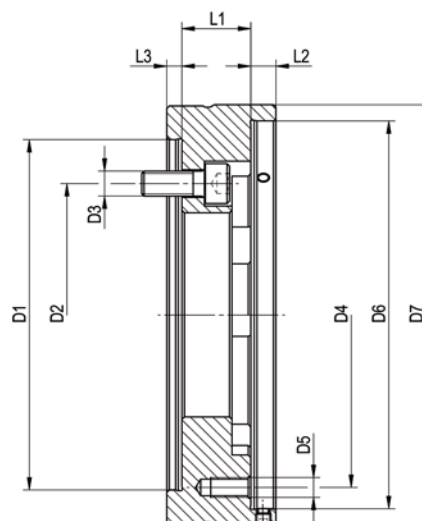
Size	32	42	52	65	80	100	120
Collet chucks	1285001	1285002	1285003	1285004	1285005	1285006 ▲	1285007 ▲
D1 mm	137	137	155	155	215	215	250
D2 mm	120	120	138	138	190	190	225
D3	6x M8	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12
D4 mm	M48x1,5	M54x1,5	M74x1,5	M74x1,5	M120x1,5	M120x1,5	M132x1,5
D5 mm	M22x1,5	M30x1,5	M36x1,5	M50x1,5	M65x1,5	M85x1,5	M105x1,5
D6	94	120	138	138	190	190	225
D7	3x M6	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8
D8	105	137	155	155	215	215	250
L1 mm	80,5	81	92,5	92,5	102	102	122
L2 mm	34,7	-	-	-	-	-	-
L3 mm	15,5	16	17	17	18,5	18,5	18,5
L4 min	-4	-2,5	2,5	2,5	-1	-1	-1
L4 max	2	3,5	8,5	8,5	5	5	5
Total stroke mm	6	6	6	6	6	6	6
Maximum draw bar pull kN	25	35	40	45	50	65	70
Total clamping force kN	60	70	80	90	100	130	140
Speed max, min ⁻¹	8000	7000	6500	6000	5500	5000	4000
Chucking capacity mm	4-32	4-42	4-52	4-65	5-80	42-100	62-120
Clamping device manual	1283285	1283286	1283287	1283288	1283289	-	-
Clamping device pneumatic	-	-	-	-	1362635	1362636	1362637
Turning fixture for soft collets	1316901	1316902	1316903	1316904	1316905	1316906	1316907

Intermediate flange



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

Size	32/42 - Nr.5	32/42 - Nr.6	52/65 - Nr.5	52/65 - Nr.6	52/65 - Nr.8	80/100 - Nr.6	80/100 - Nr.8	120 - Nr.8	120 - Nr.11
Intermediate flange	1283194	1283195	1283198	1283199	1283200	1283203 ▲	1283204	1283207	1283209
D1 mm	82,563	106,375	82,563	106,375	139,719	106,375	139,719	139,719	196,869
D2 mm	104,8	133,4	104,8	133,4	171,4	133,4	171,4	171,4	235
D3	6x M10	3x M12	6x M10	3x M12	3x M16	6x M12	3x M16	6x M16	3x M20
D4 mm	100/120	100/120	138	138	138	190	190	225	225
D5 mm	6x M8	6x M8	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12	6x M12
D6	137	137	155	155	155	215	215	250	250
D7 mm	150	165	168	168	210	230	230	270	280
L1 mm	34,5	35,5	36	35,5	42	47	40	55	40
L2 mm	10	10	10	10	10	10	10	12	12



Intermediate flange cylindrical centre mount with adjusting screw

Size	32/42-Z140	52/65-Z140	52/65-Z170	80/100-Z170	80/100-Z220	120-Z220
Intermediate flange	1283196	1283201	1283202	1283205 ▲	1283206	1283208 ▲
D1 mm	140	140	170	170	220	220
D2 mm	104,8	104,8	133,4	133,4	171,4	171,4
D3	6x M10	6x M10	6x M12	6x M12	6x M16	6x M16
D4 mm	100/120	138	138	190	190	225
D5 mm	6x M8	6x M8	6x M8	6x M12	6x M12	6x M12
D6	137	155	155	215	215	250
D7 mm	150	168	180	230	230	270
L1 mm	19,5	27,5	22,5	47	40	55
L2 mm	10	10	10	10	10	12
L3 mm	6	6	6	6	6	6

CAPTIS-M - for rotating and stationary use



APPLICATION

Ideally suited for rotating use in lathes as well as for stationary use in drilling, milling and machining centers, measuring machines as well as for conventional and manual processing.

TYPE

Operated manually with a security key.
With axial tension against workpiece stop.

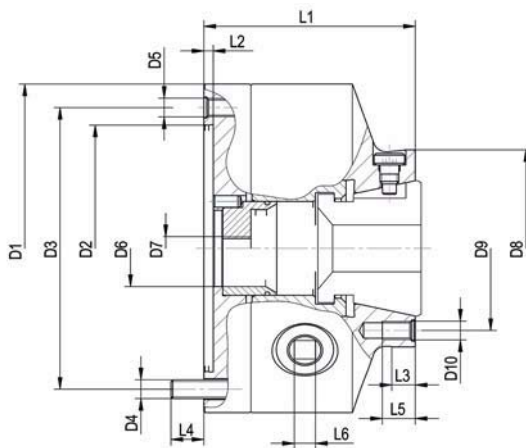
CUSTOMER BENEFITS

- ③ Compact design with reduced interfering contours for optimum workpiece accessibility and enlarged working space
- ③ Modular conversion option for internal and external workpiece stop
- ③ Stable clamping using axial tension

TECHNICAL FEATURES

- Manual lubrication
- Collet chucks with exchangeable and oil-resistant vulcanized rubber

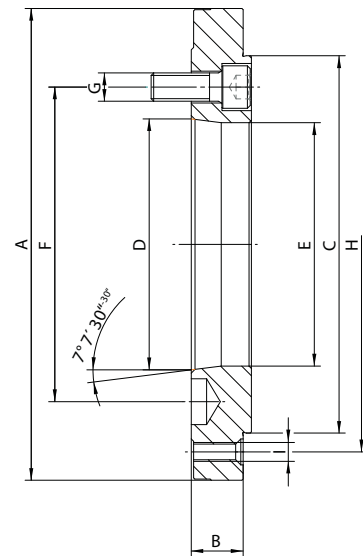
CAPTIS-M = in Latin: hold, manually



CAPTIS-M collet chuck - with axial tension against workpiece stop

Size	32	42	52	65
Collet chucks (incl. workpiece stop, protecting sleeve and security key)	1345739	1345740	1345741	1345742 ▲
D1 mm	140	160	160	200
D2 mm	105	125	125	160
D3 mm [H6]	120	140	140	176
D4	6xM8	6xM10	6xM10	6xM10
D5	3xM8	3xM10	3xM10	3xM10
D6 mm	32,5	42,5	52,5	65,5
D7	M10	M10	M10	M10
D8 mm [g6]	84	106	106	122
D9 mm	70	92	92	110
D10	3xM8	3xM8	3xM8	3xM8
L1 mm	90	100	100	110
L2 mm	4	4	4	4
L3 mm	10	10	10	10
L4 mm	13	14	14	16
L5 mm	14	16	16	16
L6 mm	9	10	10	11
Total stroke mm	6	6	6	6
Expansion collet mm	2,1	2,6	2,6	2,6
Max. tightening torque	60	120	120	120
Total clamping force kN	30	60	60	50
Speed max. min ⁻¹	5000	4500	4500	4000
Chucking capacity mm	4-32	4-42	4-52	4-65
Protecting sleeve	1345751	1345760	1345768	1345777
Workpiece stop	1345749	1345758	1345766	1345775
Clamping device manual	1283285	1283286	1283287	1283288
Clamping device pneumatic	-	-	-	-
Key (only for chucks with stationary use)	107428	107429	107429	107430
Security key (acc. to DIN 1550 for rotating chucks)	154372	154373	154373	154374
Turning fixture for soft collets	1316901	1316902	1316903	1316904

Intermediate flange

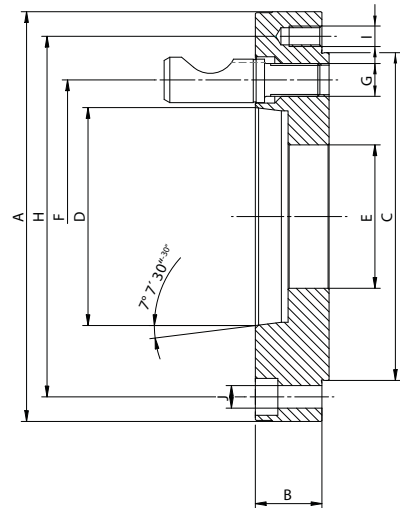


A09

Steel Intermediate flange according to **DIN ISO 702-1** (DIN 55026) / cylindrical mount on chuck side according to DIN 6350

Size	32	32	32	42/52	42/52	42/52	42/52	65/80	65/80	65/80
Short taper size	Gr. 4	Gr. 5	Gr. 6	Gr. 4	Gr. 5	Gr. 6	Gr. 8	Gr. 5	Gr. 6	Gr. 8
Intermediate flange	182902 ▲	182904 ▲	182906 ▲	182908 ▲	182910 ▲	182912 ▲	182914 ▲	182918 ▲	182920 ▲	182922 ▲
A mm	140	140	165	160	160	165	210	200	200	210
B mm	21	21	25	18	18	25	32	18	22	32
C mm	95	95	95	125	125	125	125	160	160	160
D mm	63,513	82,563	106,375	63,513	82,563	106,375	139,719	82,563	106,375	139,719
E mm	61	79,6	80	61	79,6	103,2	100	79,6	103,2	136,2
F mm	82,6	104,8	133,4	82,6	104,8	133,4	171,4	104,8	133,4	171,4
G	M10	M10	M12	M10	M10	M10	M16	M10	M12	M16
H mm	108 (120)	108 (120)	108 (120)	140	140	140	140	176	176	176
I	3x/6xM8	3x/6xM8	6xM8	6xM10	6xM10	6xM10	6xM10	6xM10	6xM10	6xM10

Complete with fastening screws



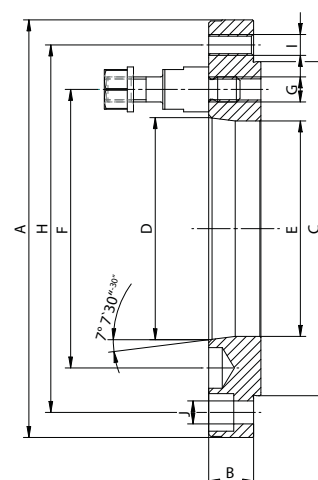
A09

Steel Intermediate flange according to **DIN ISO 702-2** (DIN 55029) / cylindrical mount on chuck side according to DIN 6350

Size	32	32	32	42/52	42/52	42/52	42/52	65/80	65/80	65/80
Short taper size	Gr. 4	Gr. 5	Gr. 6	Gr. 4	Gr. 5	Gr. 6	Gr. 8	Gr. 5	Gr. 6	Gr. 8
Intermediate flange	182958 ▲	182960 ▲	182962 ▲	182966 ▲	182968 ▲	182970 ▲	182972 ▲	182976 ▲	182978 ▲	182980 ▲
A mm	140	146	181	160	160	181	225	200	200	225
B mm	24	30	36	23,5	26,5	35,5	38,5	26,50	32,50	39,50
C mm	95	95	95	125	125	125	125	160	160	160
D mm	63,513	82,563	106,375	63,513	82,563	106,375	139,719	82,563	106,375	139,719
E mm	33	33	33	50	50	50	50	70	70	70
F mm	82,6	104,8	133,4	82,6	104,8	133,4	171,4	104,8	133,4	171,4
G	M10x1	M12x1	M16x1,5	M10x1	M12x1	M16x1,5	M20x1,5	M12x1	M16x1,5	M20x1,5
H mm	108 (120)	108 (120)	108 (120)	140	140	140	140	176	176	176
I	6xM8	6xM8	6xM8	6xM10	6xM10	6xM10	6xM10	6xM10	6xM10	6xM10
J mm	3x9	-	-	3x11	3x11	-	-	3x11	3x11	-

Complete with cam locking bolts

Intermediate flange

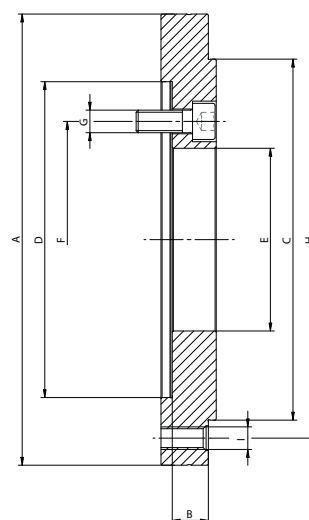


A09

Steel Intermediate flange according to **DIN ISO 702-3** (DIN 55027) / cylindrical mount on chuck side according to DIN 6350

Size	32	32	32	42/52	42/52	42/52	42/52	65/80	65/80	65/80
Short taper size	Gr. 4	Gr. 5	Gr. 6	Gr. 4	Gr. 5	Gr. 6	Gr. 8	Gr. 5	Gr. 6	Gr. 8
Intermediate flange	183014 ▲	183016 ▲	183018 ▲	183022 ▲	183024 ▲	183026 ▲	183028 ▲	183032 ▲	183034 ▲	183036 ▲
A mm	140	140	170	160	160	170	220	200	200	220
B mm	16,5	16,5	27	21,5	21,5	18	31,5	21,5	21,5	21,5
C mm	95	95	95	125	125	125	125	160	160	160
D mm	63,513	82,563	106,375	63,513	82,563	106,375	139,719	82,563	106,375	139,719
E mm	61	79,6	80	61	79,6	103,2	100	79,6	103,2	136,2
F mm	85	104,8	133,4	85	104,8	133,4	171,4	104,8	133,4	171,4
G mm	M10	M10	M12	M10	M10	M12	M16	M10	M12	M16
H mm	108 (120)	108 (120)	108 (120)	140	140	140	140	176	176	176
I mm	6xM8	6xM8	6xM8	6xM10	6xM10	6xM10	6xM10	6xM10	6xM10	6xM10
J mm	3x9	-	-	3x11	3x11	-	-	3x11	3x11	3x11

Complete with studs and collar nuts



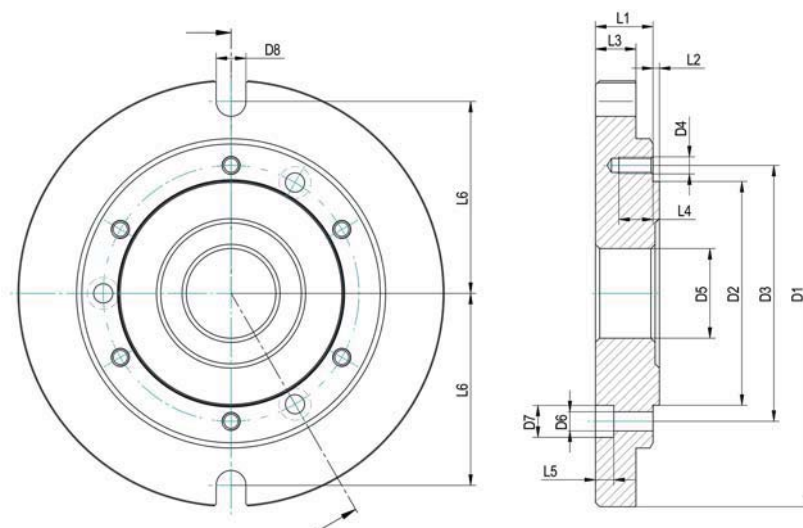
A09

Steel Intermediate flange according to **DIN ISO 702-4** (DIN 55028) / cylindrical mount on chuck side according to DIN 6350

Size	32	32	32	42/52	42/52	42/52	42/52	65/80	65/80
Flange	Gr. 3	Gr. 4	Gr. 5	Gr. 3	Gr. 4	Gr. 5	Gr. 6	Gr. 5	Gr. 6
Cylindrical mount	90	115	140	90	115	140	170	140	170
Intermediate flange	1349459 ▲	1349461 ▲	1349463 ▲	1349465 ▲	1349467 ▲	1349469 ▲	1349471 ▲	1349473 ▲	1349475 ▲
A mm	140	140	150	160	160	160	180	200	200
B mm	13	20	18	13	13	15	20	16	18
C mm	95	95	95	125	125	125	125	160	160
D mm	90 + 0,022/0	115 + 0,022/0	140 + 0,025/0	90 + 0,022/0	115 + 0,022/0	140 + 0,025/0	170 + 0,025/0	140 + 0,025/0	170 + 0,025/0
E mm	43	53	81	43	53	81	81	81	81
F mm	70,6	82,6	104,8	70,6	82,6	104,8	133,4	104,8	133,4
G mm	3xM10	3xM10	3xM10	6xM10	6xM10	6xM10	3xM12	6xM10	6xM12
H mm	120	120	120	140	140	140	140	176	176
I mm	6xM8	6xM8	6xM8	6xM10	6xM10	6xM10	6xM10	6xM10	6xM10

Complete with fastening screws

Base plate

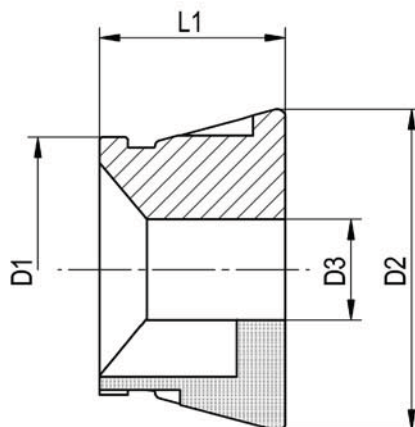


A09

Base plates for CAPTIS-M and lathe chucks with **cylindrical centre mount**, DIN 6350

Size	32	42/52	65/80
Base plate	1352890	162793	162401
D1 mm	220	240	280
D2 mm	105	125	160
D3 mm	120	140	176
D4	6xM8	6xM10	6xM10
D5 mm	40	42	55
D6 mm	14	14	14
D7 mm	28	28	28
D8 mm	3x9	3x11	3x11
D9 mm	3x15	3x18	3x18
D10	190	212	252
L1 mm	27	27	27
L2 mm	3	3	3
L3 mm	16	16	16
L4 mm	14	17	17
L5	10	11	11

CAPTIS collet



(G): Smooth
 (LQ): Longitudinal and transverse grooves
 (Q): Transverse grooves
 (W): Soft

from 4-7 mm smooth
 from 8-10 mm with trans. grooves
 caused by production

* Please specify clamping diameters D3 in the order, valid for collet chucks type LQ + Q

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
32	46,2	57,7	47	X				8-32mm			1	CAPTIS-32-47-RLQ / D3*
32	46,2	57,7	47		X				7-27mm		1	CAPTIS-32-47-SQ / D3*
32	46,2	57,7	47		X					7-22mm	1	CAPTIS-32-47-VQ / D3*

Clamping of unmachined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
32	46,2	57,7	44			X		4-32mm			1	CAPTIS-32-44-RG / D3*
32	46,2	57,7	44				X	5,15,20mm			1	CAPTIS-32-44-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
42	54	79,5	47	X				8-42mm			0,5	CAPTIS-42-47-RLQ / D3*
42	54	79,5	47		X				7-36mm		1	CAPTIS-42-47-SQ / D3*
42	54	79,5	47		X					7-30mm	1	CAPTIS-42-47-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
42	54	79,5	42			X		4-42mm			0,5	CAPTIS-42-42-RG / D3*
42	54	79,5	42				X	8,15,30mm			0,5	CAPTIS-42-42-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
52	65,7	79,5	46	X				8-52mm			0,5	CAPTIS-52-46-RLQ / D3*
52	65,7	79,5	46		X				7-45mm		1	CAPTIS-52-46-SQ / D3*
52	65,7	79,5	46		X					8-36mm	1	CAPTIS-52-46-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
52	65,7	79,5	46			X		4-52mm			0,5	CAPTIS-52-46-RG / D3*
52	65,7	79,5	46				X	8,15,30mm			0,5	CAPTIS-52-46-WG / D3*

CAPTIS collet

(G): Smooth
 (LQ): Longitudinal and transverse grooves
 (Q): Transverse grooves
 (W): Soft

from 4-7 mm smooth
 from 8-10 mm with trans. grooves caused by production

* Please specify clamping diameters D3 in the order, valid for collet chucks type LQ + Q

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
65	80	99,5	58	X				8-65mm			0,5	CAPTIS-65-58-RLQ / D3*
65	80	99,5	58		X				7-56mm		1	CAPTIS-65-58-SQ / D3*
65	80	99,5	58		X					7-46mm	1	CAPTIS-65-58-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
65	80	99,5	53			X		5-65mm			0,5	CAPTIS-65-53-RG / D3*
65	80	99,5	53				X	8,20,40mm			0,5	CAPTIS-65-53-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
80 ▲	94,5	114,5	53	X				11-80mm			1	CAPTIS-80-53-RLQ / D3*
80 ▲	94,5	114,5	53		X				7-68mm		1	CAPTIS-80-53-SQ / D3*
80 ▲	94,5	114,5	53		X					8-42mm	1	CAPTIS-80-53-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
80 ▲	94,5	114,5	53			X		5-80mm			1	CAPTIS-80-53-RG / D3*
80 ▲	94,5	114,5	53				X	20,30,40,60mm			1	CAPTIS-80-53-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
100 ▲	121	144,5	59	X				42-100mm			1	CAPTIS-100-59-RLQ / D3*
100 ▲	121	144,5	59		X				50-86mm		1	CAPTIS-100-59-SQ / D3*
100 ▲	121	144,5	59		X					50-70mm	1	CAPTIS-100-59-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
100 ▲	121	144,5	59			X		42-100mm			1	CAPTIS-100-59-RG / D3*
100 ▲	121	144,5	59				X	30,45,65,90mm			1	CAPTIS-100-59-WG / D3*

Clamping of unmachined parts with extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
120 ▲	141,8	180	61	X				62-120mm			1	CAPTIS-120-61-RLQ / D3*
120 ▲	141,8	180	61		X				50-104mm		1	CAPTIS-120-61-SQ / D3*
120 ▲	141,8	180	61		X					50-85mm	1	CAPTIS-120-61-VQ / D3*

Clamping of machined parts without extension

Size	D1	D2	L1	LQ	Q	G	W	Round	Hexagon	Square	Raising	Order No.
120 ▲	141,8	180	61			X		62-120mm			1	CAPTIS-120-61-RG / D3*
120 ▲	141,8	180	61				X	65,90,110mm			1	CAPTIS-120-61-WG / D3*

Accessories CAPTIS



Clamping device for CAPTIS collets, manual

Size	32	42
Clamping device manual	1283285	1283286
Suitable for	round	round
Weight kg	1	1,1



Clamping device for CAPTIS collets, manual

Size	52	65	80
Clamping device manual	1283287	1283288	1283289
Suitable for	round	round	round
Weight kg	1,1	1,2	1,3



Clamping device for CAPTIS collets, pneumatic

Size	80	100
Clamping device pneumatic	1362635	1362636
Suitable for	round	round
Weight kg	2,5	2,8



Clamping device for CAPTIS collets, pneumatic, 2 hand actuation

Size	120
Clamping device pneumatic (2 hand actuation)	1362637 ▲
Suitable for	round
Weight kg	3

ABSIS-C - patented quick-change function



APPLICATION

Internal clamping of round workpieces. Turning, milling, grinding and toothing operations, as well as for balancing and measuring.
Rotational machining with adaptation to CAPTIS-D, CAPTIS-A.
Stationary machining with adaptation to CAPTIS-M.
Ideal for clamping in through holes.

TYPE

Manual with adaptation to CAPTIS-M.
Force-actuation with adaptation to CAPTIS-D, CAPTIS-A.

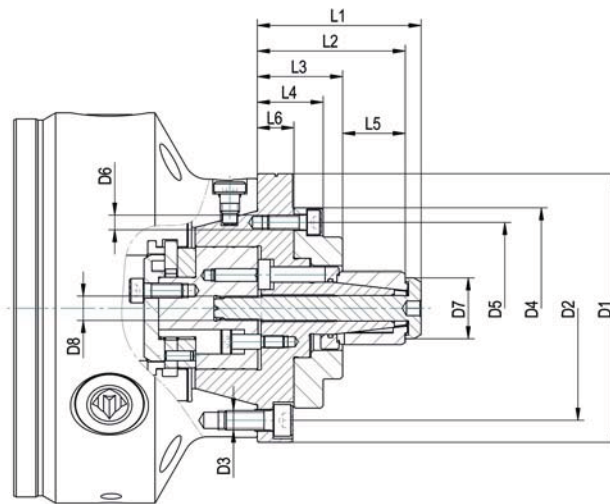
CUSTOMER BENEFITS

- Short setup and non-productive times thanks to great expansion of the segment sleeves
- Vibration damping due to high vulcanized rubber component of the clamping sleeves
- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- Fast change of segment sleeves thanks to central clamping screw
- High concentricity, axial run-out and repeatability
- Innovative quick-change function for fast retrofitting from external to internal clamping

TECHNICAL FEATURES

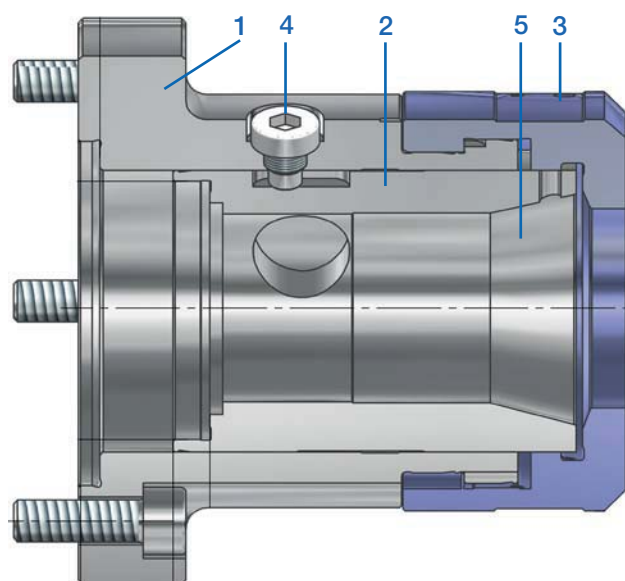
- Identical change parts as for standard segment clamping mandrel ABSIS

ABSIS-C = in Latin: segment, CAPTIS



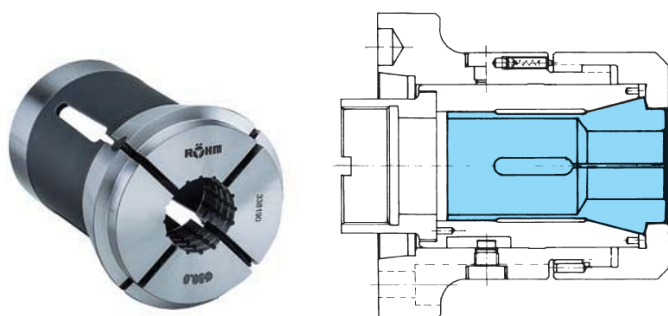
ABSIS-C clamping mandrel

Size	ABSIS 00	ABSIS 00	ABSIS 00	ABSIS 00	ABSIS 01	ABSIS 01	ABSIS 01	ABSIS 01	ABSIS 02	ABSIS 02	ABSIS 02	ABSIS 03
Segment clamping mandrel	1286200	1286201	1286202	1286203	1286204	1286205	1286206	1286207	1286208	1286209	1286210	1286211
For	CAPTIS 32	CAPTIS 42	CAPTIS 52	CAPTIS 65	CAPTIS 32	CAPTIS 42	CAPTIS 52	CAPTIS 65	CAPTIS 42	CAPTIS 52	CAPTIS 65	CAPTIS 65
D Min-Ø unclamped from mm	19,7	19,7	19,7	19,7	25,7	25,7	25,7	25,7	35,7	35,7	35,7	50,7
D Min-Ø unclamped to mm	27,7	27,7	27,7	27,7	38,7	38,7	38,7	38,7	54,7	54,7	54,7	81,7
D1	88	108	110	128	88	108	110	128	110	110	128	128
D2	70	90	92	110	70	90	92	110	90	92	110	110
D3	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8	3x M8
D4	82	82	82	82	82	82	82	82	97	97	97	102
D5	70	70	70	70	70	70	70	70	84	84	84	89
D6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6	3x M6
D7	19	19	19	19	25	25	25	25	35	35	35	48
D8	M6x0,75	M6x0,75	M6x0,75	M6x0,75	M10x1	M10x1	M10x1	M10x1	M14x1	M14x1	M14x1	M18x1
L1	62,2	62,2	62,2	62,2	67,2	67,2	67,2	67,2	95,2	95,2	95,2	105,2
L2	56,7	56,7	56,7	56,7	60,7	60,7	60,7	60,7	85	85	85	93,2
L3	35	35	35	35	35	35	35	35	42,5	42,5	42,5	44,5
L4	25	25	25	25	27	27	27	27	30,25	30,25	30,25	31,5
L5	21,7	21,7	21,7	21,7	25,7	25,7	25,7	25,7	42,5	42,5	42,5	48,7
L6	15	15	15	15	15	15	15	15	18	18	18	18,5

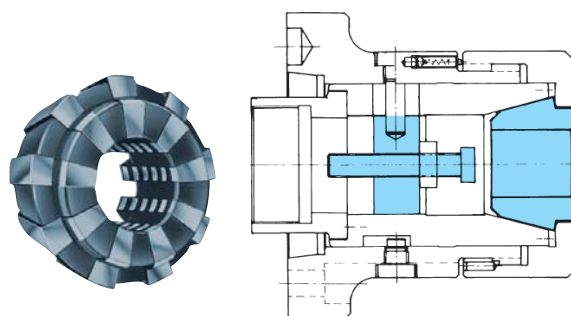


1. Body
2. Thrust sleeve for steel collets and segment collets. By replacing the thrust sleeve, duo-segment collets can be used.
3. Union nut with bayonet lock
4. Protection against torsion for thrust sleeve
 - Adapter fitting must be ordered separately. Suitable for existing draw tube, glue into thrust sleeve.
 - Special accessories, are not part of the scope of delivery. The workpiece stop can only be used for segment collets. Order separately: Cap screw or stud bolt with locknut acc. to DIN 55027.
5. Protection against torsion for collet

Hollow clamping with steel collet DIN 6343



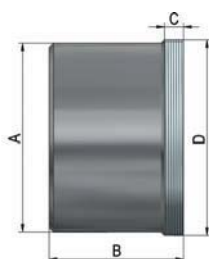
Clamping with segment collet and workpiece stop



Chuck size	Collets DIN 6343					
	Type		Clamping capacity			Tolerance
KZF 40	8206-E	DIN 6343 173 E	2-42	6-36	6-29	+0,2 -0,3
KZF 60	8207-E	DIN 6343 185 E	4-60	8-52	7-42	+0,2 -0,3
KZF 80	7037-E	DIN 6343 193 E	20-80	18-69	15-56	+0,2 -0,3

Chuck size	Segment collets DIN 6343		
	Type	Clamping capacity	Tolerance
KZF 40	Series R 36	8-42	2±0,3
KZF 60	Series R 52	19-61	2±0,3
KZF 80	-	-	-

C 15
Connecting piece for collet chuck KZF



Item no.	Größe	A	B	C	D
683648	40	62	60	8,5	M66x1,5
683649	60	85	60	8,5	M88x1,5
683652	80	100	60	12,5	M114x1,5

KZF - without axial tightening, for DIN collet chucks



APPLICATION

External clamping of round workpieces, as well as square and hexagon profiles. Turning, milling, grinding operations as well as for measuring. Ideal for bars and pipe machining on the main spindle. For using standardized DIN collet chucks or segment collet chucks.

TYPE

Force-actuated.
Internal workpiece stop optional in conjunction with segment collet.

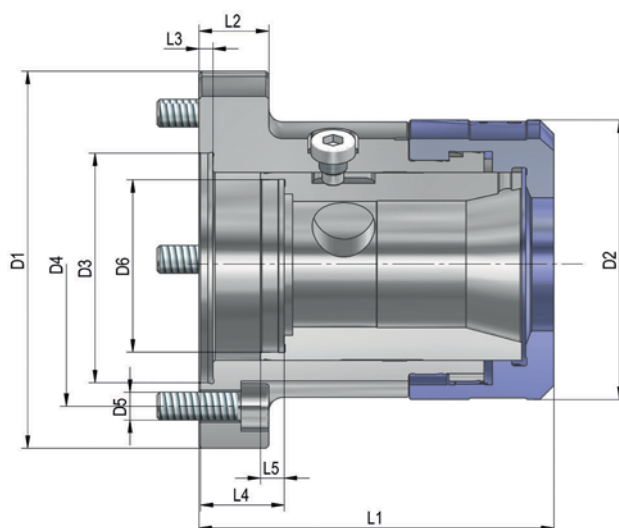
CUSTOMER BENEFITS

- ⊕ Light weight and reduced height thanks to compact design
- ⊕ Short setup times thanks to quick change of collet chuck
- ⊕ High flexibility thanks to modular system
- ⊕ Quick retrofitting to other workpieces by changing the collect chuck
- ⊕ Axially fixed collect chuck, no axial tension against internal workpiece stop

TECHNICAL FEATURES

- Hardened, low-wear design
- Either DIN steel or segment collet chucks

KZF = force-actuated, collet, flange



C 15

Power-operated collet chuck KZF, with quick-acting bayonet catch, without collet
Cylindrical center mount / short taper mount, draw tube adapter available on request

Id.-Nr.	439989	439990	439991	439992	439993	439994	439995	439996	439997	439998
Size	40	40	40	40	60	60	60	60	80	80
Mount	Z-140	Z-88	KK 5	KK 6	Z-115	Z-170	KK 6	KK 8	Z-130	KK 8
D1	160	135	170	170	157	190	210	210	187	210
D2	100	100	100	100	122	122	122	122	150	150
D3	140	88	82,563	106,375	115	170	106,375	139,719	130	139,719
D4	104,8	115	104,8	133,4	136	133,4	133,4	171,4	166	171,4
D5	4xM10	6xM8	4xM10	4xM12	8xM8	6xM12	4xM12	4xM16	8xM8	4xM16
D6	M66x1,5	M66x1,5	M66x1,5	M66x1,5	M88x1,5	M88x1,5	M88x1,5	M88x1,5	M88x1,5	M114x1,5
L1	116	116	127	128	132	132	144	146	156	170
L2	25	25	25	25	25	25	25	25	30	30
L3	5	5	16	18	5	5	18	22	5	22
L4 min	16	16	32	33	16	16	33	35	17	36
L4 max	8,5	8,5	24,5	25,5	8,5	8,5	25,5	27,5	9,5	28,5
L5	8,5	8,5	8,5	8,5	8,5	8,5	8,5	8,5	12,5	12,5
Total stroke mm	7,5	7,5	7,5	7,5	7,5	7,5	7,5	7,5	7,5	7,5
Maximum draw bar pull kN	25	25	25	25	30	30	30	30	35	35
Total clamping force kN	50	50	50	50	60	60	60	60	70	70
Adm. speed min ⁻¹	8000	8000	8000	8000	5000	5000	5000	5000	4000	4000
Chucking capacity mm	2-42	2-42	2-42	2-42	4-60	4-60	4-60	4-60	20-80	20-80
Moment of inertia J kgm ²	0,029	0,029	0,029	0,029	0,038	0,038	0,038	0,038	0,108	0,108
Weight without collet kg	7,1	5,3	7,5	7,5	9,2	9,2	10,2	14	17,5	18

KZF-S - with axial tightening, bayonet quick lock



APPLICATION

External clamping of round workpieces with smooth or toothed outer geometry for turning, milling, grinding and measuring operations. Clamping device/clamping optimal adapted to the workpiece/machining process. Ideal for short clamping lengths.

TYPE

Force-actuated.

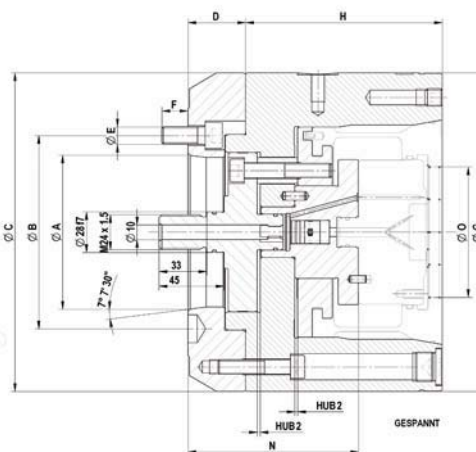
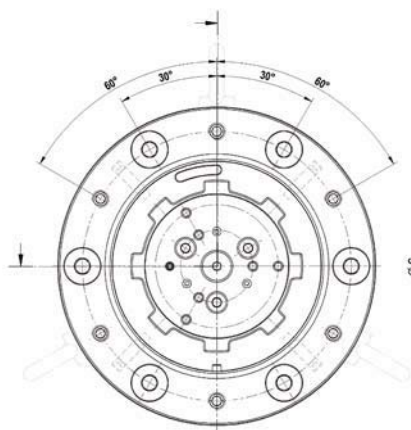
CUSTOMER BENEFITS

- Sturdy clamping of the workpiece thanks to axial tension against the workpiece stop
- Quick change of collet chuck by bayonet lock
- High concentricity, axial run-out and repeatability
- High flexibility thanks to modular system

TECHNICAL FEATURES

- Manual lubrication/low-maintenance
- Prepared for internal media feed-through, e.g. air and coolant
- Prepared for internal workpiece stop
- Collet chucks and internal workpiece stop can be individually adapted to the workpiece
- Sealing against chips

KZF-S = force-actuated, collet, flange, quick-change function



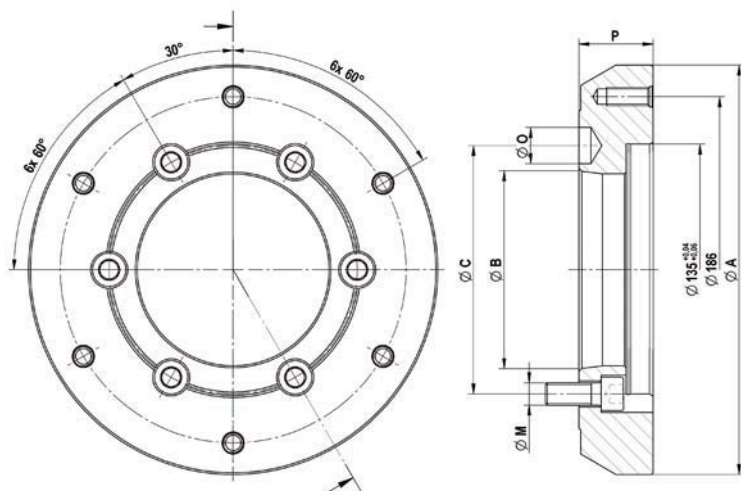
C 18

Power-operated collet chuck KZF-S, for external clamping

	KZF 80	KZF 120	KZF 180
Body collet	1117832 ▲	1117830 ▲	1125403 ▲
Base bolt	1117833	1072101	1125404
Draw piece	1117837	1117827	1125408
Fastening plate	1117835	1072105	1125406
Bolt spacer	1117836	1072103	1072103
Ground stop for reverse valve cartridge	1117839	1072113	1125410
Ground stop for ermeto pipe	1117841	1117824	1125412
Reverse valve cartridge 1 Bar	756641	863134	863134
Reverse valve cartridge 3 Bar	843866	889894	889894
F Max, in daN	30	40	40
Speed max, min ⁻¹	6000	5000	3500
Stroke mm	4	4	4
Clamping dia, min,	30	60	100
Clamping dia, max,	80	120	180
Expansion in Ø mm	1,4	1,4	1,4
Ø G	170	220	285
H mm	125	136	136

Info: kzf@roehm.biz

Accessories KZF-S



C 18

Intermediate flange ISO 702-1 (DIN 55028)

	A 05	Nr. 5 (A5)	A 05	Nr. 6 (A6)	A 06	A 08	Nr. 8 (A8)	A 08
Intermediate flange	1117843	1072115 ▲	1117845 ▲	1072117	1125416 ▲	1117847	1072119	1125418 ▲
For	KZF-S 80	KZF-S 80/AGILIS 05-07	KZF-S 81	KZF-S 120/AGILIS 05-07	KZF-S 180	KZF-S 82	KZF-S 120/AGILIS 05-07	KZF-S 180
Short-taper- $\varnothing B$	82,563	82,563	106,375	106,375	106,375	139,719	139,719	139,719
Short-taper pitch circle $\varnothing C$	104,8	104,8	133,4	133,4	133,4	171,4	171,4	171,4
Flange outer- $\varnothing A$	170	220	170	220	285	210	220	285
$\varnothing D$	105	135	105	135	200	105	135	200
$\varnothing F$ mm	143	186	143	186	250	143	186	250
$\varnothing O$ mm	16,3	16,3	19,45	19,45	19,45	24,2	24,2	24,2
Thread- $\varnothing M$	M10	M10	M12	M12	M12	M16	M16	M16
Total length flange P	35	40	35	40	45	35	40	45