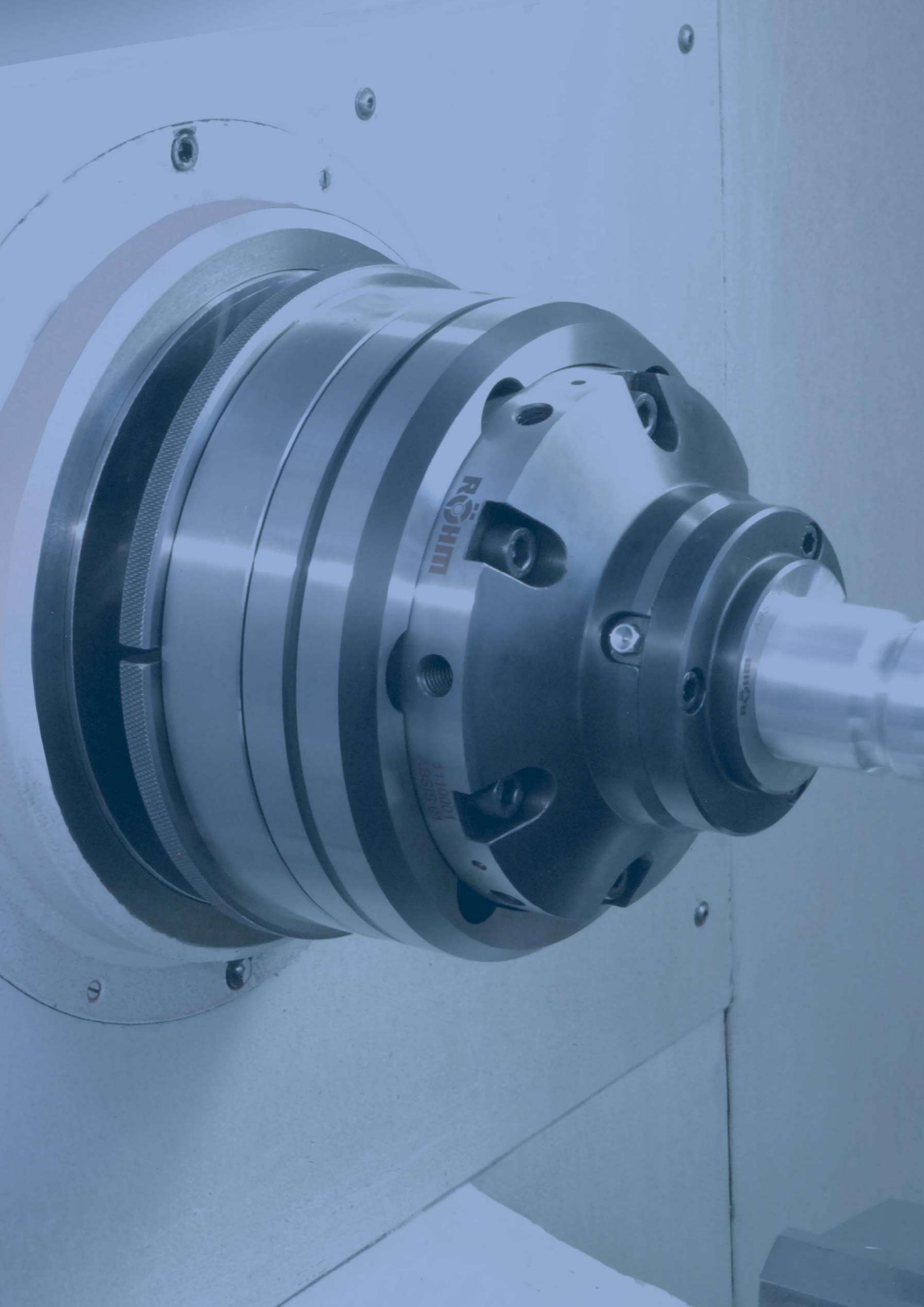




MANDRELS COLLET CHUCKS

EDITION 8

RÖHM
driven by technology



Special solutions KFG



Sliding clamping mandrel KFG clamping-Ø 30 mm

APPLICATION

Turning of a differential housing

Clamping of a differential housing in two clamping planes. Diameter difference between the clamping planes are compensated. The workpiece stop is equipped with an air sensing. The entire clamping mandrel is sealed with purge air.

CUSTOMER BENEFITS

- Two compensating clamping planes
- Concentricity of 0.02 mm



Sliding clamping mandrel KFG clamping-Ø 155 mm / clamping-Ø 161 mm

APPLICATION

Drilling of two workpieces with different diameters

Clamping of two clamping planes that are very close together. Clamping of both clamping planes is done using springs. Pneumatic unclamping via a cylinder in the basic take-up. Compact, space-saving construction. Drain boreholes for coolant.

CUSTOMER BENEFITS

- Overall height less than 200 mm
- Concentricity of 0.03 mm



Sliding clamping mandrel KFG clamping range from 98-113 mm

APPLICATION

Turning of clamping cylinder liners, raw part

Left clamping plane force-actuated by draw bar. Right clamping plane spring-actuated to compensate for workpiece tolerances. Stop can be pulled back. Different workpiece diameters can be clamped by changing the top jaws.

CUSTOMER BENEFITS

- Large clamping range elongation of 7 mm
- Large torque transmission from corrugation of the top jaws

Special solutions KFG



Sliding clamping mandrel KFG with intermediate sleeves Ø 104-120 mm

APPLICATION

Turning of clamping cylinder liners, final machining

Left clamping plane force-actuated by draw bar. Right clamping plane force-actuated by tailstock. Stop can be pulled by with air sensing. Different workpiece diameters can be clamped by changing the intermediate sleeve.

CUSTOMER BENEFITS

- ⌚ Intermediate sleeve can be changed
- ⌚ High concentricity of 0.015 mm



Sliding clamping mandrel KFG clamping-Ø 39 mm / clamping-Ø 40 mm

APPLICATION

Turning

The clamping in clamping zone 1 is done by the draw bar with serrated jaws for high torque transmission. Clamping zone 2 is actuated by springs and is equipped with an intermediate sleeve.

CUSTOMER BENEFITS

- ⌚ Intermediate sleeve protects the workpiece surface
- ⌚ Concentricity of 0.01 mm

Special solution HYKS



Hydraulically actuated clamping mandrel for internal and external clamping

APPLICATION

Grinding, turning, milling, measuring

The hydraulic medium is put under pressure by a piston or by system pressure. The elongation can be up to 0.3 % (up to 1 % for special materials) of the diameter of the extension sleeve. Clamping directly by extension sleeve or indirectly by a slotted intermediate sleeve.

CUSTOMER BENEFITS

- Cylindrical and round elongation over the entire clamping range for a maximum concentricity tolerance of 0.003 mm
- Very high clamping force in the clamping zone
- Optimum damping, extremely quiet machining and significantly higher service life of the tool due to precisely fitted clamping sleeve

TECHNICAL FEATURES

Force-actuated or manual actuation. Wear-resistant surface. The clamping systems can be put under pressure by hydraulic or pneumatic cylinders, by the machine hydraulics directly or even manually by using a screw. Different stops (optional): fixed, withdrawable, external, oscillating, etc.

Special solutions



Special mandrels

APPLICATION

Grinding, milling

Basic take-up with different replaceable head for clamping of pistons. Face clamping using internal draw piece. Position orientation using centering forks. An insertion securing device prevents incorrect loading. The actuation is done using OVS70 RÖHM clamping cylinders. The entire external contour can be machined.

CUSTOMER BENEFITS

- ⌚ Clamping head with quick change system
- ⌚ Concentricity of 0.005 mm



Clamping fixture

APPLICATION

Milling, drilling

Clamping device with three basic units. Pneumatically release; Clamping via spring force. Two basic units equipped with KFR clamping mandrels. A basic unit equipped with a power chuck.

CUSTOMER BENEFITS

- ⌚ Basic units can be equipped with different clamping systems