Technical information for collets

**for external clamping**

1. Prepare collet
2. Machine collet
3. Position workpiece
4. Tighten cam cylinder

**for internal clamping**

1. Prepare collet
2. Machine collet
3. Position workpiece
4. Tighten cam cylinder
Technical information for collets

Series clamping

Small OD allows clamping in series with a limited space.

Fixture for individual parts

Clamp in a vice by mounting on a plate.

Fixture for lathe chuck

Can hold complex forms which are impossible for a 3 jaw chuck.
technical information for collets

force effect:

collet segment travel: 0.3mm in diameter

when the cam cylinder is tightened, the collet is drawn down. at the same time the 8 collet segments tilt towards the centre and clamp the workpiece.

collet and adaptor ±0.02 mm

when the clamping cylinder is tightened, the traction cone is pulled downwards (positive down force). at the same time, the 8 collet segments tilt outwards from the centre and the workpiece is clamped.

workpiece and collet ±0.03 mm