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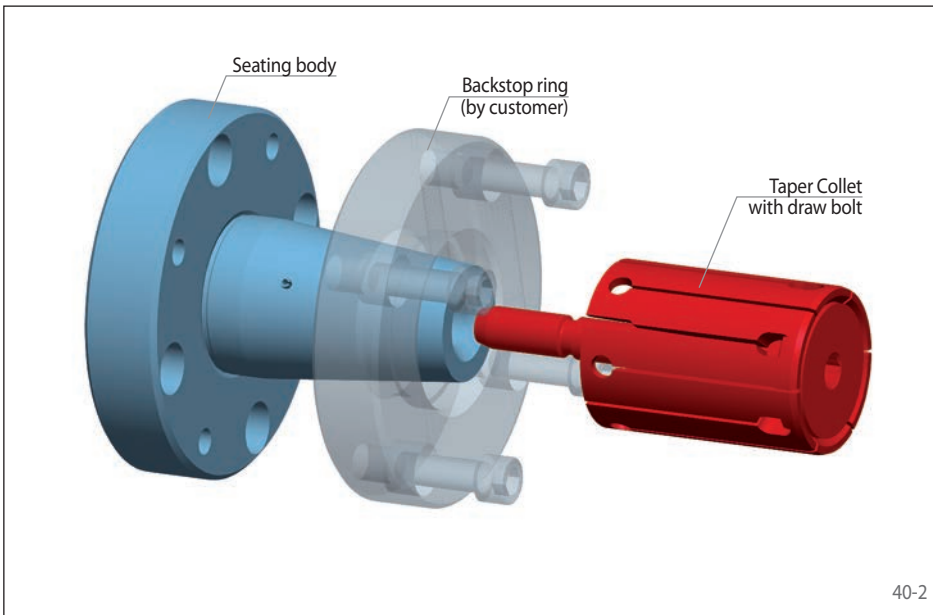
## Features

- For clamping diameters from 11,9 mm to 132 mm
- High true running accuracy  $\leq 0,01$  mm
- Permissible component tolerance up to IT15
- Pull-back against external backstop surface or external backstop ring by the customer
- For thin-walled or solid components
- Hand clamping optional possible

## Configuration

The Taper Collet Flange Mandrel consists of a seating body and a Taper Collet with draw bolt. Taper Collets with hexagon head or pre-centering and a plate with threaded bore are optionally available. The Taper Collet Flange Mandrel is attached to the machine with the seating body. The Clamping Fixture is actuated by the draw bolt, which is connected to the machine power actuating unit.

Intermediate Flanges and Spring Force Actuators are shown starting on page 64.

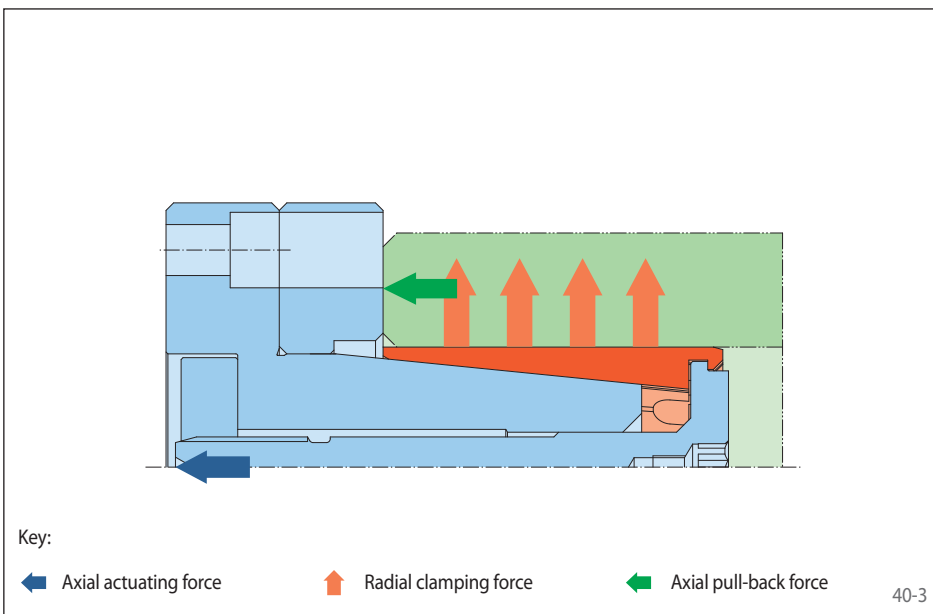


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## Clamping principle

For clamping, the Taper Collet is pulled against the seating body and radially expands over the cone of basebody. The component is centred, pressed against the backstop and aligned flush.

The cylindrical form of the component bore in the clamping area has to be smaller than the tolerance class IT7, independent of the component bore tolerance.



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