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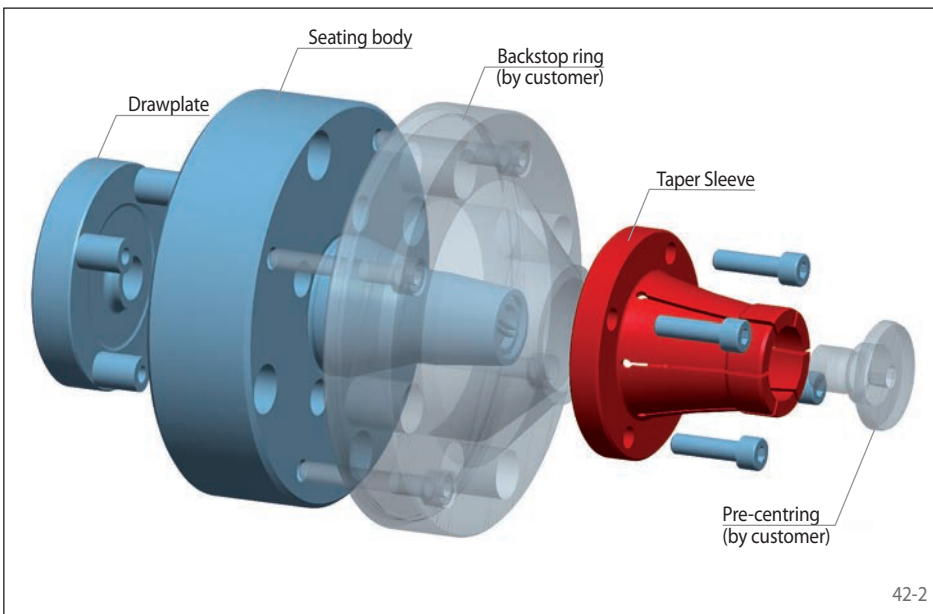
Features

- For clamping diameters from 9 mm to 275 mm
- High true running accuracy
 $\leq 0,01$ mm by HKDF 4 up to HKDF 125
 $\leq 0,015$ mm by HKDF 150 and HKDF 200
- Permissible component tolerance up to IT13
- Pull-back against external backstop surface or external backstop ring by the customer
- Impervious to ingress of foreign objects due to the rubberized slots in the Taper Sleeve

Configuration

The Taper Sleeve Flange Mandrel consists of a draw plate, a seating body and a Taper Sleeve. The Taper Sleeve Flange Mandrel is attached to the machine with the seating body. The Clamping Fixture is actuated by the draw plate, which is connected to the machine power actuating unit.

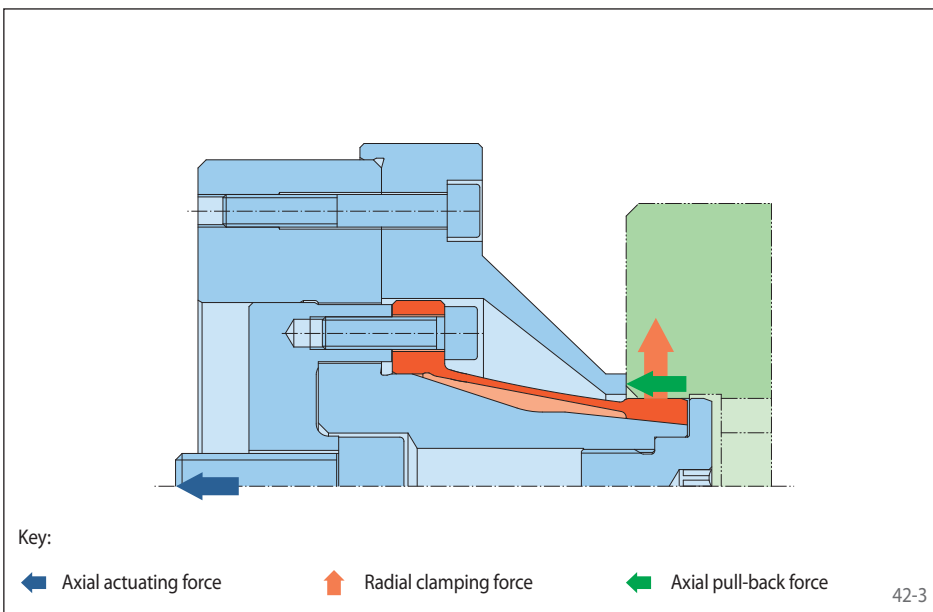
Intermediate Flanges and Spring Force Actuators are shown starting on page 58.



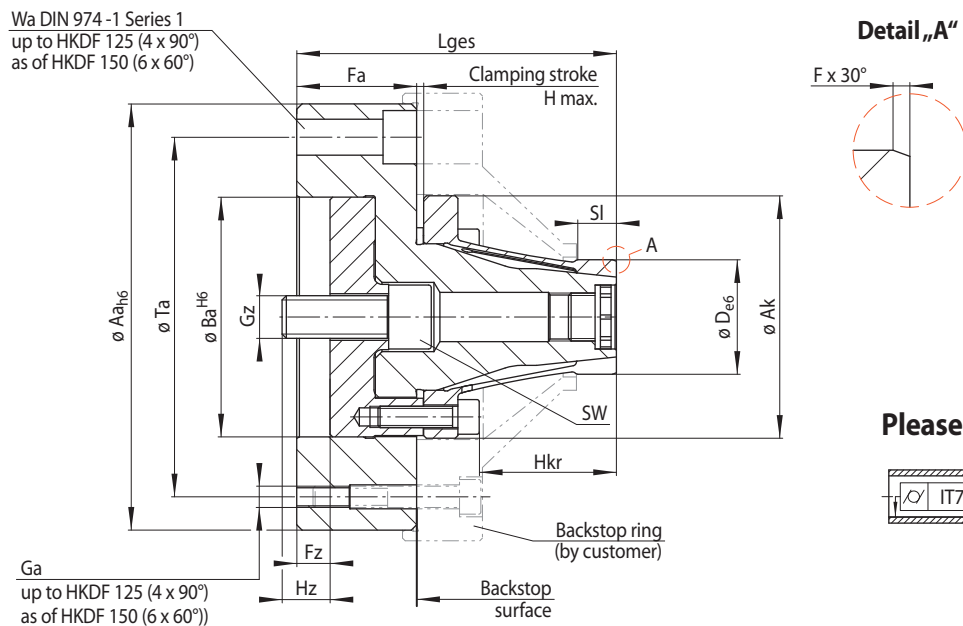
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Clamping principle

For clamping, the Taper Sleeve is pulled against the seating body. The component is centred, pressed against the backstop and aligned flush.



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Please note



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Size	Achievable clamping diameter D* mm	Maximum diameter change** Δ D mm	Max. transmissible torque*** M Nm	Max. actuating force*** F N	Aa mm	Ak mm	Ba mm	F mm	Fa mm	Fz mm	Ga mm	Gz mm	H max. mm	Hkr mm	Hz mm	Lges mm	SI mm	SW mm	Ta mm	Wa mm
HKDF 4	9 - 16	0,5	6,5	8000	90	51	50	0,5	36	14	M 6	M 12	2,7	36,5	14	92	7	-	70	8
HKDF 6	15 - 20	0,5	10	9000	90	51	50	0,5	36	14	M 6	M 12	2,7	36,5	14	92	9	-	70	8
HKDF 7	19 - 26	0,5	12	9000	90	51	50	1,0	36	14	M 6	M 12	2,7	36,5	14	92	10	-	70	8
HKDF 12	25 - 32	0,5	22	10000	90	51	50	1,0	36	14	M 6	M 12	2,7	38,5	14	95	10	-	70	8
HKDF 19	31 - 44	0,5	55	16000	120	61	60	1,0	49	19	M 8	M 16	2,7	47,5	18	118	15	-	95	10
HKDF 30	43 - 55	0,5	158	30000	160	91	90	1,0	45	12,5	M 8	M 16	2,8	51,5	18	120	15	14	135	12
HKDF 40	54 - 76	0,5	278	40000	160	91	90	1,0	45	12,5	M 8	M 16	2,8	61,5	18	130	15	14	135	12
HKDF 60	75 - 100	0,5	613	60000	185	126	125	1,0	57	12,5	M 8	M 20	2,9	58,5	20	143	15	17	160	12
HKDF 80	100 - 125	0,8	1050	80000	250	170	175	2,0	68	15,1	M 10	M 20	4,5	68	22	172,5	20	17	225	12
HKDF 100	125 - 150	0,8	1300	80000	250	170	175	2,0	68	15,1	M 10	M 20	4,5	68	22	172,5	20	17	225	12
HKDF 125	150 - 175	1,0	2050	100000	275	200	200	3,0	73	15,5	M 10	M 20	5,0	75	27,5	188	25	17	250	12
HKDF 150	175 - 225	1,2	3000	140000	300	230	225	3,0	89,5	20	M 10	M 24	7,5	98	50	240	30	19	260	16
HKDF 200	225 - 275	1,5	4500	170000	350	280	275	3,0	106,5	20	M 10	M 24	8,5	115	40	275	30	19	315	16

* Clamping diameter adjustable to two places after the decimal point • ** of the clamping diameter of the Clamping Element. • *** for clamping with pull-back action.

Example for ordering

Please indicate the size of the Clamping Fixture and the clamping diameter of your component, including component tolerance, in your order:

Size: HKDF 30
Clamping diameter: 50,47 mm
Component tolerance: H7

➔ HKDF 30-50,47H7