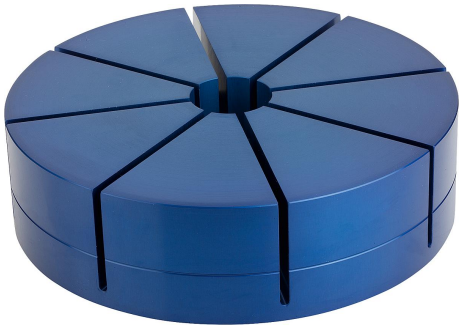
# K1184

# Collets for external clamping

## Item description/product images



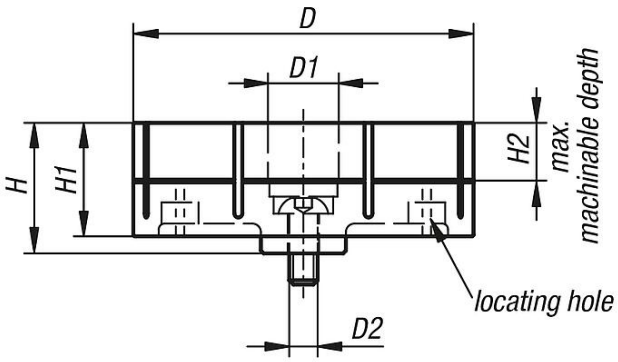
## Description

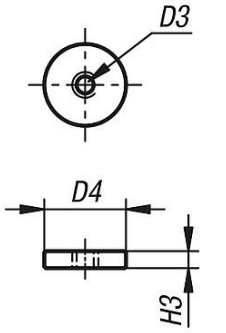
**Material:**
High-strength aluminium alloy

**Version:**
blue anodised.

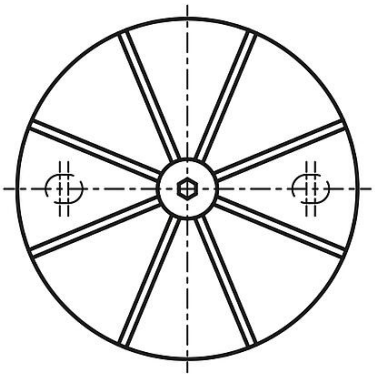
**Note:**
Collets for clamping external contours.
The contour of the workpiece to be held is machined into the collet. Free-form and asymmetrical contours can be held.
The collet mechanism enables a secure clamping of the workpiece.
Clamping travel per collet segment (8x) max. 0.15 mm.
Workpiece repeat accuracy: ±0.03.
Collet repeat accuracy: ±0.02.
Matching adaptor K1183.

## Drawings




clamp ring for machining, included

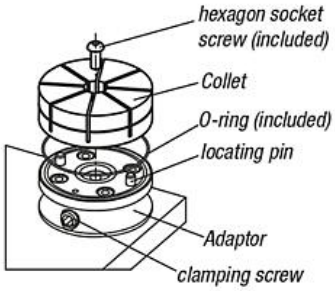


# Collets for external clamping

## Drawings

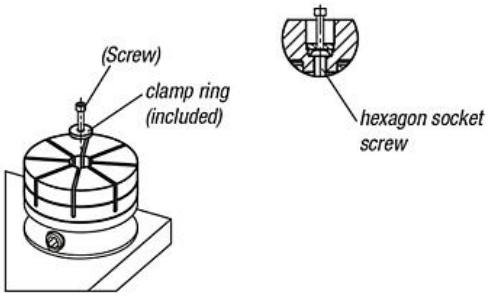
**1. Mounting collet:**
- Insert an O-ring into the groove on the top face of the clamp base.
- Set a collet on the base making sure the locating pins fit into the locating holes on the undeside of the collet. Secure the collet using a buttonhead hex socket screw.

Note:
Before mounting the collet, ensure the cam cylinder is fully loosened by turning the tightening screw counterclockwise until it stops.

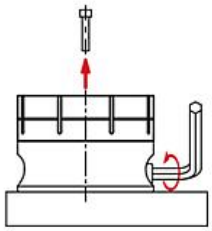



**2. Machining collet:**

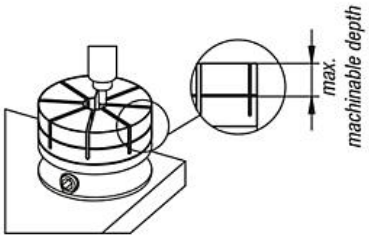
2.1
Place the clamp ring in the centre of the collet.
(Use a screw as an insertion aid)




2.2
Tighten the cam cylinder to clamp the clamp ring (recommended torque: 15Nm).
Remove the screw from the clamp ring before machining.

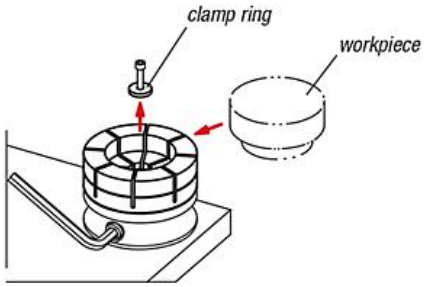


2.3
Machine the contour of the part that is to be held into the collet.

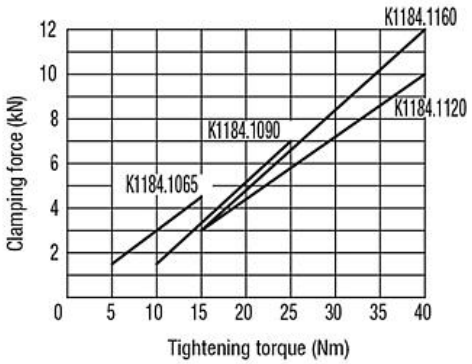



Note:
Do not machine the contour deeper than the permitted depth.

**3. Mounting workpiece:**
- Loosen the cam cylinder and remove the clamp ring.
- Place the workpiece in the contour and re-tighten the cam cylinder.




**Performance curve**




To avoid damaging the collet do not tighten the clamp without a workpiece or clamp ring.
Observe the maximum tightening torque in the table.

# Collets for external clamping

## Overview of items

### Collets for external clamping

| Order No. | D | D1 | D2 | D3 | D4 | H | H1 | H2 | H3 |
|---|---|---|---|---|---|---|---|---|---|
| **K1184.1065** | 65 | 21 | M8 | M5 | 20 | 29 | 25 | 10 | 4 |
| **K1184.1090** | 90 | 25 | M10 | M6 | 24 | 40 | 35 | 15 | 5 |
| **K1184.1120** | 120 | 25 | M10 | M6 | 24 | 46 | 40 | 20 | 5 |
| **K1184.1160** | 160 | 29 | M12 | M8 | 28 | 52 | 45 | 25 | 6 |