

# Collets

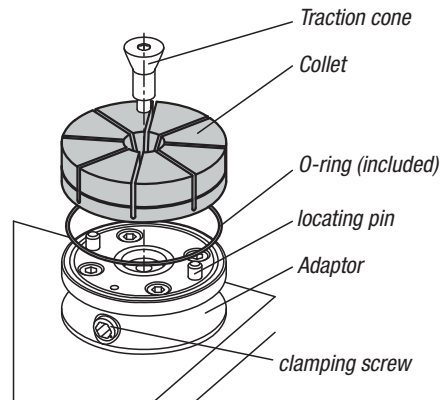
for internal clamping

## 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 underside of the collet. Secure the collet using the tapered screw.

### Note:

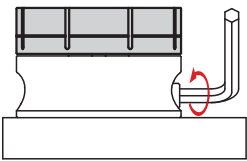
Before mounting the collet, ensure the cam cylinder is fully loosened by turning the tightening screw counterclockwise until it stops.



## 2. Machining collet:

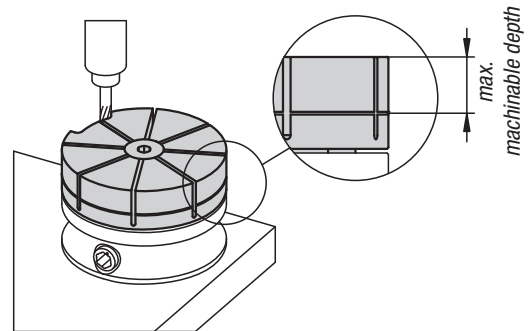
### 2.1

Fully loosen the cam cylinder and measure the OD of the collet. Tighten the cam cylinder until the collet OD has expanded by 0.15 mm.



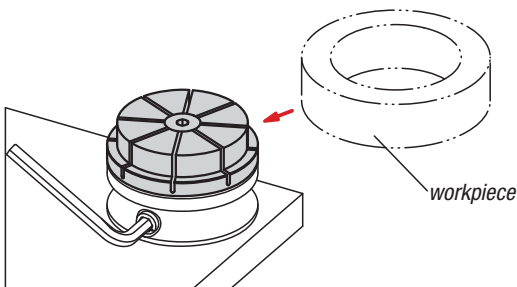
### 2.2

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

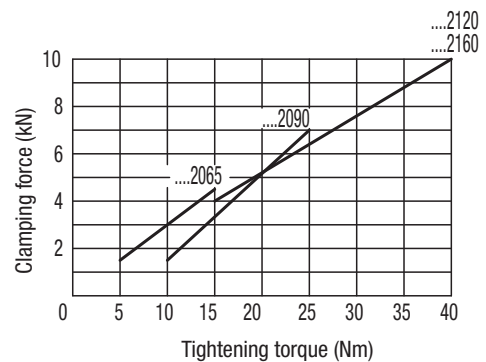


## 3. Mounting the workpiece:

- 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.