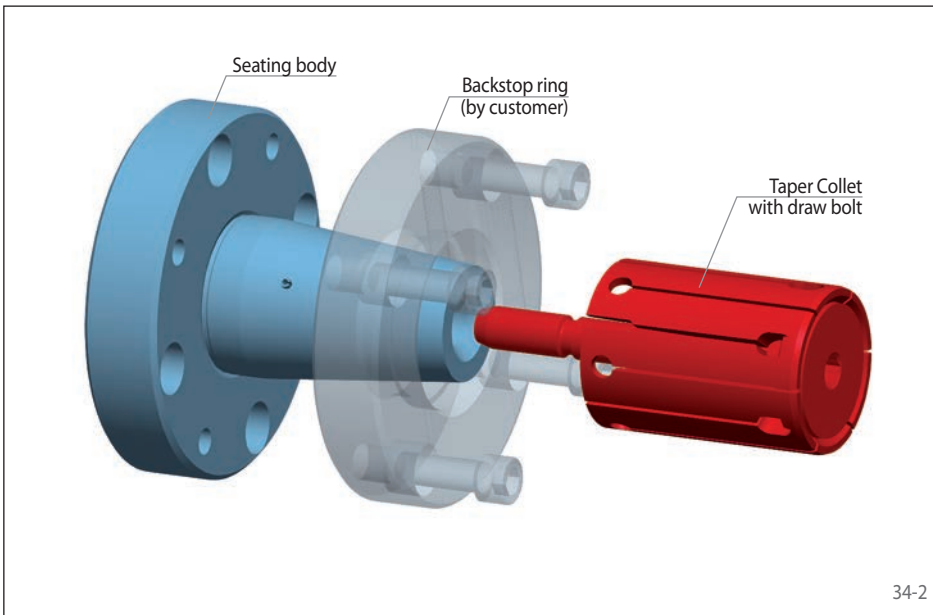


34-1

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

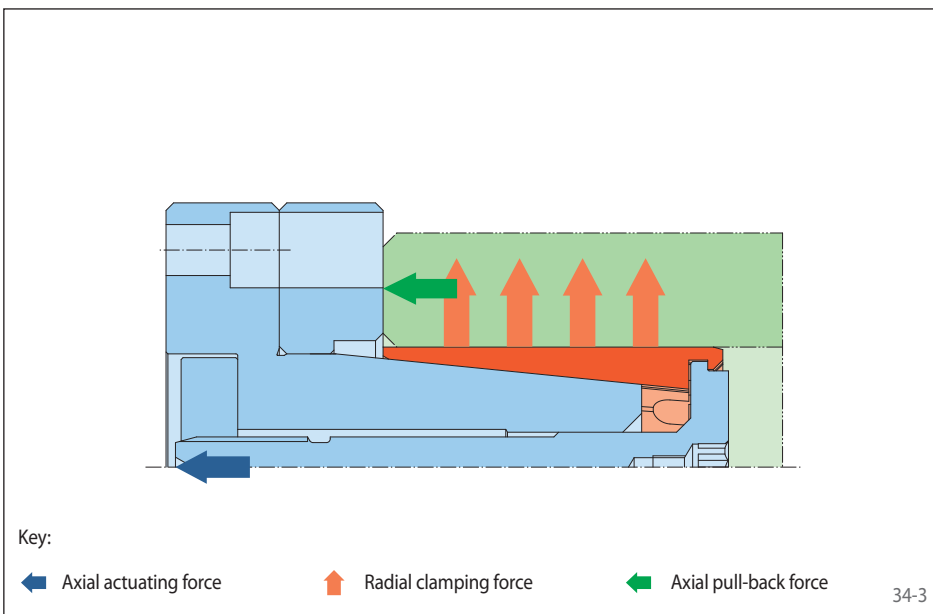


34-2

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.

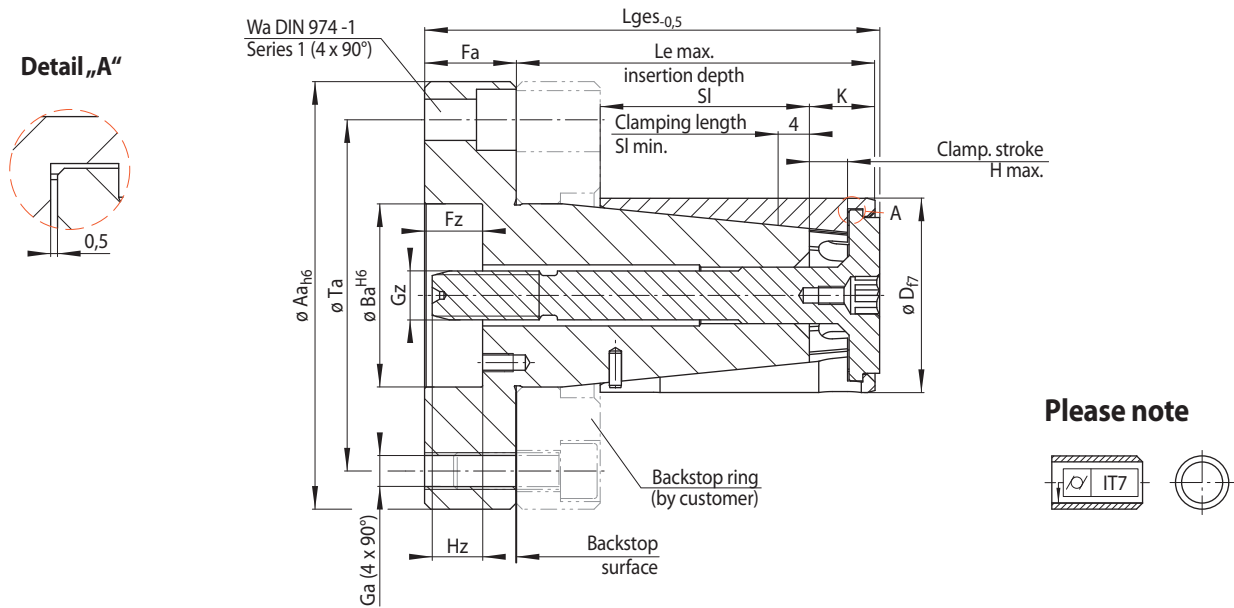
Intermediate Flanges and Spring Force Actuators are shown starting on page 58.



34-3

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.



Size	Clamping range D ¹⁾ mm	Maximum diameter change* ΔD mm	Max. transmissible torque** M Nm	Max. actuating force** F N	Aa mm	Ba mm	Fa mm	Fz mm	Ga mm	Gz mm	H max. mm	Hz mm	K mm	Le max. mm	Lges mm	SI mm	Ta mm	Wa mm
BKDF 6	11,90 - 15,00	0,6	11	5000	70	37	20	9	M 8	M 5	4,1	18,4	8,1	31,9	53,1	14,9	50	8
BKDF 7	14,70 - 20,90	1,2	13	5000	70	37	20	9	M 8	M 5	6,9	18,4	10,9	46,9	69,6	24,1	50	8
BKDF 12	20,70 - 27,90	1,2	44	12000	70	37	20	9	M 8	M 8	6,95	16,35	11,45	61,45	84,65	33,55	50	8
BKDF 18	27,70 - 32,80	1,2	58	12000	70	37	20	9	M 8	M 8	7,0	16,4	11,5	60,5	82,0	33,5	50	8
BKDF 19	32,60 - 42,80	1,2	114	20000	90	50	30	14	M 8	M 12	7,0	18,3	13,0	82,0	113,5	52,0	70	8
BKDF 27	42,60 - 51,80	1,2	147	20000	90	50	30	14	M 8	M 12	7,0	18,3	13,0	82,0	113,5	52,0	70	8
BKDF 32	51,60 - 64,00	2,4	273	30000	120	60	30	19	M 10	M 16	13,0	16,5	21,5	117,5	149,0	68,5	95	10
BKDF 43	63,60 - 72,00	2,4	333	30000	140	60	30	19	M 12	M 16	13,0	16,5	21,5	117,5	149,0	68,5	115	12
BKDF 44	71,60 - 82,00	2,4	373	30000	140	60	30	19	M 12	M 16	13,0	16,5	21,5	147,5	179,0	98,5	115	12
BKDF 54	81,60 - 132,00	2,4	424	30000	140	60	30	19	M 12	M 16	13,05	16,45	21,55	147,55	179,05	98,45	115	12

¹⁾ Please note the standard clamping ranges according to the tables on the next pages „Clamping Elements Taper Collets“.
 * 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 range of the requested Taper Collet, in your order:

Size: BKDF 27
 Clamping range: 46,60 - 47,80 mm
 ➔ BKDF 27-46,60-47,80

Insertion depth

The minimum insertion depth $Le_{min.}$ is derived according to the following formula from the component chamfer length Lf and dimension K :

$$Le_{min.} = K + Lf + 4 \text{ mm (SI}_{min.})$$