

CLAMPING HEADS

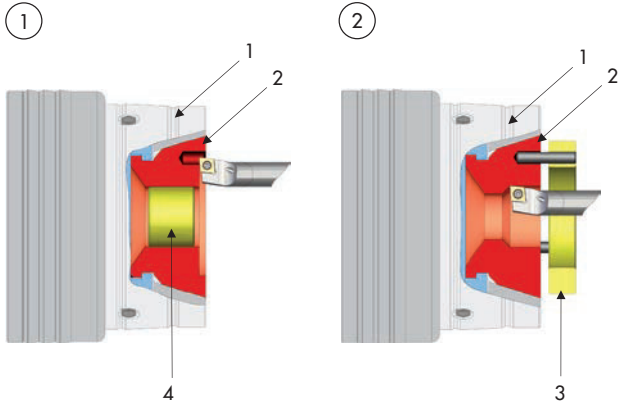
Clamping heads SE



Three SE types






	TOP	TOPG	TOP HSW
			
Applications	for clamping of raw material	for clamping of finished material	for machining to size
Sizes	26, 40, 52, 65, 100	26, 40, 52, 65, 100	40, 52, 65, 100
Clamping range of all sizes [mm]	4 – 100	4 – 100	8 – 90
Clamping surface	serrated	smooth	
Material condition	hard [60 HRC]	hard [60 HRC]	hard [60HRC] / soft [40 HRC]
Standard profiles	round square hexagonal	round	round
Special - serration	coarse toothed [Z] finely serrated [F]		

Machining to size of HSW clamping heads

Designation	
<ul style="list-style-type: none"> 1 Chuck 2 HSW clamping head [reduced hardness of 40 HRC in the bore] 3 Loading ring 4 Bolts 	



Design of the bore

Standard version	Special serration
<p>Smooth</p>  <p>Clamping virtually without clamping marks Application example: Clamping of previously machined contours</p>	<p>F-serration</p>  <p>Powerful clamping through scoring the small pointed teeth – with clamping marks Application example: Clamping of raw material</p>
<p>Radial and axial grooves</p>  <p>Powerful clamping with clamping marks Application example: Clamping of raw material</p>	<p>Z-serration</p>  <p>Powerful clamping through deep scoring of the clamping teeth – with clamping marks Application example: Clamping of raw material [e.g. oxidized, rolled material]</p>
<p>Radial grooves</p>  <p>Powerful clamping with clamping marks Application example: Clamping of raw material</p>	



Clamping head TOP. For raw material clamping

Size	Total length [mm]	Particularity	Profile	Increments [mm]	Type of serration	Clamping range [mm]	In stock	Order no.
26	34	Front nose extension	●	1	Smooth	4 - 7	✓	top26r4,0-7,0
					Radial grooves	8 - 10	✓	top26r8,0-10,0
					Radial and axial grooves	11 - 26	✓	top26r11,0-26,0
			■		Smooth	7	-	top26v7,0
			Radial grooves		8 - 18	-	top26v8,0-18,0	
			●		Smooth	7	-	top26s7,0
			Radial grooves		8 - 22	-	top26s8,0-22,0	
40	47	Front nose extension	●	1	Smooth	4 - 7	✓	top40r4,0-7,0
					Radial grooves	8 - 10	✓	top40r8,0-10,0
					Radial and axial grooves	11 - 40	✓	top40r11,0-40,0
			■		Smooth	7	-	top40v7,0
			Radial grooves		8 - 27	-	top40v8,0-27,0	
			●		Smooth	7	-	top40s7,0
			Radial grooves		8 - 32	-	top40s8,0-32,0	
52	42	No front nose	●	0,5	Smooth	4 - 7,5	✓	top52r4,0-7,5
					Radial grooves	8 - 10,5	✓	top52r8,0-10,5
					Radial and axial grooves	11 - 52	✓	top52r11,0-52,0
			■	1	Radial grooves	8 - 36	-	top52v8,0-36,0
			●		Smooth	7	✓	top52s7,0
			Radial grooves		8 - 45	✓	top52s8,0-45,0	
65	49	No front nose	●	0,5	Smooth	3 - 7,5	✓	top65r3,0-7,5
					Radial grooves	8 - 10,5	✓	top65r8,0-10,5
					Radial and axial grooves	11 - 65	✓	top65r11,0-65,0
			■	1	Radial grooves	8 - 45	-	top65v8,0-45,0
			●		Smooth	7	✓	top65s7,0
			Radial grooves		8 - 56	✓	top65s8,0-56,0	
100	59	No front nose	●	1	Radial and axial grooves	15 - 41	-	top100r15,0-41,0
						42 - 100	✓	top100r42,0-100,0
			■		Radial grooves	50 - 70	-	top100v50,0-70,0
			●			50 - 86	-	top100s50,0-86,0
			Radial grooves			50 - 86	-	top100s50,0-86,0

Explanations of the types of clamping surfaces on the previous page.



Clamping head TOPG. For clamping of finished material

Size	Total length [mm]	Particularity	Profile	Increments [mm]	Type of serration	Clamping range [mm]	In stock	Order no.
26	31	No front nose	●	0,5	Smooth	4 - 26	✓	top26gr4,0-26,0
40	44	No front nose	●	0,5	Smooth	4 - 40	✓	top40gr4,0-40,0
52	42	No front nose	●	0,5	Smooth	4 - 52	✓	top52gr4,0-52,0
65	49	No front nose	●	0,5	Smooth	3 - 65	✓	top65gr3,0-65,0
100	59	No front nose	●	1	Smooth	15 - 41	-	top100gr15,0-41,0
						42 - 100	✓	top100gr42,0-100,0

Explanations of the types of clamping surfaces on the previous page.

Clamping head TOP HSW. For machining to size

Size	Total length [mm]	Particularity	Profile	Base bore Ø [mm]	Max. axial drawtube force [kN]	In stock	Order no.
40	47	Soft I.D. and clamping head face	●	8	33	✓	top40hswr8,0
				15		✓	top40hswr15,0
				30		✓	top40hswr30,0
52	42	Soft I.D. and clamping head face	●	8	40	✓	top52hswr8,0
				15		✓	top52hswr15,0
				30		✓	top52hswr30,0
65	49	Soft I.D. and clamping head face	●	5	45	✓	top65hswr5,0
				8		✓	top65hswr8,0
				20		✓	top65hswr20,0
				40		✓	top65hswr40,0
100	59	Soft I.D. and clamping head face	●	15	65	✓	top100hswr15,0
				30		✓	top100hswr30,0
				45		✓	top100hswr45,0
				65		✓	top100hswr65,0
				90		✓	top100hswr90,0

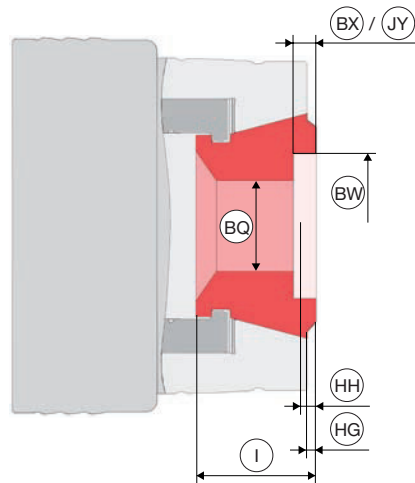
Explanations of the types of clamping surfaces on the previous page.

Loading ring [for clamping head TOP HSW]

Size	In stock	Order no.
40	✓	ar40
52	✓	ar52
65	✓	ar65
100	✓	ar100



Permissible counter bore when manufacturing to order and for HSW clamping heads. Technical data



Size	Capacity	Length	Clamping head protrusion length	Variant 1 [max. turning Ø]				Variant 2 [max. clamping depth]			
				Max. permissible turning Ø	Max. permissible turning depth	Min. turning depth	Min. clamping depth of workpiece	Max. permissible turning Ø	Max. permissible turning depth	Min. turning depth	Min. clamping depth of workpiece
	BQ	I	HG	BW	BX	JY	HH	BW	BX	JY	HH
TOP 40 / TOP 40 HSW	40	47	3	51	14	9	6	42	25	9	6
TOP 40 G	40	44	0					42	22	6	3
TOP 52 / TOP 52 G / TOP 52 HSW	52	42	0	60	12	6,5	3				
TOP 65 / TOP 65 G / TOP 65 HSW	65	49	0	78	10	6,5	3	66	26	6,5	3
TOP 100 / TOP 100 G / TOP 100 HSW	102	59	0	98	20	9	3				
				120	20	16	10				