

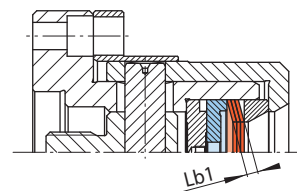
# Clamping Elements Bonded Disc Packs LFF

for customer assembled Bonded Disc Pack Flange Chucks with large component tolerances  
for setup to different clamping diameters within a given size

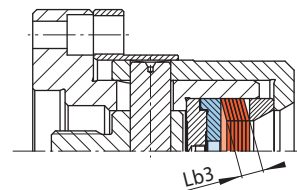
## Key

- d = Seating diameter
- D = Achievable clamping diameter
- $\Delta D$  = Maximum diameter change of the clamping diameter of the Clamping Element
- s = Clamping disc thickness
- n = Number of Clamping Discs (max. 12)
- $Lb_n = s \cdot n$   
= Bonded disc pack width
- $M_n = M_1 \cdot n$   
= Max. transmissible torque
- $Fm_n = Fm_1 \cdot n$   
= Required actuating force for component clamping with pull-back action
- $Fo_n = Fo_1 \cdot n$   
= Required actuating force for component clamping without pull-back action

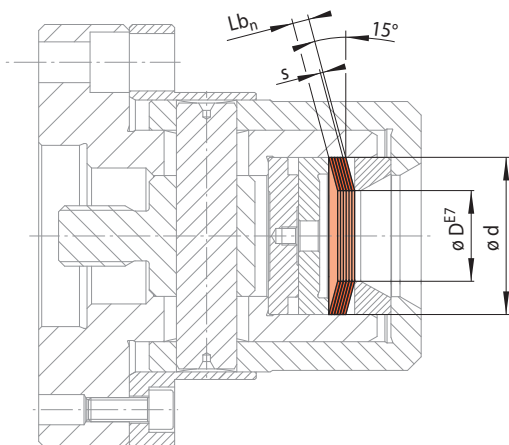
## Installation situations



Bonded disc pack widths Lb1



Bonded disc pack width Lb3



16-1

16-2

Size LFF ...	Clamping Discs LFF							Bonded Disc Packs LFF									
	d mm	D* mm	$\Delta D$ mm	s mm	$M_1$ Nm	$Fm_1$ N	$Fo_1$ N	Art.-No. 1004-	Bonded disc pack width Lb1				Bonded disc pack width Lb3				
									Lb1 mm	$M_n$ Nm	$Fm_n$ N	$Fo_n$ N	Art.-No. 3024-	Lb3 mm	$M_n$ Nm	$Fm_n$ N	$Fo_n$ N
32	10 - 15	0,8	0,9	1,5	800	640	032001	5,4	9	4800	3900	032001	10,8	18	9600	7800	032002
37	15 - 20	0,8	0,9	3,0	1200	960	037001	5,4	18	7200	5800	037001	10,8	36	14400	11600	037002
42	20 - 25	0,8	0,9	5,7	1700	1350	042001	5,4	34	10200	8100	042001	10,8	68	20400	16200	042002
47	25 - 30	0,8	0,9	8,6	2050	1650	047001	5,4	52	12300	9900	047001	10,8	100	24600	19800	047002
52	30 - 35	0,8	0,9	12	2500	2000	052001	5,4	72	15000	12000	052001	10,8	140	30000	24000	052002
57	35 - 40	0,8	0,9	17	3000	2400	057001	5,4	100	18000	14400	057001	10,8	200	36000	28800	057002
62	40 - 45	0,8	0,9	24	3600	2900	062001	5,4	140	21600	17400	062001	10,8	280	43200	34800	062002
70	45 - 50	1,0	1,15	39	5300	4300	070001	6,9	230	31800	25800	070001	13,8	460	63600	51600	070002
80	50 - 55	1,0	1,15	48	5700	4600	080001	6,9	280	34200	27600	080001	13,8	570	68400	55200	080002
80	55 - 60	1,0	1,15	59	6700	5400	080002	6,9	350	40200	32400	080003	13,8	700	80400	64800	080004
90	60 - 65	1,0	1,15	70	7000	5600	090001	6,9	420	42000	33600	090001	13,8	840	84000	67200	090002
	65 - 70	1,0	1,15	84	8000	6500	090002	6,9	500	48000	39000	090003	13,8	1000	96000	78000	090004
100	70 - 75	1,0	1,15	97	8400	6700	100001	6,9	580	50400	40200	100001	13,8	1150	100800	80400	100002
	75 - 80	1,0	1,15	110	9300	7500	100002	6,9	660	55800	45000	100003	13,8	1320	111600	90000	100004
110	80 - 85	1,0	1,15	130	9700	7800	110001	6,9	780	58200	46800	110001	13,8	1550	116400	93600	110002
	85 - 90	1,0	1,15	150	10700	8700	110002	6,9	900	64200	52200	110003	13,8	1800	128400	104400	110004
120	90 - 100	1,0	1,15	150	10000	8000	120001	6,9	900	60000	48000	120001	13,8	1800	120000	96000	120002
140	100 - 115	1,3	1,5	240	14500	11700	140001	9,0	1440	87000	70200	140001	18,0	2880	174000	140400	140002
150	115 - 125	1,3	1,5	330	17500	14500	150001	9,0	1980	105000	87000	150001	18,0	3960	210000	174000	150002
160	125 - 135	1,3	1,5	390	19500	15500	160001	9,0	2340	117000	93000	160001	18,0	4680	234000	186000	160002
170	135 - 145	1,3	1,5	460	21000	17000	170001	9,0	2760	126000	102000	170001	18,0	5520	252000	204000	170002
180	145 - 165	1,3	1,5	540	23000	18500	180001	9,0	3240	138000	111000	180001	18,0	6480	276000	222000	180002
190	155 - 165	1,3	1,5	620	24500	20000	190001	9,0	3720	147000	120000	190001	18,0	7440	294000	240000	190002

\* Clamping diameter from > up to ≤ adjustable to two places after the decimal point

The Bonded Disc Packs LFF have a larger taper angle than the Bonded Disc Packs LAF. This makes it possible to clamp larger component tolerances up to IT14 securely. The achievable true running accuracy is ≤ 0,03 mm. Bonded Disc Packs LFF can also be used in Bonded Disc Pack Flange Chucks. We request that you contact us.

## Example for ordering

Please indicate the size of the Clamping Element, the clamping diameter of your component, including component tolerance, and the desired bonded disc pack width in your order:

Size: LFF 42  
Clamping diameter: 21,47 mm  
Component tolerance: h6  
Bonded disc pack width: 10,8 mm

➔ LFF 42-21,47h6-10,8

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