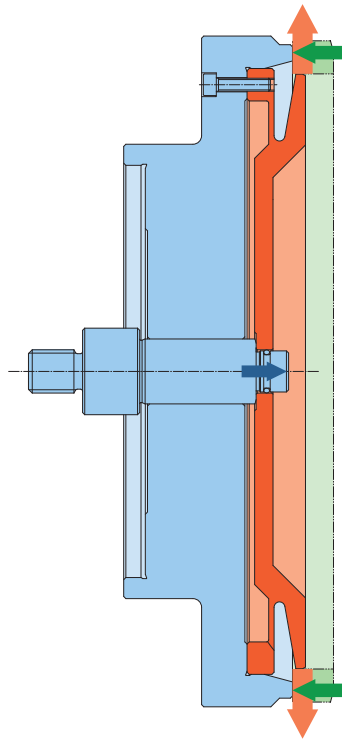


# Clamping principles for customized Clamping Mandrels

## Segmented Diaphragm Clamping Mandrels



Segmented Diaphragm Clamping Mandrel

Key:



Axial actuating force



Radial clamping force



Axial pull-back force

84-1

### Features

- For clamping diameters from 160 mm to 1 600 mm
- True running accuracy  $\leq 0,01$  mm up to clamping diameter of 500 mm
- Very high repeating accuracy  $\leq 0,005$  mm
- Permissible component tolerance up to IT13
- Short clamping fixture length
- Extended insertion depth
- Pull-back possible
- For thin-walled or solid components
- Hand clamping optional possible
- Virtually wear-free due to elastic deformation during the clamping process. Thus guarantees very long service life
- Maximum possible rigidity of the entire machine-tool/clamping-fixture system due to the short clamping fixture length
- Suitable especially for turbine stage clamping

