

Taper Collet Centre Mandrel BKDI

as Complete Clamping Fixture



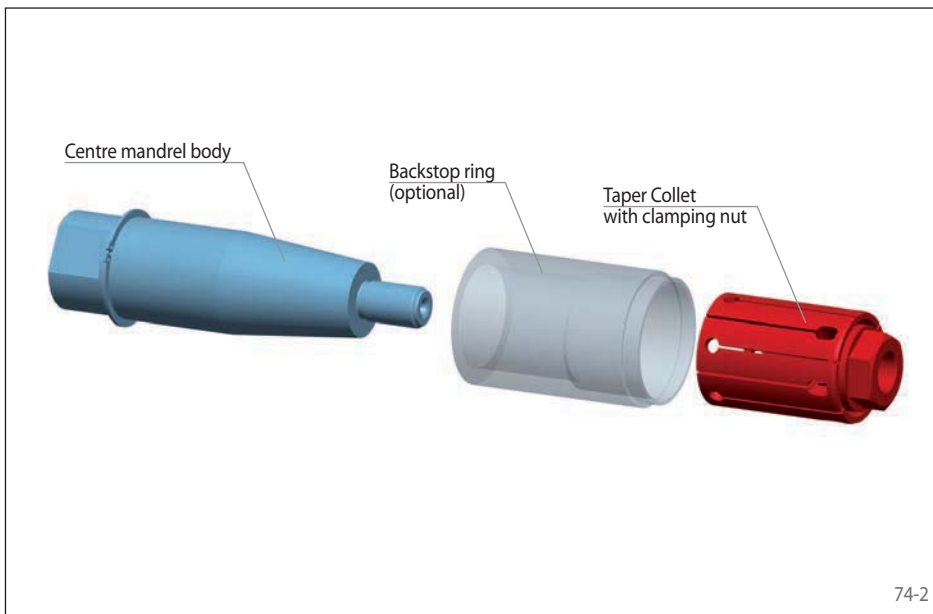
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Features

- For clamping diameters from 11,9 mm to 129,6 mm
- High true running accuracy $\leq 0,01$ mm
- Permissible component tolerance up to IT15
- Pull-back against an optional, individually designed external backstop ring
- For thin-walled or solid components
- For hand clamping

Configuration

The Taper Collet Centre Mandrel consists of a centre mandrel body and a Taper Collet with a clamping nut. A plain ground backstop pin is also available as an option. The Taper Collet Centre Mandrel is mounted between the centring tips. The Taper Collet is activated by turning the clamping nut.

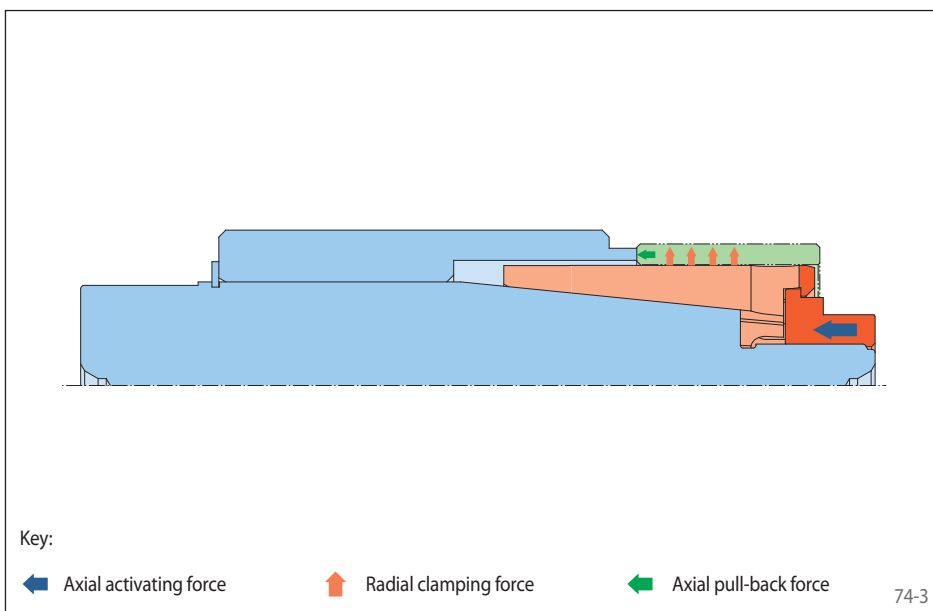


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Clamping principle

For clamping, the Taper Collet is pulled against the centre mandrel body. The component is centred, pressed against the optional backstop and aligned flush.

The cylindrical form of the component bore in the clamping area has to be smaller than the tolerance class IT7, independent of the component bore tolerance.



Key:



Axial activating force



Radial clamping force



Axial pull-back force

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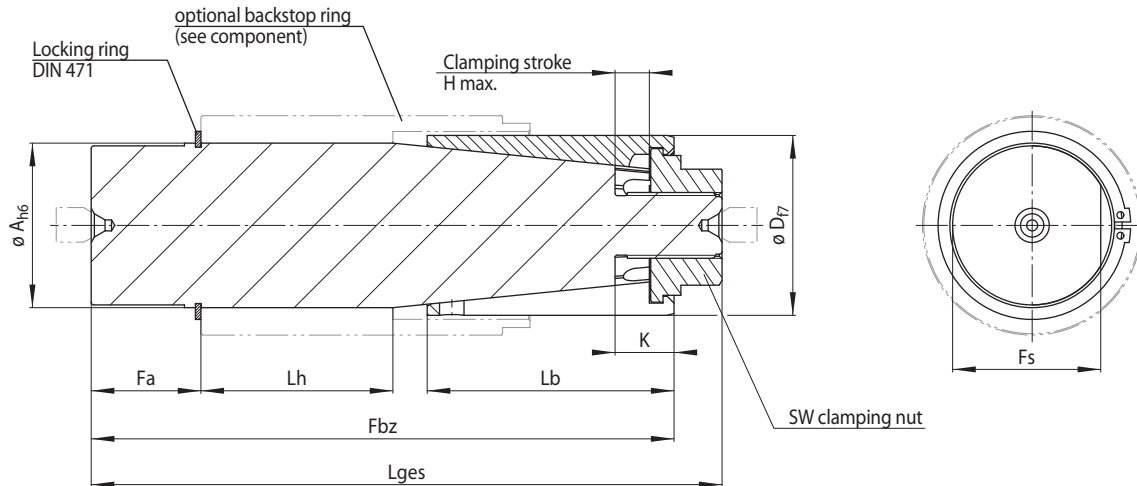
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Size	Clamping range D ¹⁾ mm	Maximum diameter change* Δ D mm	Max. transmissible torque** M Nm	Tightening torque** M _H Nm	A mm	Fa mm	Fbz mm	Fs mm	H max. mm	K mm	Lb mm	Lges mm	Lh mm	SW mm
BKDI 6	11,90 - 15,00	0,6	11	5	11	17,0	70,3	9	3	8	23	77	25,6	11
BKDI 7	14,70 - 20,90	1,2	13	7	14	17,0	83	11	6	11	35	90	25,0	11
BKDI 12	20,70 - 27,90	1,2	44	25	20	21,2	102	17	6	12	45	110	29,8	17
BKDI 18	27,70 - 32,80	1,2	58	37	26	21,2	102	22,5	6	12	45	110	30,8	17
BKDI 19	32,60 - 42,80	1,2	114	67	30	28,5	147	25	6	13	65	160	47,5	27
BKDI 27	42,60 - 51,80	1,2	147	78	39	28,7	147	34	6	13	65	160	47,2	27
BKDI 32	51,60 - 64,00	2,4	273	153	49	39,7	212	43	12	22	90	230	70,2	41
BKDI 43	63,60 - 72,00	2,4	333	175	60	40,0	212	54	12	22	90	230	70,0	41
BKDI 44	71,60 - 82,00	2,4	373	204	66	48,5	277	59	12	22	120	300	96,5	55
BKDI 54	81,60 - 132,00	2,4	424	222	77	48,5	277	68	12	22	120	300	96,5	55

¹⁾ Please note the standard clamping ranges according to the tables on the next pages „Clamping Elements Taper Collets BMD“.

* 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: BKDI 12
Clamping range: 23,70 - 24,90 mm
➔ BKDI 12-23,70-24,90

Insertion depth

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

$$Le_{min.} = K + Lf$$

Customer assembly

The Taper Collets and components shown on pages 76 to 78 are available for customer assembled Taper Collet Centre Mandrels.

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