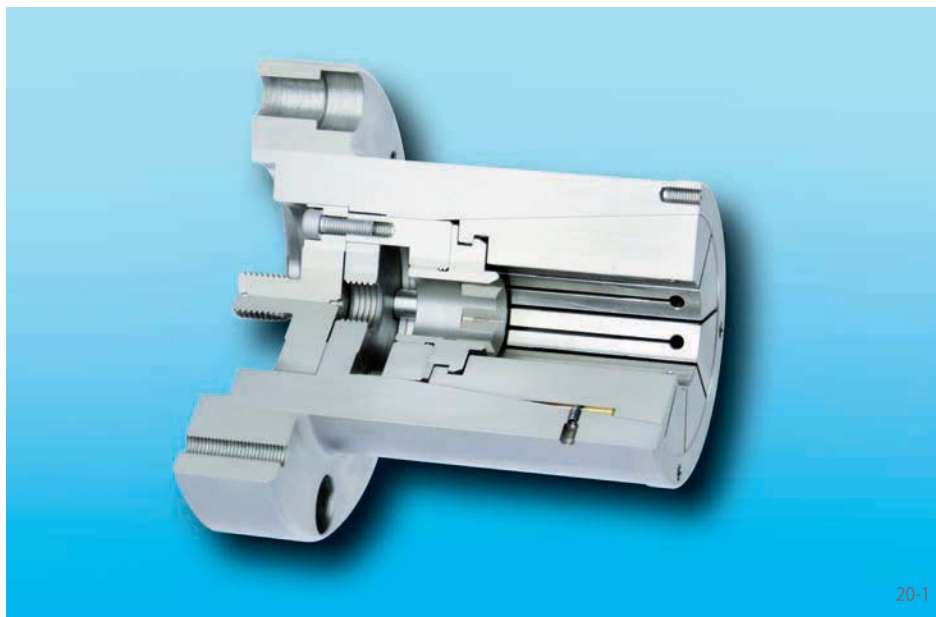


# Taper Collet Flange Chucks BKFF

as Complete Clamping Fixture

**EDMAYR**  
ANTRIEBSTECHNIK



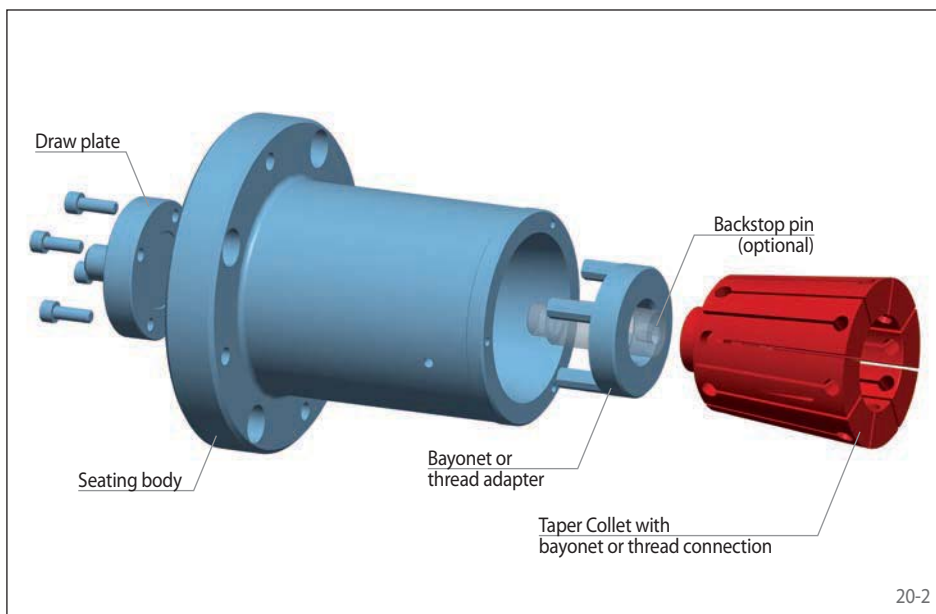
## Features

- For clamping diameters from 7,8 mm to 73,6 mm
- High true running accuracy  $\leq 0,01$  mm
- Permissible component tolerance up to IT15
- Extended insertion depth
- Pull-back against external backstop surface or optional individually designed internal backstop pin
- For thin-walled or solid components

## Configuration

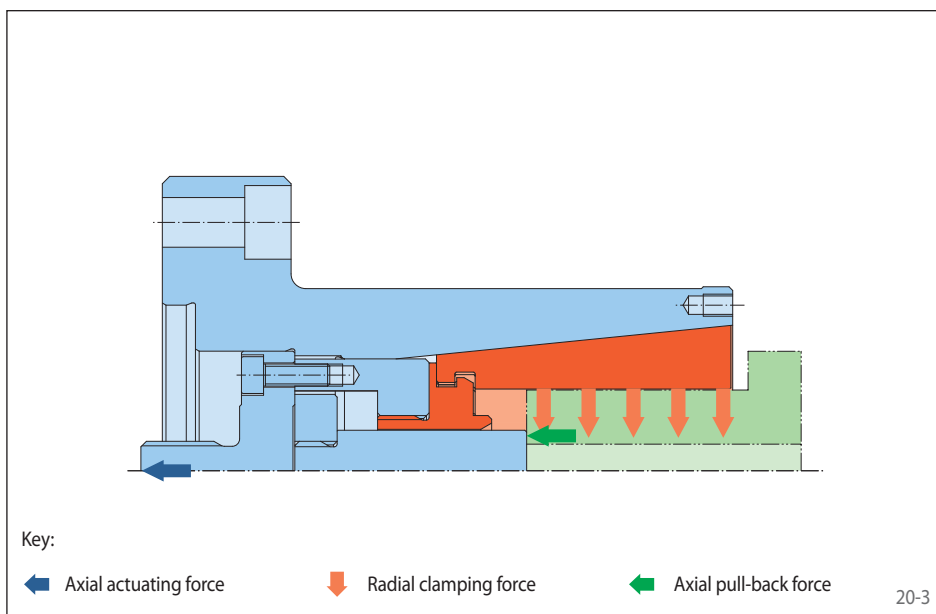
The Taper Collet Flange Chuck consists of a draw plate, a seating body, a bayonet or threaded adapter and a Taper Collet. A backstop pin is also available as an option. Depending on its size, the Taper Collet has a bayonet or threaded connection. It is taken up by the seating body in a form-fitting connection and connected via the bayonet or threaded connection with the bayonet or threaded adapter. The Taper Collet Flange Chuck is attached to the machine with the seating body. The Clamping Fixture is actuated by the draw plate, which is connected to the machine power actuating unit.

Intermediate Flanges and Spring Force Actuators are shown starting on page 86.



## Clamping principle

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



Key:

← Axial actuating force

↓ Radial clamping force

→ Axial pull-back force

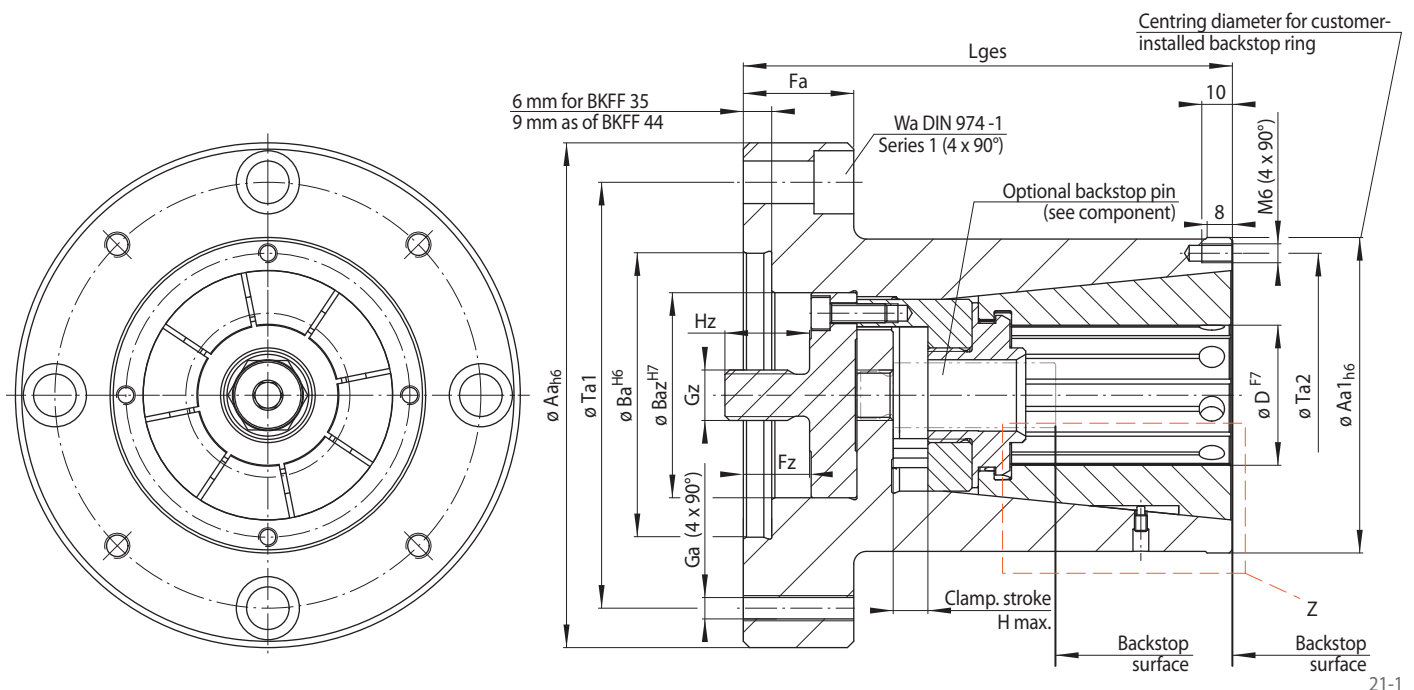
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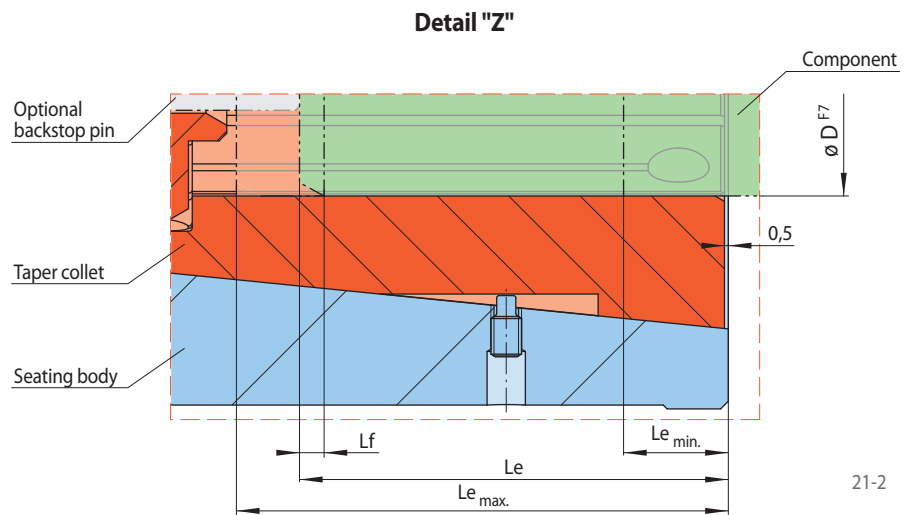
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## Insertion depth Le

The minimum insertion depth  $Le_{min.}$  is measured from the face of the seating body and derived according to the following formula from the length of the chamfer  $Lf$  of the component and the constant  $K$ :

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



Size	Clamping range	Maximum diameter change*	Max. transmissible torque**	Max. Actuating force**	Aa	Aa1	Ba	Baz	Fa	Fz	Ga	Gz	H max.	Hz	K	Le max. <sup>3)</sup>	Lges	Ta1	Ta2	Wa
	D <sup>1)</sup> mm	Δ D mm	M <sup>2)</sup> Nm	F N	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
BKFF 35	7,20 - 14,60	0,6	10 - 20	8500	90	55	50	27	20	10	M 6	M 10	3,5	14	9,5	39,5	93,5	70	45	8
BKFF 44	14,40 - 23,60	0,8	27 - 42	11000	120	70	60	50	30	19	M 8	M 16	5,0	18	12,5	40,5	110	95	60	10
BKFF 56	23,40 - 33,60	1,2	63 - 87	16000	120	75	60	50	30	19	M 8	M 16	7,0	18	21,5	44,5	119	95	65	10
BKFF 79	33,40 - 51,60	2,0	158 - 234	28000	160	100	90	65	35	21	M 8	M 16	11,0	22	25,5	64,5	155	135	90	12
BKFF 110	51,40 - 73,60	2,4	346 - 479	40000	200	135	125	90	35	22,5	M 8	M 20	13,0	28	29,5	88,5	190	175	125	12

\* of the clamping diameter of the Clamping Element. \*\* for clamping with pull-back action.

<sup>1)</sup> Please note the standard clamping ranges according to the table on the next page „Clamping Elements Taper Collets BKFF“.

<sup>2)</sup> The lower value refers to the smallest clamping diameter of the respective size, the higher value to the largest. For values between the two see the table "Taper Collet Clamping Elements" on page 22.

<sup>3)</sup> Maximum insertion depth (corresponds to clamping length)

## Example for ordering

Please indicate the size of the Clamping Fixture and the clamping range of the requested Taper Collet, in your order:

Size: BKFF 35  
Clamping range: 9,60 - 10,20 mm  
➔ BKFF 79-9,60-10,20

## Customer assembly

The Taper Collets and components shown on pages 22 to 25 are available for customer assembled Taper Collet Flange Chucks.