

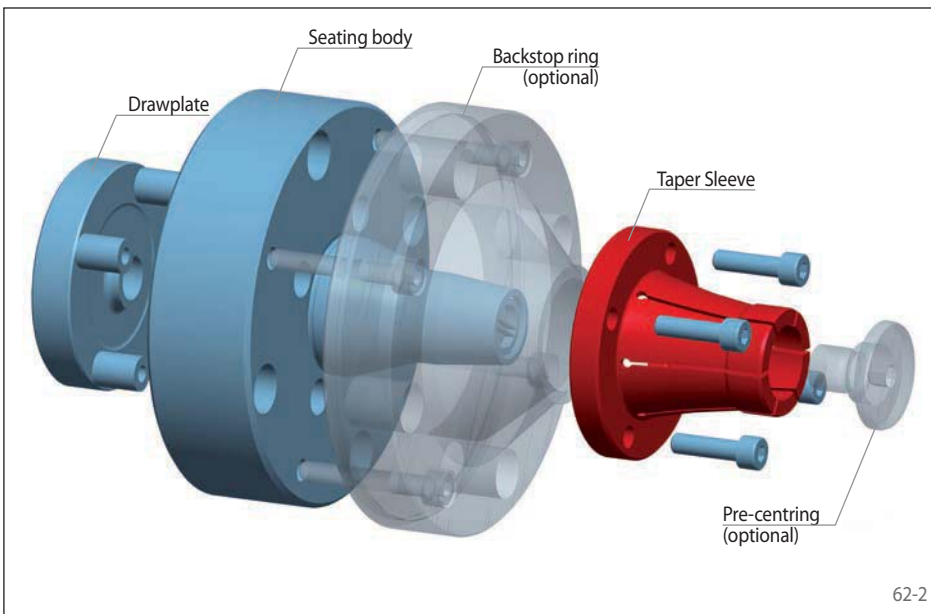
# Taper Sleeve Flange Mandrels HKDF

as Complete Clamping Fixture



## Features

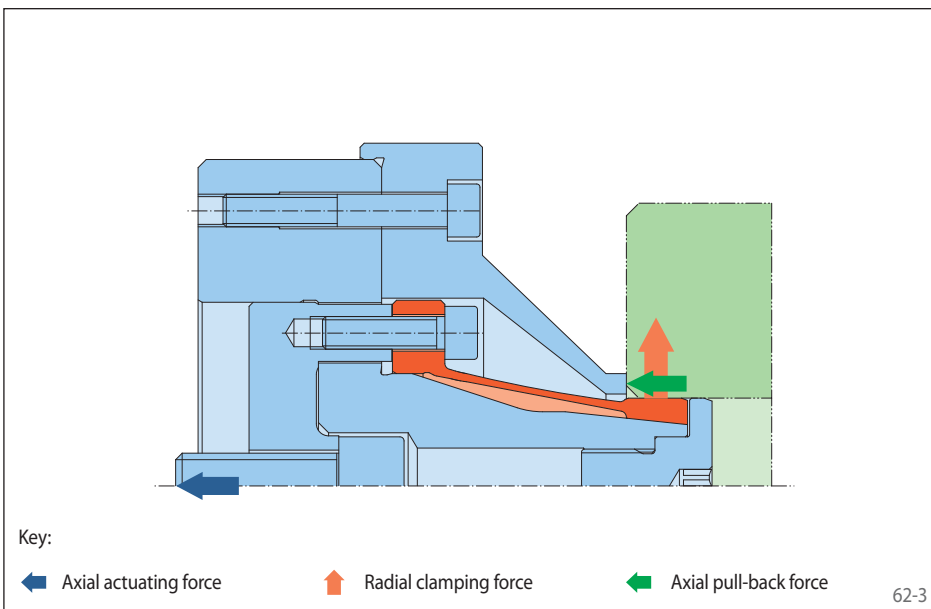
- For clamping diameters from 9 mm to 175 mm
- High true running accuracy  $\leq 0,01$  mm
- Permissible component tolerance up to IT13
- Pull-back against external backstop surface or optional, individually designed external backstop ring
- Impervious to ingress of foreign objects due to the rubberized slots in the Taper Sleeve



## Configuration

The Taper Sleeve Flange Mandrel consists of a draw plate, a seating body and a Taper Sleeve. A backstop ring and a pre-centring are optionally available. The Taper Sleeve Flange Mandrel 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

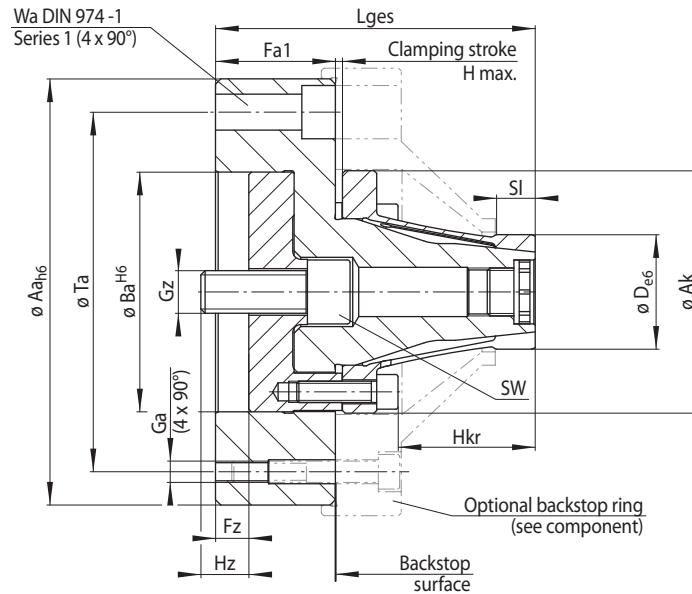
For clamping, the Taper Sleeve is pulled against the seating body. The component is centred, pressed against the backstop and aligned flush.

Key:

- ← Axial actuating force      ↑ Radial clamping force      ← Axial pull-back force

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Size	Achievable clamping diameter D* mm	Maximum diameter change** Δ D mm	Max. transmissible torque*** M Nm	Max. Actuating force*** F N	Aa mm	Ak mm	Ba mm	Fa1 mm	Fz mm	Ga mm	Gz mm	H max. mm	Hkr mm	Hz mm	Lges mm	SI mm	SW mm	Ta mm	Wa mm
HKDF 4	9 - 16	0,5	6,5	8000	90	51	50	36	14	M 6	M 12	2,7	36,5	14	92	6,5	-	70	8
HKDF 6	15 - 20	0,5	10	9000	90	51	50	36	14	M 6	M 12	2,7	36,5	14	92	8,5	-	70	8
HKDF 7	19 - 26	0,5	12	9000	90	51	50	36	14	M 6	M 12	2,7	36,5	14	92	9,5	-	70	8
HKDF 12	25 - 32	0,5	22	10000	90	51	50	36	14	M 6	M 12	2,7	38,5	14	95	9,5	-	70	8
HKDF 19	31 - 44	0,5	55	16000	120	61	60	49	19	M 8	M 16	2,7	47,5	18	118	14,5	-	95	10
HKDF 30	43 - 55	0,5	158	30000	160	91	90	45	12,5	M 8	M 16	2,8	51,5	18	120	14,5	14	135	12
HKDF 40	54 - 76	0,5	278	40000	160	91	90	45	12,5	M 8	M 16	2,8	61,5	18	130	14,5	14	135	12
HKDF 60	75 - 100	0,5	613	60000	185	126	125	57	12,5	M 8	M 20	2,9	58,5	20	143	14,5	17	160	12
HKDF 80	100 - 125	0,8	1050	80000	250	170	175	68	15	M 8	M 20	4,5	68	22	172,5	19,5	17	225	12
HKDF 100	125 - 150	0,8	1300	80000	250	170	175	68	15	M 8	M 20	4,5	68	22	172,5	19,5	17	225	12
HKDF 125	150 - 175	1,0	2050	100000	275	200	200	73	15,5	M 8	M 20	5,0	75	27	188	24,5	17	250	12

\* Clamping diameter adjustable to two places after the decimal point. \*\* 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 diameter of your component, including component tolerance, in your order:

Size: HKDF 30  
Clamping diameter: 50,47 mm  
Component tolerance: H7

➔ HKDF 30-50,47H7

## Customer assembly

The Taper Sleeves and components shown on pages 64 to 67 are available for customer assembled Taper Sleeve Flange Mandrel.

