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专业智能柔性橡胶夹头&夹具的提供者

Professional intelligent flexible rubberchuck & fixture provider

柔性夹具夹持方案工程服务推广者

Flexible fixture gripping project service promoter



橡胶夹具

Rubber Collets

设计 / 生产 / 销售

Design / Production / Sale

Guangzhou CN CNC TOOLS Co., Ltd

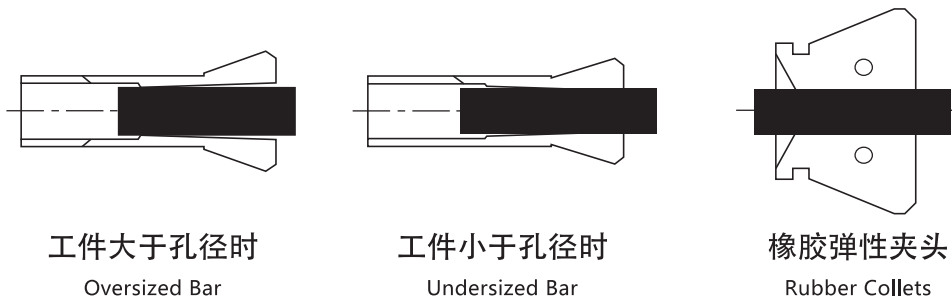
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橡胶弹性夹头

由于其独特的设计和灵活的弹性，使其夹持力是传统全钢开槽夹头的2-3倍。无论工件尺寸大小，夹紧力总是平行而又均匀地分布在工件上，而不是集中在夹头工作孔的前后两端。而传统的全钢夹头就经常出现这样的问题（如下图所示）。夹块间的材料是耐用的合成橡胶化合物，通过硫化夹块的表面和通孔紧密地连接在一起。相比传统弹簧夹头的结构，其不受高温、冷却液和铁屑介入的影响，并能在其使用寿命期间保持足够的灵活性。

Rubber-elastic collets unique in design and operation, the rubber-elastic collets can generate two to three times the gripping power of a conventional split-steel collets. Gripping force is uniform and parallel throughout the collets contact length and not concentrated at the nose or back as is frequently the case with split-steel collets. Construction is of durable synthetic rubber compound permanently bonded to hardened steel jaw insert surfaces and through-holes. It is unaffected by heat, coolants and cutting compounds and retains its flexibility over a long service life as compared to spring tempered metal designs.



工件大于孔径时

Oversized Bar

工件小于孔径时

Undersized Bar

橡胶弹性夹头

Rubber Collets

橡胶弹性夹头 VS 普通弹簧夹头

普通弹簧夹头只有在等径夹持时才能获得最大夹持力。当工件大于或小于孔径时，工件的受力点就会失去平衡，这会大大降低夹持的力度和精度。而橡胶弹性夹头不管工件的外径偏差多大，都会均匀的与夹头接触承平衡的夹持力。

Rubber-elastic collets VS conventional collets

Conventional split-steel collets provide maximum gripping efficiency only at actual bored or nominal capacity. They lose parallelism when chucking bars even a few thousandths over or under this capacity. This significantly reduces gripping strength and accuracy. Rubber-elastic collets exert uniform gripping pressure throughout the collets contact length regardless of bar tolerance deviations.

特点

- 每一个夹块都会对工件表面施加均匀、精确的夹持力，其夹持力是普通弹簧夹头的3倍。
- 耐用合成橡胶的一体式结构，保证其灵活性，并能抵制铁屑、冷却液的腐蚀。
- 夹块为一体成形磨削而成，其具更大的硬度和耐磨性，故夹持的刚性、精度是普通弹簧夹头所无法比拟的。
- 橡胶夹头可以密封工件与机器主轴免受磨料和切屑的损伤。可以作为止水夹头使用，防止冷却液的外溢。
- 夹头硬度HRC58-60，且经过深冷处理，提高产品精度稳定性。旋转跳动精度 $\leq 10\mu$,夹持范围 $\pm 0.5\text{mm}$

FEATURES

- Parallel jaw insert surfaces exert uniform, accurate gripping force up to three times greater than can be achieved with split-steel collets.
- Durable one-piece construction. Synthetic rubber retains flexibility and resists deterioration from heat, coolants and cutting compounds.
- Steel jaw inserts precision ground to assure maximum gripping accuracy. Hardened for greater wear resistance than split steel collets.
- Seal collets and machine spindle to protect from abrasive particles and sward. Automatically seals tool O.D. to permit coolant flow through tool reducing wear.
- Steel jaw hardness HRC58-62, through cryogenic treatment to improve product stability. Runout tolerance $\leq 10\mu$, Clamping tolerance nominal diameter $\pm 0.5\text{mm}$



外卡橡胶夹头
External clamping rubber collet



内涨橡胶夹头
bore clamping rubber collet



非标橡胶夹头
Non-standard clamping rubber collet



外卡夹具本体
External clamp fixture body



内涨夹具本体
bore clamp fixture body



夹具解决方案
Fixture solution

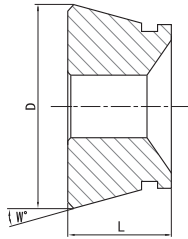
SK系列外卡橡胶夹头

SK series rubber collet



橡胶夹具
Rubber Collets

SK系列夹固头 SK series Rubber- elastic collets



► Rubber Collets SK32

规格 type	D mm	L mm	W	夹持范围 Clamping dia.	光孔 Smooth	径向槽 serrated	径向槽和轴向槽 Double serrated
SK32S	57.7	44	12	6-32	6-32	--	--
SK32N	57.7	49	12	6-32	--	8-11	12-32

► Rubber Collets SK42

规格 type	D mm	L mm	W	夹持范围 Clamping dia.	光孔 Smooth	径向槽 serrated	径向槽和轴向槽 Double serrated
SK42S	79.3	42	15	6-42	6-42	--	--
SK42N	79.3	47	15	6-42	--	8-11	12-42

► Rubber Collets SK52

规格 type	D mm	L mm	W	夹持范围 Clamping dia.	光孔 Smooth	径向槽 serrated	径向槽和轴向槽 Double serrated
SK52S	79.2	46	15	6-52	6-52	--	--
SK52N	79.2	46	15	6-52	--	8-11	12-52

► Rubber Collets SK65

规格 type	D mm	L mm	W	夹持范围 Clamping dia.	光孔 Smooth	径向槽 serrated	径向槽和轴向槽 Double serrated
SK65S	99.5	53	15	6-65	6-65	--	--
SK65N	99.5	58	15	6-65	--	8-11	12-65

► Rubber Collets SK80

规格 type	D mm	L mm	W	夹持范围 Clamping dia.	光孔 Smooth	径向槽 serrated	径向槽和轴向槽 Double serrated
SK80S	114.5	53	15	16-80	16-80	--	--
SK80N	114.5	53	15	16-80	--	--	16-80

► Rubber Collets SK100

规格 type	D mm	L mm	W	夹持范围 Clamping dia.	光孔 Smooth	径向槽 serrated	径向槽和轴向槽 Double serrated
SK100S	144.5	59	15	40-100	40-100	--	--
SK100N	144.5	59	15	40-100	--	--	40-100

► Rubber Collets SK120

规格 type	D mm	L mm	W	夹持范围 Clamping dia.	光孔 Smooth	径向槽 serrated	径向槽和轴向槽 Double serrated
SK120S	180	61	15	70-120	70-120	--	--
SK120N	180	61	15	70-120	--	--	70-120

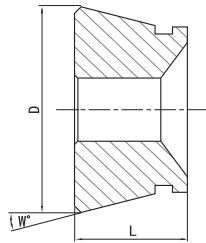


橡胶夹具
Rubber Collets

NK/EK系列外卡橡胶夹头

NK/EK series rubber collet

NK系列夹固头 NK series Rubber- elastic collets



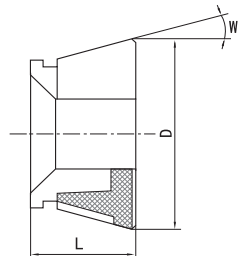
► Rubber Collets NK60

规格 type	D mm	L mm	W	夹持范围 Clamping dia.	光孔 Smooth	径向槽 serrated	径向槽和轴向槽 Double serrated
NK60S	59	30	15	6-30	6-30	--	--
NK60N	59	30	15	8-30	--	8-11	12-30

► Rubber Collets NK105

规格 type	D mm	L mm	W	夹持范围 Clamping dia.	光孔 Smooth	径向槽 serrated	径向槽和轴向槽 Double serrated
NK105S	104	40	15	6-42	6-42	--	--
NK105N	104	40	15	6-42	--	8-11	12-42

EK系列夹固头 EK series Rubber- elastic collets



► Rubber Collets EK68

规格 type	D mm	L mm	W	夹持范围 Clamping dia.	光孔 Smooth	径向槽 serrated	径向槽和轴向槽 Double serrated
EK68S	68	37	15	6-32	6-32	--	--
EK68N	68	37	15	6-32	--	8-11	12-32

► Rubber Collets EK93

规格 type	D mm	L mm	W	夹持范围 Clamping dia.	光孔 Smooth	径向槽 serrated	径向槽和轴向槽 Double serrated
EK93S	93	50	15	16-52	16-52	--	--
EK93N	93	50	15	16-52	--	--	16-52

► Rubber Collets EK110

规格 type	D mm	L mm	W	夹持范围 Clamping dia.	光孔 Smooth	径向槽 serrated	径向槽和轴向槽 Double serrated
EK110S	110	60	15	20-66	20-66	--	--
EK110N	110	60	15	20-66	--	--	20-66

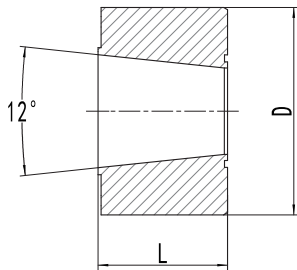
HRHK系列橡胶夹头

HRHK series rubber collet



橡胶夹具
Rubber Collets

HRHK系列橡胶夹头 HRHK Series Rubbre-elastic collets



► Rubbre-elastic collets HRHK1000

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHK1000	12°	3	6	20-28	24	±0.25	HRHK1000-D(20-28)

► Rubbre-elastic collets HRHK1100

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHK1100	12°	3	6	26-38	28	±0.25	HRHK1100-D(26-38)

► Rubbre-elastic collets HRHK1200

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHK1200	12°	6	6	36-54	44	±0.35	HRHK1200-D(36-54)

► Rubbre-elastic collets HRHK1300

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHK1300	12°	6	8	50-80	50	±0.35	HRHK1300-D(50-80)

► Rubbre-elastic collets HRHK1400

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHK1400	12°	6	10	75-120	60	±0.40	HRHK1400-D(75-120)

► Rubbre-elastic collets HRHK1500

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHK1500	12°	6	10	100-130	78	±0.50	HRHK1500-D(100-130)

► Rubbre-elastic collets HRHK1600

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHK1600	12°	6	10	130-160	86	±0.50	HRHK1600-D(130-160)

► Rubbre-elastic collets HRHK1700

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHK1700	12°	8	12	160-200	91	±0.50	HRHK1700-D(160-200)

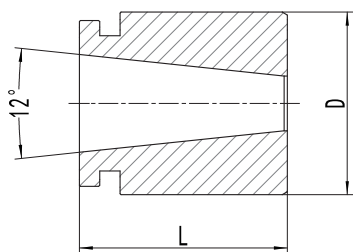


橡胶夹具
Rubber Collets

HRHJ系列橡胶夹头

HRHJ series rubber collet

HRHJ系列橡胶夹头 HRHJ Series Rubbre-elastic collets



▶ Rubbre-elastic collets HRHJ2000X

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHJ2000X	12°	3	6	16-21	31	±0.25	HRHJ2000X-D(16-21)

▶ Rubbre-elastic collets HRHJ2000

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHJ2000	12°	3	4	20-28	41	±0.25	HRHJ2000-D(20-28)

▶ Rubbre-elastic collets HRHJ2100

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHJ2100	12°	3	6	26-38	46	±0.35	HRHJ2100-D(26-38)

▶ Rubbre-elastic collets HRHJ2200

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHJ2200	12°	6	6	36-54	61.5	±0.35	HRHJ2200-D(36-54)

▶ Rubbre-elastic collets HRHJ2300

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHJ2300	12°	6	8	50-80	67.5	±0.40	HRHJ2300-D(50-80)

▶ Rubbre-elastic collets HRHJ2400

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHJ2400	12°	6	10	69-100	76	±0.50	HRHJ2400-D(69-100)

▶ Rubbre-elastic collets HRHJ2500

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHJ2500	12°	6	12	100-130	85	±0.50	HRHJ2500-D(100-130)

▶ Rubbre-elastic collets HRHJ2600

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHJ2600	12°	8	12	130-160	94.5	±0.50	HRHJ2600-D(130-160)

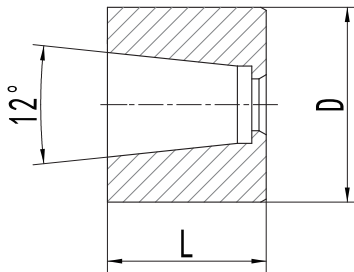
HRHN系列橡胶夹头

HRHN series rubber collet



橡胶夹具
Rubber Collets

HRHN系列橡胶夹头 HRHN Series Rubbre-elastic collets



▶ Rubbre-elastic collets HRHN3000

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHN3000	12°	3	4	20-28	24	±0.25	HRHN3000-D(20-28)

▶ Rubbre-elastic collets HRHN3100

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHN3100	12°	3	6	26-38	28	±0.25	HRHN3100-D(28-38)

▶ Rubbre-elastic collets HRHN3200

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHN3200	12°	6	6	36-54	44	±0.25	HRHN3200-D(36-54)

▶ Rubbre-elastic collets HRHN3300

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHN3300	12°	6	8	50-80	50	±0.35	HRHN3300-D(50-80)

▶ Rubbre-elastic collets HRHN3400

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHN3400	12°	6	10	70-120	60	±0.40	HRHN3400-D(70-120)

▶ Rubbre-elastic collets HRHN3500

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHN3500	12°	6	10	100-130	78	±0.50	HRHN3500-D(100-130)

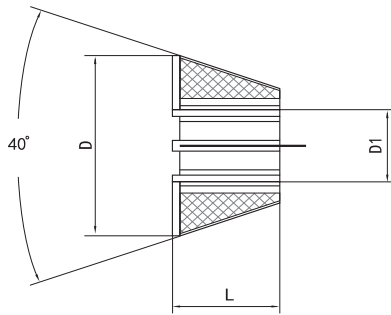
▶ Rubbre-elastic collets HRHN3600

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHN3600	12°	6	10	130-160	86	±0.50	HRHN3600-D(130-160)

▶ Rubbre-elastic collets HRHN3700

规格 type	锥度 Taper	开槽数 Slot	槽宽(mm) Groove width	D夹持范围 (mm) Clamping dia.	L(mm) Length	夹持行程 (mm) Clamping stroke	选型备注 Model selection
HRHN3700	12°	8	12	160-200	91	±0.50	HRHN3700-D(160-200)

JK系列夹固头 JK series Rubber- elastic collets



▶ Rubber Collets JSN7

规格 type	D mm	L mm	D1 mm	夹持范围 Clamping dia.
JSN7	15.7	11	4.5	2.5-4.5
			6.5	4.5-6.5

▶ Rubber Collets JSN12

规格 type	D mm	L mm	D1 mm	夹持范围 Clamping dia.
JSN12	21.8	13	7	4-7
			10	7-10

▶ Rubber Collets JSN20

规格 type	D mm	L mm	D1 mm	夹持范围 Clamping dia.
JSN20	26.9	15	9	5.4-9
			14	9-14
			16	14-16

设计定制非标涨套 Design/Customize non-standard sets

用户可来样、来图订制非标夹具。

Users can sample ,to map customized nonstandard fixture.



非标橡胶夹头

Non-standard rubber collet



橡胶夹具
Rubber Collets



四方：Square



六方：Hexagonal



花键：Spline



镶合金
Inserted alloy block



非标夹头选型示例
Example of non-standard collet selection



台阶孔：
Anomaly stepped bore



自车型：Turning type



异型：Heterotype

1.SK系列非标外卡橡胶夹头型号 SK Series of non-standard rubber collet Type

型号 (Type)	规格 (Specification)	备注 (Remark)
四方：square	SK (32/42/52/65/80) -SQU-Dim	
六方：hexagonal	SK (32/42/52/65/80) -HEX-Dim	
花键：spline	SK (32/42/52/65/80) -SPL-Dim	
台阶孔：Anomaly stepped bore	SK (32/42/52/65/80) -ANSB-Dim	
异型：heterotype	SK (32/42/52/65/80) -HET-Dim	
镶合金 inserted alloy block	SK (32/42/52/65/80) -INAB-Dim	
自车型：Turning type	SK (32/42/52/65/80) -TUPE-Dim	



橡胶夹具
Rubber Collets

自车型橡胶夹头 Turning type rubber collet

2.SK系列自车型外卡橡胶夹头型号 SK Series of Turning type rubber collet Type

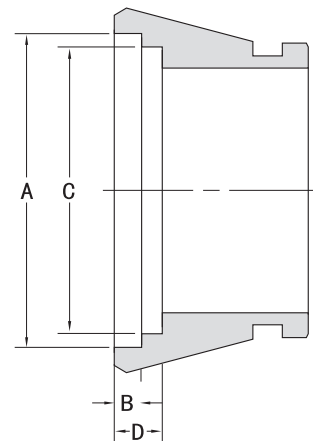
型号 (Type)	A	B	C	D	备注 (Remark)
SK32	50	4	45	7	
SK42	63	7	60	10	
SK52	63	7	60	10	
SK65	86	7	77	13	
SK80	101	7	92	13	
SK100	128	7	113	20	
SK120	145	7	125	16	

与夹具体接触部分硬度很高，夹持工件的面是软的，可以使用设备加工，统称自车型夹头，SK52- Φ 10TUPE，这个规格表示SK系列， Φ 10内孔的自车型夹头。

Contact with clip specific part hardness is very high, clamping workpiece surface is soft, you can use the equipment processing, collectively the models chuck, SK52- Φ 10 tupe , SK series, the specification of chuck Φ 10 inner hole of the model.



自车范围
Turning range



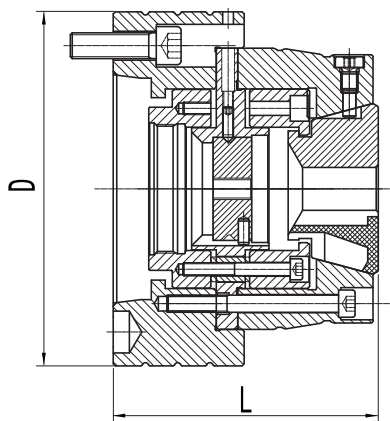
外卡橡胶夹具

External clamping rubber collet fixture



橡胶夹具
Rubber Collets

外卡夹具本体 External clamp mode



NEW

特点 (Characteristic)

- 1.系列化夹具体，后拉式平行夹紧
Serialization clamp concrete,pull back tepe parallel clamp
- 2.标配机床通用接口
Standard machine tool universal interface
- 3.更换不同孔径夹头简单，快速，方便
It is simple, fast and convenient to replace chuck with different orifice sizes
- 4.径向跳动精度0.01mm以内（型号差异）
Radial run-out accuracy within 0.01mm(Model difference)
- 5.本体锥度孔端面可增加轴向定位
Axial positioning can be added to the end face of the taper hole of the bady
- 6.配备气密检测功能
Equipped with air-tightness detectionfunction

中心出水
气密检测

1	基本参数 Basic data	SK32 本体 SK32 model	SK42 本体 SK42 model	SK52 本体 SK52 model	SK65 本体 SK65 model	SK80 本体 SK80 model	SK100 本体 SK100 model	SK120 本体 SK120 model
2	夹紧范围 (mm) Clamping Dia	6-32	6-42	6-52	6-65	16-80	40-100	70-120
3	精度 (mm) Accuracy	0.01	0.01	0.01	0.01	0.01	0.015	0.015
4	夹紧力 (KN) Clamp forc	60	70	80	90	110	135	155
5	最大转速(r/min) MAX RPM	6500	6500	6000	5500	4500	4500	4000
6	总长(mm)L Length	125	125	130	130	135	140	155
7	外径 (mm)D Exterhal Dia	122	145	165	165	180	200	235
8	拉紧螺纹 Thread	M44-M60	M50-M72	M55-M85	M72-M105	M72-M105	M84-M105	M84-M140



橡胶夹具
Rubber Collets

外卡橡胶夹具

External clamping rubber collet fixture

外卡夹具体选型 External clamp model selection

外卡 External clamp	夹头系列 Collet series	夹持外圆 Clamping diameter	中通/轴向定位 ZT/ZXD	机床接口 (Spindle nose)	拉紧螺纹 (Taut thread)
WK	SK32 SK42 SK52 SK65 SK80 SK100	Φ__	ZT ZXD ZXL	A2-4 A2-5 A2-6 A2-8 A2-11 其他	拉杆螺纹 W/N

WK	外卡(External clamp)
SK32~SK100	夹头系列代号(Colletl series code)
Φ__	夹持直径Φ__ (clamp dim Φ__)
ZT/ZXD	中通/轴向定位/轴向零移位 (ZT/ZXD/ZXL)
A2-4~其他	车床主轴鼻端A2-4~A2-11/其他接口 (Lathe spindle nose A2-4 ~ A2-11 / other interfaces)
拉杆螺纹W/N	拉紧夹具的螺纹规格, W外螺纹/N内螺纹 Thread specification for tension clamps, W external thread /N internal thread

选型示例: WKSK32-Φ 15.0-ZT-A2-6-M44*1.5W

Selection of the sample: WKSK32-Φ 15.0-ZT-A2-6-M44*1.5W

外卡SK32夹持外圆Φ 15.0中通卡盘, 机床接口A2-6, 拉杆螺纹M44*1.5外螺纹

External clamp SK32 clamping cylindrical Φ 15.0 zhongtong chuck,

machine tool interface A2-6, tie rod thread M44 * 1.5 outside

★ 详情咨询涵锐技术人员

Consult our technical staff for details

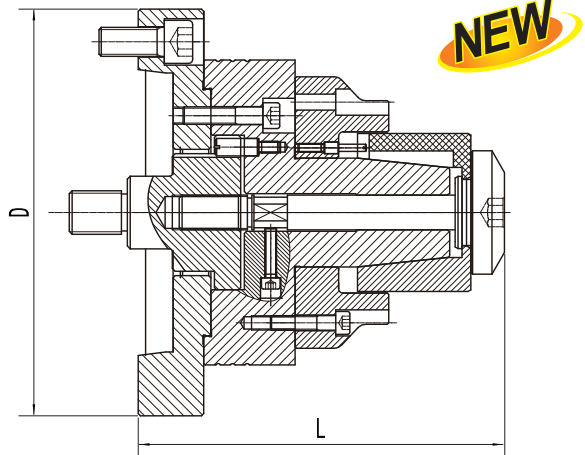
内涨橡胶夹具

Bore clamping rubber collet fixture



橡胶夹具
Rubber Collets

内涨夹具本体 Bore clamp Mandrel



特点 (Characteristic)

1.系列化夹具体，后拉式平行夹紧

Serialization clamp concrete,pull back tepe parallel clamp

2.标配机床通用接口

Standard machine tool universal interface

3.更换不同孔径夹头简单，快速，方便

It is simple, fast and convenient to replace chuck with different orifice sizes

4.径向跳动精度0.01mm以内（型号差异）

Radial run-out accuracy within 0.01mm(Model difference)

5.本体锥度孔端面可增加轴向定位

Axial positioning can be added to the end face of the taper hole of the bady

6.配备气密检测功能

Equipped with air-tightness detectionfunction



1	基本参数 Basic data	0# 本体 0# mandrel	1# 本体 1# mandrel	2# 本体 2# mandrel	3# 本体 3# mandrel	4# 本体 4# mandrel	5# 本体 5# mandrel	6# 本体 6# mandrel	7# 本体 7# mandrel
2	夹紧范围 (mm) Clamping Dia	20-28	25-38	35-55	50-85	75-135	100-130	135-165	165-200
3	精度 (mm) Accuracy	0.01	0.01	0.01	0.012	0.012	0.012	0.015	0.015
4	夹紧力 (KN) Clamp forc	42	42	85	105	125	145	165	175
5	最大转速(r/min) MAX RPM	6500	6500	6000	5500	4500	4500	4000	4000
6	总长(mm)L Length	137	148	154	170	180	200	200	235
7	外径 (mm)D Exterhal Dia	140	140	140	140	165	230	230	230
8	拉紧螺纹 Thread	M44-M60	M44-M60	M44-M60	M44-M60	M60-M100	M60-M100	M60-M100	M60-M100



橡胶夹具
Rubber Collets

内涨橡胶夹具

Bore clamping rubber collet fixture

内涨夹具体选型 Bore clamp fixture body model selection

内涨 Bore clamp fixture	芯轴系列 Mandrel series	夹持孔径 Clamping diameter	压涨套/拉涨套/卡涨套 HRHK/HRHJ/HRHN	机床接口 (Spindle nose)	拉紧螺纹 (Taut thread)
NZ	00# 0# 1# 2# 3# 5# 6# 7#	Φ__	HRHK HRHJ HRHN	A2-4 A2-5 A2-6 A2-8 A2-11 其他	拉杆螺纹 W/N

NZ	内涨 (Bore clamp fixture)
00#~7#	芯轴系列代号 (Mandrel series code)
Φ__	内涨孔径Φ__ (clamp dim Φ__)
HRHK/HRHJ/HRHN	压涨套/拉涨套/卡涨套 (HRHK/HRHJ/HRHN)
A2-4~其他	车床主轴鼻端A2-4~A2-11/其他接口 (Lathe spindle nose A2-4 ~ A2-11 / other interfaces)
拉杆螺纹W/N	拉紧夹具的螺纹规格, W外螺纹/N内螺纹 Thread specification for tension clamps, W external thread /N internal thread

选型示例: NZ0#-Φ21.0-HRHK-A2-6-M44*1.5W

Selection of the sample: NZ0#-Φ21.0-HRHK-A2-6-M44*1.5W

内涨0#芯轴撑内孔直径Φ21.0压涨套卡盘, 机床接口A2-6, 拉杆螺纹M44*1.5外螺纹

Bore clamp 0 # spindle support inner hole diameter Φ 21.0 account set of chuck,
machine tool interface A2-6, tie rod thread M44 * 1.5 outside

★ 详情咨询涵锐技术人员

Consult our technical staff for details

夹持解决方案

Clamping solution



橡胶夹具
Rubber Collets

外卡夹持解决方案 External clamping solution



法兰加长型外卡夹具

Flange extension type
(External clamping fixture)



轴向定位型外卡夹具

With axial locating seat
(External clamping fixture)



薄壳体外卡夹具

Thin shell
(External clamping fixture)

内涨夹持解决方案 Bore clamping solution



内涨夹具体

Bore clamping fixture



前置定位内涨夹具

Front position
(Bore clamping fixture)



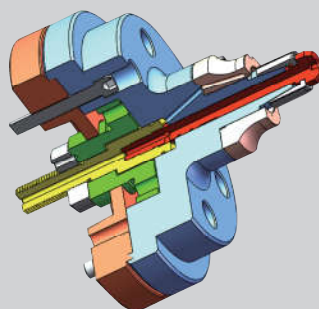
大内孔内涨夹具

Ouchi hole
(Bore clamping fixture)



内涨夹具体

Bore clamping fixture



带气密内涨夹具体

With air tightness test
(Bore clamping fixture)



内涨车具体

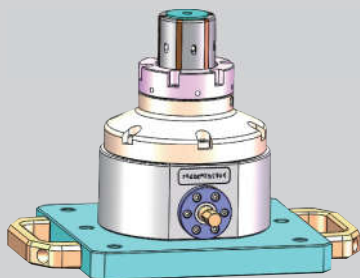
Bore clamping fixture



橡胶夹具
Rubber Collets

夹持解决方案 Clamping solution

其他夹持解决方案 Other clamping solutions



双锥度式内涨夹具
Double taper bore clamping fixture



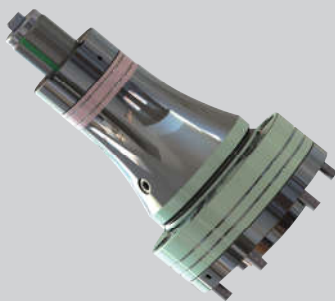
内涨芯轴夹具
Mandrel



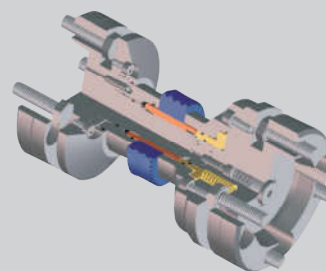
内涨滚齿夹具
Gear fixture



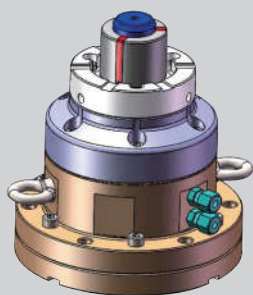
立式液压座外卡夹具
Vertical hydraulic seat
(External clamping fixture)



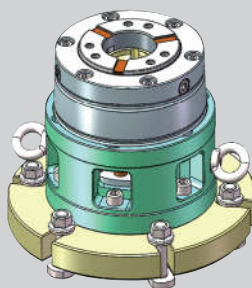
液压磨齿夹具
Hydraulic gear grinding



内涨剃齿夹具
Gear shaving fixture



立式液压座内涨夹具
Vertical hydraulic seat
(Bore clamping fixture)



外卡插齿夹具
Gear shaping fixture



多工位立加夹具
Vertical machining center fixture

自车环 Turning fixture



型号 (Type)	规格 (Specification)	备注 (Remark)
SK32	TF/SK32	
SK42	TF/SK42	
SK52	TF/SK52	
SK65	TF/SK65	
SK80	TF/SK80	
NK60/105	TF/NK60/105	
EK68/93/110	TF/EK68/93/110	

安装好自车型夹头，装入自车环，拉紧，对夹头需要加工的区域进行加工

Install the self-type chuck, load the turning fixture, tighten and process the area where the chuck needs to be processed

手动换爪器 Manual changing Devices



型号 (Type)	规格 (Specification)	备注 (Remark)
SK32	MC/SK32	
SK42	MC/SK42	
SK52	MC/SK52	
SK65	MC/SK65	
SK80	MC/SK80	
NK60/105	MC/NK60/105	
EK68/93/110	MC/EK68/93/110	

气动换爪器 Pneumatic changing Devices



型号 (Type)	规格 (Specification)	备注 (Remark)
SK52	PC/SK52	
SK65	PC/SK65	
SK80	PC/SK80	
SK100	PC/SK100	
SK120	PC/SK120	