

CLAMPING HEADS

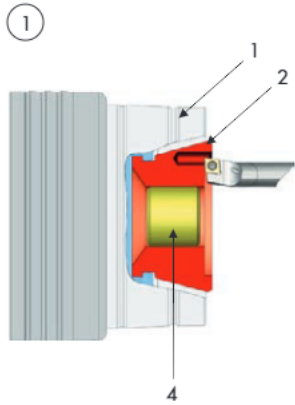
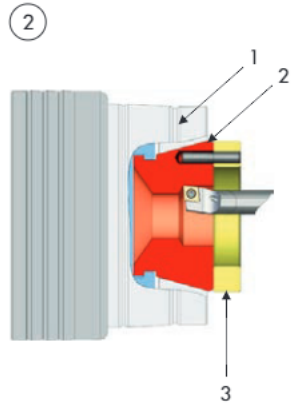
Clamping heads RD



Three RD types






	BZI	BZIG	BZI HSW
			
Applications	for clamping of raw material	for clamping of finished material	for machining to size
Sizes	32, 42, 52, 65, 80, 100, 125, 160	32, 42, 52, 65, 80, 100, 125, 160	32, 42, 52, 65, 80, 100, 125, 160
Clamping range of all sizes [mm]	4 – 160	4 – 160	5 – 130
Clamping surface	serrated	smooth	
Material condition	hard [60 HRC]	hard [60 HRC]	hard [60HRC] / soft [40 HRC]
Standard profiles	round square hexagonal	round	round
Special - serration	coarse toothed [Z] finely serrated [F]		

Machining to size of HSW clamping heads

Designation	
<ul style="list-style-type: none"> 1 Chuck 2 HSW clamping head [reduced hardness of 40 HRC in the bore] 3 Loading ring 4 Bolts 	 



Design of the bore

Standard version	Special serration
<p>Smooth</p>  <p>Clamping virtually without clamping marks Application example: Clamping of previously machined contours</p>	<p>F-serration</p>  <p>Powerful clamping through scoring the small pointed teeth – with clamping marks Application example: Clamping of raw material</p>
<p>Radial and axial grooves</p>  <p>Powerful clamping with clamping marks Application example: Clamping of raw material</p>	<p>Z-serration</p>  <p>Powerful clamping through deep scoring of the clamping teeth – with clamping marks Application example: Clamping of raw material [e.g. oxidized, rolled material]</p>
<p>Radial grooves</p>  <p>Powerful clamping with clamping marks Application example: Clamping of raw material</p>	



Clamping head BZI. For raw material clamping

Size	Total length [mm]	Particularity	Profile	Increments [mm]	Type of serration	Clamping range [mm]	In stock	Order no.	
32	47	Front nose extension	●	1	Smooth	3,0 - 7,5	✓	sk32bzir3,0-7,5	
					Radial grooves	8,0 - 10,5	✓	sk32bzir8,0-10,5	
					Radial and axial grooves	11 - 32	✓	sk32bzir11,0-32,0	
			■	1	Smooth	7	✓	sk32bziv7,0	
					Radial grooves	8 - 22	✓	sk32bziv8,0-22,0	
					Smooth	7	✓	sk32bzis7,0	
42	47	Front nose extension	●	0,5	Smooth	3,0 - 7,5	✓	sk42bzir3,0-7,5	
					Radial grooves	8,0 - 10,5	✓	sk42bzir8,0-10,5	
					Radial and axial grooves	11 - 42	✓	sk42bzir11,0-42,0	
			■	1	Smooth	7	✓	sk42bziv7,0	
					Radial grooves	8 - 28	✓	sk42bziv8,0-28,0	
					Smooth	7	✓	sk42bzis7,0	
52	46	Reduced front nose	●	0,5	Smooth	3,0 - 7,5	✓	sk52bzir3,0-7,5	
					Radial grooves	8,0 - 10,5	✓	sk52bzir8,0-10,5	
					Radial and axial grooves	11 - 52	✓	sk52bzir11,0-52,0	
			■	1	Radial grooves	8 - 36	✓	sk52bziv8,0-36,0	
					Smooth	7	✓	sk52bzis7,0	
					Radial grooves	8 - 45	✓	sk52bzis8,0-45,0	
65	58	Front nose extension	●	0,5	Smooth	4,0 - 7,5	✓	sk65bzir4,0-7,5	
					Radial grooves	8,0 - 10,5	✓	sk65bzir8,0-10,5	
					Radial and axial grooves	11 - 65	✓	sk65bzir11,0-65,0	
			■	1	Radial grooves	8 - 46	✓	sk65bziv8,0-46,0	
					Smooth	7	✓	sk65bzis7,0	
					Radial grooves	8 - 56	✓	sk65bzis8,0-56,0	
80	53	Reduced front nose	●	1	Smooth	4 - 7	✓	sk80bzir4,0-7,0	
					Radial grooves	8 - 10	✓	sk80bzir8,0-10,0	
					Radial and axial grooves	11 - 80	✓	sk80bzir11,0-80,0	
			■	1	Radial grooves	8 - 56	✓	sk80bziv8,0-56,0	
					Smooth	7	✓	sk80bzis7,0	
					Radial grooves	8 - 68	✓	sk80bzis8,0-68,0	
100	59	No front nose	●	1	Radial grooves	15 - 24	-	sk100bzi15,0-24,0	
					Radial and axial grooves	25 - 41	-	sk100bzi25,0-41,0	
			■		Radial and axial grooves	42 - 100	✓	sk100bzi42,0-100,0	
					Radial grooves	50 - 70	-	sk100bzv50,0-70,0	
125	67	Reduced front nose	●	1	Radial grooves	50 - 86	✓	sk100bzs50,0-86,0	
					■	Radial and axial grooves	25 - 125	-	sk125bzi25,0-125,0
						Radial grooves	25 - 87	-	sk125bzv25,0-87,0
160	63	Reduced front nose	●	1	Radial grooves	25 - 107	-	sk125bzs25,0-107,0	
					■	Radial and axial grooves	27 - 160	-	sk160bzi27,0-160,0
						Radial grooves	27 - 112	-	sk160bzv27,0-112,0
160	63	Reduced front nose	●	1	Radial grooves	27 - 137	-	sk160bzs27,0-137,0	

Explanations of the types of clamping surfaces on the previous page.



Clamping head BZIG. For clamping of finished material

Size	Total length [mm]	Particularity	Profile	Increments [mm]	Type of serration	Clamping range [mm]	In stock	Order no.
32	44	Reduced front nose	●	1	Smooth	3 - 32	✓	sk32bzigr3,0-32,0
42	42	Reduced front nose	●	0,5	Smooth	3 - 42	✓	sk42bzigr3,0-42,0
52	46	Reduced front nose	●	0,5	Smooth	3 - 52	✓	sk52bzigr3,0-52,0
65	53	Reduced front nose	●	0,5	Smooth	3 - 65	✓	sk65bzigr3,0-65,0
			⬢	1		7 - 56	[✓]*	sk65bzigs7,0-56,0
80	53	Reduced front nose	●	1	Smooth	4 - 80	✓	sk80bzigr4,0-80,0
100	59	No front nose	●	1	Smooth	15 - 41	-	sk100bzgr15,0-41,0
						42 - 100	✓	sk100bzgr42,0-100,0
125	67	Reduced front nose	●	1	Smooth	25 - 125	-	sk125bzgr25,0-125,0
160	63	Reduced front nose	●	1	Smooth	27 - 160	-	sk160bzgr27,0-160,0

Explanations of the types of clamping surfaces on the previous page.
* Partially on stock

Clamping head BZI HSW. For machining to size

Size	Total length [mm]	Particularity	Profile	Base bore Ø [mm]	Max. axial drawtube force [kN]	In stock	Order no.
32	44	Soft I.D. and clamping head face	●	5	15	✓	sk32bzihswr5,0
				10		✓	sk32bzihswr10,0
				20		✓	sk32bzihswr20,0
42	42	Soft I.D. and clamping head face	●	8	18	✓	sk42bzihswr8,0
				15		✓	sk42bzihswr15,0
				30		✓	sk42bzihswr30,0
52	46	Soft I.D. and clamping head face	●	8	34	✓	sk52bzihswr8,0
				15		✓	sk52bzihswr15,0
				30		✓	sk52bzihswr30,0
65	53	Soft I.D. and clamping head face	●	3	45	✓	sk65bzihswr3,0
				5		✓	sk65bzihswr5,0
				8		✓	sk65bzihswr8,0
				20		✓	sk65bzihswr20,0
				40		✓	sk65bzihswr40,0
80	53	Soft I.D. and clamping head face	●	8	44	✓	sk80bzihswr8,0
				20		✓	sk80bzihswr20,0
				40		✓	sk80bzihswr40,0
				60		✓	sk80bzihswr60,0
100	59	Soft I.D. and clamping head face	●	15	50	✓	sk100bzihswr15,0
				30		✓	sk100bzihswr30,0
				45		✓	sk100bzihswr45,0
				65		✓	sk100bzihswr65,0
				90		✓	sk100bzihswr90,0
125	67	Soft I.D. and clamping head face	●	25	70	✓	sk125bzihswr25,0
				45		✓	sk125bzihswr45,0
				70		✓	sk125bzihswr70,0
				100		✓	sk125bzihswr100,0
160	63	Soft I.D. and clamping head face	●	27	100	✓	sk160bzihswr27,0
				65		✓	sk160bzihswr65,0
				100		✓	sk160bzihswr100,0
				130		✓	sk160bzihswr130,0

Explanations of the types of clamping surfaces on the previous page.

CLAMPING HEADS

Clamping heads RD

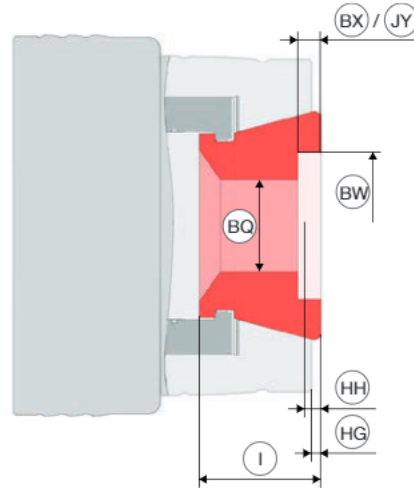


Loading ring [for clamping head BZI HSW]

Size	In stock	Order no.
32	✓	ar32
42	✓	ar42
52	✓	ar52
65	✓	ar65
80	✓	ar80
100	✓	ar100
125	✓	ar125
160	✓	ar160



Max. permissible counter bores when manufacturing to order and for HSW clamping heads. Technical data



Size	Capacity	Length	Clamping head protrusion length	Variant 1 [max. turning Ø]				Variant 2 [max. clamping depth]			
				Max. permissible turning Ø	Max. permissible turning depth	Min. turning depth	Min. clamping depth of workpiece	Max. permissible turning Ø	Max. permissible turning depth	Min. turning depth	Min. clamping depth of workpiece
				BQ	I	BW	BX	JY	HH	BW	BX
SK 32 BZI	32	47	6	40	13	13	9	35	23,5	13	9
SK 32 BZIG	32	44	3	40	10	10	6	35	20,5	10	6
SK 32 HSW	32	44	3	40	10	10	6	35	20,5	10	6
SK 42 BZI	42	47	9	64	15	14	12	45	30	15	12
SK 42 BZIG	42	42	4	64	10	10	7	45	25	10,5	7
SK 42 HSW	42	42	4	64	10,5	10,5	7	45	25	10,5	7
SK 52 BZI / SK 52 BZIG	52	46	4	64	10	10	6,5				
SK 52 HSW	52	46	4	64	10,5	10,5	7				
SK 65 BZI	65	58	9	78	18	15,5	12	66	35	15,5	12
SK 65 BZIG	65	53	4	78	13	10,5	7	66	30	10,5	7
SK 65 HSW	65	53	4	78	13	10,5	7	66	30	10,5	7
SK 80 BZI / SK 80 BZIG	80	53	4	93	11	10,5	7	81	30	10,5	7
SK 80 HSW	80	53	4	93	11	10,5	7	81	30	10,5	7
SK 100 BZ / SK 100 BZG	100	59	0	117	20	9	3				
SK 100 HSW	100	59	0	117	20	16	10				
SK 120 BZ	120	61	3	152	18	14	6	141	30	10	6
SK 120 HSW	120	61	3	152	18	14	10	136	30	10	6
SK 125 BZ / SK 125 BZG	127	67	4	167	18	16	7	151	36	16	12
SK 125 HSW	127	67	4	167	18	16	7	151	36	16	12
SK 140 BZ	140	63	5	170	17	12	8	144	36	12	8
SK 140 HSW	140	63	5	170	18	17	13	144	36	17	13
SK 160 BZ	160	63	5	210	12	12	8	188	32	12	8
SK 160 HSW	160	63	5	177	32	14	8				
				187	32	17	13				