

Pinces tirées - Zugspannzangen - Pull-type collets

Le serrage intervient en tirant la pince dans son logement au moyen d'une clé de serrage.

Ces pinces se distinguent des autres pinces tirées par leur filet extérieur, dont le diamètre est plus petit que le diamètre du corps de la pince. Elles sont recommandées principalement pour les tours outilleurs et les machines de haute précision.

Elles sont également utilisées comme pinces de serrage sur certains tours de production. Dans ce cas, leur construction est un peu différente. En exécution pour tours outilleurs, l'ouverture est très peu prononcée. Pour obtenir une bonne concentricité, il est recommandé d'employer une pince au diamètre nominal de la pièce à serrer.

Les alésages de ces pinces sont généralement lisses. Cependant, pour l'utilisation sur les tours de production, ils peuvent être obtenus rainurés en rond à partir du dia. 9 ou striés au-dessus du dia. 14 mm (rainuré en rond et en long).

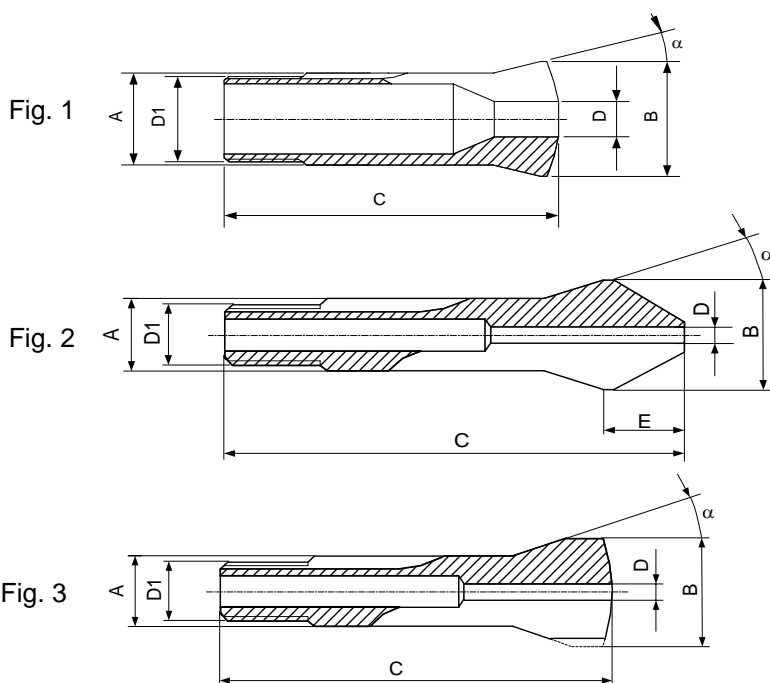
Das Spannen erfolgt von hinten mit einem Spannzangenschlüssel. Bei den Spannzangen Typ "B" ist der Aussendurchmesser des Gewindes kleiner als der Durchmesser des Schaftes (Führungsdurchmesser). Dieser Typ wird besonders für Werkzeugmacher Drehbänke und Präzisionsmaschinen empfohlen, kann aber auch als Material-Spannzange auf Produktionsmaschinen verwendet werden.

Bei Verwendung auf Werkzeugmacher Drehbänken ist die Öffnung der Spannzange gering. Um eine gute Rundlaufgenauigkeit zu erreichen ist es ratsam, eine Spannzange mit dem Nenn-Durchmesser des zu bearbeitenden Stückes zu verwenden.

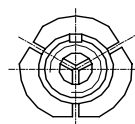
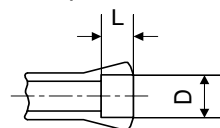
Die Spannbohrungen der Spannzangen Typ "B" sind im allgemeinen glatt. Bei Verwendung auf Produktionsmaschinen können Bohrungen auch gerillt (mit Querrillen ab 9 mm) oder geriffelt (mit Quer- und Längsrillen ab 14 mm) angeboten werden.

They are closed by being drawn back into the collet seating by means of a draw bar. The thread diameter is smaller than the collet shank diameter. The collets are mainly used on toolroom or precision lathes, but can also be used to hold bar material on capstans if the design is suitably amended. When used on toolroom lathes the collets open only a minimal amount. In order to obtain maximum concentricity it is advisable to use a collet fitting the nominal diameter of the part to be held. The bores of these collets are generally plain but can be made grooved from 9 mm diameter and serrated from 14 mm diameter (round and longitudinal grooves).

Pincés tirées - Zugspannzangen - Pull-type collets



Alésage à cran
Stufenbohrung
Step bore



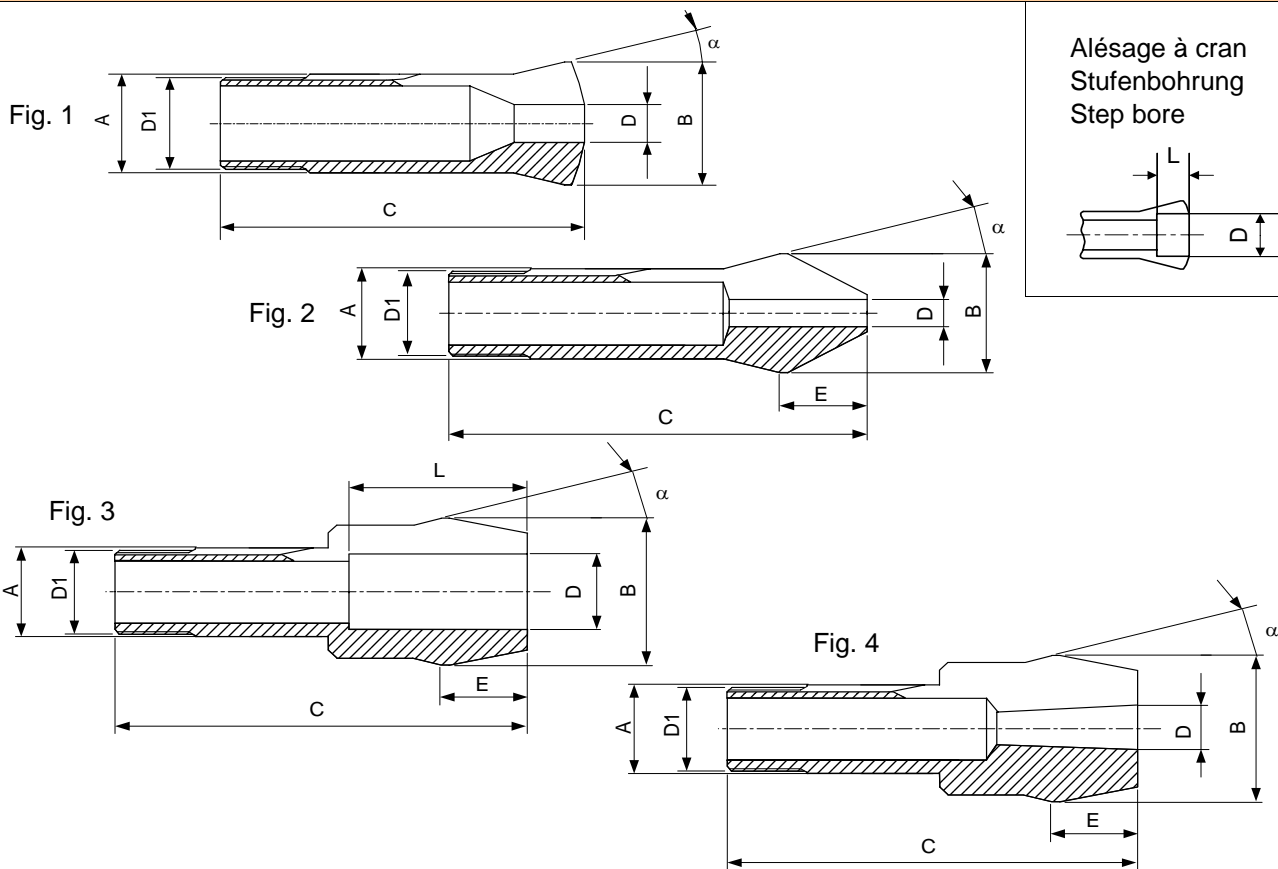
clé / Schlüssel / Spanner
B6 (72-1897) = 72-99001
B8 (72-1898) = 72-99002

Obturbateurs pour pincés, voir page Pi 34
Dichtgummi für Spannzangen auf Seite Pi 34
Rubber seals for collets on page Pi 34

| Type | Art. | A | B | C | D1 | E | α | Fig. | L | D min-max | | |
|------|----------|---|------|------|-------------------------------------|---|----------|------|--|--|---|----------------------------|
| B 6 | 72-00128 | 6 | 10.5 | 31.3 | \emptyset 5x36f" ∇ 55° | - | 20° | 1 | - 12 4.5 4 3.5 | 0.30...3.00 3.01...4.50 4.51...5.00 5.01...5.50 5.51...6.00 | | |
| | 72-01897 | 6 | 9 | 31.3 | \emptyset 5x36f" ∇ 55° | - | 20° | 3 | - 12 4.5 4 3.5 | 0.30...3.00 3.01...4.50 4.51...5.00 5.01...5.50 5.51...6.00 | | |
| B 8 | 72-00137 | 8 | 13 | 35.5 | \emptyset 6.82x0.625 ∇ 55° | - | 20° | 1 | - 13 6 5 4 3.2 2.5 1.7 1 | 0.30...4.00 4.01...6.50 6.51...7.00 7.01...7.50 7.51...8.00 8.01...8.50 8.51...9.00 9.01...9.50 9.51...10.00 | | |
| | | | | | | | | | 72-01898 | - 12.5 6 5 4 | 0.30...4.00 4.01...6.50 6.51...7.00 7.01...7.50 7.51...8.00 | |
| | | | | | | | | | | 72-00095 | - 21 | 0.30...3.30 3.31...6.50 |

Alésages standards (rond, carré, six-pans) selon liste de prix. Autres alésages sur demande
Standardbohrungen (rund, vierkant, sechskant) gemäss Preisliste. Andere Bohrungen auf Anfrage
Standard bores (round, square, hexagonal) according to pricelist. Other bores on request

Pincas tirées - Zugspannzangen - Pull-type collets



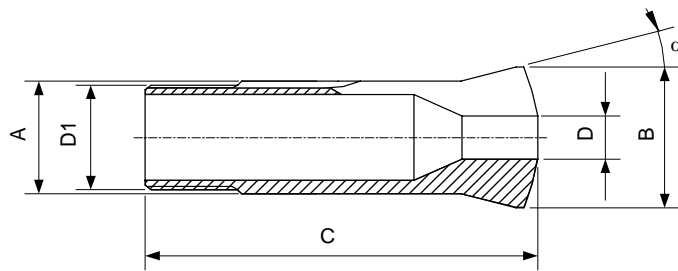
Alésage à cran
Stufenbohrung
Step bore

| Type | Art. | A | B | C | D1 | E | α | Fig. | L | D min-max | | | | | | | | | |
|----------------|---------------|----|-------|---------------------------------------|---------------------------------------|------|----------|------|----------------------|---------------|----|-------|---------------------------------------|---------------------------------------|-----|-----|----------------|----------------------|---------------|
| B 15 | 72-00139 | 15 | 21 | 55 | M13 x 1 | - | 20° | 1 | - | 0.30...9.50 | | | | | | | | | |
| | | | | | | | | | 20 | 9.51...12.50 | | | | | | | | | |
| | | | | | | | | | 8.5 | 12.51...13.00 | | | | | | | | | |
| | | | | | | | | | 7.7 | 13.01...13.50 | | | | | | | | | |
| | | | | | | | | | 7 | 13.51...14.00 | | | | | | | | | |
| | | | | | | | | | 6.5 | 14.01...14.50 | | | | | | | | | |
| B 32 UP | 72-00055 | 32 | 40 | 102 | M30 x 1.5 | - | 15° | 1 | - | 0.30...24.00 | | | | | | | | | |
| | | | | | | | | | 44 | 24.01...28.00 | | | | | | | | | |
| | | | | | | | | | 12 | 28.01...30.00 | | | | | | | | | |
| | | | | | | | | | 8 | 30.01...32.00 | | | | | | | | | |
| | | | | | | | | | B 32 | 72-00065 | 32 | 40 | 106 | \emptyset 29.7x15f" ∇ 45°/5° | - | 15° | 1 | - | 0.30...24.00 |
| | | | | | | | | | | | | | | | | | | 44 | 24.01...28.00 |
| 12 | 28.01...30.00 | | | | | | | | | | | | | | | | | | |
| 8 | 30.01...32.00 | | | | | | | | | | | | | | | | | | |
| | 72-02003 | 32 | 40 | 124 | \emptyset 29.7x15f" ∇ 45°/5° | 24 | 15° | 2 | - | 0.30...24.00 | | | | | | | | | |
| | | | | | | | | | 64 | 24.01...28.00 | | | | | | | | | |
| B 32/45 | 72-02005 | 32 | 53 | 148.5 | \emptyset 29.7x15f" ∇ 45°/5° | 32.5 | 15° | 3 | - | 1.00...24.00 | | | | | | | | | |
| | | | | | | | | | 80 | 24.01...40.00 | | | | | | | | | |
| | | | | | | | | | 72-93409 UP | 32 | 53 | 148.5 | \emptyset 29.7x15f" ∇ 45°/5° | 32.5 | 15° | 4 | - | Morse DIN228 MK-1 | |
| | | | | | | | | | | | | | | | | | 72-93410 UP | 32 | 53 |
| 72-93411 UP | 32 | 53 | 148.5 | \emptyset 29.7x15f" ∇ 45°/5° | 32.5 | 15° | 4 | - | Morse DIN228 MK-3 | | | | | | | | | | |

Alésages standards (rond, carré, six-pans) selon liste de prix. Autres alésages sur demande
Standardbohrungen (rund, vierkant, sechskant) gemäss Preisliste. Andere Bohrungen auf Anfrage
Standard bores (round, square, hexagonal) according to pricelist. Other bores on request

Pincés tirées - Zugspannzangen - Pull-type collets

Fig. 1



Alésage à cran
Stufenbohrung
Step bore

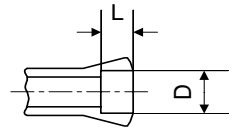


Fig. 2

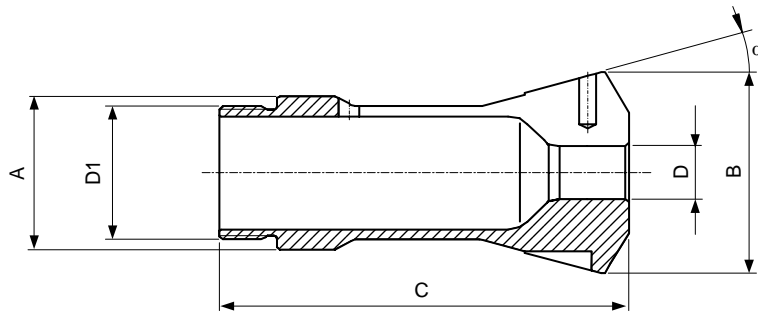


Fig. 3

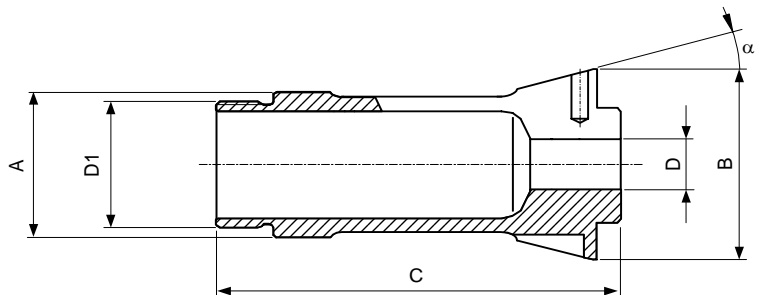
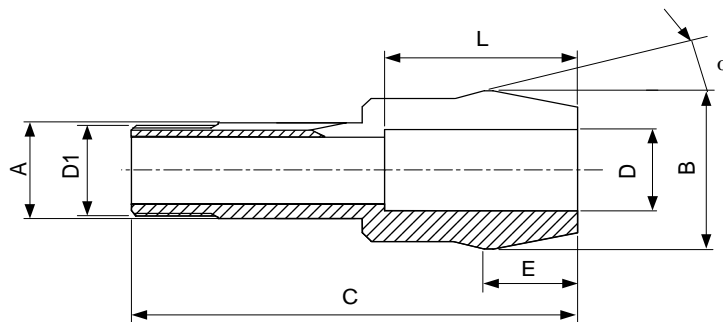


Fig. 4

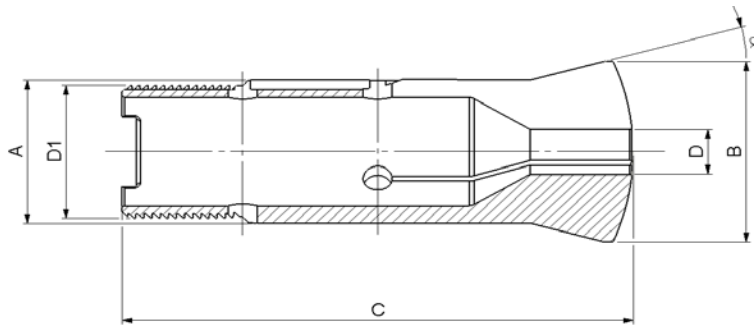


| Type | Art. | A | B | C | D1 | E | α | Fig. | L | D min-max |
|---------|--------------------|----|------|-----|---------------------------------------|----|----------|------|-----|---|
| B 32/45 | 72-93412 UP | 32 | 53 | 173 | \emptyset 29.7x15f" ∇ 45°/5° | 57 | 15° | 4 | 107 | Morse DIN228 MK-4 |
| B 34 | 72-01820 | 34 | 42 | 90 | M30 x 1 à gauche | - | 16° | 3 | - | 3.00...25.00 |
| B 45 | 72-00199 | 45 | 53 | 115 | M42 x 1.5 | - | 15° | 1 | - | 1.00...36.00 53 36.01...40.99 14 41.00...41.99 12 42.00...42.99 10 43.00...43.99 8 44.00...45.00 |
| B 46 | 72-02007 | 46 | 60.3 | 120 | M40 x 1.5 à gauche | - | 15° | 2 | - | 6.00...33.00 |

Alésages standards (rond, carré, six-pans) selon liste de prix. Autres alésages sur demande
Standardbohrungen (rund, vierkant, sechskant) gemäss Preisliste. Andere Bohrungen auf Anfrage
Standard bores (round, square, hexagonal) according to pricelist. Other bores on request

Pinces tirées - Zugspannzangen - Pull-type collets

Fig. 1



Alésage à cran
Stufenbohrung
Step bore

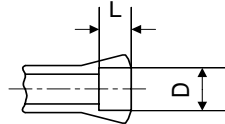


Fig. 2

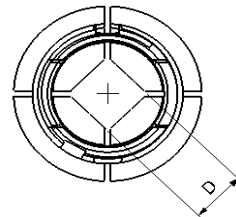
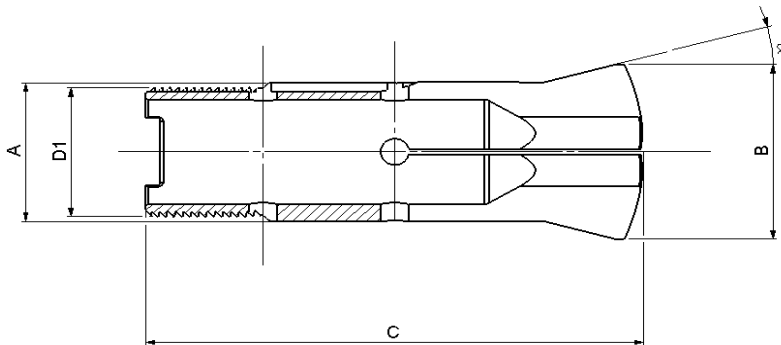
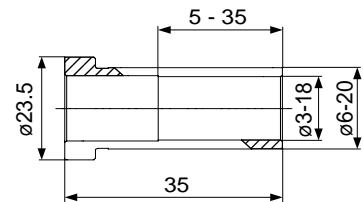
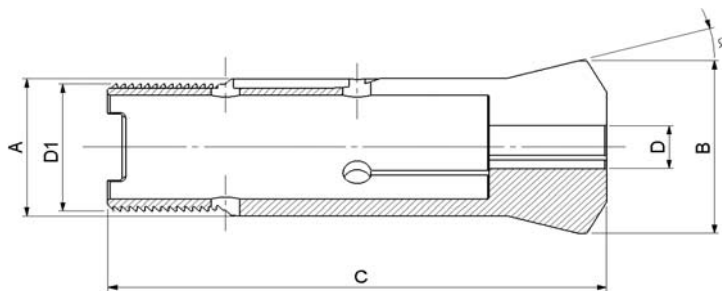



Fig. 3



Pince pour douilles
Spannzange für Hülsen
Collet for sleeves

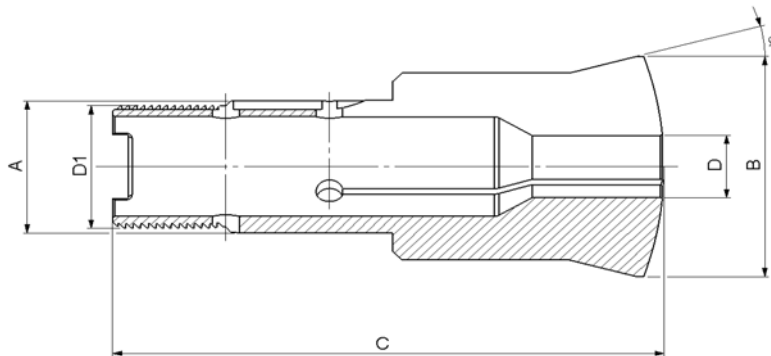
Douille 85-53310
Hülse 85-53310
Sleeve 85-53310

| Type | Art. | A | B | C | D1 | α | Fig. | L | D min.-max |
|-------|----------|----|----|-----|---------------------------------------|----------|------|---------------|--|
| HB 32 | 72-02010 | 32 | 40 | 106 | \emptyset 29.7x15f" ∇ 45°/5° | 15° | 3 | - |  6.00...20.00 |
| | 72-02030 | 32 | 40 | 106 | \emptyset 29.7x15f" ∇ 45°/5° | 15° | 1 | - | 3.00...23.79 |
| | | | | | | | | 44 | 23.80...27.99 |
| | | | | | | | | 12 | 28.00...29.99 |
| | | | | | | | | 8 | 30.00...32.00 |
| | 72-02040 | 32 | 40 | 106 | \emptyset 29.7x15f" ∇ 45°/5° | 15° | 2 | - | 3.00...20.59 |
| 44 | | | | | | | | 20.60...23.99 | |
| 12 | | | | | | | | 24.00...25.49 | |
| | | | | | | | 8 | 25.50...27.00 | |
| | | | | | | | | - | 3.00...16.99 |
| | | | | | | | | 44 | 17.00...19.79 |
| | | | | | | | | 12 | 19.80...20.99 |
| | | | | | | | | 8 | 21.00...22.60 |

Alésages standards (rond, carré, six-pans) selon liste de prix. Autres alésages sur demande
Standardbohrungen (rund, vierkant, sechskant) gemäss Preisliste. Andere Bohrungen auf Anfrage
Standard bores (round, square, hexagonal) according to pricelist. Other bores on request

Pinces tirées - Zugspannzangen - Pull-type collets

Fig. 1



Alésage à cran
Stufenbohrung
Step bore

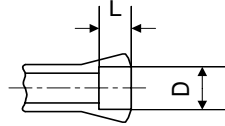
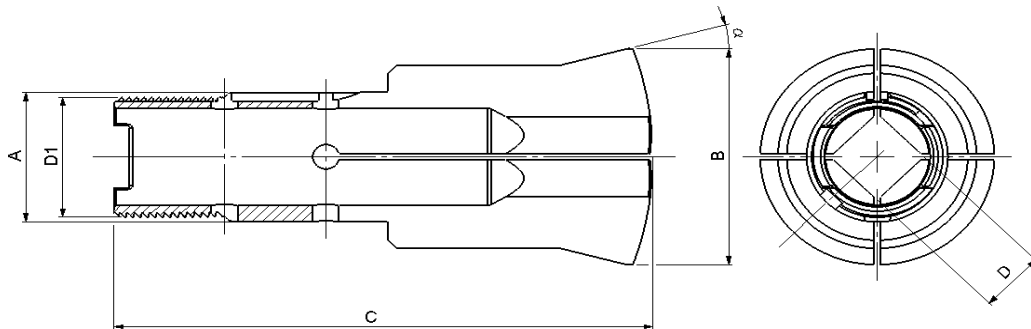


Fig. 2

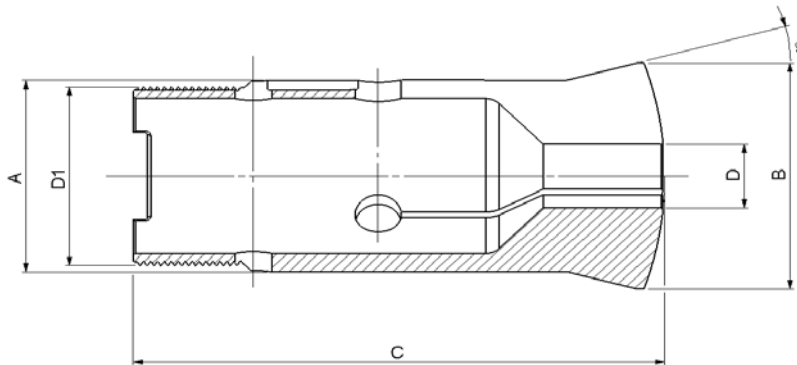


| Type | Art. | A | B | C | D1 | α | Fig. | L | D min.-max |
|----------|----------|----|-----|---|---|----------|------|---------------|---------------|
| HB 32/45 | 72-02033 | 32 | 53 | 122 | \emptyset 29.7x15f" \curvearrowright 45°/5° | 15° | 1 | - | 3.00...23.79 |
| | | | | | | | | 50 | 23.80...40.99 |
| | | | | | | | | 14 | 41.00...41.99 |
| | | | | | | | | 12 | 42.00...42.99 |
| | | | | | | | | 10 | 43.00...43.99 |
| | | | | | | | | 8 | 44.00...45.00 |
| | 72-02043 | 32 | 53 | 122 | \emptyset 29.7x15f" \curvearrowright 45°/5° | 15° | 2 | - | 3.00...20.59 |
| | | | | | | | | 50 | 20.60...34.99 |
| | | | | | | | | 14 | 35.00...35.99 |
| | | | | | | | | 12 | 36.00...36.99 |
| | | | | | | | | 10 | 37.00...37.99 |
| | | | | | | | | 8 | 38.00...38.50 |
| 72-02043 | 32 | 53 | 122 | \emptyset 29.7x15f" \curvearrowright 45°/5° | 15° | 2 | - | 3.00...16.79 | |
| | | | | | | | 50 | 16.80...28.99 | |
| | | | | | | | 12 | 29.00...29.99 | |
| | | | | | | | 10 | 30.00...30.99 | |
| | | | | | | | 8 | 31.00...31.75 | |

Alésages standards (rond, carré, six-pans) selon liste de prix. Autres alésages sur demande
Standardbohrungen (rund, vierkant, sechskant) gemäss Preisliste. Andere Bohrungen auf Anfrage
Standard bores (round, square, hexagonal) according to pricelist. Other bores on request

Pinces tirées - Zugspannzangen - Pull-type collets

Fig. 1



Alésage à cran
Stufenbohrung
Step bore

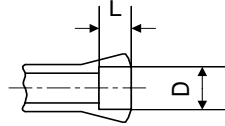
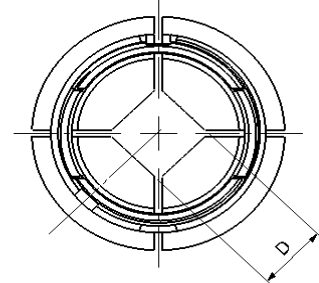
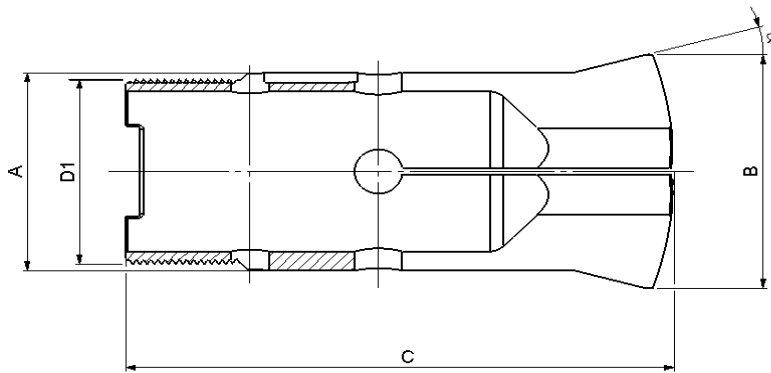


Fig. 2

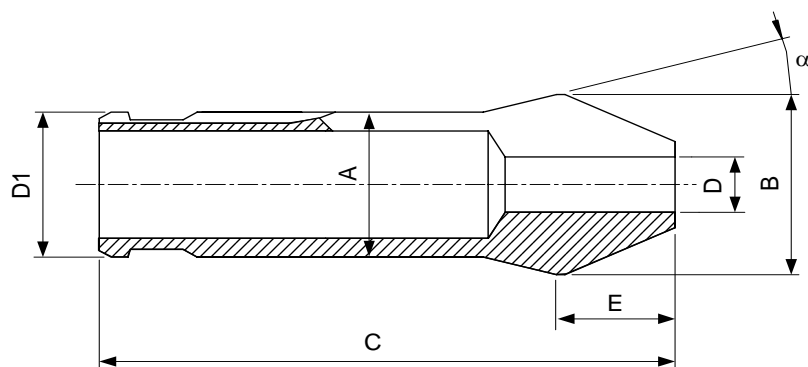


| Type | Art. | A | B | C | D1 | α | Fig. | L | D min.-max |
|-------|-----------------|----|---------------|-----|-----------|----------|------|----|---------------|
| HB 45 | 72-02036 | 45 | 53 | 115 | M42 x 1.5 | 15° | 1 | - | 3.00...36.00 |
| | | | | | | | | 53 | 36.01...40.99 |
| | | | | | | | | 14 | 41.00...41.99 |
| | | | | | | | | 12 | 42.00...42.99 |
| | | | | | | | | 10 | 43.00...43.99 |
| | | | | | | | | 8 | 44.00...45.00 |
| | 1 | - | 3.00...31.00 | | | | | | |
| | | 53 | 31.01...34.99 | | | | | | |
| | | 14 | 35.00...35.99 | | | | | | |
| | | 12 | 36.00...36.99 | | | | | | |
| | | 10 | 37.00...37.99 | | | | | | |
| | | 8 | 38.00...38.50 | | | | | | |
| | 72-02046 | 45 | 53 | 115 | M42 x 1.5 | 15° | 2 | - | 3.00...25.40 |
| | | | | | | | | 53 | 25.41...28.99 |
| | | | | | | | | 12 | 29.00...29.99 |
| | | | | | | | | 10 | 30.00...30.99 |
| | | | | | | | | 8 | 31.00...31.75 |

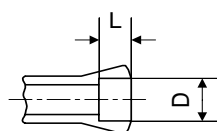
Alésages standards (rond, carré, six-pans) selon liste de prix. Autres alésages sur demande
Standardbohrungen (rund, vierkant, sechskant) gemäss Preisliste. Andere Bohrungen auf Anfrage
Standard bores (round, square, hexagonal) according to pricelist. Other bores on request

Pinces tirées - Zugspannzangen - Pull-type collets

Pince de serrage - Spannzange - Clamping collet



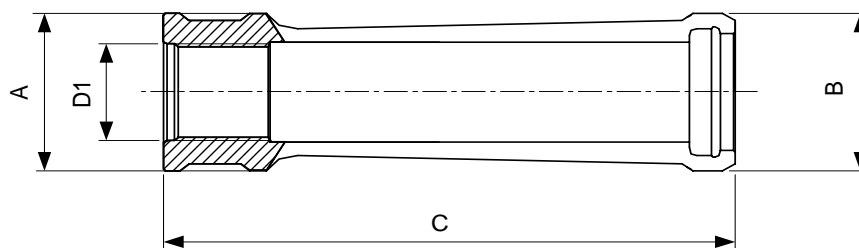
Alésage à cran
Stufenbohrung
Step bore



| Type | Art. | A | B | C | D1 | E | α | L | D min-max |
|--------|----------------|----|----|-----|----|----|----------|---------|-------------------------------|
| BCR 32 | 72-93235 | 32 | 40 | 117 | 32 | 24 | 15° | - 64 | 0.30...24.00 24.01...28.00 |
| | 72-93416 UP | 32 | 40 | 117 | 32 | 24 | 15° | - | Morse DIN228 MK-1 |
| | 72-93417 UP | 32 | 40 | 117 | 32 | 24 | 15° | - | Morse DIN228 MK-2 |
| | 72-93418 UP | 32 | 40 | 117 | 32 | 24 | 15° | - | Morse DIN228 MK-3 |

Alésages standards (rond, carré, six-pans) selon liste de prix. Autres alésages sur demande
Standardbohrungen (rund, vierkant, sechskant) gemäss Preisliste. Andere Bohrungen auf Anfrage
Standard bores (round, square, hexagonal) according to pricelist. Other bores on request

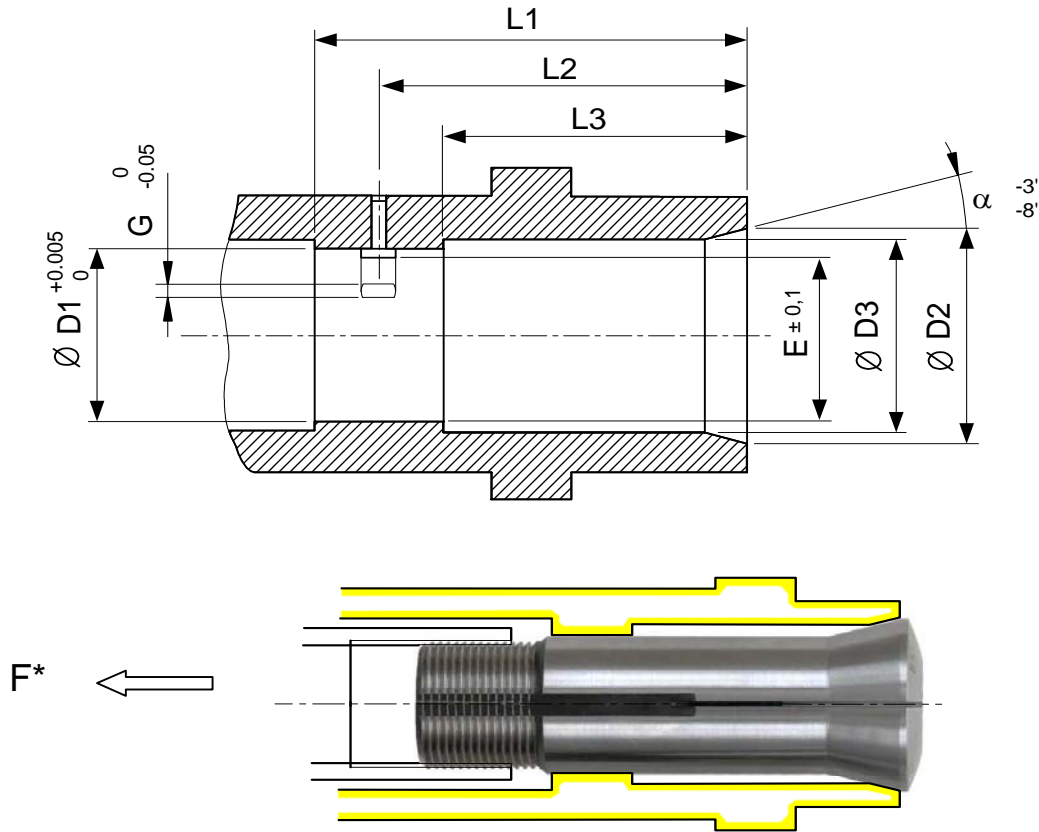
Pince de traction pour BCR Zugspannzange für BCR Pull-type collet for BCR



| Type | Art. | A | B | C | D1 |
|------|----------|----|----|-----|-----------|
| D 40 | 74-60039 | 40 | 40 | 133 | M24 x 1.5 |

Dimensions d'adaptation pour pinces
Abmessungen für Spannzangenaufnahme
Dimensions for collet seating

Broche - Spindel - Spindle



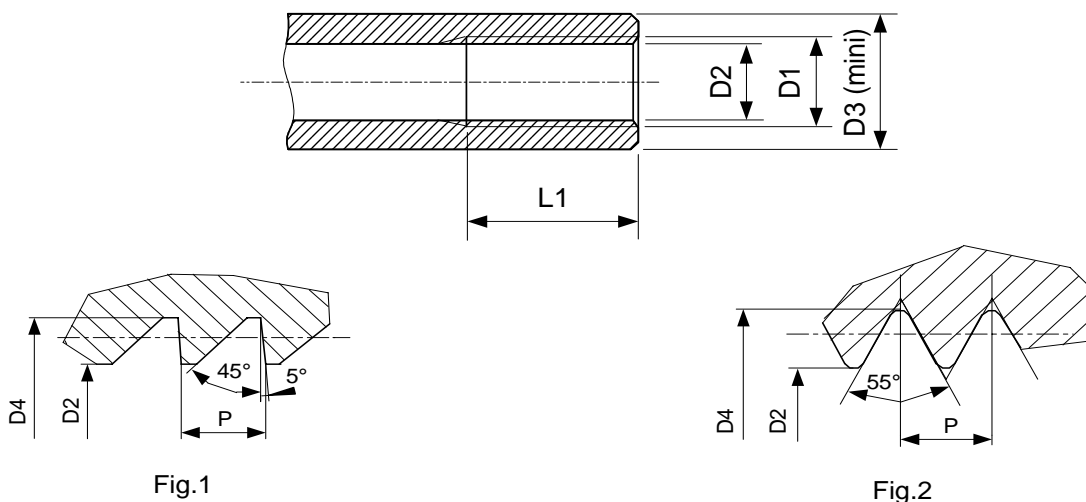
De préférence: cémenté 0,4-0,6 mm, trempé 58-62 HRC
Vorzugsweise: Einsatzgehärtet 0,4-0,6 mm, Gehärtet 58-62 HRC
Preferably : case hardened 0,4-0,6 mm, heat treat 58-62 HRC

| Type | D1 | D2 | D3 | L1 | L2 | L3 | α | E | F nom. | G |
|---------------------|---|------|----|----|----|----|----------|------|---------|------|
| B 6 72-00128 | 6 | 10.2 | 7 | 22 | 19 | 16 | 20° | 5.5 | 700 N | 0.95 |
| B 8 72-00137 | 8 | 12.8 | 9 | 25 | 20 | 17 | 20° | 7.5 | 1400 N | 1.75 |
| B 32 72-00065 | 32 | 40 | 36 | 75 | 63 | 49 | 15° | 29.9 | 11500 N | 4.9 |
| B 32/45 72-02005 | 32 | 53 | 49 | 90 | 80 | 70 | 15° | 29.9 | 11500 N | 4.9 |
| B 45 72-00199 | 45 | 53 | 49 | 84 | 66 | 52 | 15° | 42.9 | 27000 N | 4.9 |
| BCR 32 72-93235 | Demander le dessin d'adaptation nr. 72-93235IN Fragen Sie die Zeichnung Nr. 72-93235IN Ask for the drawing nr. 72-93235IN | | | | | | | | | |

F* Force de serrage pour applications générales (tournage, serrage barres, matière, fraisage)
F* Spannkraft für übliche Anwendung (drehen, spannen von Stangenmaterial, fräsen)
F* Clamping force for general applications (turning, bar holding, material, milling)

Dimensions d'adaptation pour pinces
Abmessungen für Spannzangenaufnahme
Dimensions for collet seating

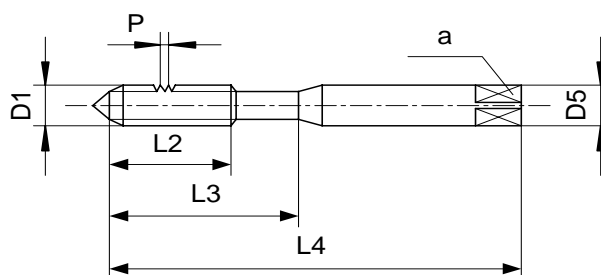
Clé de serrage - Spannschlüssel - Draw bar



Tarauts pour clés de serrage sont obtenables chez:
Gewindebohrer für Spannzangenahmen sind erhältlich bei:
Tapping tools for collet seatings are available by:



DC SWISS SA
Case postale 363
Grand-Rue 19
CH 2735 Malleray
Tel.++41 32 491 63 63
Fax.++41 32 491 64 64



| Type | D1 (x P) | D2 | D3 | D4 | L1 | Fig | Art. DC | D5 | L2 | L3 | L4 | a |
|---------------------|----------------------|------|------|------|----|-----|--------------|-----|----|----|-----|-----|
| B 6 72-00128 | ∅ 5x36f" ↘ 55° | 4.2 | 7 | 5.06 | 12 | 2 | W5 | 5 | 16 | 25 | 58 | 4 |
| B 8 72-00137 | ∅ 6.82x0.625 ↘ 55° | 6.15 | 8.5 | 6.9 | 10 | 2 | W6.82 | 7.1 | 19 | 30 | 66 | 5.6 |
| B 32 72-00065 | ∅ 29.7x15f" ↘ 45°/5° | 27.7 | 33.5 | 30 | 27 | 1 | SV30 | 20 | 37 | - | 127 | 16 |
| B 32/45 72-02005 | ∅ 29.7x15f" ↘ 45°/5° | 27.7 | 33.5 | 30 | 27 | 1 | SV30 | 20 | 37 | - | 127 | 16 |
| B 45 72-00199 | M42 x 1.5 | 40.2 | 47 | 42 | 25 | - | | | | | | |