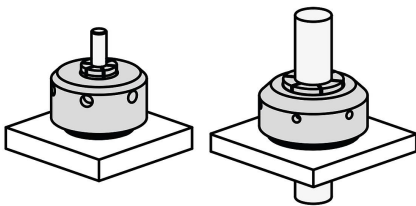


## Machinable collet for external clamping

### Item description/product images



### Description

#### Material:

Clamp nut aluminium.  
Collet steel.

#### Version:

Clamp nut hard anodised.

#### Note:

The contour of the workpiece to be clamped is machined into the collet.

The collet must be pre-tensioned at a setting of 15° before the workpiece contour is machined in.

By using the engraved degree numbers, the same tightening torque can always be achieved for secure clamping of the workpiece, even without a torque wrench.

The clamping travel of the collet K2077.01910 is 0.025 mm radially per 15° rotation. The recommended clamping travel is 0.07 mm. The maximum permissible clamping travel is 0.38 mm.

The clamping travel of the collet K2077.04950 is 0.05 mm radially per 15° rotation. The recommended clamping travel is 0.1 mm. The maximum permissible clamping travel is 0.64 mm.

The positioning collar enables a precise seat.

Workpiece repeat accuracy:  $\pm 0.02$  mm.

#### Type of operation:

The clamp nut is tightened using a hook wrench.

#### Technical data:

See Downloads, Technical Information.

#### Supplied with:

Form A: Machinable collet consisting of clamp nut and collet.

Form B: Collet.

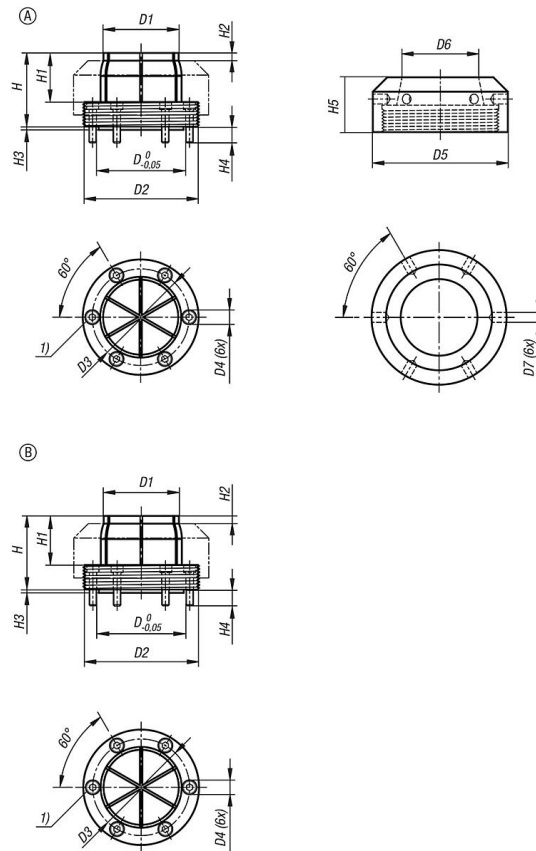
Including cap screws for fastening the collet. (metric and inch)

#### Drawing reference:

1) cap screw

# Machinable collet for external clamping

## Drawings



## Overview of items

### Machinable collet for external clamping

Order No.	Item	Form	D	D1	D2	D3	D4	D5	D6	D7	H	H1	H2	H3	H4	H5	Tightening torque max. Nm	Clamping range min. - max.	Clamping force kN
K2077.01910	Machinable Collet System	A	23,9	19,1	38,1	29	M3x16	50,8	20,1	6,4	35,6	22,9	4,6	2,5	6,8	25,4	81,5	2,5 - 15,9	17,3
K2077.04950	Machinable Collet System	A	55,9	49,5	76,2	63,8	M5x22	88,9	50,5	6,4	48,3	32,4	5,1	2,5	11,1	36,2	135,5	5,1 - 45,7	17,8
K2077.01911	Collet	B	23,9	19,1	38,1	29	M3x16	-	-	-	35,6	22,9	4,6	2,5	6,8	-	-	2,5 - 15,9	-
K2077.04951	Collet	B	55,9	49,5	76,2	63,8	M5x22	-	-	-	48,3	32,4	5,1	2,5	11,1	-	-	5,1 - 45,7	-