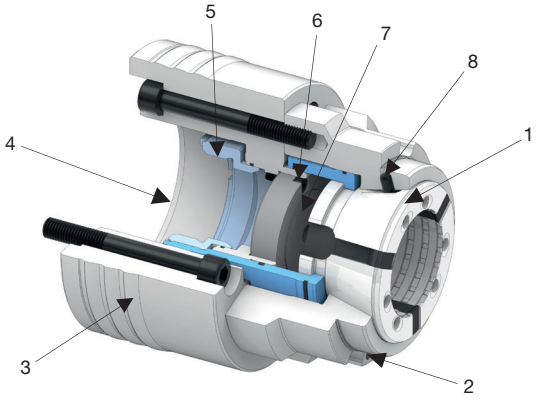
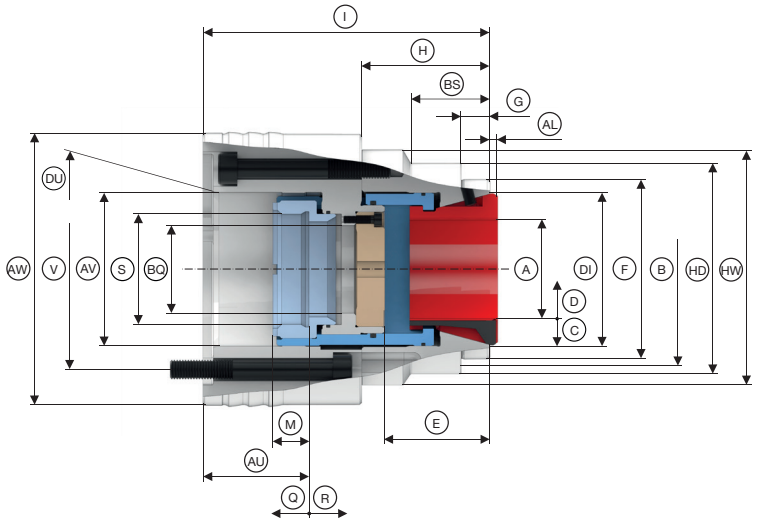
V-Line Combi pull-back size 52. Technical data

V-Line Combi pull-back in detail

1 Vulcanized clamping head with pull-back and hardened steel segments
2 Mounting thread for front
3 Spindle flange
4 Chuck passage after removal the base end-stop plate
5 Mounting thread for drawtube connection
6 Screw for base end-stop
7 Standing base end-stop for clamping with pull-back effect, central mounting thread for workpiece specific end-stop included
8 Torsional safety lock of the clamping head





Size		52	
Variant		**Combi pull-back**	**Combi pull-back**
Spindle nose	DU	A2-5	A2-6
Concentricity [mm]		0,01	0,01
Max. radial clamping force [kN]		75	75
Max. axial drawtube force [kN]		40	40
RPM n max. [1/min.]		7000	7000
Clamping range [mm]	A	4-52	4-52
Release stroke in Ø [mm]	C	0,6	0,6
Reserve stroke in Ø [mm]	D	1	1
Range / recommended workpiece tolerance [mm]		± 0,5	± 0,5
End-stop depth [mm]	E	55	55
Ø Capacity [mm]	BQ	46	46
End-stop thread size [M]	BG	10	10
Location front end-stop	F	Ø 94	Ø 94
Outer Ø 2 [mm]	HD	111	117
Outer Ø 3 [mm]	HW	125	137
Bolt hole circle end-stop	B	Ø 101 [3xM6]	Ø 101 [3xM6]
Centering length [mm]	G	15	15
Length 2 [mm]	BS	40	38
Length [mm]	H	67	67
Total length [mm]	I	150	150
Connecting thread inside	S	M60x2	M85x2
Inner Ø [mm]	AV	80,5	104,5
Depth of thread [mm]	M	19	19
Position in clamping position [mm]	AU	55,5	55,5
Reserve stroke axial [mm]	Q	2	2
Release stroke axial [mm]	R	2,5	2,5
Clamping head serrated	AM	SK52BZI	SK52BZI
Clamping head protrusion length serrated [mm]	AL	4	4
Clamping head smooth	AO	SK52BZIG	SK52BZIG
Clamping head protrusion length smooth [mm]	AN	4	4
Head Ø [mm]	DI	80	80
Bolt hole circle end-stop	V	Ø 104,8 [6xM10]	Ø 133,4 [6xM12]
Outer Ø [mm]	AW	142,5	175
Weight [kg]		9,3	14,1
Order no.		10894/0001	10894/0002

Scope of delivery

■ Chuck without base end-stop

Design of the bore. Standard version

Smooth	Radial and axial grooves	Radial grooves
		
Clamping virtually without clamping marks Application example: Clamping of previously machined contours	Powerful clamping with clamping marks Application example: Clamping of raw material	Powerful clamping with clamping marks Application example: Clamping of raw material

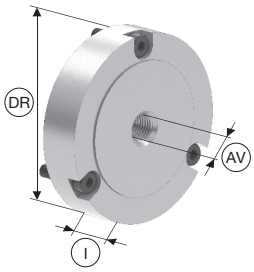
Clamping head BZI. For raw material clamping

Size	Total length [mm]	Profile	Increments [mm]	Type of serration	Clamping range [mm]	Order no.
52	46	●	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

Clamping head BZIG. For clamping of finished material

Size	Total length [mm]	Profile	Increments [mm]	Type of serration	Clamping range [mm]	Order no.
52	46	●	0,5	Smooth	3 - 52	sk52bzigr3,0-52,0

End-stop

Size	Figure	Outer Ø [mm] DR	Total length [mm] l	Inner Ø [mm] AV	Order no.
52		60	15	M10	10905/0001

Changing fixture

Variant	Figure	Size	Suitable for	Weight [kg]	Order no.
Manual		52	RD	1	mqvl52

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