

CR Type

COLLET CHUCK

筒夾式夾頭

使用說明書

INSTRUCTION MANUAL

通過ISO 9001品保系統認證合格與CE Mark認證合格廠商

Approved by ISO 9001 and CE certification

*A Stronghold
by precision and power*



重要 IMPORTANT

當您使用產品前，請詳閱並完全瞭解此說明書內之重要警告事項及使用前之注意事項。

Please ensure this instructions manual has been read and fully understand before operation.



請妥善保存本說明書
READ AND SAVE THIS BOOK

*A Stronghold
by precision and power*

AUTO Strong
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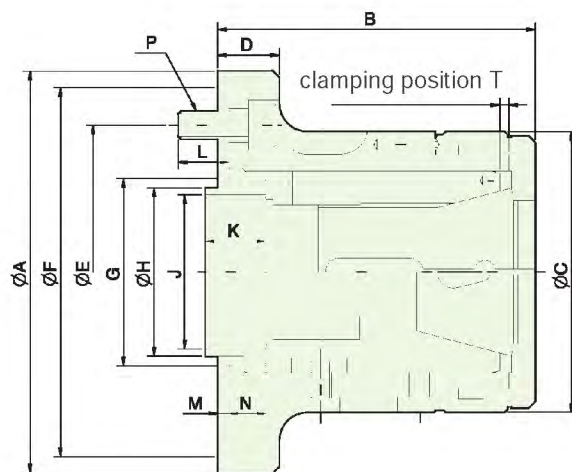
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1. 規格
Specifications

CR TYPE

Model	CR42-140	CR60-170	CR60-220
適合連接板 Matching adapter	140	170	220
容許棒材直徑 Bar capacity (mm)	42	60	60
套筒行程 Sleeve stroke (mm)	7	7	7
重量 Weight (kg)	6.2	11.5	15.5
最大容許推力 Max. push force (kN / kgf)	25 (2549)	30 (3059)	30 (3059)
最大夾持力 Max. gripping force (kN / kgf)	55 (5608)	65 (6628)	65 (6628)
最高轉速 Max. speed (r.p.m)	6000	5000	5000

Model	A(h6)	B	C	D	E	F(H6)	G	H	J max	K	L	M	N	P	T
CR42-140	155	114	100	23	104.78	140	M66XP1.5	60	M55XP2.0	25	18	6	11.9	3-M10	3.1
CR60-170	185	139	130	30	133.35	170	M90XP1.5	80	M74XP2.0	30	18	6	17.9	6-M12	3.1
CR60-220	235	141	130	32	171.45	220	M90XP1.5	80	M74XP2.0	30	20	6	19.9	6-M16	3.1

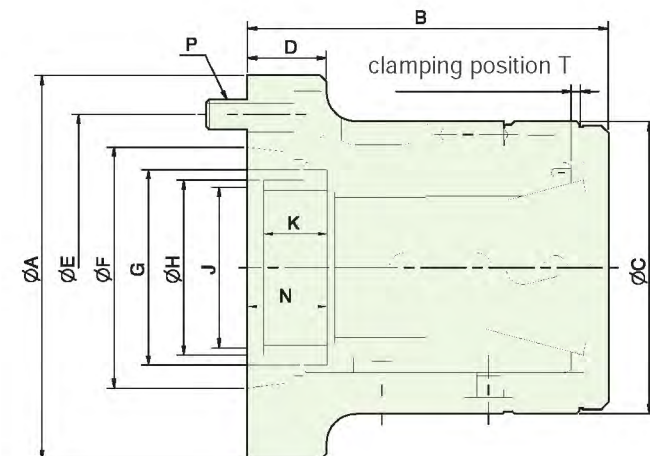


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CRA TYPE

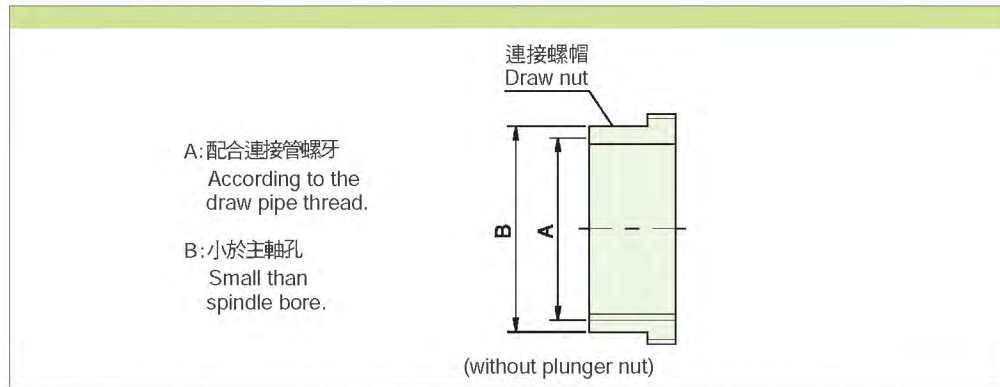
Model	CR26A4	CR30A4	CR42A5	CR42A6	CR60A6	CR80A8
適合主軸 Matching Spindle	A2-4	A2-4	A2-5	A2-6	A2-6	A2-8
容許棒材直徑 Bar capacity (mm)	26	30	42	42	60	80
套筒行程 Sleeve stroke (mm)	5	5	7	7	7	7
重量 Weight (kg)	4.5	4.1	6.2	8.2	13	21
最大容許推力 Max. push force (kN / kgf)	20 (2039)	20 (2039)	25 (2549)	25 (2549)	30 (3059)	35 (3568)
最大夾持力 Max. gripping force (kN / kgf)	44 (4486)	44 (4486)	55 (5608)	55 (5608)	65 (6628)	73 (7443)
最高轉速 Max. speed (r.p.m)	7000	7000	6000	6000	5000	4000

Model	A	B	C	D	E	F	G	H	J max	K	N	P	T
CR26A4	112	103.5	85	30	82.55	63.513	M50xP1.5	45	M40xP1.5	15	21.7	3-M10	2.3
CR30A4	112	103.5	85	30	82.55	63.513	M50xP1.5	45	M40xP1.5	15	21.7	3-M10	2.3
CR42A5	135	124	100	27	104.78	82.563	M66xP1.5	60	M55xP2.0	25	27.4	4-M10	3.1
CR42A6	170	124	100	32	133.35	106.375	M66xP1.5	66	M60xP2.0	22	27.4	4-M12	3.1
CR60A6	170	145	130	27	133.35	106.375	M90xP1.5	80	M74xP2.0	30	29.9	4-M12	3.1
CR80A8	220	170	156	35	171.45	139.719	M114xP2.0	99	M90xP2.0	27.5	32.4	6-M16	6.1



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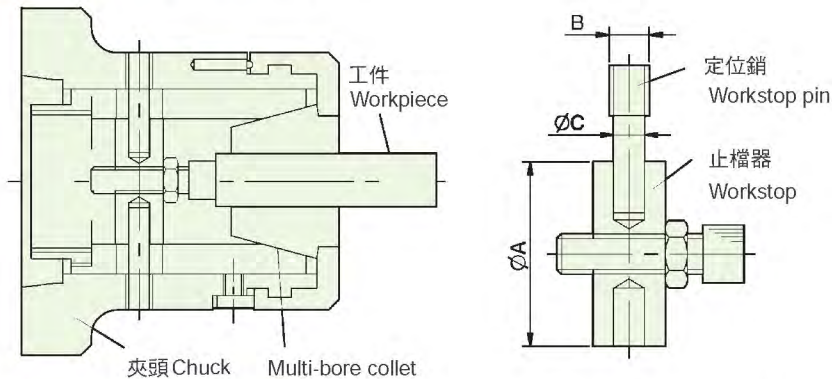
2. 連接螺帽的加工 Machining of draw nut



提供無牙的連接螺帽可配合連接管螺牙加工。若主軸孔小於連接螺帽外徑則需修改螺帽外徑(壁厚至3mm 以上)。螺帽與連接管螺牙之嚙合長度最少15mm。

The draw nut for threading to suit draw pipe. If the spindle bore small than draw nut, it is necessary to reduce the draw nut O.D. (thickness 3mm or more). The draw pipe min. length of thread engagement in the draw nut should be 15mm.

3. 固定銷及製作止檔器 Machining of workstop and pins



Chuck	∅A (H7)	B	C
CR26	32	M8	6
CR30	35	M8	6
CR42	48	M8	6
CR60	66	M10	8
CR80	90	M10	8

止檔器外徑為∅A(H7)加工2個∅C×180°的孔來配合固定銷。當使用長形筒夾或棒材由後方送料時，必須將2只固定銷拆下。
The workstop dia. is ∅A and requires 2 holes ∅C x180 deg. Apart to engage with the workstop pins. When using spring collet or barfeeding remove the workstop pins.

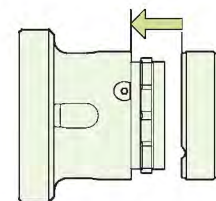
4. 夾頭的安裝步驟 Mounting steps of chuck

1. 檢查連接螺帽的螺牙能鎖入連接管。
2. 將連接螺帽鎖緊套筒。
3. 降低油壓力至最小狀態，作動油壓缸使活塞停在最前端的位置。轉動夾頭使連接螺帽鎖入連接管的螺牙，鎖入時夾頭的錐度孔須與主軸錐度同心，且夾頭之定位孔須對準主軸鼻端之定位鈕。
4. 操作油壓缸使活塞往後，夾頭與主軸錐度接合，確認定位鈕已裝配至夾頭內。
5. 鎖緊螺絲將夾頭與主軸固定，漸漸增加油壓力反覆作動夾頭至最大容許推力。

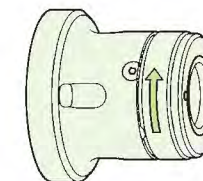
1. Check the threaded draw nut fits the draw pipe.
2. Fit drawnut to sleeve, lock in position.
3. Reduce cylinder pressure to the min. and operate the cylinder set the piston at the forward position. Thead the chuck on to the draw pipe. Align the fixing hole on the chuck with the spindle tapping hole and drive hole with the button on the spindle noses.
4. Power the cylinder to the rear position. The chuck will now move towards the spindle nose, check that the drive button is in line with the hole.
5. Tighten the chuck to the nose with bolts, increase the cylinder pressure to give the recommend max. push force.

5. 筒夾的安裝步驟 Mounting steps of collets

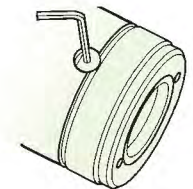
1. 拆下止檔蓋
 2. 將筒夾裝於止檔蓋上,再將筒夾裝入套筒內。
 3. 將止檔蓋裝回本體並鎖緊螺絲，檢查筒夾的夾持行程是否正確。
· MULTIBORE =最少 2mm · SPRING COLLET =大約 1mm
1. Remove cover when the chuck is in the open position.
 2. Fit the collet into the cover and insert the collet into sleeve.
 3. Refit cover and check that collet stroke the correct amount.
· MULTIBORE =2mm minimum · SPRING COLLET =1mm approx.



壓入止檔蓋
Push the cover



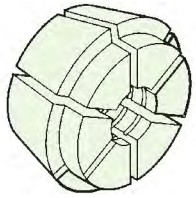
轉動止檔蓋
Turn the cover



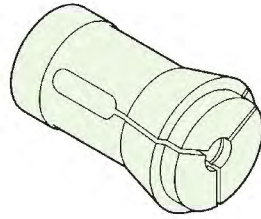
鎖緊蓋止動螺絲
Tighten the cover anti rotation screws

6. 筒夾 Collet

筒夾簡圖 Collet Drawings



Multi-Bore Collet



Spring collet

夾持範圍 Capacities

CHUCK		MULTIBORE			SPRING COLLET			
No.	Cat.No.	○	⬡	□	Cat.No.	○	⬡	□
CR26	M-667	26	22	18	161E 8744	26	22	18
CR30	M-669	30	26	21	163E 4249	30	26	21
CR42	M-673	42	36	30	173E 4728	42	36	30
CR60	M-677	60	52	42	185E 4291	60	52	42
CR80	J-660	80	69	56	193E H-47	80	69	56

使用筒夾須符合 DIN 6343 規範
Uses the collet to DIN 6343 specification.

- 套筒行程 Sleeve stroke
MULTIBORE = 7 mm
SPRING COLLET = 3 mm

7. 零件分解圖 Part list

