

**Pinces tirées - Zugspannzangen - Drawback collets**

Fig. 1

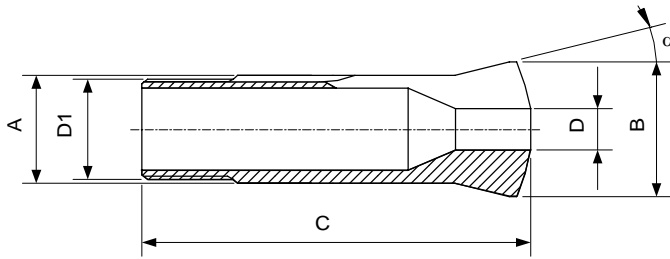


Fig. 2

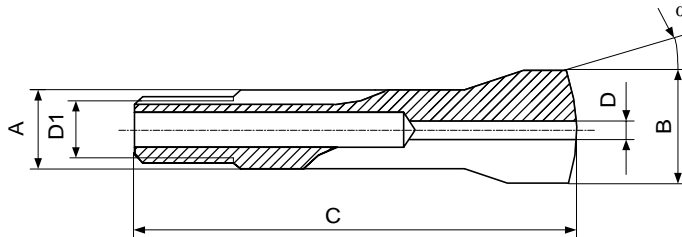
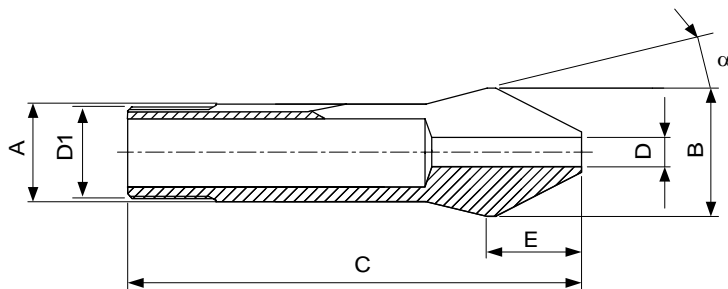
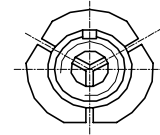
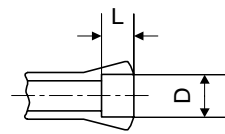


Fig. 3



Alésage à cran  
Stufenbohrung  
Step bore



**Obturbateurs pour pinces, 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               | ∅ 5x36f" ↗ 55°     | -   | 20° | 1    | -           | 0.30...3.00   |
|          |               |      |      |                    |                    |     |     |      | 12          | 3.01...4.50   |
|          |               |      |      |                    |                    |     |     |      | 4.5         | 4.51...5.00   |
|          |               |      |      |                    |                    |     |     |      | 4           | 5.01...5.50   |
| 72-01897 | 6             | 10.5 | 31.3 | ∅ 5x36f" ↗ 55°     | -                  | 20° | 2   | -    | 0.30...4.50 |               |
|          |               |      |      |                    |                    |     |     | 4.5  | 4.51...5.00 |               |
|          |               |      |      |                    |                    |     |     | 4    | 5.01...5.50 |               |
|          |               |      |      |                    |                    |     |     | 3.5  | 5.51...6.00 |               |
| B 8      | 72-00137      | 8    | 13   | 35.5               | ∅ 6.82x0.625 ↗ 55° | -   | 20° | 1    | -           | 0.30...4.00   |
|          |               |      |      |                    |                    |     |     |      | 12.5        | 4.01...6.50   |
|          |               |      |      |                    |                    |     |     |      | 6           | 6.51...7.00   |
|          | 72-01898      | 8    | 13   | 35.5               | ∅ 6.82x0.625 ↗ 55° | -   | 20° | 2    | -           | 0.30...6.50   |
|          |               |      |      |                    |                    |     |     |      | 6           | 6.51...7.00   |
|          |               |      |      |                    |                    |     |     |      | 5           | 7.01...7.50   |
|          |               |      |      |                    |                    |     |     |      | 4           | 7.51...8.00   |
| 72-00095 | 8             | 13   | 40.5 | ∅ 6.82x0.625 ↗ 55° | 7                  | 20° | 3   | -    | 0.30...3.30 |               |
| 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 |
| 6        | 14.51...15.00 |      |      |                    |                    |     |     |      |             |               |

Alésages standards selon liste de prix - Standardbohrungen gemäss Preisliste - Standard bores according to pricelist

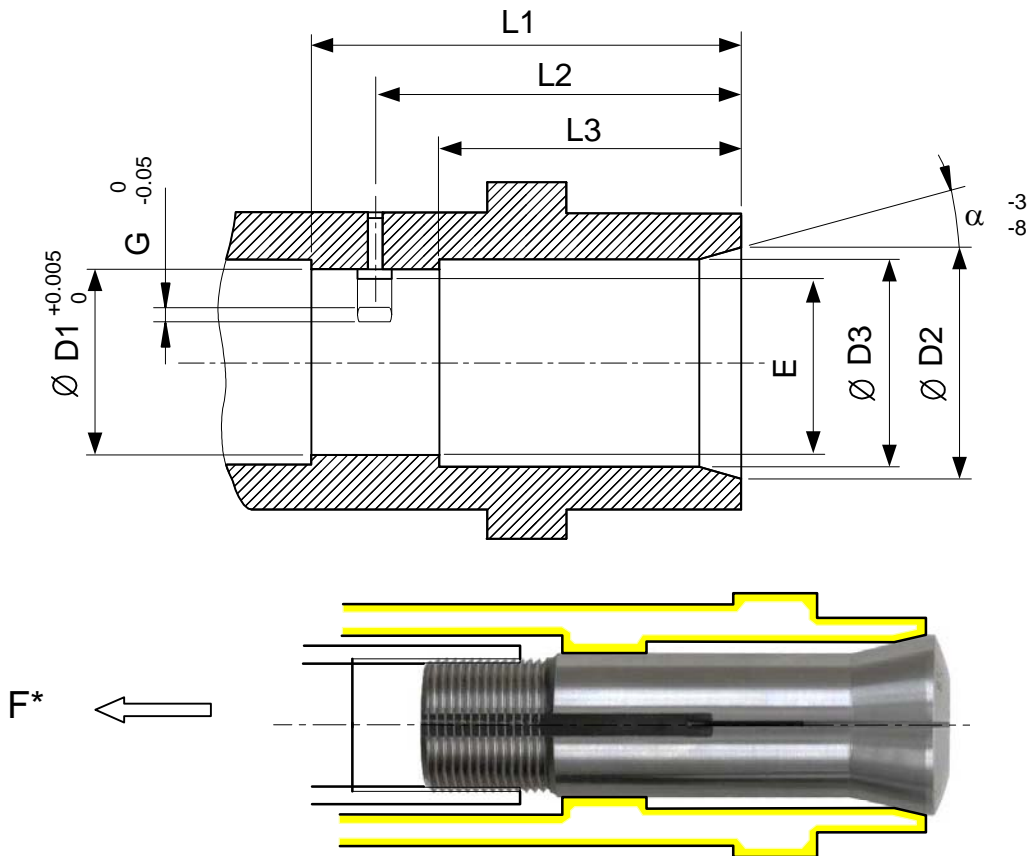
Autres alésages sur demande - Andere Bohrungen auf Anfrage - Other bores on request

**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<br>72-00128     | 6   | 10.2 | 7  | 22 | 19 | 16 | 20° | 5.4  | 700 N   | 0.95 |
| B 8<br>72-00137     | 8   | 12.8 | 9  | 25 | 20 | 17 | 20° | 7.5  | 1400 N  | 1.75 |
| B 32<br>72-00065    | 32  | 40   | 36 | 75 | 63 | 49 | 15° | 30   | 11500 N | 4.9  |
| B 32/45<br>72-02005 | 32  | 53   | 49 | 90 | 80 | 70 | 15° | 30   | 11500 N | 4.9  |
| B 45<br>72-00199    | 45  | 53   | 49 | 84 | 66 | 52 | 15° | 42.8 | 20000 N | 4.9  |
| BCR 32<br>72-93235  | Demander le dessin d'adaptation nr. 72-93235IN<br>Fragen Sie die Zeichnung Nr. 72-93235IN<br>Ask for the drawing nr. 72-93235IN |      |    |    |    |    |     |      |         |      |

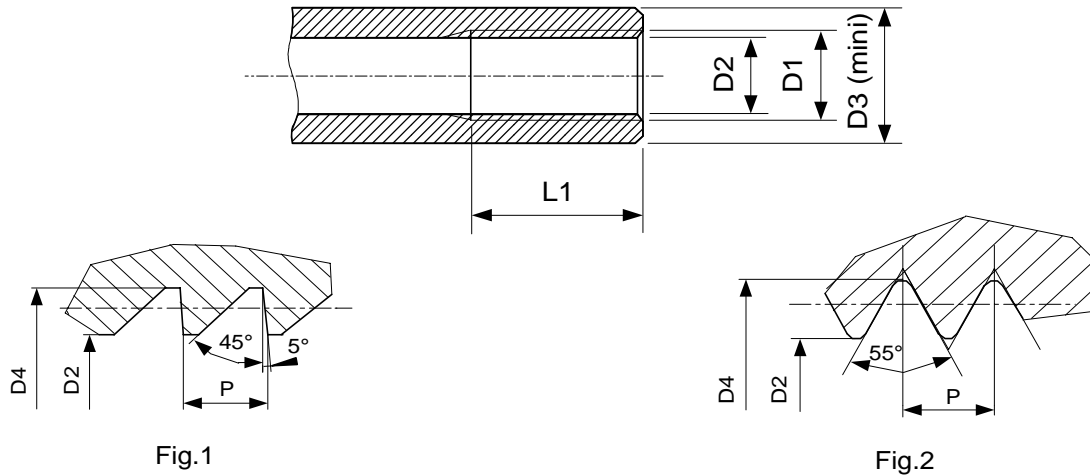
F\* Force de serrage pour applications générales (tournage, serrage barres, matière, fraisage)  
 F\* Spannkraft für übliche Anwendung (drehen, spannen von Stangenmaterial, fräsen)  
 F\* Clamping force for general applications (turning, bar holding, material, milling)

Dimensions d'adaptation pour pinces

Abmessungen für Spannzangenaufnahme

Dimensions for collet seating

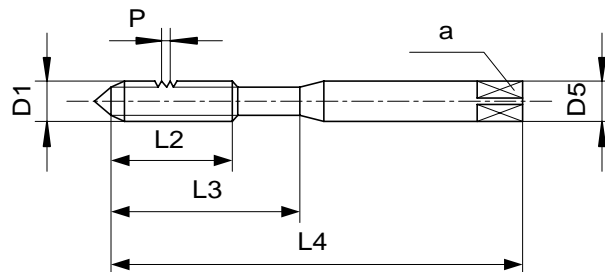
Clé de serrage / Spannschlüssel / Draw bar



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



**DC SWISS**  
 Daniel Charpilloz SA  
 Grand Rue 14  
 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<br>72-00128     | ∅ 5x36f" ↘ 55°       | 4.2  | 7    | 5.06 | 12 | 2   | <b>W5</b>    | 5   | 16 | 25 | 58  | 4   |
| B 8<br>72-00137     | ∅ 6.82x0.625 ↘ 55°   | 6.15 | 8.5  | 6.88 | 10 | 2   | <b>W6.82</b> | 7.1 | 19 | 30 | 66  | 5.6 |
| B 32<br>72-00065    | ∅ 29.7x15f" ↘ 45°/5° | 27.7 | 33.5 | 30   | 27 | 1   | <b>SV30</b>  | 20  | 37 | -  | 127 | 16  |
| B 32/45<br>72-02005 | ∅ 29.7x15f" ↘ 45°/5° | 27.7 | 33.5 | 30   | 27 | 1   | <b>SV30</b>  | 20  | 37 | -  | 127 | 16  |
| B 45<br>72-00199    | M42 x 1.5            | 40.2 | 47   | 42   | 25 | -   |              |     |    |    |     |     |