



Quick Change Collet Chucks

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Lathe fixture/Machining center fixture / Gear fixture three series solutions



Lathe fixture



Machining center fixture

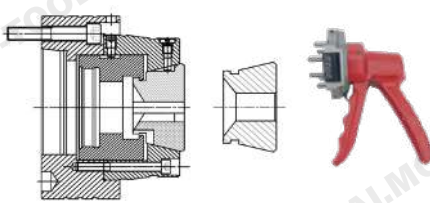
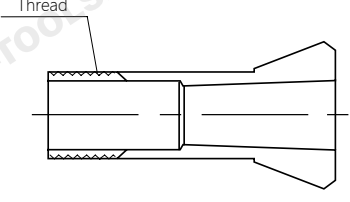
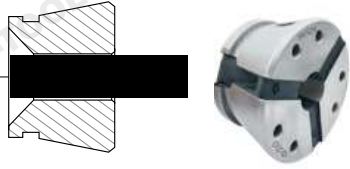
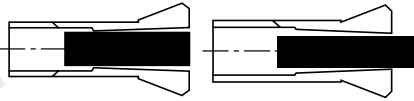
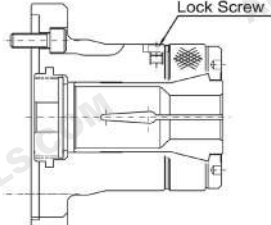
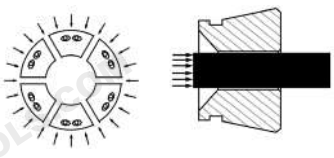
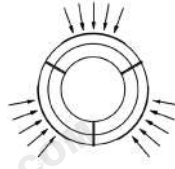
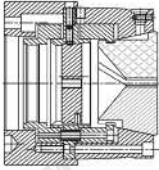
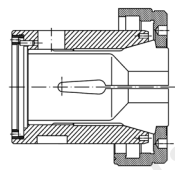


Gear fixture

OUR ADVANTAGES

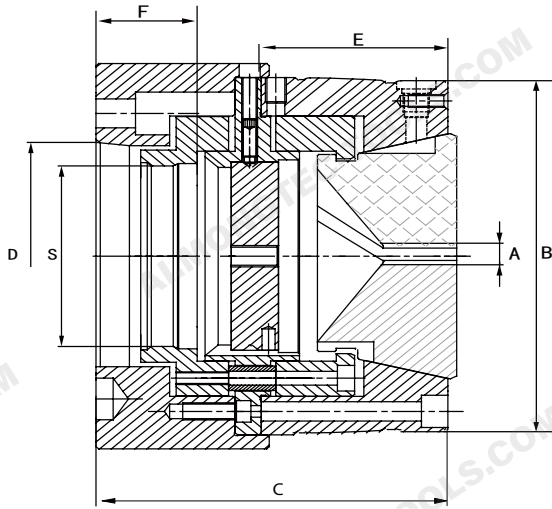
- The same industry has the most complete specifications and the most models.
- The delivery cycle is short, and the standard fixture has a large number of standing stocks.
- Quality benchmarking German quality.
- Relatively favorable price.
- Non-standard custom fixture design, manufacturing capacity is the most professional.

Advantages of our products-Exterior fixture

Advantage point	Mongtec fixture	Ordinary fixture
Quick change	Quick disassembly of special tools 	The tail thread is screwed in, and the installation is troublesome 
μ-level machining accuracy	The chuck is formed by grinding once, with three or six lobes. Split structure, each flap fully fits when clamping 	The front part is cut, but the back end is integrated, and the changes at the front and back ends are inconsistent 
	Self-centering shrinkage of inner cone, without clamping gap 	After the spring chuck is tightened, there is a sliding gap 
Strong holding force, suitable for heavy cutting	Process cylindrical clamping, close end face, double acting force, The clamping force is 2-3 times that of ordinary fixture 	Ordinary fixture is wrapped on three sides 
Large feeding gap, suitable for automation	The feeding gap of 3-petal or 6-petal rubber chuck is 1.2 mm 	Integral spring steel chuck, with single-side gap of 0.1-0.2 mm 

Lathe fixture-Exterior fixture

SK series rubber clamping fixture(pull-back type)



PRODUCT ADVANTAGES

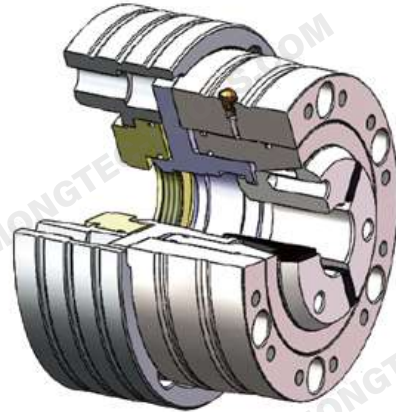
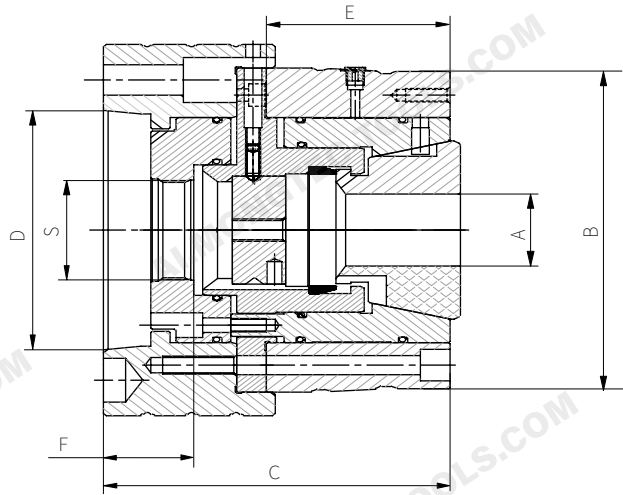
- After the positioning block is removed, it is a through hole type, which is suitable for bar processing.
- Segmented clamping, back-pulling parallel clamping, optional equipped with airtight detection and central water outlet function.
- High precision, $\leq 0.01\text{mm}$.
- The clamping range is large, up to $\pm 0.5\text{mm}$, which is suitable for automatic loading and unloading.
- The positioning block can be customized according to the size of the customer's workpiece.
- Suitable for standard spindle nose interface.
- Rubber vulcanization process, waterproof and chip-proof.
- Process bulk carburizing quenching, cryogenic treatment, quenching hardness HRC58-62.

Specifications and models	Clamping range(mm)	Clamp force (KN)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	S (mm)	MAX RPM (mm)	Remarks
SK32	5-32	70	106	114	Connecting different flanges	49	43.5	M60*2.0	7,000	
SK42	5-42	80	125	117		49	51.5	M60*2.0	6,000	
SK52	5-52	94	134	118		53	50.5	M60*2.0	6,000	
SK65	5-65	105	145	124		56	53.5	M75*2.0	6,000	
SK80	5-80	115	164	130		58	54.5	M75*2.0	5,000	
SK100	16-100	150	190	132		58	56.5	M80*2.0	4,500	
SK120	40-120	140	250	171		64	47.5	M80*2.0	4,000	
SK160	40-160	150	285	185		94.5	46.0	M85*2.0	4,000	

Specifications and dimensions are for reference only and subject to change without notice. Please confirm the latest specifications before ordering.

Lathe fixture-Exterior fixture

SK series rubber clamping fixture(push-to-close type)



PRODUCT ADVANTAGES

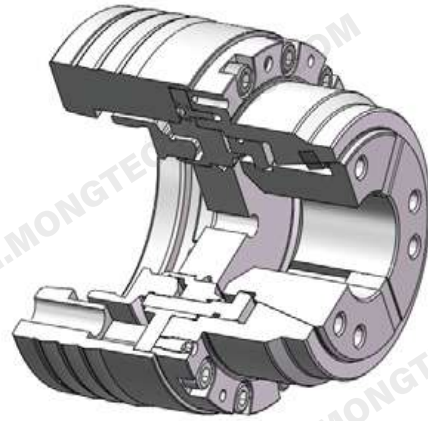
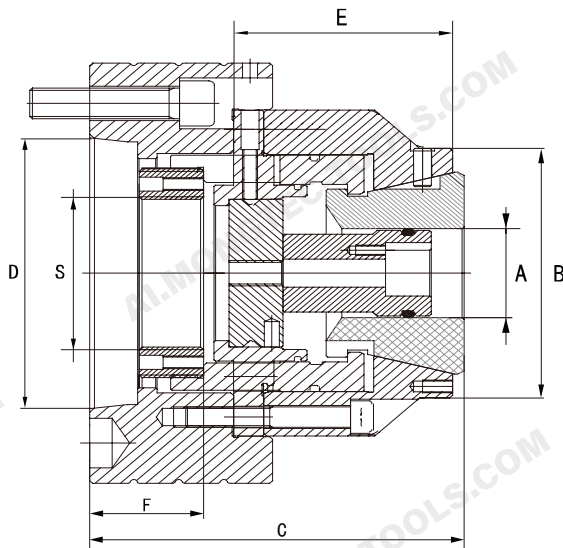
- After the positioning block is removed, it is a through hole type, which is suitable for bar processing.
- Segmented clamping, push forward parallel clamping, optional equipped with airtight detection and central water outlet function.
- High precision, $\leq 0.01\text{mm}$.
- The clamping range is large, up to $\pm 0.5\text{mm}$, which is suitable for automatic loading and unloading.
- The positioning block can be customized according to the size of the customer's workpiece.
- Suitable for standard spindle nose interface.
- Rubber vulcanization process, waterproof and chip-proof.
- Process bulk carburizing quenching, cryogenic treatment, quenching hardness HRC58-62.

Specifications and models	Clamping range(mm)	Clamp force (KN)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	S (mm)	MAX RPM (mm)	Remarks
SK32(W)	5-32	70	106	114	Connecting different flanges	49	43.5	M60*2.0	7,000	
SK42(W)	5-42	80	125	117		49	51.5	M60*2.0	6,000	
SK52(W)	5-52	94	134	118		53	50.5	M60*2.0	6,000	
SK65(W)	5-65	105	145	124		56	53.5	M75*2.0	6,000	
SK80(W)	5-80	115	164	130		58	54.5	M75*2.0	5,000	
SK100(W)	16-100	150	190	132		58	56.5	M80*2.0	4,500	
SK120(W)	40-120	140	250	171		64	47.5	M80*2.0	4,000	
SK160(W)	40-160	150	285	185		94.5	46.0	M85*2.0	4,000	

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Lathe fixture-Exterior fixture

SK series Mini rubber clamping fixture(pull-back type)



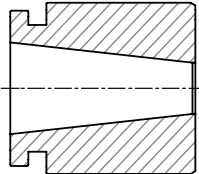
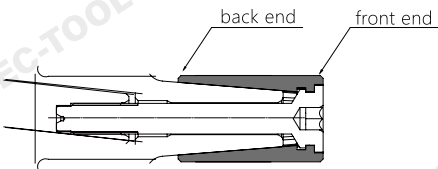
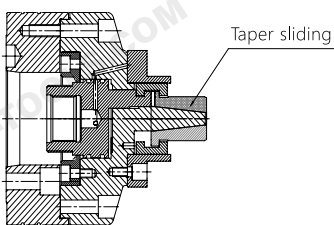
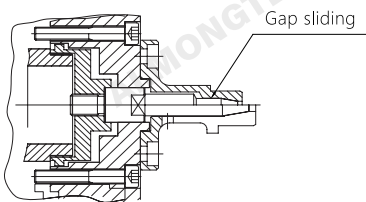
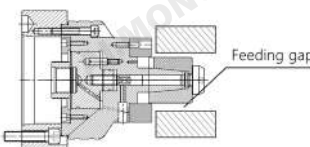
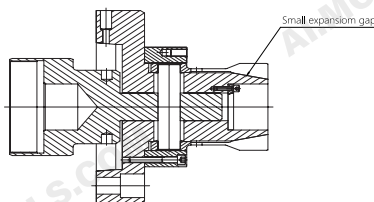
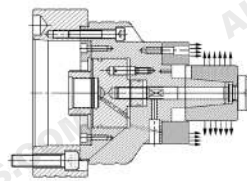
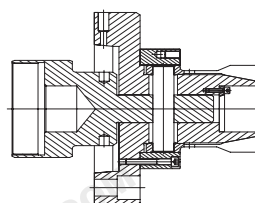
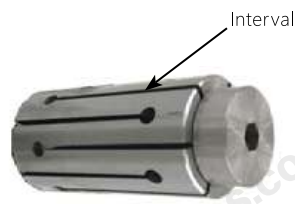
PRODUCT ADVANTAGES

- After the positioning block is removed, it is a through hole type, which is suitable for bar processing.
- Segmented clamping, back-pulling parallel clamping, optional equipped with airtight detection and central water outlet function.
- High precision, $\leq 0.01\text{mm}$
- The clamping range is large, up to $\pm 0.5\text{mm}$, which is suitable for automatic loading and unloading.
- The positioning block can be customized according to the size of the customer's workpiece.
- Suitable for standard spindle nose interface
- Rubber vulcanization process, waterproof and chip-proof
- Process bulk carburizing quenching, cryogenic treatment, quenching hardness HRC58-62

Specifications and models	Clamping range(mm)	Clamp force (KN)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	S (mm)	MAX RPM (mm)	Remarks
SK32(MZ)	5-32	70	75	117	Connecting different flanges	59.6	41.5	M50*1.5	7,000	
SK42(MZ)	5-42	80	98	124		63.5	43.0	M82*2.0	6,000	
SK52(MZ)	5-52	94	98	124		63.5	43.0	M82*2.0	6,000	
SK65(MZ)	5-65	105	111	150		59.6	60.0	M94*2.0	6,000	
SK80(MZ)	5-80	115	126	150		54.5	45.5	M104*2.0	5,000	
SK100(MZ)	16-100	150	160	170		72.0	54.5	M130*2.0	4,500	

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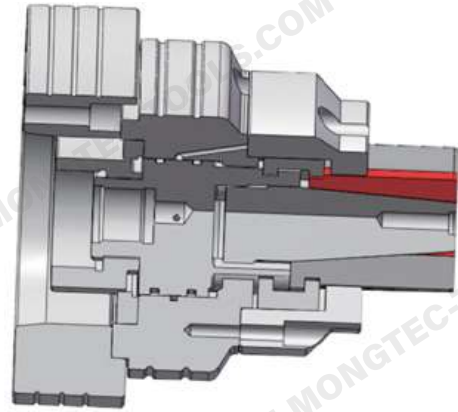
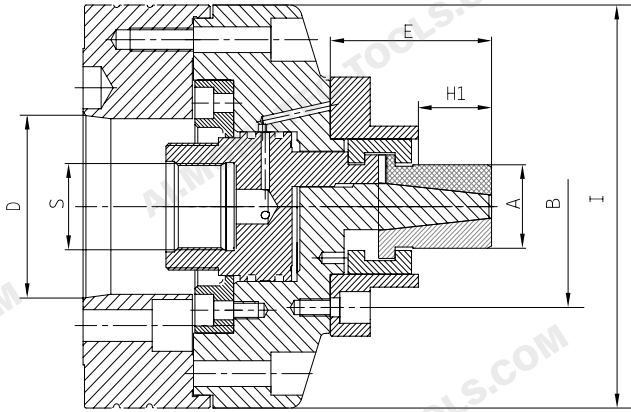
Lathe fixture-Internal expansion fixture

Advantage point	Mongtec fixture	Ordinary fixture
μ-level machining accuracy	The expansion sleeve is formed by grinding once, with three or six lobes. Split structure, each flap fully fits when clamping 	The front part is cut but the back part is integrated, front and back. Inconsistent changes at both ends 
	Self-centering shrinkage of inner cone, without clamp. Holding gap 	The spring is tensioned after expanding the sleeve, and there is a sliding gap. 
Large feeding gap, suitable for automation	The feeding gap of the three-petal or six-petal rubber expansion sleeve is 0.7-1.5mm 	Integral spring steel expansion sleeve with unilateral clearance of 0.1-0.2 mm 
High rigidity	Process inner hole is tight, end face is tight, double acting force, The clamping force is 2-3 times that of ordinary fixture. 	Ordinary expansion sleeve has low hardness and thin wall. 
Effective chip prevention	Rubber vulcanized full seal 	Gap chip storage 

Lathe fixture-

Internal expansion fixture

HJ Series Rubber Fixture



PRODUCT ADVANTAGES

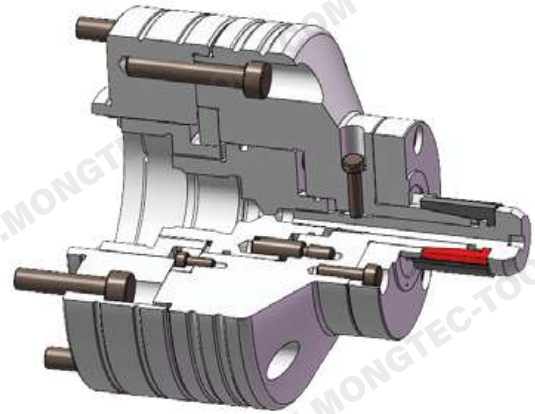
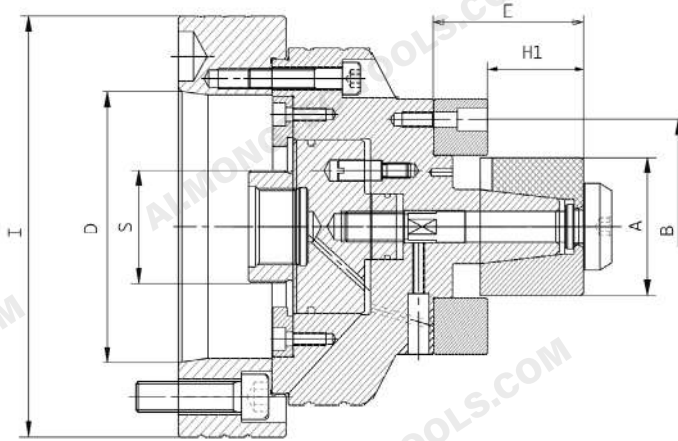
- Suitable for machining blind hole parts
- Segmented clamping body, optional equipped with airtight detection and central water outlet function.
- High precision, $\leq 0.01\text{mm}$
- The positioning block can be customized according to the size of the customer's workpiece.
- Suitable for standard spindle nose interface
- Rubber vulcanization process, waterproof and chip-proof
- Process bulk carburizing quenching, cryogenic treatment, quenching hardness HRC58-62

Specifications and models	Clamping range(mm)	Clamp force (KN)	B (mm)	I (mm)	E (mm)	H1 (mm)	S (mm)	D (mm)	MAX RPM (mm)	Remarks
HJ2000XXS	8-13	42	53(3-M5)	140-165	44	8	M30*1.5	Connecting different flanges	6,000	
HJ2000XS	13-19	42	53(3-M5)	145-165	47.5	14			6,000	
HJ2000X	16-21	42	57(3-M5)	145-165	49.5	15			6,000	
HJ2000	20-28	42	70(3-M6)	145-165	60.5	21			6,000	
HJ2100	26-38	42	75(3-M6)	145-165	66.5	25			5,000	
HJ2200	36-54	85	90(3-M6)	160-210	82.5	40			5,000	
HJ2300	50-80	105	104(3-M6)	160-210	89.5	44.5			5,000	
HJ2400	69-100	150	124(3-M6)	160-210	100	52.5			5,000	
HJ2500	100-130	150	196(6-M8)	160-210	114	48			4,500	
HJ2600	130-160	150	200(6-M8)	179-280	123	56			3,500	
HJ2700	160-192	150	216(6-M8)	235-280	190	65			3,500	

Specifications and dimensions are for reference only and subject to change without notice. Please confirm the latest specifications before ordering.

Lathe fixture- Internal expansion fixture

HN Series Rubber Fixture



PRODUCT ADVANTAGES

- Suitable for machining through-hole parts
- Segmented clamping body, optional equipped with airtight detection and central water outlet function.
- High precision, $\leq 0.01\text{mm}$
- The positioning block can be customized according to the size of the customer's workpiece.
- Suitable for standard spindle nose interface
- Rubber vulcanization process, waterproof and chip-proof
- Process bulk carburizing quenching, cryogenic treatment, quenching hardness HRC58-62

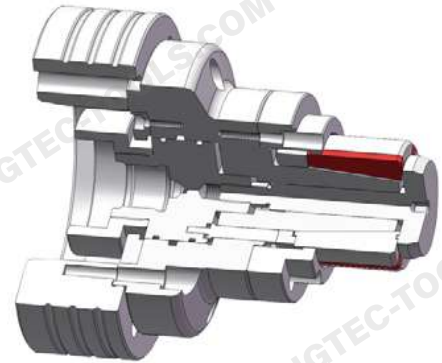
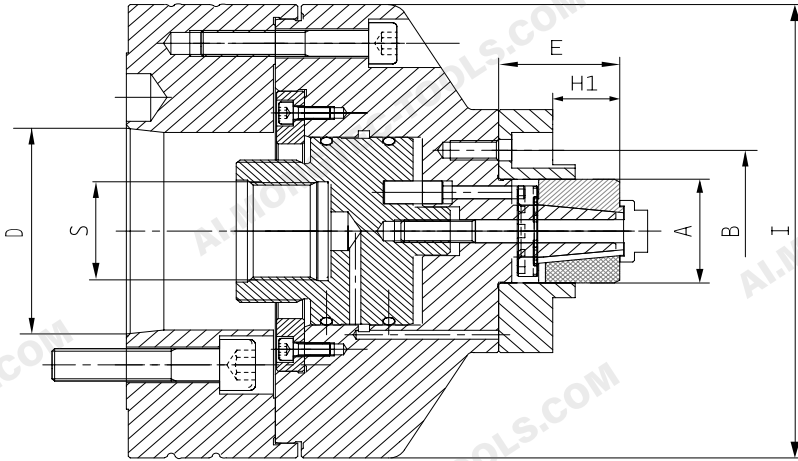
Specifications and models	Clamping range(mm)	Clamp force (KN)	B (mm)	I (mm)	E (mm)	H1 (mm)	S (mm)	D (mm)	MAX RPM (mm)	Remarks
HN3000	20-28	42	62(3-M6)	140-165	32.5	22	M30*1.5	Connecting different flanges	6,000	
HN3100	26-38	42	65(3-M6)	140-165	40	26			6,000	
HN3200	36-54	85	74(3-M6)	160-210	61	43			6,000	
HN3300	50-80	105	94(3-M6)	160-210	70	49			6,000	
HN3400	70-120	100	101(3-M6)	160-210	80	59			5,000	
HN3500	100-130	140	151(3-M8)	160-210	104	76			4,500	
HN3600	130-160	150	176(3-M8)	179-280	112	84			3,500	
HN3700	160-200	150	176(3-M8)	235-280	115	89			3,500	

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Lathe fixture-

Internal expansion fixture

HK Series Rubber Fixture



PRODUCT ADVANTAGES

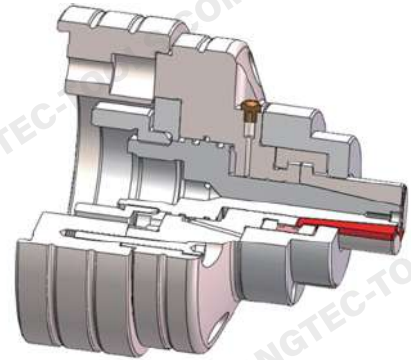
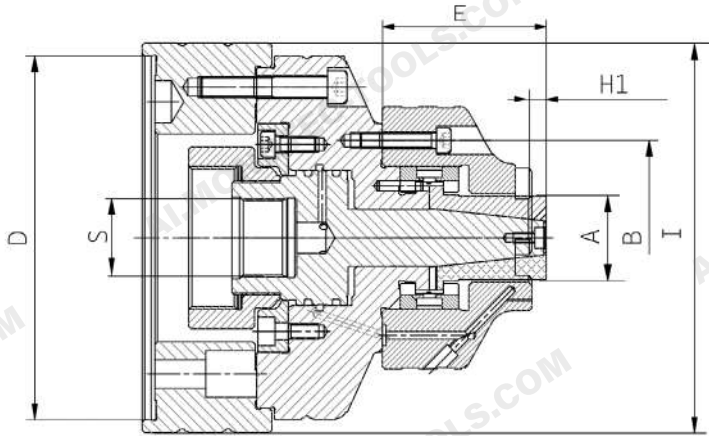
- Suitable for machining through-hole parts (its structure is similar to HN series)
- Segmented clamping body, optional equipped with airtight detection and central water outlet function.
- High precision, $\leq 0.01\text{mm}$
- The positioning block can be customized according to the size of the customer's workpiece.
- Suitable for standard spindle nose interface
- Rubber vulcanization process, waterproof and chip-proof
- Process bulk carburizing quenching, cryogenic treatment, quenching hardness HRC58-62

Specifications and models	Clamping range(mm)	Clamp force (KN)	B (mm)	I (mm)	E (mm)	H1 (mm)	S (mm)	D (mm)	MAX RPM (mm)	Remarks
HK1000	20-28	42	50(3-M6)	140-165	32.5	22	M30*1.5	Connecting different flanges	6,000	
HK1100	26-38	42	55(3-M6)	140-166	40	26			6,000	
HK1200	36-54	85	78(3-M6)	160-210	61	43			6,000	
HK1300	50-80	105	80(3-M6)	160-210	70	49			6,000	
HK1400	70-120	110	109(3-M6)	160-210	80	59			5,000	
HK1500	100-130	140	113(3-M8)	160-210	104	76			4,500	
HK1600	130-160	150	156(3-M6)	179-280	112	84			3,500	
HK1700	160-200	150	176(3-M10)	235-280	115	89			3,500	

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Lathe fixture- Internal expansion fixture

HJ Series Vulcanized Clamping Devices(XZL)



PRODUCT ADVANTAGES

- Suitable for machining thin-walled and deformable parts.
- The rubber expansion sleeve is clamped radially without axial movement.
- The expansion sleeve is pushed forward by the taper mandrel to make the expansion sleeve open, and there is no back tension.
- Suitable for machining lathe vice spindle.

Specifications and models	Clamping range(mm)	Clamp force (KN)	B (mm)	I (mm)	E (mm)	H1 (mm)	S (mm)	D (mm)	MAX RPM (mm)	Remarks
HJ2000XXS(W)	8-13	42	53(3-M5)	140-165	45.5	8	M30*1.5	Connecting different flanges	6,000	
HJ2000XS(W)	13-19	42	53(3-M5)	145-165	40	14			6,000	
HJ2000X(W)	16-21	42	57(3-M5)	145-165	47.5	15			6,000	
HJ2000(W)	20-28	42	70(3-M6)	145-165	58.5	21			6,000	
HJ2100(W)	26-38	42	70(3-M6)	145-165	64.5	25			5,000	
HJ2200(W)	36-54	85	90(3-M6)	160-210	80.5	40			5,000	
HJ2300(W)	50-80	105	104(3-M6)	160-210	87.5	44.5			5,000	
HJ2400(W)	69-100	150	124(3-M6)	160-210	97.5	52.5			5,000	
HJ2500(W)	100-130	150	196(6-M8)	160-210	112	48			4,500	
HJ2600(W)	130-160	150	200(6-M8)	179-280	121	56			3,500	
HJ2700(W)	160-192	150	216(6-M8)	235-280	188	65			3,500	

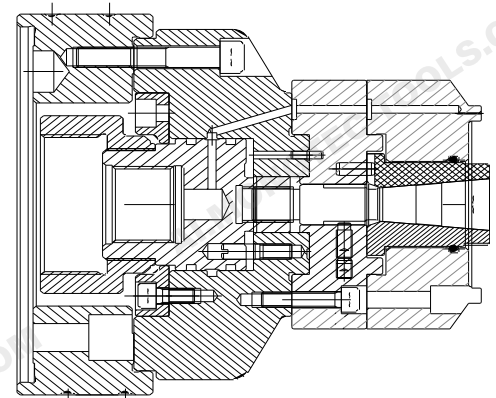
Specifications and dimensions are for reference only and subject to change without notice. Please confirm the latest specifications before ordering.

Lathe fixture-Special internal expansion fixture

T611 Internal Expansion Chuck

PRODUCT ADVANTAGES

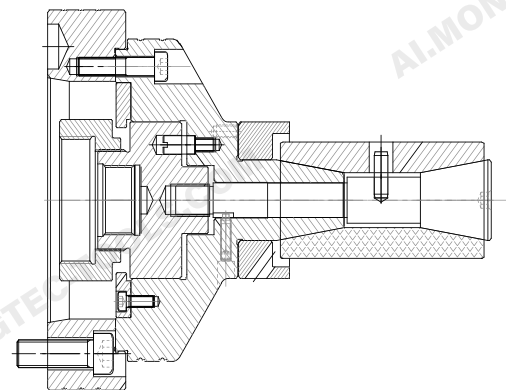
- Suitable for machining thin-walled and deformable parts.
- Segmented clamping body, optional equipped with airtight detection and central water outlet function.
- High precision, $\leq 0.01\text{mm}$
- The positioning block can be customized according to the size of the customer's workpiece.
- The rubber expansion sleeve does not move axially.
- Suitable for short tensioning length.
- The pull rod is pulled back to open the expansion sleeve, ensuring no axial movement of the workpiece.



HS Internal Expansion Chuck

PRODUCT ADVANTAGES

- Suitable for machining parts with long inner holes.
- Serialized clamping body, optional equipped with airtight detection and central water outlet function.
- High precision, $\leq 0.01\text{mm}$
- The positioning block can be customized according to the size of the customer's workpiece.



Lathe fixture-Special internal expansion fixture

Tooth-shaped Internal Expansion Chuck

PRODUCT ADVANTAGES

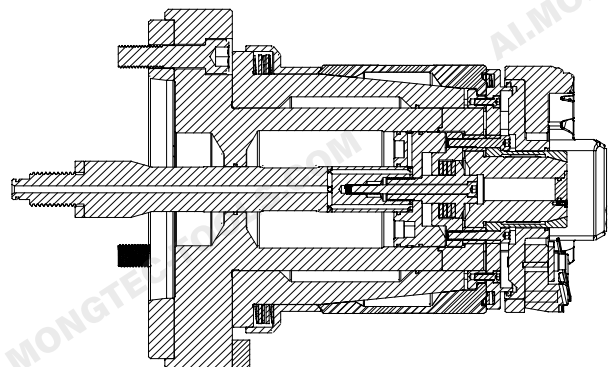
- Suitable for machining splines, gears, sprockets, indexing circles and other parts.
- Segmented clamping body, optional equipped with airtight detection and central water outlet function.
- High precision, $\leq 0.01\text{mm}$
- The positioning block can be customized according to the size of the customer's workpiece.



HS Internal Expansion Chuck (Special customization)

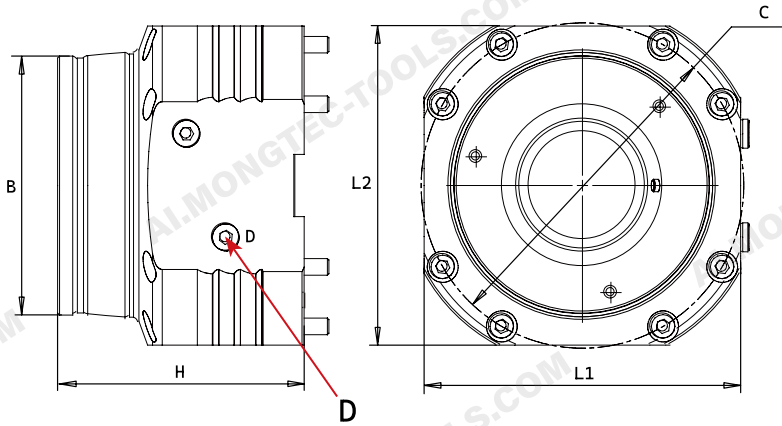
PRODUCT ADVANTAGES

- It is suitable for the processing of parts with two internal hole sizes when the workpiece is simultaneously tensioned.
- Serialized clamping body, optional equipped with airtight detection and central water outlet function.
- High precision, $\leq 0.01\text{mm}$
- The positioning block can be customized according to the size of the customer's workpiece.



Machining center fixture

WK-OPS series external clamping hydraulic clamping fixture



PRODUCT ADVANTAGES

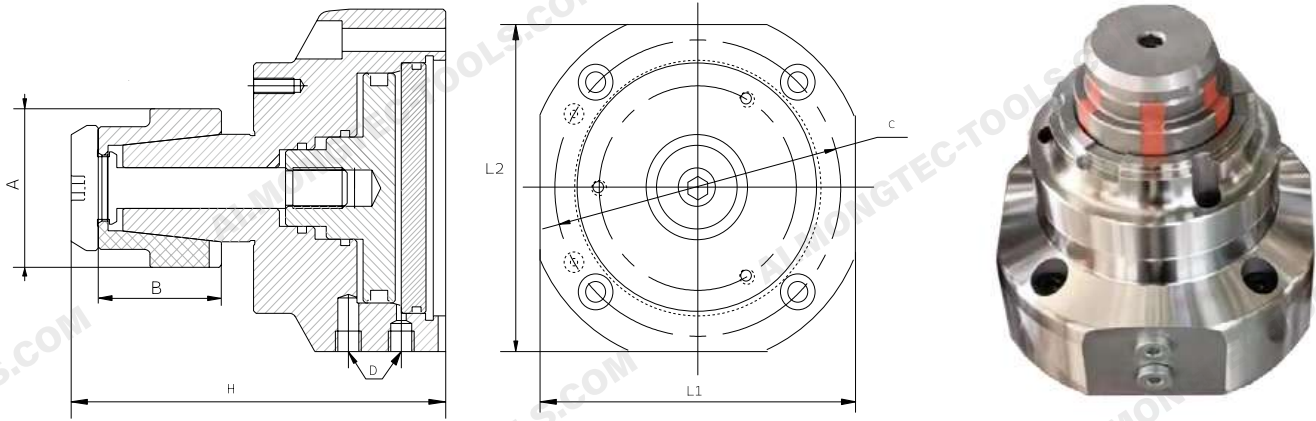
- It is suitable for drilling and milling, and can realize multi-station.
- Segmented clamping body, optional equipped with airtight detection.
- High precision, $\leq 0.01\text{mm}$.
- The positioning block can be customized according to the size of the customer's workpiece.
- Process bulk carburizing quenching, cryogenic treatment, quenching hardness HRC58-62.
- Built-in oil cylinder, compact structure, oil circuit connection can be realized on the bottom or side.

Specifications and models	Clamping range(mm)	Accuracy (mm)	H (mm)	B (mm)	C (mm)	D (mm)	L1 (mm)	L2 (mm)	Remarks
WK-OPS-SK32	5-32	≤ 0.01	95	75	LK $\phi 92(4 \times M8)$	-	80	80	
WK-OPS-SK42	5-42	≤ 0.01	120	125	LK $\phi 157(8 \times M8)$	2-1/8"	154	154	
WK-OPS-SK52	6-52	≤ 0.01	120	125	LK $\phi 157(8 \times M8)$	2-1/8"	154	154	
WK-OPS-SK65	6-65	≤ 0.01	130	130	LK $\phi 180(8 \times M8)$	2-1/8"	174	174	
WK-OPS-SK80	5-80	≤ 0.01	130	130	LK $\phi 194(8 \times M8)$	2-1/8"	186	186	
WK-OPS-SK100	26-100	≤ 0.01	140	140	LK $\phi 240(8 \times M8)$	2-1/8"	229	229	
WK-OPS-SK120	40-120	≤ 0.01	140	140	LK $\phi 270(8 \times M8)$	2-1/8"	268	268	
WK-OPS-SK160	40-160	≤ 0.01	130	130	LK $\phi 320(8 \times M8)$	2-1/8"	320	320	

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Machining center fixture

NZ-OPS series internal expansion hydraulic clamping fixture



PRODUCT ADVANTAGES

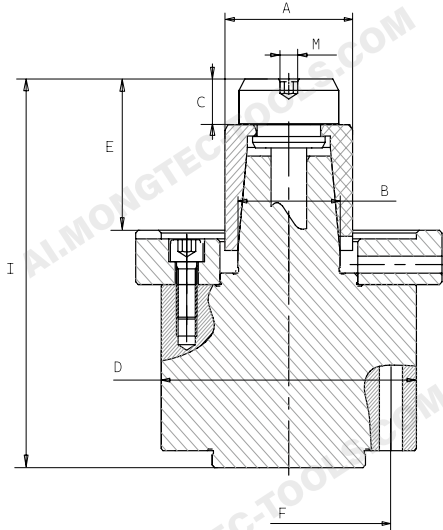
- It is suitable for drilling and milling, and can realize multi-station.
- Segmented clamping body, optional equipped with airtight detection.
- High precision, $\leq 0.01\text{mm}$.
- The positioning block can be customized according to the size of the customer's workpiece.
- Process bulk carburizing quenching, cryogenic treatment, quenching hardness HRC58-62.
- Built-in oil cylinder, compact structure, oil circuit connection can be realized on the bottom or side.

Specifications and models	Clamping range(mm)	Accuracy (mm)	H (mm)	B (mm)	C (mm)	D (mm)	L1 (mm)	L2 (mm)	Remarks
NZ-OPS-8000	20-28	≤ 0.01	120	22	LK $\phi 92(4 \times M8)$	-	80	80	
NZ-OPS-8100	26-38	≤ 0.01	135	26	LK $\phi 157(8 \times M8)$	2-1/8"	154	154	
NZ-OPS-8200	36-54	≤ 0.01	140	43	LK $\phi 157(8 \times M8)$	2-1/8"	154	154	
NZ-OPS-8300	50-80	≤ 0.01	152	49	LK $\phi 180(8 \times M8)$	2-1/8"	174	174	
NZ-OPS-8400	70-125	≤ 0.01	170	60	LK $\phi 194(8 \times M8)$	2-1/8"	186	186	
NZ-OPS-8500	125-160	≤ 0.01	130	76	LK $\phi 240(8 \times M8)$	2-1/8"	229	229	

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Machining center fixture

HMC series machining center hydraulic clamping fixture



PRODUCT ADVANTAGES

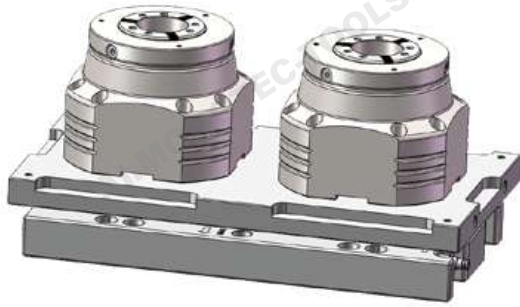
- It is suitable for drilling and milling, and can realize multi-station.
- Segmented clamping body, optional equipped with airtight detection.
- High precision, $\leq 0.01\text{mm}$.
- The positioning block can be customized according to the size of the customer's workpiece.
- Process bulk carburizing quenching, cryogenic treatment, quenching hardness HRC58-62.
- Built-in oil cylinder, compact structure, oil circuit connection can be realized on the bottom or side.

Specifications and models	Clamping range(mm)	Max clamping force	Adm. torque	M (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	I (mm)	Remarks
HMC7000	20-28	0.6	15	5	12.8	8	48	13.5	39.5	119	
HMC7100	26-38	1.3	35	6	16.8	10	56	18.5	43.0	122	
HMC7200	26-54	3.1	90	8	22.8	12.5	70	24.5	45.5	125	
HMC7300	50-80	5.5	180	8	28.8	15	85	30.5	54.0	133	
HMC7400	70-125	7.9	220	12	34.8	18	100	36.5	57.0	136	
HMC7500	125-160	7.9	220	12	34.8	18	100	36.5	57.0	136	

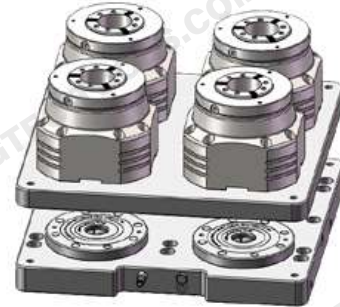
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Machining center fixture

Quick-change base



2-station



4-station

PRODUCT ADVANTAGES

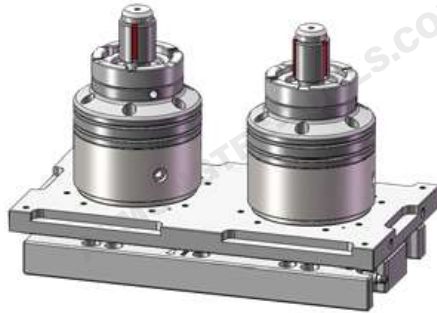
- Ideal for automated clamping
- High precision, $\leq 0.01\text{mm}$
- The replacement is simple, quick and convenient.
- Multiple clamping made possible in the smallest space
- Reduction in machine down-times

Specifications and models	Clamping range(mm)	Accuracy (mm)	Installation size (mm)	2-station		4-station		Remarks
				L1 (mm)	L2 (mm)	L1 (mm)	L2 (mm)	
WK-QCB-SK32	5-32	≤ 0.01	LK $\phi 92(4 \times M8)$	100	200	200	200	
WK-QCB-SK42	5-42	≤ 0.01	LK $\phi 157(8 \times M8)$	180	360	360	360	
WK-QCB-SK52	5-52	≤ 0.01	LK $\phi 157(8 \times M8)$	180	360	360	360	
WK-QCB-SK65	5-65	≤ 0.01	LK $\phi 180(8 \times M8)$	200	400	400	400	
WK-QCB-SK80	16-80	≤ 0.01	LK $\phi 194(8 \times M8)$	220	440	440	440	
WK-QCB-SK100	40-100	≤ 0.01	LK $\phi 240(8 \times M8)$	230	460	-	-	

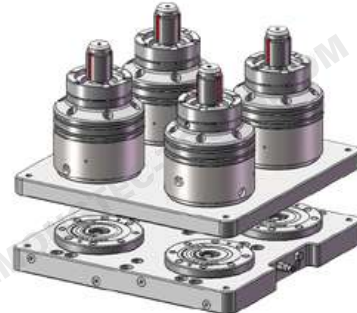
Specifications and dimensions are for reference only and subject to change without notice. Please confirm the latest specifications before ordering.

Machining center fixture

Quick-change base



2-station



4-station

PRODUCT ADVANTAGES

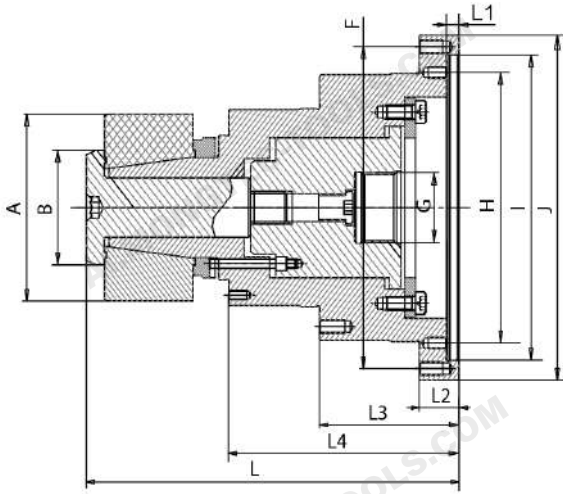
- Ideal for automated clamping
- High precision, $\leq 0.01\text{mm}$
- The replacement is simple, quick and convenient.
- Multiple clamping made possible in the smallest space
- Reduction in machine down-times

Specifications and models	Clamping range(mm)	Accuracy (mm)	Installation size (mm)	2-station		4-station		Remarks
				L1 (mm)	L2 (mm)	L1 (mm)	L2 (mm)	
NZ-QCB-0000	20-28	≤ 0.01	LK $\phi 116(6^*M8)$	100	200	200	200	
NZ-QCB-1000	26-38	≤ 0.01	LK $\phi 116(6^*M8)$	180	360	360	360	
NZ-QCB-1200	36-54	≤ 0.01	LK $\phi 116(6^*M8)$	180	360	360	360	
NZ-QCB-1300	50-80	≤ 0.01	LK $\phi 116(6^*M8)$	200	400	400	400	
NZ-QCB-1400	69-100	≤ 0.01	LK $\phi 116(6^*M8)$	220	440	440	440	
NZ-QCB-1500	100-130	≤ 0.01	LK $\phi 192(6^*M8)$	230	460	-	-	

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Gear fixture

HG series internal expansion gear hobbing fixture



PRODUCT ADVANTAGES

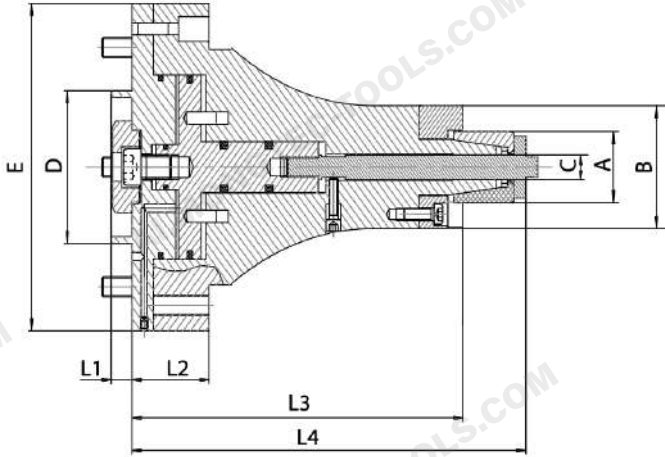
- Suitable for machining through-hole parts (its structure is similar to HN series)
- Segmented clamping body, optional equipped with airtight detection.
- High precision, $\leq 0.01\text{mm}$
- The positioning block can be customized according to the size of the customer's workpiece.
- Standard spindle interface
- Rubber vulcanization process, waterproof and chip-proof
- Process bulk carburizing quenching, cryogenic treatment, quenching hardness HRC58-62

Specifications and models	Collet size	Clamping range(mm)	B (mm)	F (mm)	G (mm)	H (mm)	I (mm)	J (mm)	L1 (mm)	L2 (mm)	L3 (mm)	L4 (mm)	L (mm)	Remarks
HG5000	HK1000	20-28	19	138	M30*1.5	116	131	150	7	15	90	125	175	
HG5100	HK1100	26-38	25	138	M30*1.5	116	131	150	7	15	90	125	178	
HG5200	HK1200	36-54	49	138	M30*1.5	116	131	150	7	15	90	125	199	
HG5300	HK1300	50-70	98	138	M30*1.5	116	131	150	7	15	90	125	215	
HG5400	HK1400	75-120	98	138	M30*1.5	116	131	150	7	15	90	125	215	
HG5500	HK1500	100-130	110	138	M30*1.5	116	131	150	7	15	90	125	230	

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Gear fixture

HM Series Hole clamping gear grinding chuck



PRODUCT ADVANTAGES

- Suitable for machining through-hole parts
- Segmented clamping body, optional equipped with airtight detection.
- High precision, $\leq 0.01\text{mm}$
- The positioning block can be customized according to the size of the customer's workpiece.
- Standard spindle interface
- Rubber vulcanization process, waterproof and chip-proof
- Process bulk carburizing quenching, cryogenic treatment, quenching hardness HRC58-62

Specifications and models	Clamping range(mm)	Clamping length(mm)	B (mm)	C (mm)	D (mm)	E (mm)	L1 (mm)	L2 (mm)	L3 (mm)	L4 (mm)	Remarks
HM6100	26-38	26	39	9.5	75	160	10	40	210	248	
HM6200	36-50	45	50	12.5	75	160	10	40	220	262	
HM6300	46-65	50	56	18.0	75	160	10	40	225	275	
HM6400	60-95	60	70	25.0	75	160	10	40	230	285	
HM6500	90-130	70	105	32.0	75	160	10	40	230	285	

Specifications and dimensions are for reference only and subject to change without notice. Please confirm the latest specifications before ordering.

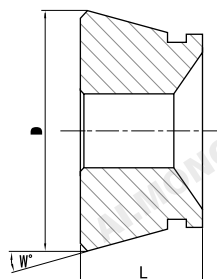
Vulcanized Clamping Devices

fittings

SK series Rubber-elastic collets

PRODUCT ADVANTAGES

- Parallel clamping
- Effective chip prevention
- High precision
- Quick model change
- Wear-resistant
- Compound design
- Long life
- Good elasticity



- S-Type: Designed for finishing smooth internal bores.
- N-Type: Designed for roughing grooved internal bores.

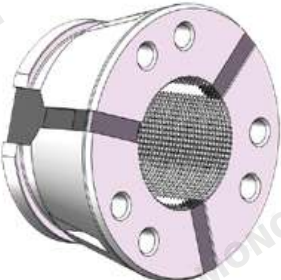
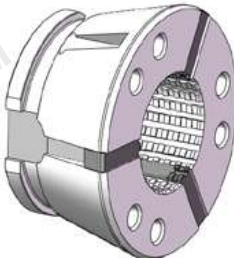
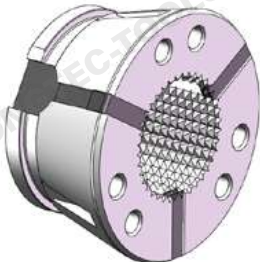
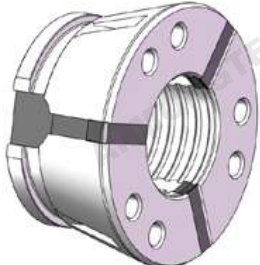
Type	D (mm)	L (mm)	W (mm)	Clamping dia.	Smooth	Serrated	Double serrated
SK32S	57.7	44	12	5-32	5-32	-	-
SK32N	57.7	47	12	5-32	-	8-11	12-32
SK42S	79.2	42	15	5-42	5-42	-	-
SK42N	79.2	47	15	5-42	-	8-11	12-42
SK52S	79.3	46	15	5-52	5-52	-	-
SK52N	79.3	46	15	5-52	-	8-11	12-52
SK65S	99.3	53	15	5-65	5-65	-	-
SK65N	99.3	58	15	5-65	-	8-11	12-65
SK80S	114.5	53	15	5-80	16-80	-	-
SK80N	114.5	53	15	5-80	-	-	16-80
SK100S	144.5	59	15	16-100	40-100	-	-
SK100N	144.5	59	15	16-100	-	-	40-100
SK120S	180	61	15	40-120	40-120	-	-
SK120N	180	61	15	40-120	-	-	70-120
SK160S	225	63	15	45-160	45-160	-	-
SK160N	225	63	15	45-160	-	-	70-160
SK220S	264	52	15	90-220	90-220	-	-
SK220N	264	52	15	90-220	-	-	70-220
SK260S	307	54	15	100-260	100-260	-	-
SK260N	307	54	15	100-260	-	-	70-260

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Vulcanized Clamping Devices

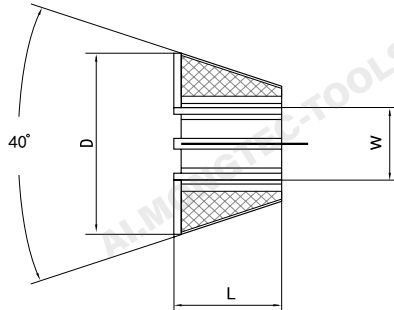
fittings

Design of rubber collet bore

	Smooth Clamping virtually without clamping marks. Application example: Clamping of previously machined contours.
	F-serration Powerful clamping through scoring the small pointed teeth – with clamping marks. Application example: Clamping of raw material.
	Radial and axial grooves Powerful clamping with clamping marks. Application example: Clamping of raw material.
	Z-serration Powerful clamping through deep scoring of the clamping teeth – with clamping marks. Application example: Clamping of raw material [e.g. oxidized, raw material].
	Radial grooves Powerful clamping with clamping marks. Application example: Clamping of raw material.

Vulcanized Clamping Devices fittings

JSN series Rubber- elastic collets



Type	D (mm)	L (mm)	W (mm)	Clamping dia.
JSN7	15.7	30	4.5	2.5-4.5
			6.5	4.5-6.5
JSN12	21.8	30	7	4-7
			10	7-10
JSN20	26.9	15	9	5.4-9
			14	9-14
		11	16	14-16

Customize non-standard collet

- Customers can provide a sample or drawing, and we will design and customize the non-standard collet accordingly.
- Design drawings according to customer's product or requirement,customize non-standard collets.

For example



Vulcanized Clamping Devices fittings

Non-standard rubber collet

		
Square	Hexagonal	Spline
		
Inserted alloy block		Anomaly stepped bore
		
Turning type	Selection example of spring steel collet	Heterotype

Type	Specification	Remark
Square	SK(32/42/52/65/80)-SQU-Dim	
Hexagonal	SK(32/42/52/65/80)-HEX-Dim	
Spline	SK(32/42/52/65/80)-SPL-Dim	
Anomaly stepped bore	SK(32/42/52/65/80)-ANSB-Dim	
Heterotype	SK(32/42/52/65/80)-HET-Dim	
Inserted alloy block	SK(32/42/52/65/80)-INAB-Dim	
Turning type	SK(32/42/52/65/80)-TUPE-Dim	

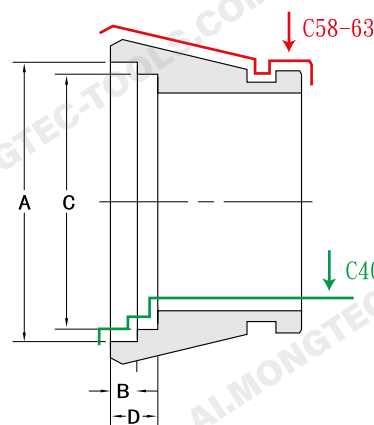
Specifications and dimensions are for reference only and subject to change without notice. Please confirm the latest specifications before ordering.

Vulcanized Clamping Devices fittings

Self-turning type external rubber collet



Turning range

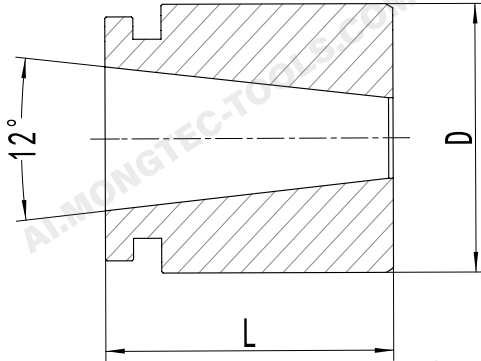


This SK Series chuck (Model: SK52- Φ 10) features a $\Phi 10$ mm inner bore and is designed with high-hardness clamping contact sections for superior wear resistance. It is ideal for clamping soft-surfaced workpieces without causing damage. Additionally, it offers a machinable design, allowing users to process and customize the chuck directly on their own equipment for specific machining needs.

Type	A	B	C	D	Remark
SK32(C)	50	4	45	7	
SK42(C)	63	7	60	10	
SK52(C)	63	7	60	10	
SK65(C)	86	7	77	13	
SK80(C)	101	7	92	13	
SK100(C)	128	7	113	20	
SK120(C)	145	7	125	16	

Vulcanized Clamping Devices fittings

HJ Series Rubber expansion sleeve



PRODUCT ADVANTAGES

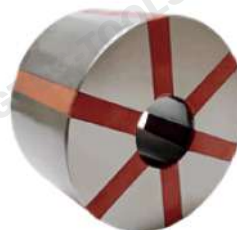
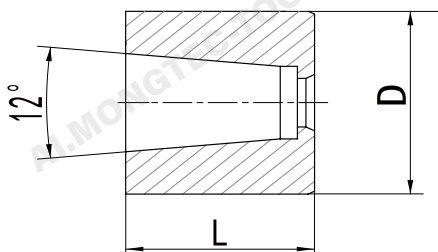
- Composite Design**
Segmented design with rubber bonding, providing high rigidity and flexible coupling.
- Excellent Elasticity**
High-elasticity rubber bonding offers superior expansion/contraction capability; single-side clamping clearance of 0.6mm.
- Extended Tool Life**
Nickel-chromium plating paired with cryogenic treatment achieves a quenching hardness of C58, ensuring a longer service life.
- High Precision**
Single-pass ground on CNC composite grinding machines. The segments expand parallelly, delivering uniform clamping force and stable load distribution.

Type	Taper	Slot	Groove width (mm)	Clamping dia (mm)	L(mm) Length	Clamping stroke (mm)	Model selection
HJ2000XXS	12°	3	2.4	8-13	30	±0.25	HJ2000XXS-D(8-13)
HJ2000XS	12°	3	3	13-19	30	±0.25	HJ2000XS-D(13-19)
HJ2000X	12°	3	3	16-21	31	±0.25	HJ2000X-D(16-21)
HJ2000	12°	3	4	20-28	41	±0.25	HJ2000-D(20-28)
HJ2100	12°	3	6	26-38	46	±0.25	HJ2100-D(26-38)
HJ2200	12°	6	6	36-54	61.5	±0.3	HJ2200-D(36-54)
HJ2300	12°	6	8	50-80	67.5	±0.40	HJ2300-D(50-80)
HJ2400	12°	6	10	69-100	76	±0.50	HJ2400-D(69-100)
HJ2500	12°	8	12	100-130	85	±0.50	HJ2500-D(100-130)
HJ2600	12°	8	12	130-160	94.5	±0.50	HJ2600-D(130-160)
HJ2700	12°	8	12	160-192	90	±0.50	HJ2700-D(160-192)

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Vulcanized Clamping Devices fittings

HN Series Rubber expansion sleeve



PRODUCT ADVANTAGES

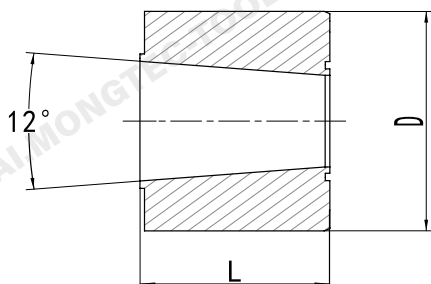
- **Composite Design**
Segmented design with rubber bonding, providing high rigidity and flexible coupling.
- **Excellent Elasticity**
High-elasticity rubber bonding offers superior expansion/contraction capability; single-side clamping clearance of 0.6mm.
- **Extended Tool Life**
Nickel-chromium plating paired with cryogenic treatment achieves a quenching hardness of C58, ensuring a longer service life.
- **High Precision**
Single-pass ground on CNC composite grinding machines. The segments expand parallelly, delivering uniform clamping force and stable load distribution.

Type	Taper	Slot	Groove width (mm)	Clamping dia (mm)	L(mm) Length	Clamping stroke (mm)	Model selection
HN3000	12°	3	4	20-28	24	±0.25	HN3000-D(20-28)
HN3100	12°	3	6	26-38	28	±0.25	HN3100-D(26-38)
HN3200	12°	6	6	36-54	44	±0.25	HN3200-D(36-54)
HN3300	12°	6	8	50-80	50	±0.35	HN3300-D(50-80)
HN3400	12°	6	10	70-120	60	±0.40	HN3400-D(70-120)
HN3500	12°	8	8	100-130	78	±0.50	HN3500-D(100-130)
HN3600	12°	6	10	130-160	86	±0.50	HN3600-D(130-160)
HN3700	12°	8	12	160-200	91	±0.50	HN3700-D(160-200)

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Vulcanized Clamping Devices fittings

HK Series Rubber expansion sleeve



PRODUCT ADVANTAGES

- **Composite Design**
Segmented design with rubber bonding, providing high rigidity and flexible coupling.
- **Excellent Elasticity**
High-elasticity rubber bonding offers superior expansion/contraction capability; single-side clamping clearance of 0.6mm.
- **Extended Tool Life**
Nickel-chromium plating paired with cryogenic treatment achieves a quenching hardness of C58, ensuring a longer service life.
- **High Precision**
Single-pass ground on CNC composite grinding machines. The segments expand parallelly, delivering uniform clamping force and stable load distribution.

Type	Taper	Slot	Groove width (mm)	Clamping dia (mm)	L(mm) Length	Clamping stroke (mm)	Model selection
HK1000	12°	3	6	20-28	24	±0.25	HK1000-D(20-28)
HK1100	12°	3	6	26-38	28	±0.25	HK1100-D(26-38)
HK1200	12°	6	6	36-54	44	±0.35	HK1200-D(36-54)
HK1300	12°	6	8	50-80	50	±0.35	HK1300-D(50-80)
HK1400	12°	6	10	70-120	60	±0.40	HK1400-D(75-120)
HK1500	12°	8	10	100-130	78	±0.50	HK1500-D(100-130)
HK1600	12°	6	10	130-160	86	±0.50	HK1600-D(130-160)
HK1700	12°	8	12	160-200	91	±0.50	HK1700-D(160-200)

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Vulcanized Clamping Devices fittings

Non-standard Rubber expansion sleeve



Customize non-standard clamping bushings

- Users can customize non-standard expansion sleeves with samples and drawings
- Design drawings according to customer's product or requirement, customize non-standard clamping bushings



Gear clamping bushings



With vertical and horizontal slot



Serrated



Hole with weight loss



Back end bonded rubber expansion sleeve



Front end bonded rubber expansion sleeve



Elastic groove vulcanized rubber expansion sleeve

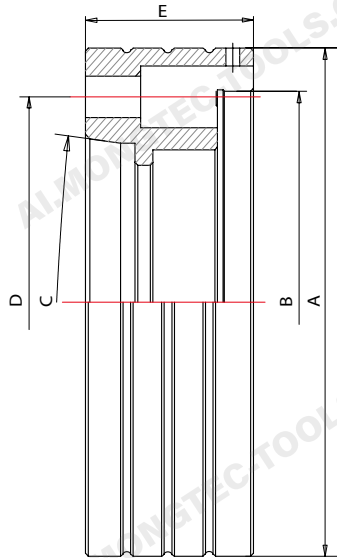


Spring steel slotted expansion sleeve

Specifications and dimensions are for reference only and subject to change without notice. Please confirm the latest specifications before ordering.

Vulcanized Clamping Devices fittings

Flange base



PRODUCT ADVANTAGES

- Hardened flange surface (or: Flange surface induction hardened)
- High precision (runout ≤ 0.01 mm)
- Universal machine tool interface
- Quick and easy changeover
- Precision ground short taper and all reference dimensions

Vulcanized Clamping Devices fittings

The flange of chuck NZ-DZFL

Specifications and models	Corresponding fixture specifications	Spindle nose	Height (mm)	Spigot Diameter (B) (mm)	OD (mm)	D (mm)	Remarks
NZ-DZFL-A4	HK1000~1400 HJ2000X~2400 HN3000~3400	A2-4	40	131	140	LKφ82.6(3*M10)	
NZ-DZFL-A5		A2-5	46	131	140	LKφ104.8(6*M10)	
NZ-DZFL-A6		A2-6	50	131	165	LKφ133.4(6*M12)	
NZ-DZFL-A8		A2-8	50	131	210	LKφ171.4(6*M16)	
NZ-DZFL-A120	HK1000~1400 HJ2000X~2400 HN3000~3400	AP120	50	131	140	LKφ104.8(6*M10)	
NZ-DZFL-A140		AP140	50	131	150	LKφ104.8(6*M10)	
NZ-DZFL-A170		AP170	50	131	180	LKφ133.4(6*M12)	
NZ-DZFL-A220		AP220	50	131	230	LKφ171.4(6*M16)	
NZ-DZFL-A6B	HK1000~1400 HJ2000X~2400 HN3000~3400	A2-6	63.5	219	235	LKφ133.4(6*M12)	
NZ-DZFL-A8B		A2-8	67.5	219	235	LKφ171.4(6*M16)	
NZ-DZFL-A11B		A2-11	73.5	219	235	LKφ235.0(6*M20)	

The flange of chuck WK-DZFL

Specifications and models	Corresponding fixture specifications	Spindle nose	Height (mm)	Spigot Diameter (B) (mm)	OD (mm)	D (mm)	Remarks
WK-SK32-A4	WK-ZT/ZXD-SK32	A2-4	62	112	130	LKφ82.6(3*M10)	
WK-SK32-A5		A2-5	65	112	135	LKφ104.8(6*M10)	
WK-SK42-A4	WK-ZT/ZXD-SK42	A2-4	62	131	145	LKφ82.6(3*M10)	
WK-SK42-A5		A2-5	62	131	145	LKφ104.8(6*M10)	
WK-SK42-A6		A2-6	65	131	165	LKφ133.4(6*M12)	
WK-SK42-120		AP-120	68	131	140	LKφ104.8(6*M10)	
WK-SK52-A5	WK-ZT/ZXD-SK52	A2-5	63	137	150	LKφ104.8(6*M10)	
WK-SK52-A6		A2-6	61	137	165	LKφ133.4(6*M12)	
WK-SK52-120		AP-120	68	137	150	LKφ104.8(6*M10)	
WK-SK65-A6	WK-ZT/ZXD-SK65	A2-6	66	148	165	LKφ133.4(6*M12)	
WK-SK65-A8		A2-8	68	148	210	LKφ171.4(6*M16)	
WK-SK65-140		AP-140	68	148	160	LKφ104.8(6*M10)	
WK-SK80-A6	WK-ZT/ZXD-SK80	A2-6	66	167	180	LKφ133.4(6*M12)	
WK-SK80-A8		A2-8	68	167	210	LKφ171.4(6*M16)	
WK-SK100-A6	WK-ZT/ZXD-SK100	A2-6	67	193	205	LKφ171.4(6*M16)	
WK-SK100-A8		A2-8	70	193	210	LKφ171.4(6*M16)	
WK-SK100-170		AP-170	71.5	193	280	LKφ235.0(6*M20)	

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Vulcanized Clamping Devices fittings

Turning fixture



Type	Specification	Remarks
SK32	TF/SK32	
SK42	TF/SK42	
SK52	TF/SK52	
SK65	TF/SK65	
SK80	TF/SK80	
NGT60/105	TF/NGT60/105	
EK68/93/110	TF/EK68/93/110	

- Install and tighten the self-propelled chuck and ring, then machine the inner bore area.

Manual changing Devices



Type	Specification	Remarks
SK32	TF/SK32	
SK42	TF/SK42	
SK52	TF/SK52	
SK65	TF/SK65	
SK80	TF/SK80	
NGT60/105	TF/NGT60/105	
EK68/93/110	TF/EK68/93/110	

Pneumatic changing Devices



Type	Specification	Remarks
SK100	PC/SK100	
SK120	PC/SK120	
SK160	PC/SK160	

Clamping solution

Expansion sleeve solutions

		
Toothed rubber expansion sleeve	Motor shell rubber expansion sleeve	Hexagonal rubber expansionsleeve with inner hole taper
		
Screw-in type back-drawn rubber expansion sleeve	Step rubber expansion sleeve	Large diameter expansion sleeve

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Clamping solution

Rubber collet clamping solution

		
Front position (Bore clamping fixture)	Rectangular rubber collet	Special rubber collet
		
Special rubber collet for sprocket	Extended rubber collet	Special rubber collet

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Clamping solution

Solution of fixture for internal expansion lathe

		
Front position (Bore clamping fixture)	Sealing glue internal expansion fixture at front end of expansion sleeve	Non-standard support (internal expansion fixture)
		
With ribbed pin (Internal expansion fixture)	Angular positioning internal expansion fixture	Non-standard support (internal expansion fixture)

Clamping solution

Internal expansion fixture clamping solution

		
Angular positioning internal expansion fixture	HN (internal expansion fixture)	Plunge internal expansion clamp with spring
		
Front angular positioning inward expansion fixture	Double taper inward expansion fixture	Internal expansion fixture
		
Double taper inward expansion fixture	Internal expansion fixture	Internal expansion fixture

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Clamping solution

Turning clamping solution

		
Front rotary pneumatic external fixture	Thin shell (External clamping fixture)	External clamp

Clamping solution

Gear clamping solution

		
Gear shaper fixture	Internal expansion hobbing fixture	Internal expansion gear grinding fixture
		
Internal expansion fixture with angular hobbing	Internal expansion hobbing fixture	Gear shaper fixture
		
Hydraulic gear grinding	Gear shaper fixture	Hydraulic gear grinding

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Clamping solution

Fixture solution for machining center

		
Machining center fixture	Internal expansion centering fixture	Machining center fixture
		
Double taper bore clamping fixture	Machining center fixture	Machining center fixture
		
Multi-station internal expansion hydraulic clamping fixture	Angular positioning internal expansion hydraulic clamping fixture	Internal expansion centering hydraulic seat

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Clamping solution

Fixture solution for machining center

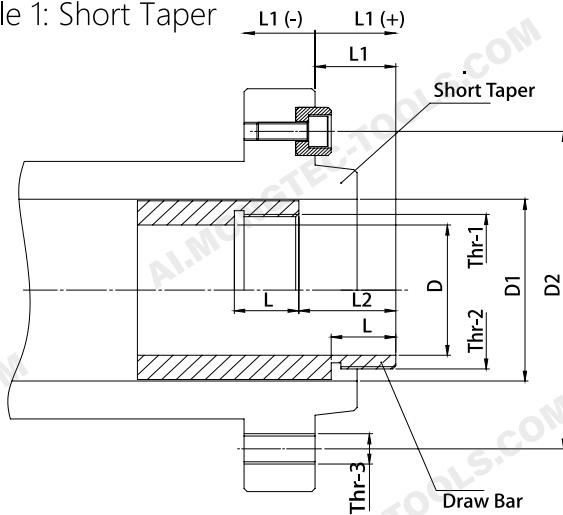
		
Internal expansion hydraulic seat	Internal expansion centering hydraulic seat	Internal expansion hydraulic seat
		
Internal expansion hydraulic seat	Internal expansion centering fixture	Multi-station internal expansion hydraulic clamping fixture

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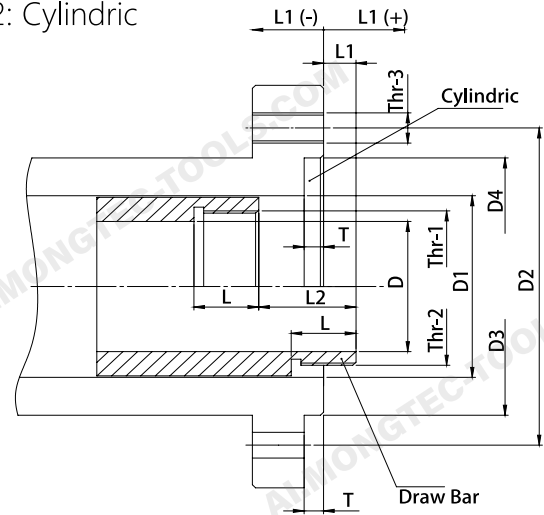
Clamping solution

Installation dimension of spindle

Style 1: Short Taper



Style 2: Cylindric



- Installation Dimensions for Push/Draw-Back Tube
- Please check your machine-spindle dimensions and complete the form below.

Installation Dimensions	
For machine tool	
Style 1 or 2	
Short Taper Size (Style 1)	
Cylindric (Style 2)	
D1	
Thr-3	
Thr-2	
Thr-1	
L2	
D	
L	
D3	
T	
L1 In front position	
D3	
D4	

- Dimension L1 has been clearly marked with a positive/negative sign.
The total number of holes for Thr-3 has been specified.

Clamping solution

Installation steps of Vulcanized Clamping Devices

Rubber collet replacement(quick change in 10 seconds)

				
Fixture with collet	Dismantle collet	The collet is taken out	Replace collet	Complete the collet change

HK(T211)Rubber expansion sleeve replacement (quick change in 30 seconds)

				
Mandrel	Installing expansion sleeve	Screw in pull rod	Installing support plate	Complete the Expansion sleeve change

HJ(T212)Rubber expansion sleeve replacement (quick change in 30 seconds)

				
Mandrel	Installing expansion sleeve	Installing coupling ring	Installing support plate	Complete the Expansion sleeve change



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