



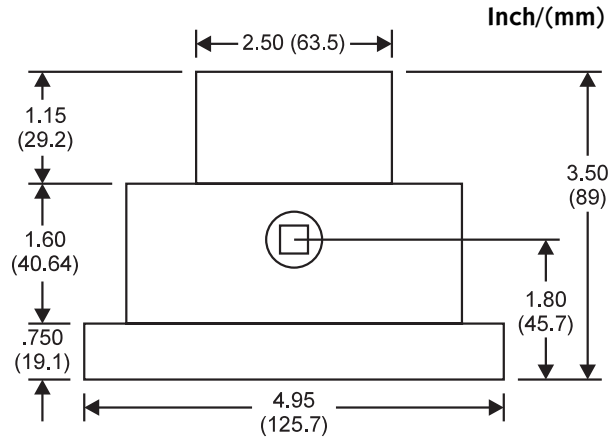
COLLET CHUCKS

MANUAL TYPE FOR 5C, 16C, 3J & 22J COLLETS

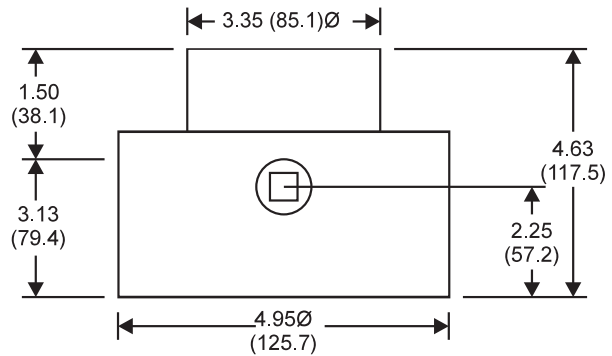
Our manual collet chucks are offered in four types: **5C, 16C, 3J & 22J**. They are designed to be used either stand alone, in multiples or for use on an indexer or rotary table. The collet chucks feature "dead length" holding (with zero part movement), and no "pull back." The collet is closed by turning the cam approximately 90°, using the wrench provided. As the cam rotates, the collet sleeve is lifted closing the collet. The collet remains stationary so that linear tolerances can be maintained. Six mounting holes are provided (5/16" on a 4.12" bolt circle.)



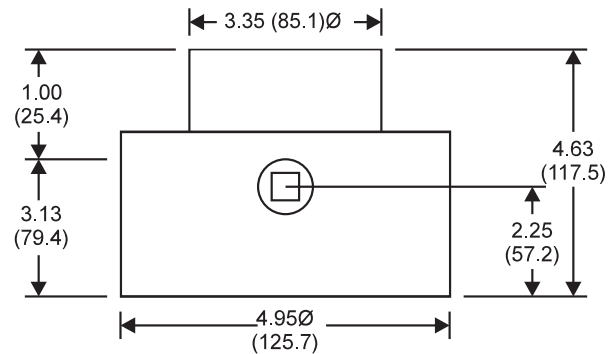
5C style chuck (PN# ACSU-5C)



16C style chuck (PN# ACSU-16C)



3J style chuck (PN# ACSU-3J)



NOTE: 22J collet chuck is available for larger collets with up to 2 1/4" capacity.

WORKHOLDING

COLLET CHUCKS



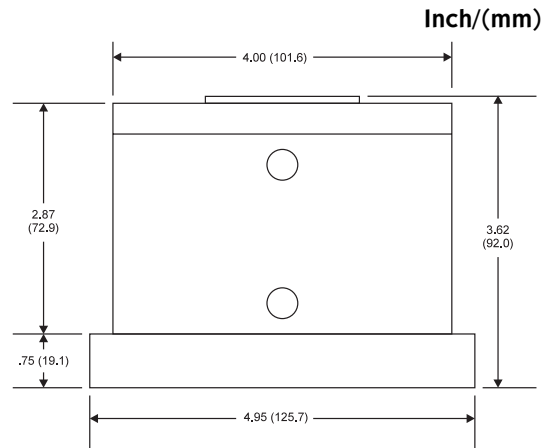
GENERAL INFORMATION

Air Operated (High Torque) for 5C, B42 & B60 Collets

The term "high torque" refers to an air mechanical collet closer which uses an air cylinder and mechanical advantage to collapse the collet. This cylinder uses air pressure to move the piston, which actuates a series of balls and incline planes to increase the force of air pressure against the collet sleeve. The air against the piston in this collet closer does not directly hold the part, but compresses the balls between the inclined planes. The movement of the balls between the inclined planes lifts the collet sleeve, collapsing the collet. This increases the holding power to well above that attained by simple air pressure. The diameter of the piston can be considerably smaller while achieving the same clamping force of a simple air cylinder with a much larger piston. The part to be machined is also held firmly against the base of the fixture and not on a cushion of air.

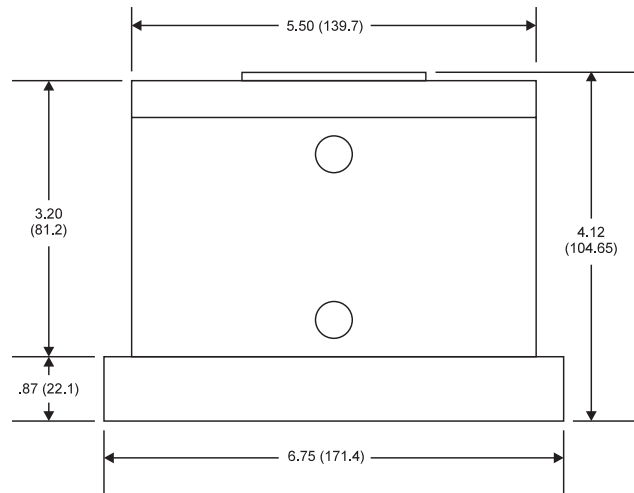
Model# ACHT-5CA

This high torque stationary 5C air collet closer is designed for use on milling, drilling and tapping operations. It can be utilized as single units, or mounted to a plate for multiple operations. They use from 50~100 PSI, depending on the holding power necessary for a particular application.



Model# ACHT-B42A

This high torque stationary air collet closer uses B-42 collets, and has been designed for use on milling, drilling and tapping machines. They can be utilized in a single or multiple fashion.



Inch/(mm)

MODEL #	ACHT-5CA	ACHT-B42A	ACSU-5CA
MAX OPERATING PRESSURE (PSI)	100		
AIR PORTS	1/8" NPTF		
MOUNTING HOLES	Four 5/16" holes on 4.50" bolt circle	Two 3/8" holes on 6.125" bolt circle	Four holes tapped 3/8"-16 on 4.50" bolt circle
WEIGHT lbs. (kg)	6 (2.7)	14 (6.3)	6 (2.7)

Model ACHT-B60A is available for larger collet sizes.

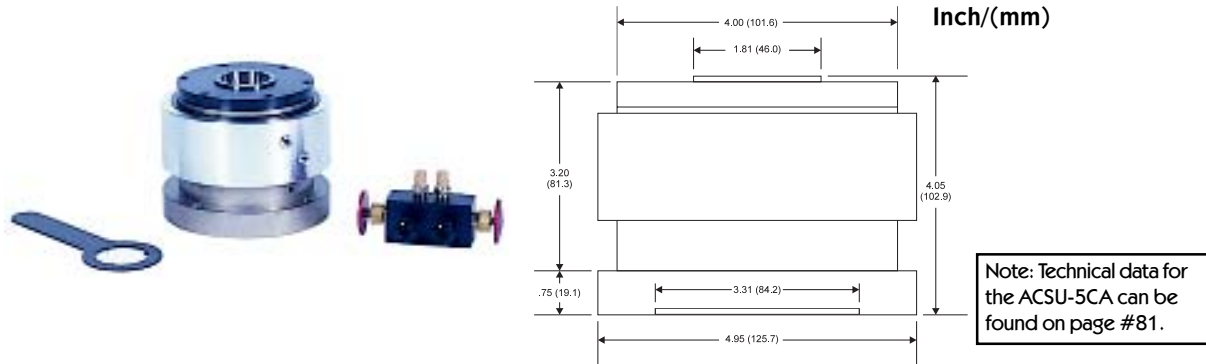
Note: Optional accessories for the ACHT models can be found on page #82.

WORKHOLDING



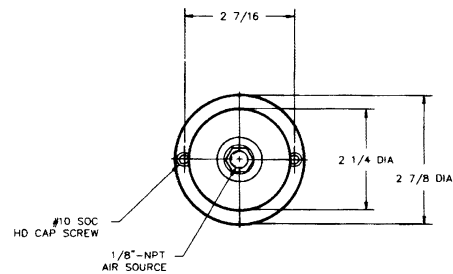
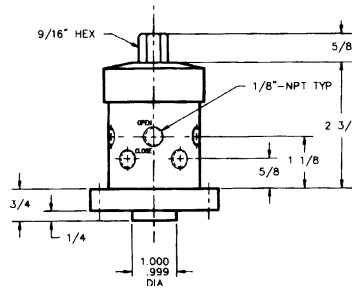
AIR COLLET CLOSER FOR ROTARY TABLE APPLICATIONS (See DMNC) MODEL #ACSU-5CA

This front mounted 5C air operated collet chuck may be used for rotary table and single station applications. The rotary gland remains in place while the air cylinder rotates. This unit comes complete with air valve hoses, fittings and a collet wrench. Note: for use on a DMNC rotary table, a collet chuck adapter plate is required.



COLLET CHUCKS ACCESSORIES FOR ACHT MODELS CENTER CONTROL VALVES

The center control valve has uses for multi-station fixtures of 2,3,4,5,6 or 8 positions. This valve eliminates the need for rotary air couplings and cams to control separate valves, and individual valves for each station. Each time the table is indexed, the holding device being used opens and closes in a pre-determined sequence.



WORKHOLDING

MODEL #	NO. OF STATIONS	OPEN	CLOSED
CCV-01	2	1	1
CCV-02	3	1	2
CCV-03	4	1	3
CCV-04	4	2	2
CCV-05	5	1	4
CCV-06	5	2	3
CCV-07	6	1	5
CCV-08	6	2	4
CCV-09	6	3	3
CCV-10	8	1	7
CCV-11	8	2	6
CCV-12	8	3	5
CCV-13	8	4	4



PN# PV-001
Four way palm valve

"O"-ring kits for all air collet closers are available through our parts department.