

Updating of technical solution

Design no. 400.56770



HYDRAULIC CLAMPING SYSTEM FOR AUTOMATIC MACHINING (TURNING AND THREADING) OF DIN 15401 AND DIN 15402 LIFTING HOOK SHANKS

MAIN FEATURES

- > Self-stirruping effect
- > High clamping force
- > Superior stiffness
- > System balancing
- > Quick retooling among different sizes

Chuck shown in the picture

Outside diameter: 600 mm, with inside relieving system. Realized for size range from no. 8 to no. 32. The same design applies to greater sizes. Hook has to get a mark allowing centering by lathe tailstock. This device chucks the machining piece through 3 simultaneous operations: radial chucking, stop clamping, position balancing. Base group houses chucking tools consisting of:

- central point (option for irregular castings);
- pre-loaded spring units for bent supports and sidelong positioning (centering as well, when central point is not supplied);
- base jaws with circular interchangeable heads, case-hardened, tempered and toothed.

Every part of this chucking group is interchangeable and adjustable on positioning.

This clamping system is assembled ahead of machine spindle and equipped with a plate arranged to house balancing masses.

The device is driven by a standard rotary hydraulic cylinder, set at the rear of lathe spindle.

Use of selected high quality steels, case-hardened and tempered. Inside bushings of sliding columns are in GCUSNI2.



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