



**COLLET  
CHUCK**

QCRL Quick Change Collet Chucks

**QCRL** series

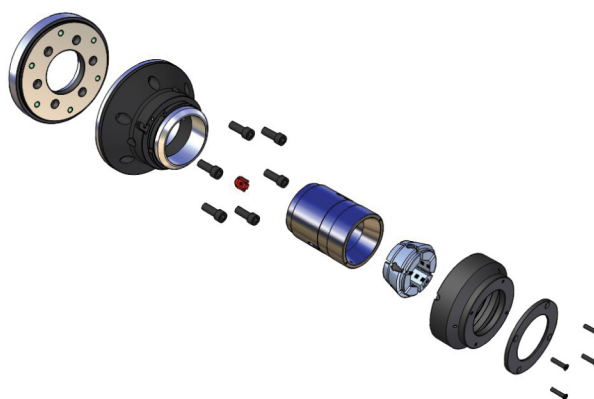
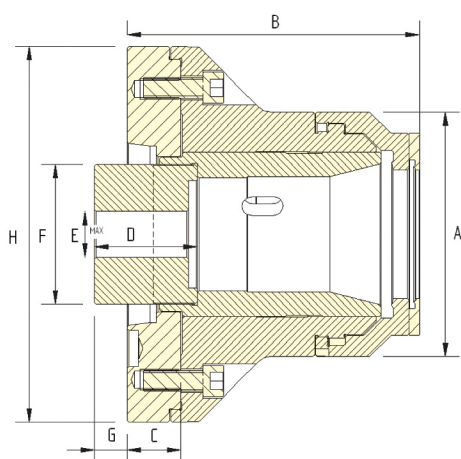


## Standard Features

- Quick change chuck design for first or second operation.
- Ideally suited for use with barfeeders.
- Fixed length collet - no part movement.
- Quick change cap with safety catch.
- Uses varibore, spring and master collets.
- Exceptional accuracy in small package.



Collet Chuck



| Specifications         |                   | QCRL 42(I) | QCRL 42 | QCRL 54  | QCRL 60  |
|------------------------|-------------------|------------|---------|----------|----------|
|                        |                   | Inch       | Din     | Inch     | Din      |
| Gripping Range - Round | Max mm            | 42         | 42      | 54       | 60       |
|                        | Min mm            | 1.6        | 4       | 1.6      | 4        |
| Collet Increment       | mm                | 3          | 2       | 3        | 2        |
| Sleeve Stroke          | mm                | 7          | 7       | 10       | 7        |
| Max Input Force        | kN                | 25         | 25      | 30       | 30       |
| Max Gripping Force     | kN                | 55         | 55      | 60       | 60       |
| Max Speed (r.p.m.)     | min <sup>-1</sup> | 7100       | 7100    | 6300     | 6300     |
| Net Weight             | kg                | 13.5       | 13.5    | 29       | 29       |
| Matching Cylinder      |                   | S1246      | S1246   | S1552/75 | S1552/75 |
| Collet Ref             | Varibore          | D-850      | D-673   | D-120    | D-677    |
|                        | Spring            | D-286      | D173E   | D-853    | D185E    |

| Dimensions | QCRL 42(I)/QCRL 42 |     |     | QCRL 54   |     |      |      | QCRL 60   |      |      |      |
|------------|--------------------|-----|-----|-----------|-----|------|------|-----------|------|------|------|
| Mount      | 140 x 6            | A5  | A6  | 170 x 6   | A5  | A6   | A8   | 170       | A5   | A6   | A8   |
| A          | 113                |     |     | 143       |     |      |      | 143       |      |      |      |
| B          | 149                | 143 | 143 | 181       | 190 | 175  | 175  | 177       | 186  | 171  | 171  |
| C          | 31.5               | 25  | 25  | 36.5      | 45  | 31.5 | 31.5 | 36.5      | 46.5 | 31.5 | 31.5 |
| D          | 60                 |     |     | 60        |     |      |      | 60        |      |      |      |
| E Max      | M58 x 1.5          |     |     | M75 x 1.5 |     |      |      | M75 x 1.5 |      |      |      |
| F          | 65                 |     |     | 82        |     |      |      | 82        |      |      |      |
| G Max      | 17                 | 23  | 23  | 15        | 25  | 21   | 21   | 14        | 5    | 21   | 21   |
| G Min      | 10                 | 16  | 16  | 5         | 15  | 11   | 11   | 7         | -2   | 14   | 14   |
| H          | 165                | 165 | 165 | 220       | 220 | 220  | 220  | 220       | 220  | 220  | 220  |

\*QCRL54 and 60 models can be supplied with additional 42mm Inch and Din collet reduction sleeves and caps. See accessory page for details and part numbers.