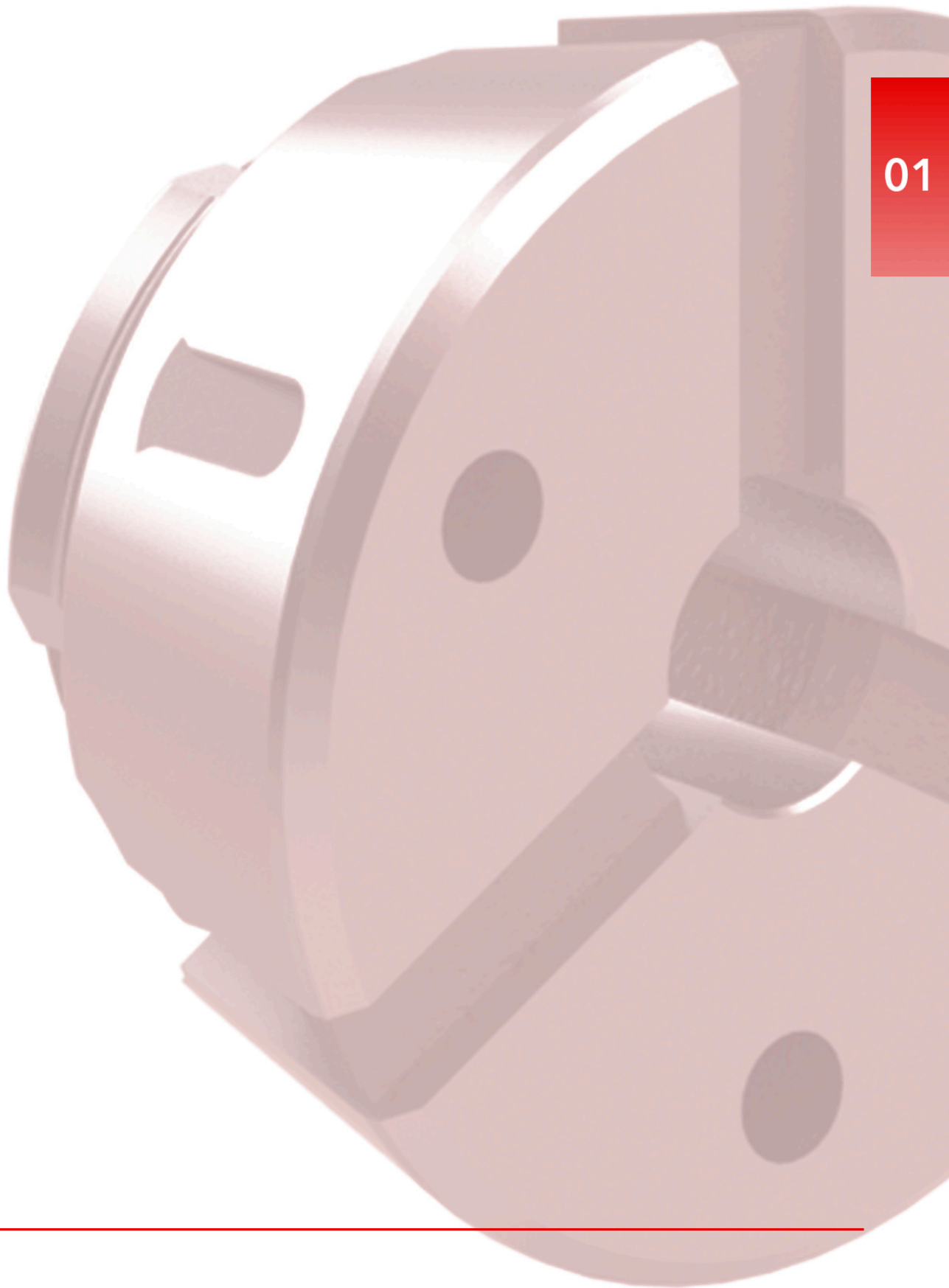
KORRETTO®

Clamping Head and Chuck

Collets · Chucks · Expanding

01



KORRETTO

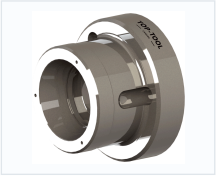
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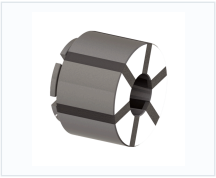
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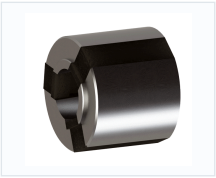
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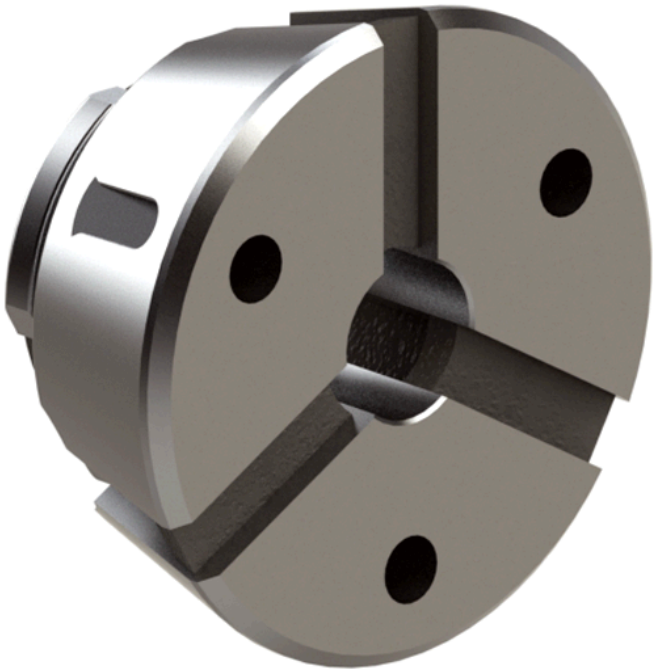
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Segmented Clamping Head

KORRETTO Segmented Clamping Heads, also called rubber-flex collets, grip the outside of round, square, hexagonal or matched-profile workpieces.

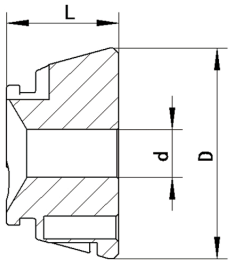


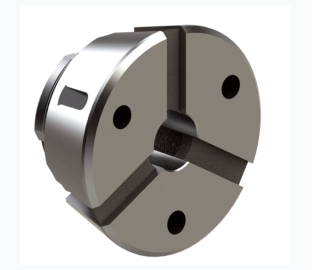
Product notes

- S: smooth bore
- R and RL: grooved bores
- EM: machinable head

Segmented Clamping Head

Dimensions and technical data

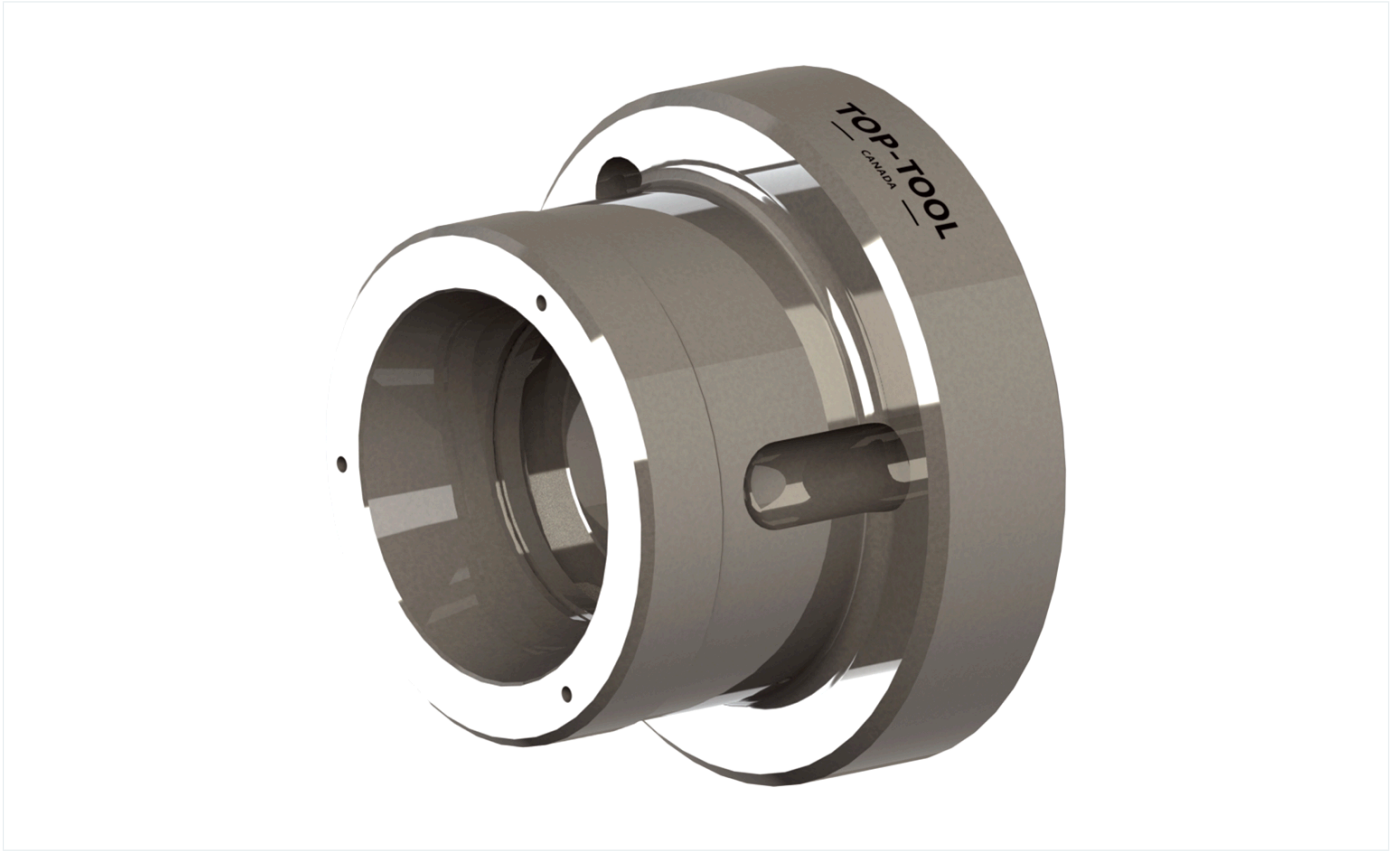




Type	Code	L (mm)	D (mm)	d (Round) (mm)	d (Square) (mm)	d (Hex) (mm)
32	32S	44	57.7	6–32	7–27	7–22
32	32R	44	57.7	8–32	8–27	8–22
32	32RL	44	57.7	11–32	—	—
32	32EM	44	57.7	4–32	—	—
42	42S	42	79.3	6–42	7–38	7–30
42	42R	42	79.3	8–42	8–38	8–30
42	42RL	42	79.3	11–42	—	—
42	42EM	42	79.3	4–42	—	—
52	52S	46	79.3	6–52	7–45	7–36
52	52R	46	79.3	8–52	8–45	8–36
52	52RL	46	79.3	11–52	—	—
52	52EM	46	79.3	4–52	—	—
65	65S	53	99.5	6–65	7–56	7–46
65	65R	53	99.5	8–65	8–56	8–46
65	65RL	53	99.5	11–65	—	—
65	65EM	53	99.5	4–65	—	—
80	80S	53	114.5	6–80	7–68	7–56
80	80R	53	114.5	8–80	8–68	8–46
80	80RL	53	114.5	11–80	—	—
80	80EM	53	114.5	4–80	—	—
100	100S	59	144.5	40–100	—	—
100	100R	59	144.5	40–100	—	—
100	100RL	59	144.5	40–100	—	—
100	100EM	59	144.5	40–100	—	—

Through-Hole Clamping Head Chuck

The KORRETTO Through-Hole Clamping Head Chuck is a quick-change collet chuck for CNC lathe workholding.

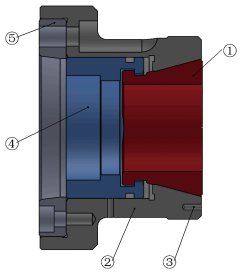


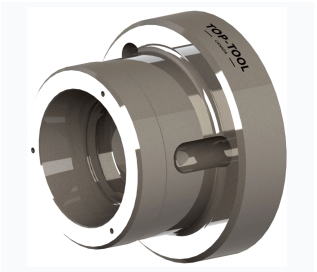
Product notes

- Through access
- Replaceable gripping head
- Broad contact

Through-Hole Clamping Head Chuck

Dimensions and technical data





Specification	Stroke (mm)	Maximum Draw Force (kN)	Maximum Radial Clamping Force (kN)	Max. clamp Diameter (mm)	Recommended Workpiece Tolerance (mm)	Maximum Speed (r/min)
32	2.5+3	25	70	32	±0.3	8000
42	2+2.5	35	80	42	±0.5	7000
52	2+2.5	40	94	52	±0.5	7000
65	2+2.5	45	105	65	±0.5	6000
80	2+2.5	50	115	80	±0.5	5500
100	3+5	65	150	100	±1.0	5000
125	3+6	70	165	125	±1.0	3200
160	3+3	100	235	160	±1.0	3200

High-Speed Pneumatic Clamping Head Chuck

The High-Speed Pneumatic Clamping Head Chuck (JAB-SK) is a pneumatic collet chuck for fast, repeated external clamping with SK rubber-flex clamping heads.

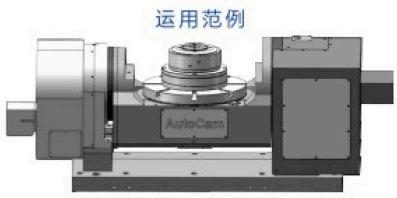


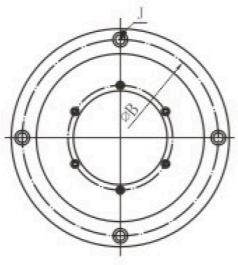
Product notes

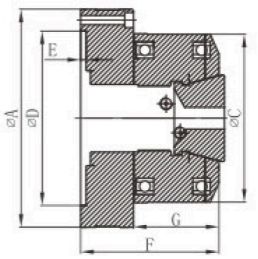
- Pneumatic actuation
- Four chuck sizes
- Pull-back clamping

High-Speed Pneumatic Clamping Head Chuck

Dimensions and technical data







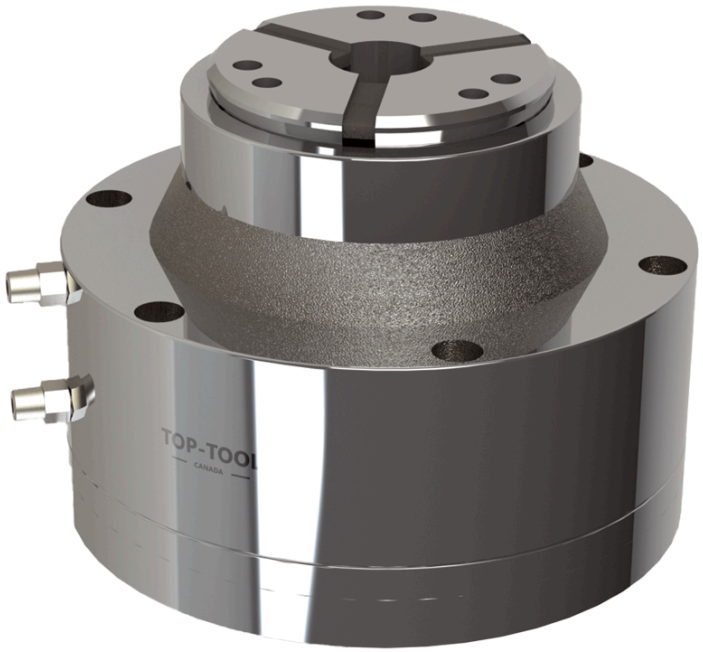


Model	ØA	ØB	ØC	ØD	E	F	G	J
JAB-SK32	170	147	118	130	5	115	61	4-M8 CSK holes
JAB-SK42	180	160	134	140	5	115	69	4-M8 CSK holes
JAB-SK52	200	180	154	160	5	127	79	4-M8 CSK holes
JAB-SK65	210	190	175	170	5	125	73	4-M8 CSK holes

Model	Maximum Speed (rpm)	Piston stroke (mm)	Clamp stroke (mm)	Clamping Torque (N·m)	Working Pressure (kg/cm²)	Clamping Range	Collet Used	Clamping Method
JAB-SK32	3000	4	1.5–2	35	3–8	Ø5–32	SK32	Pull-Back
JAB-SK42	2500	4	1.5–2	20	3–8	Ø5–42	SK42	Pull-Back
JAB-SK52	2500	4	1.5–2	25	3–8	Ø5–52	SK52	Pull-Back
JAB-SK65	2000	4	1.5–2	35	3–8	Ø5–65	SK65	Pull-Back

Vertical Fixed Hydraulic Clamping Head Chuck

The Vertical Fixed Hydraulic Clamping Head Chuck holds the workpiece at a stationary machining station.

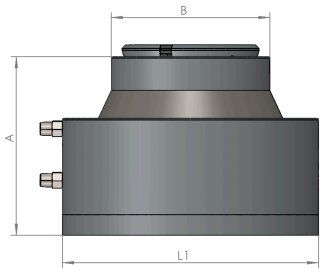


Product notes

- Stationary workholding
- Hydraulic clamp and release
- Replaceable clamping head

Vertical Fixed Hydraulic Clamping Head Chuck

Dimensions and technical data





Model	A (mm)	B (mm)	L1 (mm)	Catalog accuracy (mm)	Mounting bolts	Clamping range (mm)
52	120	125	154	0.01	PCD Ø157 (M8)	6–52
65	130	130	174	0.01	PCD Ø180 (M8)	6–65
80	130	160	186	0.01	PCD Ø194 (M8)	16–80
100	140	220	229	0.01	PCD Ø240 (M8)	26–100

Blind-Hole Segmented Mandrel System

KORRETTO Blind-Hole Segmented Mandrel System is used for internal clamping of workpieces with blind holes, semi-through holes or internal locating surfaces.

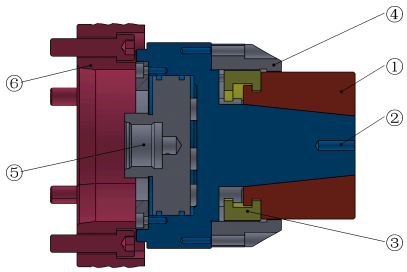


Product notes

- Internal expansion clamping: Holds the workpiece from the inside diameter.
- Blind-hole application: Suitable for blind-hole and semi-through-hole parts.
- Rubber-Flex Segmented Clamping Bushing: Hardened steel segments connected by vulcanized rubber for parallel expansion and distributed internal

Blind-Hole Segmented Mandrel System

Dimensions and technical data

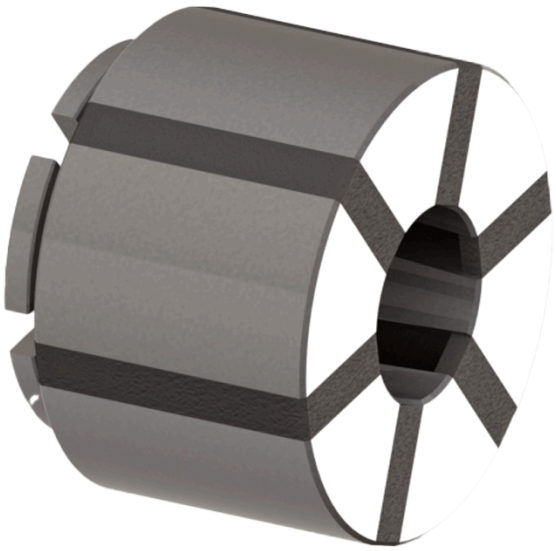




Model	Stroke (mm)	Max. Pulling Force (kN)	Max. Radial Clamping Force (kN)	Clamping Range (mm)	Recommended Workpiece Tolerance (mm)	Max. Speed (r/min)
A0	1.5+1.5	10	42	8–13	±0.2	7000
A1	1.5+2	10	42	13–19	±0.25	7000
A2	1.5+2	10	42	16–21	±0.25	7000
0	1.5+2	10	42	20–28	±0.25	7000
1	1.5+2	10	42	26–38	±0.25	7000
2	1.5+2	20	85	36–54	±0.25	7000
3	2+2.5	25	105	50–80	±0.35	6000
4	2.5+3	35	150	69–100	±0.4	6000
5	3+3	40	170	100–130	±0.5	5000
6	3+3	40	170	130–160	±0.5	4000
7	3+4	45	190	160–190	±0.5	3200

Segmented Clamping Bushing for Blind-Hole Clamping

The Segmented Clamping Bushing for Blind-Hole Clamping (SB2 series) is the replaceable gripping element for a matching Blind-Hole Segmented Mandrel System.

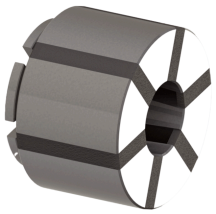


Product notes

- Blind-hole clamping
- Replaceable SB2 bushing
- Steel gripping segments

Segmented Clamping Bushing for Blind-Hole Clamping

Dimensions and technical data



Model	Clamping diameter / range (mm)	Recommended workpiece tolerance (mm)	Maximum clamping length (mm)	Size increment (mm)
SB2A0	8	±0.2	6	0.5
SB2A0	8.5	±0.2	6.7	0.5
SB2A0	9	±0.2	7.4	0.5
SB2A0	9.5	±0.2	8.1	0.5
SB2A0	10	±0.2	8.8	0.5
SB2A0	10.5	±0.2	9.4	0.5
SB2A0	11	±0.2	10.1	0.5
SB2A0	11.5	±0.2	10.8	0.5
SB2A0	12	±0.2	11.5	0.5
SB2A0	12.5	±0.2	12.2	0.5
SB2A0	13	±0.2	12.9	0.5
SB2A1	13–19	±0.25	14	0.5
SB2A2	16–21	±0.25	15	0.5
SB200	20–28	±0.25	21	0.5
SB210	26–38	±0.25	25	0.5
SB220	36–54	±0.25	40	0.5
SB230	50–80	±0.35	44.5	0.5
SB240	69–100	±0.4	52.5	0.5
SB250	100–130	±0.5	53	1
SB260	130–160	±0.5	61	1
SB270	160–190	±0.5	63	1

Segmented Clamping Bushing for Through-Hole Clamping

The Segmented Clamping Bushing for Through-Hole Clamping (SB1 series) is a replaceable internal-gripping element for a matching Through-Hole Segmented Mandrel System.

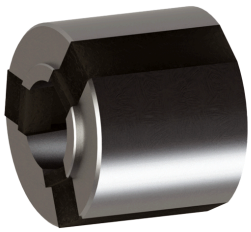


Product notes

- Open-through bores
- SB100-SB170 sizes
- Replaceable gripping element

Segmented Clamping Bushing for Through-Hole Clamping

Dimensions and technical data



Model	Clamping range (mm)	Recommended workpiece tolerance (mm)	Maximum length (mm)	Size increment (mm)
SB100	20–28	±0.25	22	0.5
SB110	26–38	±0.25	26	0.5
SB120	36–54	±0.25	43	0.5
SB130	50–80	±0.35	49	0.5
SB140	69–100	±0.4	59	0.5
SB140	101–120	±0.4	59	1
SB150	100–130	±0.5	86	1
SB160	130–160	±0.5	96	1
SB170	160–200	±0.5	94	1

Through-Hole Segmented Mandrel System

The Through-Hole Segmented Mandrel System holds a workpiece from its bore using a matched SB1 segmented clamping bushing.

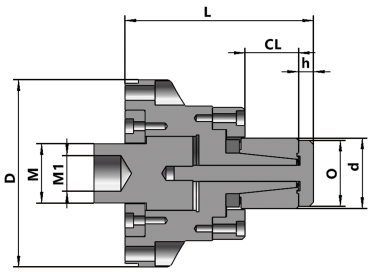


Product notes

- Internal bore clamping
- SB1 segmented bushing
- Pull-back mechanism

Through-Hole Segmented Mandrel System

Dimensions and technical data





Model	D (mm)	L (mm)	O (mm)	h (mm)	Expansion Range d (mm)	M
KB100	139	100	19	7.5	20–28	M44×1.5
KB110	139	110	25	11	26–38	M44×1.5
KB120	139	130	35	10	36–54	M44×1.5
KB130	139	140	49	11	50–80	M44×1.5
KB140	139	155	68	16	69–100 / 101–120	M44×1.5
KB150	230	195	97	16	100–130	M44×1.5
KB160	230	220	125	25	130–160	M44×1.5
KB170	230	245	156	29.5	160–200	M44×1.5

Model	M1	Collet Used	Type	Stroke (mm)	Max. CL (mm)	Recommended Workpiece Tolerance (mm)
KB100	M30×1.5	SB100	Pull-back	1.5+2	22	±0.25
KB110	M30×1.5	SB110	Pull-back	1.5+2	26	±0.25
KB120	M30×1.5	SB120	Pull-back	1.5+2	43	±0.25
KB130	M30×1.5	SB130	Pull-back	2+2.5	49	±0.35
KB140	M30×1.5	SB140	Pull-back	2.5+3	59	±0.4
KB150	M30×1.5	SB150	Pull-back	3+3	86	±0.5
KB160	M30×1.5	SB160	Pull-back	3+3	96	±0.5
KB170	M30×1.5	SB170	Pull-back	3+3	94	±0.5

Clamping Head Chuck with Inner Stop

The Clamping Head Chuck with Inner Stop combines outside-diameter gripping with an inner workpiece stop.

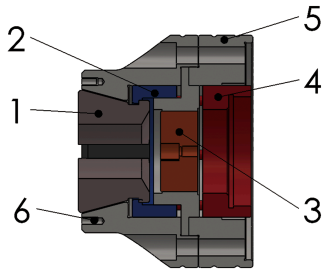


Product notes

- Axial workpiece location
- Outside-diameter gripping
- Short and long shafts

Clamping Head Chuck with Inner Stop

Dimensions and technical data





Specification	Stroke (mm)	Maximum Draw Force (kN)	Maximum Radial Clamping Force (kN)	Max. clamp Diameter (mm)	Recommended Workpiece Tolerance (mm)	Maximum Speed (r/min)
32	2.5+3	25	70	32	±0.3	8000
42	2+2.5	35	80	42	±0.5	7000
52	2+2.5	40	94	52	±0.5	7000
65	2+2.5	45	105	65	±0.5	6000
80	2+2.5	50	115	80	±0.5	5500
100	3+5	65	150	100	±1.0	5000
125	3+6	70	165	125	±1.0	3200
160	3+3	100	235	160	±1.0	3200

Clamping Heads for Multi-Spindle Machines

The KORRETTO clamping-head range for multi-spindle machines provides replaceable rubber-flex gripping elements matched to specific machine spindles.

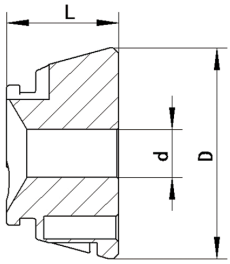


Product notes

- Machine-specific references
- Length and diameter matching
- Groove options

Clamping Heads for Multi-Spindle Machines

Dimensions and technical data





Applicable Machine	Reference Code	L Overall Length (mm)	D Outside Diameter (mm)	Clamping Range (mm)	A Groove / Clamping Face Code	by Increment (mm)
Index MS16	16I	35	44.3	4–16	L	0.5
Index MS16	16I	35	44.3	8–16	R	0.5
Index MS16	16I	35	44.3	11–16	RL	0.5
Index MS18	22I	36	44.3	4–22	L	0.5
Index MS18	22I	36	44.3	8–22	R	0.5
Index MS18	22I	36	44.3	11–22	RL	0.5
Index MS22	9022L	37	44.3	4–22	L	0.5
Index MS22	9022R	37	44.3	8–22	R	0.5
Index MS22	9022RL	37	44.3	11–22	RL	0.5
Index MS22	9022BL	40	44.3	4–22	L	0.5
Index MS22	9022BR	40	44.3	8–22	R	0.5
Index MS22	9022BS	40	44.3	11–22	RL	0.5
Index MS32	32I	47.15	61	4–32	L	0.5
Index MS32	32I	47.15	61	8–32	R	0.5
Index MS32	32I	47.15	61	11–32	RL	0.5
Schütte AF26, SE25, SE26, SF26-S	39S	38	60.5	4–26	L	0.5
Schütte AF26, SE25, SE26, SF26-S	39S	38	60.5	8–26	R	0.5
Schütte AF26, SE25, SE26, SF26-S	39S	38	60.5	11–26	RL	0.5
Mori Say 6-26	69B	43	69.8	6–32	L	0.5
Index ABC	42I	43	69.8	6–32	L	0.5

Clamping Head Bore Tool

The KORRETTO Clamping Head Bore Tool is a turning fixture for preparing EM machinable rubber-flex collets.



Product notes

- EM head preparation
- Four fixture sizes
- Bore-to-size setup

Clamping Head Bore Tool

Dimensions and technical data



Model	Compatible Collet
TF42	42EM
TF52	52EM
TF65	65EM
TF80	80EM

Clamping Head Changeover Tool

The KORRETTO Clamping Head Changeover Tool helps install and remove compatible rubber-flex collets during setup and maintenance.



Product notes

- Manual changing tools
- Pneumatic options
- Automation integration

Clamping Head Changeover Tool

Dimensions and technical data



Tool Model	Compatible Collet Code
CCT42	42S/SR/RL
CCT52	52S/SR/RL
CCT65	65S/SR/RL
CCT80	80S/SR/RL