

COLLET CHUCK

PULLING FORCE SYSTEM



UNILOCK COLLET-CHUCK FOR C.N.C. LATHES

04

UNIÖCK
clamping solutions

THE ACCURACY OF MECHANICS,
THE HUMAN TOUCH.



SMH - COLLET-CHUCK

PULLING FORCE SYSTEM



In the pulling force system the collet couples directly with the spindle cone.

Main uses

Applied to the lathe main spindle it is suitable for bar machining. Moreover, thanks to the construction flexibility of the system, it allows easy specific solutions (drawn bars, rectified items, rolled items, pipes).

The rubber coating of the collets does not allow shavings to pass inside the spindle.

QUICK CHANGE COLLET

The system allows a fast front removal of the collet. In this way, replacement or disassembly collet cleaning operations result easier and quicker, without dead times.

Available in the following models:

SMH 42 - bar passage \varnothing 42 mm

SMH 52 - bar passage \varnothing 52 mm

SMH 65 - bar passage \varnothing 65 mm

SMH 80 - bar passage \varnothing 80 mm

SMH 100 - bar passage \varnothing 100 mm

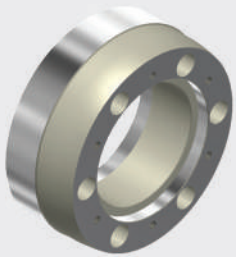
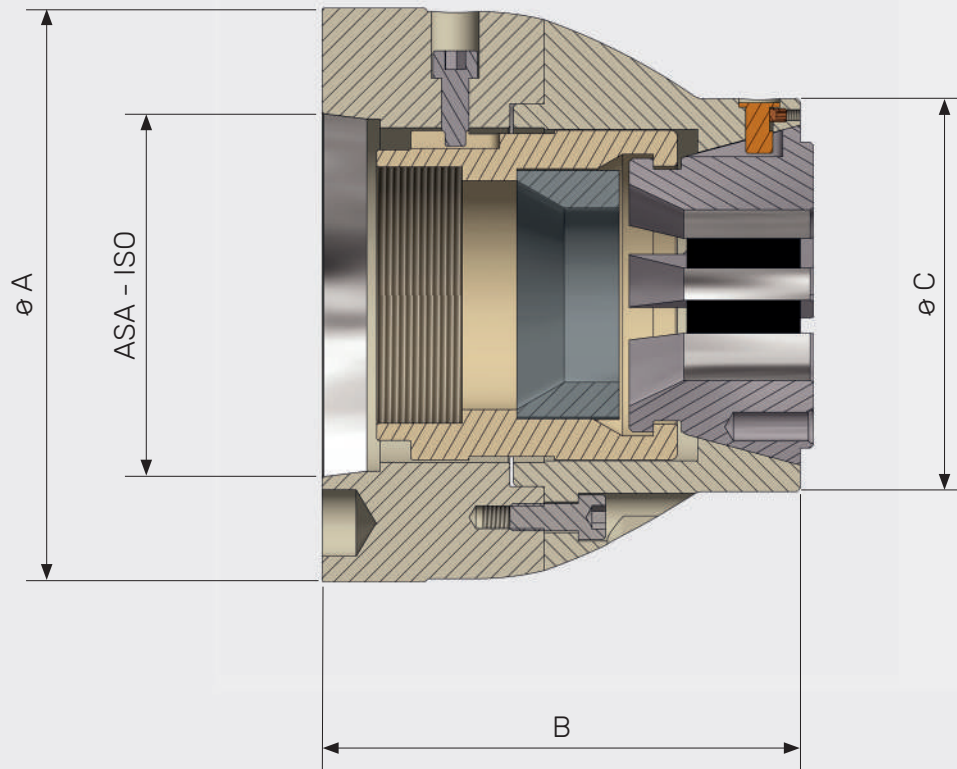
All models are **COMPATIBLE**
with original **HAINBUCH** collets

ADVANTAGES

- Strong clamping strength
- Machining tolerance lower than **DIN** tables
- Minimum weight and small clearance
- Range of machining: -1.0 mm
- Strength for a noteworthy decrease of the vibrations of the piece machined
- Clamping of raw pieces (rolled, forged, cast elements)
- Quick change collet

SMH - COLLET-CHUCK

PULLING FORCE SYSTEM



Base ASA or ISO



Master sleeve



Bush



Quick change clamping nut



Collet

ITEM N.	ASA	ISO	A	B	C	●	⬡
SMH 42	5	115 - 120	\varnothing 135	127	\varnothing 95	\varnothing 42	ch 38
SMH 52	5	115 - 120	\varnothing 135	127	\varnothing 95	\varnothing 52	ch 45
SMH 65	5 - 6	120 - 170	\varnothing 168	140	\varnothing 115	\varnothing 65	ch 56
SMH 80	6 - 8	140 - 170	\varnothing 208	145	\varnothing 142	\varnothing 80	ch 68
SMH 100	8 - 11	170	\varnothing 228	162	\varnothing 168	\varnothing 100	ch 86



SMH - CLAMPING COLLECT

PULLING FORCE SYSTEM



SMH clamping collets are made up from metal inserts, units of vulcanised rubber. This allows the collet to close radially in a perfect manner, blocking the piece along the entire length of the hole and eliminates the intrusion of shavings to pass inside the spindle.

Applied to the lathe main spindle it is suitable for bar machining.

Moreover, the construction flexibility of the system allows easy specific solutions (drawn bars, rectified items, rolled items, pipes).

QUICK CHANGE COLLET

The system allows a fast front removal of the collet. In this way, replacement or disassembly collet cleaning operations result easier and quicker, without dead times.

All **UNILOCK** SMH collets are **COMPATIBLE** with original **HAINBUCH** collet-chucks

ADVANTAGES

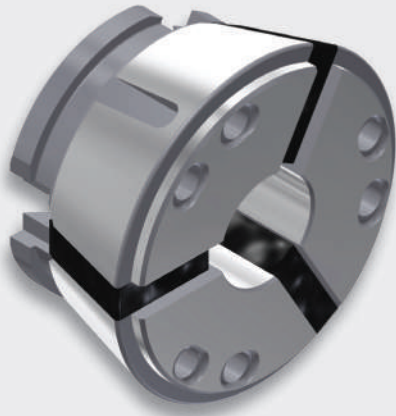
- **UNILOCK SMH COLLETS** close with tapered coupling.

This feature allows a bar clamping over the entire length of the collet hole with a force from 5 to 10 times greater than conventional collets

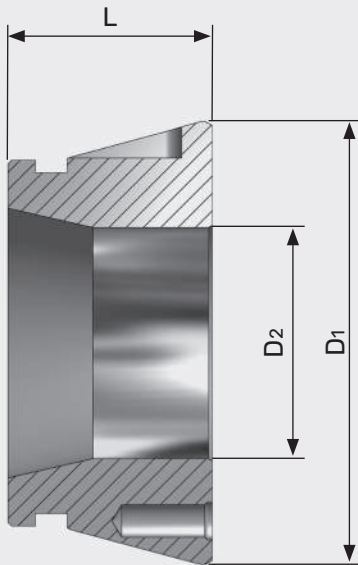
- Excellent elasticity
- Reduction of vibrations
- Less tool wear
- No wear on the collet
- Does not mark the surface of the piece
- Quick change collet
- Fewer machine downtimes.

SMH - CLAMPING COLLECT

PULLING FORCE SYSTEM

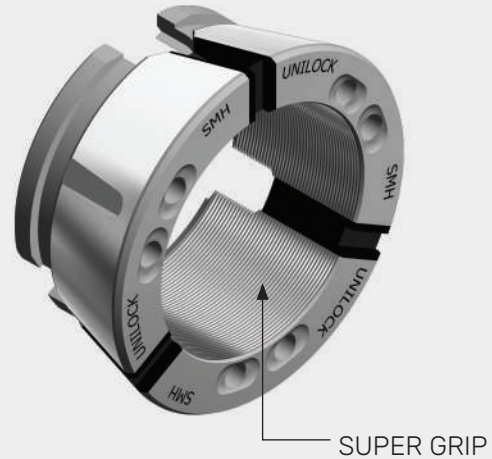


**UNILOCK
PNEUMATIC EXTRACTOR**
Quick and easy collet
replacement.



SUPER GRIP

High friction coefficient



SUPER GRIP COLLETS as well as maintaining the basic features, it presents an high friction coefficient obtained by a special machining process, which increases the clamping force even further.

The **"dynamic friction coefficient"** is determined on the basis of the roughness present inside the collet and must be considered according to the type of material to be machined (e.g. stainless steel, steel, brass).

MATERIAL	DYNAMIC FRICTION COEFFICIENT
STAINLESS STEEL	0,42
STEEL	0,48
BRASS	0,55
NO COATING	0,18

ITEM N..	D1	L	D2	
			●	⬡
SMH 6970 zw	ø 69,50	42	ø 36	ch 31
SMH 32	ø 57,7	47	ø 32	ch 27
SMH 42	ø 79,3	42	ø 42	ch 37
SMH 52	ø 79,3	46	ø 52	ch 45
SMH 65	ø 99,5	54	ø 65	ch 56
SMH 80	ø 114,5	53	ø 80	ch 68
SMH 100	ø 144,5	63	ø 100	ch 86
SMH 160	ø 225	63	ø 160	ch 140



SMH AX - COLLET-CHUCK

DEAD-LENGTH COLLET SYSTEM



Dead-length collet system with radial clamping without axial movement. Used EXCLUSIVELY on the lathes sub-spindle.

QUICK CHANGE COLLET

The system allows a fast front removal of the collet. In this way, replacement or disassembly collet cleaning operations result easier and quicker, without dead times.

Available in the following models:

SMH AX 52
bar passage \varnothing 52 mm

SMH AX 65
bar passage \varnothing 65 mm

SMH AX 80
bar passage \varnothing 80 mm

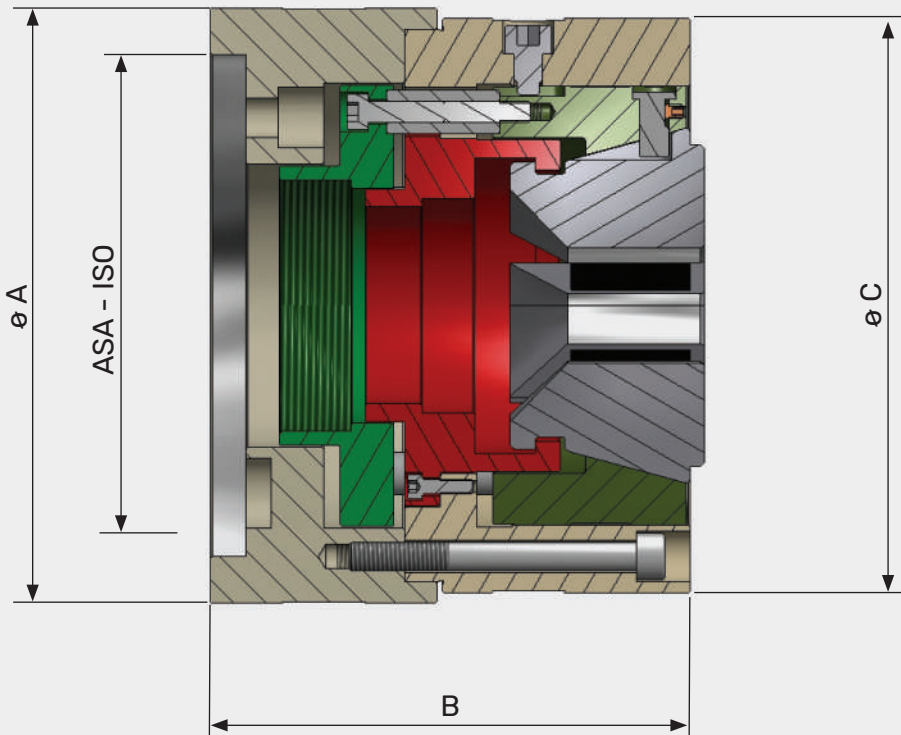
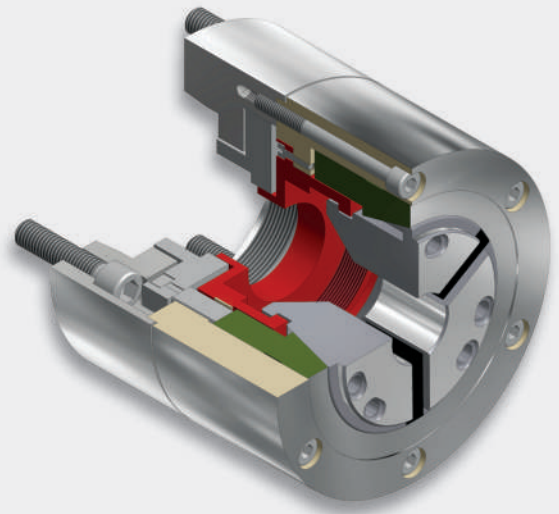
All UNILOCK SMH AX
collet-chuck are **COMPATIBLE**
with original HAINBUCH collets

ADVANTAGES

- Suitable for grip without radial effort
- Reduced piece grip depth
- Quick change collet

SMH AX - COLLET-CHUCK

DEAD-LENGTH COLLET SYSTEM



ITEM N.	ASA	ISO	A	B	C	●	⬡
SMH AX 52	5	115 - 120	$\varnothing 145$	120	$\varnothing 140$	$\varnothing 52$	ch 45
SMH AX 65	5 - 6	140 - 170	$\varnothing 167$	135	$\varnothing 161$	$\varnothing 65$	ch 56
SMH AX 80	6 - 8	140 - 170	$\varnothing 210$	145	$\varnothing 180$	$\varnothing 80$	ch 68

clamping solutions

2021 edition



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