

CLAMPING TECHNOLOGY SOLUTIONS FOR GRINDING SPECIALISTS

Modern production in the field of grinding demands flexible clamping devices with an especially high degree of repeat accuracy. And each application poses different requirements with regard to clamping technology.

Aside from standardised clamping tools Nann has great experience in the development and production of special clamping devices. Extensive warehousing and an elaborate sales system enable you to very quickly apply the clamping devices that fit your requirements. This is how you can integrate our clamping devices into your manufacturing process in an

optimum way. You can trust in our experience. We at Simon Nann GmbH & Co. KG keep a finger on the pulse of production and know about the requirements of high-value clamping technology. Comprehensive know-how and a high degree of in-house manufacturing ensure robustness, precision and an excellent price-performance ratio. What is more, Nann has an in-house test centre for functional tests of new clamping devices.

Nann has been providing innovation and quality in the field of clamping technology as an owner-operated company since 1937. Today, more than 70 qualified staff members in the

development, manufacturing and sales departments work for our customers' success with great experience and strong commitment. See for yourself the advantages of our company and our products in standard or special design.

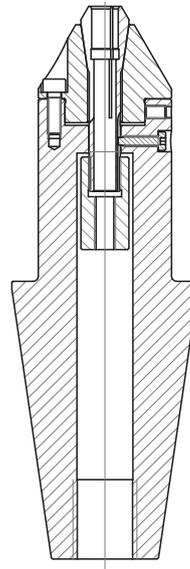
Our products are suitable for grinding machines of the following manufacturers:

- Walter
- Schütte
- Anca
- Haas
- Rollomatic
- Ulmer
- TTB
- Leistriz
- ISOG
- further manufacturers on request

EXTERNAL CLAMPING SPECIAL COLLET CHUCKS FOR DRAW-BACK COLLETS TWO-PART POWER CHUCK

Data and facts:

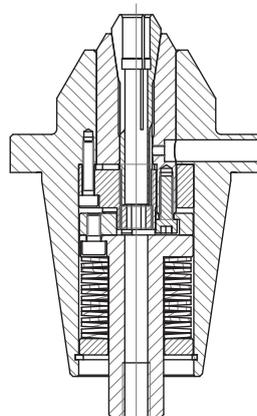
- for draw-back collets
- for high precision collets
- for spindles with rotating hydraulic or pneumatic cylinders
- various sizes and clamping ranges
- any fixture



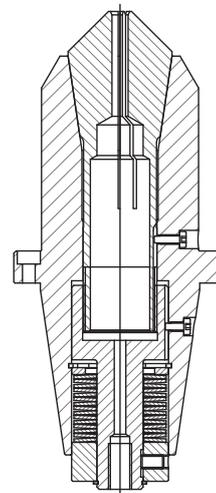
EXTERNAL CLAMPING SPECIAL COLLET CHUCKS FOR DRAW-BACK COLLETS POWER CHUCK WITH DISC SPRINGS

Data and facts:

- for draw-back collets
- for high precision collets
- drawback or axially fixed collet
- for spindles with rotating hydraulic or pneumatic cylinders
- various sizes and clamping ranges
- any fixture



Fixed collet



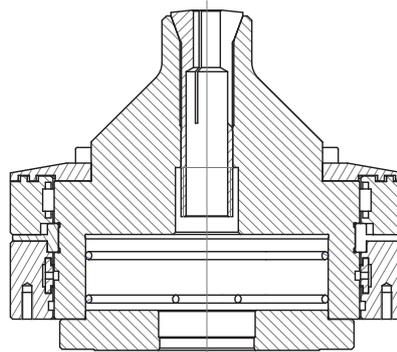
Drawback collet



EXTERNAL CLAMPING POWER CHUCK TYPE PSF-ZT

Data and facts:

- high clamping power without clamping cylinder
- clamping via disc springs
- unclamping via compressed air
- permanently connected supply ring for compressed air
- fatigue-proof clamping
- suitable for clamping of short workpieces
- easy installation and trouble-free mounting
- for various spindle flanges
- also available for internal clamping



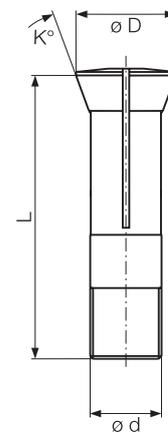
EXTERNAL CLAMPING DRAW-BACK COLLETS

Data and facts:

- for workpiece clamping on grinding machines
- small axial movement of the collet during clamping
- suitable for very short workpieces
- very high concentricity
- for automatic loading

Drawback collets

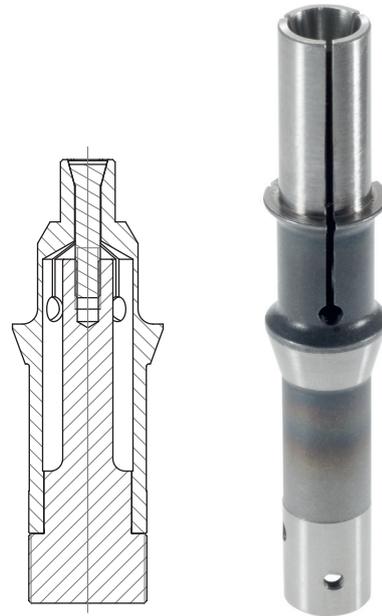
Art. no.	d	D	L	K°	thread G	max. bore
349 E	20	26,3	69,0	15	S 19,7 x 1,667	20
355 E	20	28	117,5	17,5	S 20 x 2	18
364 E	25	34	92,5	15	S 25 x 1/15"	22
3713 E	32	40	100,0	15	S 29,7 x 1/15"	30



INTERNAL CLAMPING SPECIAL COLLETS, THREE-PART EXPANDING COLLET

Data and facts:

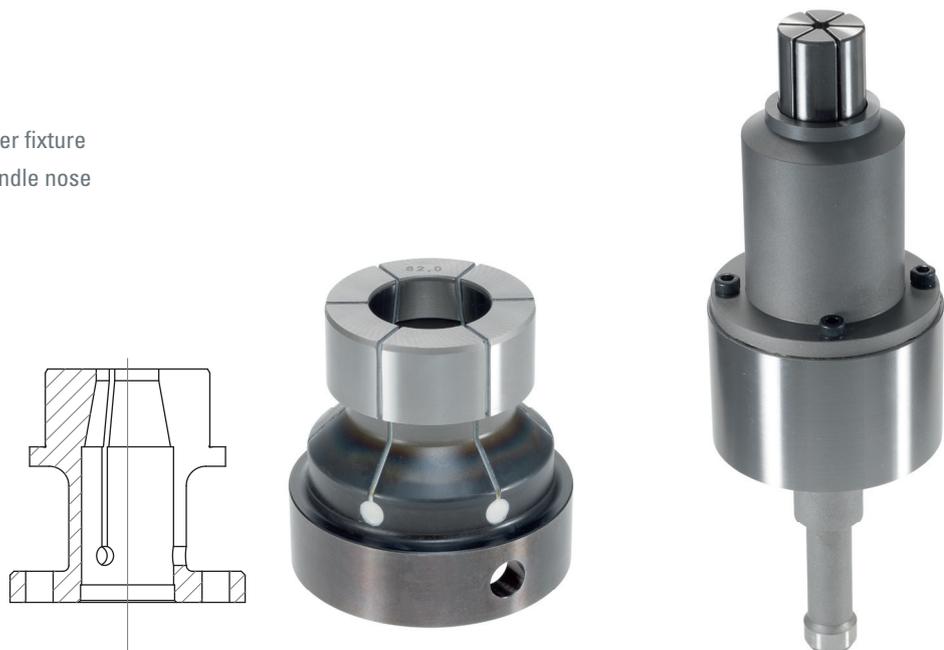
- can be used, if the customer already has a fixture for draw-back collets and wants to internally clamp a workpiece
- widely differing variants available, we will be pleased to give you advice
- manufacture according to Nann construction or customer drawing
- the collet body is extended forwards, the front part is adapted to the workpiece that needs clamping, and will be slotted according to request



INTERNAL CLAMPING SPECIAL COLLETS, EXPANDING COLLET WITH FLANGE FIXTURE

Data and facts:

- with cylindrical flange or short-taper fixture depending on the design of the spindle nose
- operated by pressure or tension
- suitable end stops on request



INTERNAL CLAMPING SPECIAL COLLET CHUCK



EXTERNAL CLAMPING CHUCKS FOR HIGH PRECISION DRAW-BACK COLLETS

Data and facts:

- for high precision draw-back collets
- simple chuck design
- case hardened
- highest concentricity
- cylindrical fixture
- clamping chuck adjustable in the spindle
- for spindles with rotating hydraulic or pneumatic cylinder

Chucks suitable for Walter machines

Art. no.	D1	D	L	L1	L2	L3	collets
2.7400.2.001.000	70,0	22,0	75,0		7,0	52,0	3148 E
2.7400.2.001.010	69,0	22,0	105,0		7,0	82,0	3148 E
2.7400.2.002.000	70,0	34,0	75,0		7,0	52,0	3409 E
2.7400.2.002.010	69,0	34,0	105,0		7,0	82,0	3409 E
2.7400.2.003.000	66,8	52,0	90,0	23,0	30,0	42,0	3718 E
2.7400.2.003.010	67,5	52,0	97,0		7,0	74,0	3718 E
2.7400.2.004.000	70,0	70,0	105,0	38,0	45,0	44,0	3851 E

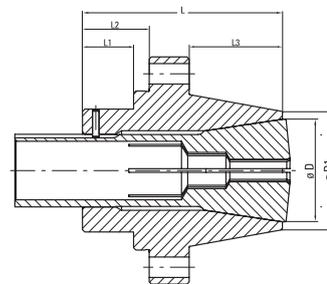
Further chucks for a variety of machine manufacturers are available on request.



Chuck for Anca machines



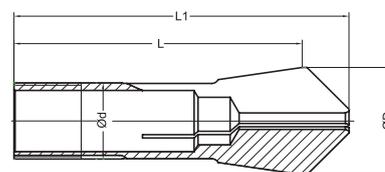
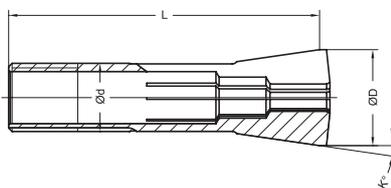
Chuck for Walter machines



EXTERNAL CLAMPING HIGH PRECISION DRAW-BACK COLLETS

Data and facts:

- for workpiece clamping on tool grinding machines
- small axial movement on the collet during clamping process
- suitable for short workpieces (except extended version)
- very high running concentricity
- for automatic loading



High precision draw-back collets

Art. no.	d	D	L	L1 max.	K°	thread G	max. bore ○	increment
3148 E	12	18	63		8° 17'50"	Tr 12 x 1	10,0	0,5
3148 E - V	12	18	63	76	8° 17'50"	Tr 12 x 1	10,0	0,5
3409 E	20	28	90		8° 17'50"	Tr 20 x 1,5	16,0	0,5
3409 E - V	20	28	90	106	8° 17'50"	Tr 20 x 1,5	16,0	0,5
3718 E	32	45	120		8° 17'50"	Tr 32 x 1,5	27,0	0,5
3718 E - V	32	45	120	148	8° 17'50"	Tr 32 x 1,5	27,0	0,5
3851 E	45	60	120		8° 17'50"	Tr 35 x 1,5	36,0	1,0
3851 E - V	45	60	120	145	8° 17'50"	Tr 35 x 1,5	36,0	1,0

Collets 3148 E, 3409 E, 3718 E are also available with additional internal thread.

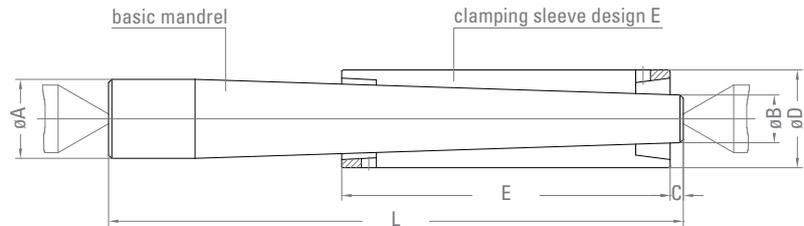
Running concentricity

Clamping diameter d from	d to	Testing point L	Running concentricity standard
1	1,6	5	0,005
1,6	3	10	0,005
3	6	16	0,005
6	10	25	0,005
10	18	30	0,005
18	24	30	0,005
24	36	30	0,005

INTERIOR CLAMPING SLEEVE MANDRELS FOR TYPE E CLAMPING SLEEVES

Data and facts:

- concentricity and true running inspection
- simple turning and grinding works
- holding between centres
- manually operated
- cylindrical clamping
- large clamping range
- concentricity 0,01



INTERNAL CLAMPING INTERNAL CLAMPING SLEEVES WITH SINGLE TAPER

Data and facts:

- for internal clamping during grinding, turning and concentricity control
- for manually operated clamping, self-locking effect
- the clamping sleeves are made from special spring steel and partially tempered on both sides. Collets are hardened to approx. HRc 48 and 56 depending on the design
- segment clamping sleeves vulcanised between HRc 58 and 60



Clamping sleeve type E



Clamping sleeve type B



Segment clamping sleeves
on request

Besides the clamping devices presented above, Simon Nann GmbH & Co. KG offers a wide variety of further standard clamping devices. You can find the standard clamping devices catalog and additional information on the various products and further services on our website: www.nann.de

Our skilled team with profound technical understanding and direct link to the development and production departments awaits you. Feel free to contact us for any questions on special requirements or special clamping devices at any time by phone on +49(0)7429392-0, by email at info@nann.de or in a personal conversation.