



ELMECA

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ELMECA Lever Operated Collet Chucks

Centre Height Required :

1. **C 20, C 25, C 40, and C 60** chucks can be mounted on any lathe with 4" or more height centre. By changing the method of mounting these chucks can be mounted on a lathe having a centre height of less than 4".
2. **Model M B40** can be mounted on any lathe having a centre height of 150mm. or more.

Mounting :

Mounting is simply by a back plate similar to true chuck. A tapped hole is required to be provided on the headstock body below the spindle to fix the anchor bolt of the lever mechanism. Fitting and dismantling can be done in a matter of minutes. Simplified mounting instructions are provided with the chuck.

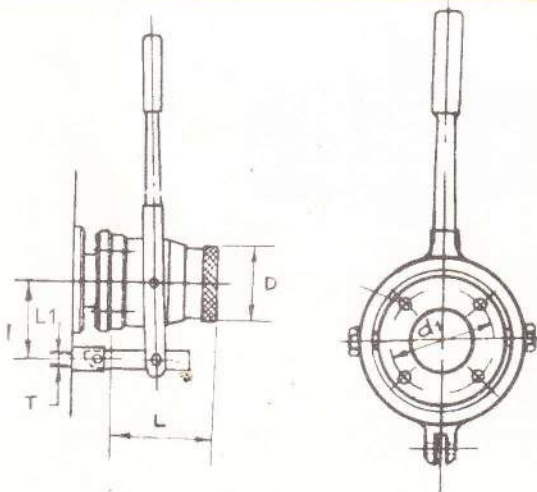
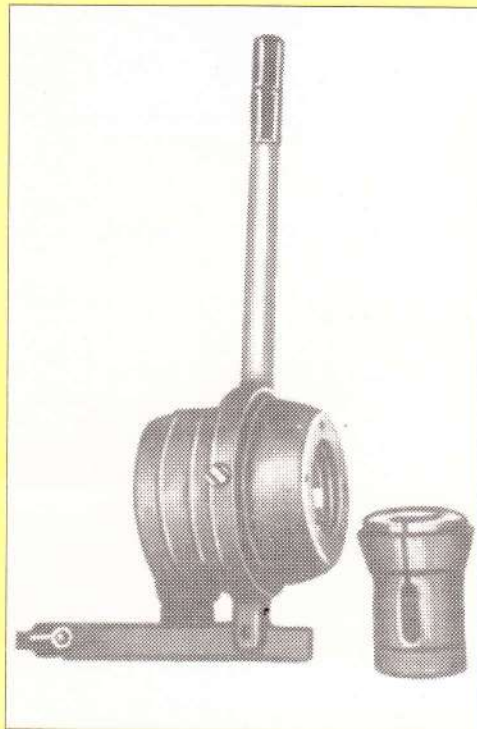
Collets :

Standard size collets for these chucks are normally available with us ex-stock. Model MB-40 is designed for use of multisize collets.

Collets for C25 & C60 Chucks are interchangeable with that of Traub A25 & A60 machines.

Lever operated Collet Chucks are specially designed for second operation of mass production on even an ordinary centre lathe. They can be conveniently used for small or medium batch production on a Turret or Automat.

The workpiece is clamped with a positive grip and with very high accuracy. Opening and closing of the collet is by a single lever and can be done while the spindle is running - thus saving 50% to 80% of idle time. The body and all moving parts are of alloy steel duly hardened and ground.



Sl. No.	1.	2.	3.	4.	5.
Type of Chuck	C-20	C-25	C-40	C-60	MB-40
Capacity of the Collet Dia. (mm)	4-20	4-25	4-40	4-60	4-40
Max. Speed at Which it Can be Used	3000	3000	2500	2000	2000
Over-Hang L (mm)	80	103	115	124	120
D	74	94	70	142	110
d1 (mm)	64	75	113	124	120
'd' for Back Plate	6 Holes	6 Holes	3 Holes	6 Holes	6 Holes
	M4	M6	M8	M8	M8
T	M8	M10	M10	M16	M16
L1 (mm)	100	130	130	130	130
Weight in kg. W/Out Collet	2.5	4.25	6.0	10.75	9.0

ELMECA Milling Fixtures Indexing & Non Indexing

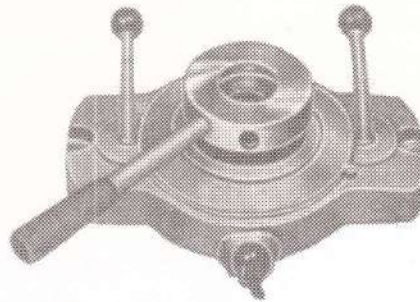
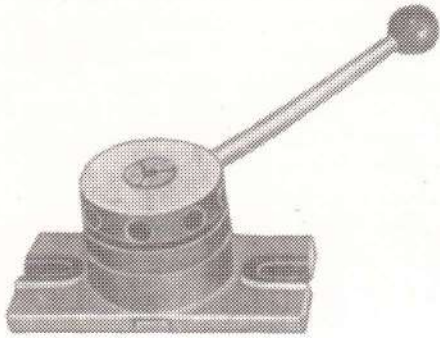
Vertical Indexing Fixture

This is a precision indexing attachment for series production. It consists of the following :

1. Base Plate for indexing attachment.
2. Chuck arrangement - either collets or 3-jaw self-centering chuck.

The base plate is splash-proof. Index plates are interchangeable. One index plate of 24 slots is provided as standard. Index plates with different slots can be supplied at extra cost. The index plates are completely covered against chips. Double, adjustable quick locks have been

provided by which index plunger is completely freed from cutting pressures and thus perfect vibrationless working is assured. Indexing can be carried out both according to graduated collar and by means of index plate.

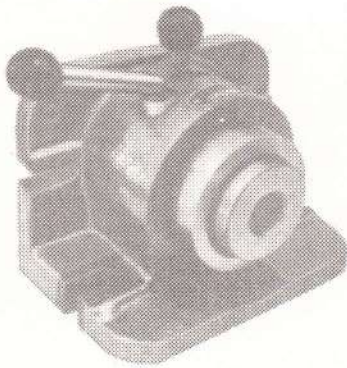


Collet Fixture With Collets

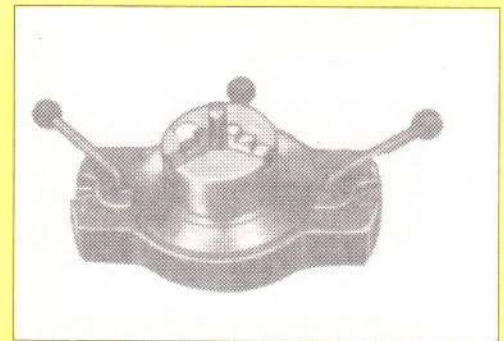
This is a great time saver on a variety of second operation work - Turning, Milling, Drilling, Tapping, Shaping, Eccentric Turning or Boring - all machining operations come alike to this simple, yet versatile equipment.

Model

	Total Length	Width	Height	Weight	Graduation of graduated collar	No. of slots in index plate
1. Non-Indexing Collet Fixture :						
a. With 25mm capacity Model NIMF-25	225mm	110mm	100mm	5 Kg.	—	—
b. With 42mm capacity Model NIMF-42	225mm	110mm	100mm	5 Kg.	—	—
2. Indexing Fixture :						
a. With 25mm capacity Model IMF-25	320mm	230mm		14 Kg.	360°	24
b. With 42mm capacity Model IMF-42	320mm	230mm		14 Kg.	360°	24
with Chuck Model VIC-110	320mm	230mm		16 Kg.	360°	24



HORIZONTAL AND VERTICAL INDEXING MILLING FIXTURES :
Being all the advantages of Indexing Milling Fixtures, it has an added advantage of fixing either horizontally or vertically on milling and Drilling Machines.



keeping in step with today's technological strides, we make improvements in the designs of our products. Hence the product supplied may have features different from those described in this bulletin.

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