

# KFD-AF



### APPLICATION

Centric or compensating clamping chuck with which the workpiece is centered either via a center or via the jaws.

### TYPE

Compensating clamping power chuck with cylindrical center mount or short taper mount.  
3-jaw version with serration (90°).

### CUSTOMER BENEFITS

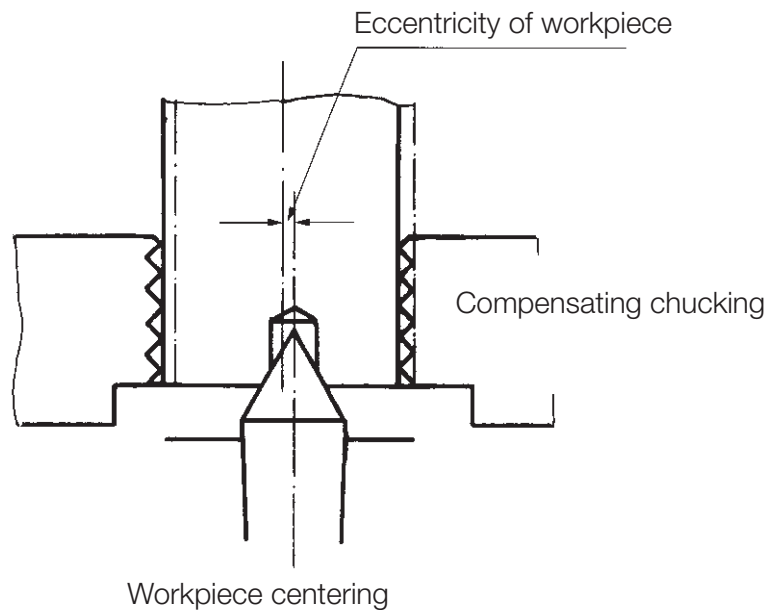
- ③ Flexible use thanks to retrofitting to centric clamping using center inserts
- ③ Low-maintenance thanks to special sealing against dirt and cooling water

### TECHNICAL FEATURES

- Proven wedge hook system
- Compensation is realized by the radially floating chucking piston
- Piston lubrication at centric clamping
- Base jaw lubrication

### Note:

When ordering, please specify power chuck, center insert and mounting flange



### Functionality of the compensating chuck (KFD-AF):

The workpiece is taken up in the center point which is mounted in an insert, and clamped by centrally compensating jaws. Compensation is realized by the radially floating chucking piston. By simply exchanging the center insert, the chuck can be very quickly retrofitted to centric clamping.

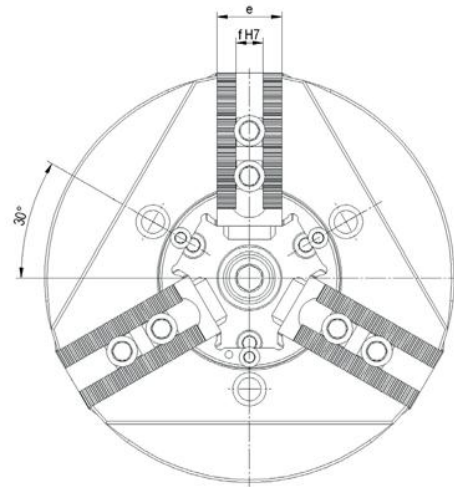
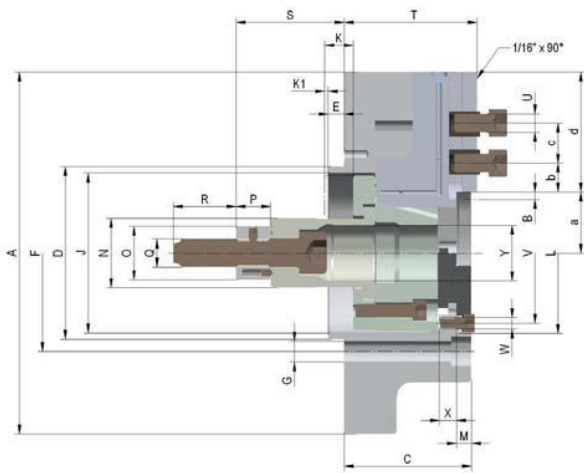
### Interchangeable centering inserts:

- with spring-loaded center
- with solid center
- for self-centering chucking (no compensation)

### Interchangeable mounting adapters:

- with cylindrical mount
- with short taper recess
- with option for radial fine adjustment, upon request

# KFD-AF



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3-jaw compensation chucks KFD-AF, with serration 90°, center insert and chuck mount interchangeable

Item no.	144620	144621	144622	144623
Size	160	200	250	315
A mm	160	200	250	315
Jaw travel B mm	4,8	5,6	6,7	6,7
C mm	78	85	93	111
Dh6 mm	90	115	135	150
E mm	14	14	14	14
F mm	104,8	133,4	171,4	171,4
G mm	3 x $\varnothing$ 12	3 x $\varnothing$ 14	3 x $\varnothing$ 18	3 x $\varnothing$ 18
J mm	82	103	122	139
Wedge stroke K mm	18	21	25	25
K1 mm	2	2	3	3
LH6 mm	90	95	120	140
M mm	10	11	13	13
Ng6 mm	38	42	50	60
O mm	34	40	46	46
P mm	25	30	30	30
Q mm	M16	M20	M24	M24
R mm	40	45	55	55
S min.	56	75	94	94
S max.	74	96	119	119
T mm	82	90	98	116
U	M12	M12	M16	M16
V mm	72	80	102	102
W mm	3 x M8	3 x M8	3 x M10	3 x M10
X mm	12	15	15	15
YH6 mm	32	32	38	48
a min.	27,2	34,4	40,3	46,3
a max.	32	40	47	53
b min.	8	8	10	10
c min.	19	19	25	25
c max.	37	49	64	90
d mm	48	60	78	104,5
e mm	35	40	50	50
fH7 mm	17	17	21	21
Maximum draw bar pull kN	25	36	50	65
Max. total clamping force approx. kN	50	72	110	150
Max. admissible speed min-1	3500	3200	3000	2300
Compensation on $\varnothing$ mm	3	3	4	4
Moment of inertia J kgm <sup>2</sup>	0,04	0,1	0,218	0,744
Weight without jaws approx. kg	13	20	28	60
Actuating cylinders (recommended)	OVS-85/105	OVS-105	OVS-130	OVS-150

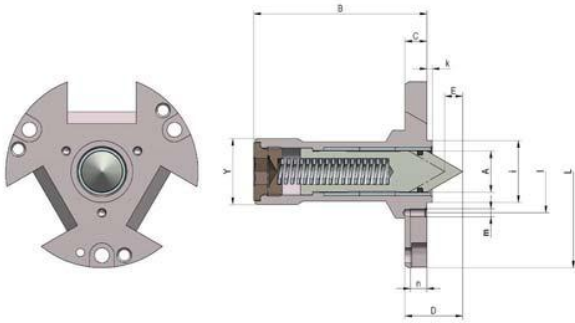
Note: When ordering, specify power chuck, center insert and mounting flange  
The diameter Ng6 must be guided in the spindle

Power-operated com-  
pensating chuck

# Accessories KFD-AF

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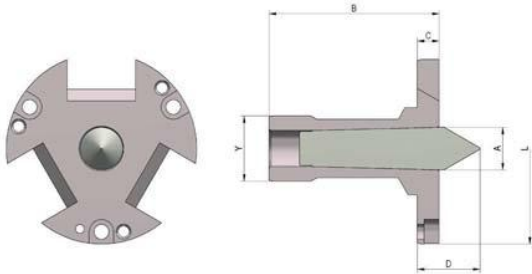
Centering insert with spring-loaded centre



Item no.	Size	A mm	B mm	C mm	D mm	E mm	Lj6 mm	i-0,05 mm	k mm	Yg6 mm	l mm	m	n mm
144624	160	17,5	90	13	~30	6	90	30	4	32	40	M 5	8
144625	200	20,5	91	14	~33	8	95	30	4	32	40	M 5	10
144626	250	25,5	109	16	~38	10	120	40	4	38	50	M 5	10
144627	315	30,5	125	16	~42	13	140	45	4	48	60	M 6	12

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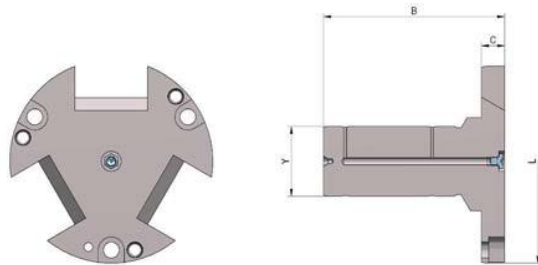
Centering insert with fixed centre



Item no.	Size	A mm	B mm	C mm	D mm	Lj6 mm	Yg6 mm
144628	160	~18	90	13	~33	90	32
144629	200	~18	91	14	~33	95	32
144630	250	~24	109	16	~38	120	38
144631	315	~32	125	16	~46	140	48

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Centering insert for centric clamping



Item no.	Size	B mm	C mm	Lj6 mm	Yg6 mm
144632	160	90	13	90	32
144633	200	91	14	95	32
144634	250	109	16	120	38
144635	315	125	16	140	48

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Reversible top jaws, 3-jaw set, hardened serration 90° - material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
046408	160/200	68	45	34,7	1/16"x 90°
118522	160/200	75	49	36	1/16"x 90°
046414	250/315	103,5	58	50	1/16"x 90°

Additionally or later applied, hardened jaws must be ground out in the chuck.

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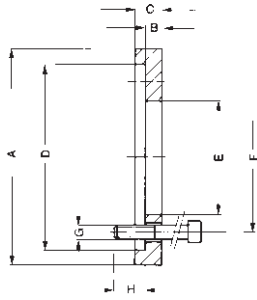
Soft top jaws, 3-jaw set, can be hardened serration 90° - material: 16 MnCr 5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm	Serration
133152	160	66,7	53	36,5	1/16"x 90°
133153	200	75	53	36,5	1/16"x 90°
133154	250	95	54,5	45	1/16"x 90°
133155	315	103	80	50	1/16"x 90°

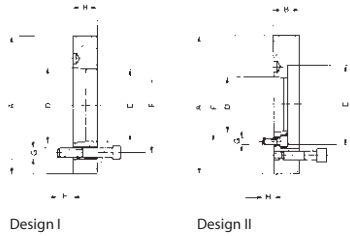
# Accessories KFD-AF

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**Adaptor plates with cylindrical center mount to DIN 6353 complete with mounting screws**



Item no.	Size	A mm	B mm	C mm	DH6 mm	EH6 mm	F mm	G	H mm
144636	160	160	16	22	140	90	104,8	3 x M 10	14
144637	200	200	16	22	170	115	133,4	3 x M 12	16
144638	250	250	17	23	220	135	171,4	3 x M 16	24
144639	315	280	17	23	220	150	171,4	3 x M 16	24

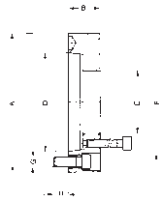
C 15  
**Adaptor plates with short taper mount ISO 702-1 (DIN 55026/55021) complete with mounting studs**



Design I

Design II

Item no.	Size	Design	A mm	B mm	D mm	EH6 mm	F mm	G	H mm
144643	160/5	I	135	29	KK 5	90	104,8	3 x M10	15
144646	160/6	III	165	30	KK 6	90	133,4	3 x M12	18
144649	200/5	II	165	33	KK 5	115	104,8	3 x M10	14
144652	200/6	I	165	30	KK 6	115	133,4	3 x M12	18
144655	250/6	II	210	36	KK 6	135	133,4	3 x M12	18
144658	250/8	I	210	33	KK 8	135	171,4	3 x M16	24
144661	315/8	I	210	34	KK 8	150	171,4	3 x M16	25
144664	315/11	III	280	46	KK 11	150	235	3 x M20	30



Design III