

Pull Back HRG Collet Chuck Setup manual

IMPORTANT NOTE:

Before you use the product, please read instructions carefully. Keep the instructions on file.



PULL BACK COLLET CHUCK

		MAX. CHUCKING CAPACITY									
Model		Plunger stroke	Round	Hex	Square	Max. D.B. pull	Max. clamping force	Max. speed	Weight	Matching	Max. pressure
		mm	mm	mm	mm	kN (kgf)	kN (kgf)	min⁻¹ (r.p.m.)	(kg)	steel collet	MPa (kgf/cm²)
HRG-42	A5	4.5	4–42	7–36	7–30	34.3 (3500)	78.4 (8000)	7000	6.2	HRG-42	2.8 (28)
HRG-65	A6	4.5	4–65	8–56	8–46	44.1 (4500)	103 (10500)	5500	13.6	HRG-65	3.0 (30)
HRG-80	A8	4.5	5–80	8–68	8–56	50.0 (5100)	115 (11730)	5500	19	HRG-80	2.3 (23)

PARTS LIST OF PULL BACK COLLET CHUCK



D	L	A [DIN
Test Bar mm	mm	Class 1	Class 2
3.0-6.0	16	0.015	0.020
6.0-10.0	25	0.015	0.020
10.0-18.0	40	0.020	0.030
18.0-24.0	50	0.020	0.030
24.0-30.0	60	0.020	0.030
30.0-42.0	80	0.030	0.040

Note 1: Collet chucks conform to DIN 6343 Class 2. Note 2: HAAS' rubber grip collets conform to DIN 6343 Class 1.



Name of parts

Adapter plate

Body

Wedge plunger

Draw nut

Hex. Socket cap bolt

Pin

Set bolt

Hex. socket set screw

Qty

1

1

1

1

4

1

1

1

PULL BACK COLLET CHUCK SETUP STEPS:



*Setting 282 allows users to switch between OD and ID clamping **OD clamping** tells the controller the workpiece is clamped when the drawtube is retracted **ID clamping** tells the controller the workpiece is clamped in the **extended** position *** M14** activates the spindle brake

*M19 orients and holds the spindle in position. It can be used on machines not equipped with a spindle brake



(Use M19 to help tighten bolts)



USE COLLET CHANGING TOOL TO INSTALL / REMOVE THE COLLET





- Tighten the mounting bolts according to the specified torque.
- Use included bolts only.

Bolt size	Tightening torque				
M6	12.7 N m (9.4 lb-ft)				
M8	38.2 N m (28.2 lb-ft)				
M10	72.6 N m (53.5 lb-ft)				
M12	106.8 N m (78.8 lb-ft)				
M14	170.6 N m (125.8 lb-ft)				
M16	250.0 N m (184.4 lb-ft)				
7/16"–14	108.5 N m (80.0 lb-ft)				

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