

Chucks & Jigs로 생산 가능한 제품



W159 소재명: Planet carrier
추천척: UBL, OPA



W164 소재명 : Rev clutch
추천척 : PDD, OPA, DIC



W174 소재명 : Top flange
추천척 : UBL, PDD, OPA



W183 소재명 : Speed gear
추천척 : UBL, OPA, DIC, GDC



W185 소재명: SUN GEAR
추천척: UBL, PDD, OPA



W197 소재명: Diff drive gear
추천척: UBL, IPA, DF



W227 소재명 : Output shaft
추천척 : UBL, OPA



W253 소재명 : Drum
추천척 : UBL, PDD, PDI



W258 소재명 : Hub
추천척 : UBL, PDD



W266 소재명 : Front hub
추천척 : UBL PDD



W314 소재명 : Front head comp
추천척 : OPA, PDC



W351 소재명: Housing
추천척: UBL, OPA



W406 소재명: BOW
추천척: UBL, PDD



세계 No.1 SPECIAL POWER CHUCK 전문기업을 자랑하는 칸웍크홀딩스
WORKHOLDING
www.khanchuck.com



KHAN Workholding
ver. 1.0

www.khanchuck.com

NO.1

Special Power Chucks
Power Chuck
Collet Chucks
Rotating Cylinders
Jigs & Fixtures

Manufacturer of
Special Power Chucks

UBL / PDD / OPA

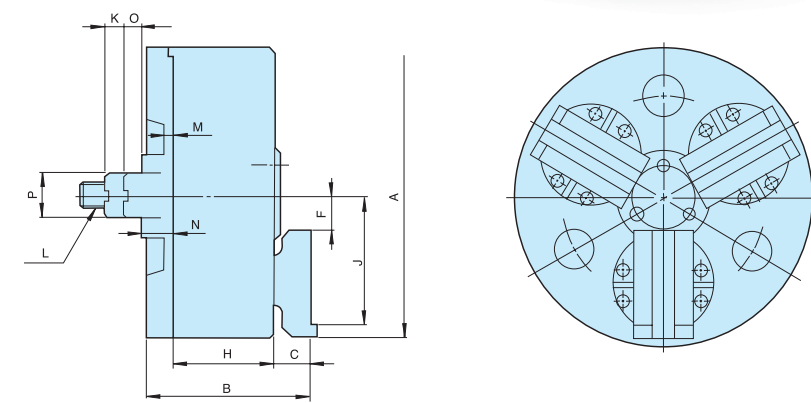
In the World!



KHAN®
Workholding co., Ltd.

UBL

만능 볼 록 파워 척
Universal Ball lock power chuck



※All dimension of centering type compensating type. 3-jaw and 2-jaw are the same.

- 주물 또는 단조품 Chucking공으로 가공 물을 끌어 당기며 척킹하므로 10°의 구 배면도 척킹 가능하며, Jaw가 좌우로 5°씩 자동 지향되는 형식으로 파인력이 강력합니다.
 - 단조품의 축을 Center기준으로 Chuck Jaw가 보상되는 특수형도 있습니다.
 - 척 부착방법은 ASA 및 JIS 규격의 숏 테이퍼 스피indle (ShortTaperSpindle)에 직접부착하는 방식과 척 이답터를 사용하는 두가지 방법이 있습니다.
 - 동일한 구조의 2Jaw model도 있습니다
- This is used for chucking castings or forgings. It pulls in the work during chucking so that it can chuck a tapered surface (up to 10°). Jaws' orientation can automatically change right and left by 5° in each direction so that it has very strong clamping power.
 - There is a special type which compensates jaws as the axis of forgings being center.
 - There are two methods of mounting chuck : using adaptor and fixing on short taper spindle in accordance with ASA and JIS.
 - There is 2 jaws model with same layout.

사양 (Specifications)

Spec. Type	Jaw stroke (DIA. mm)	Plunger stroke(mm)	Gripping DIA (mm)		Max.Drawbar pull(Kgf)	Gripping force(Kgf)	Max.speed (r.p.m)	Weight (Kg)	GD ² (Kgf.m ²)	Recommended cylinder
			Max.	Min.						
UBL-6	7.9	11.3	120	12.7	2700	8100	4000	18	0.15	RCV-125
UBL-8	9.5	14.3	152	16	3600	10800	3500	27	0.48	RCV-125
UBL-10	12.7	17.5	203	50	4500	13500	3000	45	1.23	RCV-150
UBL-12	12.7	17.5	241	63	4500	16200	2500	67.5	2.42	RCV-150
UBL-15	15.8	22.3	317	76	6800	20400	2000	84.5	8.49	RCV-200
UBL-18	15.8	22.3	394	89	6800	20400	1500	120	15.17	RCV-200
UBL-21	15.8	22.3	470	162	6800	20400	1000	180	25.00	RCV-200

차수 (Dimensions)

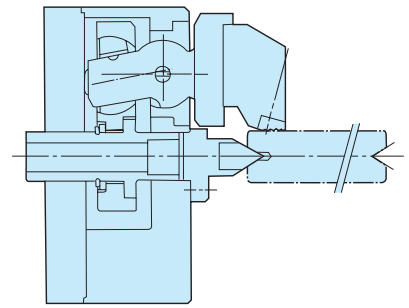
Type Symbo	6	8	10	12	15	18	21	Type Symbo	6	8	10	12	15	18	21	
A	162	200	254	300	381	457	533	J	Outer Dia	73.15	88.95	112.7	133.20	171.45	209.55	247.65
B	104.6	123.3	147.1		163.4			K	Inner Dia	22.15	25.35	30.1	50.76	69.75	107.85	145.95
C	19.3	23.3	29.1		32.4				Max.	16.7	17.3	20.2	22.9	24.1		
								Min.	5.4	3	2.7	5.4	1.8			
F	20.3	25.15	30	50.5	65.8	103.9	142	L	M16		M18		M24			
H	84.2	100.1	118.3	116	141.6			P	30.16	31.75	41.27		57.16	88.90		

UBL

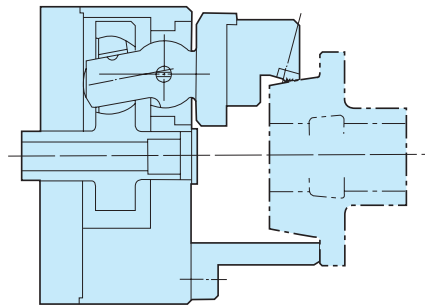
만능 볼 록 파워 척
Universal Ball lock power chuck



• UBL Chuck의 구조 (The structure of the UBL chuck)



Compensating type

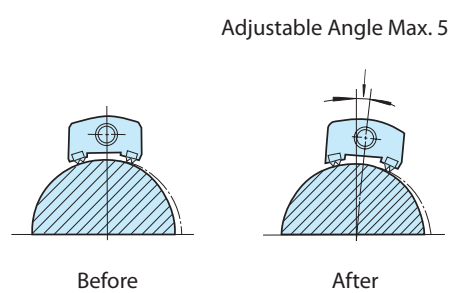


Centerizing type

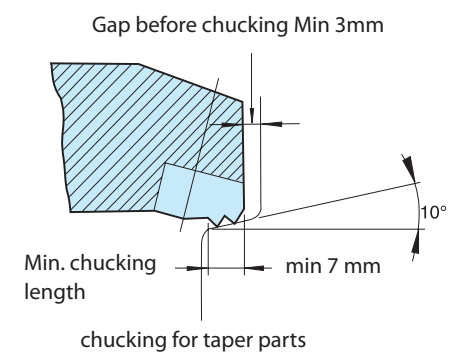
- 가공물을 당겨서 척킹합니다.
- 가공물이 절대로 부상하지 않습니다.
- 테이퍼부를 파악할 수 있습니다.
- 조가 좌우로 5°씩 자동조절 됩니다.
- 고속회전으로 사용할 수 있습니다.
- 길이가 짧은 외경 테이퍼부의 척킹도 가능합니다.
- 내부에 이물질이 침투하지 않도록 설계되었습니다.
- 원형이 아닌 제품의 척킹도 가능합니다.
- 센터를 기준으로 하는 2조 심보상형 척도 있습니다.
- 힘의 손실이 없으며, 척킹 힘이 입력의 3배 입니다.
- 가공물을 척킹할 때 자동적으로 가공물의 중심이 잡혀 집니다.
- UBL Chuck은 단조품 및 주조품의 내외경과 축의 센터를 기준으로 하는 외경 척킹용으로 적합합니다.

- Pulls in work when it chucks.
- Work shall never float.
- Easy to clamp taper parts.
- Jaws can be automatically adjusted in left and right directions by 5°.
- It can be used at high speed rotation.
- It is possible to chuck short outside taper parts.
- It is designed to protect the intrusion of foreign particles.
- It is possible to chuck the work which are not round shape.
- There is center compensation chuck with 2 jaws based on the center.
- There is no loss in power. The chucking force is about three times of the input power.
- The object is automatically centered when it is chucked.
- This is suitable for chucking outside and inside of forgings and castings and chucking outside of shaft based on the shaft center.

• 자동지향각도 (Automatic adjustable angle)



Adjustable Angle Max. 5°



Gap before chucking Min 3mm

Min. chucking length

chucking for taper parts

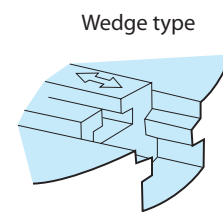
• 척킹부의 최소길이 (Min. Length in chucking parts)

UBL

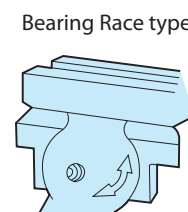
만능 볼 록 파워 척
Universal Ball lock power chuck



• 슬라이딩(Sliding) 구조 (Smooth rotating)

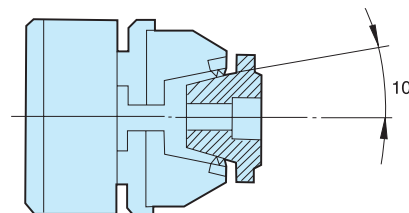


a lots of abrasion

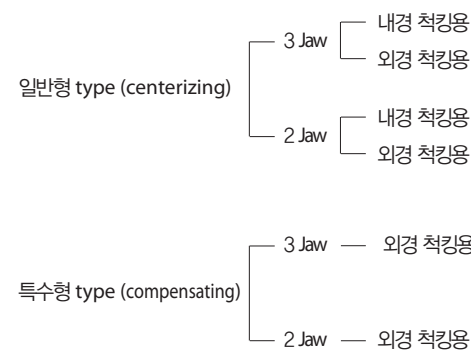


Smooth Rotating

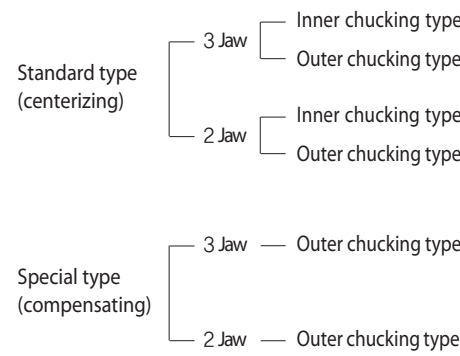
• 척킹부의 최대각도 (Max. taper angle in chucking parts)



• UBL Chuck의 기종별 분류 및 기능 (Classification and function)

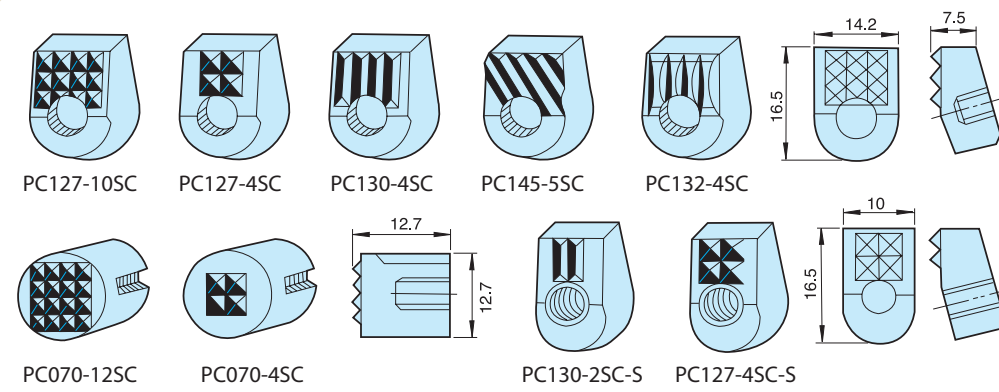


※ 일반형과 특수형 척의 모든 치수는 동일합니다.



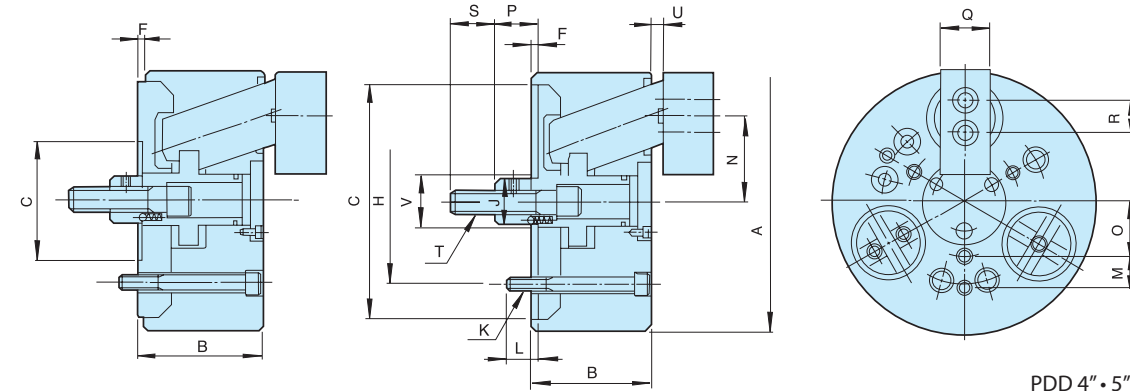
※ All dimensions of standard and special types are the same.

• 초경 인서트 종류 (Inserts)



PDD

3조 강력형 드로다운 파워 척
Draw down power chuck



PDD 4" x 5"

- 가공물을 끌어당기며 척킹하여 주는 특징이 있어 직각도 및 평행도가 중요한 때 사용되며, 척킹 범위가 크므로 여러 기종을 Top Jaw 교환만으로 가공이 가능합니다.
- 척 부착방법 : 척 이답터 (Adaptor) 사용

- This power chuck pulls in work during chucking so that it is suitable for machining work which requires squareness and parallelism on machining. It has wide chucking range so that it can be used in various types of work by changing only top jaws.
- Use chuck adaptor.

시양 (Specifications)

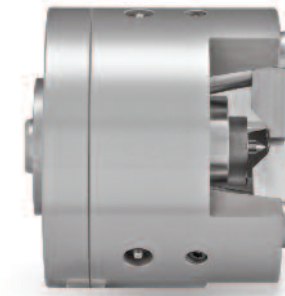
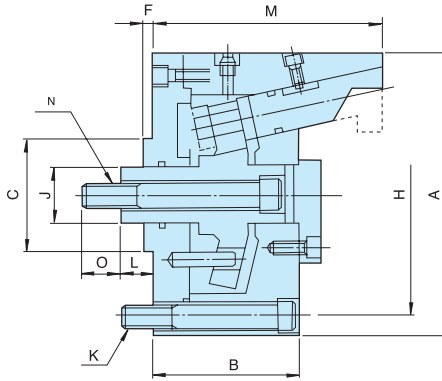
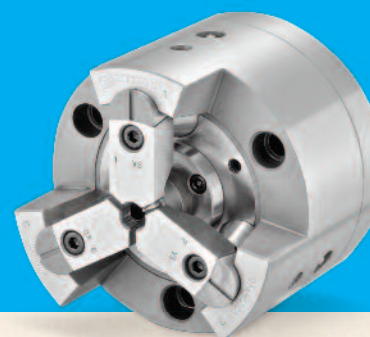
Spec. Type	Jaw stroke (DIA. mm)	Plunger stroke(mm)	Gripping DIA (mm)		Max.Drawbar pull(Kgf)	Gripping force(Kgf)	Max-speed (r.p.m)	Weight (Kg)	GD ² (Kg·m ²)	Recommended cylinder
			Max.	Min.						
PDD-4	5	7	50	15	600	1500	3500	4.5	0.03	RCV- 75
PDD-5	5	7	65	15	1000	2000	3500	7.3	0.07	RCV- 75
PDD-6	7.2	10	85	35	1500	2500	3500	13.8	0.18	RCV-100
PDD-8	7.2	10	200	40	2500	4500	3000	27	0.66	RCV-125
PDD-10	10.8	15	250	50	3500	6000	2500	45.8	1.50	RCV-125
PDD-12	10.8	15	300	50	4500	7500	2000	68	3.20	RCV-150
PDD-15	14.56	20	380	60	5500	9000	1500	110	9.00	RCV-200

치수 (Dimensions)

Type Symbo	4	5	6	8	10	12	15	Type Symbo	4	5	6	8	10	12	15
A	110	130	165	210	254	304	381	O	25	30	35	45	55	70	95
B	60	70	85	95	110	125	140	P	Max.	19	33	38	47	71	
C(H6)	60	80	140	190	230	300		Min.	12	23	28	32	51		
F			5					Q	25	30	35	40	50	60	70
H	80	100	104.77	133.35	171.45	230		R	-	-	-	26	32	36	40
J	25	28	32	38	50	52	60	S	20	25	36	46	50		
K	3-M8	6-M10	6-M12	6-M16	6-M20			T	M10x1.5	M12x1.75	M16x2.0	M20x2.5	M24x3.0	M27x3.0	M30x3.5
L	14	14	16	23	22	27	30	U	Max.	10.5	14	19	26		
M	-	-	20	25	30	35	45	Min.	3.5		4		6		
N	Max. 37	44	58	71	85	102	133.64	V	28	30	35	42	52	55	90
	Min. 34.5	41.5	54.4	67.4	79.6	96.6	126.36		-	-	-	-	-	-	-

OPA

정밀 외경 척킹용 핀 아버 파워척
Outside pin arbor power chuck



- 가공물을 끌어당기며 척킹하여 주는 특징이 있어 직각도 및 평행도가 중요한 정밀제품 가공이 적합합니다.
- 척 부착방법 : 척 이답터 (Adaptor) 사용

- This power chuck pulls in work during chucking so that it is suitable for machining work which requires precision, squareness and parallelism on machining.
- Use chuck adaptor.

시양 (Specifications)

Spec. Type	Jaw stroke (DIA. mm)	Plunger stroke(mm)	Gripping DIA (mm)		Max.Drawbar pull(Kgf)	Gripping force(Kgf)	Max-speed (r.p.m)	Weight (Kg)	GD ² (Kg·m ²)	Recommended cylinder
			Max.	Min.						
OPA-80	3.4	8	80	15	1200	5500	4000	8	0.067	RCV- 75
OPA-100	4.2	10	100	20	2000	9400	3600	16	0.20	RCV-100
OPA-140	4.2	10	140	60	2500	11700	3400	27	0.54	RCV-125
OPA-180	4.2	10	180	100	3000	14000	3000	46	1.43	RCV-125
OPA-230	4.2	10	230	120	4000	18000	2500	70	3.50	RCV-150

치수 (Dimensions)

Type Symbo	80	100	140	180	230	Type Symbo	80	100	140	180	230
A	130	162	210	250	320	K	3-M8	3-M12	3-M16	6-M16	
B	72	90	100	110	130	L	Max.	18	22.5	25	30
C(h6)	60		80		120	Min.	10	12.5	15	20	
F	5			7		M	103	130	155	165	200
H	100	130	170	210	270	N	M12x1.75	M16x2.0	M18x2.5	M20x2.5	
J	24	30	40	45	50	O	20	30		40	

KHAN®