CHIA-MO

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50 YEARS

PINZE PER TORNI MONOMANDRINO

COLLETS FOR SINGLE-SPINDLE LATHES

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PINZE PER TORNI MONOMANDRINO
COLLETS FOR SINGLE-SPINDLE LATHES

Le pinze per torni monomandrino vengono impiegate su macchine da produzioni, torni cnc e torni a fantina mobile Star, Tornos, Bechler, Tsugami, Citizen, Strohm, Nomura, Manurhin, Peterman, Bechet, Hanwha, Nexturn. Si utilizzano sia sul mandrino principale che sul contromandrino. Sono disponibili con alesaggio tondo, esagonale, quadro e possono essere eseguiti profili speciali su richiesta.

Collets for single-spindle lathes are used on production machines, CNC lathes and sliding head stock lathes Star, Tornos, Bechler, Tsugami, Citizen, Strohm, Nomura, Manurhin, Peterman, Bechet, Hanwha, Nexturn. They are used on both the main spindle on sub spindle. They are available with bore round, hexagonal, square and special profiles can be run on demand.

Descrizione e specifiche
Le pinze per torni monomandrino sono costruite con acciaio certificato altamente legato, sono temprate e completamente rettificate. Tutto il ciclo produttivo viene svolto nel nostro stabilimento in Italia con macchine utensili di alta precisione ed è rigorosamente controllato. Grazie all'ampia disponibilità di magazzino possiamo generalmente spedire il materiale il giorno stesso della ricezione dell'ordine.

Description and Specifications
Collets for single-spindle lathes are produced with certified top quality steel, they are hardened and completely grinded. All production cycle is carried out in our factory in Italy with high precision machines and is carefully controlled. Thanks to the availability of stock, we can usually ship the material the same day as order is received.

Maggiori informazioni
Possono essere fornite con superficie liscia, rigata o zigrinata. Per una maggiore forza di serraggio possiamo eseguire sul foro della pinza un rivestimento in metallo duro. Possiamo inoltre eseguire pinze con battuta, pinze fuori centro, pinze con misura decimale e sagome speciali con elettroerosioni.

Further Information
They can be supplied with bore smooth, grooved or serrated. For greater clamping force we can perform on the hole of the collets a carbide coating. We can also perform collets with stop, out of centre collets, collets with decimal measure and special shapes with EDM.

Prodotti
Pinze stringibarra – Pinze spingibarra – Pinze di serraggio a spinta – Pinze a doppio cono – Pinze tirate – Pinze a cono morse – Bussole in metallo duro per torni a fantina mobile.

Products
Clamping collets – Push type collets – Feed fingers collets – Double cone collets – Draw back collets – Morse taper collets – Hard metal bushes for sliding head stock lathes.

FORMA DEGLI ALESAGGI
CLAMPING FORM

L
LISCIO
(SMOOTH)

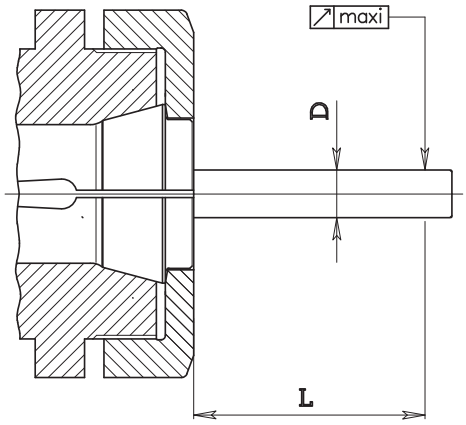
Z
ZIGRINATO
(SERRATED)

R
RIGATO
(GROOVED)

ZN
ZIGRINATO NON PASSANTE
(SERRATED MIX)

PROVA DI CONCENTRICITÀ
ROTATIONARY CONCENTRICITY TEST

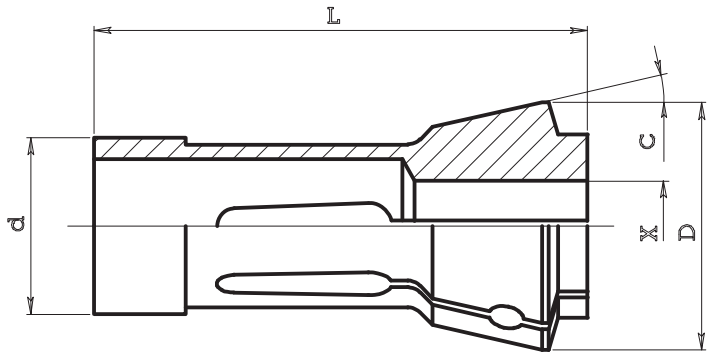
Alesaggio D / Bore D		L	Limite max di concentricità / Max concentricity limit	
			Pinze standard / Standard collets	Pinze alta precisione / High precision collets
0.5	1	3	0.015	0.005
1	1.6	6	0.02	0.005
1.6	3	10	0.02	0.008
3	6	16	0.02	0.008
6	10	25	0.02	0.008
10	18	40	0.03	0.010
18	24	50	0.03	0.010
24	30	60	0.03	0.010
30	50	80	0.04	0.015
50		100	0.04	0.015



Le pinze Chia-mo sono costruite con acciaio certificato altamente legato.
Tutto il ciclo produttivo viene svolto nella nostra officina con macchine utensili di alta precisione in accordo alla normativa DIN 6343 ed è rigorosamente controllato.

Chia-mo collets are produced with certified top quality steel.
All production cycle is carried out in our factory with high precision machines according to DIN 6343 specification and is carefully controlled.

PINZE SPINTE Tipo 010 DIN 6343
COLLETS



Art. / Code		d	D	L	C	Alesaggio max / Max bore		
						○	⬡	□
010.006	101 E	8	12	42	16°	6	—	—
010.013	110 E	10	16	43	15°	7	—	—
010.014	109 E	10	16	47	20°	7	6	5
010.019		12	17	27	20°	8.5	—	—
010.025	117 E	14	18	46	13°	10	8	7
010.027		12	18	64	16°	10	8	7
010.028	116 E	13	19	64	16°	10	8	7
010.029	120 E	15	21	64	16°	12	10	9
010.030	121 E	15	22	47	20°	10	9	7
010.031	1212E	16	21	66	16°	12	10	9
010.032	123 E	16	22	55	15°	12	10	7
010.036		18	23	52		13	—	—
010.038	127 E	18	25	67	15°	12	10	9
010.042	136 E	20	26	54	15°	16	12	10
010.043	1299E	20	27.5	60	15°	17	15	12
010.045	138 E	20	28	67	16°	16	12	10
010.049	139 E	22	28	67	13°	16	12	10
010.051	140 E	22	30	55	15°	18	15	12
010.053	1323E	22	32	66	16°	18	15	12
010.060	143 E	25	31	54	15°	21	18	15
010.063	144 E	25	34	65	15°	20	17	14
010.064	145 E	25	35	77	16°	20	17	14
010.065	146 E	26	32	67	13°	20	17	14

Art. / Code		d	D	L	C	Alesaggio max / Max bore		
						○	⬡	□
010.067	147 E	27	38	72.7	15°	23	19	16
010.070	148 E	28	38	70	15°	23	20	16
010.074	1446E	30	38	65	15°	25	22	18
010.078	157 E	30	42	80	16°	25	22	18
010.084	161 E	32	45	75	15°	26	22	18
010.086	1473E	32	40	65	15°	26	22	18
010.092	162 E	35	43	70	15°	25	22	18
010.093	163 E	35	48	80	15°	30	26	22
010.101	1536E	37	47	92	16°	32	27	22
010.102		38	50.3	86	15°	32	29	22
010103	164 E	38.08	48.75	108	15°	32	29	22
010.111	171 E	42	55	94	15°	36	32	25
010.115		44	51.7	92	16°	37	32	26
010.117	173 E	48	60	94	15°	42	36	30
010.121		52	63	92	15°	46	38	32
010.122		52	65	94	15°	46	38	32
010.125		56	68	94	15°	50	42	35
010.127	177 E	58	70	94	15°	52	45	36
010.130		60	72	102	15°	54	40	32
010.133	185 E	66	84	110	15°	60	52	42
010.140		80	98	115	15°	70	60	50
010.147		95	117	125	15°	80	68	56
010.150		115	135	140	15°	100	86	80

PINZE DI EMERGENZA Tipo 010
EMERGENCY COLLETS

CARATTERISTICHE:
Le pinze di emergenza possono essere facilmente lavorate dal cliente per eseguire una presa pezzo con le dimensioni o la forma desiderata. Sono fornite con spine di registro per il serraggio sul mandrino. Hanno una durezza inferiore sulla "testa" (38/40 HRC) per permettere la lavorabilità.

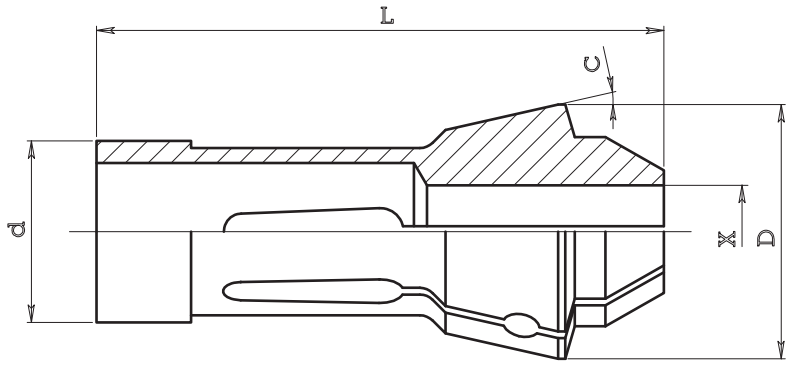
ISTRUZIONI:
Inserire la pinza sul mandrino. Assicurassi che le spine siano in posizione nella pinza. Chiudere la pinza. Eseguire la sgrossatura e la finitura al diametro desiderato.

SPECIFICATION:
Emergency collets can be easily bored out or machined by the customer to the desired size or shape. Pins are supplied for accurate machining. The head is soft (hardness 38/40 HRC) for machining to specific.

INSTRUCTION:
Insert the collet in the spindle. Be sure pins are in place in the collet. Close the collet. Rough and finish the bore to the chucking diameter of the part.

Art. / Code		d	D	L	C
010.064 EM	145 E	25	35	77	16°
010.074 EM	1446 E	30	38	65	15°
010.084 EM	161 E	32	45	75	15°
010.101 EM	1536 E	37	47	92	16°
010.117 EM	173 E	48	60	94	15°
010.127 EM	177 E	58	70	94	15°
010.133 EM	185 E	66	84	110	15°

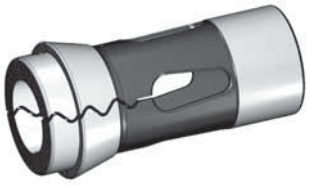
PINZE MUSO LUNGO Tipo 010
EXTENDED-NOSE COLLETS

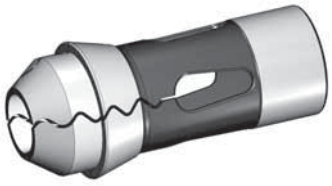


Art. / Code		d	D	L	C	Alesaggio max / Max bore		
						○	⬡	□
010.028ML	116 E	13	19	70	16°	10	8	7
010.029ML	120 E	15	21	71	16°	12	10	9
010.031ML	1212E	16	21	71	16°	12	10	9
010.042ML	136 E	20	26	62	15°	16	12	10
010.045ML	138 E	20	28	75	16°	16	12	10
010.051ML	140 E	22	30	63	15°	18	15	12
010.064ML	145 E	25	35	85	16°	20	17	14

Art. / Code		d	D	L	C	Alesaggio max / Max bore		
						○	⬡	□
010.074ML	1446E	30	38	79	15°	25	22	18
010.084ML	161 E	32	45	90	15°	26	22	18
010.101ML	1536E	37	47	107	16°	32	27	22
010.117ML	173 E	48	60	113	15°	42	36	30
010.127ML	177 E	58	70	114	15°	52	45	36
010.133ML	185 E	66	84	132	15°	60	52	42

Disponibili a richiesta pinze con foro liscio e taglio "zig-zag".
Available on request smooth collets with "zig-zag" cutting.





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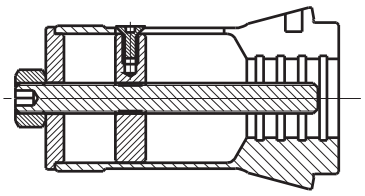
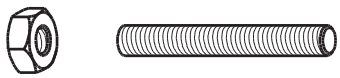
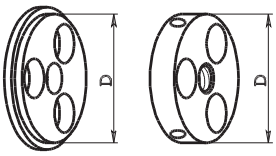
FERMI PER PINZE Tipo 011
COLLET STOPPERS



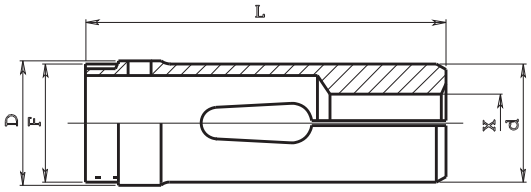
Art. / Code	Per pinza / For collet	D
011.051	010.051	17
011.070	010.070	23
011.084	010.084	26
011.117	010.117	42.5
011.127	010.127	52.3
011.133	010.133	60,5
011.140	010.140	70.5



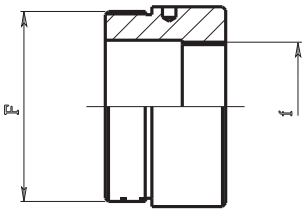


PINZE DI AVANZAMENTO Tipo 012
FEED FINGERS COLLETS

Art. / Code		D	d	L	F sx	Alesaggio max / Max bore ○	⬡	□
012.007	207 E	18	16	70	16x1	12	11	9
012.009	217 E	21.5	20.5	70	20x1	16	14	11
012.025	220 E	24	22	85	22x1	18	16	13
012.037	236 E	30	29	95	28x1	25	22	17
012.038	237 E	31	29	90	29x1	25	22	17
012.052		36	35	116	34x1	30	26	20
012.060	254 E	42	40	116	40x1	36	30	25
012.073	260 E	52	50	116	50x1	46	40	32
012.077		54	52	130	51x1	46	40	32
012.083	273 E	60	58	140	58x1	52	45	36

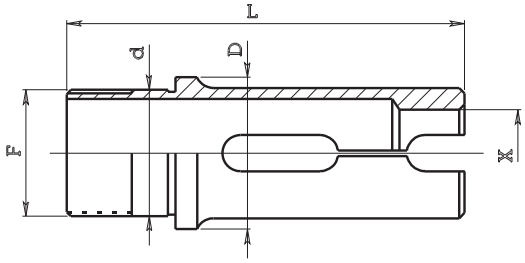


ADATTATORI PER PINZE DI AVANZAMENTO Tipo 013
FEED FINGERS FITS



Art. / Code	F sx	f sx	da	a	Macchina / Machine
013.101	22x1	16x1	012.025	012.007	INDEX 18 riuduzione a INDEX 12
013.102	28x1	22x1	012.037	012.025	INDEX 24 riuduzione a INDEX 18
013.103	29x1	22x1	012.038	012.025	INDEX 25 riuduzione a INDEX 18
013.104	40x1	28x1	012.060	012.037	INDEX 36/B42 riduzione a INDEX 24/B30
013.105	40x1	29x1	012.060	012.038	INDEX 36/B42 riduzione a INDEX 25
013.106	58x1	40x1	012.083	012.060	INDEX 52/B60 riduzione a INDEX 36/B42

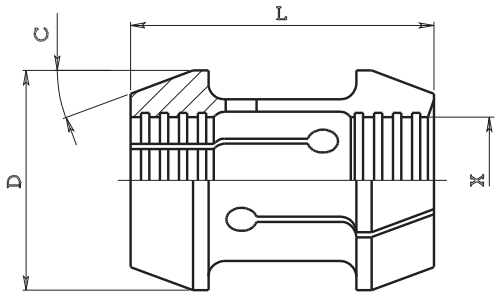
PINZE DI AVANZAMENTO CON MANDATA ESTERNA Tipo 014
FEED FINGERS WITH OUTSIDE SPRING CATCH



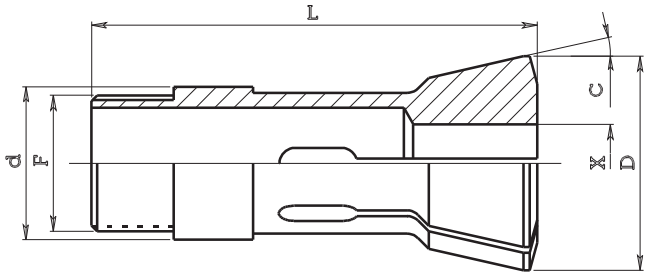
Art. / Code		D	d	L	F	Alesaggio max / Max bore ○	⬡	□
014.003	242 E	42	36	120	36x1.5	30	26	21
014.006	259 E	56	50	138	50x1.5	42	36	29
014.012	278 E	75	68	138	68x1.5	60	52	42

PINZE A DOPPIO CONO Tipo 016
DOUBLE CONE COLLETS

Art. / Code	D	L	C	Alesaggio max / Max bore ○	⬡	□
016.024	34	56	17°30'	26	22	18
016.052	34.5	74	25°	26	22	18
016.054	26	55	25°	15	13	10
016.055	50	80	20°	36	31	25
016.043	60	80	17°	45	39	30
016.056	69.5	100	18°	60	52	42
016.051	70	80	16°	52	43	36
016.057	72	100	17°	56	50	40
016.062	81	90	17°	60	52	42
016.070	91	100	17°	70	62	50
016.080	108	105	17°	80	68	56
016.100	130	120	17°	100	86	70
016.120	155	130	16.45°	120	105	95

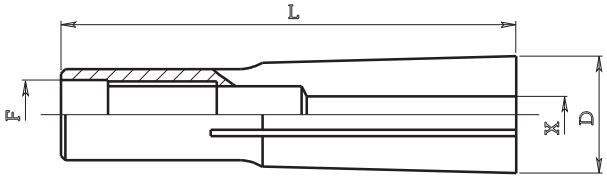


PINZE TIRATE Tipo 018
DRAW BACK COLLETS

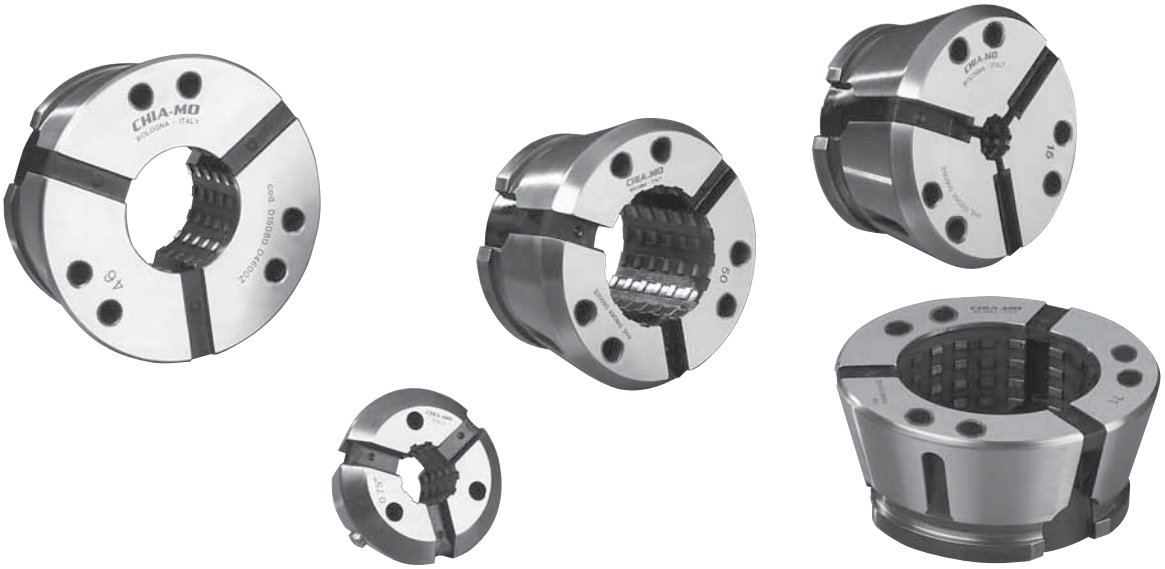


Art. / Code		d	D	L	C	F		Alesaggio max / Max bore ○	⬡	□
018.020	324E	15	21.5	55	20°	13x1		13	—	—
018.028	349E	20	26.3	73	15°	19.7x1.66	a dente di sega	20	—	—
018.046	363E	25	33.5	87.5	16°	23x1		22	—	—
018.048	364E	25	33.7	97.6	15°	24.7x15	a dente di sega	25	20	16
018.063	385E	31.75	37.3	87	10° 3'	1.134"x20 fil"	(int. 1.047"x20 fil")	28	22	19

PINZE PORTA UTENSILI A CONO MORSE Tipo 020
MORSE TAPER COLLETS



Art. / Code	D	L	F	C.M. / M.T.	X min	X max	Prog.	Macchina / Machine
020.200	18	69	M10	2	2	14	0.25	GIORGI GM20-25-30-32 / ITS TCA 301 / SAIC B26 DUPLOMATIC FR50 / STEINEL SH1-SV1-SV3-5 / BRIDGEPORT testa M (F3/8''-16)
020.300	24	86	M12	3	2	18	0.5	CLARKSON affilatrice MARK1 / RAVETTA PB32 DUPLOMATIC FR70 / ITS 36-60 / SAIC B45

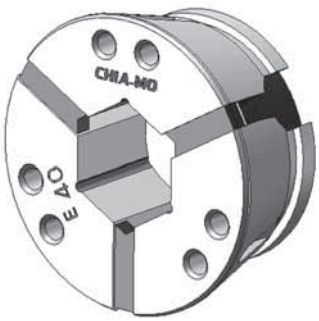


FORMA DEGLI ALESAGGI
CLAMPING FORM

L
LISCIO
(SMOOTH)

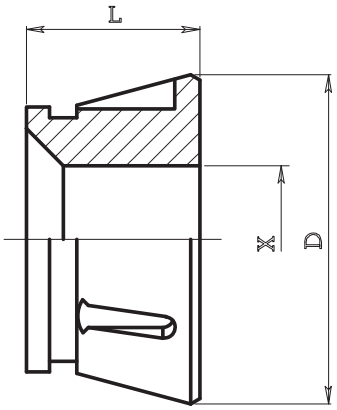
Z
ZIGRINATO
(SERRATED)

Q
QUADRATO
(SQUARE)



E
ESAGONALE
(HEXAGONAL)

PINZE DI SERRAGGIO Tipo 015
CLAMPING COLLETS



Art. / Code	Passaggio barra / Collet tipe	D	L	Alesaggio max / Max bore		
				○	⬡	□
015.065	65	99.5	53	65	56	46
015.080	80	114.5	53	80	68	56

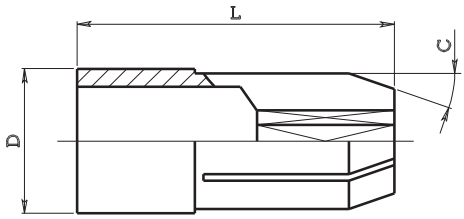
CARATTERISTICHE:
- **Semplifica e rende più rapido il cambio pinza**
- **Aumenta la rigidità del bloccaggio del pezzo da lavorare**

CHARACTERISTICS:
- Simplified and quicker collet changing
- Increased rigidity in blocking the piece to be machined

ATTREZZATURA MANUALE PER CAMBIO PINZA
MANUAL COLLETS CHANGE EQUIPMENT

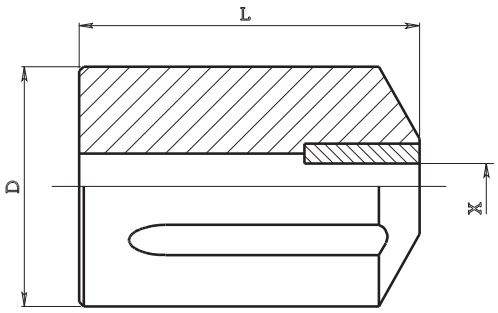
Art. / Code	Passaggio barra / Collet Tipe	Art. pinza / Collet code
015.065CH	65	015.065
015.080CH	80	015.080

BOCCOLE GUIDA BARRA IN METALLO DURO
HARD METAL BUSHES



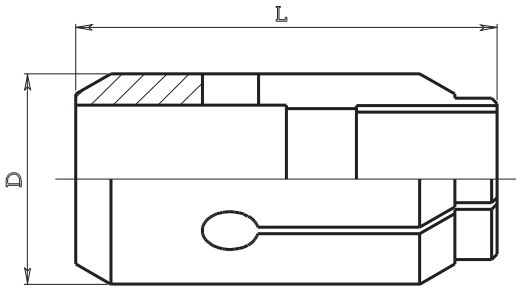
Art. / Code	D	L	C	Macchina / Machine
039.110	9	30	19°	STROHM M4-5 / TORNOS M4-T4
039.130	15	35	19°	STROHM 105-125 / TORNOS M10-R10
039.150	16	35	19°	STROHM 105-125 / TOBRE 10 / TORNOS M10-R10
039.220	28	45	29°	STROHM 205 / TORNOS M20-RR20
039.230	32	45	19°	STROHM 255 / TORNOS M25

BUSSOLE GUIDA BARRA FISSE IN METALLO DURO Tipo 040
HARD METAL FIXED BUSHES



Art. / Code	D	L	X max	Macchina / Machine
040.011	10	18	4.5	STROHM M4-5 / TORNOS M3
040.020	13	30	8	PETERMAN 1-P4 / TORNOS M4-M6-T4-TV / BECHLER A7
040.031	15	30	10	STROHM M75-105-125 / TORNOS M7
040.040	16	30	10	PETERMAN P7-P7R / BECHLER A10 / STROHM M75-105-125
040.050	20	30	13	BECHET 1068-1268 / STROHM 125 / BECHLER A10 / PETERMAN 10-10H7
040.051	22	35	13	TORNOS R10
040.060	25	35	18	PETERMAN 10-10HS-10R-10HSR / OCEA THF25
040.073	32	45	24	STROHM 205-255 / TORNOS M15-R16-RR20-M25 / OCEA THF40
040.080	35	45	22	PETERMAN 2A-2AR-P16-P20
040.090	40	45	30	TORNOS M20-M25-M28 / BECHET 2568 / PETERMAN P25

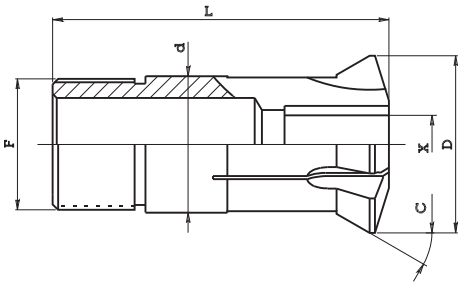
BUSSOLE GUIDA BARRA IN METALLO DURO REGISTRABILI (spinte)
HARD METAL ADJUSTABLE BUSHES (THRUST)



Art. / Code	D	L	Macchina / Machine
041.108	8	30	BECHLER A4-A7
041.116	16	40	BECHLER A7-A10-AE10
041.120	20	40	BECHLER A10
041.130	30	60	BECHLER B12-16-20
041.134	34	60	BECHLER B12-16-20
041.142	42	72	BECHLER C26
041.148	48	73	BECHLER C32

BUSSOLE GUIDA BARRA IN METALLO DURO REGISTRABILI (tirate)

HARD METAL ADJUSTABLE BUSHES (DRAW BACK)



Art. / Code	d	D	L	C	F	X max	Macchina / Machine
042.010	7	9.5	30	16°	6x0.5	3.5	PETERMAN P3
042.030	9	11.5	25	30°	6x0.5 int.	4.5	PETERMAN P4
042.040	9	12.5	44	16°	8x0.75	4.5	TORNOS M4-T4-TV / PETERMAN P4 / CITIZEN L10-L10 WATCH
042.050	9	13	52	30°	9x0.7	4.5	TORNOS M4-T4-TV / BECHLER A-AR-AS4 / GAUTHIER 1H-GM75-GM17 / STROHM M 45
042.060	10	14	57	36°	10x1	4.5	TORNOS M4
042.070	11	14.5	53	16°	10x0.75	7	TORNOS M7 / TSUGAMI NP-4W / TSUGAMI MORI B207III
042.080	12	15.5	50	16°	10x0.75	7	PETERMAN P7
042.090	12	15	52	30°	12x1	7	TORNOS M7-TV-MS1 / BECHLER A-AR-AS7 / PETERMAN NO1R-P7-M7 STROHM M-SJ75K M75 / TSUGAMI NP-4W / TORNOS-BECHLER ENC 16-162-164
042.100	13	16	41.5	15°	12.5x0.75	9	BECHLER AE7 - AE10 - AR10
042.110	13	17	68	5°	13x1	9	TORNOS M7 MAGIC
042.120	14	18	64	16°	13x0.75	9	TORNOS R10
042.130	16	19.8	58	16°	14x1	10	TORNOS MV-R10 / PETERMAN P7R / BECHET RMA7-RMA17 STAR SCN10DX-JNC10-RNC10 / CITIZEN G10-D10-L10-L101-F12 NOMURA I-CAM NN 1053A / TORNOS-BECHLER ENC 16-162-164
042.140	16	20	55	30°	16x1	10	GIGY GL16 / PETERMAN P7R / TORNOS MV
042.150	18	24	69	36°	18x1	10	TORNOS MS7-R10 MAGIC
042.160	18	22	60	30°	18x1	12.7	TORNOS M10-R10-R125-MS7 / GIGY GL16
042.170	18	22	60	30°	16x1	12.7	TORNOS M10-R10-R125-MS7 / BECHLER A-AR-AS 10 / MANURHIN TRAMINER 13 STROHM M-SJ 125K-M 105-125 / CITIZEN D10-L10-L101-F12 TSUGAMI NT-NP 11 / TORNOS-BECHLER ENC 16-162-164
042.180	20	25	55	30°	20x1	13	BECHLER A-AR-AS 10 / PETERMAN 10-10HS-PS127 / GAUTHIER 1H-GM75-GM127 STROHM 75-105-125 / TORNOS-BECHLER ENC 16-162-164
042.200	21	24	57.4	12.5°	18x1	12	STAR VNC12-SNC15DX-JNC16-RNC16
042.210	22	29	68	16°	19x1	16	TORNOS M14-M15-R16-M17 / PETERMAN 10R-10HSR / STAR VNC 12 MANURHIN TRAMITER 16-20 KMX 20-26-220-226 / STROHM 205-255 TSUGAMI NT-NP16-NT-NP17-MARK11
042.212	22	29	68	16°	22x1		TRAUB TNL 16-16G / STROHM M-SJ 155K / NOMURA SN127-SN160-NN160C-D STAR SNC15DX-JNC16-RNC16-SST16-KIR16
042.220	24	30	61	30°	24x1	16	TORNOS M15-R16-M20-RR20 / TORNOS-BECHLER ENC 16-162-164 TOP100 PETERMAN P16 / CITIZEN E16-E16J-F16-G16-L16I-L16N-L16IV-L16VI-L16E TSUGAMI NT-NP16 NT-NP17 MARK11-BS12III / TORNOS DELTA 12
042.230	25	30	71	30°	25x1	16	TORNOS M14-M15-R16-M20-RR20 / PETERMAN 10R-10HSR / GAUTHIER GM15 BECHET RMA 12-RMA I 12-RMA 15-RMA I 15
042.240	27	30	57	13°	24x1	16	BECHLER BE 16-20
042.245	28	34	81	16°	25x1	20	STAR KNC16-VNC20-KNC20 / CITIZEN L20E-L20VI / TRAUB TNL16
042.246	28	38	81	30°	25x1	20	MANURHIN TRAMINER 20-KMX20-26-220-226 / GILDEMEISTER GLD 20 / TSUGAMI S20-NT-NP20-MARK11 / TORNOS DELTA 20
042.250	32	40	71	30°	32x1	21	TORNOS M20-RR20-M24-M25 / PETERMAN 2A-P16R-P20-2AR-P20R / BECHET RMA19-RMA I 19 GAUTHIER GM20 / CITIZEN D16-E20-F20 / TSUGAMI NT-NP20
042.255	34	41	87.5	10°	34x1	25	MANURHIN KMX26-KMX226 / STAR SNC25DX-KJR25 / CITIZEN E25-F25 NOMURA NN20R-NN25R / TORNOS-BECHLER ENC 16-162-164 / GILDEMEISTER GLD 25 / TSUGAMI MORI B26III
042.260	35	40	65	12°	34x1	26	BECHLER CR26
042.270	40	45	65	12°	38x1	26	BECHLER C26-32
042.280	40	48	71	30°	40x1	26	PETERMAN P25-P25R / BECHET RMA25-RMA I 25-RMA32-RMA I 32-TCN32 GAUTHIER GM20-GM25
042.290	40	48	65	30°	40x1	26	BECHLER B-BR12 B-BR16 B-BR20
042.300	40	48	72	30°	36x1	25	TORNOS-BECHLER ENC 262-264 TOP200 / GILDEMEISTER GAC 25L / STROHM M205-255 SN25C
042.302	41	46	54	10°	38x1	32	TSUGAMI MORI BS 32
042.305	42	49	81	16°	40x1	32	STAR JNC25-KNC25-JNC32-KNC32-VNC32 / CITIZEN E32 / GILDEMEISTER 32 TSUGAMI NT-NP32 NT-NP32 MARK11 / MIRABEL 321 MANURHIN
042.310	43	48	65	12°	42x1	32	BECHLER CR 35
042.320	44	53	87	20°	40x1	32	TORNOS MR32
042.325	46	53	92	16°	45x1	38	NEXTURN SA 38E
042.330	48	58	73	20°	48x1.25	32	TORNOS M25-M28-R28-MR32 / PETERMAN P25R
042.340	48	56	81	30°	48x1.25	32	BECHLER C-CR26 C-CR32