

Crawford QCD Standard Quick Change Collet Chucks

For A Type Spindles

- 🔧 Ideal for both bar and secondary operation,
- 🔧 Dead Length Operation
- 🔧 QCD Standard Length Chucks use DIN type Multi-Bore Collets for a powerful parallel grip over a wide diameter range. When gripping short components or where marking of a finished diameter is to be avoided use the B type spring Collet of a fixed bore size Collet.
- 🔧 Collets are available for round, Hex or Square Stock.
- 🔧 Large Capacity- QCD Chuck maximum round 2.36" (60mm)
- 🔧 Save set up time-Quick Change Bayonet Cap Design
- 🔧 Accurate-.0002" TIR from rear mounting register and working collet taper.
- 🔧 Repeatability .0002" on duplicate parts
- 🔧 Design for A type spindles and Din 55026. For other spindle mounts call for availability
- 🔧 1 Year Warranty

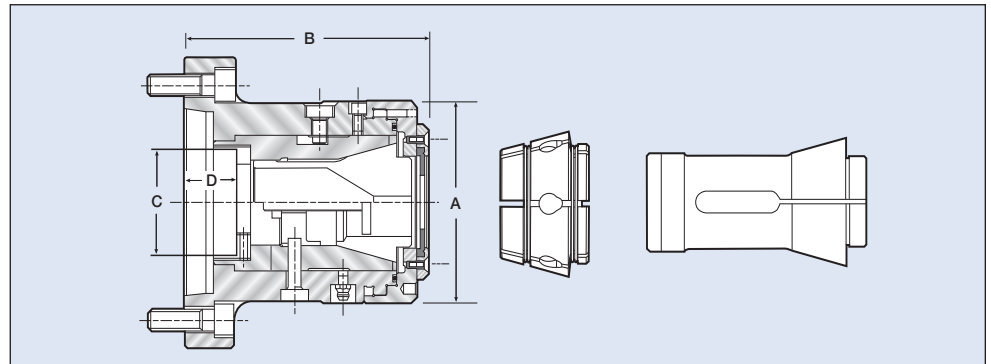
Uses Din 6343 Multibore Collets see page 124 or B Type Spring Collets see page 116-120

- (1) Weight shown for chucks are net and do not include either collets or drawbar adapters
- (2) Each collet size requires a polyurethane chip Chuck Seal.
- (3) Additional Quick Change Chuck Caps can be ordered for pre-loading collets and further reducing downtime.
- (4) Backstop cannot be used with Spring Collets

C† Maximum drawtube thread 'C'

D† Maximum drawtube length retracted 'D'

E† Maximum forward stroke required



QCD Series for Multibore or Spring DIN Standard type Collets

Chuck Type	QCD-42	QCD-42	QCD-60	QCD-60
Mount	A2-5	A2-6	A2-6	A2-8
Multibore Collet	M-673	M-673	M-677	M-677
(4)Spring Collet	B42-4728	B42-4728	B60-4291	B60-4291
Capacity Round (mm/in)	42/1.65	42/1.65	60/2.36	60/2.36
Capacity Hex (mm/in)	38/1.50	38/1.50	52/2.05	52/2.05
Capacity Square (mm/in)	30/1.18	30/1.18	42/1.65	42/1.65
A (mm/in)	114/4.49	114/4.49	146/5.75	146/5.75
B (mm/in)	147/5.79	147/5.79	191/7.52	191/7.52
C† (mm/in)	60/2.36	60/2.36	70/2.76	70/2.76
D† (mm/in)	31/1.22	31/1.22	48/1.89	48/1.89
E† (mm/in)	9/.35	9/.35	10/.39	10/.39
(1) Chuck Weight	19 lbs	19.8 lbs	28.1 lbs	30.9 lbs
Drawbar Force (lb/f)	5,392	5,392	8,536	8,536
Clamping Force (lb/f)	13,199	13,199	22,200	22,200
Maximum RPM	6000	6000	6000	4500
(2)Chuck Seal Part No.	D-237	D-237	D-485	D-485
(3)Chuck Cap Part No.	C-428GA	C-428GA	C-142GA	C-142GA
Ejector Part No.	D-242	D-242	D-490	D-490
Backstop Part No.	D-241	D-241	D-678	D-678
Chuck Order No.	D-233	D-234	D-475	D-477