

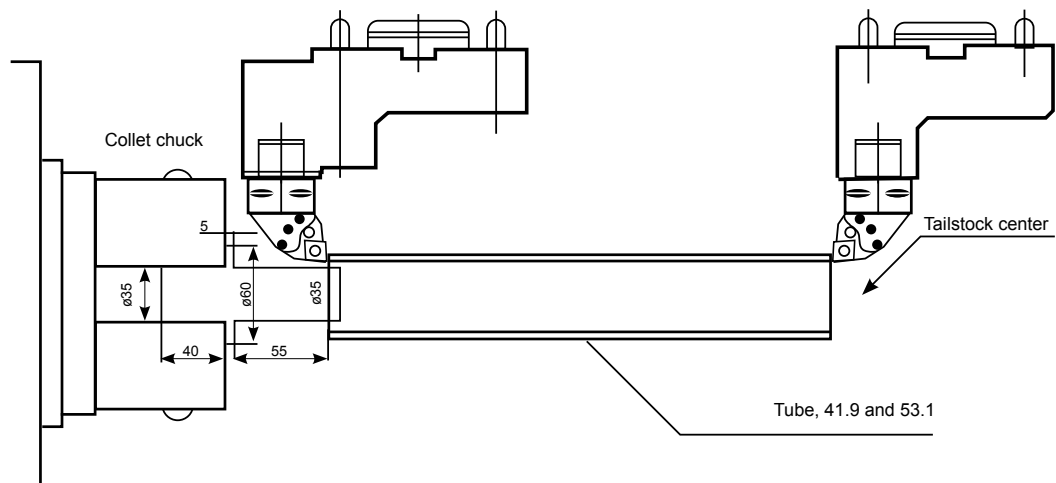
Multi-level internal clamp

Task:

Simultaneously machining both sides of aluminum tubes with varying internal diameters, to a specific length. Also adding an external thread to both sides.

Customized adjustments:

The customer removed one of the clamping levels at short notice.



Solution:

A two-level centering clamp is designed so that it can clamp different pipes – with two or three levels, as needed.

Procedure:

The pipes are pushed manually over the two-level centering clamp; there is a removable stop on the collet chuck side. A socket screw sits inside the centering device for the tailstock center. Using this screw, floating tapered rings expand the clamping balls outward, thereby clamping the pipe evenly over its entire length.

Summary:

Simultaneous machining from both sides saves time and expenses, and can improve machining precision.