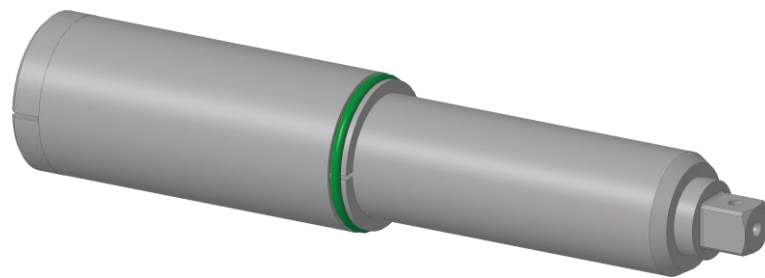


# Cleco

## BD, BTS, BTi Series



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## 1 About this Document

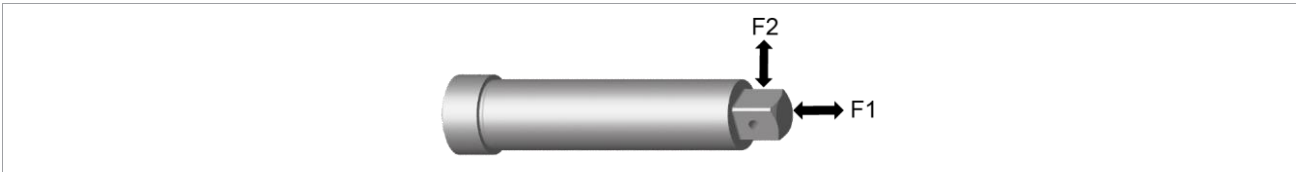
This document is valid for the following products:

Fixtured Spindle BD, BTS, BTi Series

### Other Documents

Number	Document
P2610KA	Quick guide Assembly Floating Adapter- BD BTS(i)

## 2 Spring chuck



### 2.1 Size 1

Output drive straight / Output drive offset

Chuck Order No.	Spring deflection <sup>1</sup> [mm]	Output drive	Spring force	Compression spring		
				Order No.	Extended [N]	Retracted [N]
S388074	50	3/8"	Weak	S919056	10±1.5	26.8±3
922325PT	50	3/8"	Standard	942016PT	19±2.2	48±2.6
S333110	50	3/8"	Strong	910916	33±4	91±4.8


Chuck Order No.	Axial force [F1] <sup>2</sup>		Lateral force [F2] <sup>2</sup>		
	Pressure [N]	Tensile [N]	Extended [N]	Retracted 50% [N]	Retracted 100% [N]
S388074	1500	750	550	650	750
922325PT	1500	750	550	650	750
S333110	1500	750	550	650	750

<sup>1</sup> Further spring deflections on request

<sup>2</sup> The specified values refer to continuous load

## 2.2 Size 2


Output drive straight / Output drive offset

Chuck Order No.	Spring deflection <sup>1</sup> [mm]	Output drive 	Spring force	Compression spring		
				Order No.	Extended [N]	Retracted [N]
On request	50	1/2"	Weak	S919056	10±1.5	26±3
910609	50	1/2"	Standard	942016PT	19.6±2.2	48.6±2.6
S331765	50	1/2"	Strong	910916	33±4	91±4.8
On request	50	3/4"	Weak	S919056	10±1.5	26±3
935552	50	3/4"	Standard	942016PT	19.6±2.2	48.6±2.6
On request	50	3/4"	Strong	912043		

Chuck Order No.	Axial force [F1] <sup>2</sup>		Lateral force [F2] <sup>2</sup>		
	Pressure [N]	Tensile [N]	Extended [N]	Retracted 50% [N]	Retracted 100% [N]
910609	4500	3200	350	400	500
S331765	4500	3200	350	400	500
935552	4500	3200	350	400	500

## 2.3 Size 3

Output drive straight / Output drive offset

Chuck Order No.	Spring deflection <sup>3</sup> [mm]	Output drive 	Spring force	Compression spring		
				Order No.	Extended [N]	Retracted [N]
On request	50	3/4"	Weak	S919056	10±1.5	26±3
910613	50	3/4"	Standard	942016PT	19±2.2	48±2.6
S333111	50	3/4"	Strong	910916	33±4	91±4.8

Chuck Order No.	Axial force [F1] <sup>4</sup>		Lateral force [F2] <sup>4</sup>		
	Pressure [N]	Tensile [N]	Extended [N]	Retracted 50% [N]	Retracted 100% [N]
910613	6500	5000	500	600	750
S333111	4500	5000	500	600	750

<sup>1</sup> Further spring deflections on request

<sup>2</sup> The specified values refer to continuous load

<sup>3</sup> Further spring deflections on request

<sup>4</sup> The specified values refer to continuous load

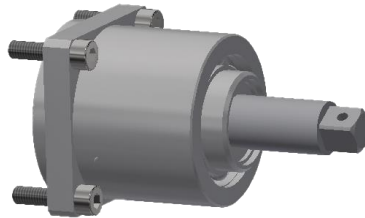
## EN 3 Spring chuck including flange housing

Output drive straight / Output drive offset



Order No.	Size	Torque [Nm]	Weight [kg]
S308434	1 – 3/8"	60	On request
S308435	2 – 1/2"	160	On request
S308450	2 – 3/4"	200	On request
S308436	3 – 3/4"	520	2.25
S308437	1 – 3/8"	60	On request
S308438	2 – 1/2"	110	On request
S308475	2 – 3/4"	200	On request
S308439	3 – 3/4"	300	On request
S308440	4 – 3/4"	520	On request
S308474	4 – 1"	660	On request

Angle output drive



Order No.	Size	Permissible load on the output shaft			Lateral force on the adapter <sup>1</sup>		Weight [kg]
		Torque [Nm]	Compression <sup>1</sup> [N]	Tensile <sup>1</sup> [N]	Extended [N]	25 mm Retracted [N]	
929041	1 – 3/8"	60	1700	6800	1800	2100	0.54
929053	2 – 1/2"	170	1850	6800	2500	3000	On request
929061	2 – 3/4"	210	1850	6800	2500	3000	On request
929065	3 – 3/4"	300	3800	7800	3000	3450	2.25
929077	4 – 3/4"	520	12,000	13,000	4300	5050	On request
929089	4 – 1"	660	12,000	13,000	4300	5050	On request

<sup>1</sup> In the case of continuous loading, multiply the specified values by 0.3

## 4 Locking

### Socket retaining rings

Plastic ring with steel insert



Order No.	Size ■	Inner diameter [mm]
10005S	3/4"	31.8
10032S	3/4"	36.5
10034S	3/4"	41.3
10008S	1"	44.5
10010S	1"	50.8
10015S	1"	54.0
10016S	1"	57.2
10017S	1"	63.5
10019S	1"	66.7
10020S	1 1/2"	73.0
10025S	1 1/2"	85.7

### Metal ring



Order No.	Size ■	Inner diameter [mm]
MET-1301C	3/8"	17.2
MET-1302C	3/8"	19.6
MET-1401C	1/2"	22.5
MET-1402C	1/2"	27.6
MET-1600C	3/4"	40.5
MET-1800C	1"	49.5

## 1 Zu diesem Dokument

Dieses Dokument gilt für folgende Produkte:

Einbauschrauber Serie BD, BTS, BTi

### Weiterführende Dokumente

Nummer	Dokument
P2610KA	Kurzanleitung Montage – Federnder Schlüsselkopf - BD BTS(i)

## 2 Federnder Schlüsselkopf



### 2.1 Baugröße 1

Abtrieb zentrisch / Abtrieb versetzt

Schlüsselkopf Bestell-Nr.	Federweg <sup>1</sup> [mm]	Abtrieb ■	Federkraft	Druckfeder		
				Bestell-Nr.	Ausgefедert [N]	Eingefедert [N]
S388074	50	3/8"	Schwach	S919056	10±1,5	26,8±3
922325PT	50	3/8"	Standard	942016PT	19±2,2	48±2,6
S333110	50	3/8"	Stark	910916	33±4	91±4,8

Schlüsselkopf Bestell-Nr.	Axialkraft [F1] <sup>2</sup>		Querkraft [F2] <sup>2</sup>		
	Druck [N]	Zug [N]	Ausgefедert [N]	Eingefедert 50 % [N]	Eingefедert 100 % [N]
S388074	1500	750	550	650	750
922325PT	1500	750	550	650	750
S333110	1500	750	550	650	750

<sup>1</sup> Weitere Federwege auf Anfrage

<sup>2</sup> Die angegebenen Werte beziehen sich auf Dauerbelastung



## 2.2 Baugröße 2

Abtrieb zentrisch / Abtrieb versetzt

Schlüsselkopf Bestell-Nr.	Federweg <sup>1</sup> [mm]	Abtrieb ■	Federkraft	Druckfeder		
				Bestell-Nr.	Ausgefедert [N]	Eingefедert [N]
Auf Anfrage	50	1/2"	Schwach	S919056	10±1,5	26±3
910609	50	1/2"	Standard	942016PT	19,6±2,2	48,6±2,6
S331765	50	1/2"	Stark	910916	33±4	91±4,8
Auf Anfrage	50	3/4"	Schwach	S919056	10±1,5	26±3
935552	50	3/4"	Standard	942016PT	19,6±2,2	48,6±2,6
Auf Anfrage	50	3/4"	Stark	912043		

Schlüsselkopf Bestell-Nr.	Axialkraft [F1] <sup>2</sup>		Querkrаft [F2] <sup>2</sup>		
	Druck [N]	Zug [N]	Ausgefедert [N]	Eingefедert 50 % [N]	Eingefедert 100 % [N]
910609	4500	3200	350	400	500
S331765	4500	3200	350	400	500
935552	4500	3200	350	400	500

## 2.3 Baugröße 3

Abtrieb zentrisch / Abtrieb versetzt

Schlüsselkopf Bestell-Nr.	Federweg <sup>3</sup> [mm]	Abtrieb ■	Federkraft	Druckfeder		
				Bestell-Nr.	Ausgefедert [N]	Eingefедert [N]
Auf Anfrage	50	3/4"	Schwach	S919056	10±1,5	26±3
910613	50	3/4"	Standard	942016PT	19±2,2	48±2,6
S333111	50	3/4"	Stark	910916	33±4	91±4,8

Schlüsselkopf Bestell-Nr.	Axialkrаft [F1] <sup>4</sup>		Querkrаft [F2] <sup>4</sup>		
	Druck [N]	Zug [N]	Ausgefедert [N]	Eingefедert 50 % [N]	Eingefедert 100 % [N]
910613	6500	5000	500	600	750
S333111	4500	5000	500	600	750

<sup>1</sup> Weitere Federwege auf Anfrage

<sup>2</sup> Die angegebenen Werte beziehen sich auf Dauerbelastung

<sup>3</sup> Weitere Federwege auf Anfrage

<sup>4</sup> Die angegebenen Werte beziehen sich auf Dauerbelastung

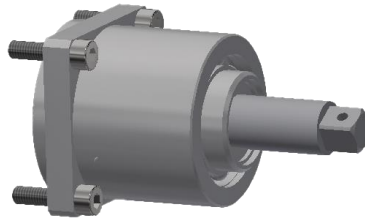
## DE 3 Federnder Schlüsselkopf inklusive Flanschgehäuse

Abtrieb zentrisch / Abtrieb versetzt



Bestell-Nr.	Baugröße	Drehmoment [Nm]	Gewicht [kg]
S308434	1 – 3/8"	60	Auf Anfrage
S308435	2 – 1/2"	160	Auf Anfrage
S308450	2 – 3/4"	200	Auf Anfrage
S308436	3 – 3/4"	520	2,25
S308437	1 – 3/8"	60	Auf Anfrage
S308438	2 – 1/2"	110	Auf Anfrage
S308475	2 – 3/4"	200	Auf Anfrage
S308439	3 – 3/4"	300	Auf Anfrage
S308440	4 – 3/4"	520	Auf Anfrage
S308474	4 – 1"	660	Auf Anfrage

Abtrieb Winkel



Bestell-Nr.	Baugröße	Zulässige Belastung auf Abtriebswelle			Querkraft am Schlüsselkopf <sup>1</sup>		Gewicht [kg]
		Drehmoment [Nm]	Druck <sup>1</sup> [N]	Zug <sup>1</sup> [N]	aus-gefedert [N]	25 mm eingefedert [N]	
929041	1 – 3/8"	60	1700	6800	1800	2100	0,54
929053	2 – 1/2"	170	1850	6800	2500	3000	Auf Anfrage
929061	2 – 3/4"	210	1850	6800	2500	3000	Auf Anfrage
929065	3 – 3/4"	300	3800	7800	3000	3450	2,25
929077	4 – 3/4"	520	12 000	13 000	4300	5050	Auf Anfrage
929089	4 – 1"	660	12 000	13 000	4300	5050	Auf Anfrage

<sup>1</sup> bei Dauerbelastung die angegebenen Werte mit 0,3 multiplizieren

## 4 Arretierung

### Sicherungsringe für Steckschlüsseinsätze

Kunststoffring mit Stahleinsatz



Bestell-Nr.	Abtrieb ■	Innendurchmesser [mm]
10005S	3/4"	31,8
10032S	3/4"	36,5
10034S	3/4"	41,3
10008S	1"	44,5
10010S	1"	50,8
10015S	1"	54,0
10016S	1"	57,2
10017S	1"	63,5
10019S	1"	66,7
10020S	1 1/2"	73,0
10025S	1 1/2"	85,7

### Metallring

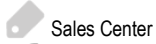


Bestell-Nr.	Abtrieb ■	Innendurchmesser [mm]
MET-1301C	3/8"	17,2
MET-1302C	3/8"	19,6
MET-1401C	1/2"	22,5
MET-1402C	1/2"	27,6
MET-1600C	3/4"	40,5
MET-1800C	1"	49,5

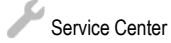
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