



## **Thame adopts a new workholding approach to achieving perfect roundness**

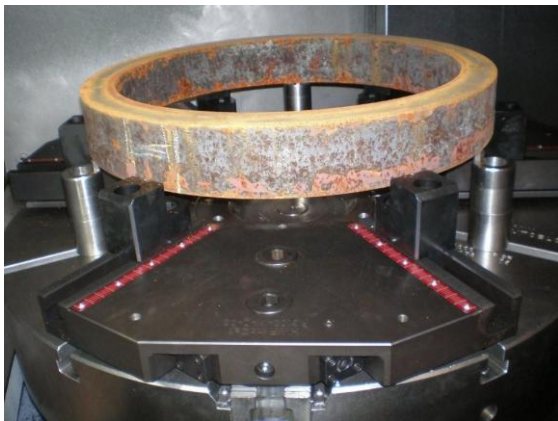
The award-winning InoZet clamping system developed by HWR Spanntechnik has been designed primarily to lower out of roundness on turned parts to an acceptable level and is particularly relevant to the machining of large ring-type workpieces. By converting a standard three-jaw chuck into a six-jaw chuck the clamping forces are distributed more evenly around the workpiece. This contributes to reduced distortion of the workpiece and to a significant improvement in machined roundness – for example, out of roundness on a 610 mm turned diameter can be reduced from 0.20 mm to 0.03mm.

Now available from sole UK agent Thame Workholding, each InoZet segment – which takes a range of standard clamping jaws including soft, hard and segment styles for internal and external clamping – functions as a ‘bridge’ with up to 10 degrees of pendulum movement. The net result is that the workpiece is effectively self-centred as the clamping force is applied and the out-of-balance effect is virtually eliminated.

The more evenly distributed clamping force makes this new system ideally suited to the machining of deformation-sensitive workpieces as well as out-of-round blanks and components deformed by heat treatment. The pendulum mechanism is protected from contamination to maintain the chuck’s true running properties and,

overall, the system's robust construction should ensure many years of trouble-free operation.

InoZet makes the conversion of an existing three-jaw chuck into a highly flexible, compensating six-jaw chuck a quick and easy process – and one offering large cost savings. Because the clamping jaws on each pendulum segment can be positioned as required within the entire clamping range of the chuck, there is no requirement for additional sets of clamping jaws or any need for expensive 'specials'. Added to which this award-winning clamping system can be retrofitted to any size and make of standard three-jaw chuck from 250 mm diameter upwards.



Clamping Raw Ring with Inozet



Finished Ring

The above ring was machined on a Vertical Turning Machine clamped in a 610mm diameter chuck with three jaws achieving a roundness of 0.20mm after InoZet was installed the part was finished with a roundness of 0.03mm.

To arrange for a demonstration or to get more detailed information of this award-winning clamping system please contact the sales office at Thame Workholding.

**THAME WORKHOLDING**

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