

# STANDARD CLAMPING ELEMENTS



**POWER CLAMP**

6 - 10



**CLAMPS**

11 - 38



**SUPPORT BLOCKS**

39 - 44



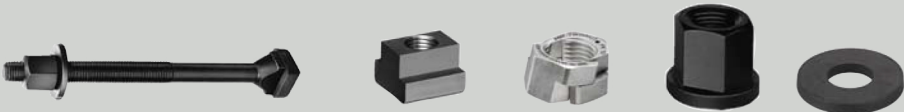
**SETTING ELEMENTS  
MANDREL AND FLOATING CLAMP**

45 - 66



**CLAMPING BOLTS, NUTS AND WASHERS**

67 - 89



**CLAMPING SETS AND ACCESSORIES**

90 - 96



**PULL-DOWN CLAMPS**

97 - 115



**POSITIONING ELEMENTS**

116 - 128



**STOPS AND PRECISION T-NUTS**

129 - 134



**CENTRING CLAMP AND ECCENTRIC CLAMP**

135 - 144



## PARALLEL SUPPORTS-SET, SUPER-PRECISION

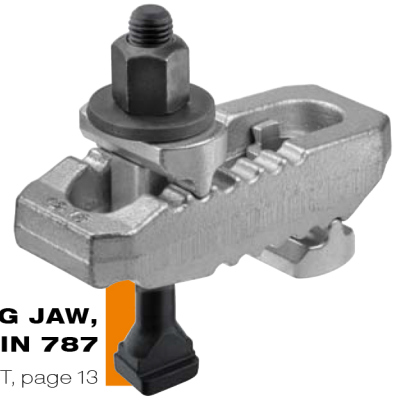
No. 6347SP, page 118



Optimised wooden case  
for perfect handling!

## „CROCODILE“ CLAMPING JAW, COMPLETE WITH DIN 787

No. 6312VT, page 13



## ALUMINIUM BASE

No. 6406AF, page 50

**NEW!**



## POWER CLAMP

No. 7600, page 6  
New size!



- + Low installation height
- + Clamping force up to 22 kN or 49 kN
- + Continuously adjustable

## SPACER ELEMENT

No. 7600Z, page 7  
New size!



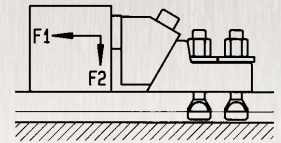
## PRESSURE PAD

No. 7600D, page 8  
New sizes!



The wedge action of clamping jaws is the characteristic feature of these pull down clamps. It causes the "pull down effect", which presses the workpiece against both, stop and machine table. The clamping force is resolved to its horizontal and vertical components F1 and F2. The lateral catch of jaws allows complete machining from above of top faces even for low sized workpieces without problems.

The clamp forces mentioned in the tables are achieved by using the optimal size of bolts and utilizing the respective permissible torque. Force F1 presses the workpiece against the stop, pull down force F2 is achieved with a plain face of workpiece.



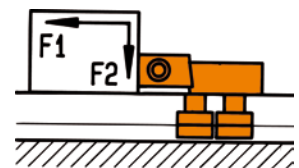
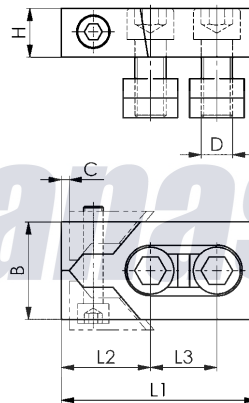
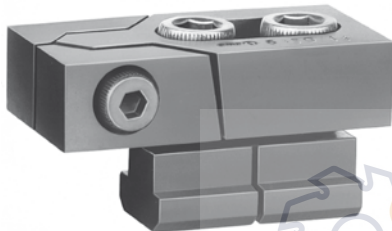
## No. 6490

### Low height clamping jaws, model „Bulle“

tempered and burnished. Packing: 2 units in carton, complete with cap screw ISO 4762-10.9, T-nuts DIN 508 and hexagon key ISO 2936.

Available in pairs only!

Order no.	Slot	B	C	D	H	L1	L2	L3	F1 [kN]	F2 [kN]	Weight [g]
72959	12	40	3	M10	20	80	39	26	16	0,6	1150
72967	14	40	3	M12	20	80	39	26	22	0,9	1250
72975	16	40	3	M12	20	80	39	26	22	0,9	1330
72983	16	50	4	M14	25	100	46	34	32	1,2	2340
72991	18	50	4	M16	25	100	46	34	36	1,4	2540
73007	20	50	4	M16	25	100	46	34	36	1,4	2660
73015	22	78	5	M20	30	140	65	50	36	1,4	5980
73023	24	78	5	M20	30	140	65	50	36	1,4	6330
73031	28	78	5	M24	30	140	65	50	40	1,6	7060
73049	30	78	5	M24	30	140	65	50	40	1,6	7580



CAD



## No. 6491

### Slot stop

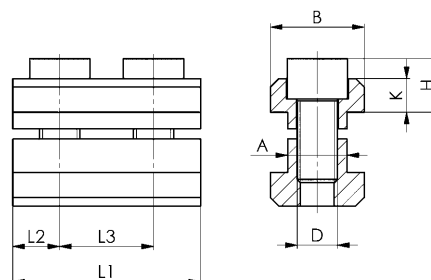
tempered and burnished.



Order no.	Slot	A	B	D	H	K	L1	L2	L3	Weight [g]
73817	12	11,7	18	M8	12	7	36	9,0	18	100
73825	14	13,7	22	M8	12	8	44	11,0	22	140
73833	16	15,7	25	M12	15	9	50	12,5	25	240
73841	18	17,7	28	M12	16	10	56	14,0	28	340
73858	20	19,7	32	M16	19	12	64	16,0	32	520
73866	22	21,7	35	M16	21	14	70	17,5	35	720
73874	24	23,7	40	M20	23	16	80	20,0	40	880
73882	28	27,7	44	M20	24	18	88	22,0	44	1460

### Application:

To be used for longitudinal or transversal function. The low overall height allows application with flat workpieces.



Recommendations



No. 911LG-H100F

CAD





## No. 6492

### Flat clamp, model „Mini-Bulle“

tempered and burnished. Packing: 2 units in carton, complete with fastening screws ISO 4762 (8.8) and hexagon key ISO 2936. Only delivered in pairs!



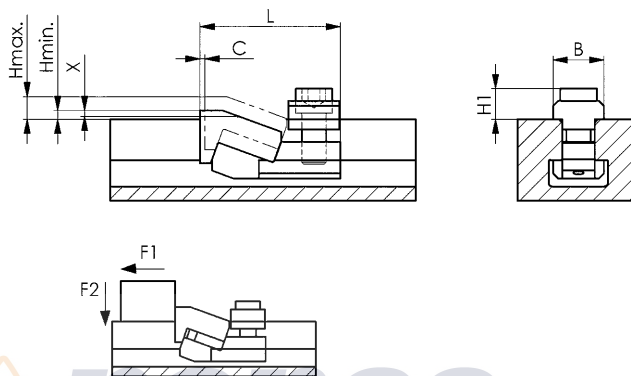
Order no.	Slot	H min.	H max.	B	C	H1	L	X	F1 [kN]	F2 [kN]	Weight [g]
73098	12	2,5	13,5	18	1,8	11	52	5	5,0	0,6	300
73106	14	1,5	13,5	22	1,8	11	55	5	5,5	0,7	380
73114	16	2,5	17,0	25	2,5	15	68	6	8,0	0,9	700
73122	18	1,5	16,0	28	2,5	15	71	6	9,0	1,0	830
73080	22	4,5	21,5	35	3,0	20	89	9	16	1,9	1740

Hmin./Hmax.: depending on groove depth to DIN 650.

The clamping piece can be ground by X mm. This allows lower clamping heights to be achieved.

### Application:

These tempered clamps are designed for extremely low workpieces. Wedge action of jaws presses the workpiece firmly and safely against the machine table. The horizontal forces are compensated by a screw related to slot size, which blocks the clamp without damage to table.



CAD



## No. 6492D

### Flat clamp, double, model „Mini-Bulle“

tempered and burnished. Packing: 2 units in carton, complete with fastening screws ISO 4762 (8.8) and hexagon key ISO 2936. Only delivered in pairs!



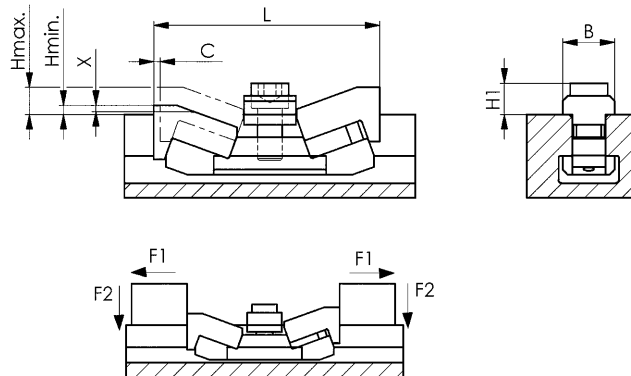
Order no.	Slot	H min.	H max.	B	C	H1	L	X	F1 [kN]	F2 [kN]	Weight [g]
73486	12	2,5	13,5	18	1,8	11	86	5	5,0	0,6	370
73494	14	1,5	13,5	22	1,5	11	88	5	5,5	0,7	485
73791	16	2,5	17,0	25	2,5	15	112	6	8,0	0,9	850
73809	18	1,5	16,0	28	2,0	15	114	6	9,0	1,0	1060
73924	22	4,5	21,5	35	2,7	20	145	8	16,0	1,9	2200

Hmin./Hmax.: depending on groove depth to DIN 650.

The clamping piece can be ground by X mm. This allows lower clamping heights to be achieved.

### Application:

Particularly short workpieces can be clamped with these tempered flat clamps. The wedge effect of the jaws tightly and reliably presses the workpiece against the machine tool table. The horizontal forces are absorbed by a screw corresponding to the groove size, and this firmly clamps the clamp without damaging the table.



CAD



### Recommendations



No. 911LG-H100F

Subject to technical alterations.

## No. 6365

### Pull-Down Clamp

Hardened steel

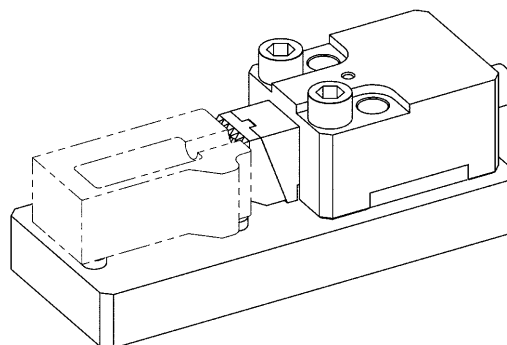
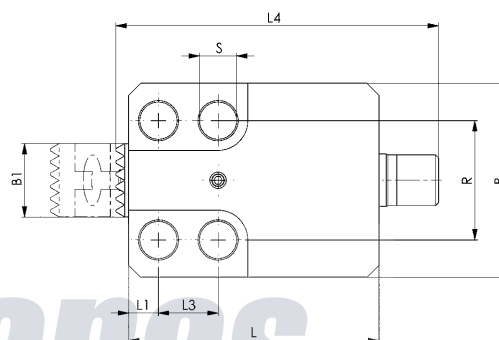
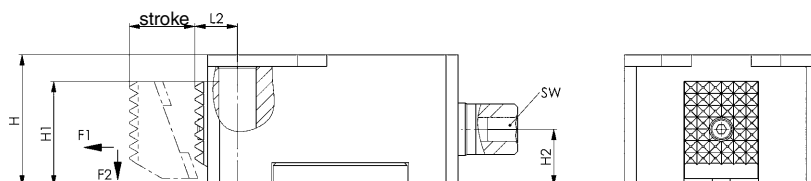


CAD

Order no.	Size	B	B1	H	H1	H2	F1 [kN]	F2 [kN]	Weight [g]
88492	12	65	25	44	36	19	20	2	1515
79392	16	80	30	50	41	21	40	4	2604

### Application:

This clamping jaw must be able to run on the mounting surface.



### Recommendations



No. 6365G,  
page 100



No. 6365N,  
page 100

### Dimensions:

Order no.	L	L1	L2	L3	L4	R	dia. S	SW	Stroke [mm]
88492	84	10	14	20	108,5	40	12,5	8	22
79392	102	15	18	25	123,0	50	16,5	10	27

## No. 6365G

### Clamping Jaws, serrated

Hardened steel



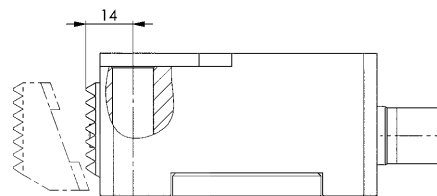
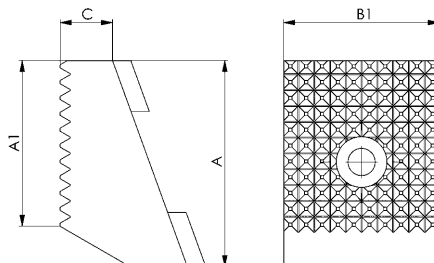
CAD



Order no.	Size	A	A1	B1	C	Weight [g]
88500	12	32,5	26	24,6	8,5	69
120360	16	37,5	31	29,8	7,5	99

#### Note:

This clamping jaw be part of standart sortiment for draw-down clamp 6365-\*\*-001.



## No. 6365N

### Clamping Jaws, with ridge

hardened steel



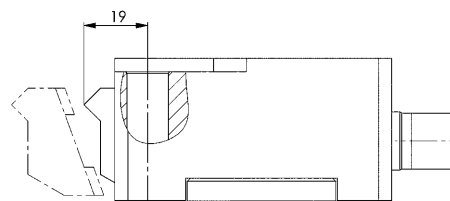
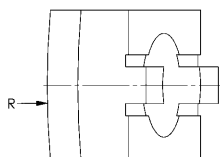
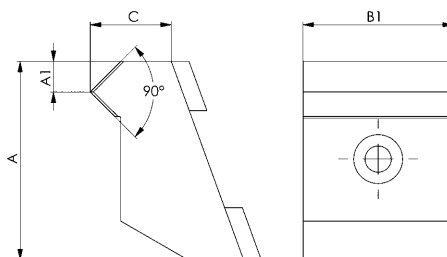
CAD



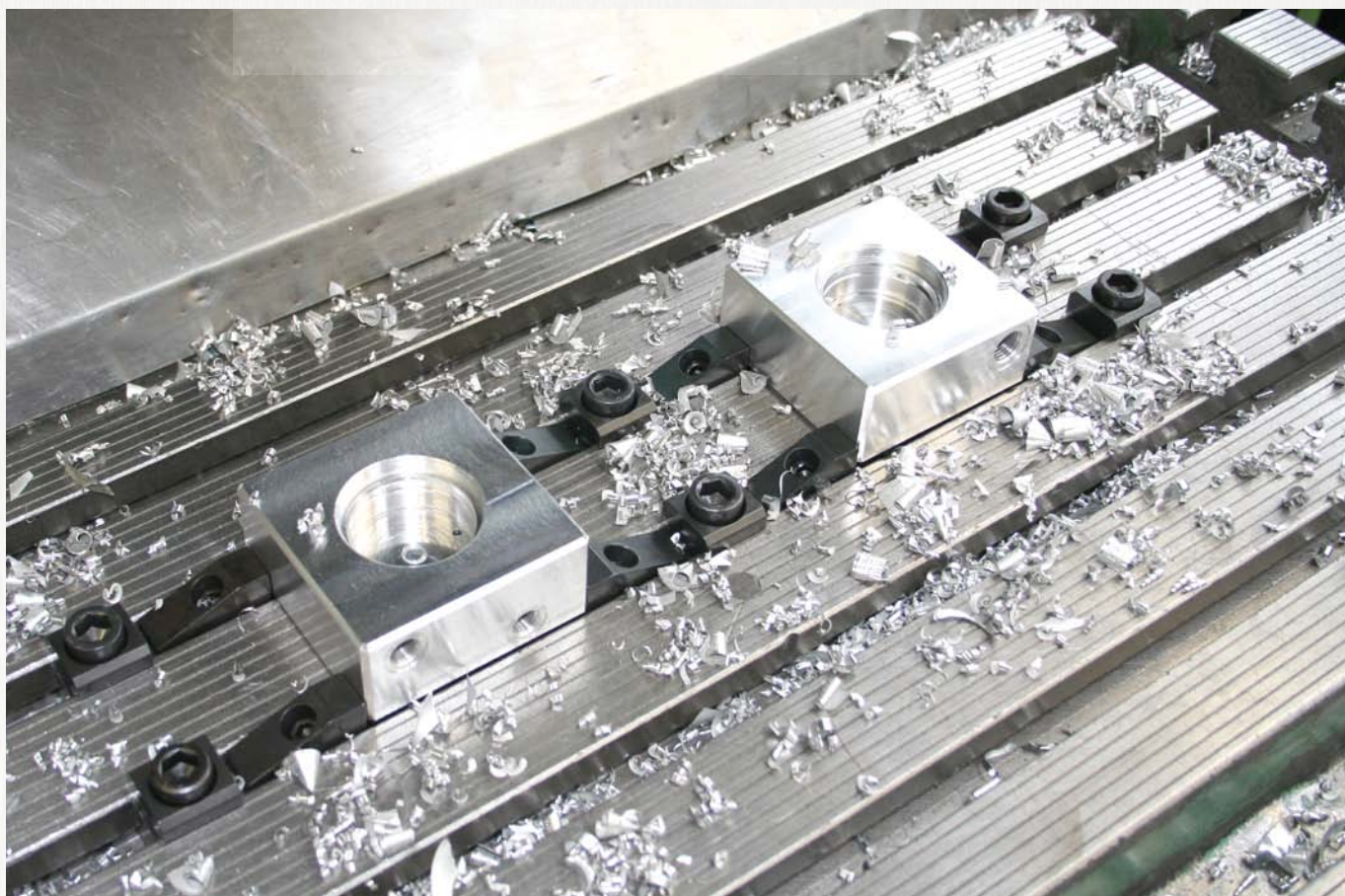
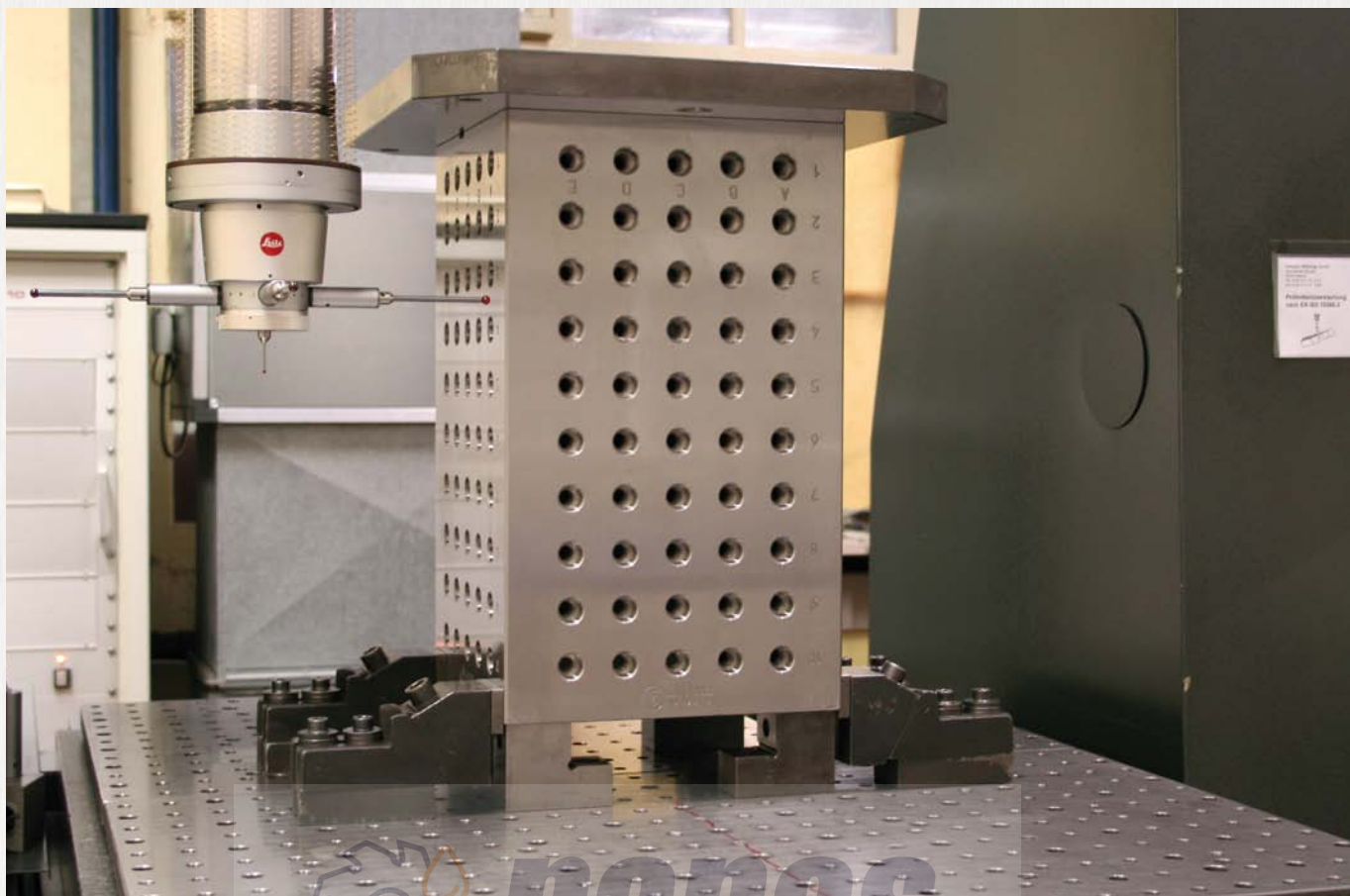
Order no.	Size	A	A1	B1	C	R	Weight [g]
88526	12	32,5	5	24,6	13	200	74
88542	16	37,5	5	29,8	12,5	250	110

#### Application:

Suitable for pull-down clamp no. 6365. Especially suitable for workpieces with a very uneven or hard surface (castings).









No. 6494

## Low height clamping jaws, model „Maxi-Bulle“

Body: spherical casting. Jaws: tempered and burnished. Packing: 2 units in carton with hexagon key ISO 2936 without screw s or bolts. Available in pairs only!



CAD

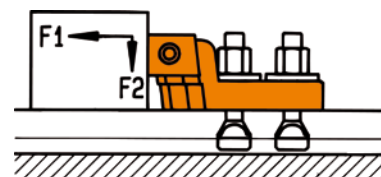
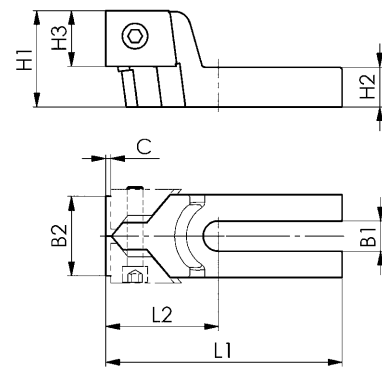


Order no.	Slot	B1	B2	C	H1	H2	H3	L1	L2	F1* [kN]	F2* [kN]	Weight [g]
73130	10 12 14	13	40	3	50	20	30	115	60	6 10 15	0,2 0,4 0,6	1590
73148	16 18 20	19	50	4	60	25	35	150	72	20 28 36	0,8 1,1 1,4	2940
73155	22 24 28 30 32 36	31	80	5	75	30	45	205	102	38 38 40 40 44 44	1,5 1,5 1,6 1,6 1,7 1,7	7900

\* Clamping forces F1 and F2 depend on the groove width.

## Application:

The clamping jaws „Maxi-Bulle“ for work on larger heights was developed from the tried and tested Model „Bulle“ no. 6490. The wedge faces of these clamps are skilfully arranged to achieve maximum clamping force with low exertion. For fastening, 2 T-slot bolts DIN 787 for each clamping jaw, according to T-slot size in use, should be ordered separately. For lower arrangement of clamping screws use cap screws ISO 4762 with washers DIN 6340 and T-nuts 508.



## Recommendations



No. 911LG-H100F

Subject to technical alterations.

## No. 6497

### Extra strong clamping jaw

High design with exact prismatic guide.

Main body: malleable iron.

Clamping jaws: case-hardening steel, case-hardened. Reversible clamping jaws with smooth side for machined workpieces and serrated side for rough clamping surfaces.



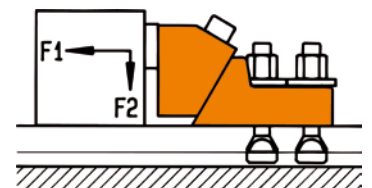
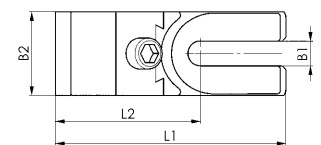
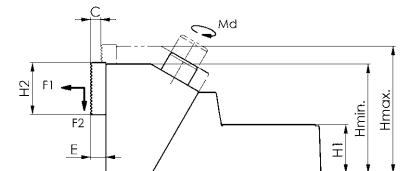
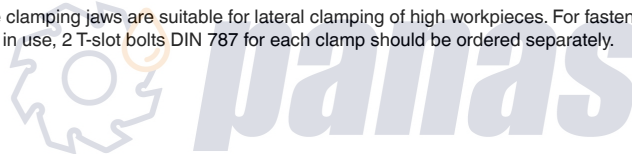
CAD

Order no.	Slot	B1	B2	C	E	H min.	H max.	H1	H2	L1	L2	F1* [kN]	F2* [kN]	Md [Nm]	Weight [g]
73213	12	19	65	8	12	85	99	38	40	179	112,5	8	1,2	20	4037
	14											15	2,2	40	
	16											20	3,0	45	
	18											28	4,2	60	
73221	20	26	75	11	12	100	118	45	40	230	138,5	25	4,5	85	6688
	22											25	4,5	85	
	24											32	4,8	95	
	28											32	4,8	95	
	30											36	5,4	110	
73239	32	38	90	15	12	120	145	56	40	265	158	50	7,5	160	11031
	36														
	42														

\* Clamping forces F1 and F2 depend on the groove width.

### Application:

Due to their large clamping faces these clamping jaws are suitable for lateral clamping of high workpieces. For fastening on the machine table we recommend the use of 2 clamping screws! Related to T-slot size in use, 2 T-slot bolts DIN 787 for each clamp should be ordered separately.



## No. 6497G

### Stable clamping jaws, closed

High design with exact prismatic guide.

Body: malleable casting.

Clamping jaws: Case-hardening steel, case-hardened.

Reversible clamping jaws with smooth side for machined workpieces and serrated side for rough clamping surfaces.

Closed groove for use on vertical turning and boring machines.



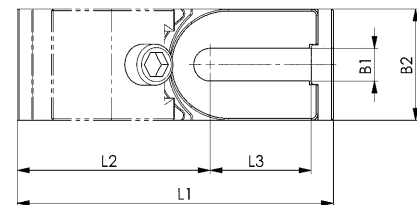
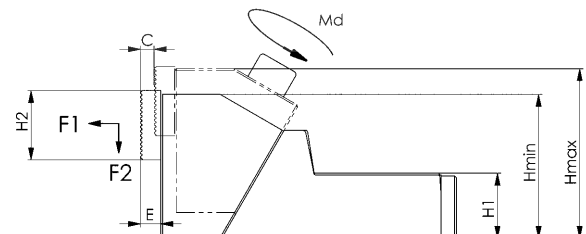
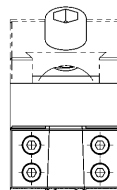
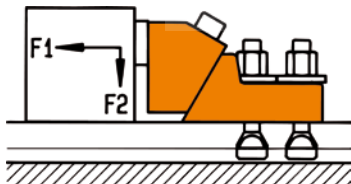
CAD



Order no.	Slot	B1	B2	C	E	H min.	H max.	H1	H2	L1	L2	L3	F1* [kN]	F2* [kN]	Md [Nm]	Weight [g]
376426	12	19	65	8	12	85	99	38	40	187	112,5	60	8	1,2	20	4202
	14												15	2,2	40	
	16												20	3,0	45	
	18												28	4,2	60	
376442	20	26	75	11	12	100	118	45	40	242	138,5	83	25	4,5	85	7029
	22												25	4,5	85	
	24												32	4,8	95	
	28												32	4,8	95	
	30												36	5,4	95	
376467	32	38	90	15	12	120	145	56	40	283	158,0	95	50	7,5	170	12150
	36															
	42															

### Application:

Due to their large clamping faces these clamping jaws are suitable for lateral clamping of high workpieces. For fastening on the machine table we recommend the use of 2 clamping screws! Related to T-slot size in use, 2 T-slot bolts DIN 787 for each clamp should be ordered separately.



### Recommendations



No. 6497B,  
page 106



No. 911LG-H100F

## No. 6497A

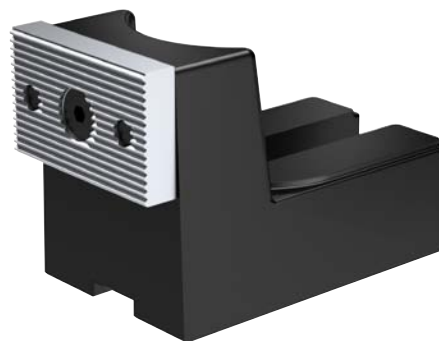
### Stop, fixed

High design.

Body: Cast steel.

Clamping jaws: Case-hardening steel, case-hardened.

Reversible clamping jaws with smooth side for machined workpieces and serrated side for rough clamping surfaces.



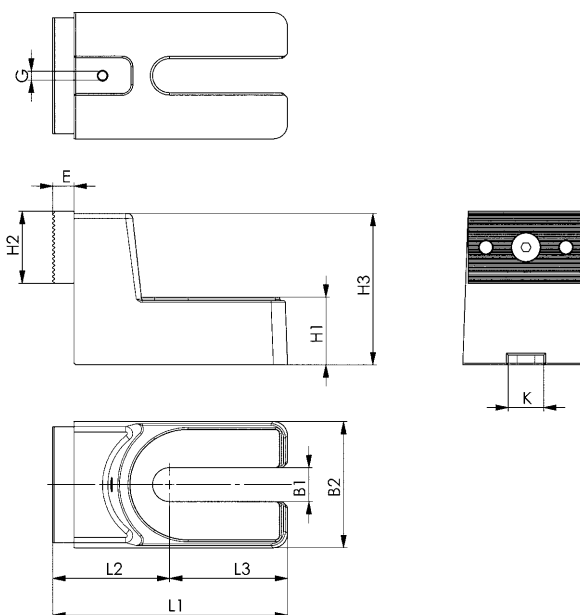
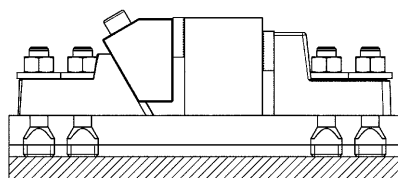
Order no.	Slot	B1	B2	E	G	H1	H2	H3	K	L1	L2	L3	Weight [g]
550509	12 14 16 18	19	65	12	M6	38	40	85	20	132	66,0	66,0	2857
550510	20 22 24 28 30	26	75	12	M6	45	40	100	20	177	85,5	91,5	4673
550511	32 36 42	38	90	12	M6	56	40	120	20	211	95,0	116,0	7900

### Application:

Stop for workpieces or fixtures that are clamped or fastened to the machine table using a stable clamping jaw. Depending on requirements, the clamping jaw can be rotated so that either a smooth surface or a serrated surface is available.

### Note:

Flat sliding block no. 6322A or 6322B enables the stop to be accurately positioned in the machine table groove.



### Recommendations



No. 6497B,  
page 106



No. 6497B

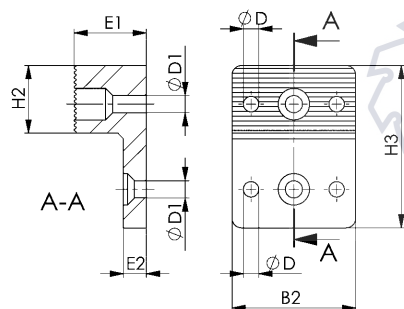
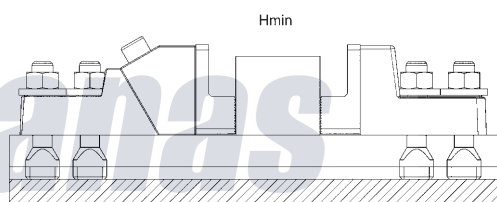
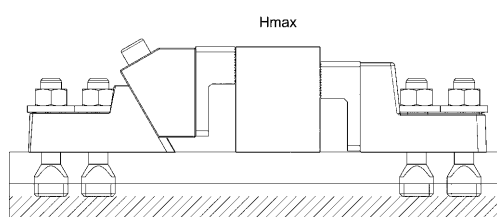
## Clamping jaw

Case-hardened steel, nitrided, with fastening bolt M8

Order no.	Size	B2	D	D1	E1	E2	H2	H3	Weight [g]
550512	19	65	8,1	9	38	12	35	85	889
550513	26	75	8,1	9	38	12	45	100	1306
550514	38	90	8,1	9	38	12	50	120	1829

### Application:

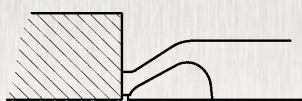
Clamping jaw with serrated surface for machining of unmachined parts. Can be mounted on the stable clamping jaw or the stop.



## CLAMPING WITH HORIZONTAL PRESSURE:

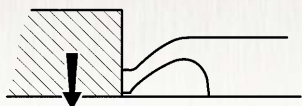
Fastening the horizontal clamp with screws is sufficient to hold and clamp the workpiece. The active part of the clamp consists of three elements - one rigid and two flexible parts

### A workpiece is clamped in 3 steps:



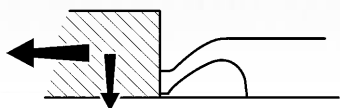
#### Contact:

The flexible clamp elements are positioned against the workpiece.



#### Hold:

The flexible clamp elements push the workpiece down until it comes into contact with the rigid clamping fingers.

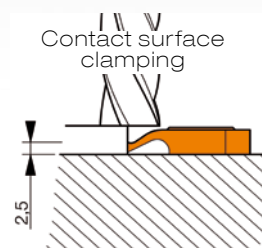
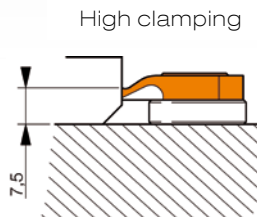
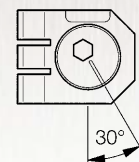
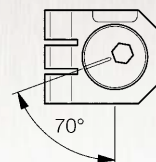


#### Clamping and positioning:

The rigid clamping finger clamps the workpiece.

Clamping force: 4,000 N  
Tightening torque: 9 Nm  
Cam stroke: 1.2 mm

Use of the cam:  
1/4-turn quick clamp



## No. 6493N

### Flat clamp for slotted table, horizontal

consisting of one clamping element and one stop.



Order no.	Slot	Clamping force [N]	Clamping height [mm]	Stroke	A	B	Weight [g]
70144	10	4000	7,5	1,2	46	18	140
70169	12	4000	7,5	1,2	48	18	150
70185	14	4000	7,5	1,2	52	22	162
70342	16	4000	7,5	1,2	48	25	178
70664	18	4000	7,5	1,2	48	25	190

### Recommendations



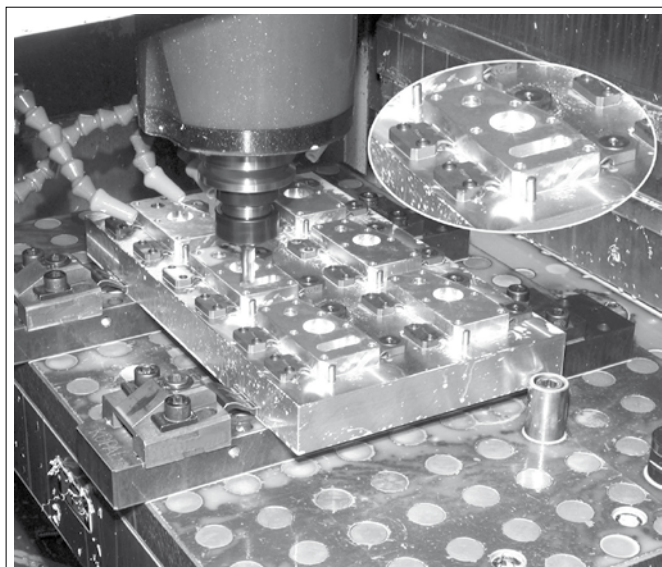
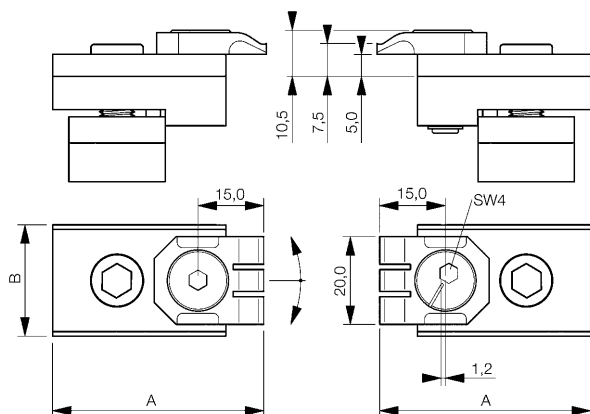
No. 6493SP,  
page 108



No. 6493S,  
page 108



No. 6493F,  
page 109



Subject to technical alterations.



## No. 6493SP

### Clamping element, horizontal



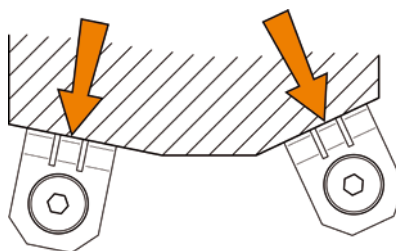
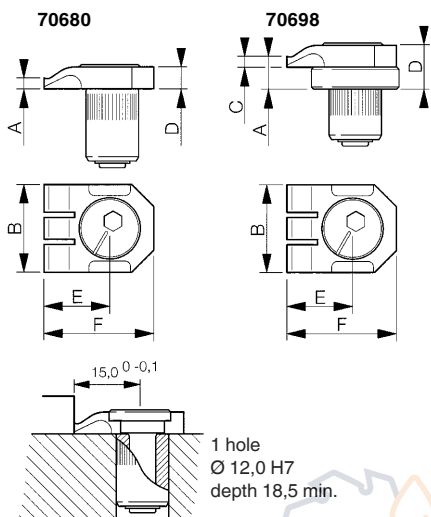
Order no.	Clamping force [N]	Clamping height A [mm]	B	C	D	E	F	Weight [g]
70680	4000	2,5	20	-	5	15*	25	29
70698	4000	7,5	20	2,5	10	15*	25	29

\* Cam stroke = 1.2 mm.

#### Application:

These hold-down clamps rotate around a camshaft that provides the clamping force. They can clamp in any direction.

Clamping element (1 rigid stop) enables the workpiece to lie flush with the stops.



## No. 6493S

### Stop, pivoting

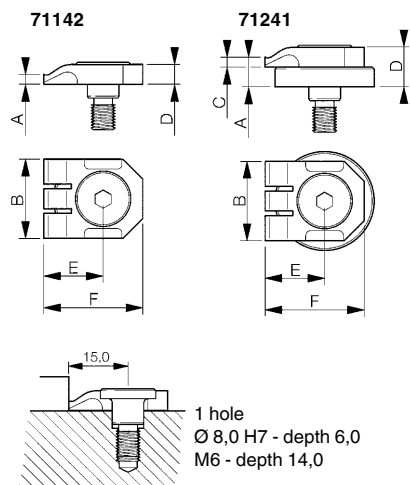
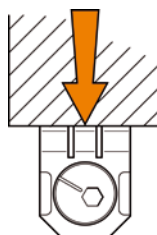
the rigid, ground, pivoting stops are secured by special screws that guarantee high accuracy during installation.



Order no.	Clamping height A [mm]	B	C	D	E	F	Weight [g]
71142	2,5	20	-	5	15	25	19
71241	7,5	20	2,5	10	15	25	19

#### Application:

The pivoting stop (1 rigid stop) requires two stops to position a workpiece along a straight line.



## No. 6493F

### Stop, fixed

the ground, fixed stops are secured by special screws that guarantee high accuracy during installation.

Size 1 - Simple stop

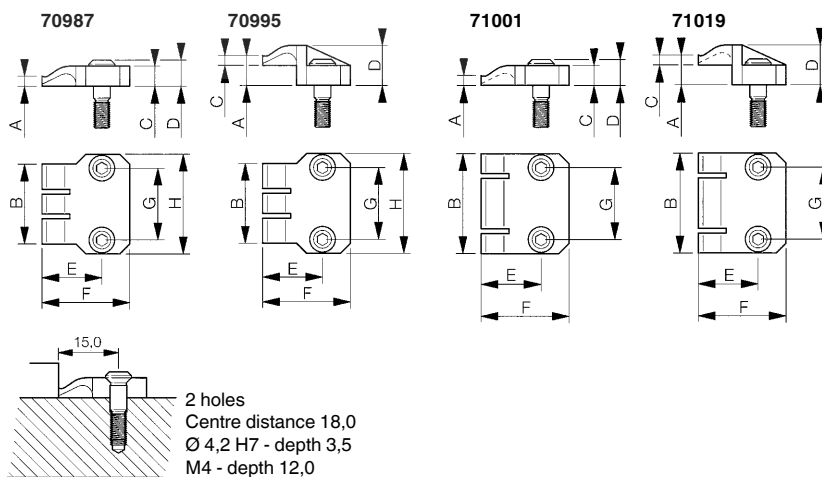
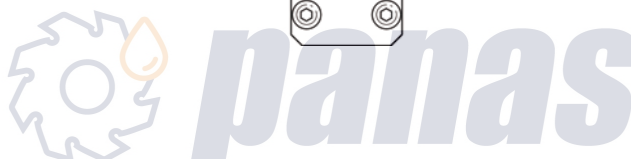
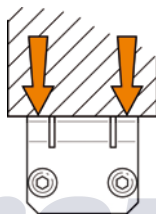
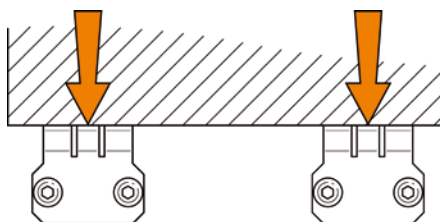
Size 2 - Double stop

Order no.	Size	Clamping height A [mm]	B	C	D	E	F	G	H	Weight [g]
70987	1	2,5	20	5,0	6,5	15	22	18	25	23
70995	1	7,5	20	2,5	10,0	15	22	18	25	23
71001	2	2,5	25	5,0	6,5	15	22	18	-	23
71019	2	7,5	25	2,5	10,0	15	22	18	-	23

### Application:

Size 1 - Single stop (1 rigid stop): Two stops are required to position a workpiece along a straight line.

Size 2 - Double stop (2 rigid stops): One stop is sufficient to position a workpiece along a straight line.



CAD





No. 6489

### Mechanical pull-down spring clamp, eccentric

Quenched and tempered steel, plasma-nitrated.



Order no.	Clamping force vertical [kN]	torque Md [Nm]	dia. K [mm]	Lateral compensation per clamp [mm]	Clamping rim height min. for Al-alloy [mm]	Weight [g]
375600	5	18	10,9-11,8	±0,25	9	2150
375667	5	18	11,9-12,8	±0,25	9	2150
375683	5	18	12,9-13,8	±0,25	9	2150
375709	5	18	13,9-14,8	±0,25	10	2250
375725	5	18	14,9-15,8	±0,25	10	2250
375741	5	18	15,9-16,8	±0,25	10	2250

**Application:**

- Used for workpieces with existing or retrofitted holes.
- Once the clamping segments are engaged in the holes, reliable 5-sided finishing is possible without a problem.
- A simple hexagon socket spanner (SW 10) is used to actuate the element.
- The existing clamping rim fastens the pull-down clamping element on the machine table.
- For positioning on a fixture, the underside has two positioning holes (pin ISO 8734 - 8 mm).

**Advantage:**

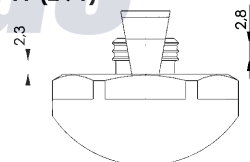
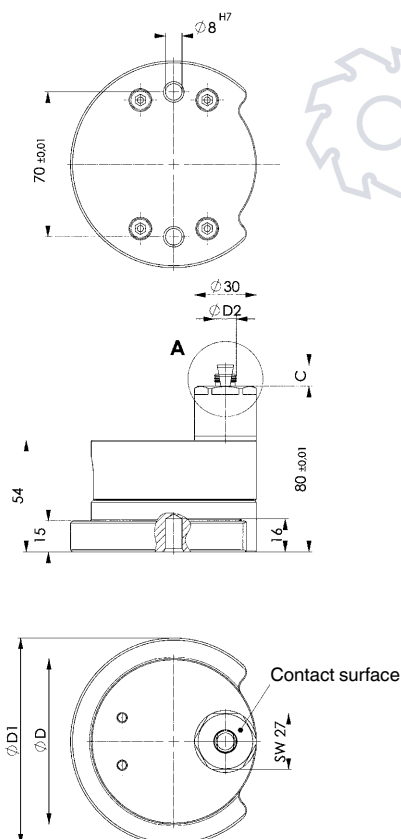
- All components are plasma-nitrided and are hence very resistant to wear and corrosion.
- Two-part clamping segments are interlocked externally.
- Flexible in use thanks to ease of handling and clamping on the machine table.

**Note:**

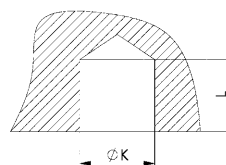
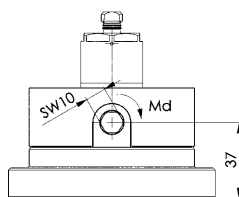
- Please check with us for clamping of hardened workpieces or workpieces made of GG / GGG.
- The radial force must be observed!
- The lateral force when positioning the workpiece must not exceed the „lateral force“ specified in the table.
- The clamping jaws for the machine vices can be used for clamping on the machine table (No. 6325; Order no.: 74682, 373878).

**On request:**

Other sizes and special versions without pull-down and as support elements.



### Clamping hole in workpiece



## Recommendations

DIN 6314,  
page 20

No. 6310,  
page 18

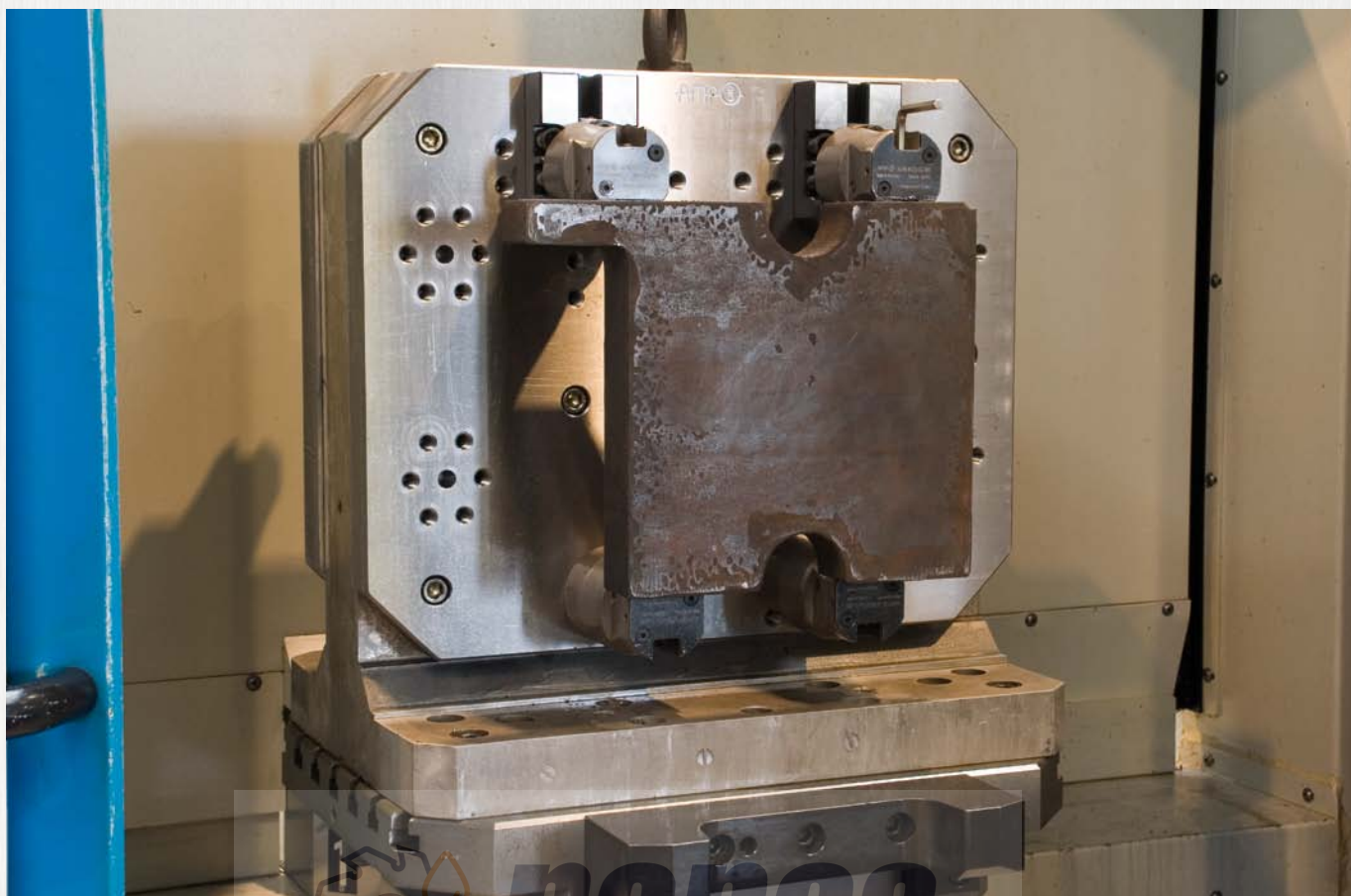


No. 6311,  
page 19

### Dimensions:

Order no.	Permissible horizontal force [kN]	Radial force of sleeve segments [kN]	Expansion of sleeve [mm]	Clamping piston diameter [mm]	Side load (unclamped) [N]	C	D	D1	D2
375600	2,8	27	1,5	22	100	10,5	80	100	10,6
375667	2,8	27	1,5	22	110	10,5	80	100	11,6
375683	3,0	27	1,5	22	130	10,5	80	100	12,6
375709	3,0	27	1,5	22	160	10,5	80	100	13,6
375725	3,5	27	1,5	22	200	10,5	80	100	14,6
375741	3,5	27	1,5	22	250	10,5	80	100	15,6

Subject to technical alterations.





**No. 6498**

## Edge Clamp

complete with mounting. Fastened with screws of strength class 10.9.



Order no.	Size	Slot	torque Md [Nm]	H ±0,1	F1 [kN]	F2 [kN]	Weight [g]
73890	M12x14	14	75	65	12	7	1530
375501	M16x18	18	80	75	20	10	2627
374355	M20x24	24	160	100	25	17	5996

### Application:

The mechanical side clamp with hold-down effect can be used as a clamping element and as a fixed stop. Moving the adjusting bolt causes hook ends to clamp the workpiece. At the same time, a pull-down effect occurs on the contact surface. Attaching a lateral stop enables the workpiece to be repeatedly clamped. When used in conjunction with base plate 6498FT, the side clamp can also be placed across the table groove. In conjunction with round base plate no. 6498FR, only along the table groove.

### Advantage:

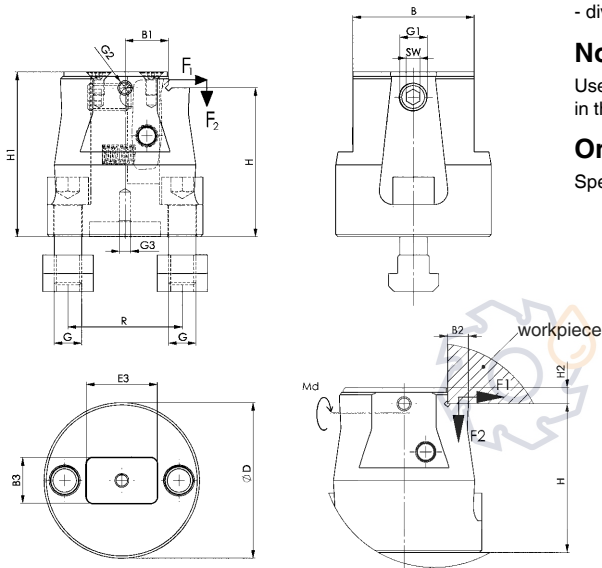
- compact dimensions
- workpiece fastened rigid and secure through pull-down effect
- plate tension increased to make holes and grooves
- lateral plate tension to completely finish surfaces without collision contour
- lateral thread enables a stop to be fastened
- can be used for horizontal and vertical applications
- reduced tooling time and tool elements cuts tooling costs
- diverse and variable applications.

### Note:

Use of a flat sliding block no. 6322A or no. 6322B enables the side clamp to be accurately positioned in the machine table groove.

### On request:

Special versions (dimension H ±0.01) are available.



*panas*



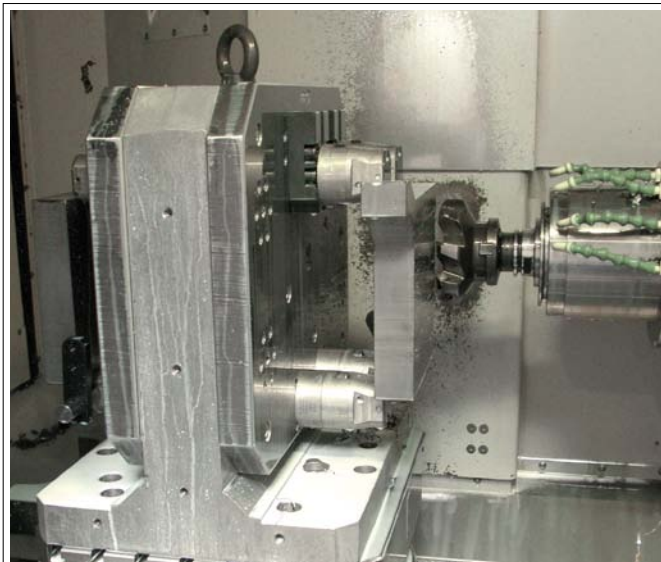
### Recommendations



No. 911LG-H100F

### Dimensions:

Order no.	Size	B	B1	B2	B3	D +2	E3	G	G1	G2	G3	H1	H2	R	SW
73890	M12x14	53	19,0	9,0	20	68	31,0	M12	M12	M6	M6	72	7	50	6
375501	M16x18	60	20,5	13,5	20	78	25,5	M16	M16	M6	M6	95	20	50	8
374355	M20x24	88	28,5	18,0	20	108	38,0	M20	M16	M6	M6	118	18	75	10



Subject to technical alterations.

## No. 6498FR

### Base plate, round

complete with fixing screws. Fastened with screws of strength class 10.9.

Order no.	Size	Slot	H ±0,1	B3	D +2	E3	E4	G	G3	R	Weight [g]
73916	M12x14	14	30	20	68	31,0	28,0	M12	M6	50	930
375527	M16x18	18	50	20	78	25,5	25,5	M16	M6	50	1780
374371	M20x24	24	60	20	108	40,0	31,0	M20	M6	75	4680

### Application:

Used in conjunction with side clamp no. 6498 to clamp across and along the table groove. The size M16x18 fits properly for use on the M16 grid plate.

### Advantage:

- Simple use of the side clamp when clamping along and across the groove
- Increase in the workpiece mounting surface.

### Note:

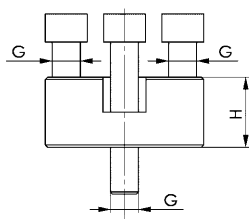
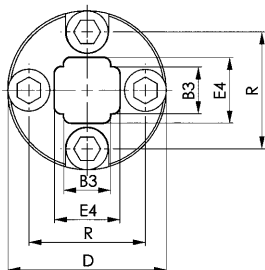
Use of two flat sliding blocks no. 6322B enables exact connection of the side clamp to the round base plate. The base plate can be exactly positioned on the machine with the flat sliding blocks no. 6322A or no. 6322B.

### On request:

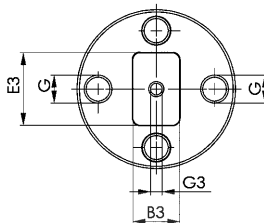
Special versions (dimension H ±0.01) are available.



View from above



View from below



### Recommendations



No. 911LG-H100F

## No. 6498FT

### Base plate

complete with mounting. Fastened with screws of strength class 10.9.

Order no.	Size	Slot	H ±0,1	B	E1	E2	G	L	R	Weight [g]
73908	M12x14	14	30	70	40	65	M12	110	50	1330
375543	M16x18	18	50	125	40	90	M16	130	100	4864
374397	M20x24	24	60	120	75	150	M20	200	85	7614

### Application:

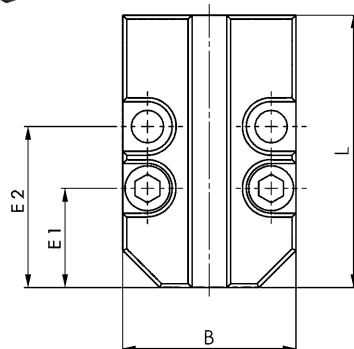
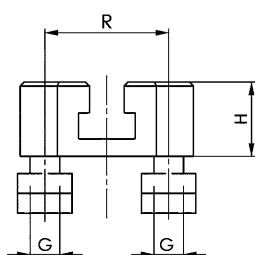
Used in conjunction with side clamp no. 6498 to also clamp across the table groove.

### Advantage:

- Simple use of the side clamp when clamping even across the groove
- Increase in the workpiece mounting surface.

### On request:

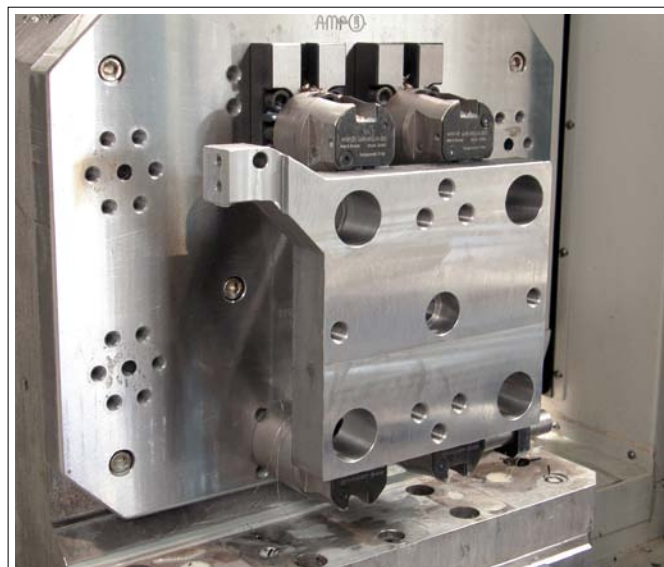
Special versions (dimension H ±0.01) are available.



### Recommendations



No. 911LG-H100F



Subject to technical alterations.



## No. 6495

### T-slot clamp

complete with mounting.  
Steel, tempered and burnished.



Order no.	Size	Slot	F1 [kN]	F2 [kN]	H2	SW [mm]	Weight [g]
374140	12	14	7	3,5	10	5	91
374132	16	18	10	5,0	12	6	188
374124	20	22	16	8,0	15	8	363

### Application:

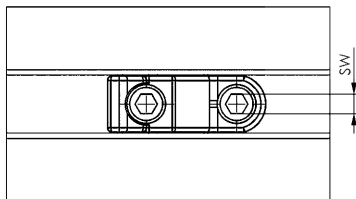
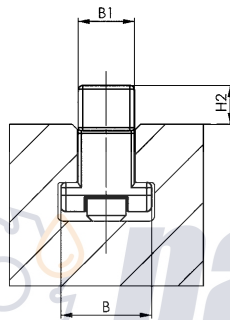
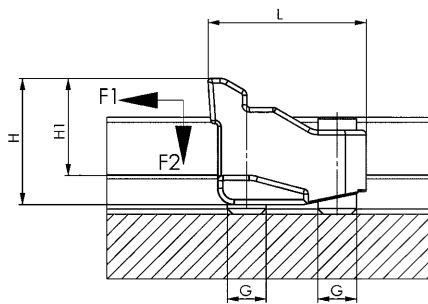
1. Slide T-slot clamp into T-slot of the machine table.
2. Position on workpiece.
3. Secure fastening bolt for machine table.
4. Actuating the clamping bolt clamps the workpiece.

### Advantage:

- For clamping of very thin workpieces
- Lateral clamping of workpieces to completely finish surfaces without interference contours
- Can be used for horizontal and vertical applications.

### Note:

To reduce wear to the fastening bolt, we recommend using AMF screw compound No. 6339. It possesses a synergistic combination of highly-effective solid lubricants and is heat-resistant and does not wash out.



### Recommendations



No. 911LG-H100F

### Dimensions:

Order no.	Size	B	B1	G	H	H1	L
374140	12	22	13,6	M10	31	24	40
374132	16	28	17,4	M12	39	30	49
374124	20	35	21,5	M16	50	37	63

Order no.	Size	G	L	SW [mm]	Weight [g]
79186	12	M10	25	5	14
78907	16	M12	30	6	24
77834	20	M16	40	8	59

## No. 6495S

### Fastening bolt for T-slot clamp

Strength class 10.9



## No. 6496

### Flat clamp

Complete with mounting.  
Steel, tempered and burnished.



Order no.	Size	Slot	G	F1 [kN]	F2 [kN]	H min.	H max.	Weight [g]
374157	M12x14	14	M12	15	7,5	16	25	579
374165	M12x16	16	M12	15	7,5	16	25	600
374173	M16x18	18	M16	20	10,0	19	30	1011
374181	M16x20	20	M16	20	10,0	19	30	1055
374199	M20x22	22	M20	30	15,0	22	36	1670
374207	M20x24	24	M20	30	15,0	22	36	1705
374215	M20x28	28	M20	30	15,0	22	36	1807

### Application:

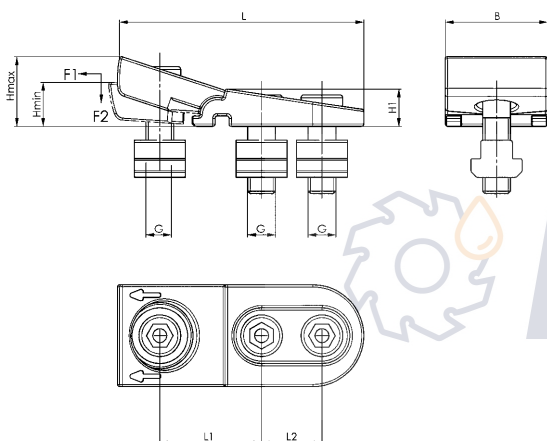
1. Slide flat clamp into T-groove of the machine table.
2. Position on workpiece.
3. Secure fastening bolts for machine table.
4. Actuating the clamping bolt clamps the workpiece.

### Advantage:

- For clamping of very thin workpieces
- Lateral clamping of workpieces to completely finish surfaces without interference contours
- Can be used for horizontal and vertical applications.

### Note:

To reduce wear to the fastening bolts, we recommend using AMF screw compound No. 6339. It possesses a synergistic combination of highly-effective solid lubricants and is heat-resistant and does not wash out.



### Dimensions:

Order no.	Size	B	H1	L	L1	L2
374157	M12x14	44	16	110	45-48	26
374165	M12x16	44	16	110	45-48	26
374173	M16x18	56	19	130	50-54	33
374181	M16x20	56	19	130	50-54	33
374199	M20x22	62	22	152	58-63	41
374207	M20x24	62	22	152	58-63	41
374215	M20x28	62	22	152	58-63	41



## No. 6496BF

### Mounting kit for flat clamp

comprising 3 DIN 6912 hexagonal bolts, 3 DIN 508 T-groove nuts and 1 DIN 6319C spherical washer.



Order no.	Size	Slot	G	L	SW [mm]	Weight [g]
313379	M12x14	14	M12	30	10	49
313395	M12x16	16	M12	35	10	56
313411	M16x18	18	M16	35	14	90
313437	M16x20	20	M16	40	14	104
313452	M20x22	22	M20	45	17	177
313478	M20x24	24	M20	45	17	189
313494	M20x28	28	M20	55	17	228

### Recommendations



No. 911LG-H100F

