

STANDARD CLAMPING ELEMENTS



POWER CLAMP



6 - 10

CLAMPS



11 - 38

SUPPORT BLOCKS



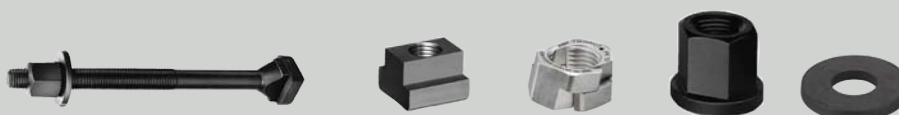
39 - 44

SETTING ELEMENTS MANDREL AND FLOATING CLAMP



45 - 66

CLAMPING BOLTS, NUTS AND WASHERS



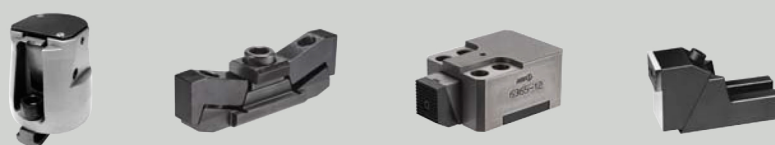
67 - 89

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

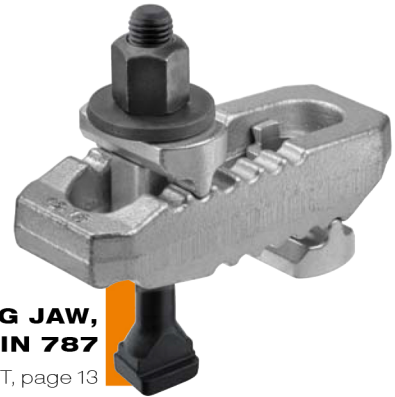
No. 6347SP, page 118



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!

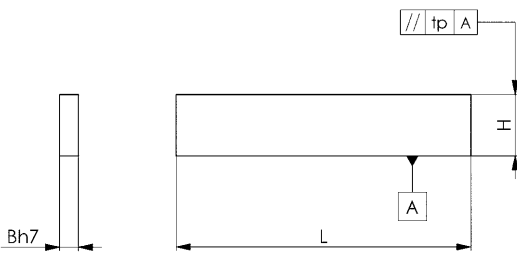


No. 6350

Parallel stops in pairs

For machine grooves.
Can also be used as parallel washers.
Plain parallel in height, fine-ground, in pairs.
Case-hardened.

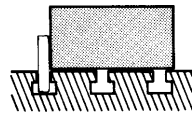
Pair tolerance t_p at height IT 5.
Rated dimensional tolerance in height ISO 2768m.
Rated dimensional tolerance in width h7.
Remaining dimensions to DIN ISO 2768m.



Order no.	B	H	L	Weight [g]
74260	8	25	100	315
74278	10	32	100	500
74286	12	40	100	750
74294	14	50	100	1100
74302	16	50	160	2000
74310	18	63	160	2850
74328	20	63	160	3170
74336	22	80	160	4400
74344	24	80	160	4800
74351	28	100	160	7000

Application:

The parallel stops are intended primarily for small to medium-sized machines. Their thickness is matched to the machine groove with a tolerance of H8. A pair of these stops is inserted into a machine groove, allowing the workpieces to be quickly positioned parallel to the table.



No. 6328

Cylindrical stop

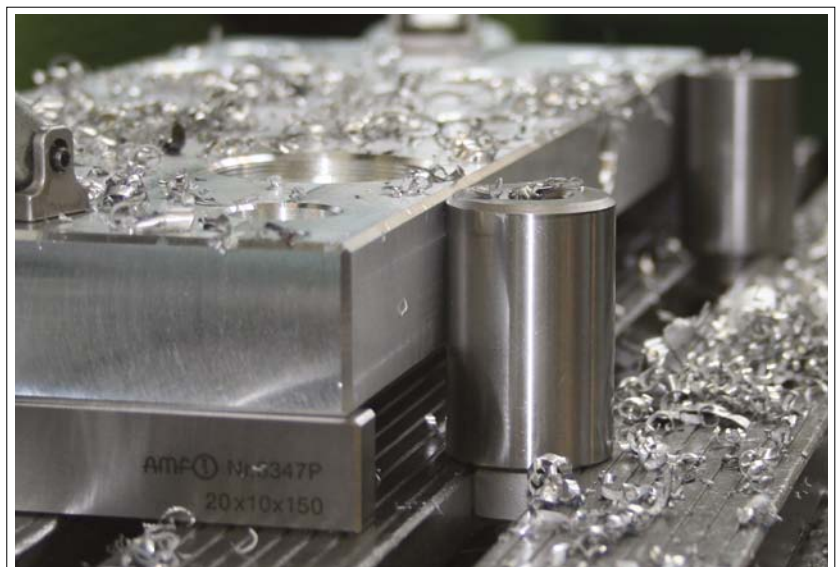
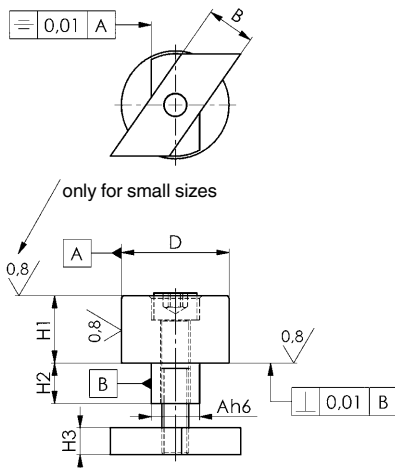
case hardened and ground. The short version, ground to ± 0.01 mm tolerance in height can be used as support.



Order no.	Slot	A h6	B -0.6	D ± 0.01	H1 ± 0.01 short	H1 ± 0.2 long	H2	H3	Screw ISO 4762	Weight [g]
75150	12	0-0,011	12	20	15	-	8	6	M6x25	55
75192	12	0-0,011	12	20	-	25	8	6	M6x35	80
75200	14	0-0,011	14	32	25	-	9	8	M8x35	200
75218	14	0-0,011	14	32	-	50	9	8	M8x60	355
75168	16	0-0,011	16	32	25	-	10	8	M8x45	220
75176	16	0-0,011	16	32	-	50	10	8	M8x70	375
75226	18	0-0,011	18	40	25	-	15	10	M10x50	360
75234	18	0-0,011	18	40	-	50	15	10	M10x75	600
75242	22	0-0,013	20	40	25	-	15	14	M10x55	410
75259	22	0-0,013	20	40	-	50	15	14	M10x80	650
75267	28	0-0,013	22	46	25	-	20	16	M12x60	630
75275	28	0-0,013	22	46	-	50	20	16	M12x90	950

On request:

Further sizes available.

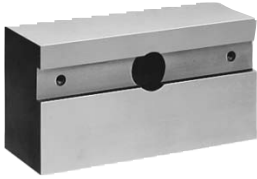


Subject to technical alterations.

No. 6351

Parallel stop, single

case hardened and ground. Parallelism within 0.02 mm, matched tolerance 0.02 mm. Nominal tolerance DIN 7168 medium.



Order no.	Slot	B	C	H	L	suitable bolt combination: DIN508, ISO4762, DIN6340, DIN787 compl.	Weight [Kg]
74369	10-24	60	40	30	125	M10x10-M20x24	1,6
74377	12-36	80	55	60	160	M12x12-M24x36	5,7
74385	12-36	100	75	100	160	M12x12-M24x36	12,1



No. 6351

Parallel stop, in pairs

case hardened and ground. Parallelism within 0.02 mm, matched tolerance 0.02 mm. Nominal tolerance DIN 7168 medium.



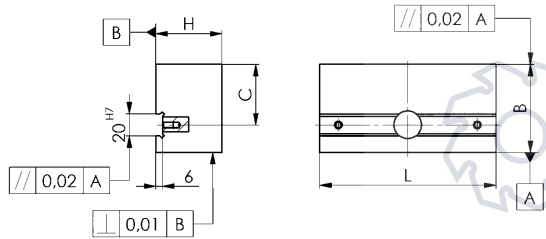
Order no.	Slot	B	C	H	L	suitable bolt combination: DIN508, ISO4762, DIN6340, DIN787 compl.	Weight [Kg]
75358	10-24	60	40	30	125	M10x10-M20x24	3,2
75366	12-36	80	55	60	160	M12x12-M24x36	11,4
75374	12-36	100	75	100	160	M12x12-M24x36	24,2

Application:

Parallel stops are the ideal setting elements for medium and large sized machines. Fixed type blocks. 6322 A and sliding blocks DIN 6323 fit the 20H7 slots of the parallel stop. Combinations with the various precision blocks allow use on tables with different slot sizes.

The following clamping options on the machine table are possible:

- 1) Bolts for T-slots DIN 787 complete (consisting of bolts for T-slots DIN 787, hexagonal nuts DIN 6330B and washers DIN6340) or
- 2) Allen bolts ISO 4762 with T-nuts DIN 508 and washers DIN 6340.



No. 6353

Precision angle stop

case hardened and ground.

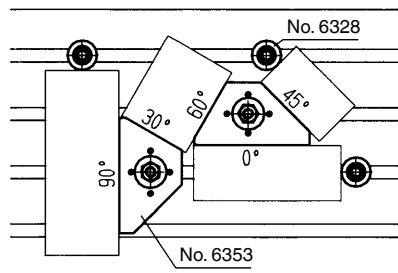
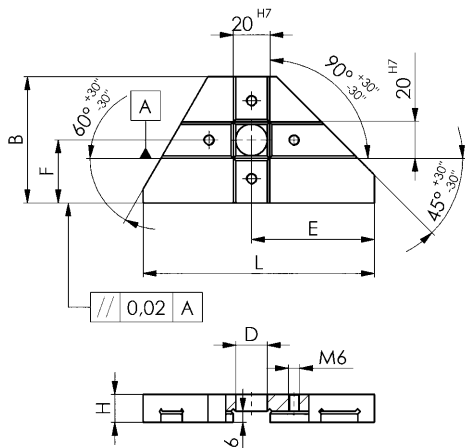
Setting: parallel and at angles of 30, 45, 60 and 90° related to T-slots. Guaranteed precision for all faces according to slots ±30°.



Order no.	Size	Slot	B	D	E	F	H	L	Weight [g]
74450	125	10-20	68	17	66,5	34	15	125	550
74468	200	12-36	98	25	100,0	49	20	200	1900

Application:

Fixed type tenons no. 6322A and loose type tenons DIN 6323 match with the mentioned table slots. The universal stops can alternatively be fastened complete with T-slots bolts DIN 787 or with T-nuts DIN 508 with screws ISO 4762 and washers DIN 6340. The high precision of the above mentioned universal stops guarantees the positioning accuracy required for almost any machining job. Machining can start straight away. There is no need to meter stop.



Subject to technical alterations.

No. 6355V
Prismatic clamping block, single

case hardened and ground

Order no.	Size	B	D	E ±0.01	F	G1	G2	H1 ±0.014	H2	L1	L2	L3	Weight [Kg]
75085	12-65	80	12-65	30,0	15	M 12	M 8	35	60	100	56	27	3,2
75093	20-110	125	20-110	52,5	25	M 16	M 10	55	100	100	53	32	8,1

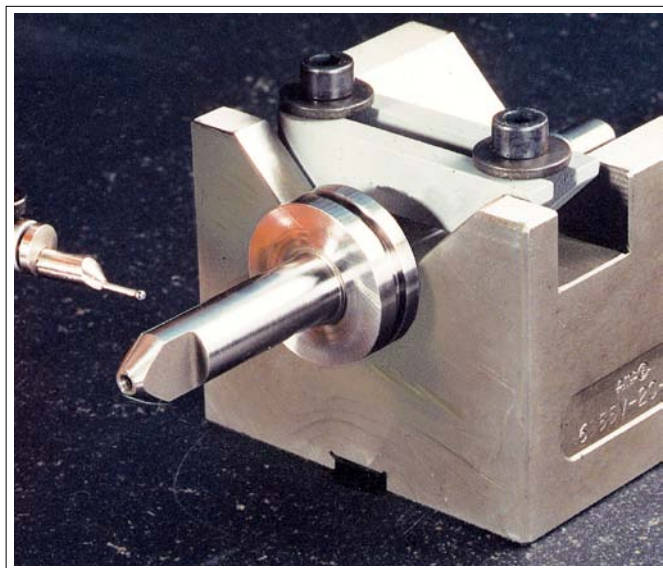
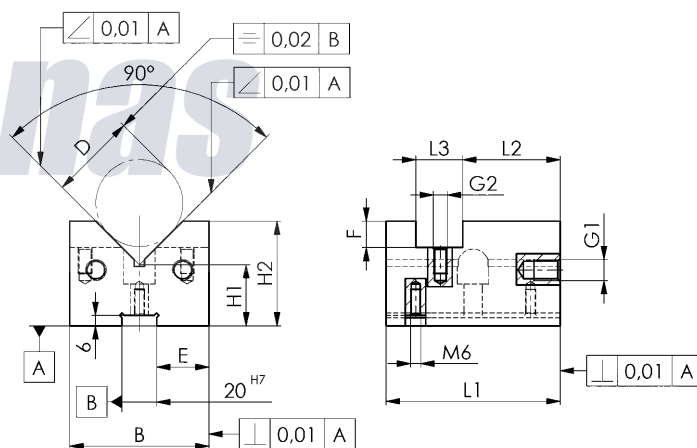

No. 6355V
Prismatic clamping block, pair

case hardened and ground

Order no.	Size	B	D	E ±0.01	F	G1	G2	H1 ±0.014	H2	L1	L2	L3	Weight [Kg]
75143	12-65	80	12-65	30,0	15	M 12	M 8	35	60	100	56	27	6,4
75184	20-110	125	20-110	52,5	25	M 16	M 10	55	100	100	53	32	16,2

Application:

For alignment and clamping of round shafts and workpieces parallel and centric to a table slot. Can be used as parallel stops and supports!



No. 6357

Stop, adjustable

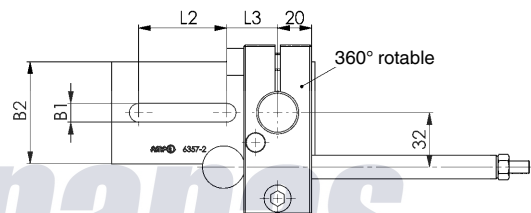
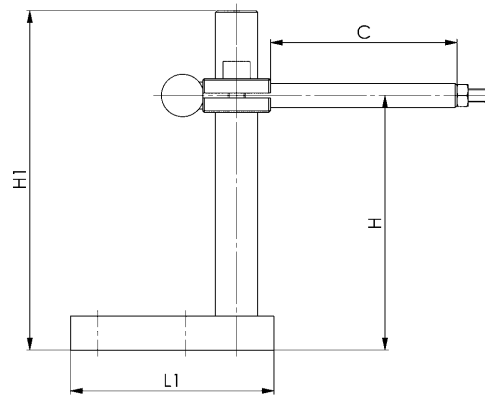
with hexagon key.
Tempering steel



Order no.	Size	Slot	B1	B2	C	H	H1	L1	L2	L3	Weight [g]
75655	2	10, 12, 14, 16, 18	11	60	0-110	30-190	200	120	52	30	2450
75663	3	16, 18, 20, 22, 24, 28	17	80	0-110	30-190	200	160	73	40	3250

Application:

The quickly adjustable stop is suitable for positioning workpieces on various tooling machines and vices. It has a wide range for height and length adjustments. Setting is done with the supplied T-handle hexagon key.



CAD



No. 6358

Side stop

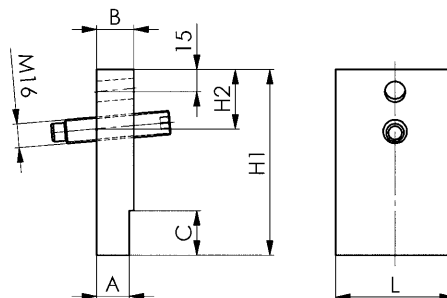
Tempering steel blued, with 2 threaded holes M16 for 2 positions. Set screw DIN 915 M16x80.



Order no.	Slot	B	C	H1	H2	L	Weight [g]
75879	18	20	20	100	40	50	805
75887	20	25	30	125	40	80	1880
75895	22	25	30	125	40	80	1920
75903	24	32	40	150	65	100	3515
75911	28	32	40	150	65	100	3645
75929	36	40	50	160	65	120	4870

Application:

The stop is used for safe positioning of long and heavy workpieces on slotted machine tables. It is inserted into the slot - at an inclined position due to its undersize and locks the workpiece against the parallel stop, e.g. no. 6351.



CAD



Subject to technical alterations.

DIN 6323

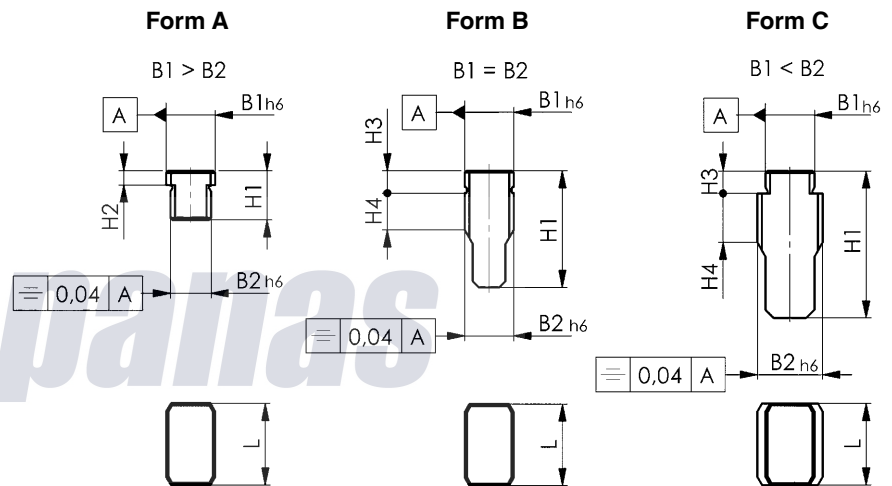
Loose type tenons

Steel C15, case hardened and ground.

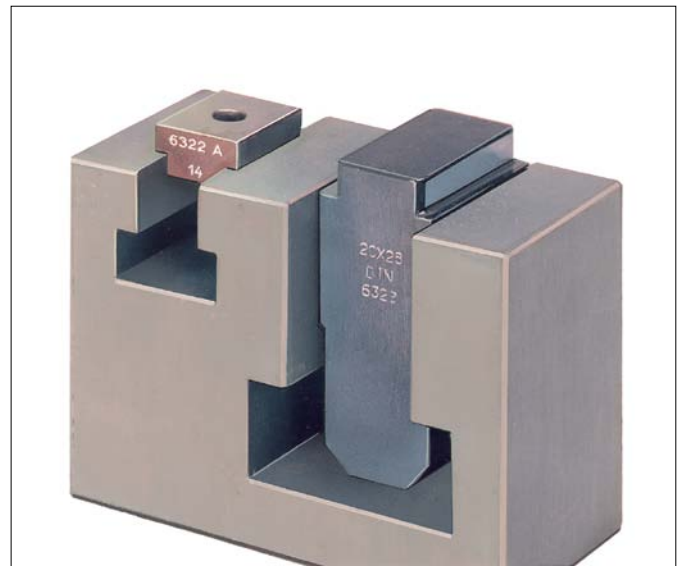
Order no.	Nominal width of T-slot on fixture B1	Nominal width of T-slot on machine B2	Form	H1	H2	H3	H4	L	Weight [g]
71811	12	10	A	12,0	3,6	-	-	20	20
71829	12	12	B	28,6	-	5,5	9	20	45
71837	20	12	A	14,0	5,5	-	-	32	50
71845	20	14	A	14,0	5,5	-	-	32	55
71852	20	16	A	14,0	5,5	-	-	32	60
71860	20	18	A	14,0	5,5	-	-	32	65
71878	20	20	B	45,5	-	7	16	32	200
71886	20	22	C	50,5	-	7	18	40	290
71894	20	24	C	55,5	-	7	20	40	350
71902	20	28	C	61,5	-	7	24	40	460
71910	20	36	C	76,5	-	7	30	50	940

Application:

After rough alignment of fixture, the tenons DIN 6323 are pushed into T-slot from the side. No fixed T-nuts can obstruct the transport of fixtures and no damage to machine tables can occur.



CAD



Subject to technical alterations.

No. 6322A

Fixed type tenons

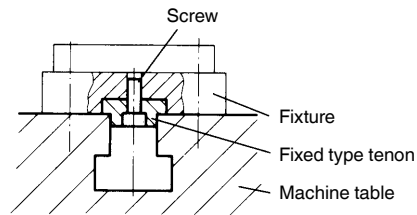
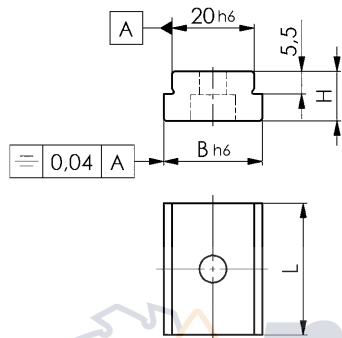
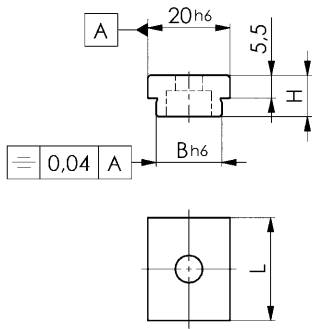
(previously DIN 6322 developed 1957)
C15 case-hardened.



Order no.	Nominal width of T-slot on machine B	Nominal width of T-slot on fixture	H	L	Screw DIN84 or ISO4762	Weight [g]
71555	10	20	10	22	M6x10	20
71563	12	20	10	22	M6x10	25
71571	14	20	10	25	M6x16	28
71589	16	20	10	25	M6x16	30
71597	18	20	10	25	M6x16	30
71613	22	20	12	32	M6x16	50
71621	24	20	12	32	M6x16	55
71639	28	20	12	32	M6x16	60
71647	36	20	12	32	M6x16	75

Application:

These fixed type tenons are screwed in pairs into the standard 20 mm wide set slots of vices or fixtures. By changing the tenons you can work on machines with different slot sizes. For very heavy fixtures we recommend the use of loose type tenons DIN 6323.



No. 6322B

Low type tenons

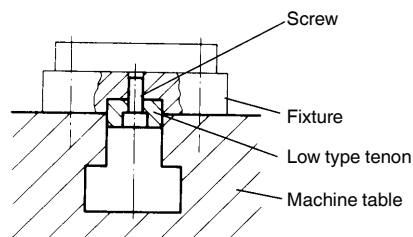
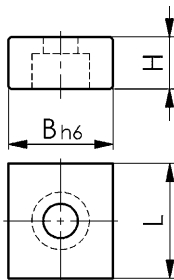
Steel C15, case hardened and ground.



Order no.	B	H	L	Screw DIN84 or ISO4762	Weight [g]
71696	10	8	20	M4x10	15
71704	12	8	20	M5x12	19
71712	14	10	22	M6x16	21
71720	16	10	22	M6x16	26
71738	18	10	22	M6x16	30
71746	20	10	22	M6x16	34
71753	22	12	32	M6x16	55
71761	24	12	32	M6x16	62

Application:

Low-type tenons are useful and inexpensive to use, when a fixture is always used on the same machine. For very heavy fixtures we recommend the use of loose type tenons DIN 6323.



Subject to technical alterations.