

STANDARD CLAMPING ELEMENTS



POWER CLAMP



6 - 10

CLAMPS



11 - 38

SUPPORT BLOCKS



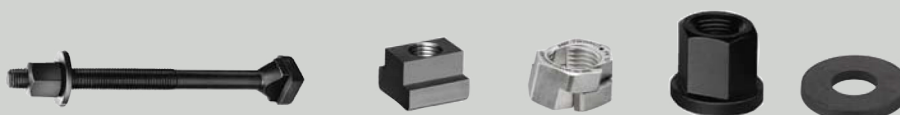
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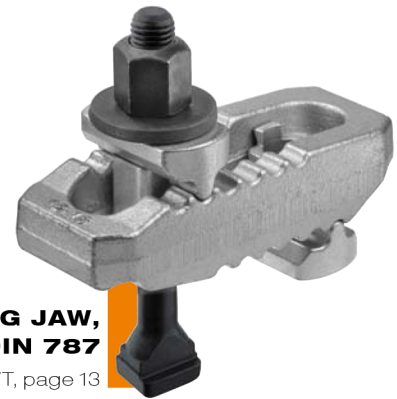
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Optimised wooden case
for perfect handling!

„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!

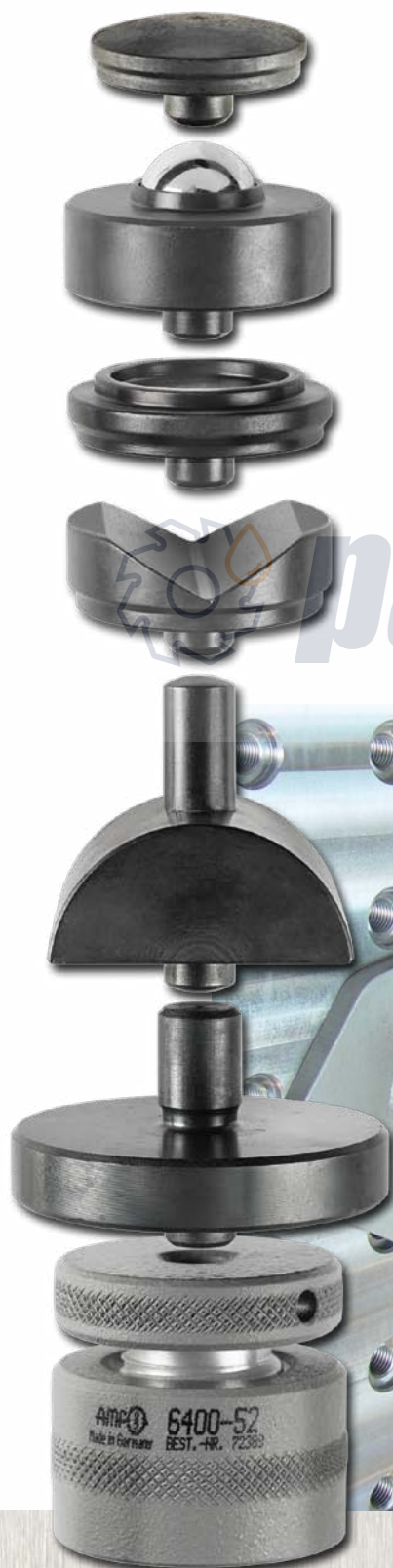


THE MOST IMPORTANT FACTS ABOUT SETTING ELEMENTS

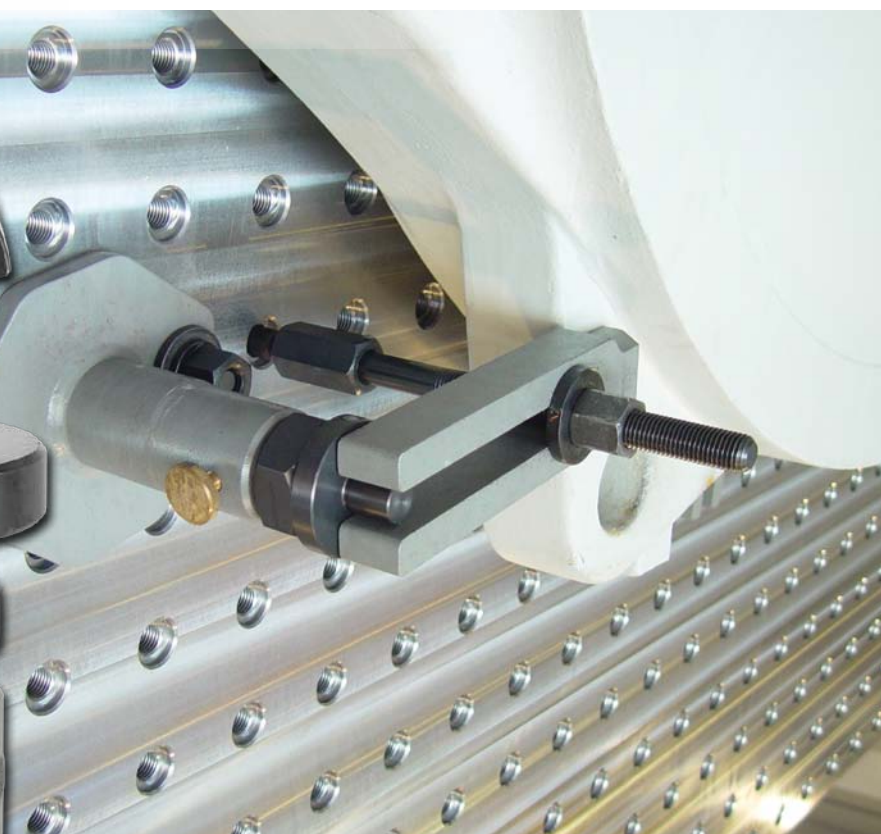
Developed by AMF and proven in service for decades, these screw and aligning jacks offer a broad range of applications. Due to their robust construction, these screw jacks function securely and precisely, with stepless adjustment even under heavy loads.

APPLICATIONS AND COMBINATIONS:

- > Safe and reliable clamp supports for heights from 38 to 1250 mm.
- > Accurate and safe supporting and setting of any workpiece in various levels and heights.
- > Aluminium screw jacks for delicate machine tables, surface plates and plane tables.
- > Magnetic screw jacks for horizontal and vertical supporting and setting.



panas



No. 6415

Height setting screw jack

with 2 locating pins DIN 6325 (12x50 and 12x80). Centring hole dia. 12 mm. Tempering steel, blued. Spindle: M30x1.5 metric fine thread with end stopbody. Bearing insert turns on pressed-in plain bearing bush.



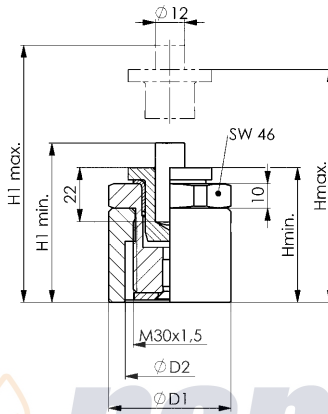
Order no.	Size	H min.	H max.	D1	D2	with location pin 12x50 H1min.-H1max.	with location pin 12x80 H1min.-H1max.	F max. [kN]	Weight [g]
86504	75	55	75	50	36	83-103	113-133	30	680
86512	115	75	115	50	36	103-143	133-173	30	880

Application:

The height setting screw jack can be used without locating pins or with pads no. 6440 and no. 6441. With centering pad no. 6242 combinations with all AMF-screw jacks are possible. They allow sensitive adjusting up to height of 1370 mm. A bearing insert prevents the workpiece from being turned while the jack is adjusted.

Note:

Suitable pads are no. 6440, 6441, 6442. Suitable base is no. 6442.



Recommendations



No. 6440,
page 56

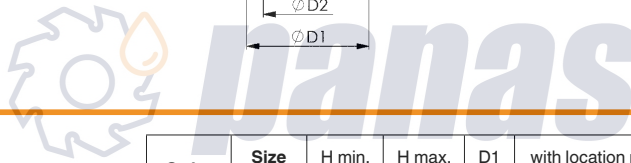


No. 6441,
page 56



No. 6442,
page 56

CAD



No. 6416

Height setting screw jack with magnetic base

with 2 locating pins DIN 6325 (12x50 and 12x80). Centring hole dia. 12 mm. Tempering steel, blued. Spindle: M30x1.5 metric fine thread with end stopbody. Bearing insert turns on pressed-in plain bearing bush.



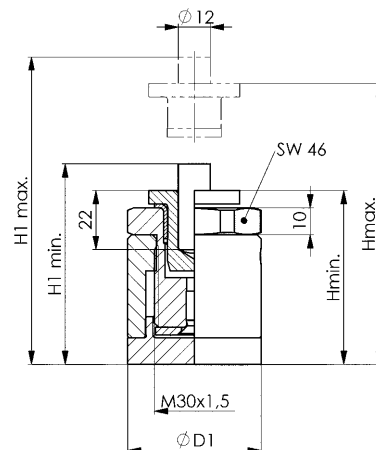
Order no.	Size	H min.	H max.	D1	with location pin 12x50 H1min.-H1max.	with location pin 12x80 H1min.-H1max.	F max. [kN]	Weight [g]
86520	85	65	85	50	93-113	123-143	30	800
86538	125	85	125	50	113-153	143-183	30	1000

Application:

The height setting screw jack can be used without locating pins or with pads no. 6440 and no. 6441. With centering pad no. 6242 combinations with all AMF-screw jacks are possible. They allow sensitive adjusting up to height of 1370 mm. A bearing insert prevents the workpiece from being turned while the jack is adjusted.

Note:

Suitable pads are no. 6440, 6441, 6442.



Recommendations



No. 6315GN,
page 22



No. 6315GNG,
page 22

CAD



Subject to technical alterations.

No. 6420

Height setting screw jack with pivotable ball

Steel tempered, burnished. Ball made of hardened steel.



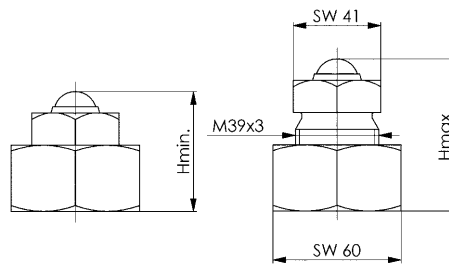
Order no.	Size	H min.	H max.	F max. [kN]	Weight [g]
72546	70	56	70	30	950

Application:

This element with its punctual support is particularly useful in the support and alignment of free-form surfaces e.g. of workpieces which are made of cast iron and forging-grade steels. The precision of alignment is approx. 0.1 mm.

Advantage:

- The pivotable ball minimizes the friction on the support and reduces the required operating forces.
- The use of a point-like support prevents the transmission of the torsional force created by the movement of the spindle. The position of the workpiece remains unchanged.
- The simple and rugged construction provides for a long lasting service life.



Recommendations



No. 6415,
page 46

No. 6400

Screw jack with flat support

Centring hole dia. 12 mm. Spindle: Trapezoidal thread, self-locking with end stopbody. Tempering steel, varnished.



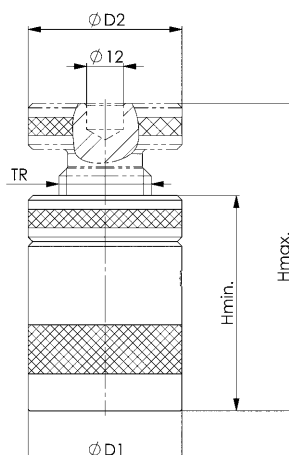
Order no.	Size	H min.	H max.	TR	D1	D2	F max. [kN]	Weight [g]
72397	50	38	50	20x 4	31	31	25	190
72389	52	42	52	30x 4	50	50	100	550
72405	70	50	70	30x 4	50	50	100	620
72413	100	70	100	30x 4	50	50	100	900
72421	140	100	140	40x 7	68	68	120	2760
72439	210	140	210	50x 8	80	70	170	4600
72447	300	190	300	65x10	100	80	350	9000
72496	200	140	200	65x10	100	80	350	6900
72504	280	190	280	80x10	140	110	600	19000

Advantage:

Higher support forces through material optimisation with sizes 50 - 140.

Note:

Size 50 without centring hole \varnothing 12 mm. The sizes 52-100 are suitable for clamps with a slot width of approx. 14-22 mm. The screw jack no. 6430 represents a useful addition for large clamping heights. The sizes 140-300 are suitable for clamps with a slot width of approx. 20-40 mm. For these, the screw jacks no. 6435S represent a useful addition for large clamping heights. When using clamps DIN 6315B, 6315C and 6315GN from 26 mm slot width, we recommend, by way of precaution, fixing cap no. 6443. The sizes 200-280 are intended for supporting large workpieces. Suitable attachments for screw jack sizes 52-280 are nos. 6440, 6441, 6442, 6443 and 6445. The suitable support for sizes 52-100 is no. 6442.



Recommendations



No. 6440,
page 56



No. 6441,
page 56

No. 6400M

Screw jack with flat support and magnetic base

Centring hole dia. 12 mm. Spindle: Self-locking trapezoidal thread with final stop. Painted tempered steel.



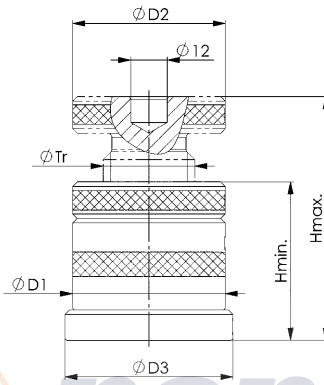
Order no.	Size	H min.	H max.	TR	D1	D2	D3	F max. [kN]	Weight [g]
73320	62	52	62	30x4	50	50	55	100	700
73361	80	60	80	30x4	50	50	55	100	770
73403	110	80	110	30x4	50	50	55	100	1050

Advantage:

Higher support forces through material optimisation with sizes 62 - 110.

Note:

AMF-magnetic screw jacks are designed for horizontal and vertical applications. The permanent magnet ensures a lasting and precise positioning of workpiece on vertical faces. The screw jacks are suitable for clamps with a slot width of approx. 14-22 mm. When using clamps DIN 6415B, 6315C and 6315GN from 26 mm slot width, we recommend, by way of precaution, fixing cap number no. 6443. Suitable caps for screw jack no. 6400M are nos. 6440, 6441, 6443 and 6445. The suitable support for the dismantled magnetic base is no. 6442.



Recommendations



No. 6440, page 56



No. 6443, page 57

CAD



No. 6400G

Screw jack with flat support and thread

Thread for fastening.

Centring hole M12. Spindle: Trapezoidal thread, self-locking with end stopbody. Tempering steel, varnished.



Order no.	Size	H min.	H max.	TR	D1	D2	F max. [kN]	Weight [g]
376194	52	42	52	30x4	50	50	100	550
376210	70	50	70	30x4	50	50	100	620
376236	100	70	100	30x4	50	50	100	948

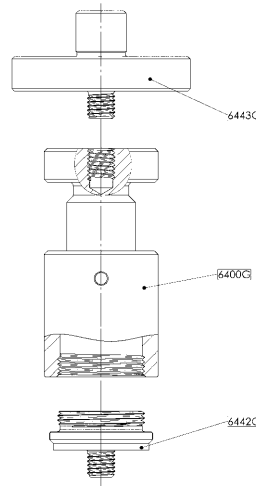
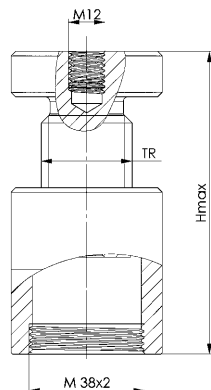
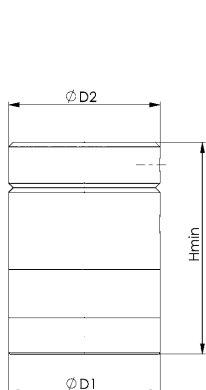
Application:

Especially suited for use on vertical turning and boring machines to achieve optimal clamping heights and absorb centrifugal forces.

Advantage:

Screw jack can be screwed onto the heavy-duty screw jack no. 6435SG to guarantee optimum security against the occurrence of centrifugal forces. Fixing cap no. 6443G or a screw for retaining a clamp can be incorporated into the screw jack top.

Higher support forces through material optimisation with sizes 52 - 100.



Recommendations



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No. 6435SG, page 55

CAD



Subject to technical alterations.

No. 6401

Aluminium screw jack

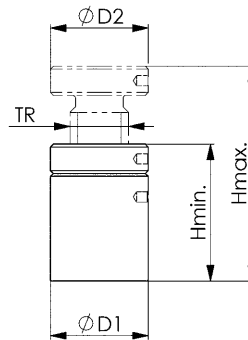
Centring hole dia. 12 mm. Spindle: Tempering steel, blued, Trapezoidal thread, self-locking with end stopbody. Base: Aluminium 400 N/mm² tensile strength.



Order no.	Size	H min.	H max.	TR	D1	D2	F max. [kN]	Weight [g]
75770	52	42	52	30x4	50	50	30	370
75788	70	50	70	30x4	50	50	30	430
75796	100	70	100	30x4	50	50	30	600

Note:

Safeguards machine tables against damage (swarf do not penetrate into table face but into alu-base). Useful for all machine tool tables, surface plates and plane tables with precision faces. For larger clamping heights use centering pad no. 6442 and screw jacks no. 6400. Suitable pads are no. 6440, 6441, 6442, 6443/14 and 6445. Suitable base is no. 6442. Do not adjust screw jack under load!



Recommendations



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No. 6440, page 56



No. 6405

Aluminium screw jack with magnetic base

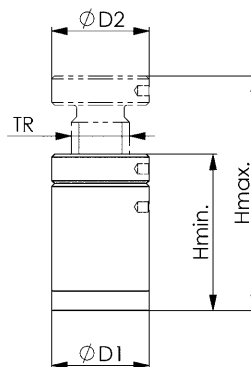
Centring hole dia. 12 mm. Spindle: Tempering steel, blued. Trapezoidal thread, self-locking with end stopbody. Base: Aluminium 400 N/mm² tensile strength.



Order no.	Size	H min.	H max.	TR	D1	D2	F max. [kN]	Weight [g]
75804	62	52	62	30x4	50	50	30	380
75812	80	60	80	30x4	50	50	30	550
75820	110	80	110	30x4	50	50	30	710

Note:

AMF-magnetic screw jacks are designed for horizontal and vertical applications. The permanent magnet ensures a lasting and precise positioning of workpiece on vertical faces. For larger clamping heights use centering pad no. 6442 and screw jacks no. 6400. Suitable pads are no. 6440, 6441, 6442, 6443/14 and 6445. Do not adjust screw jack under load!



No. 6406

Aluminium screw jack with swarf protection

Scraper ring protects screw jack spindle against chips. Centring hole dia. 12 mm. Spindle tempering steel, blued. Trapezoidal thread, self-locking with end stopbody.

Composed of:

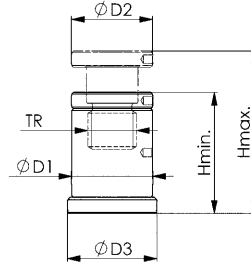
- screw jack
- Alu-base (size 10) or magnetic base (size 20).

Order no.	Size	H min.	H max.	TR	D1	D2	D3	F max. [kN]	Weight [g]
72850	10	75	88	30x4	50	50	50	30*	630
72868	20	75	88	30x4	50	50	55	30*	720

* ensured to max. 350 mm total height, danger of buckling for larger figures!

Note:

Suitable pads are no. 6440, 6441 and 6445.
Do not adjust screw jack under load!



Recommendations



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No. 6441, page 56

CAD



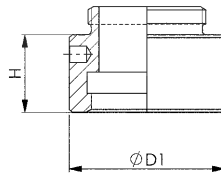
No. 6406A

Alu-intermediate ring

for additional height increase.



Order no.	Size	H	D1	Weight [g]
72876	12	12,5	50	38
72884	25	25,0	50	76
72926	50	50,0	50	165



CAD



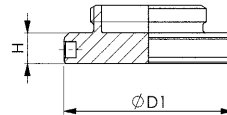
No. 6406M

Magnetic base

for screw jacks.



Order no.	H	D1	Weight [g]
72157	10	55	210



CAD



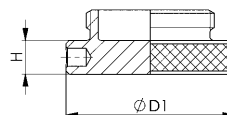
No. 6406AF

Aluminium base

For screw jacks



Order no.	H	D1	Weight [g]
557186	10	50	60



NEW!

No. 6406-125

Aluminium screw jack with swarf protection

Scraper ring protects screw jack spindle against chips. Centring hole dia. 12 mm. Spindle tempering steel, blued. Trapezoidal thread, self-locking with end stopbody.

Composed of:

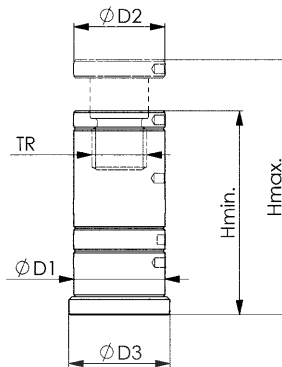
- screw jack
- intermediate ring 12.5 mm
- intermediate ring 25 mm and
- Alu- and magnetic base.

Order no.	Size	H min.	H max.	TR	D1	D2	D3	F max. [kN]	Weight [g]
72371	125	75	125	30x4	50	50	55	30*	920

* ensured to max. 350 mm total height, danger of buckling for larger figures!

Note:

Suitable pads are no. 6440, 6441 and 6445.
Do not adjust screw jack under load!



Recommendations



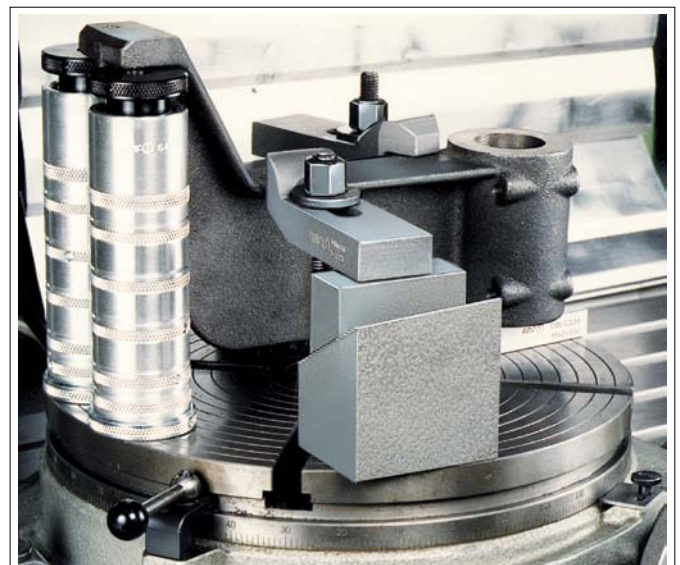
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Subject to technical alterations.



No. 6460

Wedge block „Herkules“ height wedge

Centering hole dia. 12 mm. Spherical graphite cast iron and steel tempered and burnished. Wedge faces precision machined. Complete with one ball-pad no. 6440.

Order no.	Size	H min.	H max.	B1	B2	L	SW	H/U* [mm]	F max. [kN]	Weight [g]
72777	63	50	63	40	40	63	13	0,86	40	1300
72785	125	100	125	115	60	125	24	1,16	100	8600
72793	190	170	190	145	80	175	36	2,02	250	23750

*H/U= height adjustment per single turn.

Application:

The fine-machined wedge surfaces permits a smooth, precise adjustment to less than 1/10 mm. The double wedge effect produces a large stroke and precise vertical movement with no lateral shift. The height wedge proves its worth with heavy castings or forgings on large tool machines. The AMF „Herkules“ whipstock has an additional centring hole in the floor of the base area. This enables the whipstock to be mounted on „heavy screw jacks“. A DIN 6325 12x30 cylinder pin is required for this purpose.

Note:

Suitable pads are no. 6440, 6441 and 6442.



Recommendations



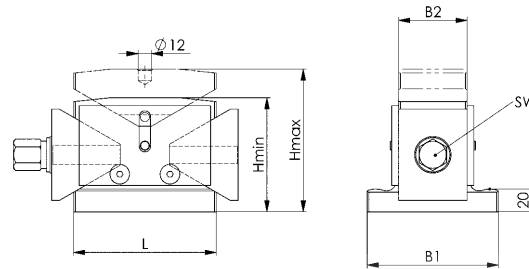
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No. 6444,
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No. 6465

Precision wedge block

Centring hole Ø 12 mm. Case-hardened steel and fine-machined wedge surfaces. A spherical attachment no. 6440 is included with every precision whipstock.

Order no.	Size	H min.	H max.	H/U* [mm]	F max. [kN]	SW [mm]	Weight [Kg]
375592	55	50	55	0,71	40	22	2,8
375618	85	77	85	0,71	250	36	11,5

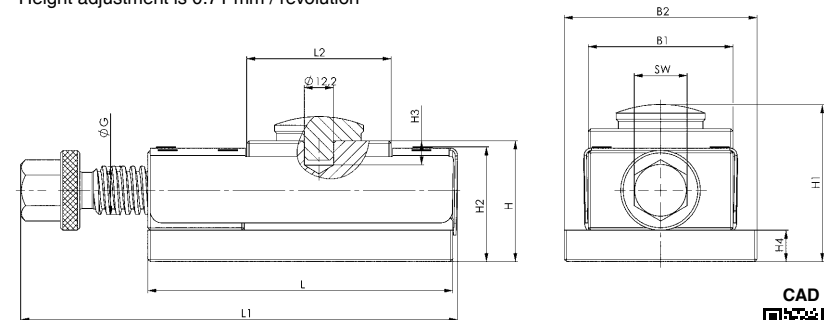
*H/U= height adjustment per single turn.

Application:

- The fine-machined wedge surfaces permits a smooth, precise adjustment to less than 1/10 mm.
- Operation can be via an open-ended spanner - hence ensuring enhanced safety and ease of handling due to the large adjusting forces.
- The double wedge effect produces a precise vertical movement with no lateral slide.
- The flat design of the precision height wedge enables higher safety properties to be realised when aligning heavy and large components.
- The precision whipstock has an additional centring hole in the floor of the base surface. (suitable for a pin ISO 8734 - 12 mm diameter)

Note:

- Suitable caps for the precision whipstock are nos. 6440, 6441 and 6442
- Precision whipstock can be adjusted under load
- Height adjustment is 0.71 mm / revolution



Recommendations



No. 6440,
page 56



No. 6445,
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No. 6443,
page 57

Dimensions:

Order no.	B1	B2	G	H1	H2	H3	H4	L	L1	L2
375592	60	80	20	60-65	47,5	10	13	128	150-179	60
375618	100	140	30	87-95	74,0	20	15	210	242-287	81

Subject to technical alterations.

No. 6430S

Atlas screw jack with counter nut

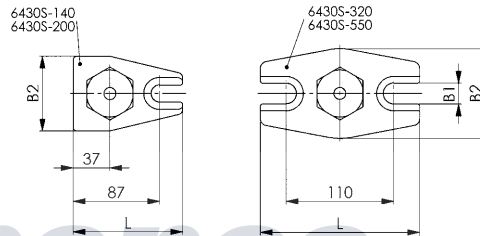
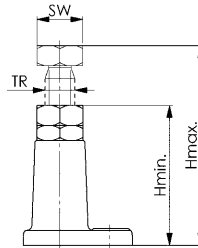
Centring hole dia. 12 mm. Spindle complete: tempering steel with trapezoidal thread. Spindle head blued. Housing: cast iron, varnished.



Order no.	Size	H min.	H max.	TR	B1	B2	L	SW	F max. [kN]	Weight [Kg]
72553	140	100	140	30x6	18	75	110	46	60	1,8
72561	200	140	200	30x6	18	75	110	46	60	2,2
72579	320	200	320	30x6	22	90	160	46	40	3,8
72587	550	320	550	30x6	22	90	160	46	25	4,9

Note:

When using clamps DIN 6315B, 6315C and no. 6315GN with slot-sizes above 26 mm we recommend the use of locating pad no. 6443 for safety. Suitable pads are no. 6440, 6441, 6442, 6443 and 6445. Do not adjust screw jack under load!



Recommendations



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No. 6443, page 57



No. 6445, page 57



No. 6435S

Heavy screw jack

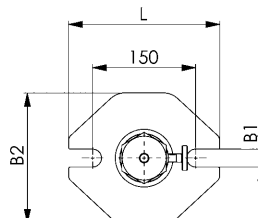
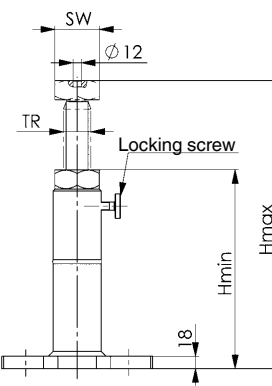
with brass locking screw. Centring hole dia. 12 mm. Spindle complete: tempering steel with trapezoidal thread. Spindle head blued. Housing: tempering steel, varnished.



Order no.	Size	H min.	H max.	TR	B1	B2	L	SW	F max. [kN]	Weight [Kg]
72637	300	200	300	40x7	26	190	220	65	80	8,0
72645	460	290	470	40x7	26	190	220	65	60	12,0
72652	750	430	750	40x7	26	190	220	65	50	12,6
72660	1250	710	1250	40x7	26	190	220	65	40	16,5

Note:

When using clamps DIN 6315B, 6315C and no. 6315GN with slot-sizes above 26 mm we recommend the use of locating pad no. 6443 for safety. Suitable pads are no. 6440, 6441, 6442, 6443 and 6445. Do not adjust screw jack under load!



Recommendations



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No. 6441, page 56



No. 6445, page 57



No. 6438S

Screw jack, quick-action

stepless adjustment with brass locking screw. Centring hole dia. 12 mm. Spindle complete: tempering steel, with trapezoidal thread. Spindle head blued. Housing: tempering steel, varnished.

Order no.	Size	H min.	H max.	TR	B1	B2	D	L	SW	F max. [kN]	Weight [Kg]
75705	450	320	450	40x7	26	190	90	220	65	50	11,5
75713	710	450	710	40x7	26	190	90	220	65	40	13,7
75721	1250	710	1250	40x7	26	190	90	220	65	30	18,3

Application:

This screw jack allows for very fast pre-setting following with stepless adjusting for the whole height range. Suitable pads are no. 6440, 6441, 6442, 6443 and 6445.

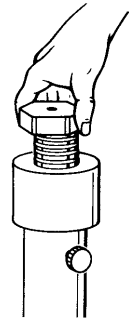
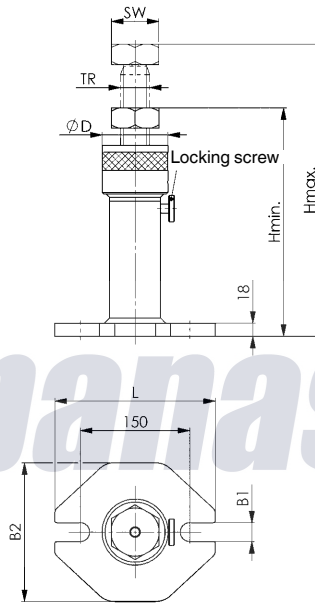
Note:

Important note for height adjustment:

- Hold spindle, max. 6 kg
 - release locking screw
 - turn spindle
 - adjust to required height
- Do not adjust screw jack under load!



panas



Recommendations



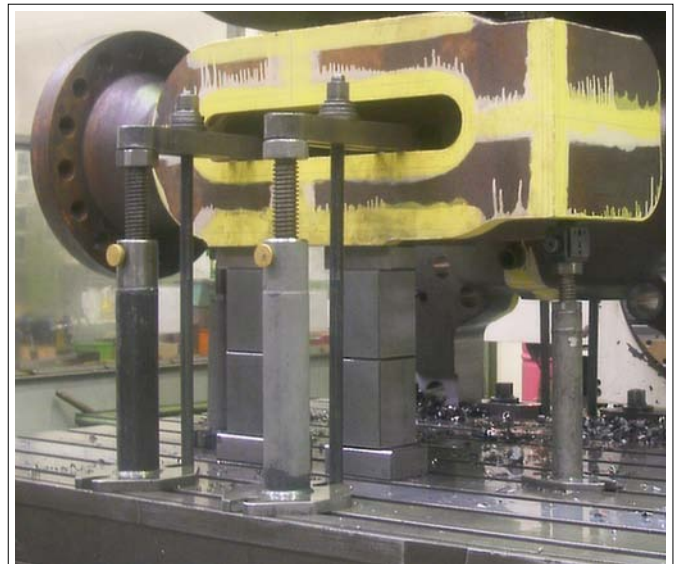
No. 6440,
page 56



No. 6441,
page 56



No. 6442,
page 56



Subject to technical alterations.

No. 6435SG

Heavy screw jack

with brass locking screw. Centring hole M12 mm. Spindle compl.: tempering steel with trapezoidal thread. Spindle head blued. Housing: tempering steel, varnished.

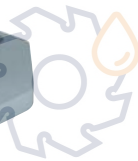
Order no.	Size	H min.	H max.	TR	B1	B2	L	SW	F max. [kN]	Weight [Kg]
376251	300	200	300	40x7	26	190	220	65	80	8,0
376277	460	290	470	40x7	26	190	220	65	60	12,0
376293	750	430	750	40x7	26	190	220	65	50	12,6
376319	1250	710	1250	40x7	26	190	220	65	40	16,5

Advantage:

- Base plate with closed elongated holes for use on vertical turning and boring machines
- Thread in the head's mounting surface for fixing the clamping elements used with centrifugal forces

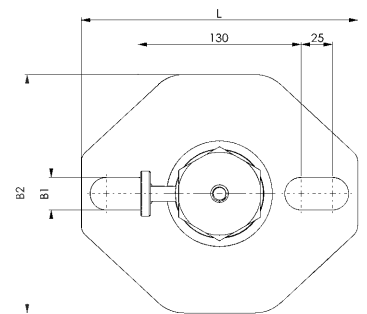
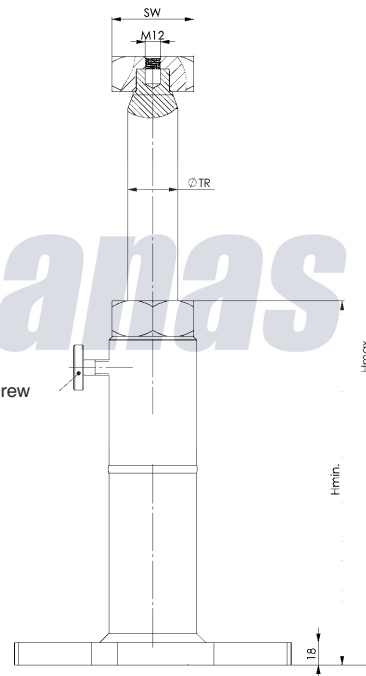
Note:

When using clamps no. 6315GNG with slot-sizes above 26 mm we recommend the use of locating pad no. 6443G for safety. Suitable pads are no. 6442G and 6443G. Do not adjust screw jack under load!



panas

Locking screw



Recommendations



No. 6442G,
page 58



No. 6443G,
page 58



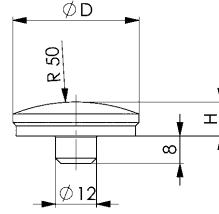
CAD

No. 6440

Ball-pad

Steel tempered, burnished.

Order no.	H	D	Weight [g]
72710	10	37	90



CAD

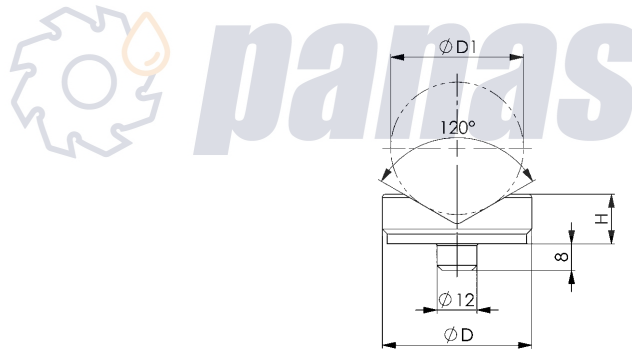


No. 6441

Vee-pad

Steel tempered, burnished.

Order no.	Size	H	D	D1 min.	D1 max.	Weight [g]
72728	45	15	45	10	50	120
72769	65	30	65	22	100	545



CAD

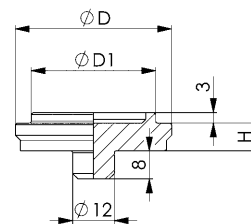


No. 6442

Centering-pad

Steel tempered, burnished.

Order no.	H	D	D1	Weight [g]
72736	8	45	35,8	120



CAD



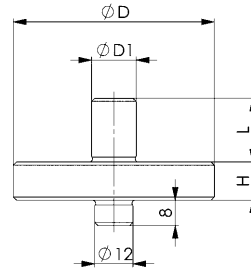
Subject to technical alterations.

No. 6443

Locating-pad

for forked clamps. Steel tempered, burnished.

Order no.	Size	H	D	D1	L	Weight [g]
72751	14	12	63	14	15	310
72744	25	15	78	25	25	650

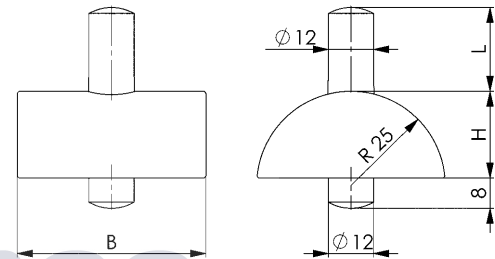


No. 6444

Locating-pad

with cylindrical face. Steel tempered and burnished.

Order no.	H	B	L	Weight [g]
72454	23	50	19	370

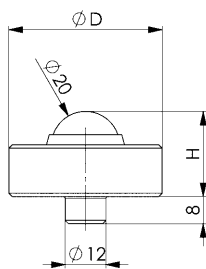


No. 6445

Support with pivotable ball

Steel tempered, burnished. Ball made of hardened steel.

Order no.	H	D	F max. [kN]	Weight [g]
72819	25	45	30	240

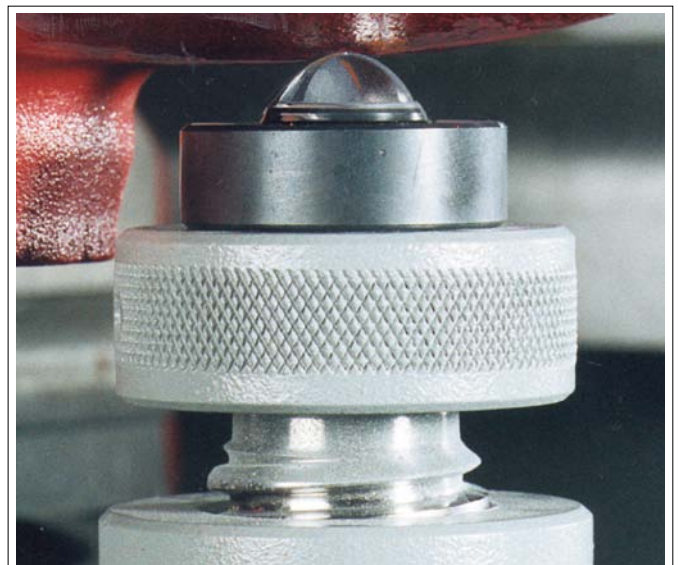


Application:

This rugged element was designed for the supporting and alignment of workpieces made of cast iron and forging-grade steels. Designed for use with AMF-screw jacks.

Advantage:

- The pivotable ball minimizes the friction on the support and reduces the required operating forces.
- The use of a point-like support prevents the transmission of the torsional force created by the movement of the spindle. The position of the workpiece remains unchanged.
- The simple and rugged construction provides for a long lasting service life.



Subject to technical alterations.

No. 6442G

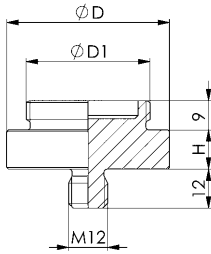
Centring plate with thread

Steel tempered, burnished.

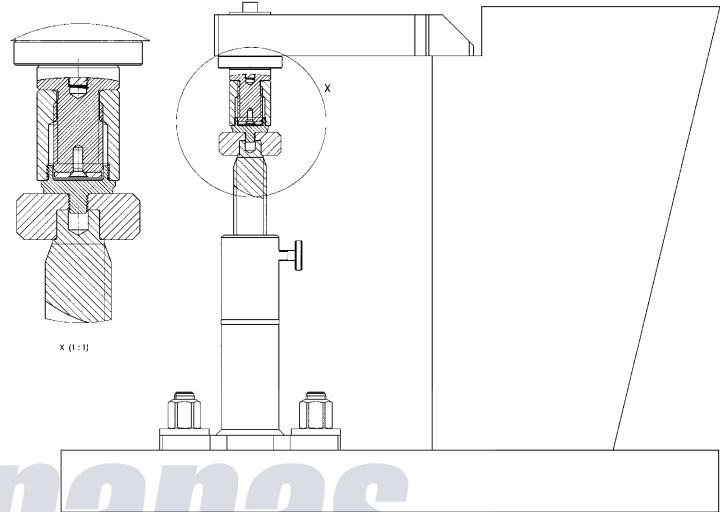
Order no.	H	D	D1	Weight [g]
376335	12	50	M38x2	240

Advantage:

Centring plate can be screwed onto screw jacks. Safety with vertical turning and boring machines! The screw jacks no. 6400G can be screwed onto the centring plate.



CAD



No. 6443G

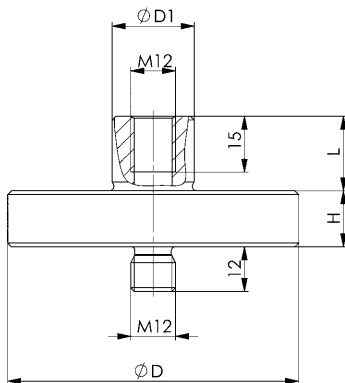
Fixing cap with thread

for forked clamps. Steel tempered, burnished.

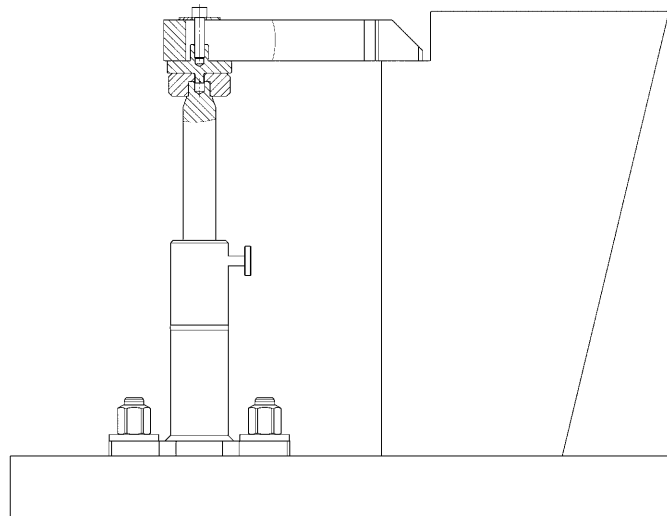
Order no.	Size	H	D	D1	L	Weight [g]
376350	25	15	78	22	20	601

Advantage:

Centring plate can be screwed onto screw jacks. Internal thread for additional fastening of clamps onto screw jacks. Safety with vertical turning and boring machines.



CAD



No. 6417

Mandrel

blued, with brass thrust piece.

Order no.	Size	Slot	H ±0,1	H1 min.	H1 max.	H2 min.	H2 max.	dia. D1	dia. D2	dia. D3	G1	G2	SW	Weight [g]
74179	80	14	80	116	148	8	40	40	50	32	M12	M16	27	1270

Application:

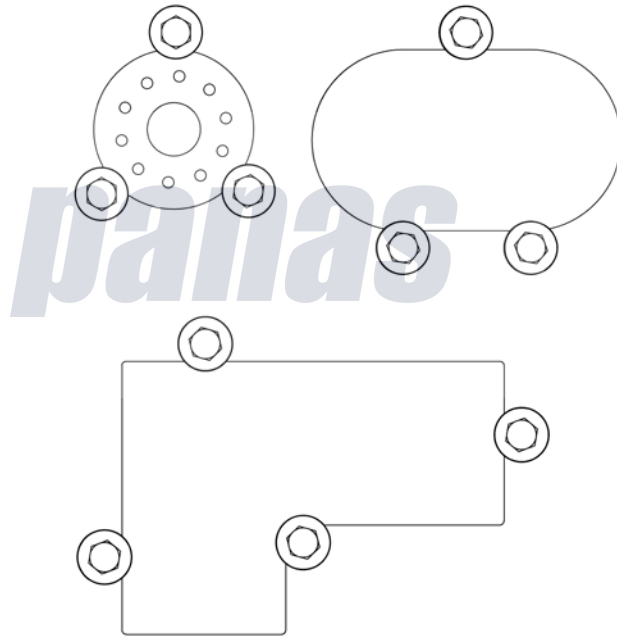
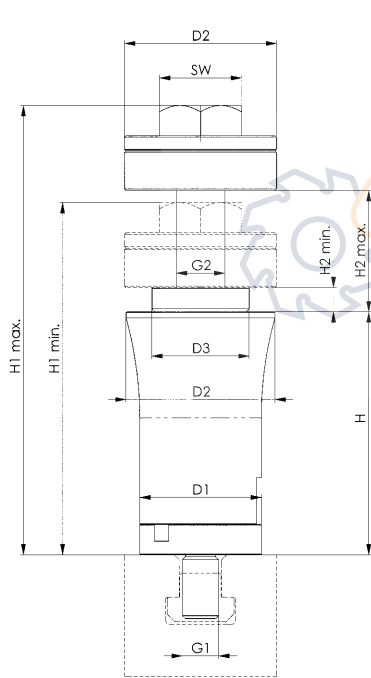
- The mandrels are fastened to the machine table by means of T-nuts.
- The mandrel is fixed on the slotted table by operating the SW 27 mm pre-tensioning nut.
- Clamping is by means of the SW 27 mm screw of tempered steel.
- Damage to the workpiece is prevented by a brass clamping ring.

Advantage:

- Reduced tooling time and tool elements cuts tooling costs
- Optimal use of the machine table
- Tension on flat workpieces increased to make holes, threads and grooves

Note:

- Suitable for workpiece thicknesses from 8 to 40 mm
- Support height 80 mm
- Also available is an extension screw for workpiece thicknesses from 40 - 72 mm and Spacer elements of 25 mm and 50 mm to increase the support height



Recommendations



No. 6417Z, page 60



No. 6417SP, page 60



Subject to technical alterations.

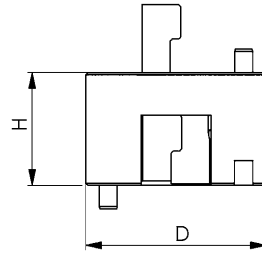
No. 6417Z
Spacer element

blued.

Order no.	Size	dia. D	H	Weight [g]
74195	25	40	25	214
74211	50	40	50	459

Application:

Used to increase the support height.

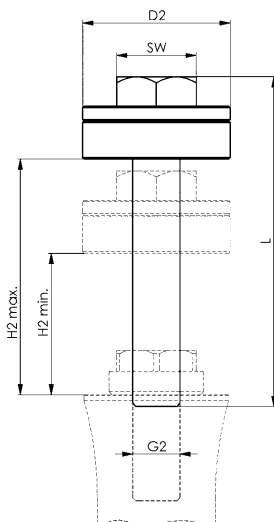

No. 6417SP
Spindle, long

blued.

Order no.	Size	L	dia. D2	G2	SW	H2 min.	H2 max.	Weight [g]
74237	M16	104	50	M16	27	40	72	423

Application:

Used to increase the clamping height.



Subject to technical alterations.

No. 6418

Support element, mechanical

incl. DIN 508-M12x14 nut for T-grooves, M12x30-10.9 threaded stud. Body: Case-hardened steel, manganese phosphatised and ground. Body: Aluminium.



Order no.	Size	Support force F max. [kN]	H	Stroke [mm]	SW1	SW2	G	Weight [g]
75416	M12	8	78-83	5	21	6	M12	939

Application:

- Fasten support element (2x M6 connecting thread) on fixture.
 - Note operator side!
 - Alternatively: Remove M12 x 10 threaded stud and replace with M12 x 30 threaded stud and mount the support element with key (size 21), e.g. for T-groove mounting
 - (No defined operator side ensured).
- Turning the clamping cam (hexagon socket size 6) on the outside surface of the red protective sleeve positions the supporting bolt against the workpiece with light spring force.
- Turning further as far as it will go (lock) - a total of 180° - locks the clamping mechanism of the supporting bolt without length change.
 - The support element is positioned on the workpiece and locked.
- Turning in the opposite direction (unlock) releases the clamping. Continuing to turn back as far as it will go - a total of 180° - moves the supporting bolt to the end position.

Advantage:

- Used as an extra support to prevent sagging and vibration of the workpiece.
- Mounted directly under a clamping point, it prevents distortion of the workpiece.
- Compensation of large workpiece tolerances (castings).

Note:

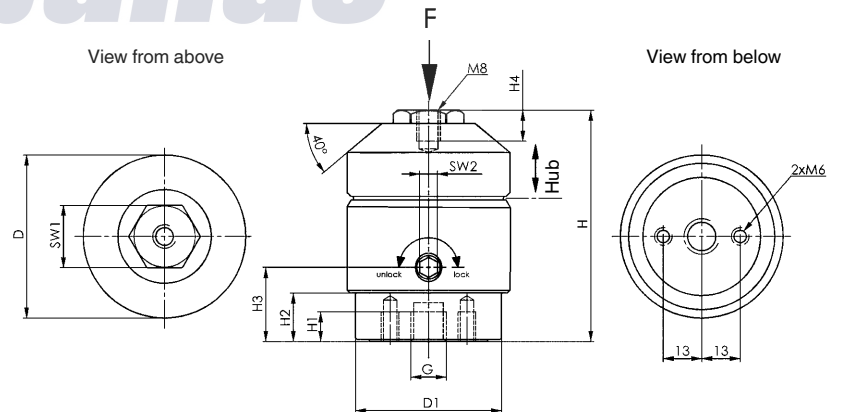
- M8 thread on supporting bolt can be mounted with pressure screws (Nos. 7110DHX, 7110DIX, 7110DKX, 7110DFX).
- Customer-specific extensions can also be mounted.
- For reliable function the M12 threaded hole must always be closed.

Dimensions:

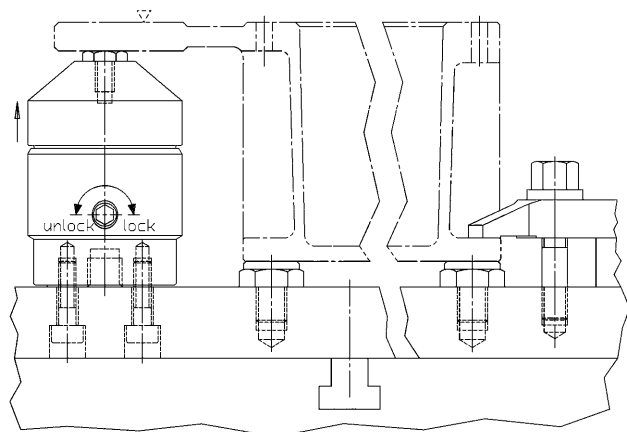
Order no.	Size	D	D1	H1	H2	H3	H4
75416	M12	55	49,4	10	16	25	10,5



panas



Application example:



CAD

No. 6419

Floating clamp

incl mounting for T-grooves.



Order no.	Size	Slot	G	Md min. - max. [Nm]	F [kN]	Setting travel H	Clamping stroke H2*	Weight [g]
75754	12	14	M12	15-30	2-8	102-112	0-12	1880
75622	16	18	M16	50-115	8-25	163-175	10-25	6250

* Clamping stroke = clamping range with upper and lower standard clamping jaw.

Application:

1. Fasten floating clamp on fixture or machine table.
2. Adjust height stop and swivel range with red adjustment sleeve and lock with threaded stud. When setting the upwards height limitation, allow for generous play (workpiece manufacturing tolerance).
3. Press floating clamp downwards.
4. Swivel clamping jaws in as far as they will go.
 - The floating clamp is positioned with light spring force on bottom of workpiece.
5. Tighten floating clamp with hexagon nut.
 - During the clamping process the workpiece is clamped and at the same time supported.
6. Unclamping is carried out in the reverse sequence.

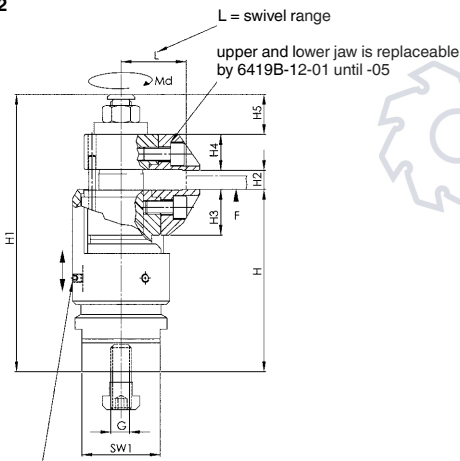
Advantage:

- Especially suitable for large, hard-to-machine components (size 16).
- No deformation when clamping weak components.
- Vibration suppression during machining.
- Clamping of ribs, creases and tabs for stiffening on clamped components.
- Deformation-free clamping of blanks.

Note:

- The floating clamp is used to clamp and support overdetermined clamping points on components.
- For customer-specific clamping situations the supplied clamping jaws can be replaced with the following clamping jaws (Nos. 6419B-12 and 6418B-16) (max. tightening torque = 43 Nm)

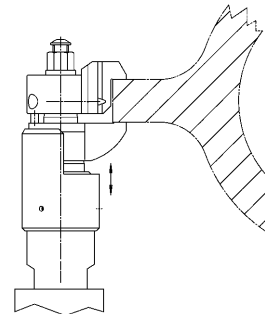
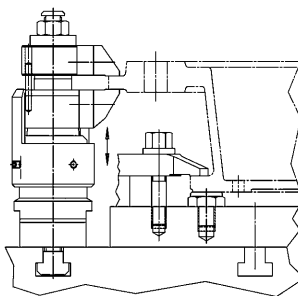
Size 12



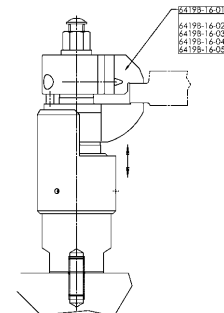
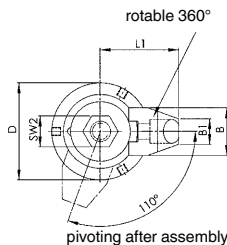
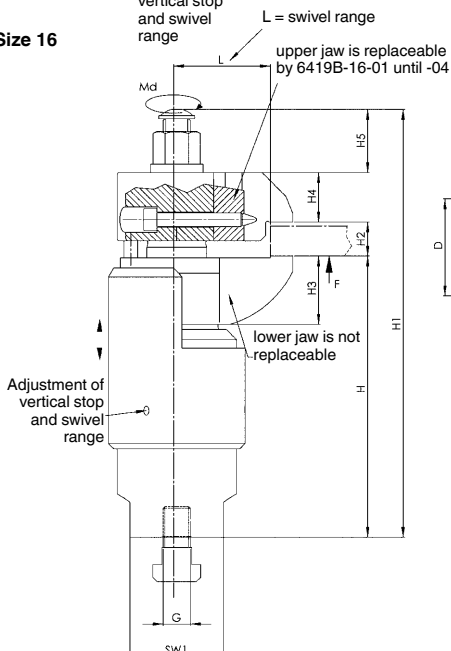
Dimensions:

Order no.	Size	SW1	SW2	B	B1	D	H1	H3	H4	H5	L	L1
75754	12	46	18	28	15	57	163	26,8	21	32	39	46
75622	16	55	24	54	20	80	261	40,0	29	45	54	68

Application examples:



Size 16



Subject to technical alterations.

No. 6419B-12-01

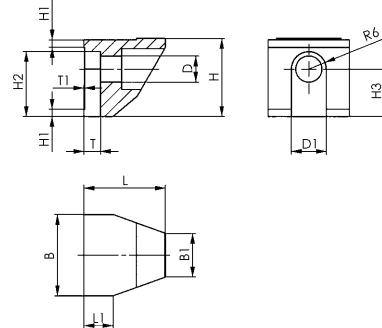
Clamping jaw

Case-hardened steel, nitrided and burnished.
Lower standard clamping jaw.

Order no.	Size	B	B1	D	D1 +0,02	H -0,1	H1	H2 -0,1	H3 ±0,1	L	L1	T +0,2	T1	Weight [g]
71233	12	28	15	9	12	26,8	2,5	22,3	16,3	28	10	5,5	0,2	83

Note:

Fastening with ISO 4762-M8 cylinder bolts.



No. 6419B-12-02

Clamping jaw

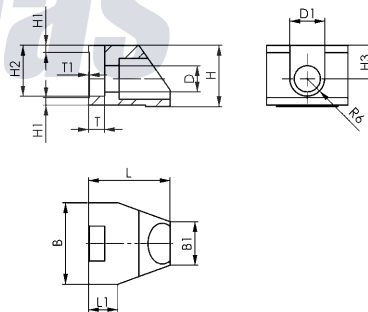
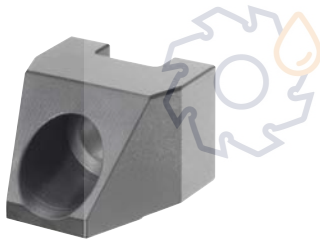
Case-hardened steel, nitrided and burnished.
Upper standard clamping jaw.

Order no.	Size	B	B1	D	D1 +0,02	H -0,1	H1	H2 -0,1	H3 ±0,1	L	L1	T +0,2	T1	Weight [g]
71605	12	28	15	9	12	21	2,5	17,5	11,5	29,5	11,5	5,5	0,2	71

Clamping range = workpiece thickness 0-12 mm.

Note:

Fastening with ISO 4762-M8 cylinder bolts.



No. 6419B-12-03

Clamping jaw

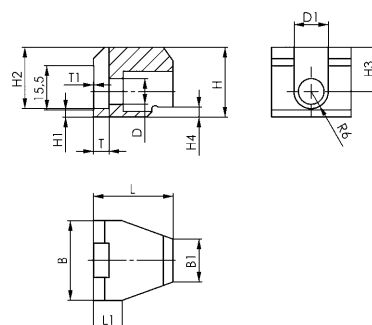
Case-hardened steel, nitrided and burnished.
Upper exchangeable clamping jaw.

Order no.	Size	B	B1	D	D1 +0,02	H -0,1	H1	H2 -0,1	H3 ±0,1	H4	L	L1	T +0,2	T1	Weight [g]
74229	12	28	15	9	12	24,5	2,5	21,5	15,5	3,5	29,5	11,5	5,5	0,2	94

Clamping range = workpiece thickness 4-16 mm.

Note:

Fastening with ISO 4762-M8 cylinder bolts.



No. 6419B-12-04

Clamping jaw

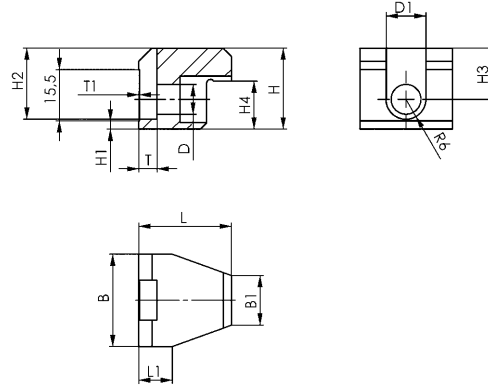
Case-hardened steel, nitrided and burnished.
Upper exchangeable clamping jaw.

Order no.	Size	B	B1	D	D1 +0,02	H -0,1	H1	H2 -0,1	H3 ±0,1	H4	L	L1	T +0,2	T1	Weight [g]
74245	12	28	15	9	12	24,5	2,5	21,5	15,5	14,5	29,5	11,5	5,5	0,2	90

Clamping range = workpiece thickness 15-27 mm.

Note:

Fastening with ISO 4762-M8 cylinder bolts.



No. 6419B-12-05

Clamping jaw

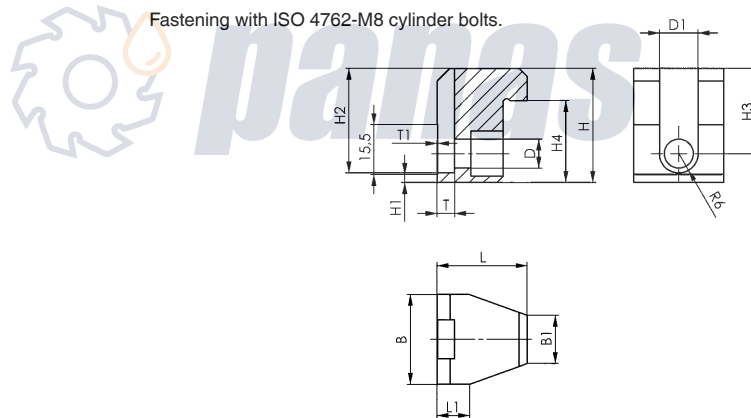
Case-hardened steel, nitrided and burnished.
Upper exchangeable clamping jaw.

Order no.	Size	B	B1	D	D1 +0,02	H -0,1	H1	H2 -0,1	H3 ±0,1	H4	L	L1	T +0,2	T1	Weight [g]
75051	12	28	15	9	12	35,5	2,5	32,5	26,5	25,5	29,5	11,5	5,5	0,2	132

Clamping range = workpiece thickness 26-38 mm.

Note:

Fastening with ISO 4762-M8 cylinder bolts.



No. 6419B-16-01

Clamping jaw

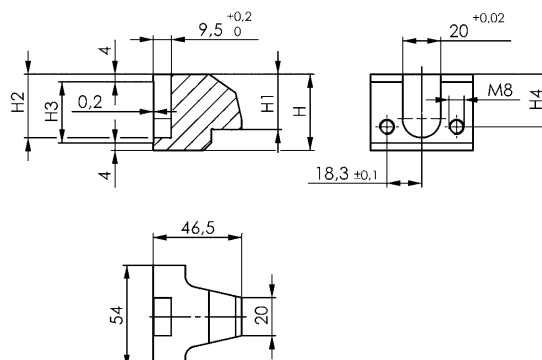
Case-hardened steel, nitrided and manganese phosphatised.
Upper standard clamping jaw.

Order no.	Size	H	H1	H2	H3	H4	Weight [g]
75382	16	40	29	33,3	32	27,6	400

Clamping range = workpiece thickness 10-25 mm.

Note:

Fastening with ISO 4762-M8x50 cylinder bolts.



No. 6419B-16-02

Clamping jaw

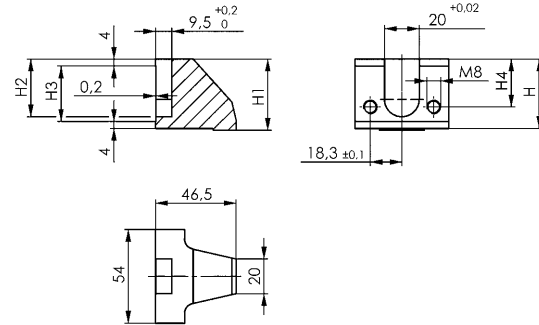
Case-hardened steel, nitrided and manganese phosphatised.
Upper exchangeable clamping jaw.

Order no.	Size	H	H1	H2	H3	H4	Weight [g]
75424	16	40	41	33,3	32	27,6	380

Clamping range = workpiece thickness 0-14 mm.

Note:

Fastening with ISO 4762-M8x50 cylinder bolts.



No. 6419B-16-03

Clamping jaw

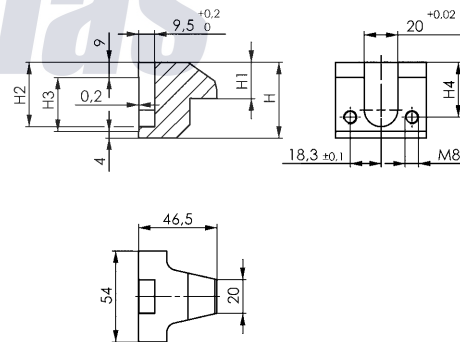
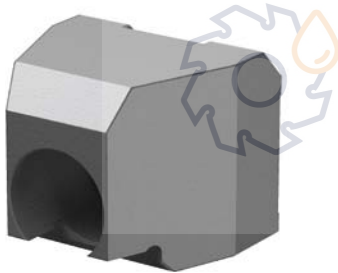
Case-hardened steel, nitrided and manganese phosphatised.
Upper exchangeable clamping jaw.

Order no.	Size	H	H1	H2	H3	H4	Weight [g]
75440	16	45	21,6	38,3	32	32,6	440

Clamping range = workpiece thickness 23-38 mm.

Note:

Fastening with ISO 4762-M8x50 cylinder bolts.



No. 6419B-16-04

Clamping jaw

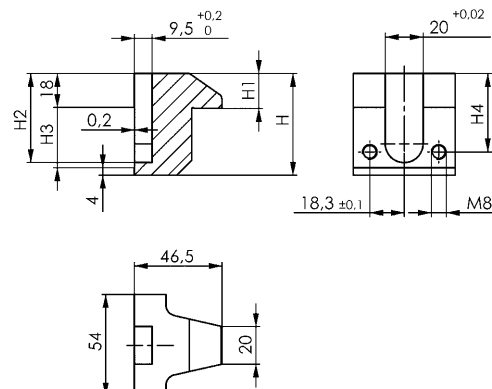
Case-hardened steel, nitrided and manganese phosphatised.
Upper exchangeable clamping jaw.

Order no.	Size	H	H1	H2	H3	H4	Weight [g]
75630	16	54	18,6	47,3	32	41,6	510

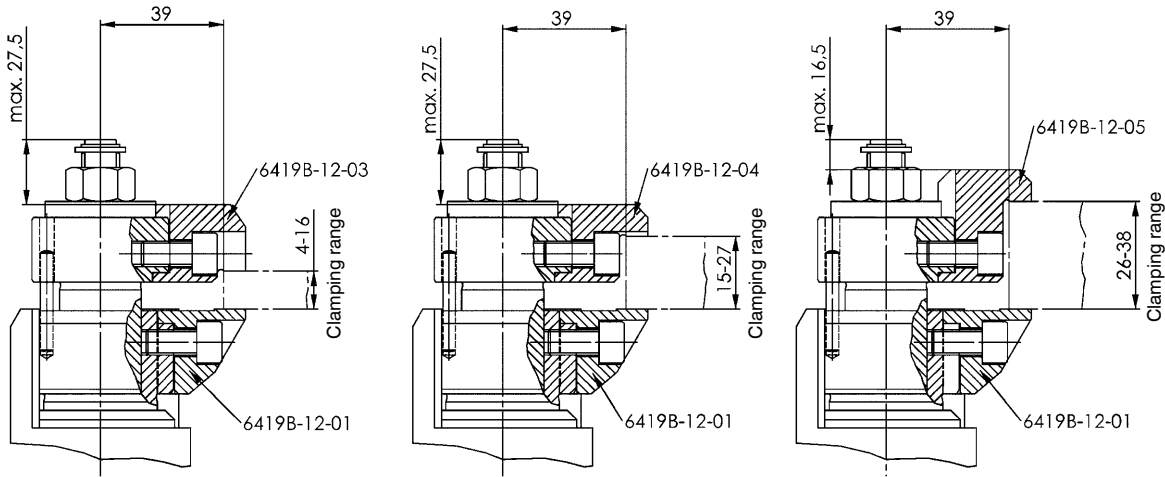
Clamping range = workpiece thickness 35-50 mm.

Note:

Fastening with ISO 4762-M8x50 cylinder bolts.



Application examples clamping jaw No. 6419B-12



Application examples clamping jaw No. 6419B-16

