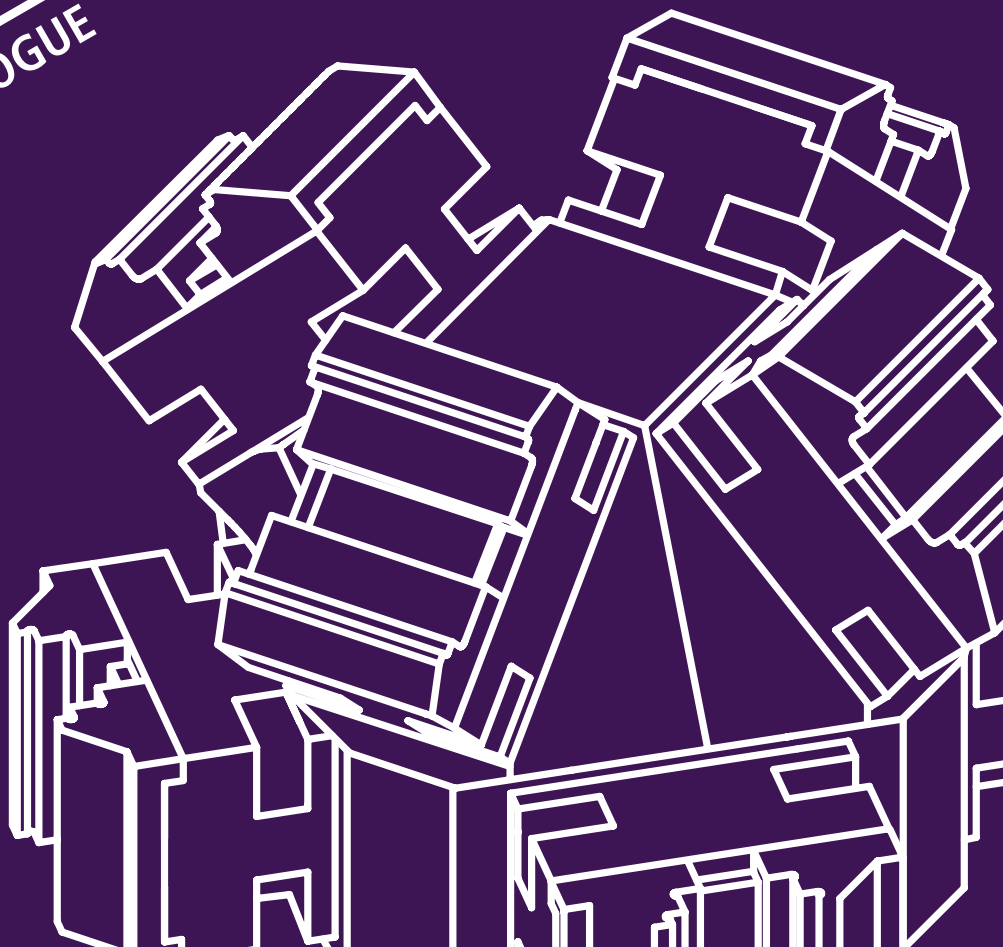
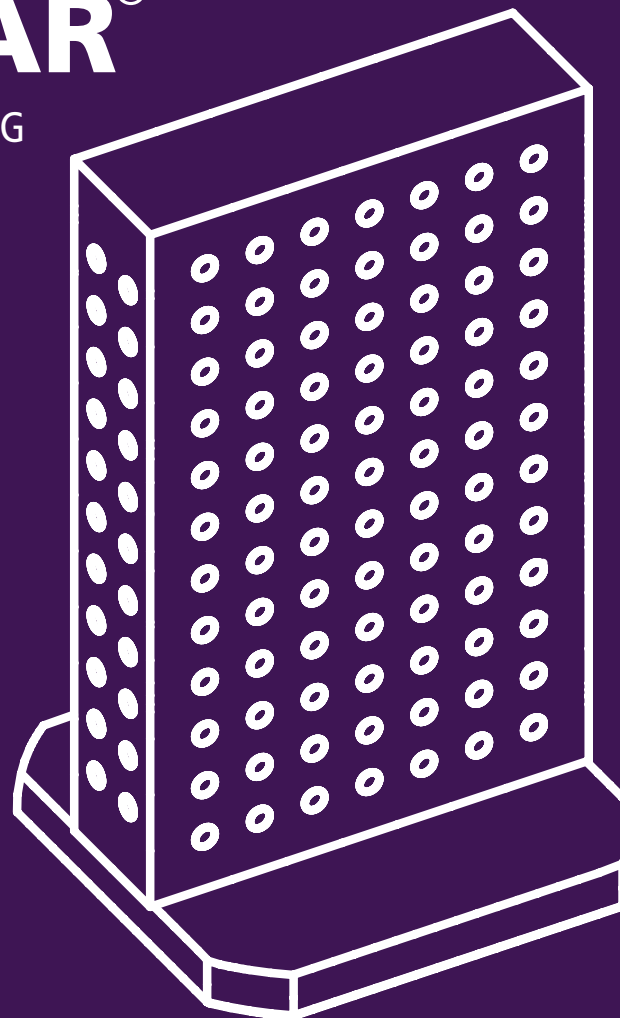
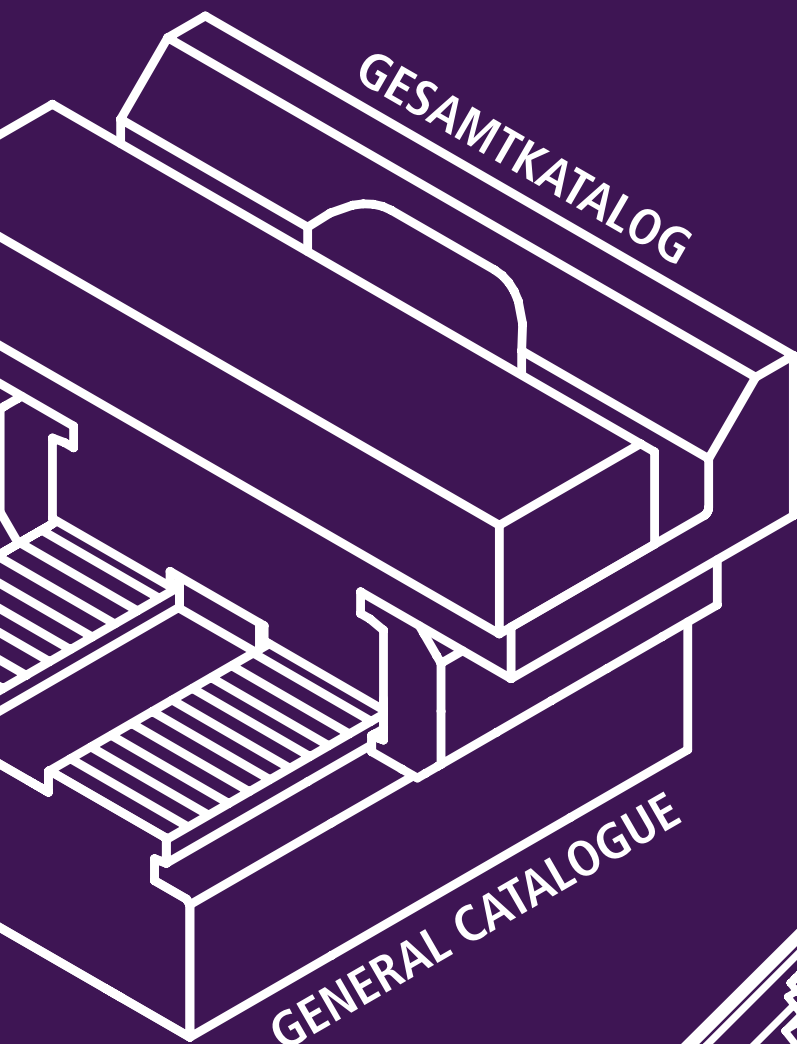


swiss **MODULAR**®

by Triag International AG



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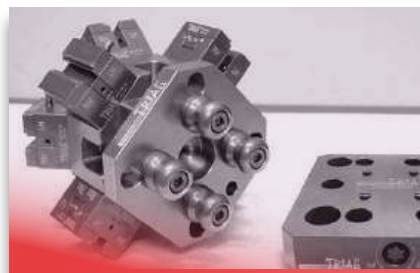
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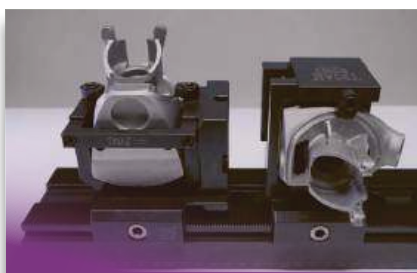
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Über uns About us

1990 Die Triag AG wurde im Jahr 1990 von Edi Zängerle, Ursula Landtwing und Beat Baumgartner gegründet. Sie vertrieb ihre Spannsysteme sowie Zerspanungswerkzeuge namhafter Hersteller hauptsächlich auf dem Schweizer Markt.

HEUTE Wir, die Triag International AG, konzentrieren uns seither auf die Entwicklung, Produktion sowie den weltweiten Vertrieb unserer modernen Spannsysteme. Sowohl mit unserem tiefen und breiten Standard Sortiment, als auch mittels werkstückspezifischen Sonderlösungen möchten wir unseren Kunden dabei helfen, ihren Maschinenraum optimal auszunutzen, um dadurch die grösstmögliche Effizienz zu erzielen. Unsere Spannsysteme können von der konventionellen Fräsmaschine bis hin zu modernen 5-Achs-Fräszentren mit oder ohne Automatisierung eingesetzt werden. Diese Effizienz nutzen wir auch in der Herstellung unserer Spannsysteme in unserer eigenen Fertigung.

Auf ein gutes Arbeitsklima und unsere Umwelt legen wir sehr grossen Wert, denn nur mit einem funktionierenden Team und einem grossen Umweltbewusstsein können wir unsere Kunden offen und nachhaltig bedienen.

1990 Triag AG was founded in 1990 by Edi Zängerle, Ursula Landtwing and Beat Baumgartner. Triag AG distributed its clamping systems as well as cutting tools of well-known manufacturers primarily on the Swiss market.

TODAY Triag International AG concentrates on the development, manufacturing and worldwide distribution of our modern clamping systems. With our wide range of standard products as well as by means of custom-built solutions we aim to help our customers to get the most out of their machine space in order to achieve the highest efficiency possible. Our modular workholding systems can be applied from conventional up to 5-axis milling machines, with or without automation. We benefit this efficiency in in our own production too.

We focus on a good working atmosphere and place great value on our environment. We believe that these factors are essential to provide an open and sustainable service.



Übernahme der Geschäftsleitung
durch die nächste Generation.

2024

Takeover of management by the next generation.

Triag International AG launcht die neue Marke swissMODULAR. Die Marke umfasst das gesamte Sortiment an Spannsystemen und Mineralgussstürmen.

2023

Triag International AG has rebranded to swissMODULAR. The new brand includes the whole range of clamping systems and epoxy mineral tombstones.

Entstehung der Triag International AG und der Schwesterfirma Tribur Invent GmbH, die sich auf den weltweiten Vertrieb mit eigenem Engineering, eigener Produktion und Mineralguss Giesserei konzentrieren.

2013

The formation of Triag International AG and the sister company Tribur Invent GmbH, which are focusing on worldwide distribution with their own engineering, manufacturing and epoxy mineral casting.

Gründung der Triag AG

1990

Foundation of Triag AG

**Im Herzen der Schweiz
In the heart of Switzerland**

**swiss
MODULAR®**

by Triag International AG



Triag International AG

Bösch 84 CH-6331 Hünenberg

☎ +41 41 727 27 77

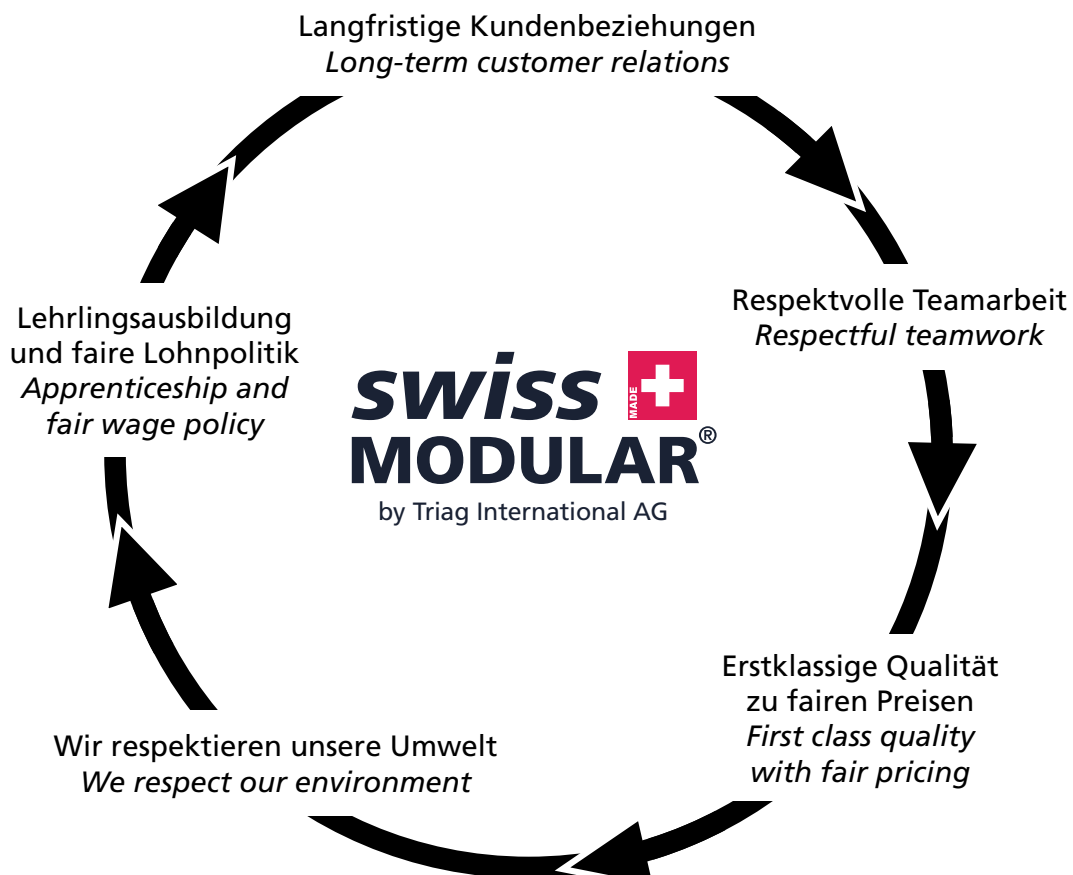
✉ spannen@triag-int.ch

✉ clamping@triag-int.ch



swissmodular.com

Official Website



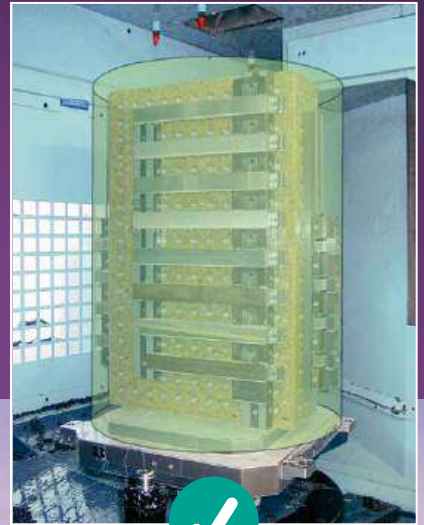


Time to say goodbye
to the dinosaur vises!



SECRETS OF

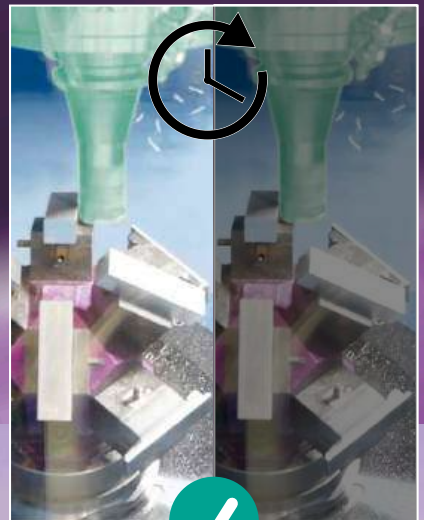
RAUM SPACE



«In Gebäuden ist es üblich, den Raum komplett zu vermieten. Wieso nicht auch in Ihrer Maschine?»

«In buildings, it is common to rent out the full space. Why not in your machine?»

ZEIT TIME



«Flugzeuge sollen möglichst kurze Zeit geparkt bleiben. Das gleiche gilt für die Frässpindel.»

«Aircrafts should remain parked for the shortest amount of time. The same rule applies to the milling spindle.»

MIXED PRODUCTION



AUTOMATION

«Eine durchdachte Automation ist unverzichtbar. Sie soll 24/7 unbemannte Produktion und lange Spindellaufzeiten ermöglichen.»



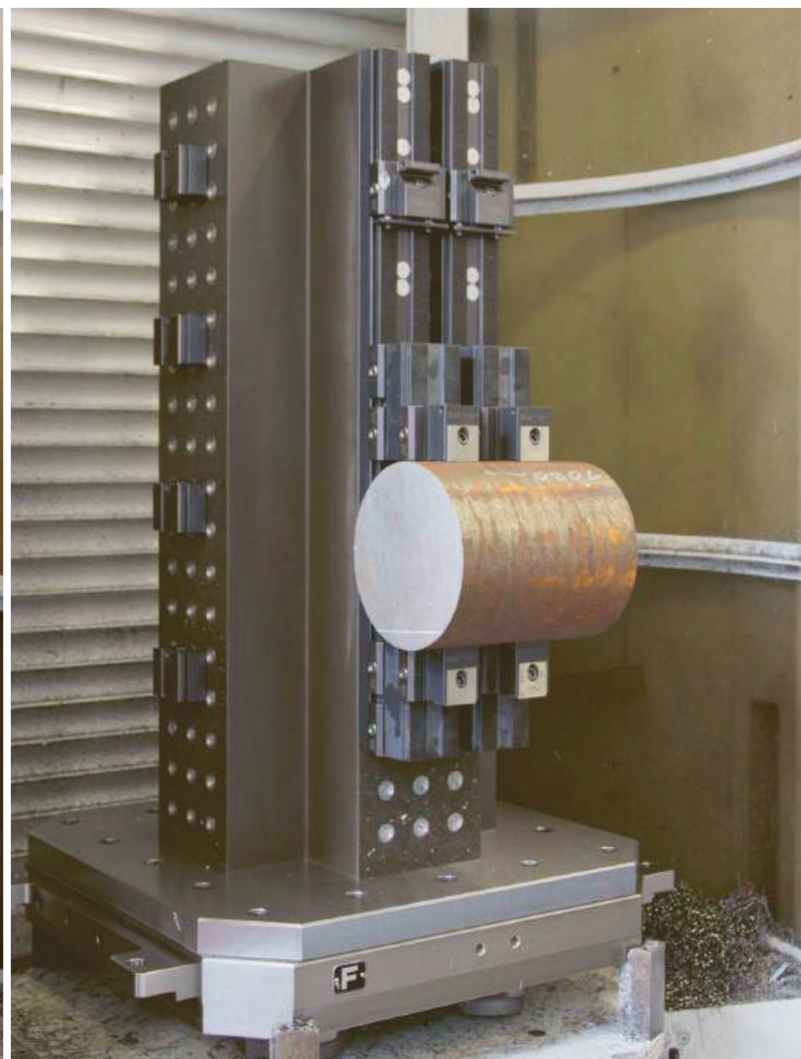
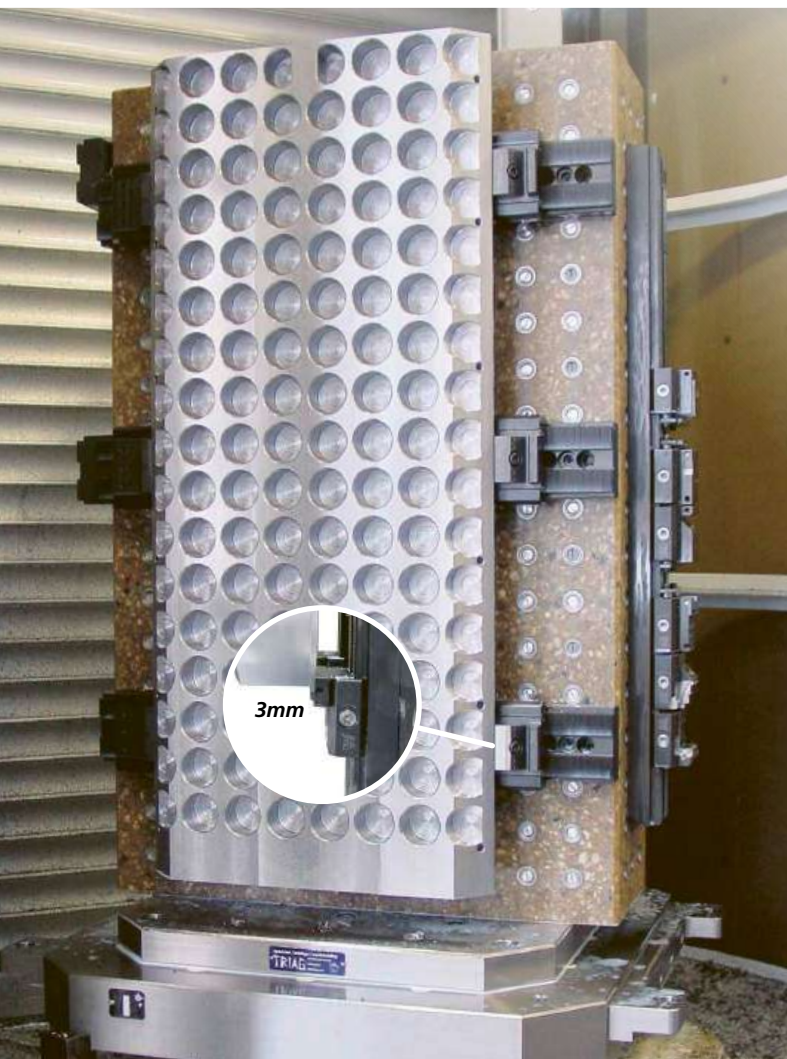
«A smart automation is essential. It should enable 24/7 unmanned production and long spindle running times.»

«Modular» bedeutet:

3 dimensionales Anpassen an Werkstück und Maschine

Vorteile des modularen Mehrfachspannens:

- Möglichkeit der chaotischen Produktion
- Schneller Werkstückwechsel
- Vielseitigkeit durch Kombination mehrerer Komponenten, 3D modular (Schienen, mechanisch oder hydraulisch betätigte Spannelemente etc.)
- Einfache Montageprozesse
- Lange Lebensdauer, geringe zusätzliche Instandhaltungskosten
- Beschädigte Komponenten können einfach ersetzt werden
- Längere unbemannte Laufzeit
- Deutlich weniger Werkzeug- und Palettenwechsel
- Schont die Maschine, da der gesamte Bearbeitungsraum genutzt wird
- Preis: Kann trotz der Vorteile mit einem Spannstock mithalten
- Geringerer Aufwand in der Logistik, Lagerhaltung und Beschaffung
- Höhere Spanndichte, mehr Teile aufgespannt
- Spannen von kleinen wie grossen Werkstücken



«Modular» means:

Adapting to workpiece and machine situation in 3 dimensions

Advantage of modular workholding:

- Possibility of chaotical manufacturing
- Fast workpiece change
- Flexibility because of different components, 3D modular
- Simple to set up
- Cost effective
- Easy to replace spare parts
- Long unmanned production
- Less tool changes
- The machines are used in the whole working area
- Competitive price to standart vises
- Simple to be purchased and used on different machines
- High density workholding, you clamp more parts!
- Long and reliable live with low maintenance cost

Chaotische Spannung für das Erledigen von verschiedenen Jobs gleichzeitig.
Optimale Nutzung eines Horizontal-Bearbeitungszentrums.

*Mixed set up on a Mazak horizontal machine with
18 pallets. This is used for unmanned production of
small quantities of different materials.*



Modulare Mehrfachspannsysteme werden in ihrer Bedeutung für die Zerspanung noch immer unterschätzt. Dabei sind sie sowohl in der Einzelteillfertigung als auch für Grossserien flexibel einsetzbar. Zurückzuführen ist diese Flexibilität auf das Konstruktionsprinzip der Systeme, ihre handhabbare, kompakte Bauweise wie auch die hohe Spannkraft und Spanndichte.

Bei der Beurteilung modularer Mehrfachspannsysteme gibt es eine eigentümliche Konstellation: Zum einen sieht der Einzelteil- und Kleinserienfertiger enorme Vorteile für die Anwendung in der Serienfertigung, beispielsweise rückbaubarer Vorrichtungsbaukasten. Zum anderen erkennt der Serienfertiger genau diese Vorzüge für die Einzelteil- und Kleinserienfertigung. Diese Sichtweise zu hinterfragen und zu verdeutlichen, worin die fertigungsspezifischen Vorteile modularer Mehrfachspannsysteme liegen, ist Ziel des Beitrags.

Modulare Mehrfachspannsysteme sind flexibel anwendbar

Für viele Zerspanungsarbeiten ist der klassische Maschinenschraubstock auch heute noch die passende Spannung. Mit den ständig neuen und erhöhten Anforderungen geht allerdings die Entwicklung der Spanntechnik in eine andere Richtung. Will man ein hohes Mass an Flexibilität und eine grosse Spanndichte erzielen und sollen gleichzeitig verschiedene Werkstücke auf kleinstem Raum gespannt werden, kommt der klassische Maschinenschraubstock oft an seine Grenzen. Häufig führt hier nur ein modulares Mehrfachspannsystem zum Erfolg. Spannsysteme müssen heute möglichst flexibel sein. Damit lassen sie sich an veränderte Umstände anpassen und können so die Wirtschaftlichkeit des Bearbeitungsprozesses erhalten. Modular ist ein Spannsystem, wenn es nach dem Baukastenprinzip aus Elementen zusammengesetzt und erweiterbar ist. Neben diesen grundsätzlichen Eigenschaften bedarf das Spannsystem jedoch weiterer prägnanter Merkmale: So muss es einfach und schnell zu handhaben sein, eine kompakte Bauweise mit hoher Spannkraft und Spanndichte verbinden und möglichst autarke Spannstellen aufweisen, deren Spanndruck einzeln zu verstellen ist. Im Idealfall kann mit nur einer Basisschiene ein breites Backenprogramm mit geringem Aufwand aufgebaut werden.

In der Serienfertigung besteht der wohl grösste Vorteil modularer Mehrfachspannsysteme darin, dass sich das System als rückbaubarer Vorrichtungsbaukasten für ein vielseitig gefächertes Werkstückspektrum einsetzen lässt. So spart sich der Anwender oft teilespezifische, teure Vorrichtungen. Mehrfachspannsysteme können zudem das Engineering vereinfachen, da sich auf vorhandenes Spannmaterial zurückgreifen lässt. So sind kurze Planungs- und Umrüstzeiten realistisch. Darüber hinaus trägt das modulare System zur erhöhten Prozesssicherheit bei und fördert die Qualitätstreue, die heute ein elementares, unabdingbares Kriterium der modernen Fertigung ist. Schliesslich ist ein Mehrfachspannsystem mit mehreren unabhängigen Spannstellen auch für den Einsatz in der Serie ideal, da so mehrere Werkstückspannungen mit unterschiedlichen Parametern möglich sind.

Anwendung ist bei horizontalem und vertikalem Aufbau möglich

Häufig wird bei der Serienfertigung eine Maschine mit horizontalem Aufbau, Palettenbahnhof und Spanntürmen verwendet. Was aber ist mit vertikalen Bearbeitungszentren? Wo liegen hier die Vorteile eines Mehrfachspannsystems? Spanntürme, die in der Serienfertigung mit modularen Mehrfachspannsystemen bestückt werden, weisen eine hohe Spanndichte auf, die zur verlängerten Spindelzeit führt. Gleichzeitig ist auch eine hervorragende Zugänglichkeit der Werkzeuge gewährleistet.



1

Vertikalmaschinen, deren komplette Tischflächen mit einem modularen Mehrfachspannsystem bestückt sind, ermöglichen Spanndichten, die denen auf Horizontalmaschinen gleichen

Mit einer vierten Achse kann eine Vertikalmaschine zur Serienmaschine mit Mehrseitenbearbeitung aufgerüstet werden, wobei auch hier eine hohe Spanndichte und Zugänglichkeit erreicht wird. Die horizontale und die vertikale Strategie lässt sich mit dem gleichen Spannsystem umsetzen, was bei Maschinenausfall mitunter eine echte Problemlösung darstellt.

Autarke Spannstellen sind auch für die Kleinserie wichtig

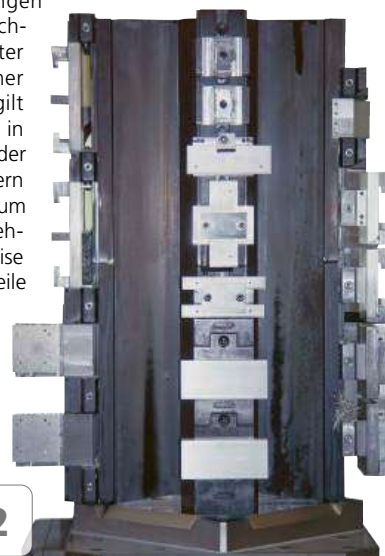
In der Einzelteil- und Kleinserienfertigung spielen modulare Mehrfachspannsysteme grundsätzlich die gleichen Vorteile wie in der Serienfertigung aus: hohe Spanndichte, geringere Werkzeugwechselzeiten, bessere Tischauslastung, gute Zugänglichkeit, einfache Handhabung, einfaches Engineering. Besonders wichtig ist hier jedoch die Flexibilität der Spanntechnik. Gerade bei kleinen Losgrößen geht viel Zeit beim Umrüsten verloren. Um diesen Vorgang zu optimieren, ist der Einsatz modularer Spannsysteme häufig das einzige Mittel. Daher ist die schnelle Verstellbarkeit der einzelnen Spannstellen in Spanndruck, Backenbreite oder Backenausführung unabdingbar.

Autarke Spannstellen sind gerade für den Einzelteillfertiger immens wichtig. Mit ihnen kann er sicherstellen, dass sich verschiedene Werkstücke aus unterschiedlichen Materialien gleichzeitig und prozessspezifisch spannen lassen (siehe Bild 2).

Der notwendige Spanndruck wird dabei ebenso gewährleistet wie die Verformungsfreiheit des Werkstücks. Letztlich resultiert aus der höheren Spanndichte eine längere Spindelzeit. Bei wiederkehrenden Kleinserien ist die reproduzierbare Spannsituation sehr wichtig. Wie in der Grossserie kann auch bei Kleinserien oder Einzelteilen die Tischfläche mit einem Mehrfachspannsystem besser ausgenutzt, der Werkzeugwechsel reduziert und die Wirtschaftlichkeit erhöht werden (siehe Bild 3).

Bei genauer Betrachtung der verschiedenen Fertigungsstrategien - Horizontal- oder Vertikal-BAZ sowie Serien-, Einzelteil- oder Kleinserienfertigung- wird die Vermischung der Verfahren deutlich. Die vermeintlichen Unterschiede sind oft nicht gross. Auch ist die Investition, die beim Übergang von einer Strategie zur anderen notwendig wird, jederzeit vertretbar und zu argumentieren. So erweist sich beispielsweise eine hochwertige Spannschiene mit drei oder vier Spannstellen als weitgehend preisneutral zu einem klassischen Maschinenschraubstock.

Für viele Anwendungen sind modulare Mehrfachspannsysteme ein echter Problemlöser und daher unumgänglich. Dies gilt sowohl für den Einsatz in der Serie als auch in der Einzelteillfertigung. Insofern haben beide Anwender - um zum Anfang zurückzukehren - mit ihrer Sichtweise recht. Nur gelten die Vorteile eben nicht nur für den jeweils anderen Bereich, sondern vor allem auch für den eigenen.



2

Kleinserienfertigung auf Horizontalmaschinen: Autarke Spannstellen ermöglichen die gleichzeitige, spezifische Fixierung unterschiedlicher Werkstücke.

Small batch production of different work pieces on a horizontal machining centre (family of parts)

The dormant potential

From the press

Modular and multiple workholding systems are still underestimated in their economic potential. But they have proven their point in many practical applications in batch production, in some cases even on small series. This is due to their modular, compact design resulting in a very high workpiece density. In spite of their compact size, the clamping force is considerable. Producers of small batches see the advantages of these systems mainly in the quantity production, whereas the mass producer uses these modular vice elements on some occasions to quickly set up a fixture for only a few parts. The reason for this fact you will find in this editorial.

Modular workholding systems are very flexible in their use

For many machining applications the classical machine vice is still the suitable workholding solution. Since the introduction of the CNC machining centres the demand for flexible, modular systems has constantly increased. These systems allow the accommodation of many parts in a limited workspace. Also the number of tool changes are considerably reduced, which means less machining time per part and longer spindle time between the loading stops. Consequently the machine productivity goes up.

Modern multiple workholding systems must be flexible. The setting up of their modules must be simple and quick. The kit like components have to be adaptable to many different workholding configurations, just by placing them into other locations or changing jaws. Their clamping force must be adjustable to protect the workpiece. In the ideal case the base rail must be able to accommodate many different vice modules and jaws.

In the production of larger batches the modular workholding systems have the greatest advantages. Their interchangeable modules can be placed to suit the workpieces often replacing expensive dedicated fixtures. Engineering of fixtures may be simplified.

Hence planning and set up from one part to the next can be shortened. Multiple workholding systems contribute also to more constant and precise parts improving the interchangeability of products, an important criterion in today's industrial world. In some cases it is even possible to clamp a family of parts in one setup. Some of our customers take advantage of this feature.

Installation possible on horizontal and vertical machines

On horizontal machines tombstones (fixture carrying towers) are often installed on the pallets. This arrangement allows for machining on three faces even with very high workpiece density. What about machines with vertical spindles? Where are the advantages of multiple workholding

systems on such machines. The machine table can be filled with several workholding systems side by side allowing many parts to be clamped in a small area. If an indexer (fourth axis) is installed with a bridge or a trunnion exactly the same machining features are possible as on a horizontal

The output of a vertical machine with a fully loaded table surface is similar to that of a horizontal machine.

machines – lots of parts even when machining on three faces. If independent base rails are used they can be installed vertically as well as horizontally. A high interchangeability of components gives good flexibility in case of a machine break down.

Multiple workholding also for small batch production and families of parts

A very important advantage besides the points mentioned for large quantity production, is the workholding of part families, particularly if the parts are produced at intervals. In such cases the flexibility and the simplicity of set up is of great importance. For instance shaped jaws may be stored in the tool room ready for the next production run. In some applications users build dedicated fixtures and install Compact Clamp or microCLAMP vice modules on their own fixtures (see picture 2).

Naturally the rail based systems like the Power Clamp or the Compact Clamp can be used as a conventional vice if only one vice module and one end module is used. For wider workpieces sometimes two or more systems are installed side by side. Doing that, the vice modules and the reference surfaces are aligned by the serrations or the pins in the base rail.

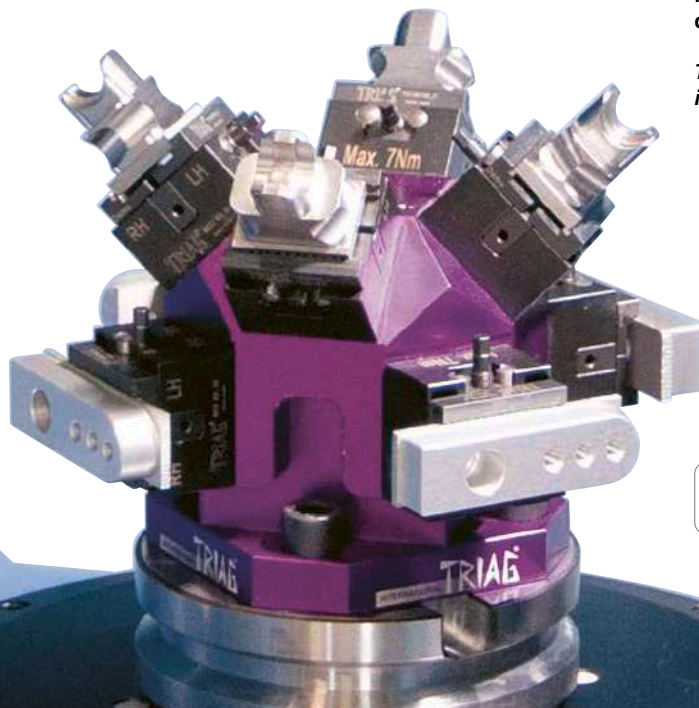
Again, the clamping of different workpieces allows the use of the same tool on various cuts therefore giving longer machining cycles and less tool changes (see picture 3).

The investment in a multiple workholding system with three or four workholding stations is about the same as that for a conventional machine vice. But the multiple workholding system gives the user much greater flexibility and versatility.



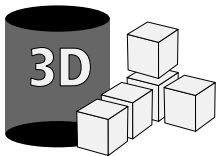
Die Verwendung von Mehrfachspannsystemen auch in der Kleinserienfertigung reduziert den Werkzeugwechsel und erhöht die Wirtschaftlichkeit.

The use of a multiple workholding system is also beneficial in small batch machining.



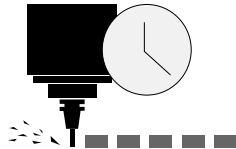
Mehrfachspannung auf spaceGRIP 1
Multiple workholding on spaceGRIP 1

WIE? HOW?



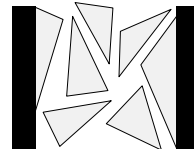
**3D-Modularität
für eine optimale
Raumnutzung**

*3D-Modularity for
an optimal use of
space*



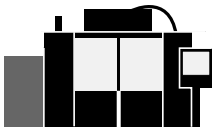
**Mehrfachspannung
für weniger
Maschinenstandzeit**

*Multiple workholding
for less machine down
time*



**Chaotisches Spannen für
das Erledigen von verschie-
denen Jobs gleichzeitig**

*Mixed clamping for the
manufacturing of different
jobs at the same time*



Grundvoraussetzung:
Zuverlässige Maschine mit
ausreichenden Werkzeug
und Paletten Plätzen und
eine geeignete Automati-
sierungsmethode

Basic requirement:
*Reliable machine with suf-
ficient tool an palett places
and a suitable automation
method*





***power*CLAMP & 5axes**





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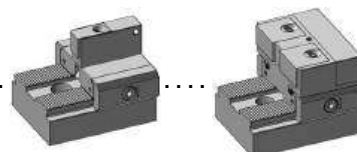
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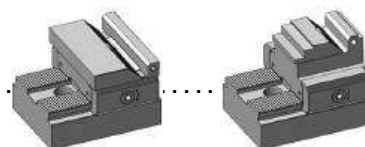
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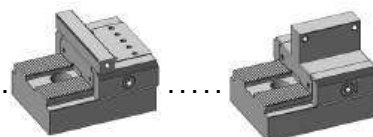
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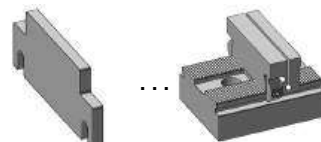
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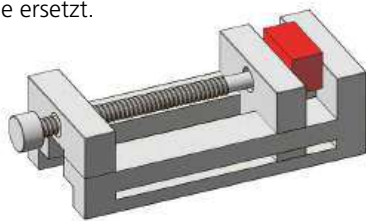


Warum modular Spannen Why modular workholding

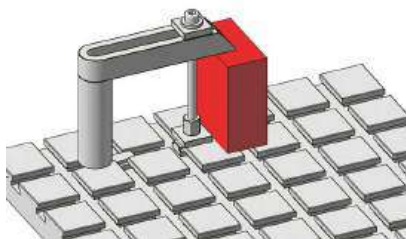
powerCLAMP

Der klassische Maschinenschraubstock ist für gewisse Zerspanungsarbeiten vielfach die richtige Wahl, obwohl man einen Spannstock ohne Mehrkosten auch mit einem Modularesystem aufbauen kann. Er wird durch die ständig erhöhten Anforderungen an die Prozessoptimierung immer mehr durch modulare Spannsysteme ersetzt.

The classic machine vise is for some application still a good option, on the other hand can you set up the same with a modular clamp system at not higher costs! Because of always increasing demand and high competition you see more modular systems at endusers places, to keep up with productivity.



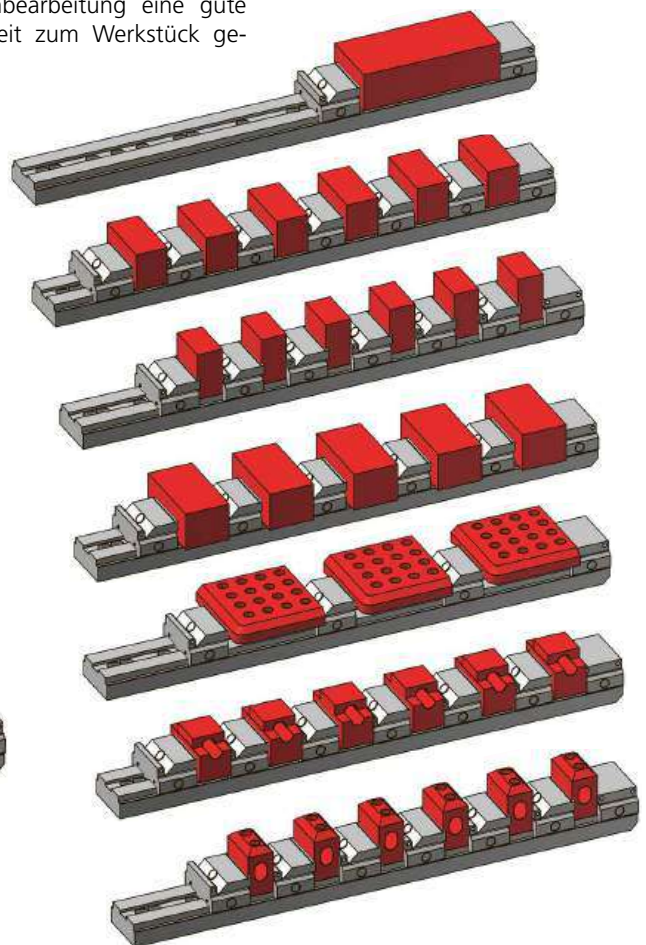
Spannen mit dem Spannstock
Clamping with the machine vise



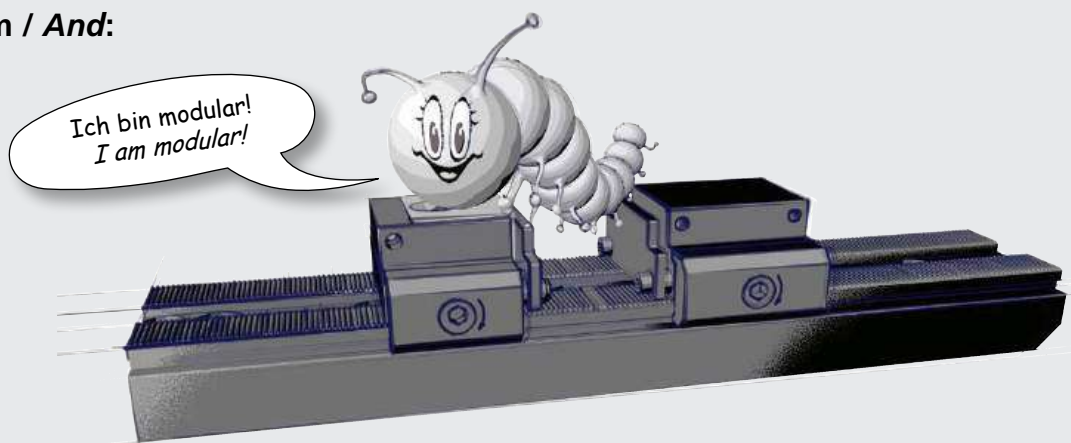
Spannen mit Spannpratzen
Clamps in operation

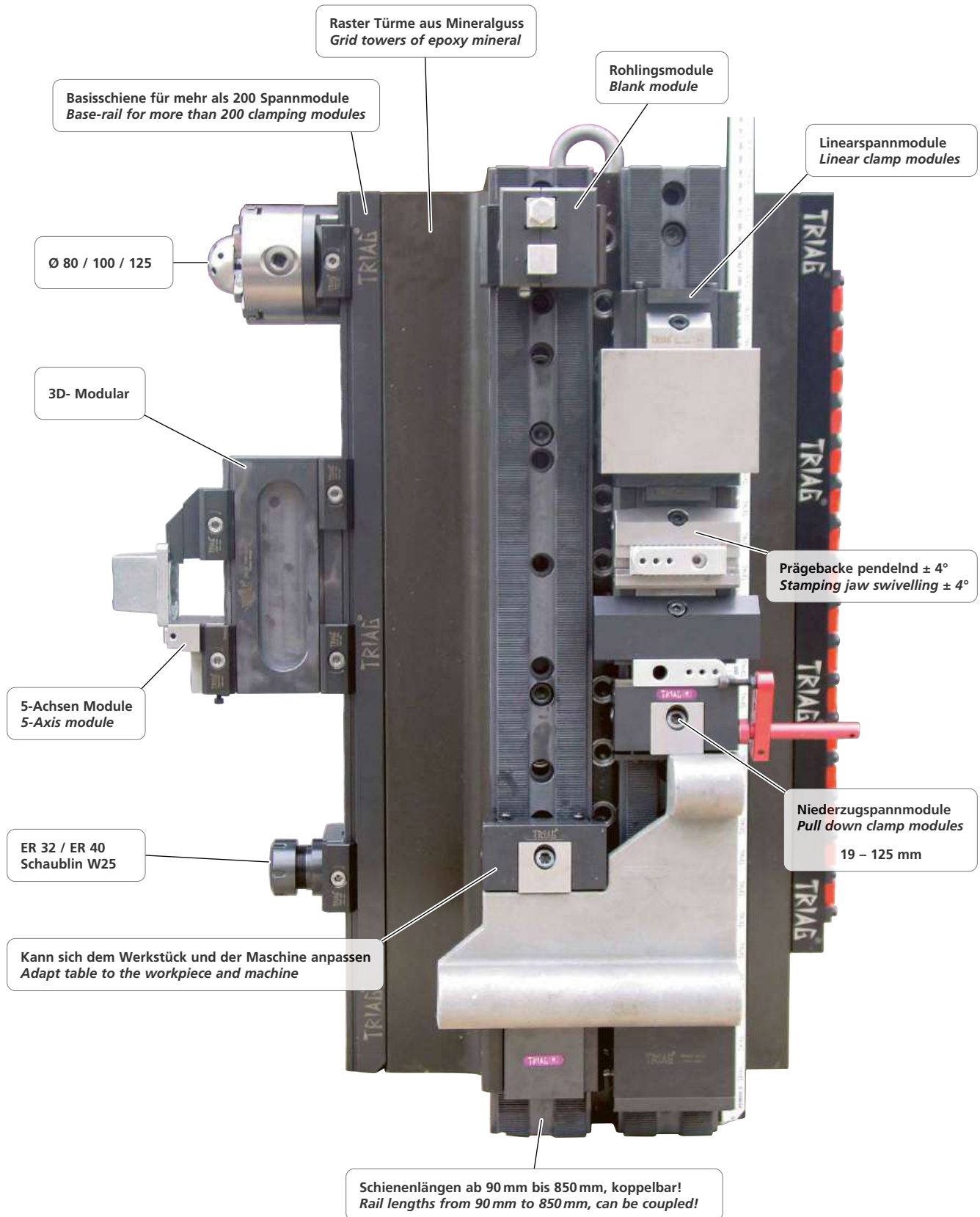
Mit den modularen Systemen wird ein hohes Mass an Flexibilität und grosser Spanndichte erreicht. Dies führt auch bei der Einzelteil- und Kleinserienfertigung zur Senkung der kostenintensiven Nebenzeiten, die einen wichtigen Faktor in der Wertschöpfungskette darstellen. Gegenüber Vorrichtungen ist der Vorteil, dass bei einem modularisiertem Aufbau die Aufspannung aus einem Baukastensystem (also standardisierten Einzelbauteilen) besteht, die kostengünstiger sind und für andere Aufspannungen wiederverwendet werden können. Zudem wird für die 3-Seitenbearbeitung eine gute Zugänglichkeit zum Werkstück gewährleistet.

With modular clamp system you achieve a high flexibility and also high density of holding workpieces. This brings you big advantages also by producing single parts or small quantities! Compared to dedicated fixtures you can use this vises for many different applications.



Ausserdem / And:





Modulares Spannen =

Einzelspannung, Mehrfachspannung sowie auch das Spannen von kleinen, grossen oder unförmigen Werkstücken.
Chaotisches, gemischtes spannen!

Modular workholding =

Single clamping, multiple clamping small parts and large workpieces can be clamped, also shaped parts are possible to clamp.
Mixed setups in chaotical clamp situation!

Mit dem Spannsystem Power Clamp hat die Triag International ein Produkt entwickelt, welches die Vorteile des klassischen Maschinenschraubstocks mit der Modularität eines innovativen Spannsystems in einer optimalen Art und Weise kombiniert und eine enorme Vielseitigkeit bietet. Einfache Spannungen sind genauso möglich wie Mehrfachspannungen und Spannungen von schwierigen Werkstücken.

With Power Clamp Triag has developed a product which includes the advantages of a classical vise and has the features of an advanced modular system. It can be used to clamp single parts (small and big) or multiple workholding as well as difficult to clamp parts.

Schnelligkeit / Quickness



1

Eine Schraube lösen
Loosen a screw



2

Abheben und neu platzieren
lift and change position



3

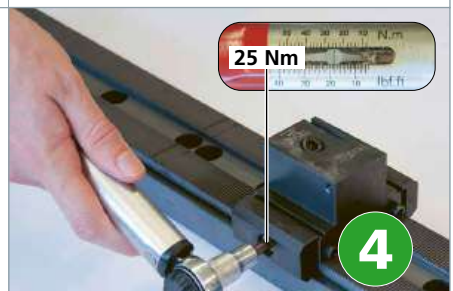
Eine Schraube anziehen
fasten one screw

Mit nur einer Schraubspindel, welche von beiden Seiten her zugänglich ist, werden die positionierten Module in einem patentierten Patzensystem zuverlässig geklemmt.

Die Module können an jeder Stelle der Trägerschienen aufgesetzt werden. Verglichen mit dem üblichen axialen Aufchieben beschleunigt das den Aufbau von Mehrfachspannern und ermöglicht, diese Spannsysteme auch bei beengten Platzverhältnissen komfortabel zu rüsten.

With only one bolt screw (left and right hand thread) the clamp modules can be lifted and change position in 2mm steps.

This patented system is unique and fast, as well as accurate.



4

Drehmoment beachten
Observe the torque

Geringes Gewicht Low weight



= Einfaches Handling
= Easy handling

Das Modul kann mit zwei Fingern abgehoben werden.

The clamp module can be moved by two fingers.



Einfache Reinigung Easy cleaning



Keine spänefüllenden T-Nuten (im Gegensatz zu vielen Wettbewerbsprodukten) - Basis bilden stabile, mit Teilstücken verlängerbare Trägerschienen. Sie verfügen über eine hochgenau gefräste Verzahnung.

Eine Vielzahl an Spannmodulen mit unterschiedlichen Spannelementen lassen sich auf den Trägerschienen in einem Raster von 2 mm positionieren.

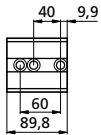
No chip catching T-slots (opposite of many competitors). The base rails are rigid and can be used modular in length width and height. The serration is accurate and checked for each base rail.

Many different clamp modules can be used on only one type base rail (step 2 mm)

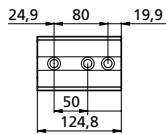
Basisschienen / Base rails

Masssystem / Measurement system = metric & inch **powerCLAMP**

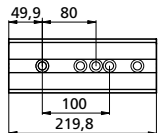
90 mm



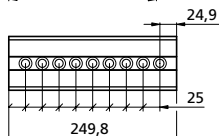
125 mm



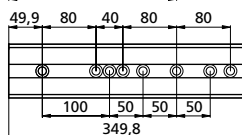
220 mm



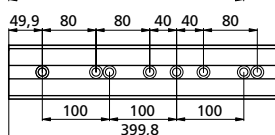
250 mm



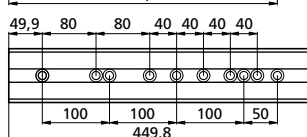
350 mm



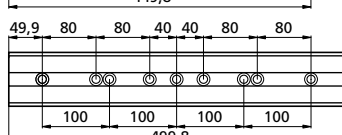
400 mm



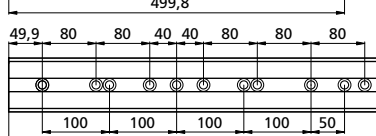
450 mm



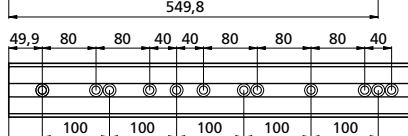
500 mm



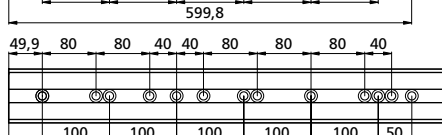
550 mm



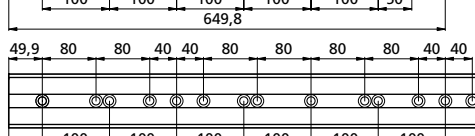
600 mm



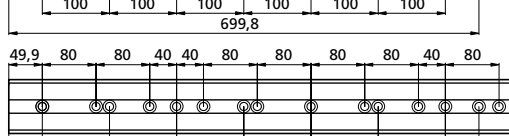
650 mm



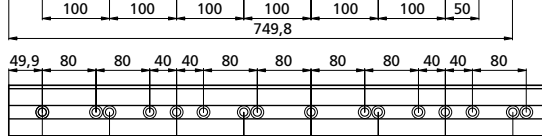
700 mm



750 mm

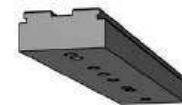


800 mm



Schienen sind in den folgenden Höhen lieferbar:

Rails are in following ups available:



➔ 35 mm



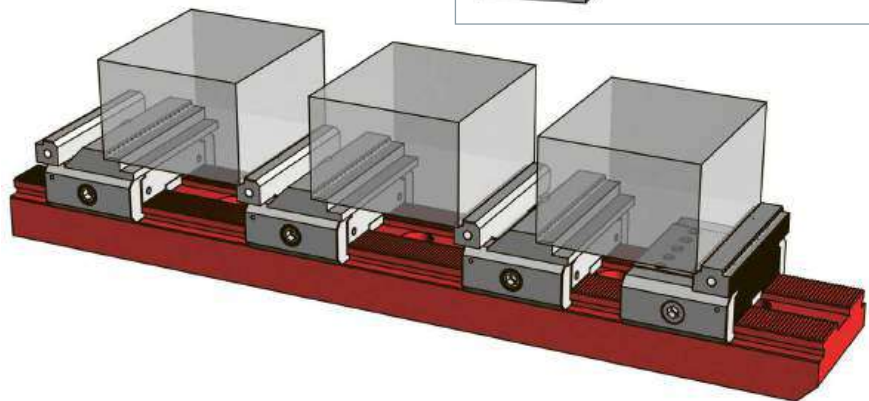
➔ 60 mm



➔ 80 mm



➔ 175 mm



Basisschiene

Die Basisschiene ist das Grundelement des modularen Spannsystems von Triag International und ist in den Höhen 35 mm, 60 mm, 80 mm und 175 mm verfügbar. Auf der Basisschiene werden alle Spann- und Anschlagmodule über eine Schraubspindel mit einer Haltekraft von 15.000 daN (= 15 t) befestigt. Eine schnelle und genaue Positionierung ist durch die Verzahnung (2 mm Teilung) auf der Basisschiene gewährleistet und sorgt somit für kurze Rüstzeiten.

Durch den Einsatz von Erhöhungsmodulen wird die Werkstück-Zugänglichkeit speziell bei 5-Achsenmaschinen auch mit kurzen Werkzeugaufnahmen ermöglicht. Somit ist die Maximalgröße der Werkstücke nur noch durch die Maschinengröße eingeschränkt. Die Basisschiene dient in diesem Zusammenhang als mechanisches Nullpunktsystem.

Die Basisschienen sind für eine schnelle Aufspannung auf den gängigsten Palettensystemen konzipiert. Aus Gewichtsgründen können auch die eigens entwickelten Spanntürme aus Mineralguss eingesetzt werden. Diese verfügen über eine so hohe Vibrationsdämpfung, dass dadurch im oberen Bereich der Türme sehr präzise gearbeitet und dabei eine exzellente Oberflächengüte erreicht werden kann.

Basisschienen / Base rails

Masssystem / Measurement system = metric & inch powerCLAMP



Mit verschiedenen Basismodulen kann man auch die 3. Dimension Modular gestalten! Mit der Höhe von 60 mm kann die Modulhöhe auf 94 respektive auf 109 mm erhöht werden (34/49 Modulhöhe). Die Länge von 130 mm erlaubt es jeweils ein Spannmodul und ein Anschlagmodul zu platzieren.

There are different sizes of riser blocks to increase the height of the clamp modules. This way you can get from 34 to a clamp height of 94 or 109 mm depending on the clamp module you choose. This riser blocks makes the power clamp system 3D-modular!

Mehr auf Seite | More on Page 48

Base rail

The base rail is the basic element of the Triag modular clamp system. We offer them in different lengths and heights and more than a hundred different standard clamp modules will fit onto the base rails.

Holding force which the clamp modules are clamped to the base rail is 15'000 daN (15t). The precision serration in 2mm pitch allows to fit the clamps fast and accurate.

All three dimension are modular!
You can double or triple the length with coupling the rails or you can use them side words in a row. Also the height is modular (please see next page)



Basisschienen in Zoll
Base rails in inch



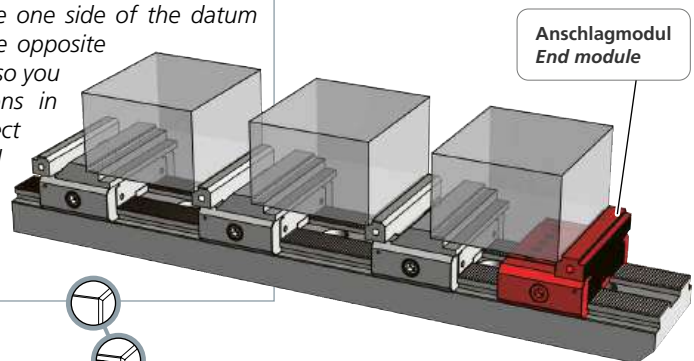
Das Anschlagmodul / End modules

Für das Spannsystem «Power Clamp» ist in der Regel nur ein Anschlagmodul als «feste Backe» notwendig. Mittels der 2 mm Verzahnung lässt sich das Modul sehr genau auf der Basisschiene positionieren und ist mit der Schraubspindel schnell befestigt.

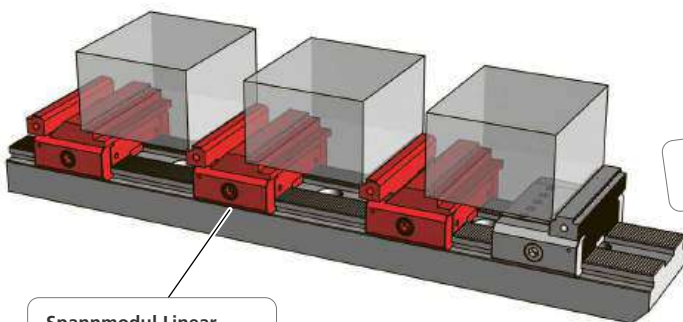
Für die unterschiedlichen Bearbeitungssituationen steht eine Vielzahl von Ausführungen zur Verfügung. Diese unterscheiden sich in der Breite der Backen (ab 19 mm bis max. 150 mm) als auch in der Beschaffenheit der Spannflächen (glatt, geriffelt, gerillt, hartmetallbeschichtet oder mit Prägeverzahnung, mit der direkt geprägt werden kann).

In a row of parts there is usually one end module followed by the clamp modules. For all the different clamp situation we offer a wide range of different end modules from 19 mm to 150 mm.

Usually you have one side of the datum face flat and the opposite double serrated so you have two options in one. Also direct stamping end modules with a workholding step of 3 mm are available.



Anschlagmodul
End module



Spannmodul Linear
Linear clamping module

Verschiedene Ausführungen der Anschlagflächen!
Different styles at grip surfaces!



Lineare Direktprägespannung
Linear direct stamping module

Das Spannmodul / Clamp modules

Die «beweglichen Backen» gibt es in zwei Ausführungen. Zum einen für das Niederzugspannsystem und zum anderen für das Linearspannsystem. Dabei dient das Spannmodul bei beiden Systemen wiederum als Anschlagmodul für die nächste Aufspannung.

Die Breite der Spannfläche bewegt sich wie bei den Anschlagmodulen im Bereich zwischen 19 mm und 125 mm. Durch die innovativen Ausführungen der Spannflächen wie z. B. die Prägebacken oder Druckstifte werden enorme Haltekräfte erreicht.

Bei umfangreichen Testreihen zu der Werkstückverschiebung bei einer Spannkraft von 2000 daN und einer Zerspankraft von bis zu 600 daN wurden bei der Verwendung von Prägebacken nur minimale Abweichungen vom Nullpunkt festgestellt. Leichte Abweichungen von der Parallelität der Werkstücke werden mit der Pendelfunktion ($\pm 4^\circ$) ausgeglichen.

Innovative Lösungen gibt es auch für spezielle Spannaufgaben, wie z.B. Formbacken, Dreibacken- und Spannzangenfutter, Vakuumplatten oder Magnetspannplatten.

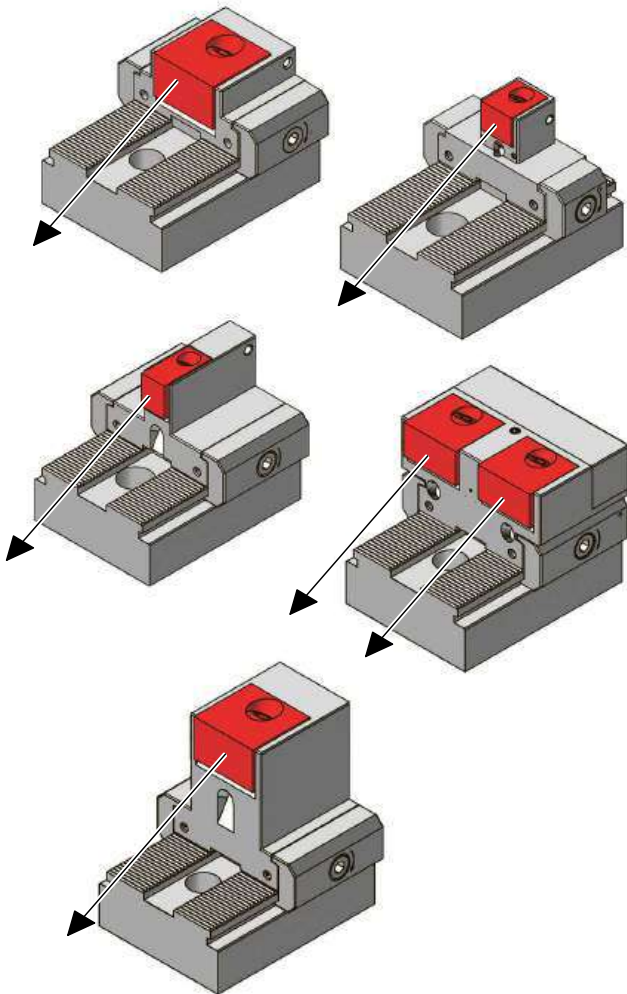
There are mainly two different types of clamp modules. Linear and pull down jaws both with integrated datum face for the next workpiece. Datum face can normally be double serrated or flat.

The movable jaws you can get in various versions such as hardened flat, carbide coated soft jaws double serrated, linear pull down, direct stamping dovating and more. The width of the clamps modules starts from 19 mm up to 125 mm.

Clamping force goes to a maximum of 2800 daN (2,8t).

For special clamping situations we offer also chucks, collet chucks vacuum plates or even magnet plates which fits onto the Power Clamp base rails.

Niederzugspannmodule
Pull down clamp modules



Die Fakten beim Niederzugspannsystem

Verstellbereich: 0- 4,1 mm
 Spannkraft: Bis 2'800 daN

Vorteile beim Niederzugspannsystem:

- Höhere Haltekräfte
- Hohe Wiederholgenauigkeit
- Optimale Spannmethode für Kleinteile
- Mit Schnellwechselbacken
- Doppelspannsystem in einer Backe zum Spannen und Bearbeiten von zwei Kleinteilen
- Mit Vorsatz als Linearspannsystem einsetzbar
- Auch Anschläge mit Niederzugeffekt erhältlich

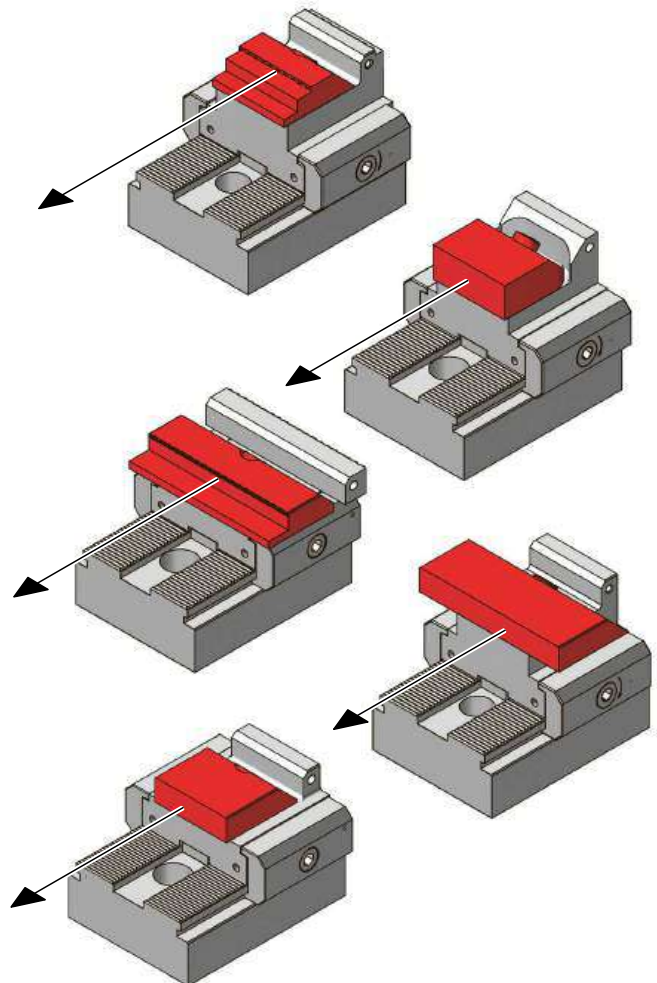
Facts for pull down clamp modules

Jaw range: 0- 4,1 mm
 Clamping force: up to 2'800 daN

Advantages pull down jaws:

- Higher holding force
- With linear adaptable jaws
- Also with pull down jaws for the stop side available
- With adapter set can be changed to linear
- Also pull down jaws for datum face

Linearspannmodule
Linear clamp modules



Die Fakten beim Linearspannsystem

Verstellbereich: 0- 5,0 mm
 Spannkraft: Bis 1'600 daN

Vorteile beim Linearspannsystem:

- Spannstockähnliches Spannen
- Prozesssichere Positionierung der zweiten Aufspannung
- Gut geeignet für die Erstellung von individuellen Formbacken
- Sicherer Halt mit Prägetechnik

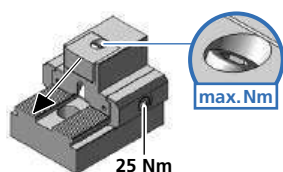
Facts for linear clamp modules

Jaw range: 0- 5,0 mm
 Clamping force: up to 1'600 daN

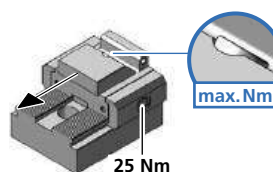
Advantages linear jaws:

- Similar clamp as conventional vise
- Good for shaped jaws
- Secure clamped with direct stamping jaws
- Higher accuracy

ACHTUNG / CAUTION



Niederzug Spannmodule
Pull adown module



Linear Spannmodule
Linear module

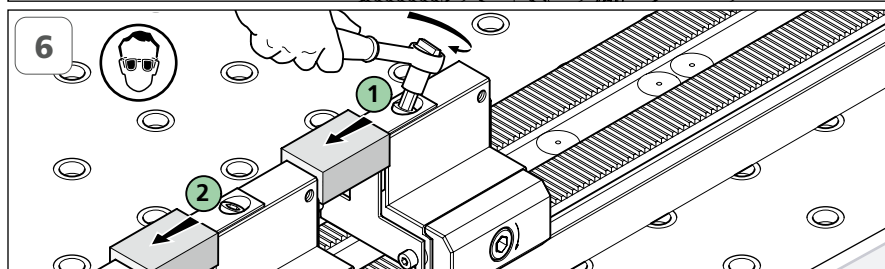
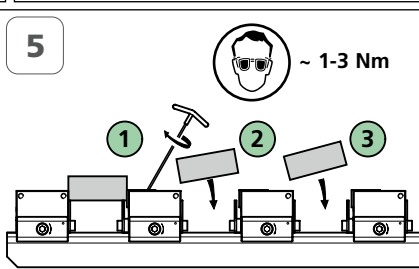
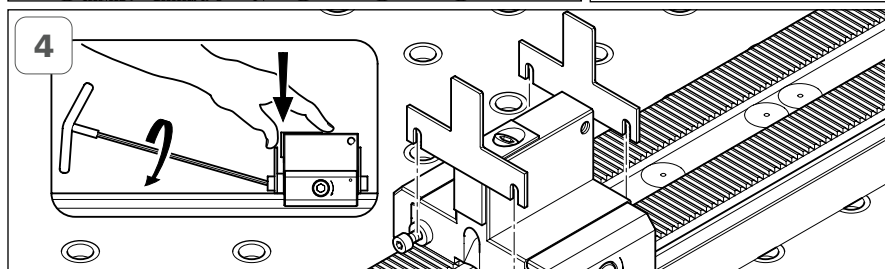
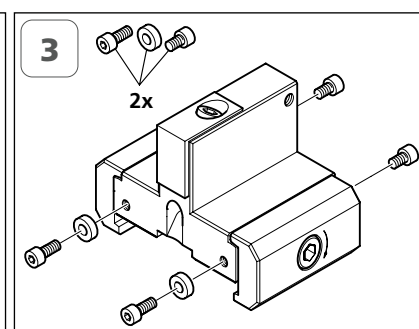
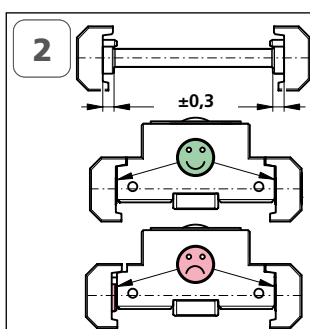
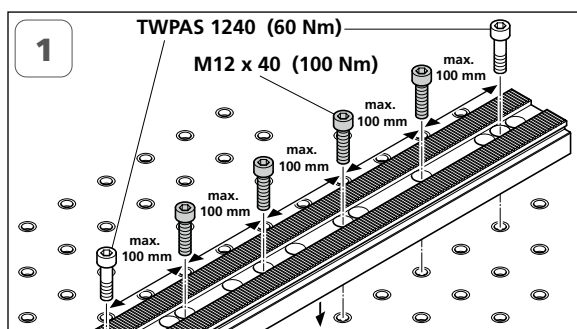


Schraube / Screw	Drehmoment / Torque		Spannkraft / Workholding force		
	Nm	(lb-ft)	~daN	~(lb)	~t
M5 + M6	4	3	= 500	1100	0,50
	5	3,7	= 580	1280	0,58
	6	4,4	= 690	1520	0,69
	7	5,2	= 780	1720	0,78
	8	5,9	= 880	1940	0,88
	9	6,6	= 980	2160	0,98
M6	10	7,4	= 1020	2250	1,02
	12	8,9	= 1220	2690	1,22
	14	10,4	= 1450	3200	1,45
M8	15	11	= 1520	3350	1,52
	4	3	= 410	900	0,41
	5	3,7	= 490	1080	0,49
	6	4,4	= 560	1230	0,56
	7	5,2	= 660	1450	0,66
	8	5,9	= 730	1600	0,73
	9	6,6	= 810	1790	0,81
	10	7,4	= 900	1980	0,90
	15	11	= 1520	3350	1,52
	20	14,8	= 1810	3990	1,81
M10	25	18,4	= 2100	4630	2,10
	10	7,4	= 400	880	0,40
	20	14,8	= 1400	3090	1,40
	30	22,1	= 2000	4410	2,00
	40	29,5	= 2800	6170	2,80

Schraube Screw	Drehmoment Torque		Spannkraft Workholding force		
	Nm	(lb-ft)	~daN	~(lb)	~t
M8	10	7,4	= 400	880	0,4
	20	14,8	= 800	1760	0,8
	30	22,2	= 1200	2650	1,2
	40	29,6	= 1600	3530	1,6

WICHTIG: Die angegebenen Drehmomente sind die absoluten Maximalwerte. Über die Spannkräfte geben die Tabellen Auskunft.

IMPORTANT: The torque numbers specified represent the absolute maximum. The table at the bottom of this page provides further information on the workholding forces.



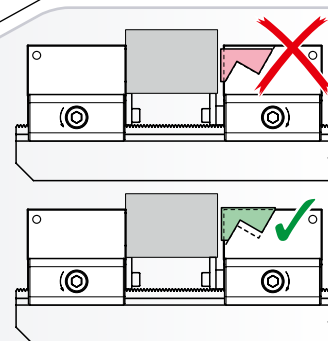
7

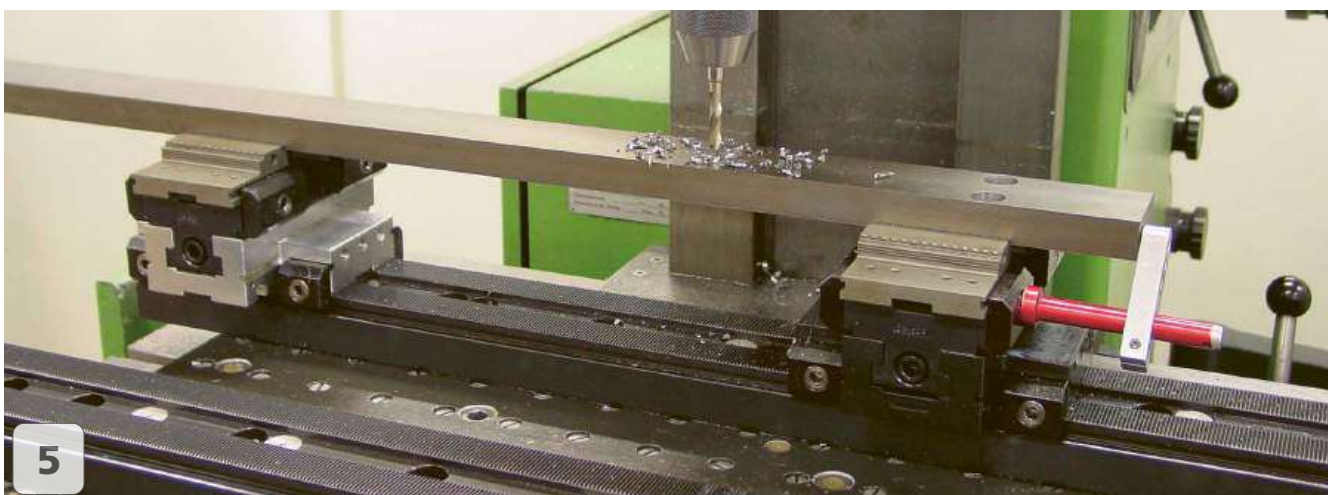
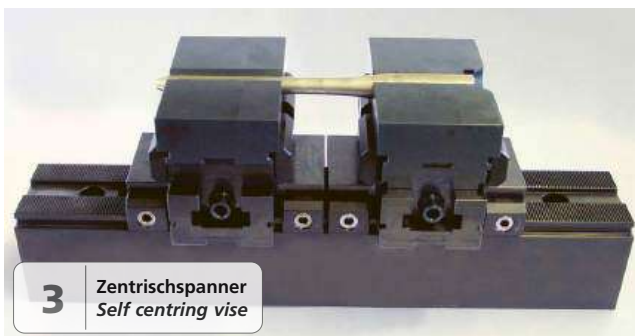
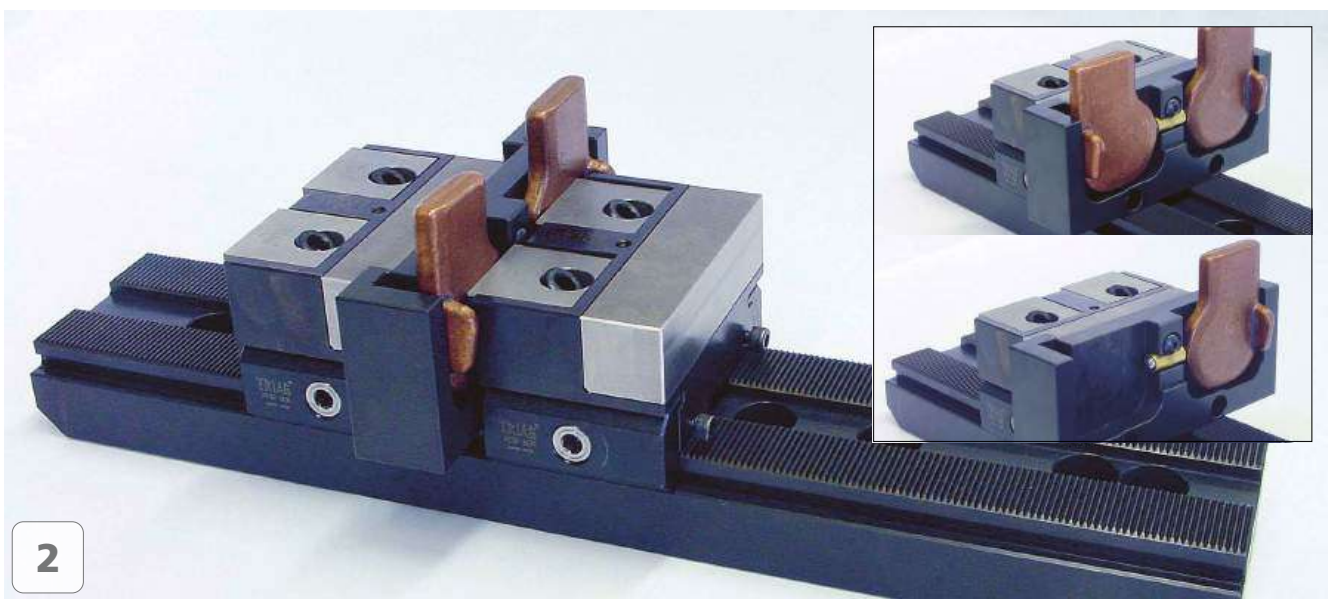
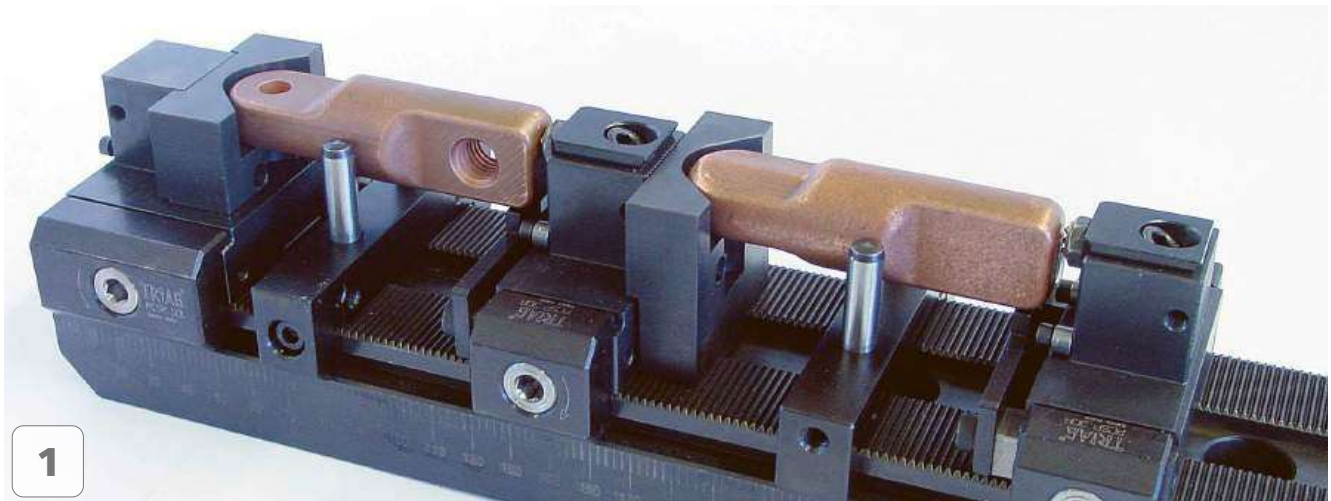
WICHTIG:

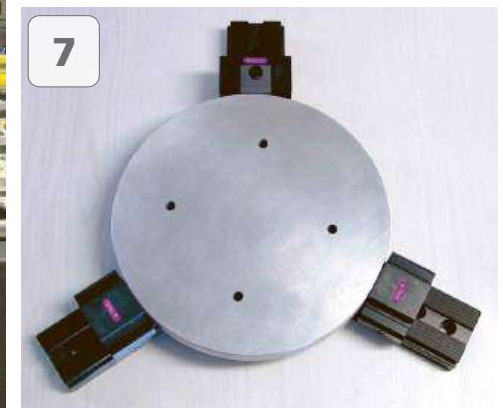
Vor dem Positionieren der Spannmodule für ein neues Werkstück, ist die **Spannbacke ganz zurück zu stellen**, dies gewährleistet eine sichere Spannung!

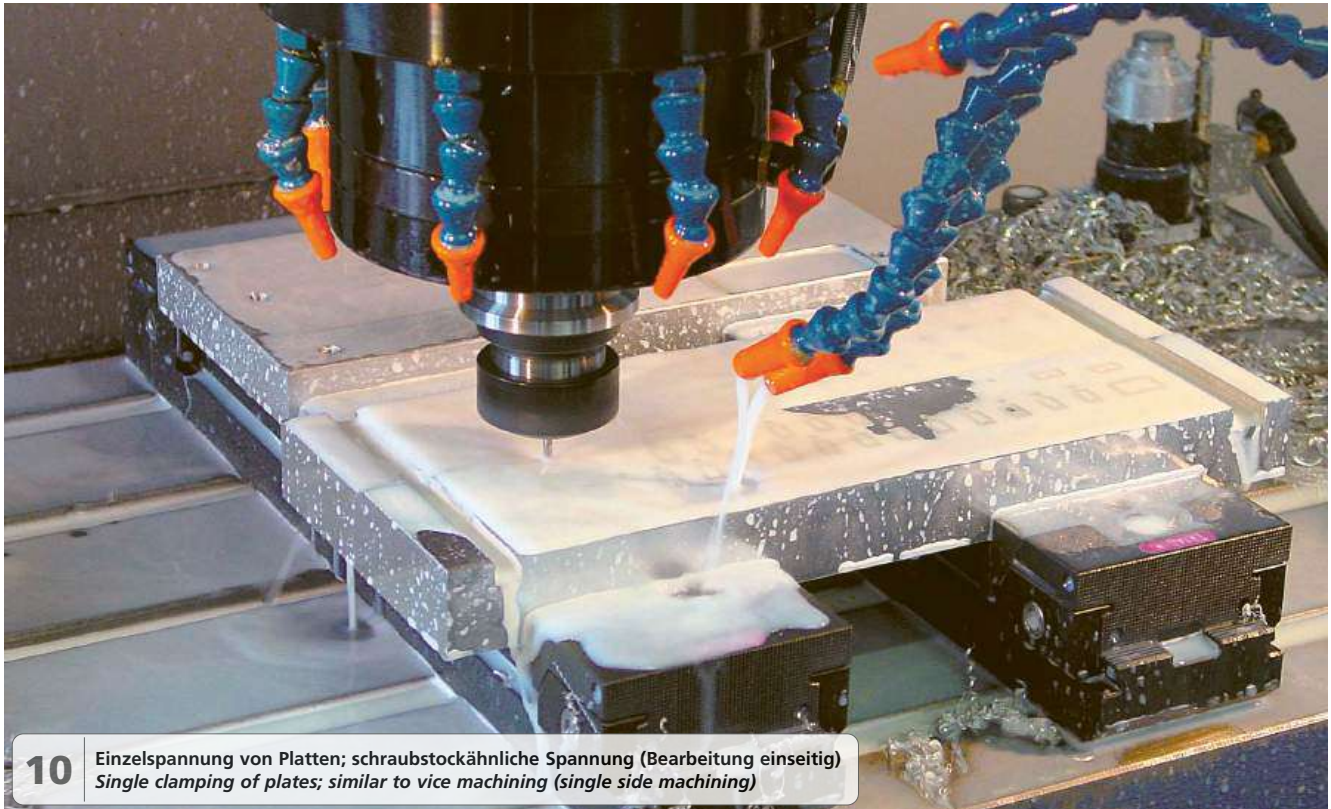
IMPORTANT:

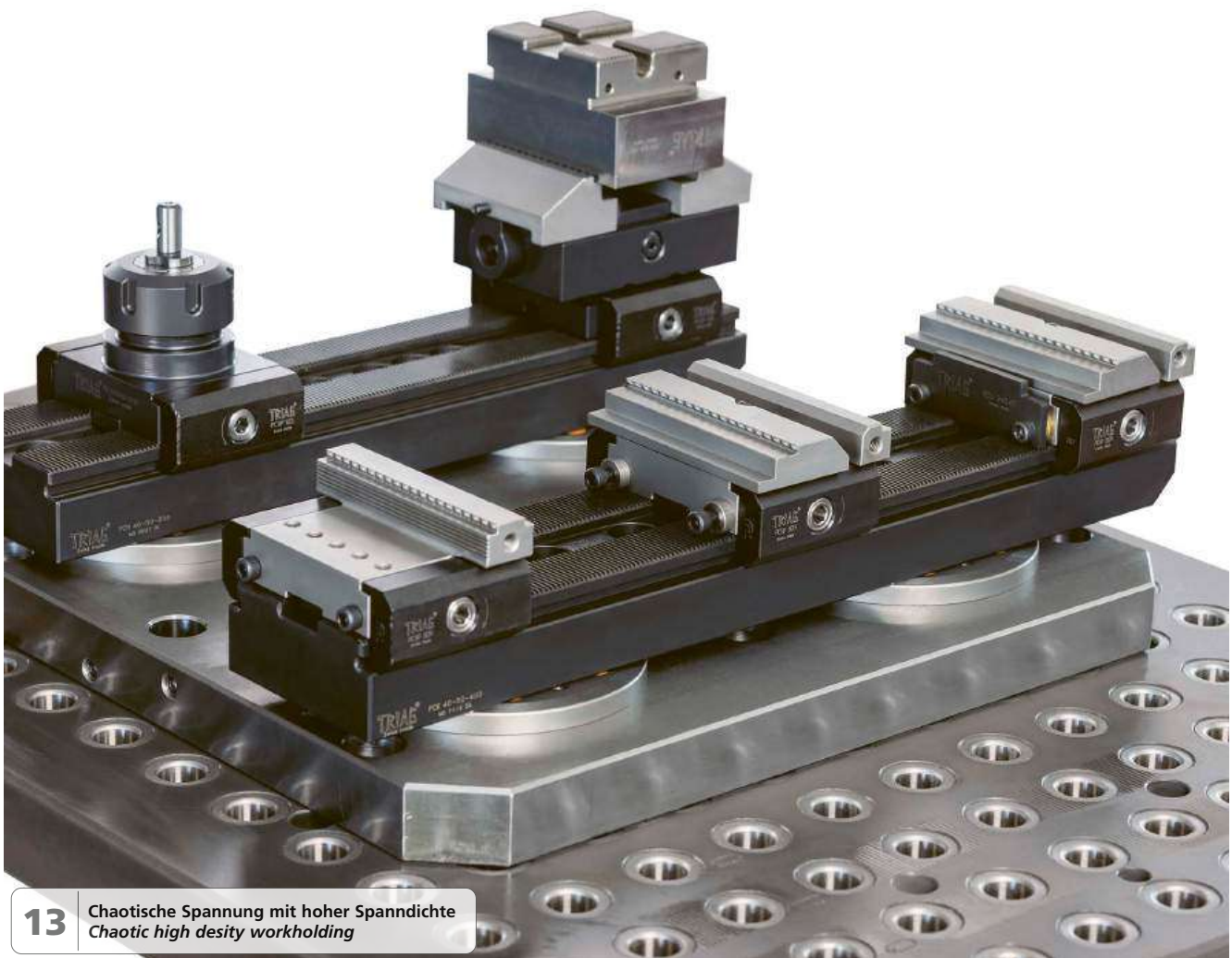
Prior to setting up a new clamping module the **clamping jaw of the vice module must be retracted all the way!** This guarantees proper clamping of the new workpiece.



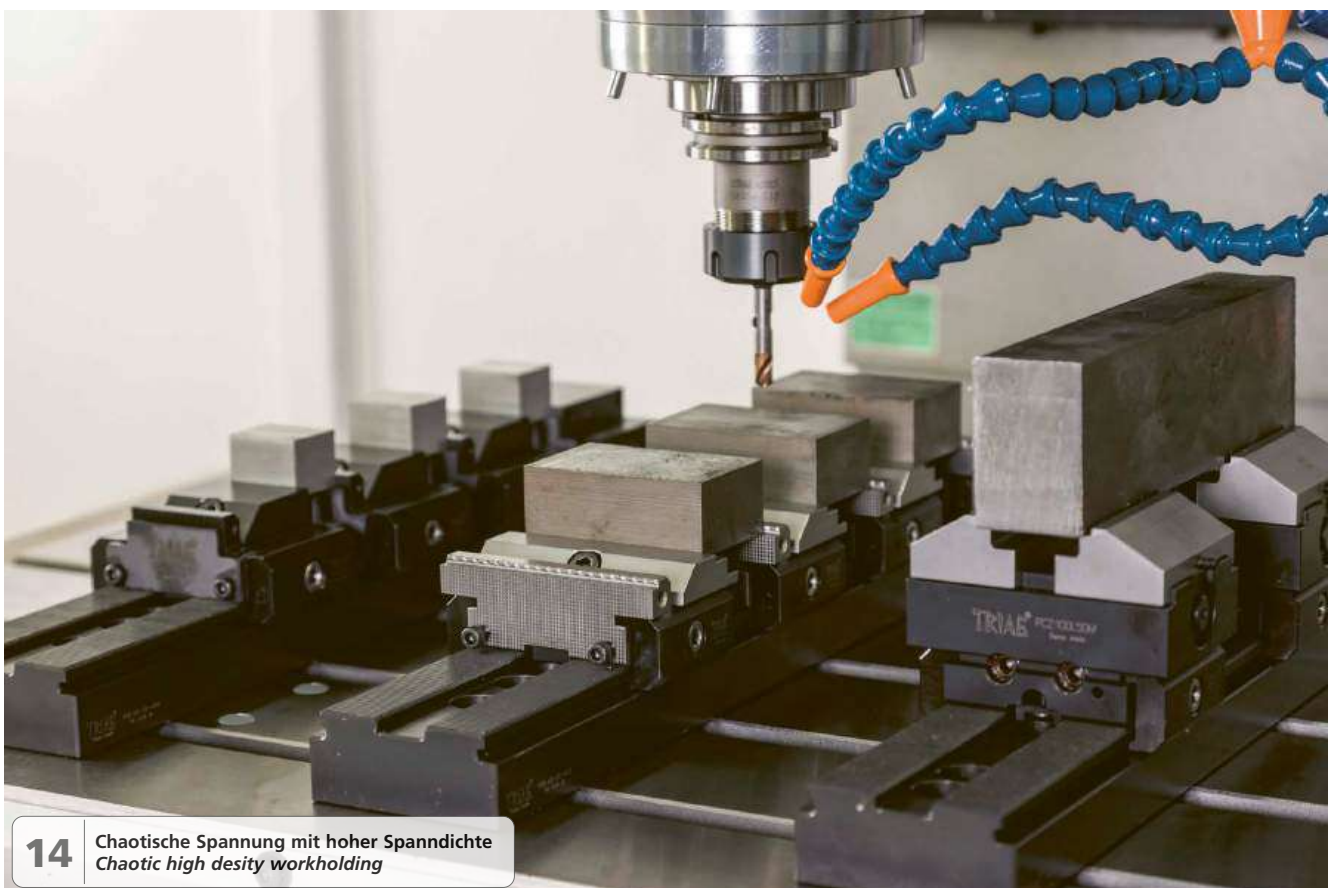




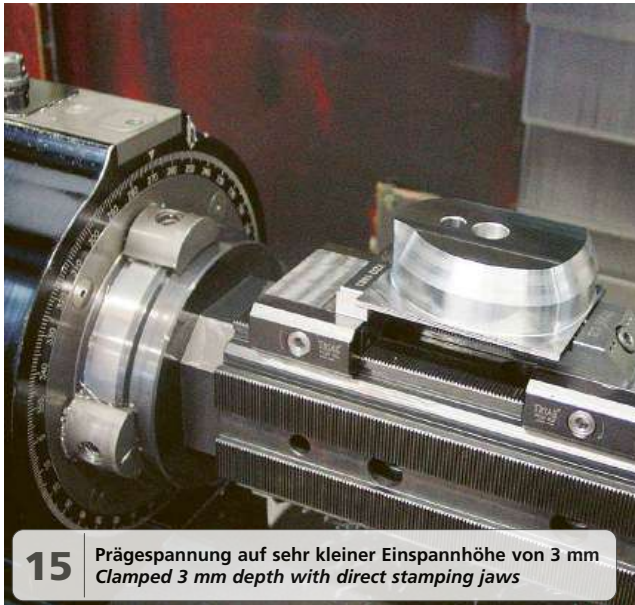




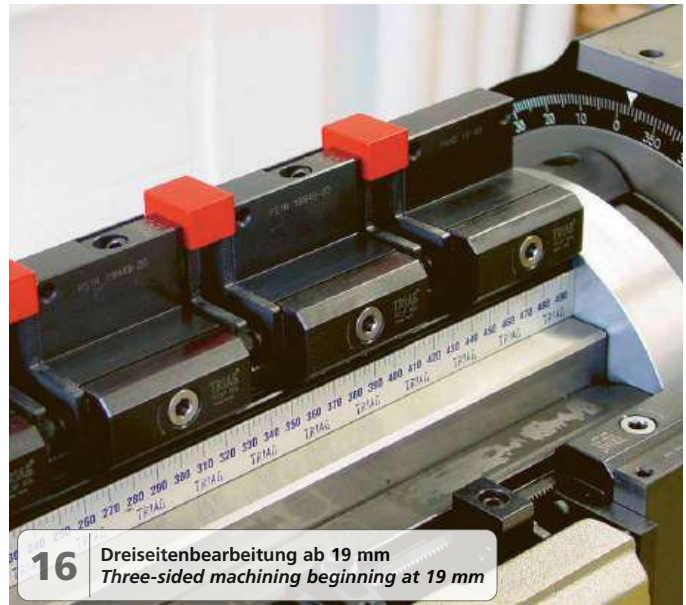
13 Chaotische Spannung mit hoher Spanndichte
Chaotic high density workholding



14 Chaotische Spannung mit hoher Spanndichte
Chaotic high density workholding



15 Prägespannung auf sehr kleiner Einspannhöhe von 3 mm
Clamped 3 mm depth with direct stamping jaws



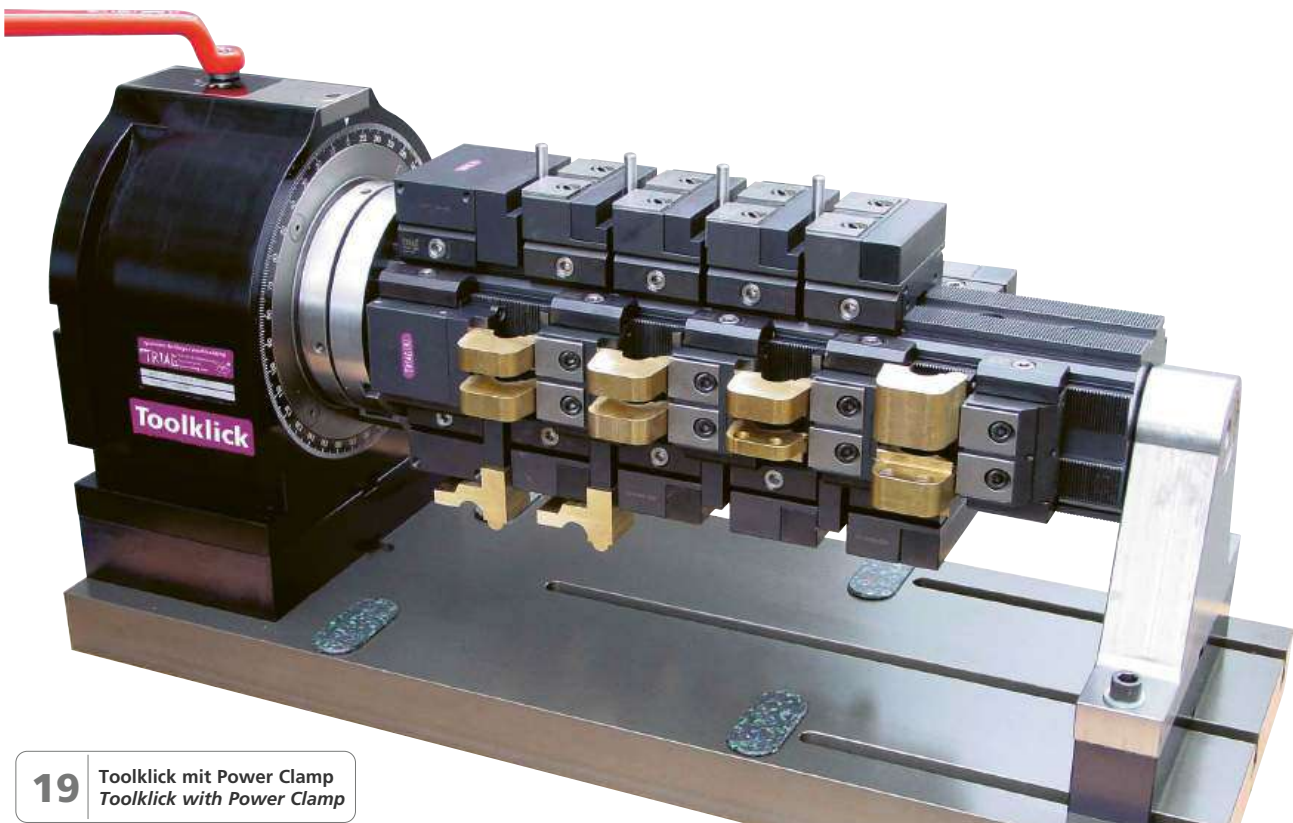
16 Dreiseitenbearbeitung ab 19 mm
Three-sided machining beginning at 19 mm



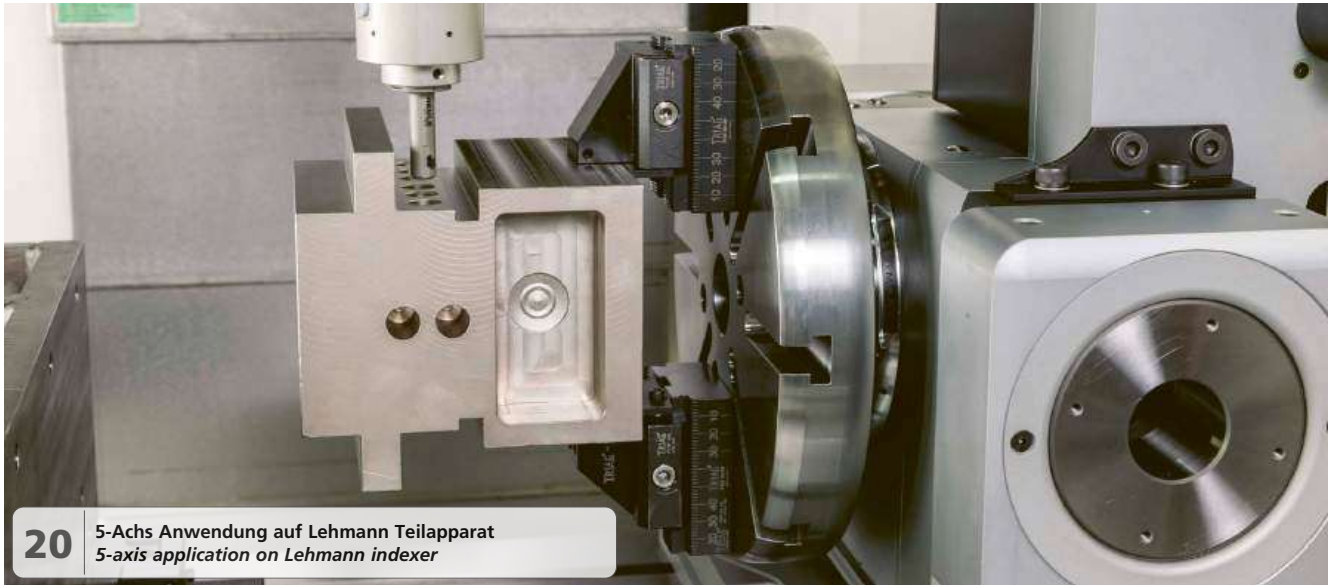
17 ... im Einsatz auf der 4. Achse
... in action on the 4th axis



18 Das Triag Power Clamp im Einsatz als Spannstock (Starterset)
Triag Power Clamp in action as machine vise (starter set)

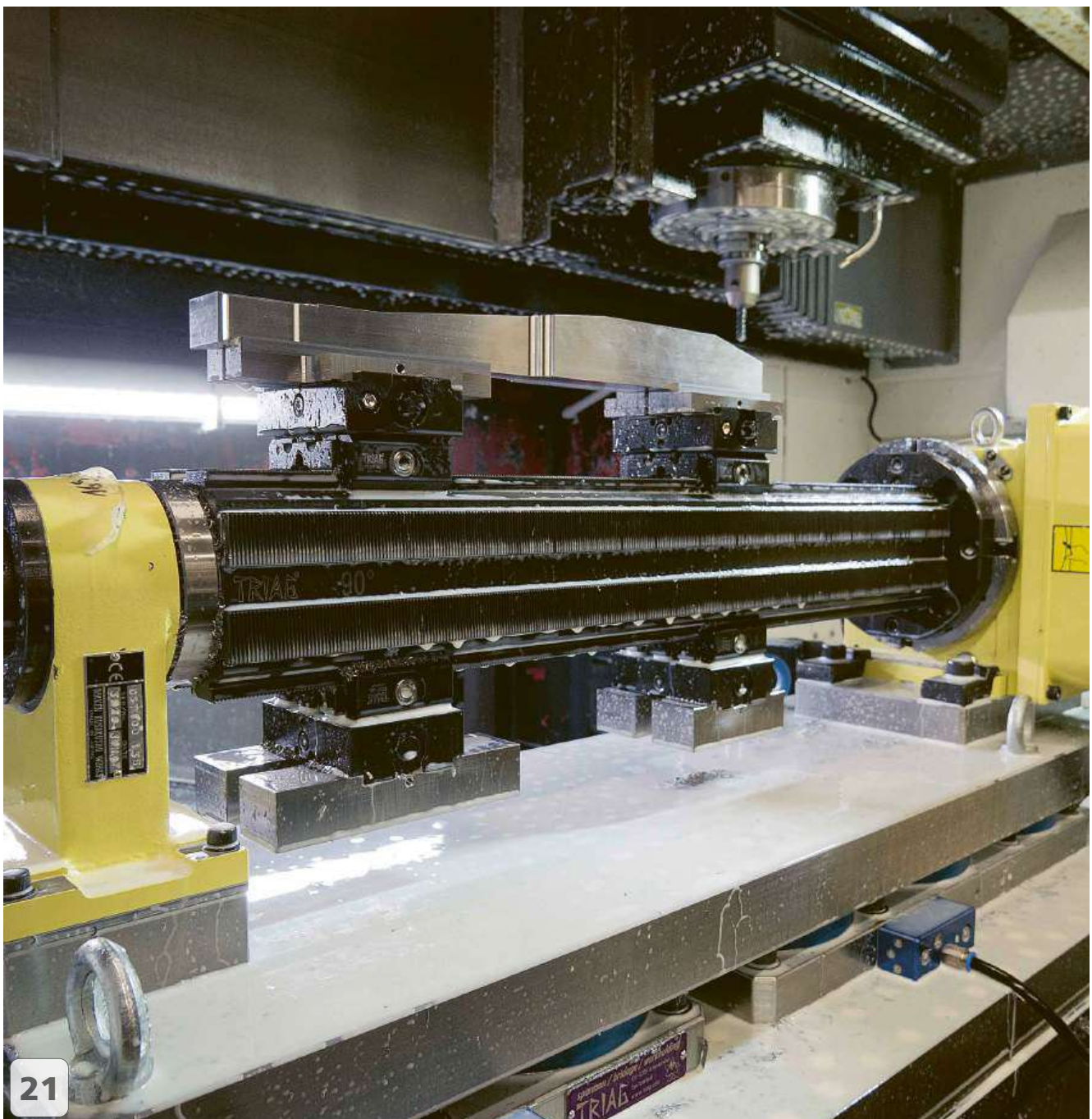


19 Toolclick mit Power Clamp
Toolclick with Power Clamp

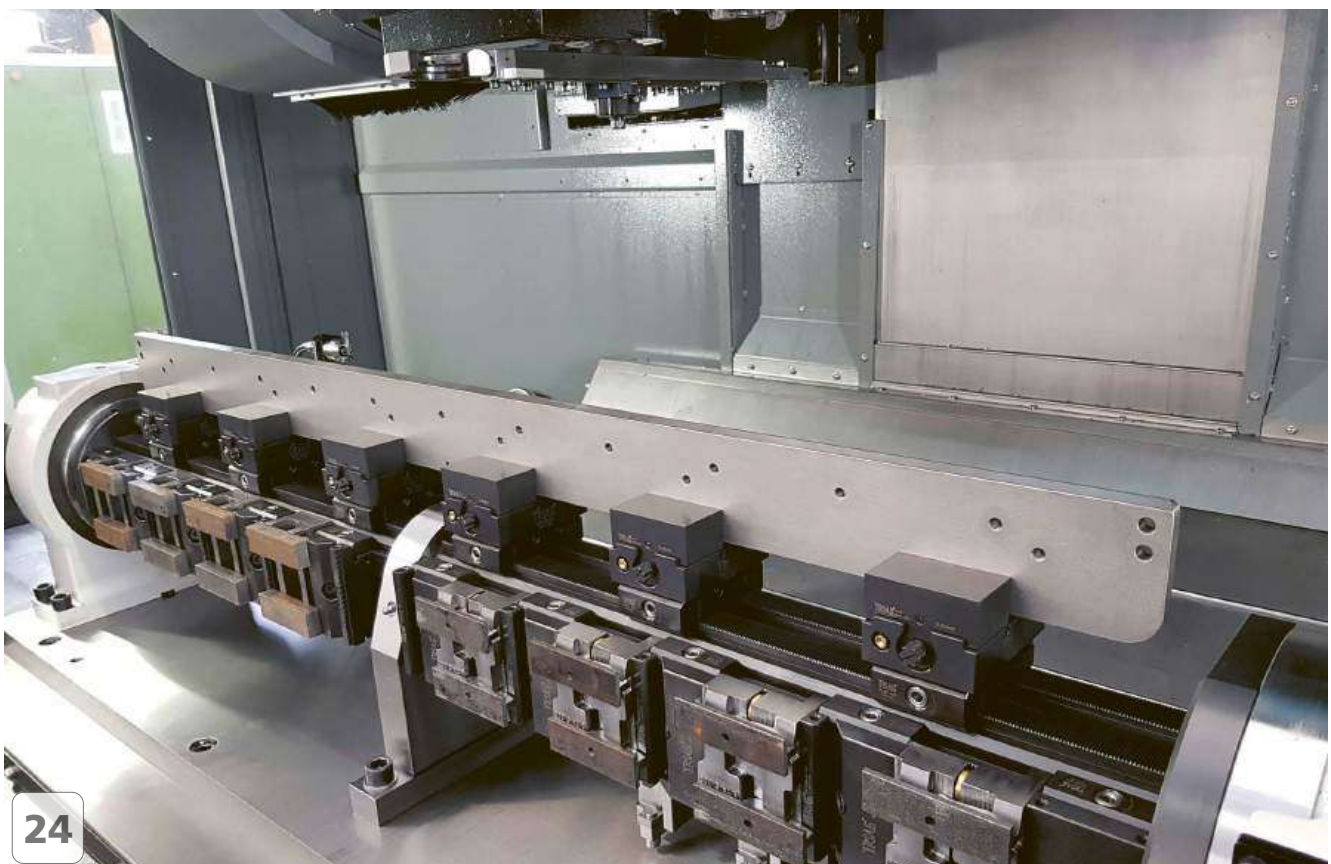
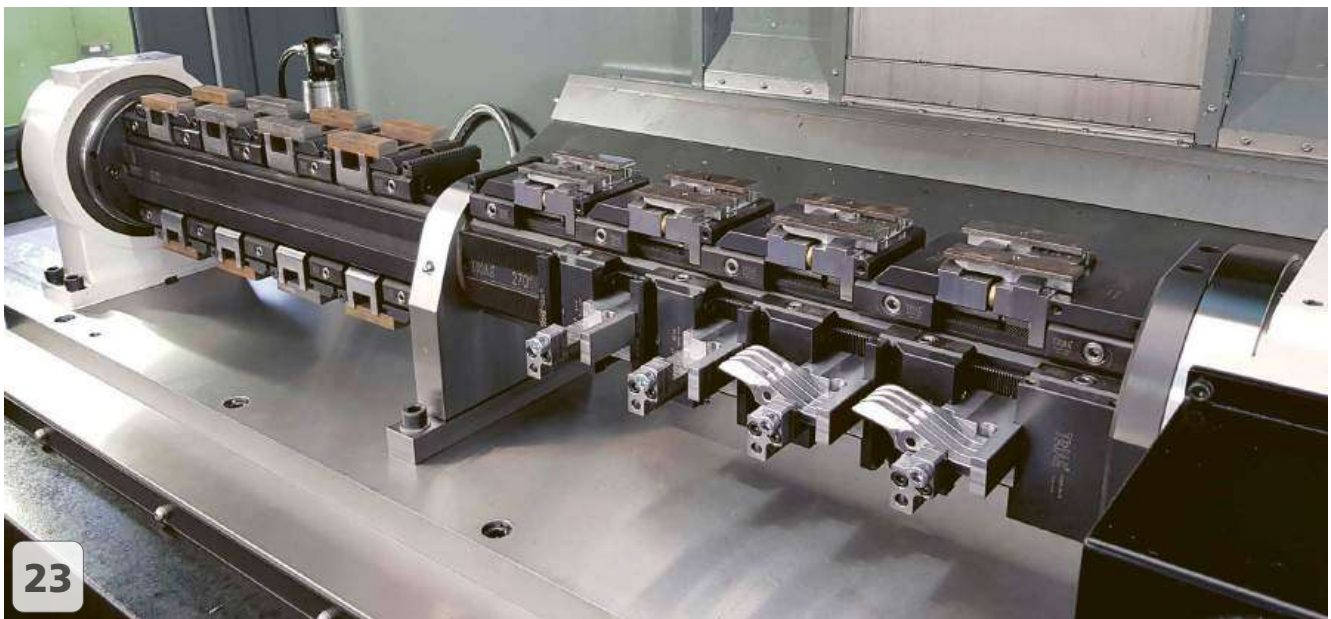
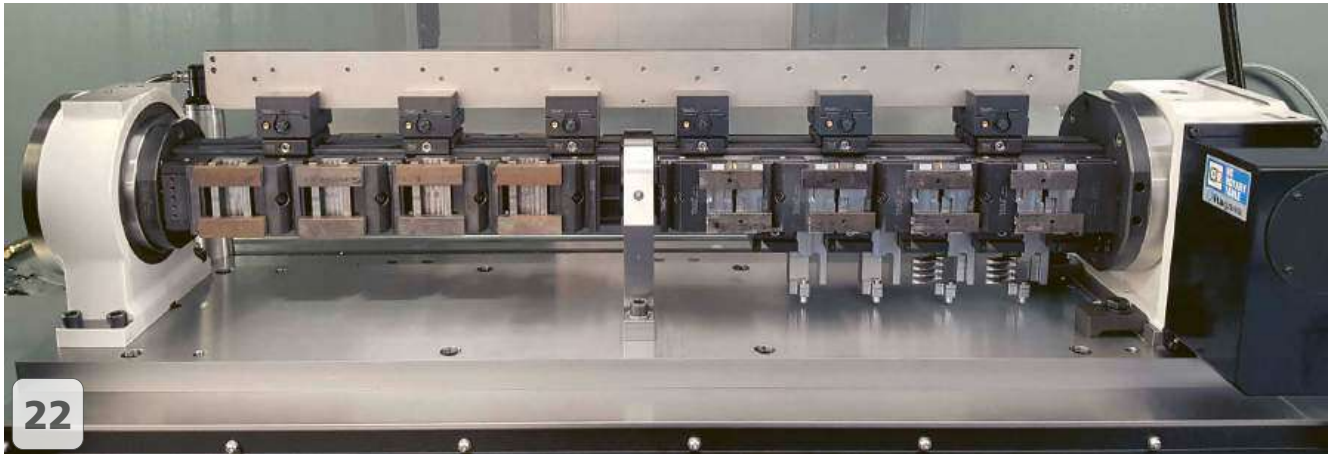


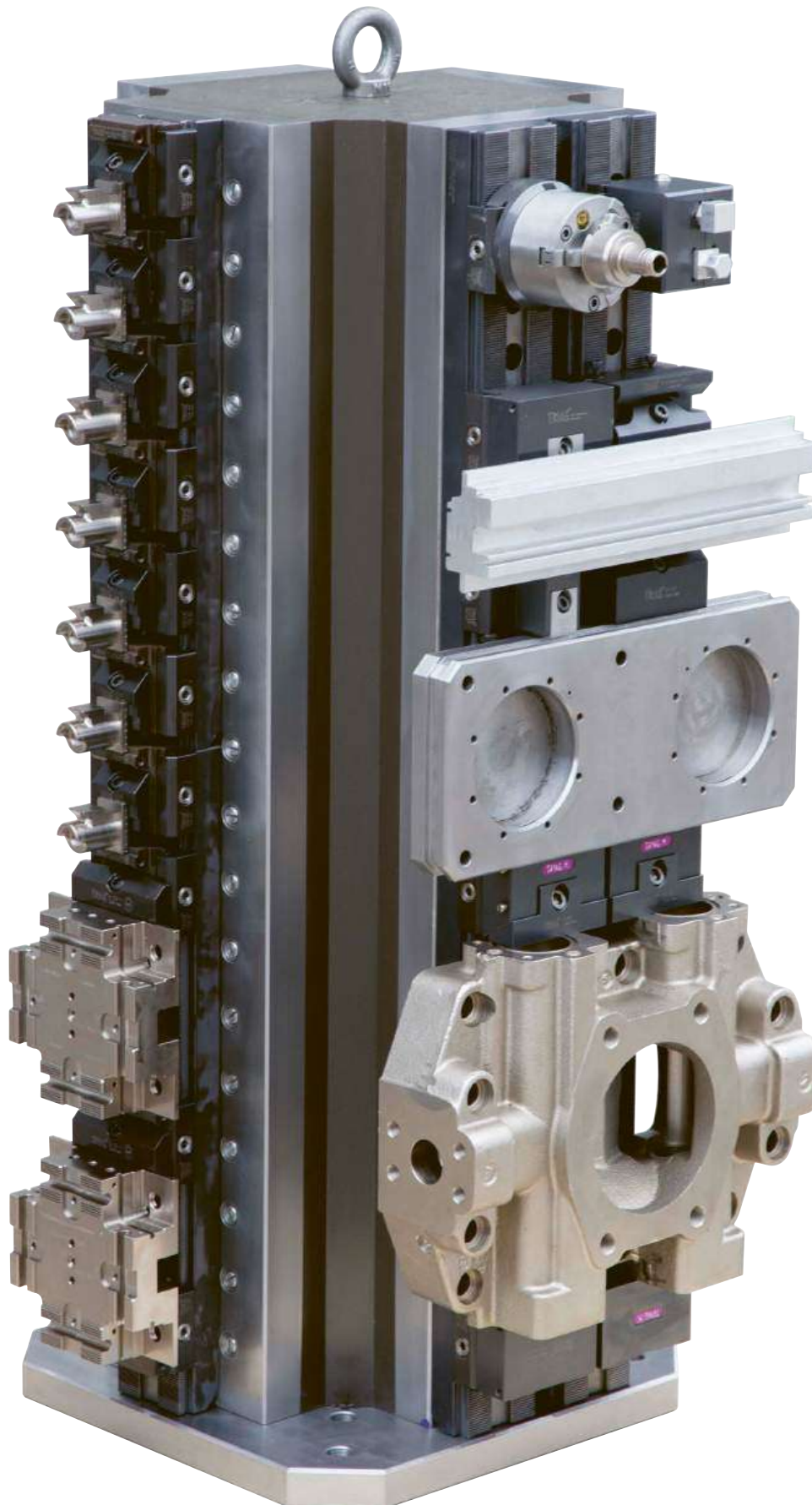
20

5-Achs Anwendung auf Lehmann Teilapparat
5-axis application on Lehmann indexer



21





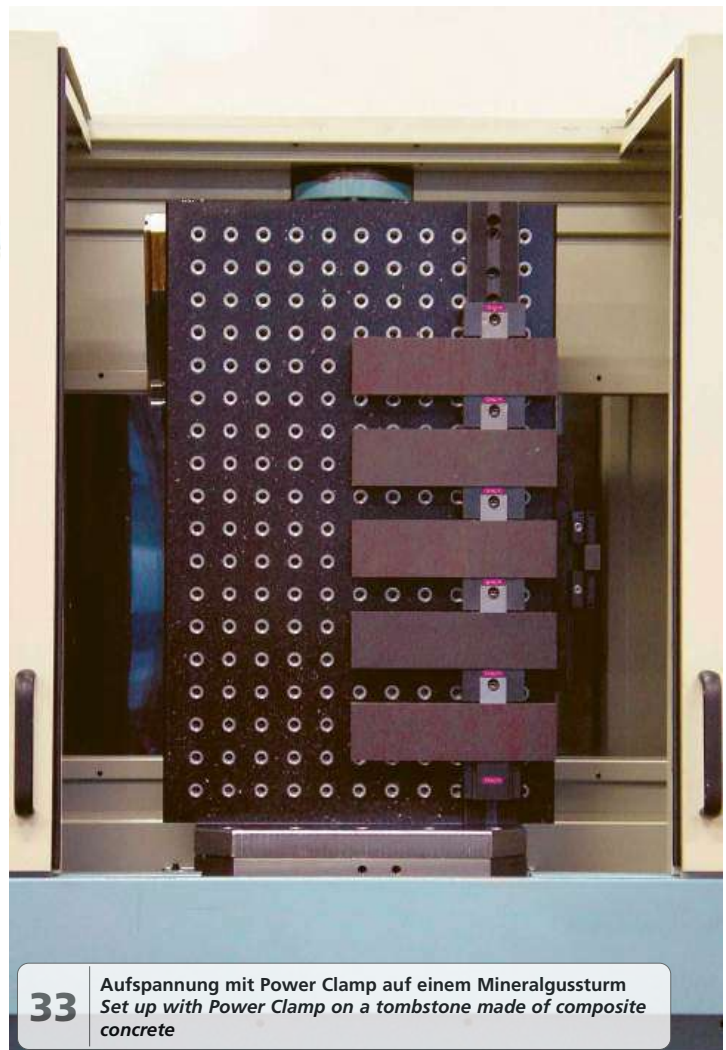
25

tripoxyMINERAL Kreuzturm mit PowerCLAMP Schienen für chaotische Spannung
tripoxyMINERAL Cross version with PowerCLAMP baserails for chaotic workholding

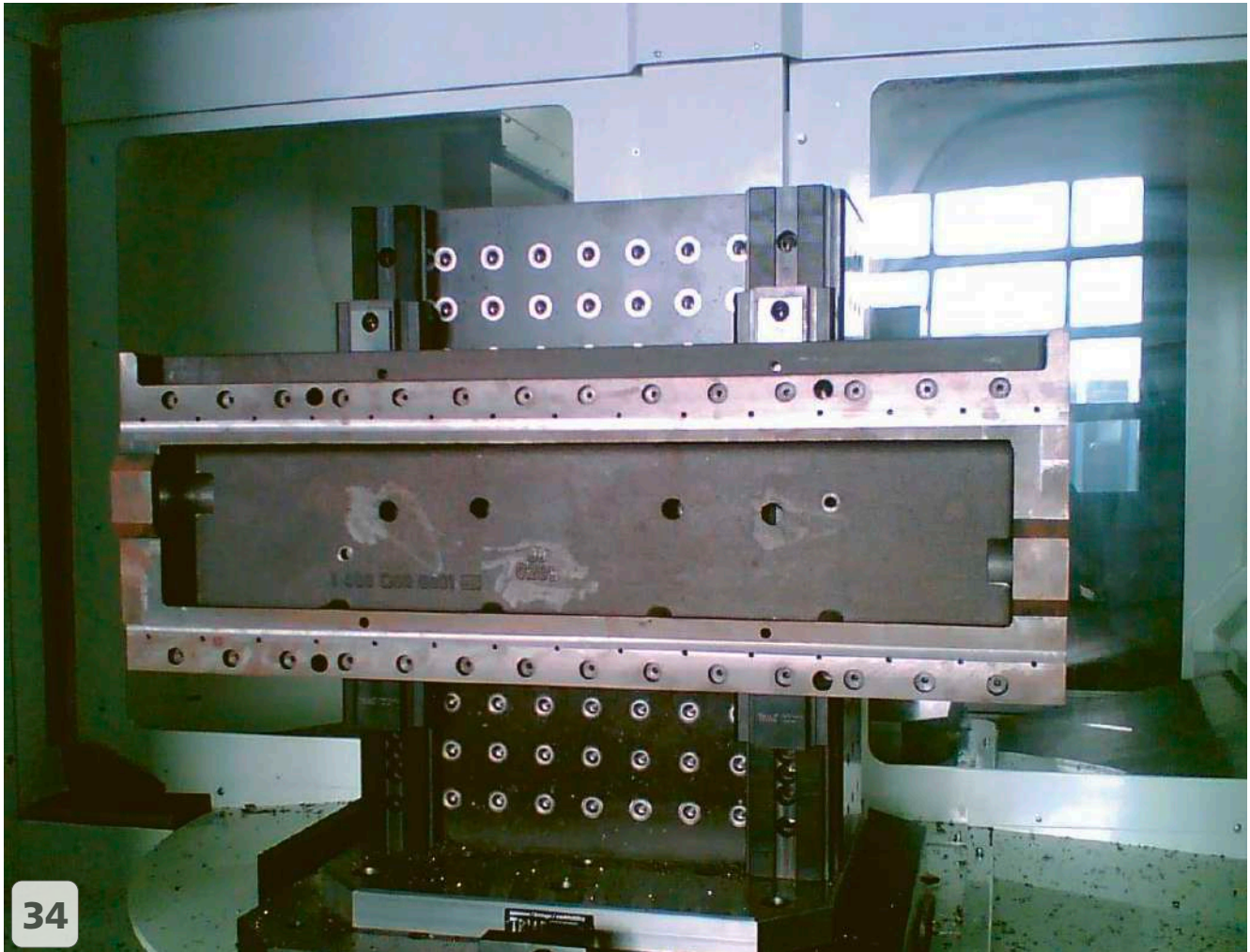
31 tripoxyMINERAL mit unterschiedlichen Werkstücken bestückt
tripoxyMINERAL tombstones holding a variety of workpieces



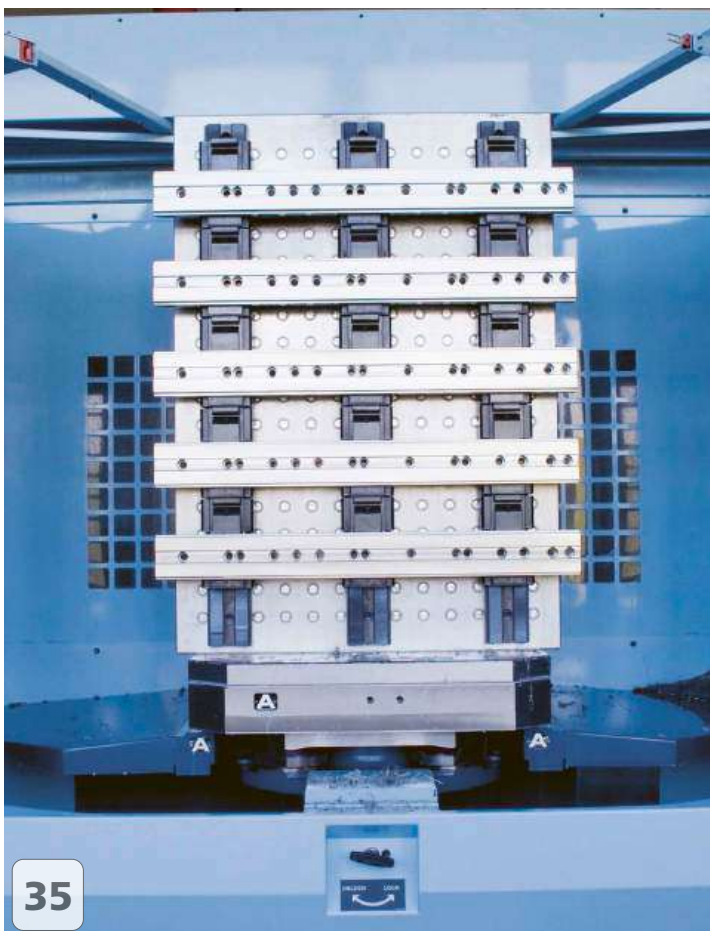
32 Zentrischspanner auf einem Spezialturm
Centric vices installed on a special tombstone



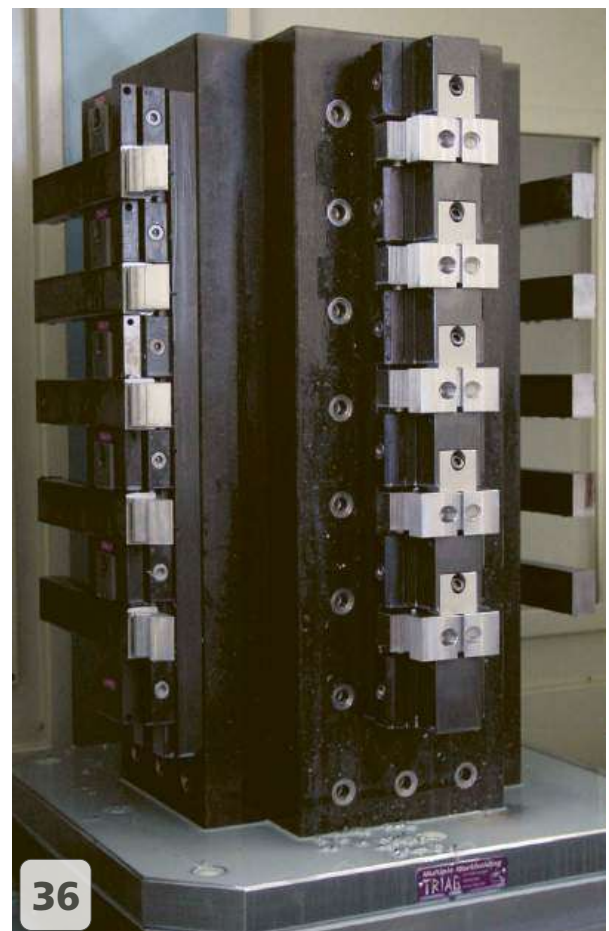
33 Aufspannung mit Power Clamp auf einem Mineralgussturm
Set up with Power Clamp on a tombstone made of composite concrete



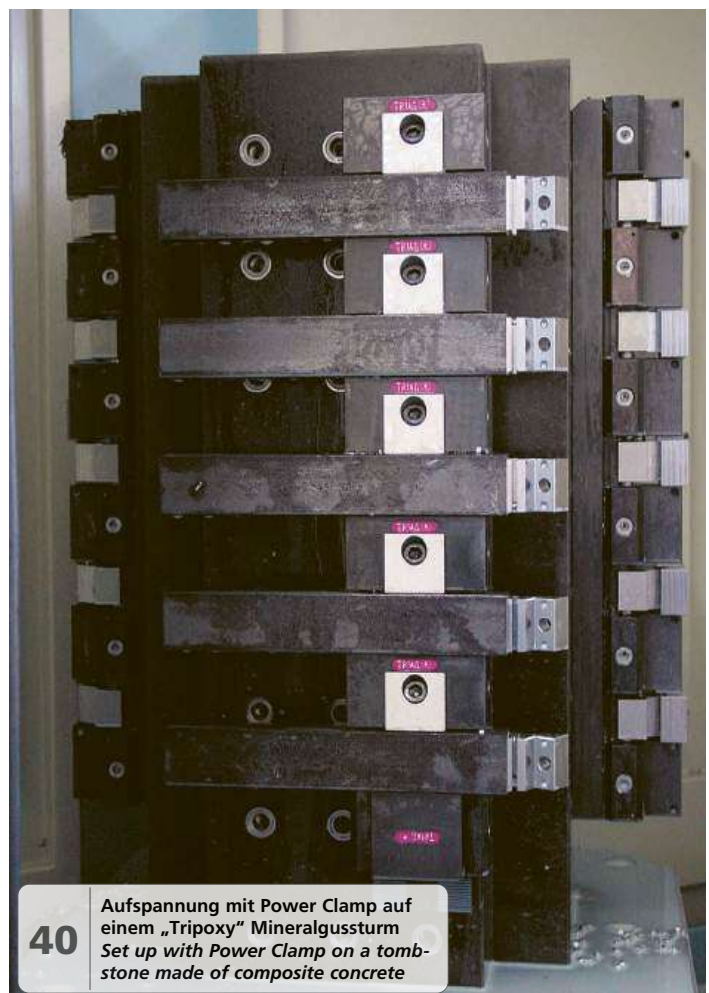
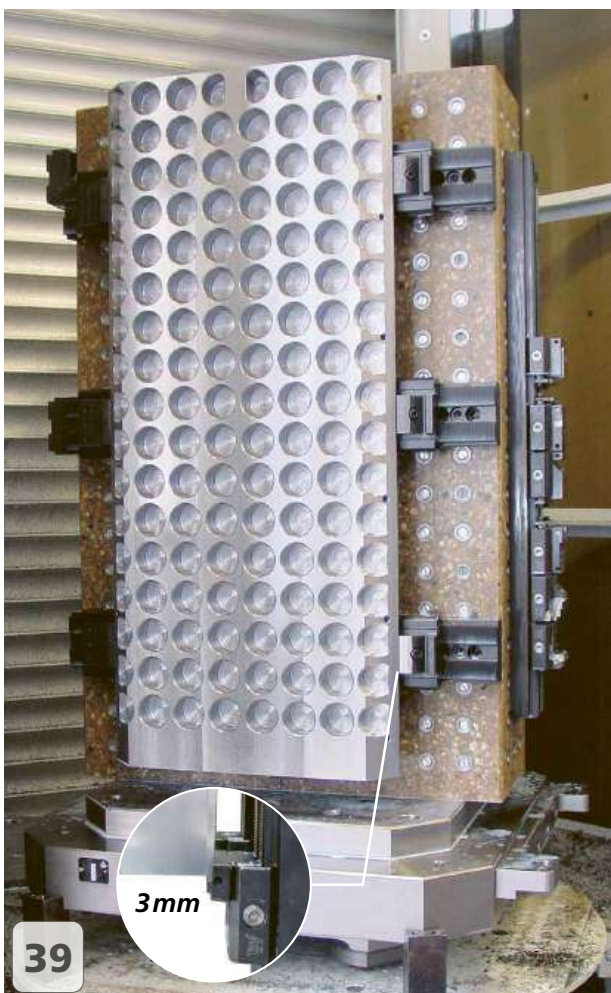
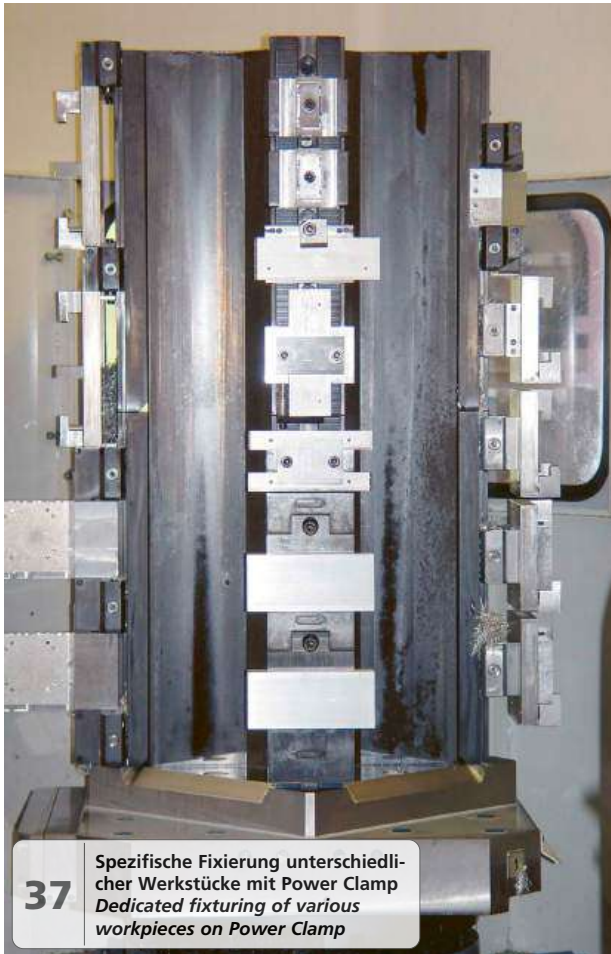
34

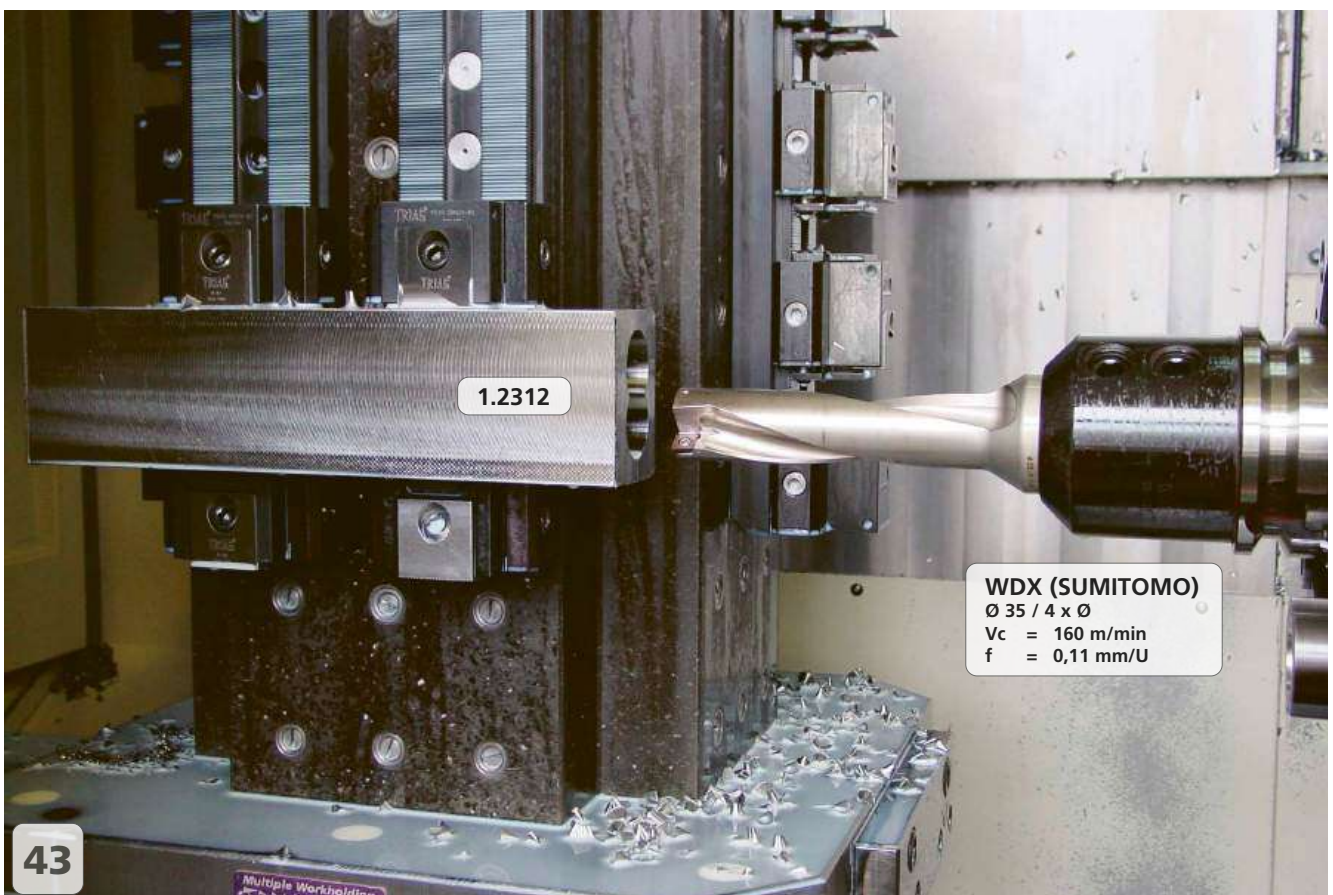
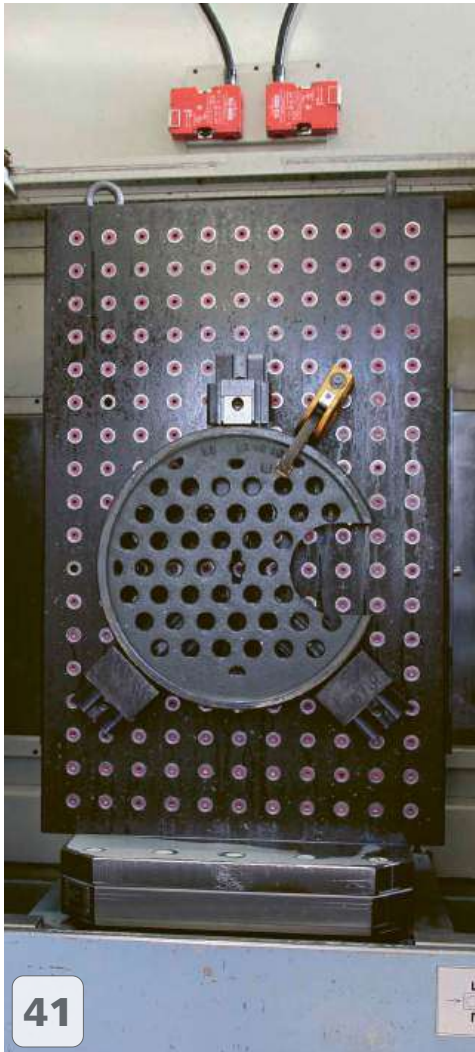


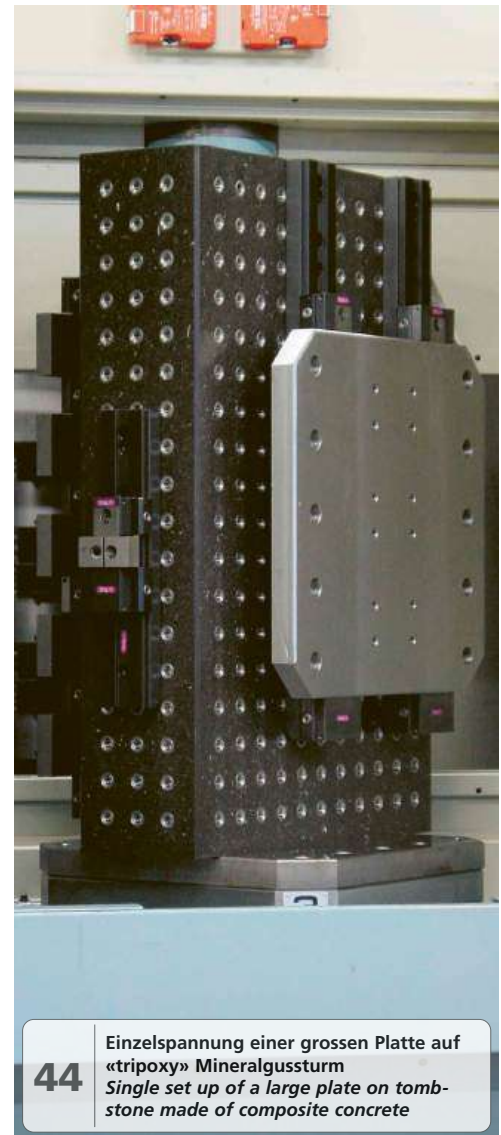
35

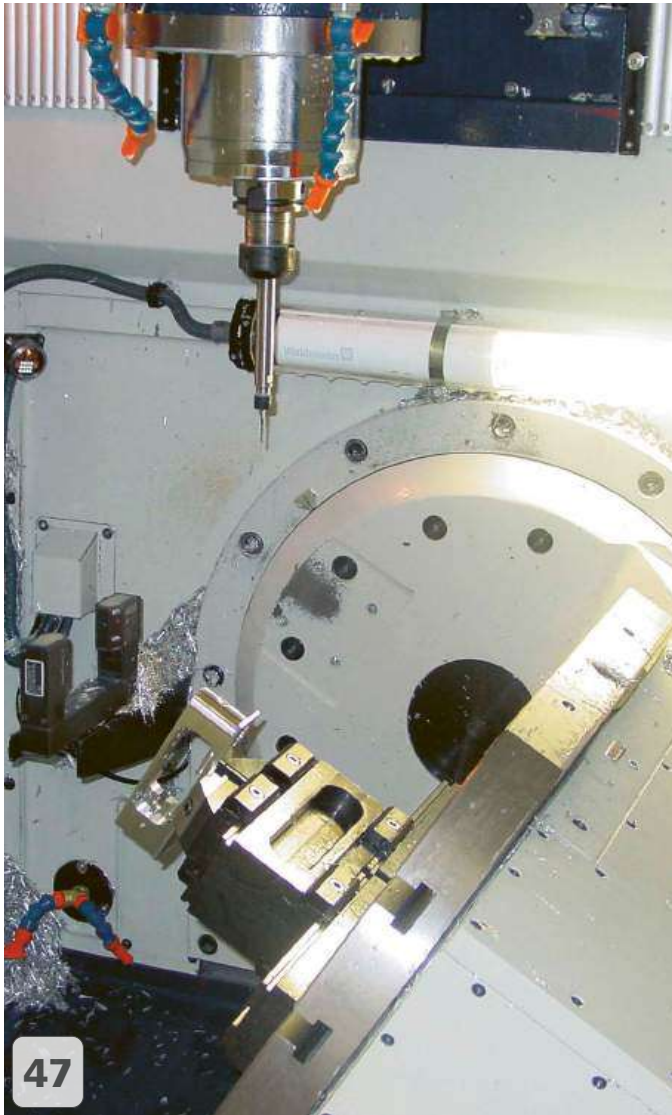


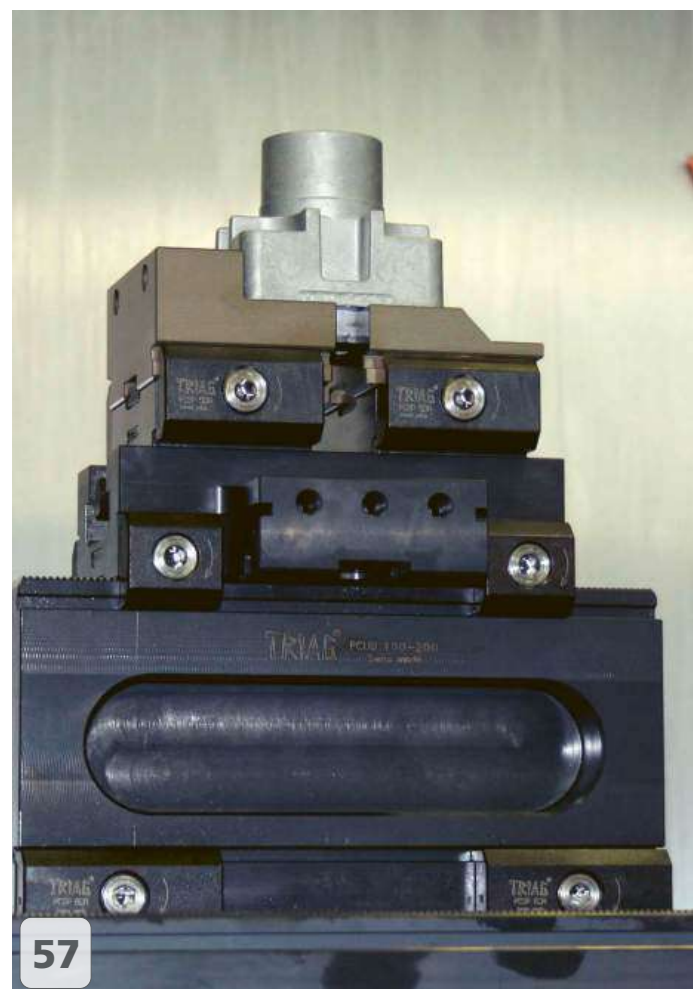
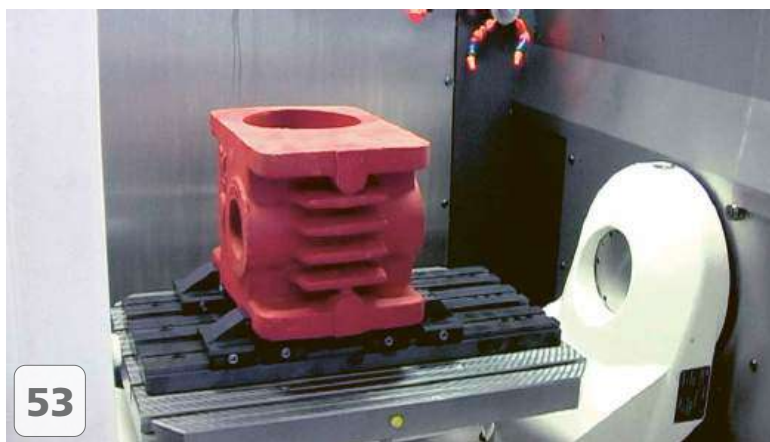
36

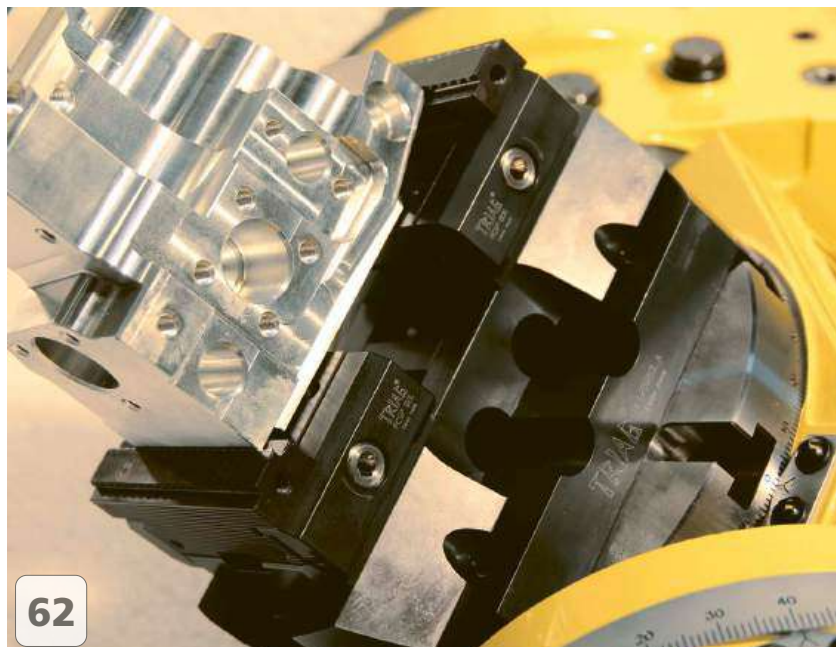
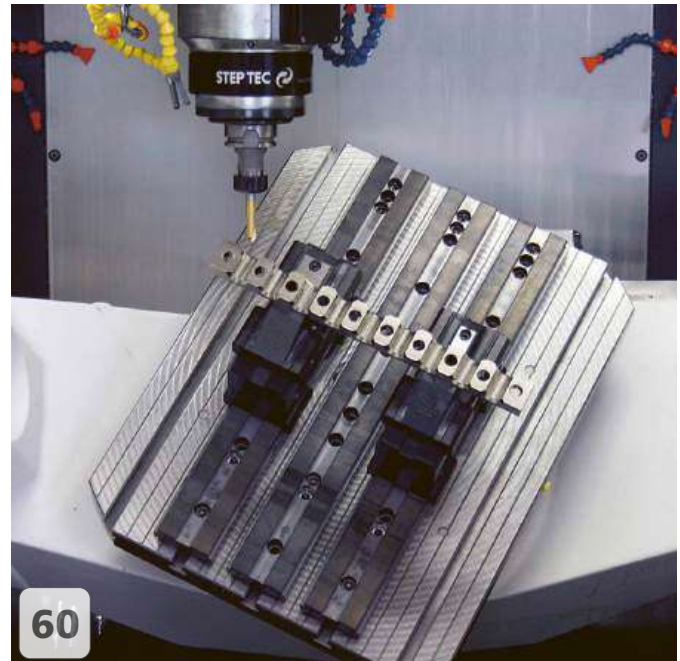












Modulares Mehrfachspannen auf 5-Achsen-Maschinen

Immer öfter werden die 5-Achsen-Maschinen in den Produktionsabläufen eingesetzt, um den Ansprüchen der heutigen effizienten Herstellung gerecht zu werden und weltweit wettbewerbsfähig zu bleiben. Die Werkstückspannung ist sehr anspruchsvoll und fordert die technischen Mitarbeiter ausserordentlich, wie auf den nachfolgenden Bildern dargestellt.

Modular workholding system for 5-axis machines

Increasingly, the 5-axis machines are used in the production processes to be in accordance with the demands of today's efficient manufacturing and remain globally competitive. The workpiece clamping is very demanding and calls for extremely technical staff, as shown on the following pictures.

Vorteile der Triag 5-Achsen Spannsysteme:

- Die unteren Basisschienen dienen sowohl als mechanisches Nullpunktspannsystem, aber auch als Spannstock.
- Die Spannkraft wirkt direkt beim Werkstück, trotzdem ist das Werkstück ob klein, lang oder gross mit kurzen Werkzeugen sehr gut zugänglich. (Die Einschränkung ist der Maschinentisch)!
- Bei der Dreiseitenbearbeitung ist auch Mehrfachspannung möglich.
- Es können über 200 verschiedene Spannmodule, sowie Rohmodule, Zentrischspanner, Dreibackenfutter, Spannzangenfutter, Vakuumschneidmodule usw. aufgesetzt werden. Die Schnittstelle ist immer dieselbe.
- Sehr schnelles Umrüsten!
- Wenig Reinigungsaufwand, da keine T-Nuten vorhanden sind.
- Besonders gut geeignet für 5-Achsen-Maschinen. Alle Spannvorrichtungen können auch auf Horizontal- und Vertikalmaschinen universell eingesetzt werden.

Benefits of Triag 5-axis workholding systems:

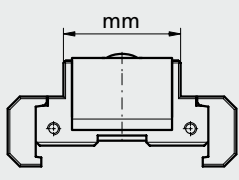
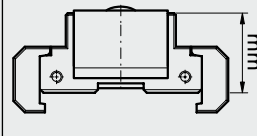
- *The lower base rails serve both as a mechanical zero-point clamping system, but also as a vice.*
- *The tension acts directly at the workpiece, the workpiece is still, whether small, long or large, very accessible with short tools. The constraint is the machine table!*
- *3-side machining is possible as well.*
- *There may be placed over 200 different clamping modules, as well as raw modules, self-centring modules, three jaw chuck, collet chuck, vacuum clamping modules and so on. The interface is always the same.*
- *Very fast setup!*
- *Reduced cleaning required, since no T-slots available.*
- *Especially suitable for 5-axis machines. All clamping devices can also be used universally on horizontal and vertical machines.*



Geeignet sowohl für kleine ...
Especially suited for small ...



... als auch für grosse Werkstücke!
... as well as large workpieces!

System System		bei Anschlagmodulen for end module		Modulnutzbreite Module clamping width		Modulnutzhöhe Module clamping height	
A	Apto Clamp	N	nitriergelärtet nitrated	19 25 26 34 43 48 58 61 68 78 94 125		34 44 49 62 75 78	
P	Power Clamp	D	durchgelärtet through hardened				
C	Compact Clamp	bei Spannmodulen for vice modules					
M	Micro Clamp	1 2 3	Anzahl Spannbacken Number of jaws				
V	Vorrichtungsbau module Workholding modules for dedicated fixtures	-	keine Spannbacke no clamping jaw				

P

S

1

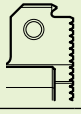
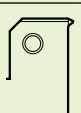
R

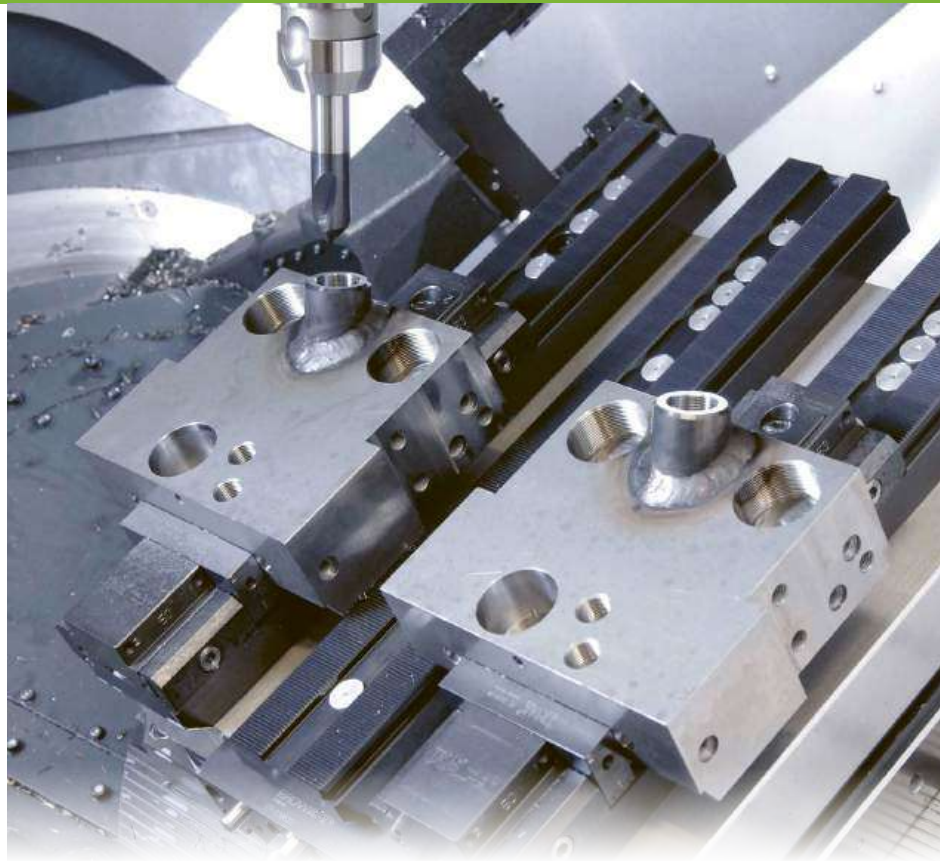
48

N

34

-80

Modultyp Type of module		Anschlagfläche der Module Datum face		Backenhub Stroke of clamping jaw		Spannbackentyp Type of clamping jaw	
A	Anschlagmodul End module	F	Anschlagfläche glatt Datum face flat	N	Niederzug Pull down	B01 - B313	Spannbacken Clamping jaws
S	Spannmodul Clamping module	R	Anschlagfläche geriffelt Datum face double serrated	L	linear / parallel linear / parallel	-013 - -105	Modul ohne Spannbacken Module without clamping jaw
T	Trägermodul Supporting module	D	eine Seite glatt, eine Seite geriffelt one face flat, one face double serrated	-	ohne Spannbacke no clamping jaw		
R	Rohling Blank	G	Anschlagfläche gerillt Datum face serrated				
		X	spezielle Ausführung special execution				
		5X	5axes Clamp				
		P	 Fläche unterhalb der Prägung gerillt Area below the stamping serrated				
		PF	 Fläche unterhalb der Prägung glatt Smooth surface below the stamping				
		PV	 Präge vorstehend, Fläche unterhalb der Prägung glatt Stamping protruding, surface below the stamping flat				
		P6	prägen / stamping				



Die Basisschiene ist die Grundlage des Power Clamp Spannsystems

Der Einsatz der Basisschiene als Modularspannstock ist jedem Mechaniker ein Begriff. Die Vorteile ihres Einsatzes als mechanisches Nullpunktsystem sind in der Zwischenzeit ebenfalls ins Planungsdenken der mechanischen Fertigung eingeflossen.

Die Power Clamp-Schiene dient als Basis für über 200 verschiedene Spannmodule, Zentrischspanner, Rohlingsmodule und Vakuumplatten.

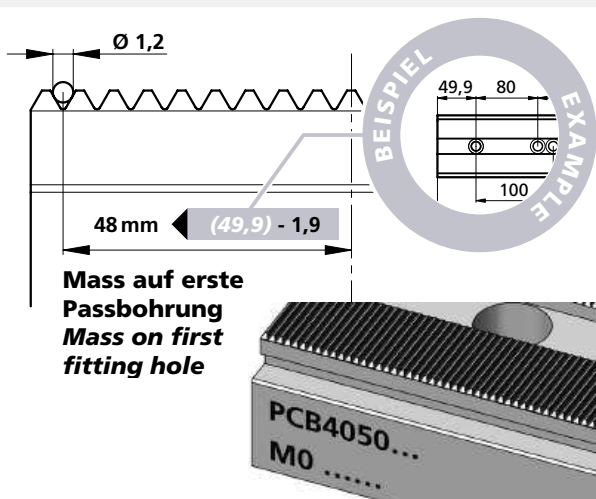
The serrated base rail is the basic structure of the Power Clamp workholding system

Using the base rail as a modular workholding vise is standard practice to any mechanic. The advantages of using it as a zero point system have also widely influenced the planning stages of mechanical production.

The Power Clamp base rail serves as a supporting plate for more than 200 different clamping modules, self centring vises, blank modules and vacuum clamping plates.

Toleranz gilt für alle PCB-Basisschienen / Tolerance applies to all PCB base rails

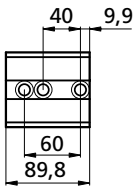
Toleranzklassen	Tolerance classes
P6	+0.06
P5	+0.05
P4	+0.04
P3	+0.03
P2	+0.02
P1	+0.01
P0	+0.005
M0	-0.005
M1	-0.01
M2	-0.02
M3	-0.03
M4	-0.04
M5	-0.05
M6	-0.06



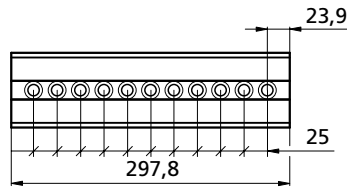
Montagevideo
Assembly video



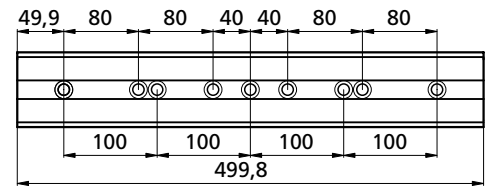
PCB6090 kg ~1,7



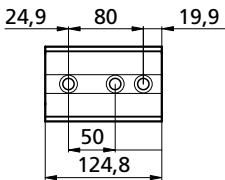
PCB25300 kg ~5,4



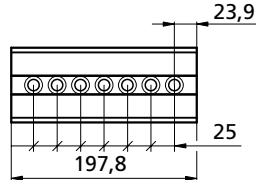
PCB4050500 kg ~9,5



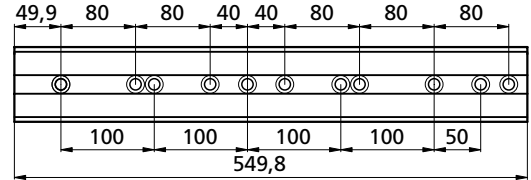
PCB4050125 kg ~2,3



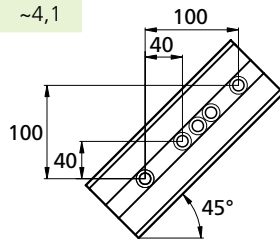
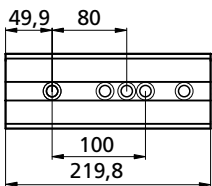
PCB25200 kg ~3,6



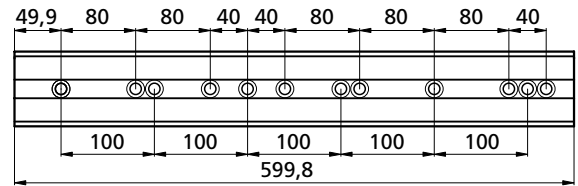
PCB4050550 kg ~10,3



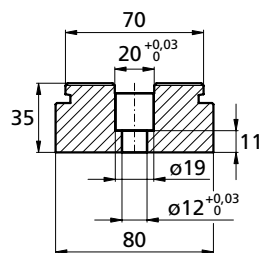
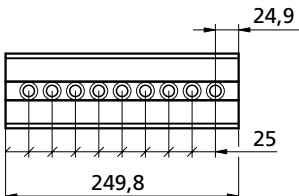
PCB4050220W2 kg ~4,1



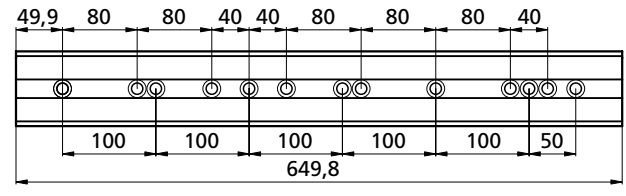
PCB4050600 kg ~11,3



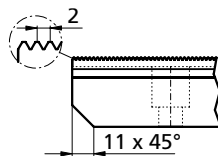
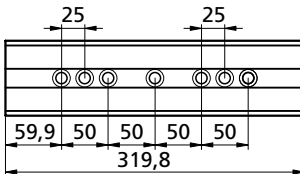
PCB2550250 kg ~4,5



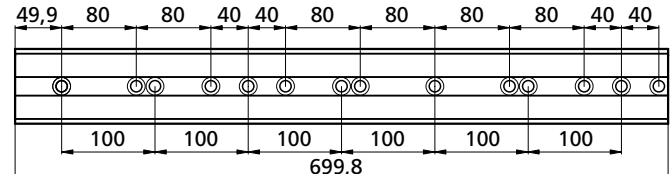
PCB4050650 kg ~12,2



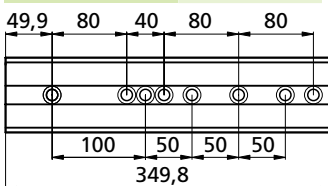
PCB50320 kg ~6,0



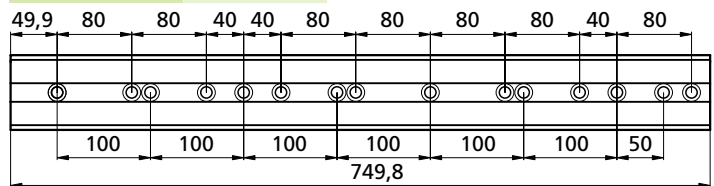
PCB4050700 kg ~13,2



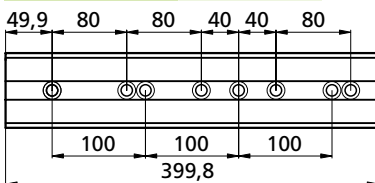
PCB4050350 kg ~6,5



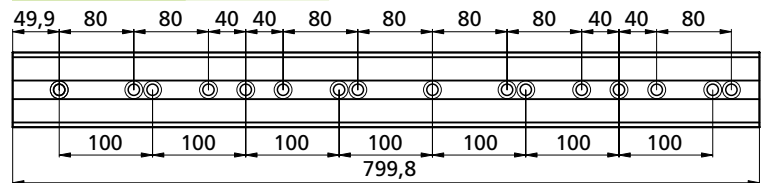
PCB4050750 kg ~14,1



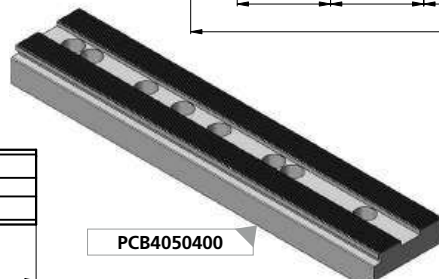
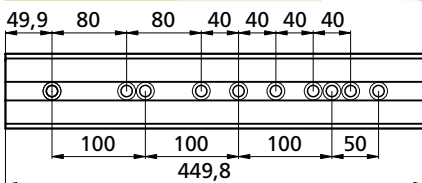
PCB4050400 kg ~7,5



PCB4050800 kg ~15,0



PCB4050450 kg ~8,4

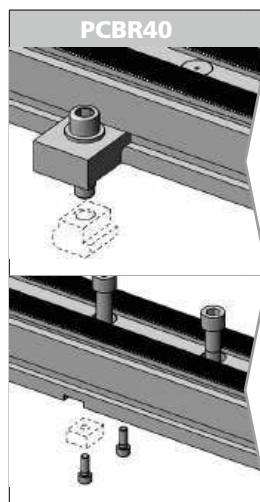
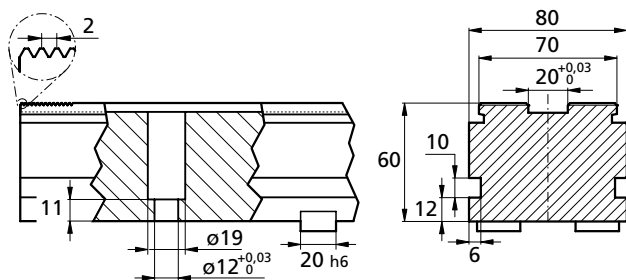


PCB4050400

Basisschienen in Zoll
Base rails in inch



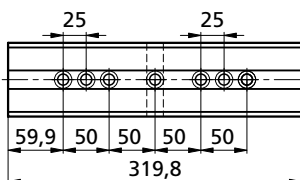
Bestellbeispiel / Ordering example: **PCB4050125**



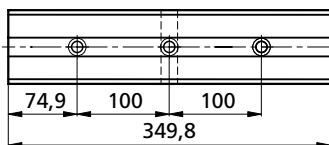
1. Befestigung **1. Fastening**
Mit den seitlichen Laträtzen, kann die Basisschiene frei auf Ihrem Maschinentisch montiert werden.
With the lateral clamps, the base-rail can be mounted freely on your machine table.

2. Befestigung **2. Fastening**
Diese Nutensteine sind zum Ausrichten der Basisschiene auf Ihrem Maschinentisch.
These t-slot nuts are for aligning the base-rail on your machine table.

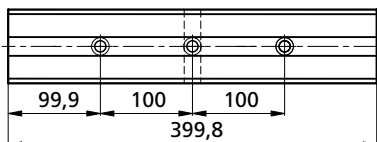
PCB50320H60	
1	1x TF190449
2	2x M6X12ISO4762
3	2x SM1136-20
kg	~10,3



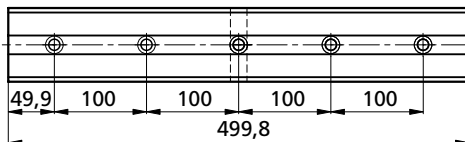
PCB100350H60	
1	1x TH170888
2	2x M6X12ISO4762
3	2x SM1136-20
kg	~11,7



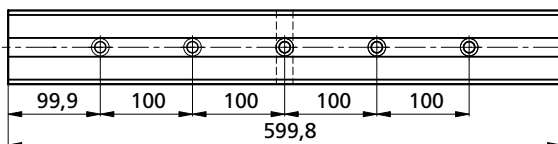
PCB100400H60	
1	1x TB140546
2	2x M6X12ISO4762
3	2x SM1136-20
kg	~13,4



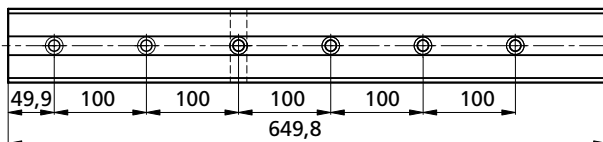
PCB100500H60	
1	1x TB140553
2	2x M6X12ISO4762
3	2x SM1136-20
kg	~16,7



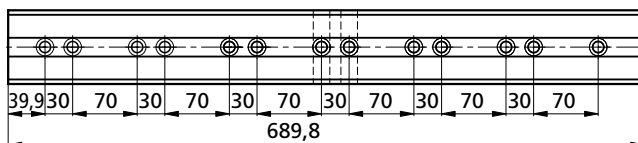
PCB100600H60	
1	1x TB140556
2	2x M6X12ISO4762
3	2x SM1136-20
kg	~20,1



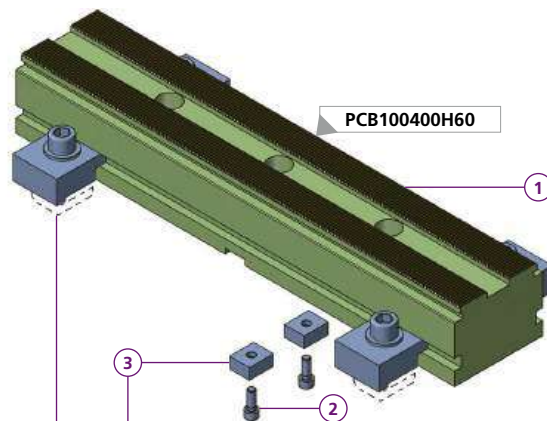
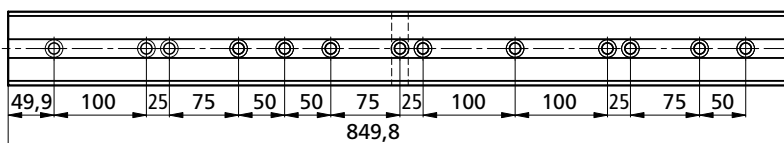
PCB100650H60	
1	1x TB140559
2	2x M6X12ISO4762
3	2x SM1136-20
kg	~21,8



PCB100690H60	
1	1x ZL100122
2	2x M6X12ISO4762
3	2x SM1136-20
kg	~22,6

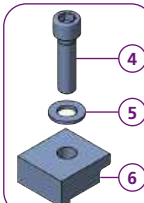


PCB100850H60	
1	1x TB140562
2	2x M6X12ISO4762
3	2x SM1136-20
kg	~27,9



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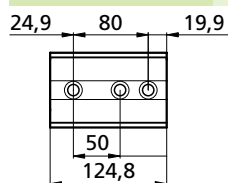
PCBR40	
4	1x M12X45ISO4762
5	1x TN100251
6	1x TK200035
kg	~0,25



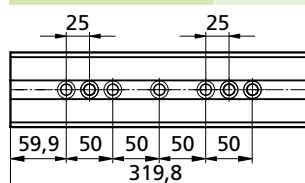
T-Nutensteine
T-slot nuts
T-Nutensteine je nach Maschinentisch, muss separat bestellt werden.
T-slot nuts depending on the machine table, must be ordered separately.

Bestellbeispiel / Ordering example: 1x PCB100400H60 & 2x M6X12ISO4762 & 2x SM1136-20

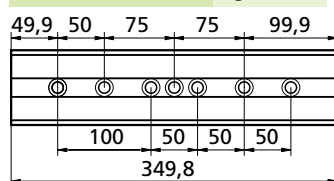
PCB4050125H80 kg ~5,5



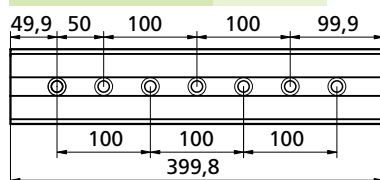
PCB50320H80 kg ~14,3



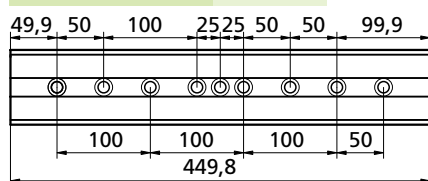
PCB50350H80 kg ~15,8



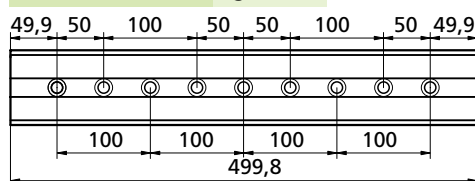
PCB50400H80 kg ~18,1



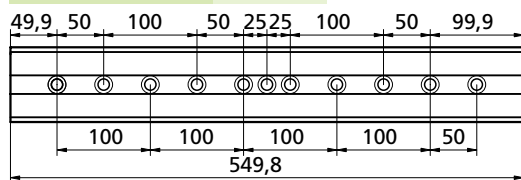
PCB50450H80 kg ~20,2



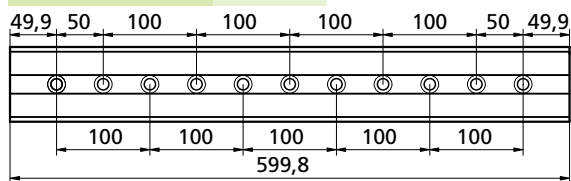
PCB50500H80 kg ~22,6



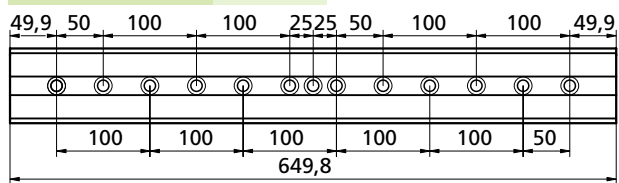
PCB50550H80 kg ~24,7



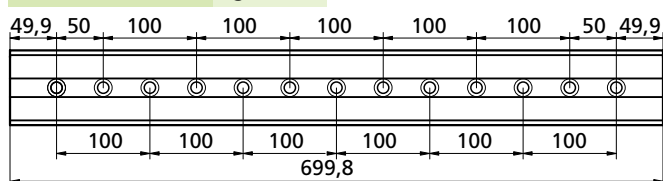
PCB50600H80 kg ~27,3



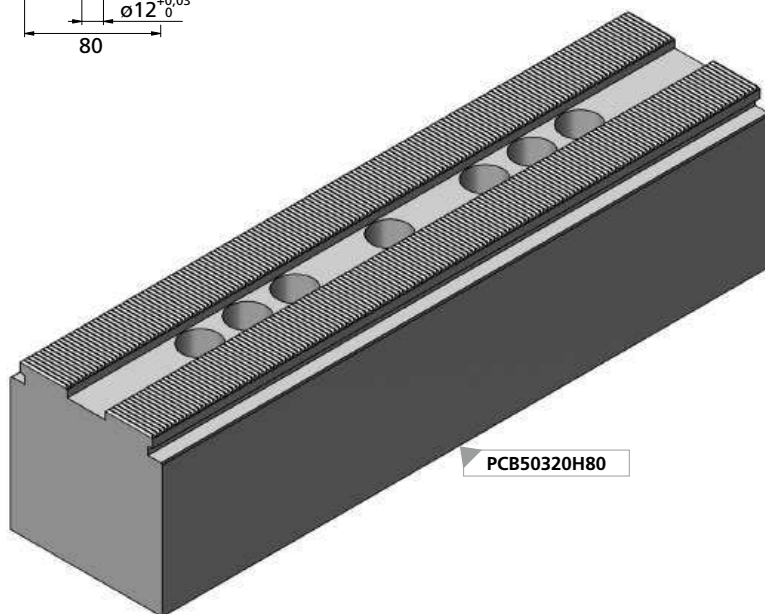
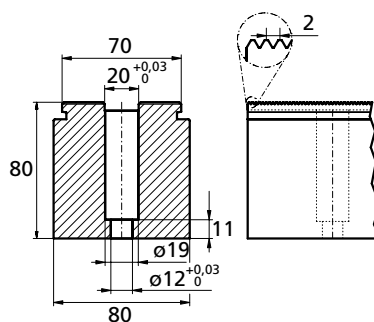
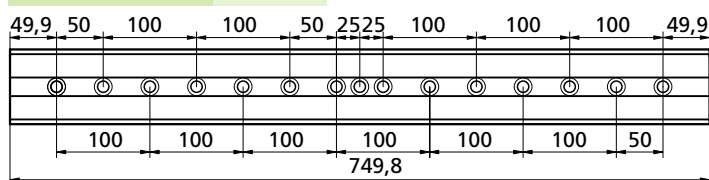
PCB50650H80 kg ~29,2



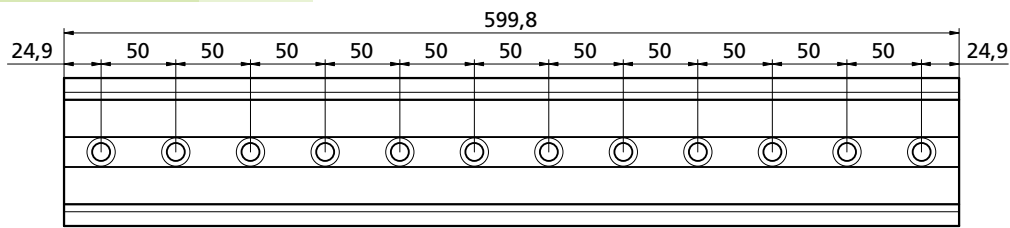
PCB50700H80 kg ~31,5



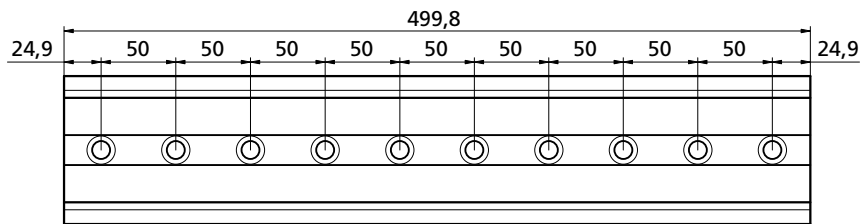
PCB50750H80 kg ~33,9



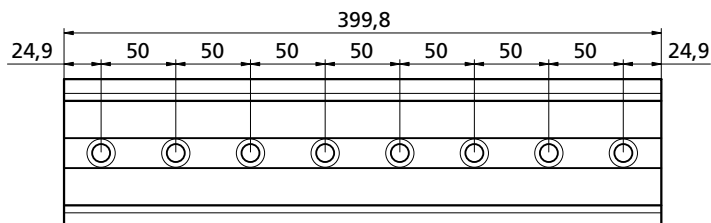
PCMB50600H175 **kg ~40**



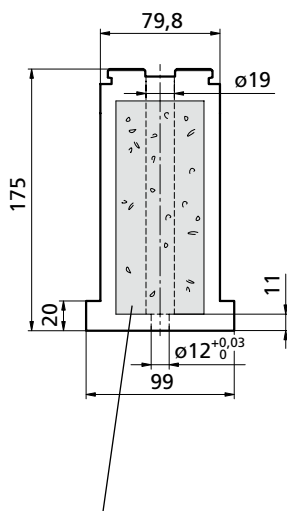
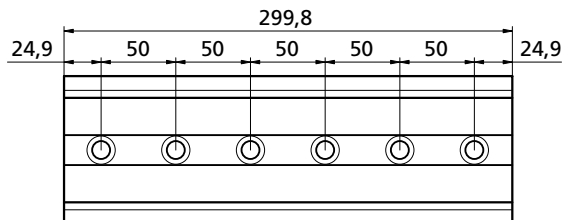
PCMB50500H175 **kg ~34**



PCMB50400H175 kg ~27



PCMB50300H175 **kg ~21**



Epoxy Mineral
Für gute Vibrationsdämpfung
For brilliant dampening effect



PCMB50400H175

Kupplungsstück (Basisschienen zum koppeln) Coupling element (Base rails for coupling)

powerCLAMP

Kupplungsstücke für PCB Basisschiene auf Mineralguss-Türmen

Mit diesen Kupplungsstücken ist es möglich, die PCB Basisschienen zu verlängern. Aufgrund des durchgängigen Kraftschlusses wird eine übermäßige Belastung des Mineralgussturmes vermieden. Erforderlich ist eine Modifikation der Enden der Basisschienen gemäss der untenstehenden Zeichnung durch den Anwender. Selbstverständlich können neue Schienen bereits mit dieser Modifikation ausgeliefert werden.

So können die zwei Kupplungsstücke montiert werden, die nach dem Platzieren der Schienen eingesetzt und festgezogen werden. Eine zusätzliche Schraube (B) nimmt allfällige, senkrecht zur Befestigungsfläche auftretende Kräfte auf.

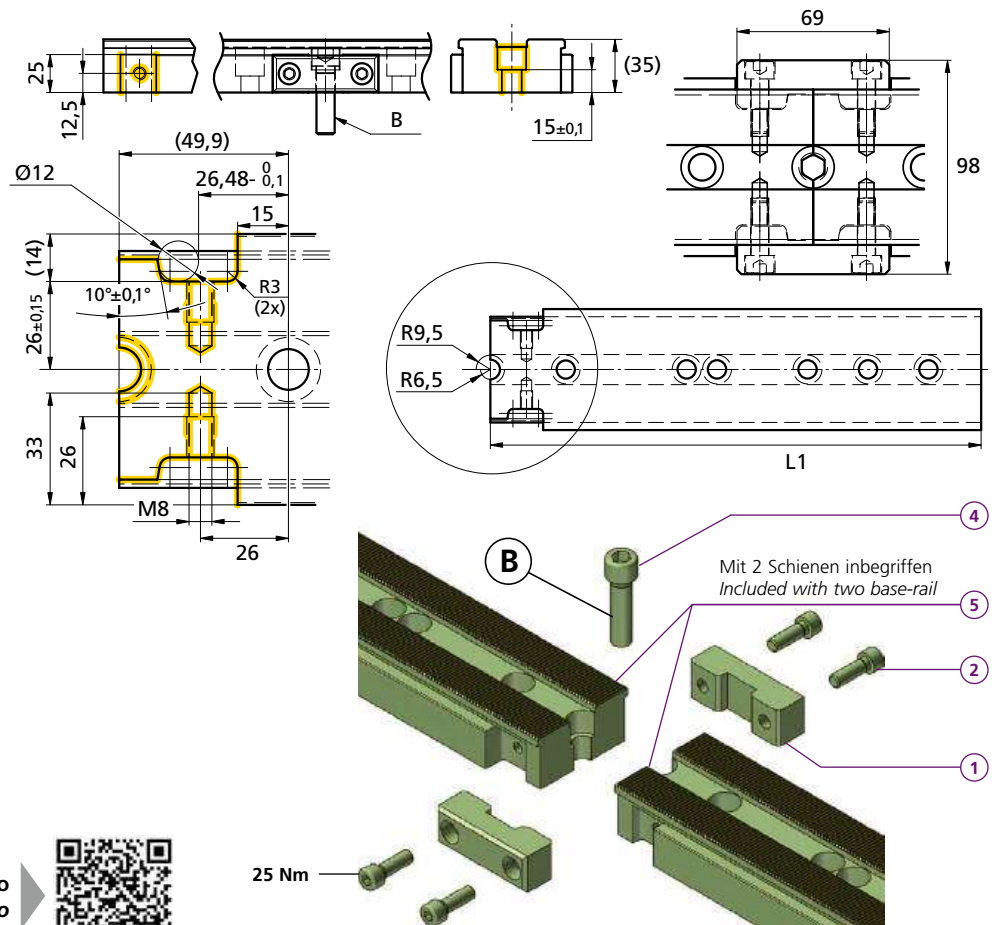
Coupling element for PCB base rails mounted on epoxy mineral tombstones

With this coupling element, it is possible to extend the PCB base rail by a second rail. Due to the frictional connection, the behaviour of the associated items is approximate to the behaviour of a continuous rail. A modification according to the drawing below (made by the customer) is required at the end of the base rails. New base rails can be supplied with this modification.

So the two coupling elements can be placed between the base rails. An additional screw (B) is taken the force flatwise to the seating.

Detailzeichnung zum Bearbeiten aller Basisschienen H35, um die Aussparung für das Kupplungsstück bei vorhandenen Schienen nachträglich herzustellen.

Detail drawing for machining all base rails H35 to retrofit the recess for the coupling piece on existing rails.



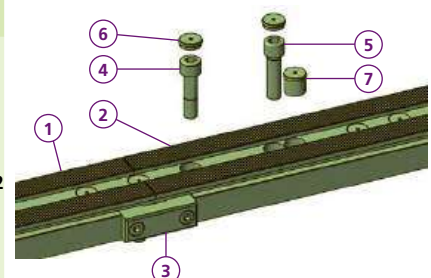
Montageanleitung siehe Video
Assembly instructions see video



PCBP69SET		PCB4050250KP	PCB4050400KP	PCB4050450KP	PCB4050500KP	PCB4050650KP	PCB4050700KP
1	2x TW090078	5	5	5	5	5	5
2	4x M8X25ISO4762	L1 = 250	L1 = 400	L1 = 450	L1 = 500	L1 = 650	L1 = 700
4	1x M12X45ISO4762	kg ~5,1	kg ~7,9	kg ~8,9	kg ~9,9	kg ~12,8	kg ~13,8
kg	~0,4						

Bestellbeispiel / Ordering example: PCB4050250KP

PCB850SET		PCB900SET		PCB950SET		PCB1000SET	
1	1x PCB4050400KP	1	1x PCB4050650KP	1	1x PCB4050700KP	1	2x PCB4050500KP
2	1x PCB4050450KP	2	1x PCB4050250KP	2	1x PCB4050250KP	3	1x PCBP69SET
3	1x PCBP69SET	3	1x PCBP69SET	3	1x PCBP69SET	4	4x TWPAS1240
4	4x TWPAS1240	4	4x TWPAS1240	4	4x TWPAS1240	5	6x M12X40ISO4762
5	5x M12X40ISO4762	5	6x M12X40ISO4762	5	6x M12X40ISO4762	6	10x PCPF16L6
6	9x PCPF16L6	6	10x PCPF16L6	6	10x PCPF16L6	7	8x PCPF16L18
7	9x PCPF16L18	7	8x PCPF16L18	7	9x PCPF16L18	kg	~20,2
kg	~17,1	kg	~18,2	kg	~19,1		

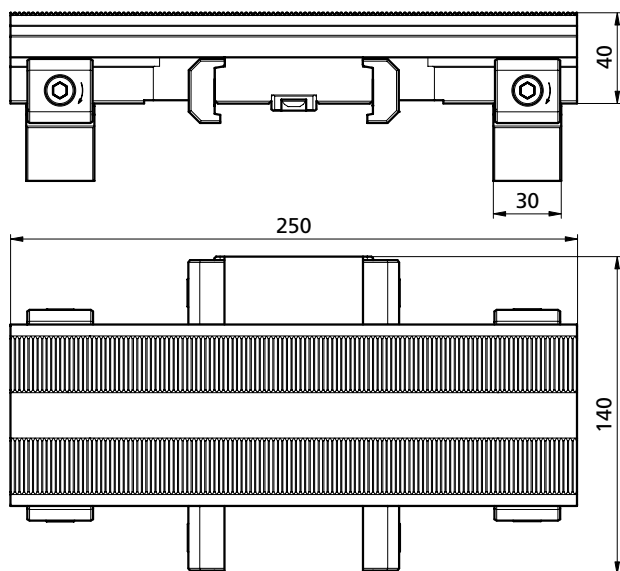
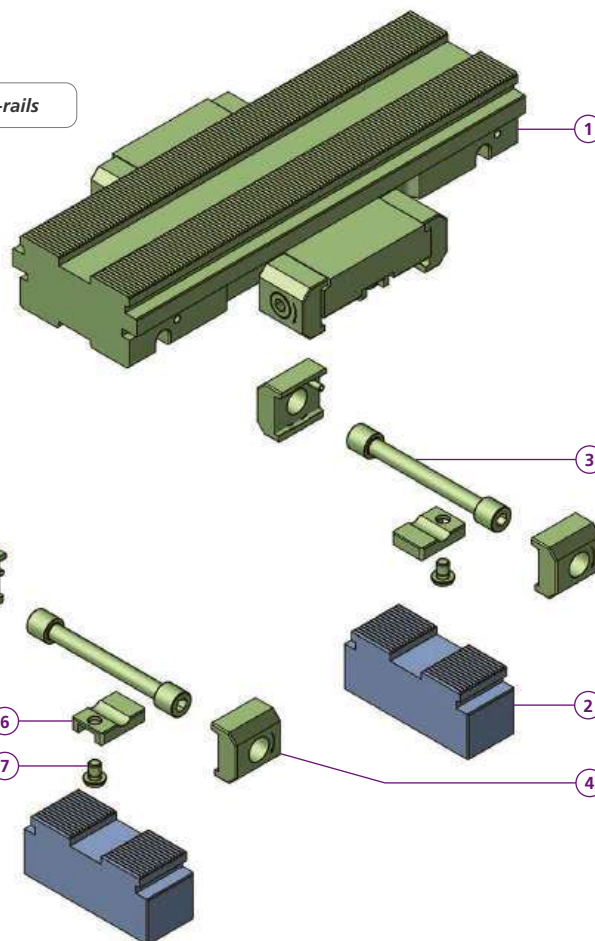
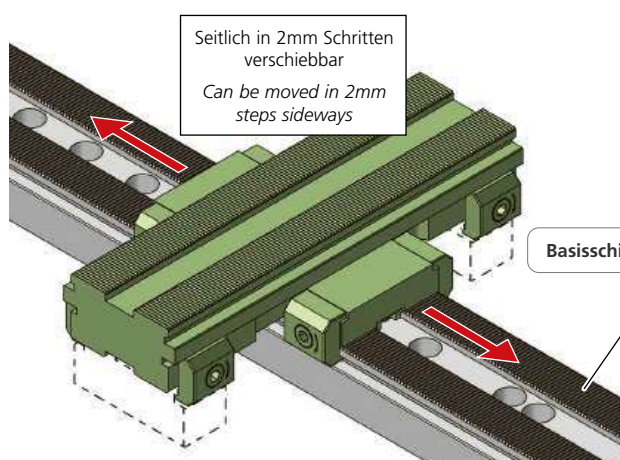


Bestellbeispiel / Ordering example: PCB850SET

Querschiene 90° Crossbar 90°

PCB250Q90-H35

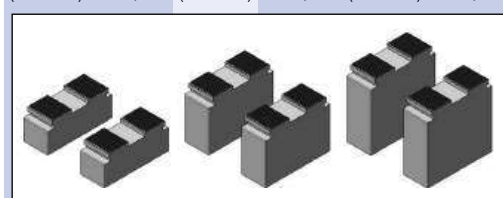
powerCLAMP



Schienenhöhe / Rail height

PCB250Q90H35	
①	1x TH151032
②	2x
③	4x PCS14
④	4x PCSP30L
⑤	4x PCSP30R
⑥	4x PCGU2030
⑦	1x M6X8ISO7380
kg	~8,18

AS35	kg	AS60	kg	AS80	kg
(H = 35)	~0,6	(H = 60)	~1,1	(H = 80)	~1,5



Seitliche Stützen

Bei Gebrauch der Querschiene 90°, werden je nach Höhe der Basisschiene auf dessen sie aufgesetzt sind, zwei seitliche Stützen AS35 / AS60 / AS80 unterlegt.

Side support

When using the cross rail 90°, a side support AS35 / AS60 / AS80 is underlaid, depending on the height of the base rail on which it is placed.

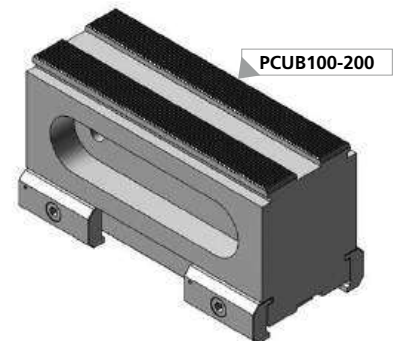
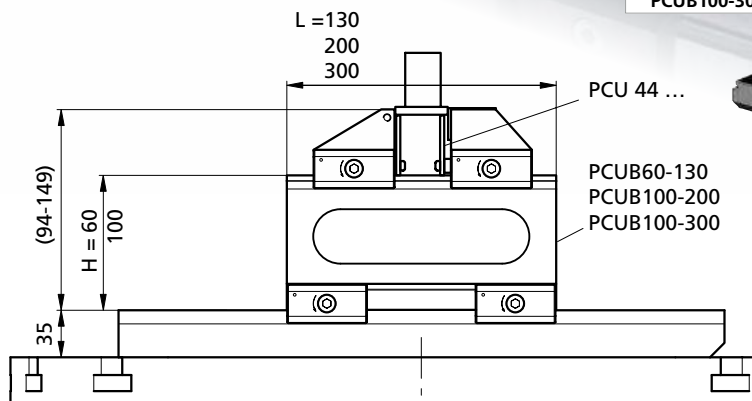
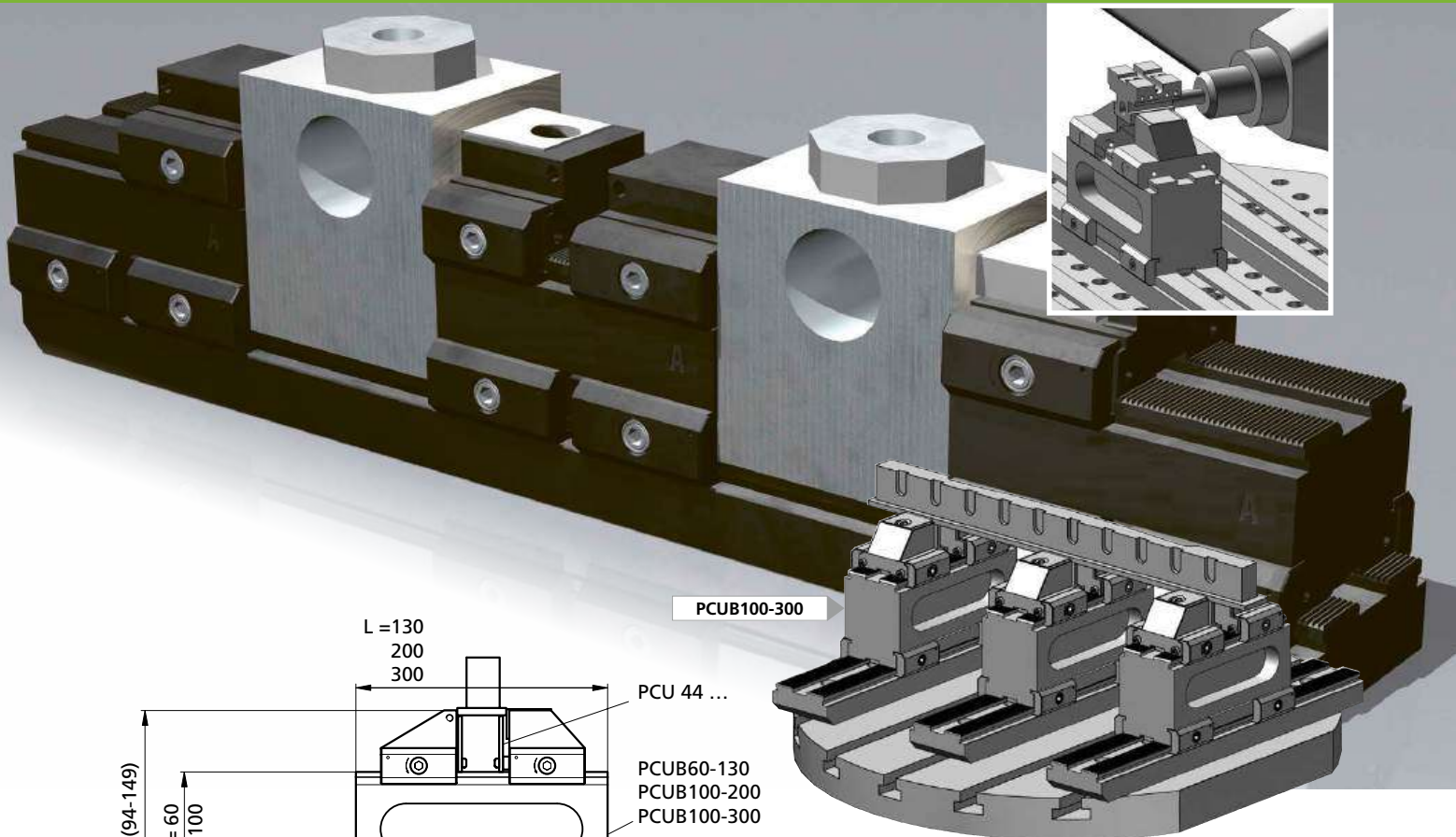
Bestellbeispiel / Ordering example: PCB250Q90H35

Separat bestellen / Order separately

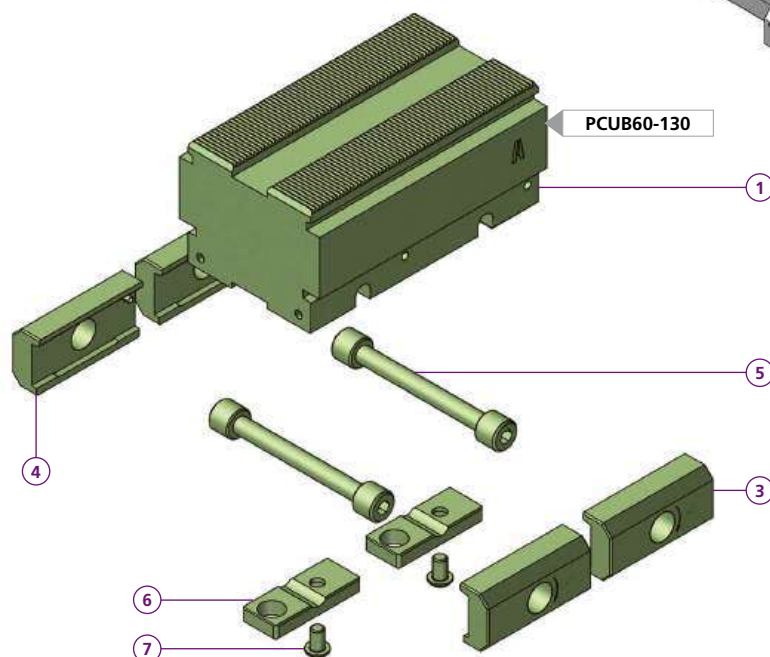
Erhöhung für 5-Achsenmaschinen Riser for 5-axis machines

PCUB60-130
PCUB100-200
PCUB100-300

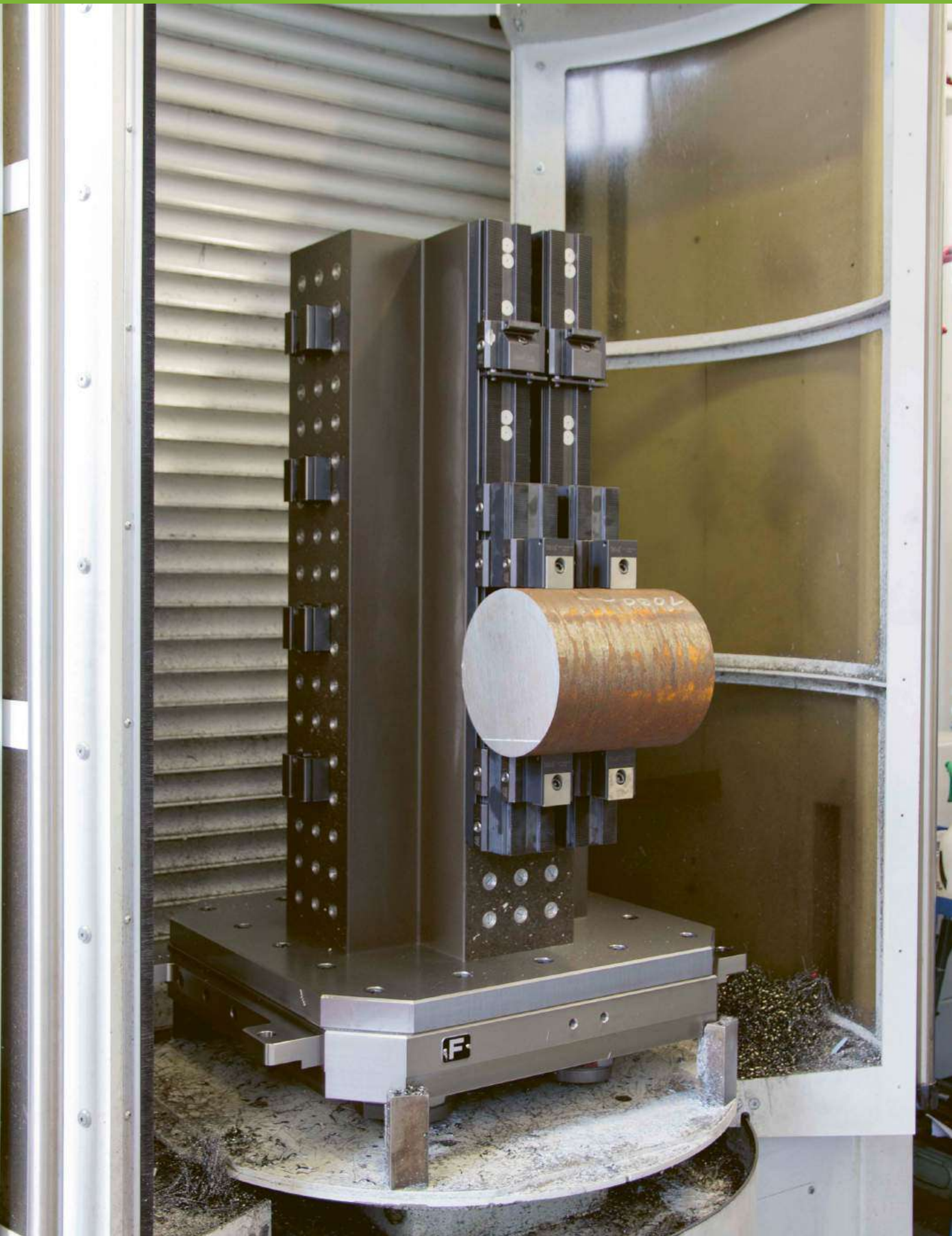
powerCLAMP

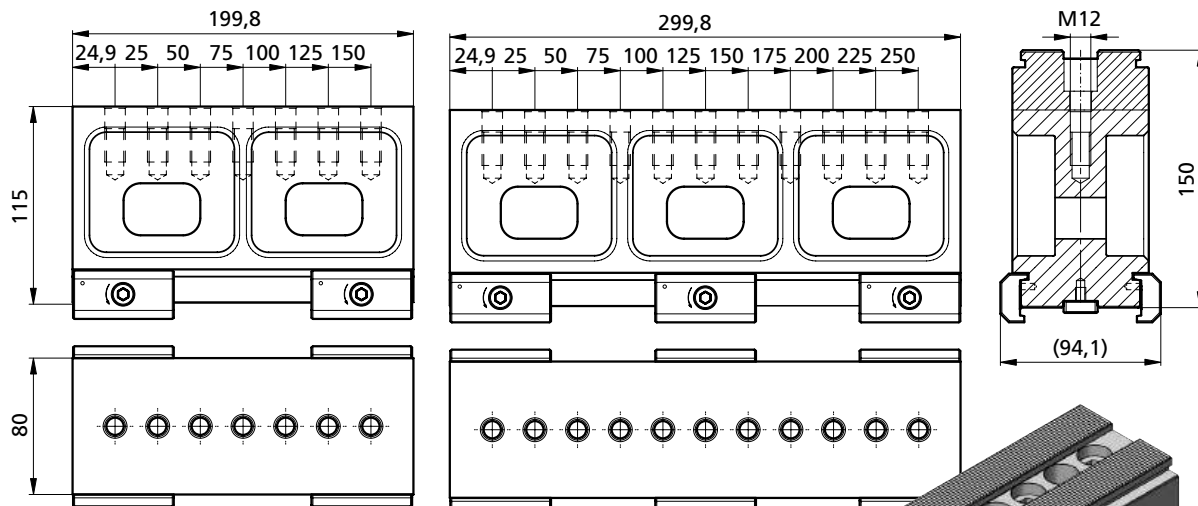


PCUB60-130	
1	1x TK120596
3	2x PCSP60R
4	2x PCSP60L
5	2x PCS14
6	2x PCGU2049
7	2x M6X8ISO7380
L	= 130
H	= 60
kg	~5,8
PCUB100-200	
1	1x TK130108
L	= 200
H	= 100
kg	~10,5
PCUB100-300	
1	1x TK130109
3	3x PCSP60R
4	3x PCSP60L
5	3x PCS14
6	3x PCGU2049
7	3x M6X8ISO7380
L	= 300
H	= 100
kg	~16

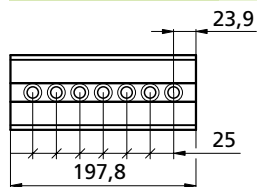


Bestellbeispiel / Ordering example: **PCUB100-200**

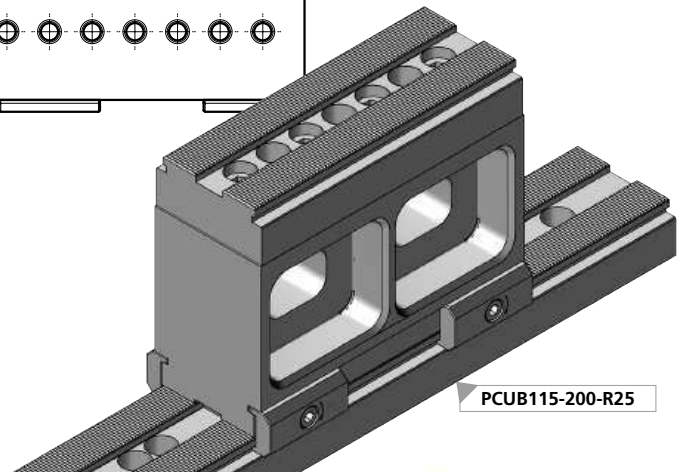
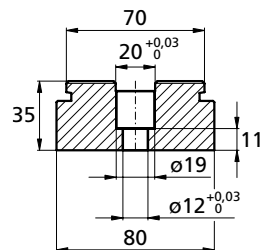
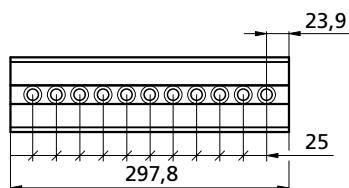




PCB25200 kg ~3,6



PCB25300 kg ~5,4



PCUB115-200-R25

PCUB115-200-R25

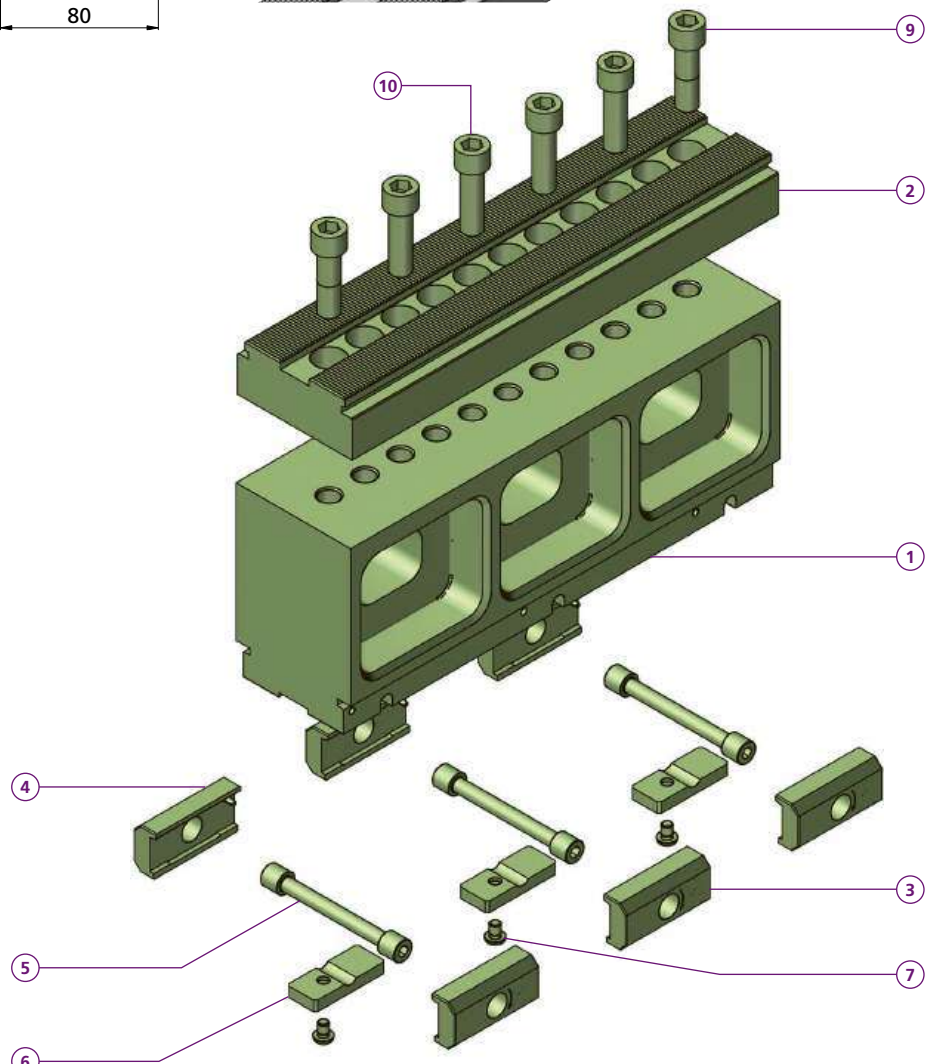
- 1x TK130323
- 1x PCB25200
- 2x PCSP60R
- 2x PCSP60L
- 2x PCS14
- 2x PCGU2049
- 2x M6X8ISO7380
- 2x TWPAS1240
- 2x M12X40ISO4762

kg ~13

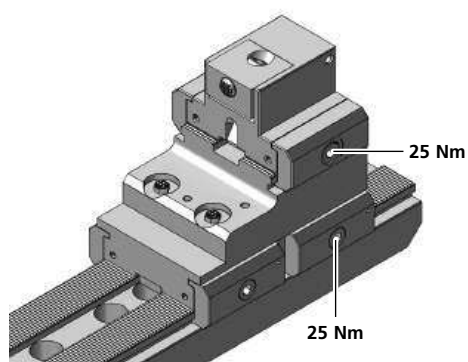
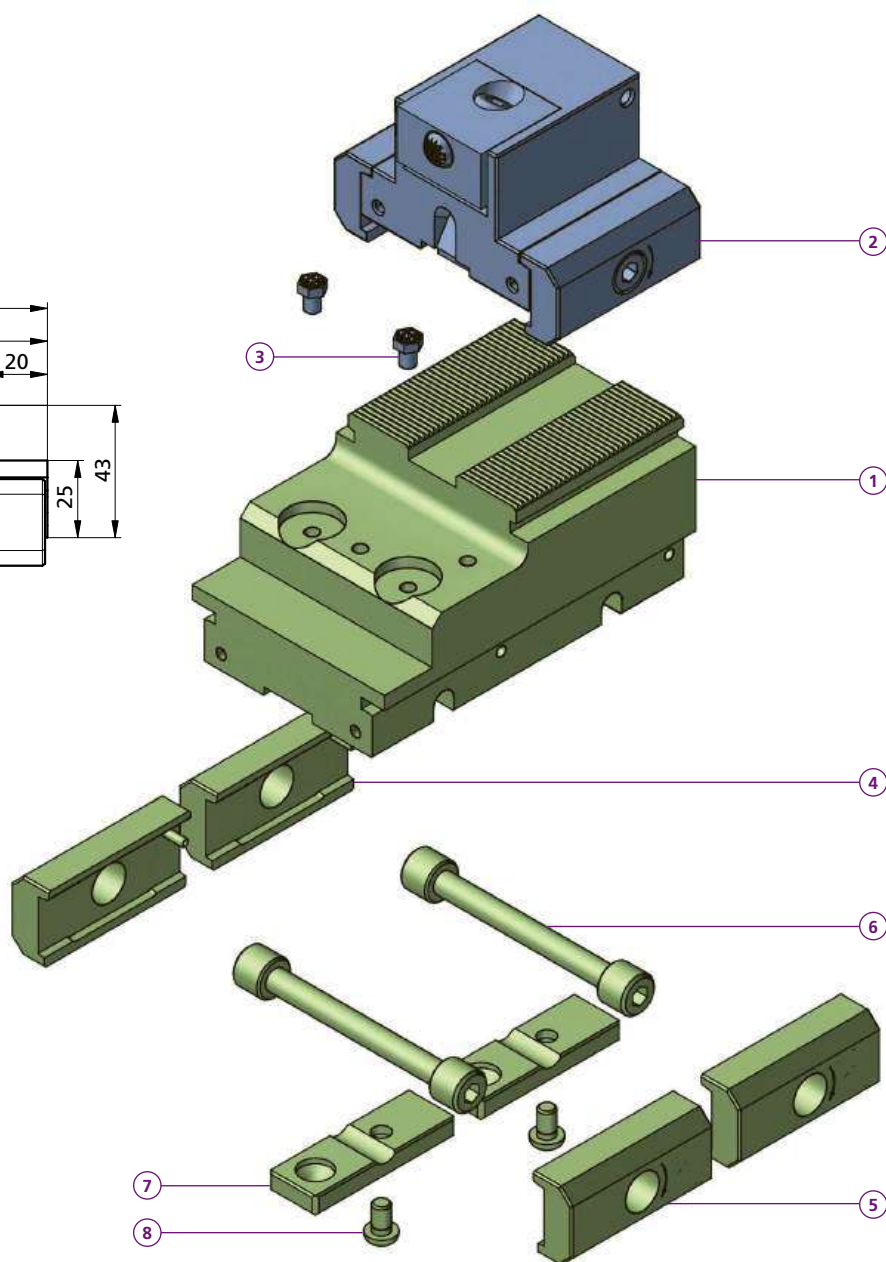
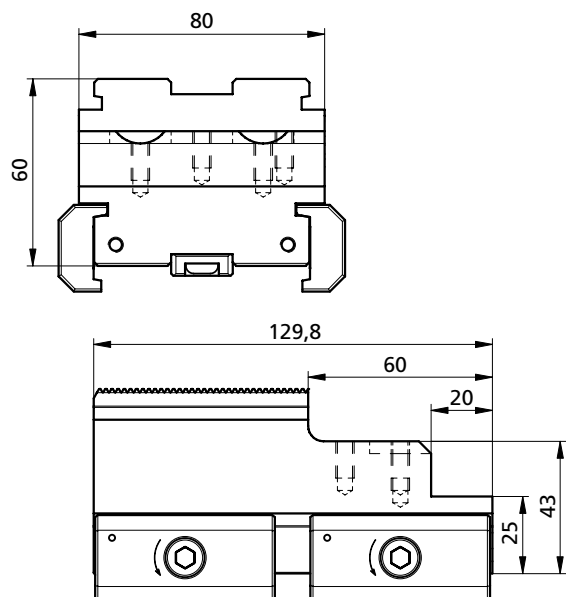
PCUB115-300-R25

- 1x TK130324
- 1x PCB25300
- 3x PCSP60R
- 3x PCSP60L
- 3x PCS14
- 3x PCGU2049
- 3x M6X8ISO7380
- 2x TWPAS1240
- 4x M12X40ISO4762

kg ~19,6



Bestellbeispiel / Ordering example: PCUB115-300-R25



PCUB60-70-130	
①	1x TK130707
②	1x PS1F43N49-60
③	2x CCHMR
④	2x PCSP60L
⑤	2x PCSP60R
⑥	2x PCS14
⑦	2x PCGU2049
⑧	2x M6X8ISO7380
kg	~4,3

p. 64

Zubehör / Accessories p. 337

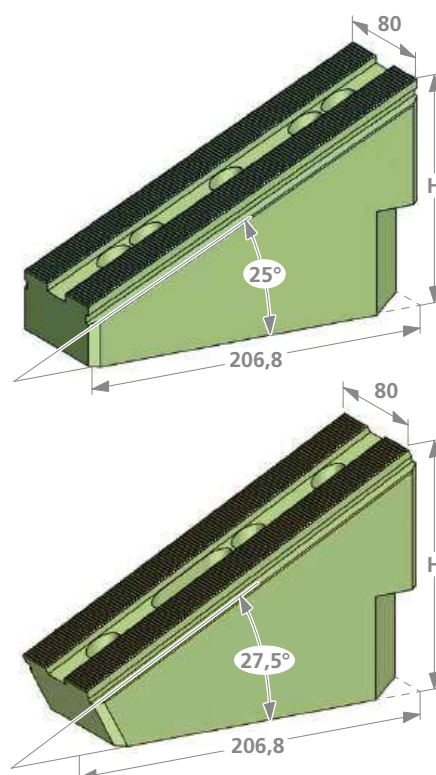
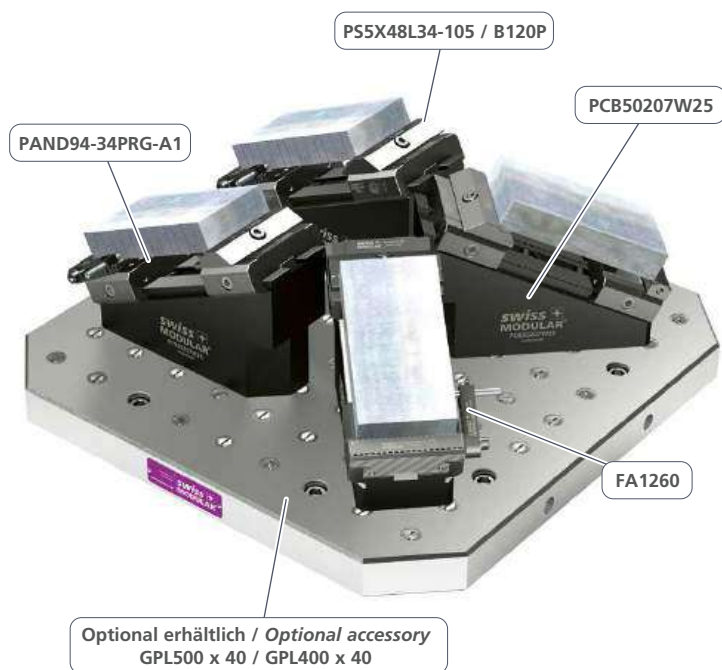
Bestellbeispiel / Ordering example: PCUB60-70-130

Separat bestellen / Order separately

Schräge Basisschiene für 5-Achsenmaschinen Slanted base rail for 5-axis machines

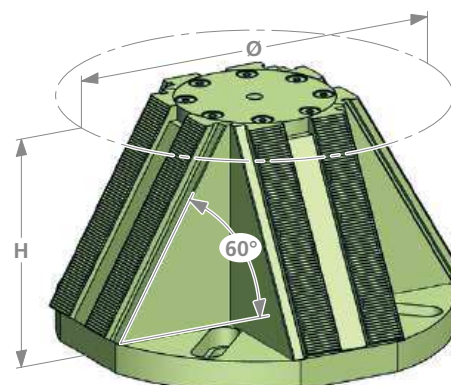
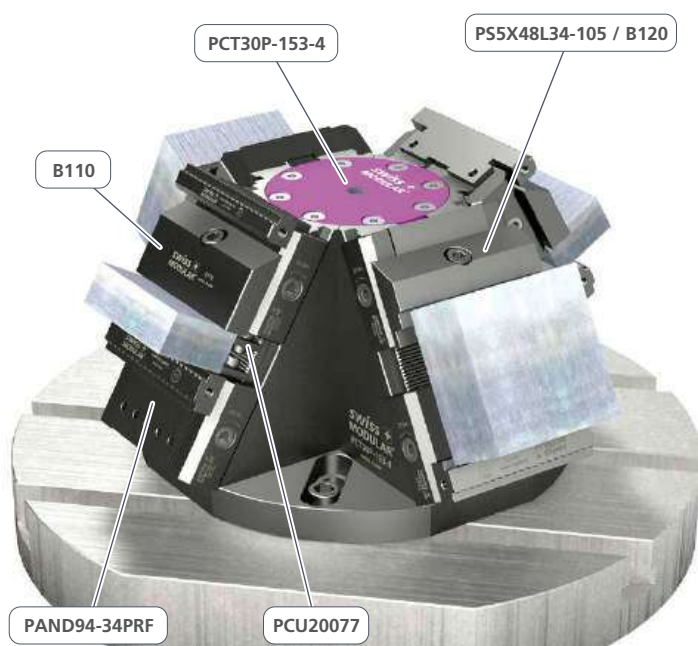
5axes
powerCLAMP

Art. Nr.	kg	Δ	H
PCB50207W25	~9,2	25°	131,5
PCB50207W27	~9,5	27,5°	139,7



Die Basisschienen können auf einem 50 mm Raster je nach Bedarf parallel oder diagonal platziert werden.
The base rails can be placed on a 50 mm grid either parallel or diagonal as required.

Art. Nr.	kg	Δ	Ø	H
PCT30P-153-4	~24	60°	266	152,4



Die Stahl-Mineralgusspyramide verfügt über eine powerCLAMP Schnittstelle und ermöglicht eine kompakte und zugleich flexible 5-Achs-Bearbeitung. Die Module werden in einem Winkel von 60° montiert. Dank dem eingesetzten Mineralguss, hat die Konstruktion ein relativ tiefes Gewicht bei einer hohen Festigkeit.
The steel mineral casting pyramid has a powerCLAMP interface and enables compact and, at the same time, flexible 5-axis machining. The modules are mounted at an angle of 60°. Due to the mineral cast used, the construction has a relatively low weight with a high rigidity.

Monobloc Balken & Gegenlager zu Teilapparat Monobloc & Counterbearing for 4th-axis

powerCLAMP

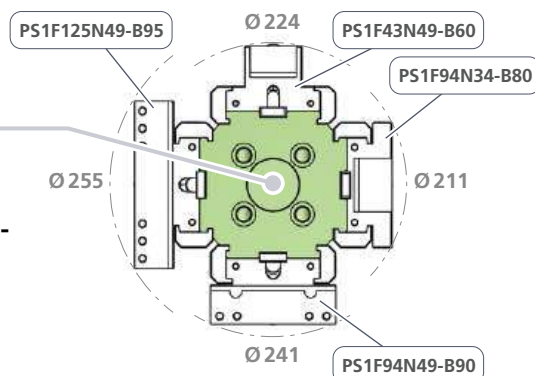
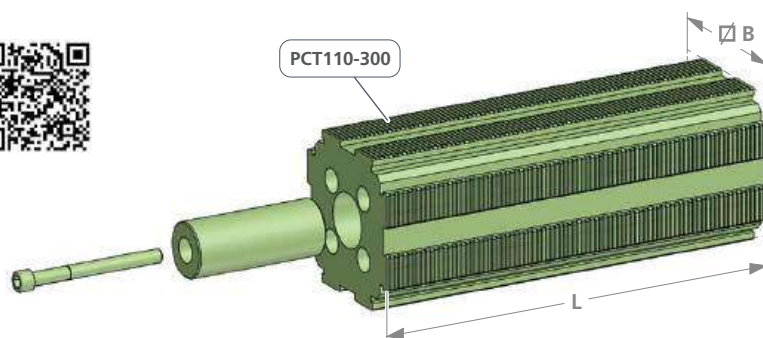
Art. Nr.	kg	L	B
PCT110-300	~24,5	300	110x110
PCT110-350	~27,5	350	110x110
PCT110-400	~31,5	400	110x110
PCT110-450	~35,5	450	110x110
PCT110-500	~39,5	500	110x110
PCT110-550	~43,0	550	110x110
PCT110-600	~47,0	600	110x110
PCT110-650	~51,0	650	110x110
PCT110-700	~55,2	700	110x110

Stahl-Mineralguss
Steel-expoxy mineral

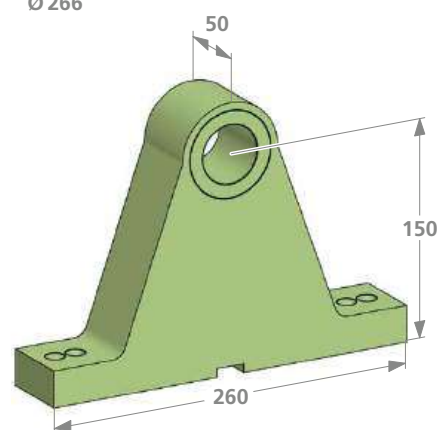
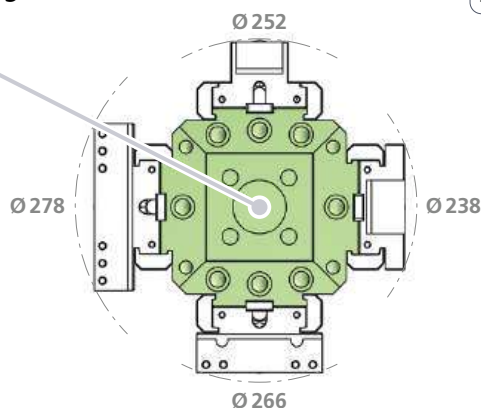
Art. Nr.	kg	L	B
PCMT150-700	~83,0	700	150x150
PCMT150-750	~89,0	750	150x150
PCMT150-800	~95,0	800	150x150
PCMT150-850	~101,0	850	150x150

Gegenlager
Counterbearing

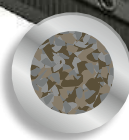
Art. Nr.	kg
PCGL15050	~8,0



Störkreise bei ver-
schiedenen Spann-
modulen
Workpiece diam-
eter with different
clamping modules



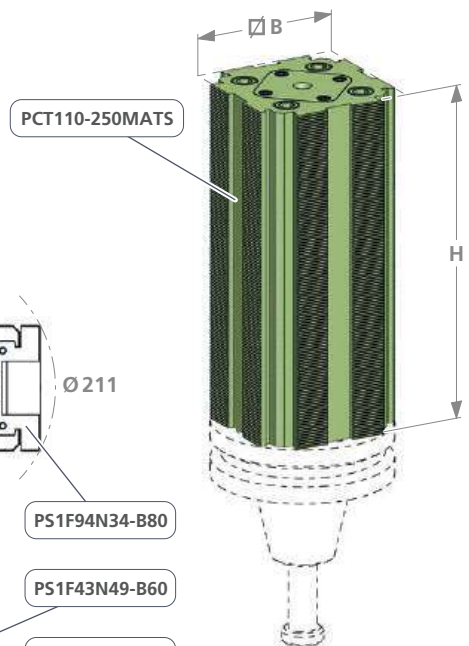
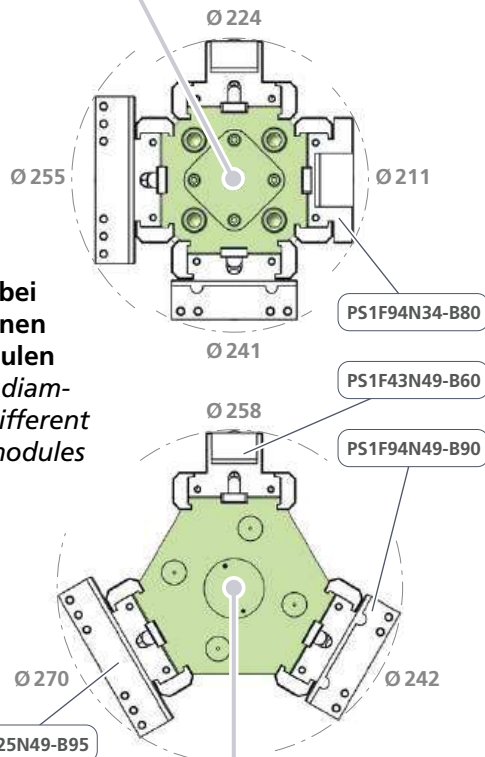
Reduziert Vibrationen und ist leicht
Reduces vibrations and is light



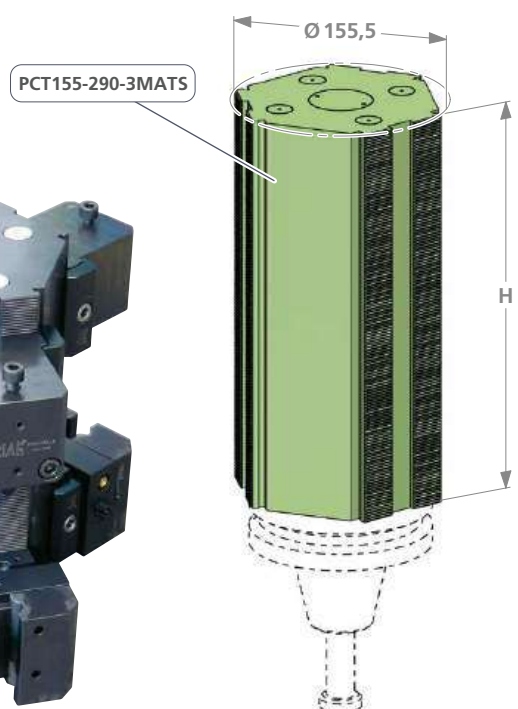
Art. Nr.	kg	H	B
PCT110-250MATS	~17	250	110x110
PCT110-300MATS	~21	300	110x110



Störkreise bei verschiedenen Spannmodulen
Workpiece diameter with different clamping modules



Art. Nr.	kg	H
PCT155-290-3MATS	~30	290



Spanntürme zu 5-Achs Bearbeitungszentren Clamping fixtures for 5 axis machines

powerCLAMP



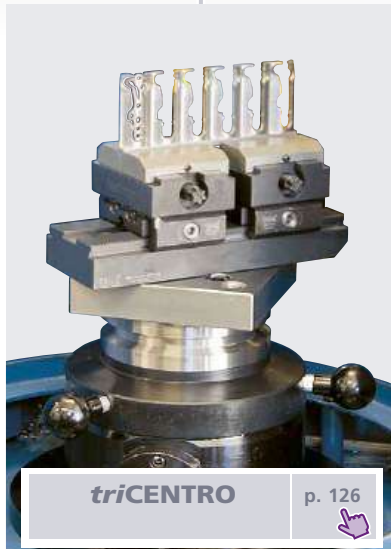
powerCLAMP

p. 81



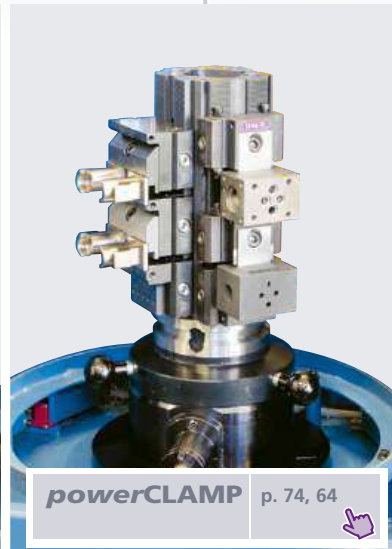
microCLAMP

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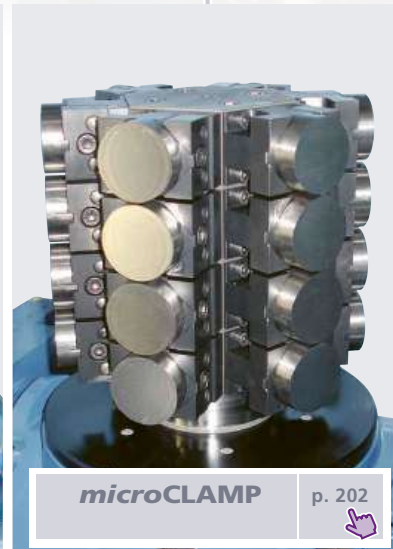
triCENTRO

p. 126



powerCLAMP

p. 74, 64



microCLAMP

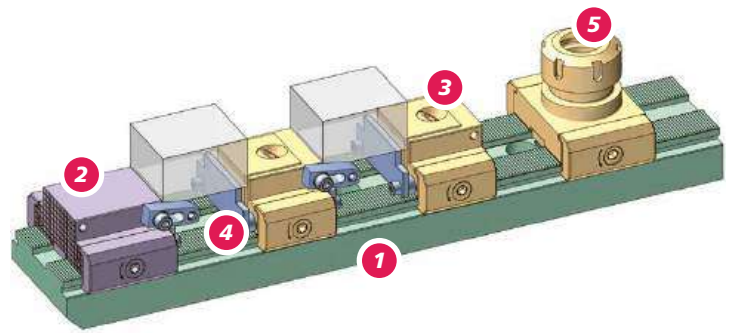
p. 202





BESTELLBEISPIEL / ORDERING EXAMPLE

1x PCSET18-450A 2x PCSET18-N3 1x PS1X50N62-ER32



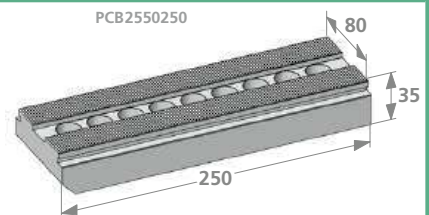
Zu jeder Basisschiene gehört 1 Anschlagmodul «Tabelle 2» nach Ihrer Wahl!
Each base rail comes with 1 end module "table 2" of your choice!

1

Basisschienen / Base-rails

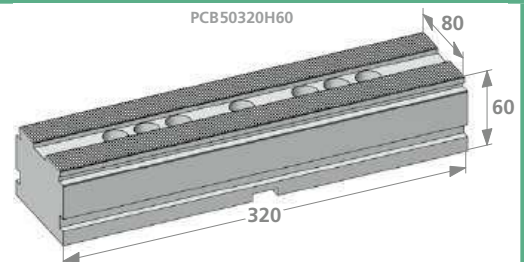
PCSET18-250A	PCB2550250	PCSET18-600A	PCB4050600
PCSET18-350A	PCB4050350	PCSET18-650A	PCB4050650
PCSET18-400A	PCB4050400	PCSET18-700A	PCB4050700
PCSET18-450A	PCB4050450	PCSET18-750A	PCB4050750
PCSET18-500A	PCB4050500	PCSET18-800A	PCB4050800
PCSET18-550A	PCB4050550		

PCB2550250



PCSET18-320B	PCB50320H60
PCSET18-400B	PCB100400H60
PCSET18-500B	PCB100500H60
PCSET18-600B	PCB100600H60
PCSET18-650B	PCB100650H60
PCSET18-690B	PCB100690H60
PCSET18-850B	PCB100850H60

PCB50320H60

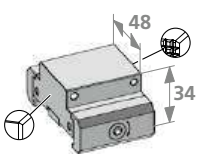


2

Anschlagmodule / End modules

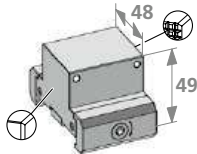
48

PAND 48-34



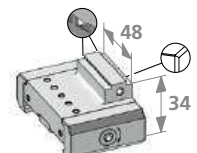
01

PAND 48-49



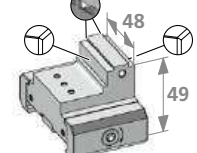
02

PAND 48-34 PRF-A1



03

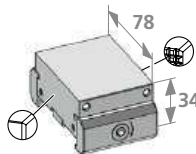
PAND 48-49 PRF-A1



04

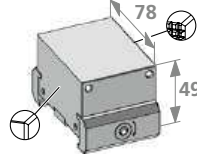
78

PAND 78-34



05

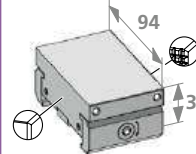
PAND 78-49



06

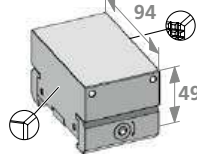
94

PAND 94-34



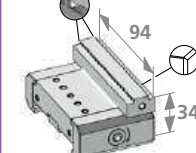
07

PAND 94-49



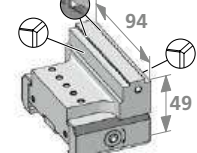
08

PAND 94-34 PRF-A1



09

PAND 94-49 PRF-A1



10

F = glatt / flat

R = geriffelt / double serrated

☉ = Direktprägebacken / Direct stamping

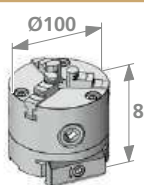


5

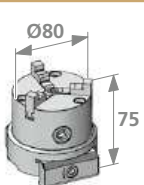
Dreibackenfutter | Spannzangenmodul | Mini-Zentrischspanner Three-jaw chuck | Collet module | Mini-self centering vise



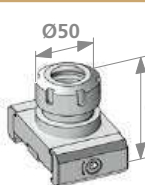
PS3X125L87BSET



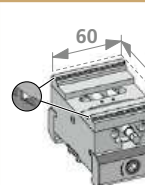
PS3X100L82BSET



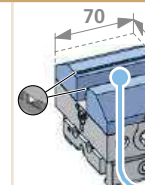
PS3X80L75BSET



PS1X50N62-ER32



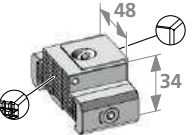
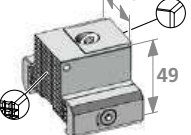
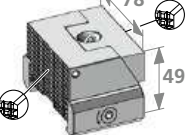
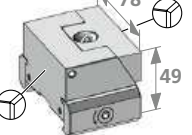
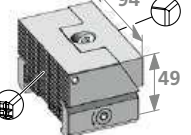
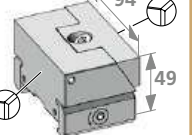
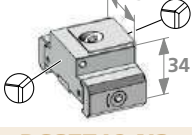
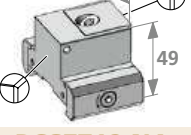
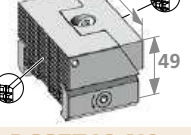
PCZ80L40PRG62



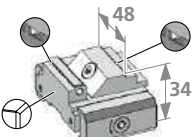
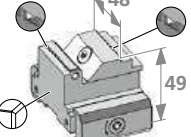
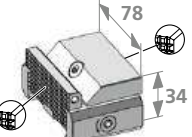
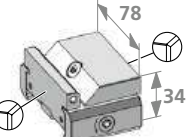
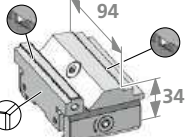
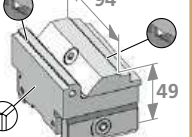
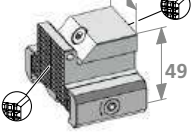
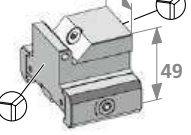
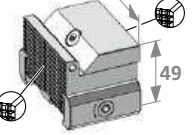
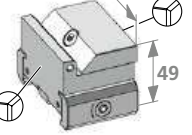
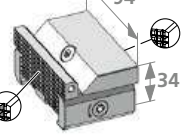
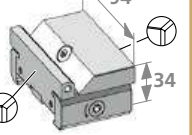
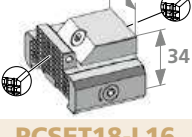
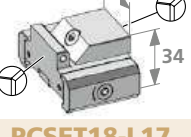
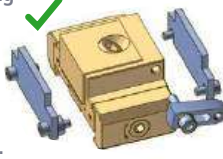
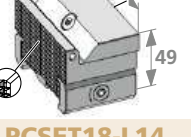
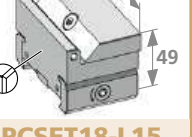
PCZ100L50



3 Niederzugspannmodule / Pull down clamp modules

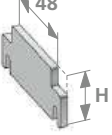
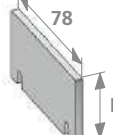
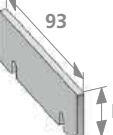
48		78		94	
PS1R48N34 B80N 	PS1R48N49 B80N 	PS1R78N49 B90R78 	PS1F78N49 B90F78 	PS1R94N49 B90 	PS1F94N49 B90 
PCSET18-N1	PCSET18-N2	PCSET18-N5	PCSET18-N6	PCSET18-N7	PCSET18-N8
PS1F48N34 B80N 	PS1F48N49 B80N 	F = glatt / flat R = geriffelt / double serrated = Direktprägebacken / Direct stamping		PS1R94N49 B93 	
PCSET18-N3	PCSET18-N4			PCSET18-N9	

Linearspannmodule / Linear clamp modules

PS1PF48L34 B115P 	PS1PF48L49 B115P 	PS1R78L34 B141 	PS1F78L34 B140 	PS1PF94L34 B120P 	PS1PF94L49 B120P 
PCSET18-L1	PCSET18-L2	PCSET18-L5	PCSET18-L6	PCSET18-L9	PCSET18-L11
PS1R48L49 B106 	PS1F48L49 B105 	PS1R78L49 B141 	PS1F78L49 B140 	PS1R94L34 B111 	PS1F94L34 B110 
PCSET18-L3	PCSET18-L4	PCSET18-L7	PCSET18-L8	PCSET18-L12	PCSET18-L13
PS1R48L34 B106 	PS1F48L34 B105 	Bei jedem Niederzug und Linear Spannmodul sind 2 Parallelunterlagen nach Ihrer Wahl und 1 Fränschlag enthalten. 		PS1R94L49 B111 	PS1F94L49 B110 
PCSET18-L16	PCSET18-L17			PCSET18-L14	PCSET18-L15

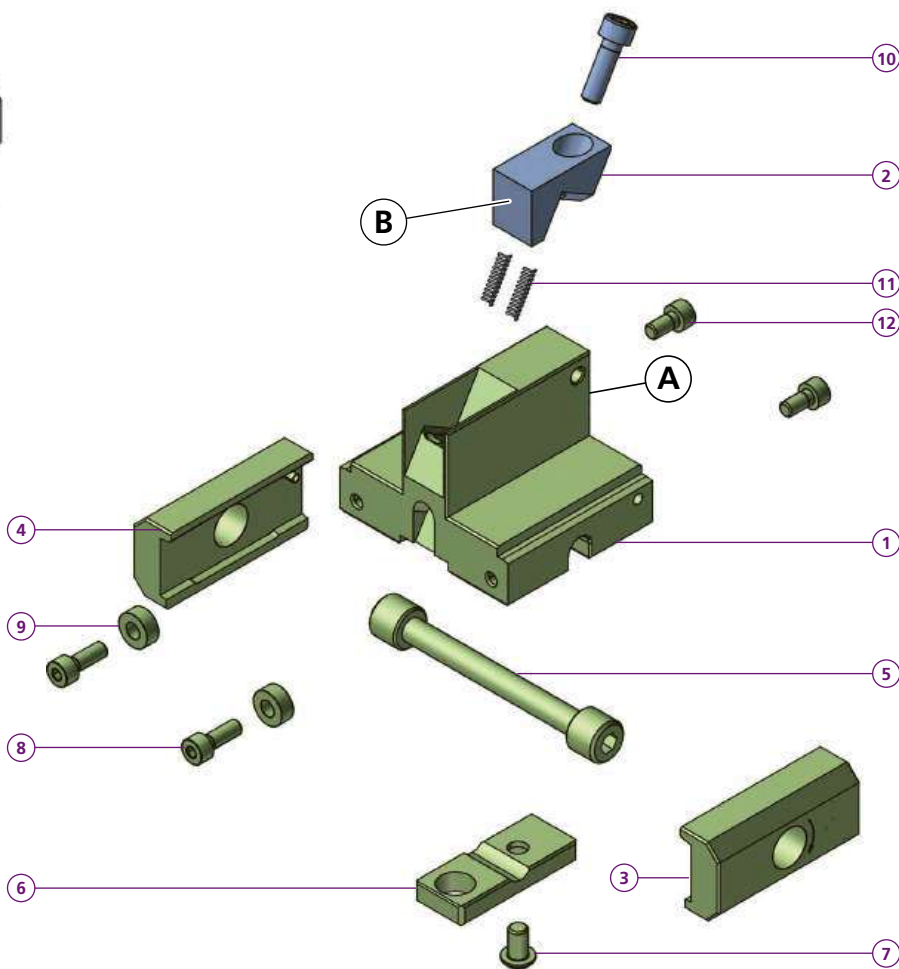
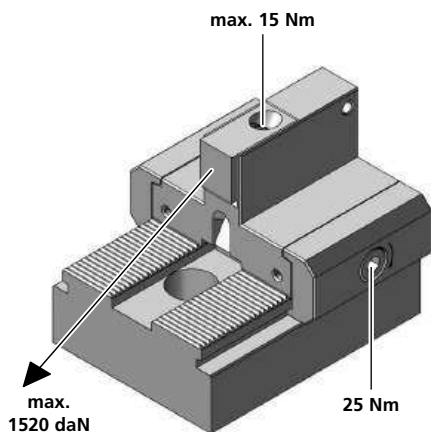
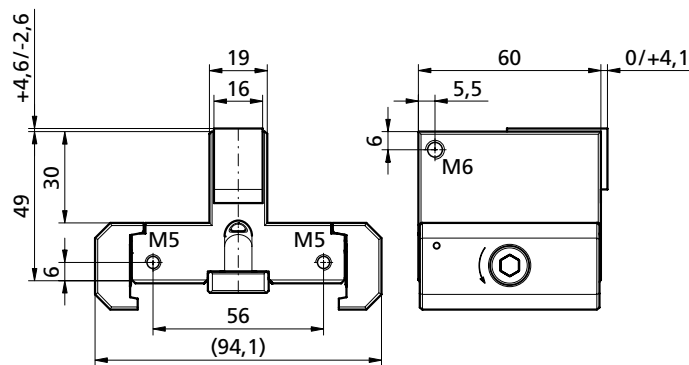
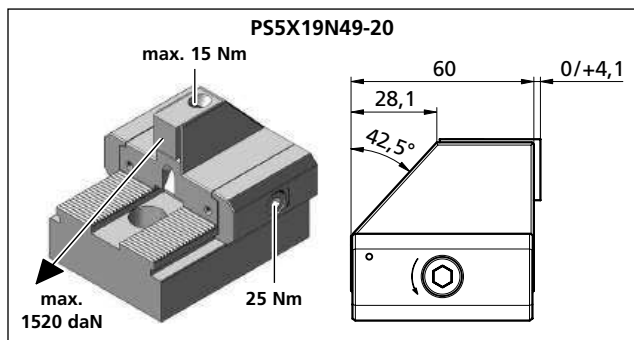
Each pull-down and linear clamping module includes 2 parallels of your choice and 1 milling buffer.

4 Parallelunterlagen / Steel parallels

48	78	94
PCU29047  H PCU 20 047 PCU 24 047 PCU29047 PCU 31 047 PCU 34 047 PCU 39 047 PCU 44 047 PCU 46 047 B48- ...	PCU39077  H PCU 20 077 PCU 24 077 PCU 29 077 PCU 31 077 PCU 34 077 PCU39077 PCU 44 077 B78- ...	PCU29093  H PCU 14 093 PCU 20 093 PCU 24 093 PCU29093 PCU 31 093 PCU 34 093 PCU 39 093 PCU 44 093 PCU 46 093 PCU 47 093 B94- ...

Fränschlag / Milling buffer  1 x Inklusive / Included

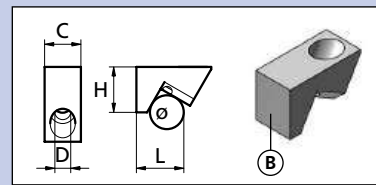




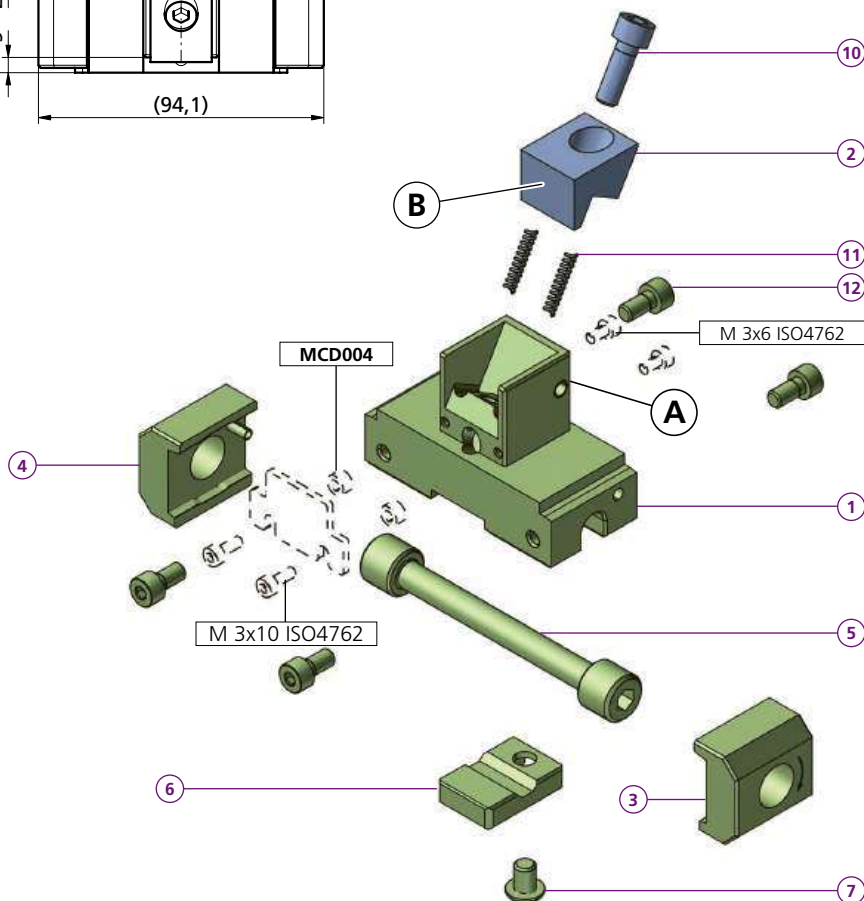
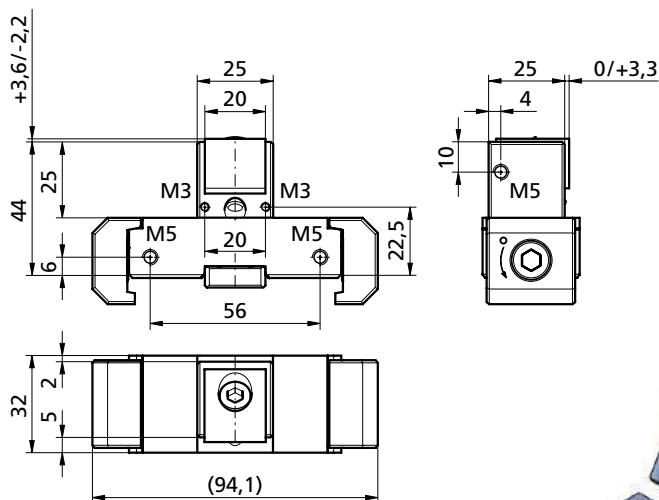
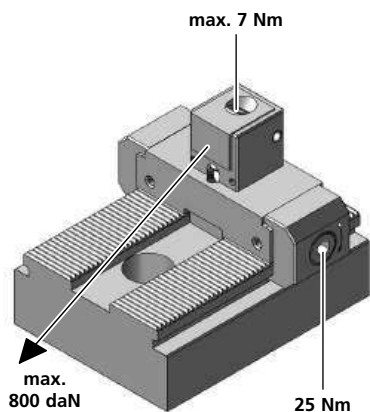
	PS5X19N49-20
1	1x TF140449
9	2x PCD005
8	2x M5X14ISO4762
kg	~1,1
	PS1F19N49-20
1	1x TF150961
	PS1R19N49-20
1	1x TF140448
2	1x
3	1x PCSP60R
4	1x PCSP60L
5	1x PCS14
6	1x PCGU2049
7	1x M6X8ISO7380
8	2x M5X14ISO4762
9	2x PCD005
10	1x M6X20ISO4762
11	2x FED0418
12	2x M5X10ISO4762
kg	~1,2

	B20	B21	B22
C	16	16	16
H	20	20	20
L	19	19	19
D	6,5	6,5	6,5
ø	12	12	12
i	HV700	HV700	*
	x0,2mm	x0,2mm	
kg	~0,06	~0,06	~0,06

Bestellbeispiel / Ordering example: 1x **PS1R19N49-20** & 1x **B21**

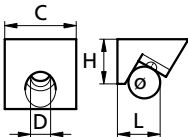


Separat bestellen / Order separately

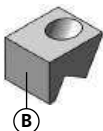


PS1F25N44-13	
1	1x TF150960
PS1R25N44-13	
1	1x TF140450
2	1x
3	1x PCSP30R
4	1x PCSP30L
5	1x PCS14
6	1x PCGU2030
7	1x M6X8ISO7380
10	1x M6X16ISO4762
11	2x FED03018
12	4x M5X10ISO4762
kg	~0,6

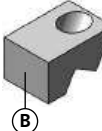
Bestellbeispiel / Order				
				
B13	B14	B15	B16	
C	20	20	20	20
H	16	16	16	16
L	13,8	13,8	13,8	19
D	6,5	6,5	6,5	6,5
e	10	10	10	10
i	HV700	HV700	*	*
	x0,2mm	x0,2mm		
kg	~0,05	~0,05	~0,05	~0,06



B13, B14, B15

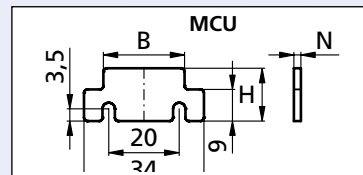


B16



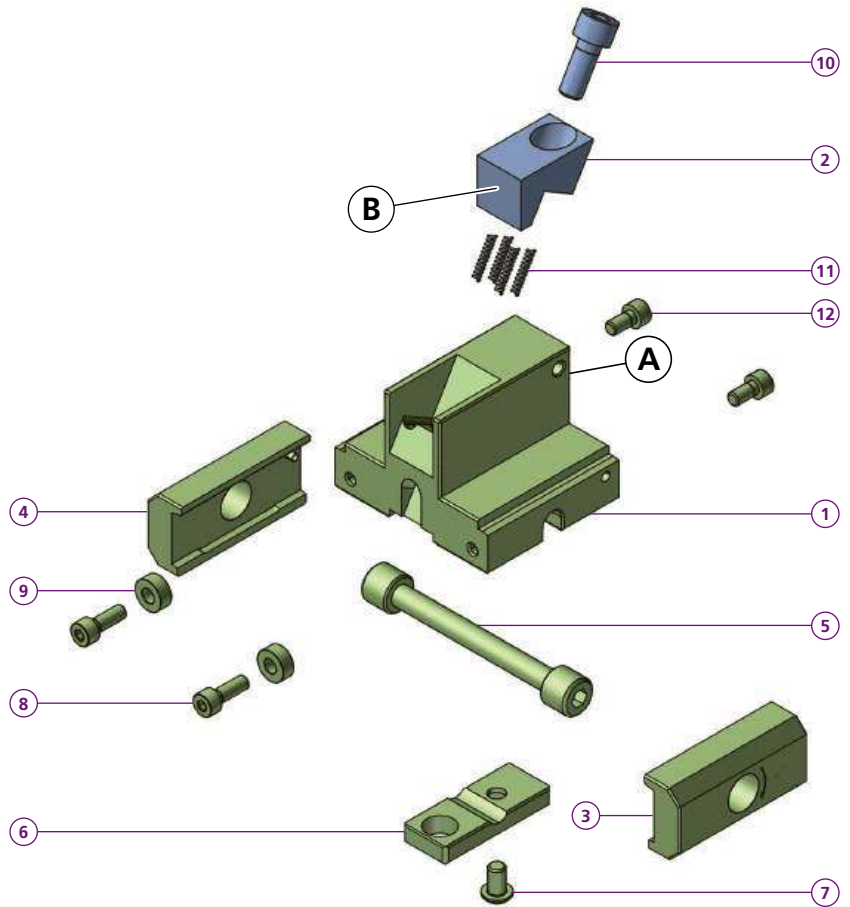
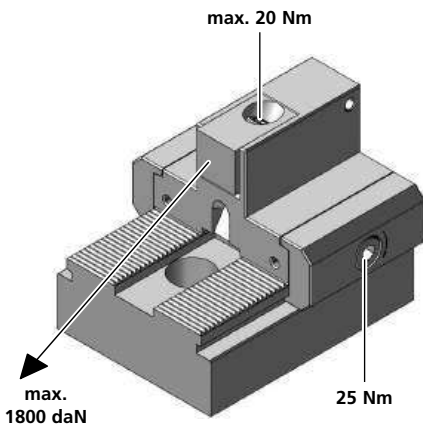
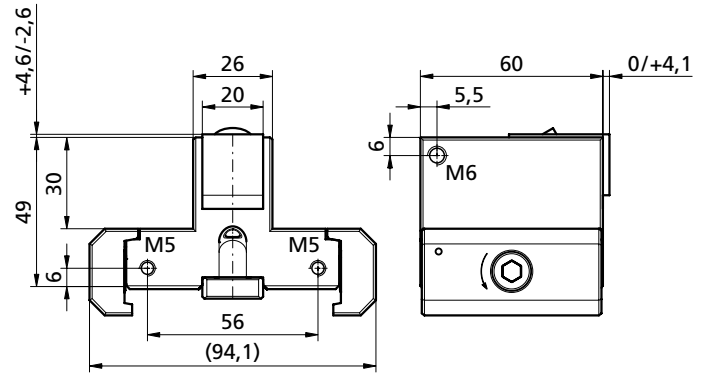
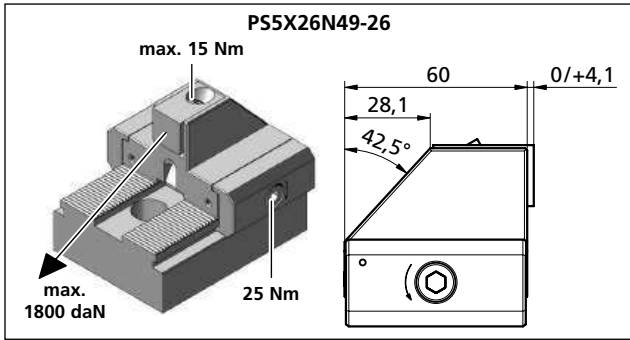
	H	B	N	kg
MCU11037	11	23	2	~0,004
MCU15037	15	23	2	~0,006
MCU18037	18	23	2	~0,008
MCU20037	20	23	2	~0,008
MCU22537	22,5	23	2	~0,008

2x M3X10ISO4762
2x M3X6ISO4762
2x MCD004



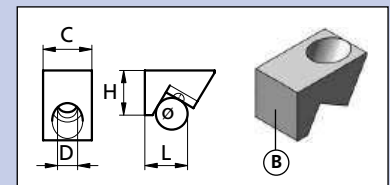
* = weicher Stahl / soft steel

Separat bestellen / Order separately



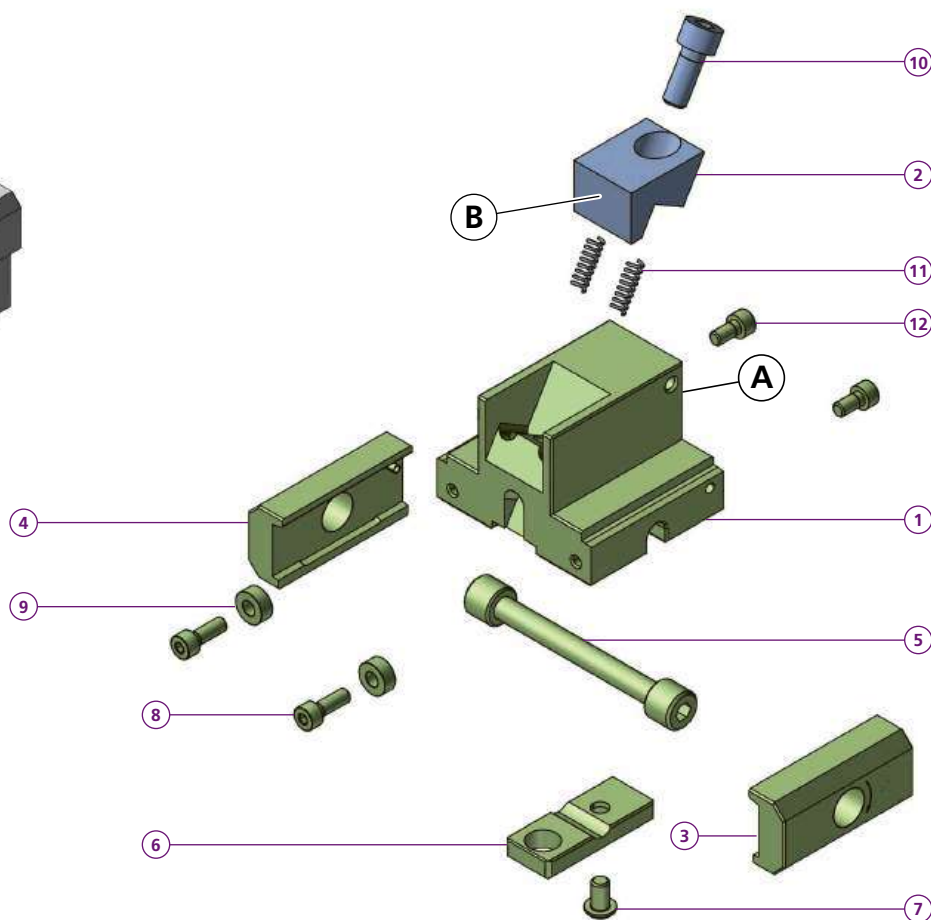
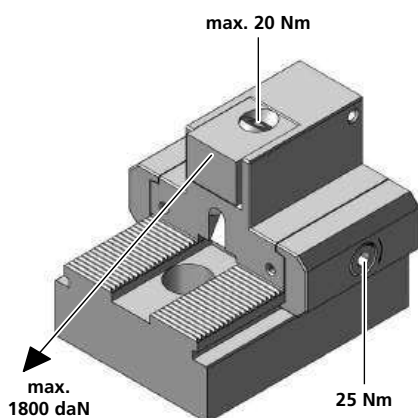
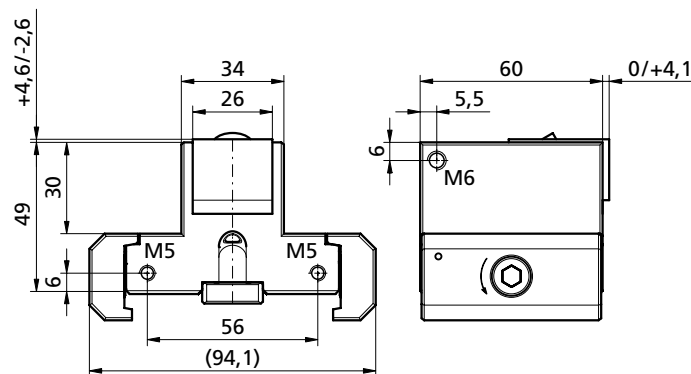
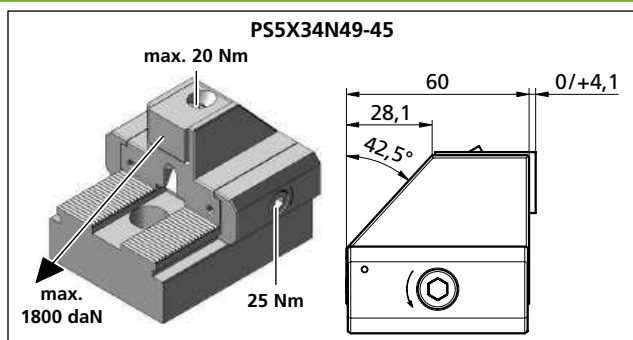
PS5X26N49-26	
1	1x TF140453
9	2x PCD005
8	2x M5X14ISO4762
kg	~1,1
PS1F26N49-26	
1	1x TF140451
PS1R26N49-26	
1	1x TF140452
2	1x
3	1x PCSP60R
4	1x PCSP60L
5	1x PCS14
6	1x PCGU2049
7	1x M6X8ISO7380
8	2x M5X14ISO4762
9	2x PCD005
10	1x M8X20ISO4762
11	4x FED0418
12	2x M5X10ISO4762
kg	~1,2

Bestellbeispiel / Ordering example: 1x PS1R26N49-26 & 1x B26		
	B26	B27
C	20	20
H	20	20
L	19	19
D	9	9
ø	12	12
i	HV700	HV700
	x0,2mm	x0,2mm
kg	~0,07	~0,07
		B28
		20
		20
		19
		9
		12
		*
		~0,07



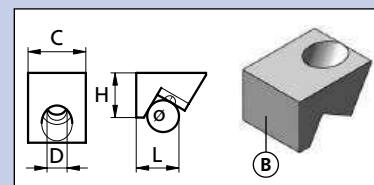
PS1R/F34N49-45

PS5X34N49-45



PS5X34N49-45	
1x TF140455	
2x PCD005	
2x M5X14ISO4762	
kg	~1,2
PS1F34N49-45	
1x TF191071	
PS1R34N49-45	
1x TF140454	
1x	
1x PCSP60R	
1x PCSP60L	
1x PCS14	
1x PCGU2049	
1x M6X8ISO7380	
2x M5X14ISO4762	
2x PCD005	
1x M8X20ISO4762	
2x FED0618	
2x M5X10ISO4762	
kg	~1,3

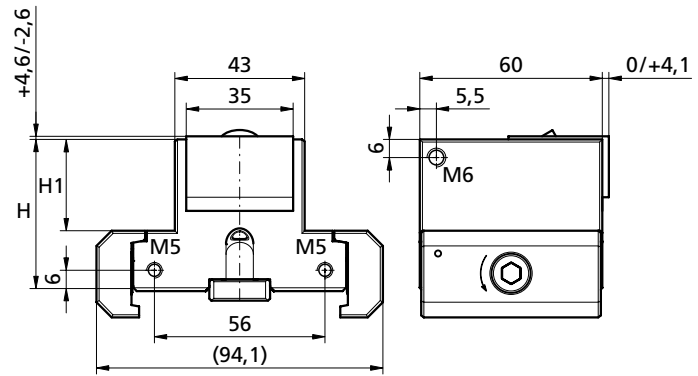
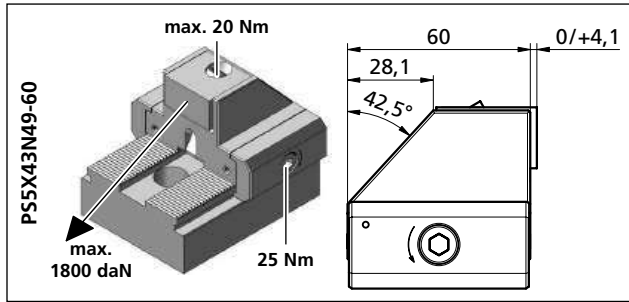
Bestellbeispiel / Ordering example: 1x PS5X34N49-45 & 1x B47HM				
	B45	B46	B47	B47HM
C	26	26	26	26
H	20	20	20	20
L	19	19	19,1	19,1
D	9	9	9	9
ø	12	12	12	12
i	HV700	HV700	*	HM
	x0,2mm	x0,2mm		
kg	~0,1	~0,1	~0,1	~0,1



* = weicher Stahl / soft steel

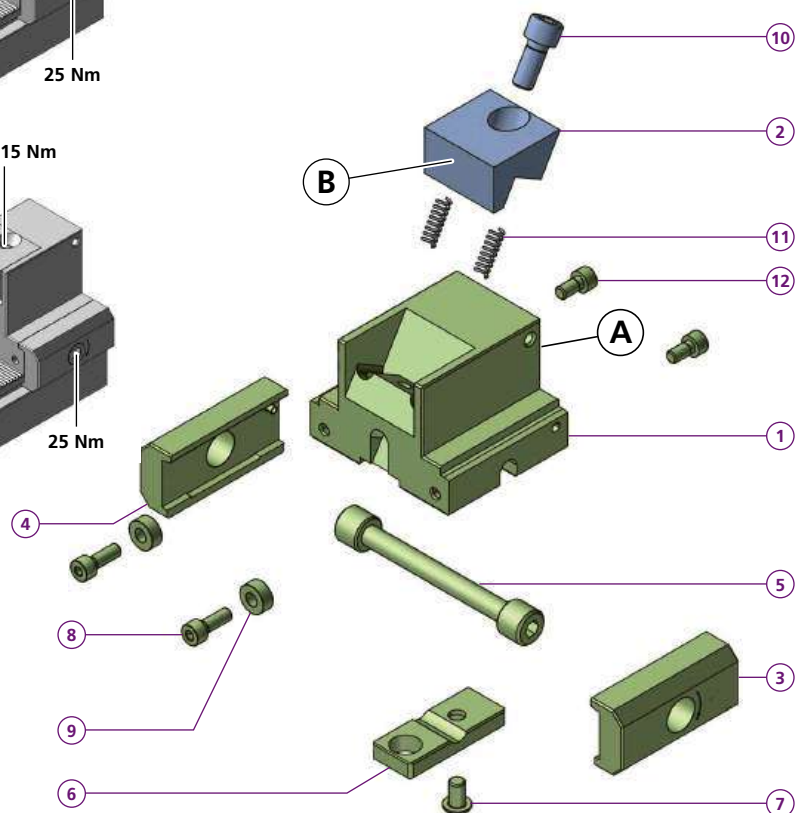
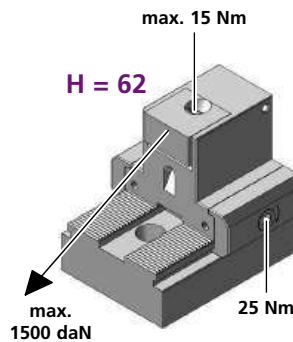
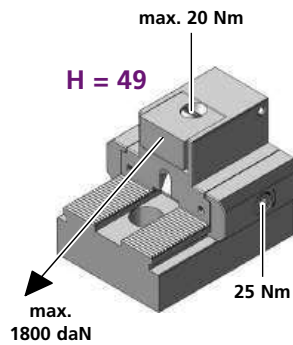
HM = Hartmetallbeschichtet / Carbide coated

Separat bestellen / Order separately



PS5X43N49-60	
1x TF140458	
2x PCD005	
2x M5X14ISO4762	
kg ~1,3	
PS1F43N49-60	
1x TF140456	
PS1R43N49-60	
1x TF140457	
1x PCSP60R	
1x PCSP60L	
1x PCS14	
1x PCGU2049	
1x M6X8ISO7380	
2x M5X14ISO4762	
2x PCD005	
1x M8X20ISO4762	
2x FED0618	
2x M5X10ISO4762	
H = 49	
H1 = 30	
kg ~1,4	

PS1F43N62-60	
1x TF140459	
PS1R43N62-60	
1x TF140460	
H = 62	
H1 = 43	
kg ~1,7	



Bestellbeispiel / Ordering example: 1x PS1R43N49-60 & 1x B61

Bestellbeispiel / Ordering example: 1x PS1R43N49-60 & 1x B61													
	B58	B60	B61	B62	B62HM	B65	B66	B67	B68	B69	B77	B79F	B79R
C	35	35	35	35	35	35	35	35	35	35	35	35	35
H	20	20	20	20	20	20	20	20	20	25	20	20	20
L	26	19	19	19	19	19	19	24	26	22	22	25	25
D	9	9	9	9	9	9	9	9	9	9	9	9	9
o	12	12	12	12	12	12	12	12	12	12	12	12	12
i	ALU	56HRC	56HRC	*	HM	HV700 x0,2mm	HV700 x0,2mm	HV700 x0,2mm	*	*	56HRC	HV700 x0,2mm	HV700 x0,2mm
kg	~0,07	~0,12	~0,12	~0,12	~0,12	~0,12	~0,12	~0,14	~0,15	~0,15	~0,12	~0,18	~0,18

B69
M5X10ISO4762

+11,5/-0,7 0/+7

FED 0628

B58

B60, B61, B62, B62HM

B65, B66, B67

B68

B77

B79F, B79R

C

H

D

L

B

6

3xM6 (CCHMR)

12

12

B

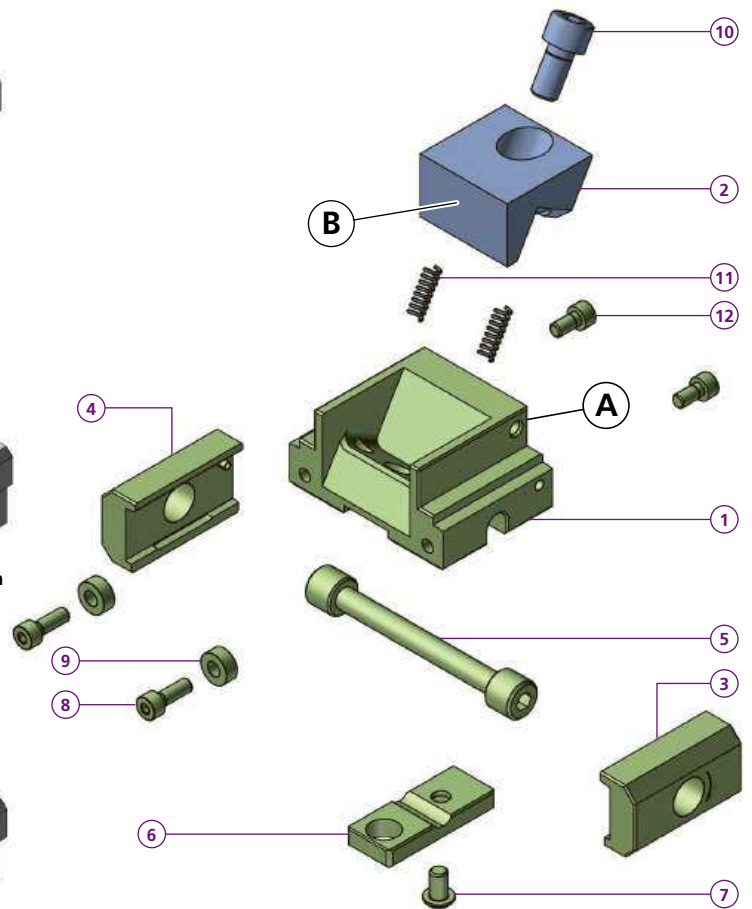
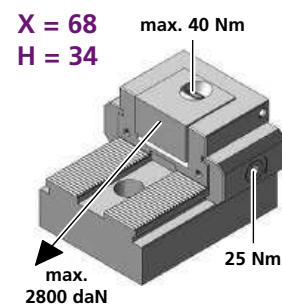
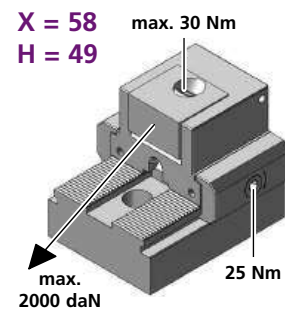
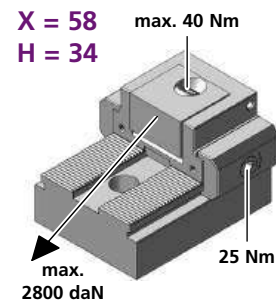
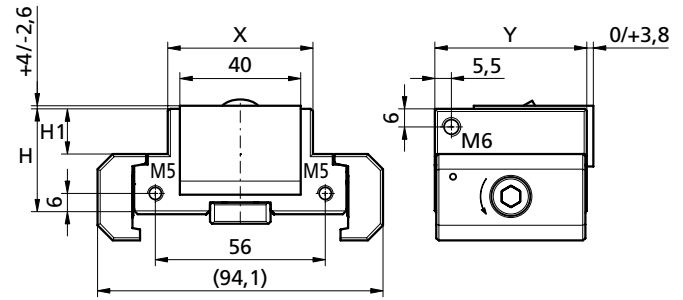
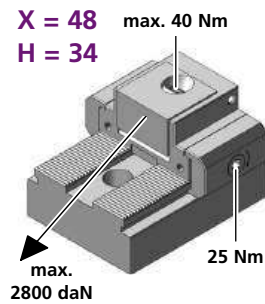
± 9°

Spannbacke mit CCPDR
Jaw with CCPDR

B

± 4°

B

**PS1F48N34-80**

① 1x TF140461

PS1R48N34-80

① 1x TF140462

② 1x

③ 1x PCSP50R

④ 1x PCSP50L

⑤ 1x PCS14

⑥ 1x PCGU2049

⑦ 1x M6X8ISO7380

⑧ 2x M5X14ISO4762

⑨ 2x PCD005

⑩ 1x M10X25ISO4762

⑪ 2x FED0618

⑫ 2x M5X10ISO4762

X = 48

H = 34

H1 = 15

Y = 50

kg ~0,9

PS1F58N34-80

① 1x TF140463

PS1R58N34-80

① 1x TF140464

X = 58

H = 34

H1 = 15

Y = 50

kg ~0,9

PS1R58N49-80

① 1x TK120129

③ 1x PCSP60R

④ 1x PCSP60L

X = 58

H = 49

H1 = 30

Y = 60

kg ~1,6

PS1F68N34-80

① 1x TF140465

PS1R68N34-80

① 1x TF140466

X = 68

H = 34

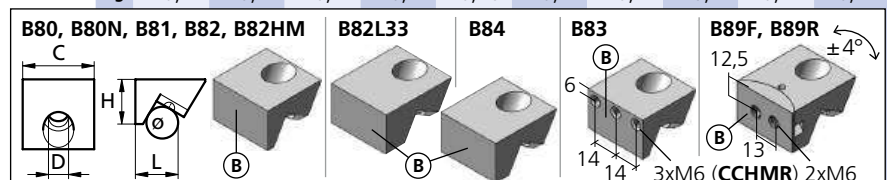
H1 = 15

Y = 50

kg ~1,0

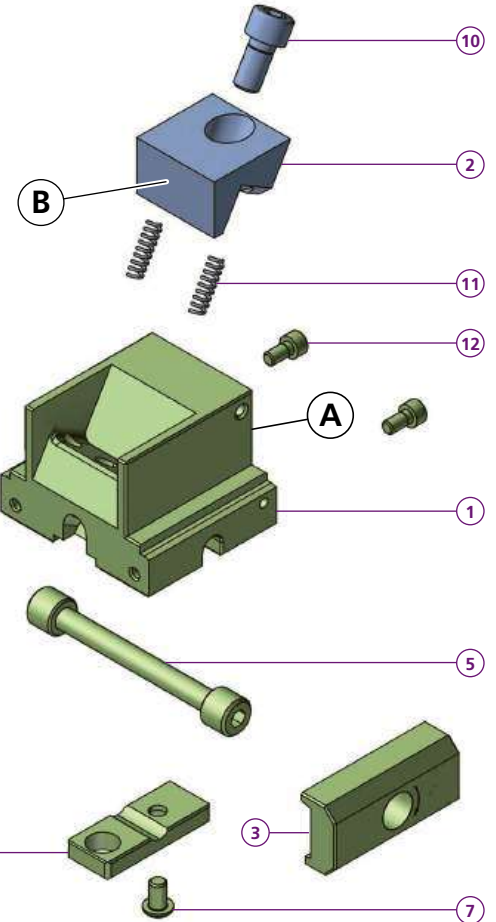
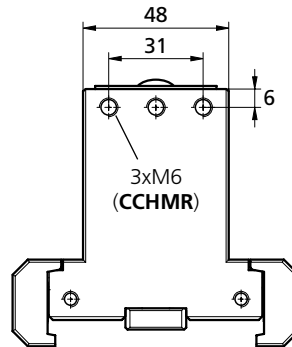
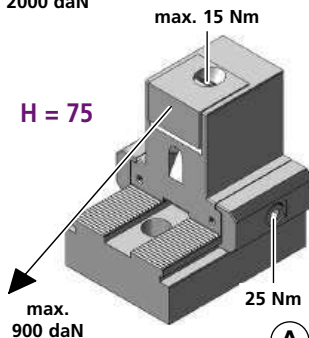
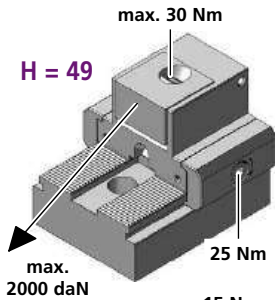
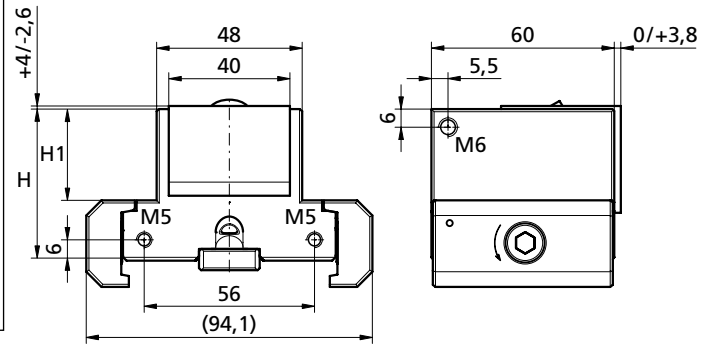
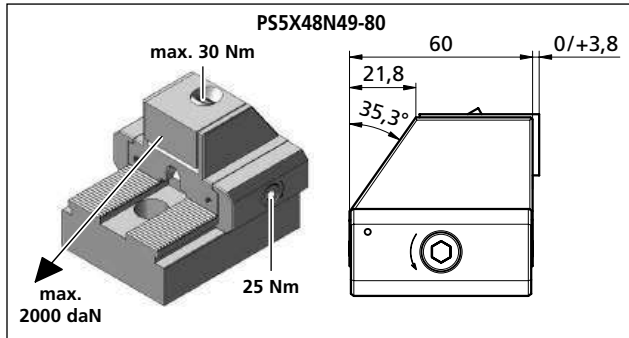
Bestellbeispiel / Ordering example: 1x **PS1F68N34-80** & 1x **B82HM**

	B80	B80N	B81	B82	B82L33	B82HM	B83	B84	B89F	B89R
C	40	40	40	40	40	40	40	40	40	40
H	25	25	25	25	25	25	25	25	25	25
L	22	22	22	22,2	33	22,2	22	26,3	29	29
D	11	11	11	11	11	11	11	11	11	11
e	15	15	15	15	15	15	15	15	15	15
i	56HRC	HV700 x0,2mm	56HRC	*	*	56HRC	HV700 x0,2mm	*	HV700 x0,2mm	HV700 x0,2mm
kg	~0,2	~0,2	~0,2	~0,2	~0,28	~0,2	~0,2	~0,2	~0,24	~0,24



* = weicher Stahl / soft steel

HM = Hartmetallbeschichtet / Carbide coated

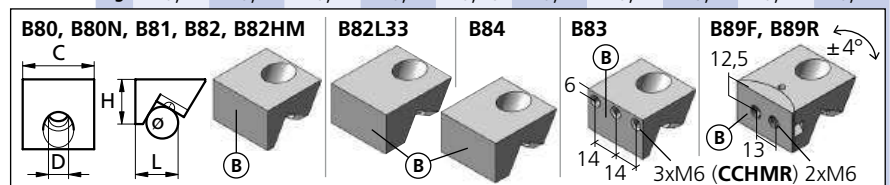


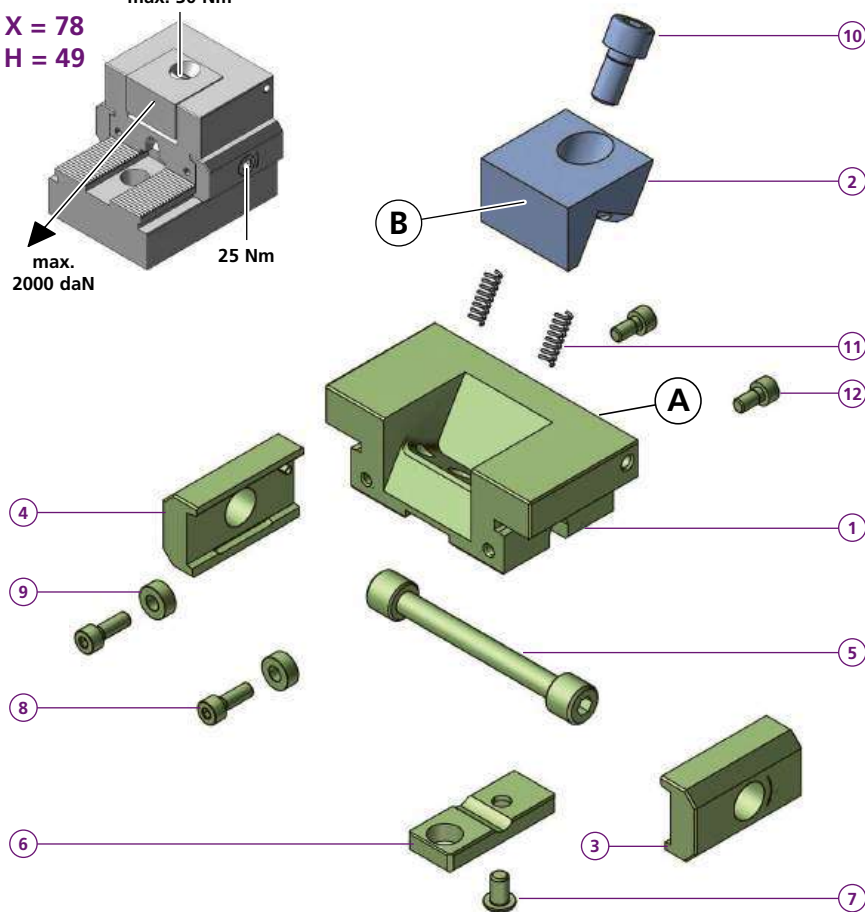
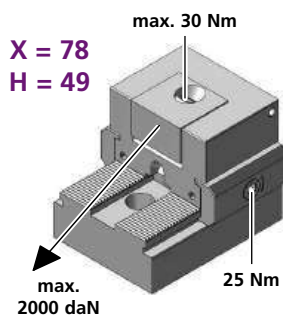
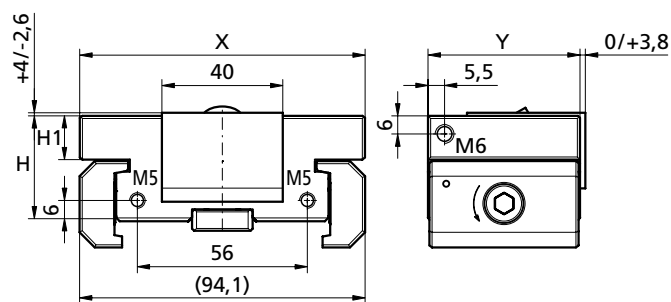
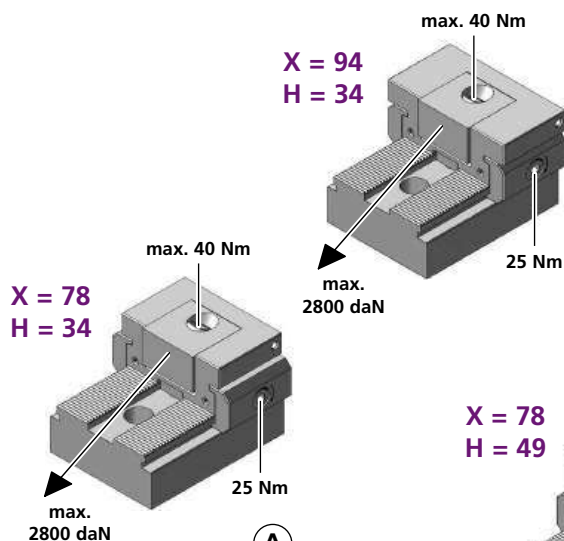
PS5X48N49-80	
1	1x TF140469
9	2x PCD005
8	2x M5X14ISO4762
kg	~1,3
PS1F48N49-80	
1	1x TF140467
PS1R48N49-80	
1	1x TF140468
2	1x
3	1x PCSP60R
4	1x PCSP60L
5	1x PCS14
6	1x PCGU2049
7	1x M6X8ISO7380
8	2x M5X14ISO4762
9	2x PCD005
10	1x M10X25ISO4762
11	2x FED0618
12	2x M5X10ISO4762
H	= 49
H1	= 30
kg	~1,4

PS1R48N75-80	
1	1x TF140471
H	= 75
H1	= 56
kg	~2,0

Bestellbeispiel / Ordering example: 1x PS1F48N49-80 & 1x B80

	B80	B80N	B81	B82	B82L33	B82HM	B83	B84	B89F	B89R
C	40	40	40	40	40	40	40	40	40	40
H	25	25	25	25	25	25	25	25	25	25
L	22	22	22	22,2	33	22,2	22	26,3	29	29
D	11	11	11	11	11	11	11	11	11	11
ø	15	15	15	15	15	15	15	15	15	15
i	56HRC	HV700 x0,2mm	56HRC	*	*	56HRC	HV700 x0,2mm	*	HV700 x0,2mm	HV700 x0,2mm
kg	~0,2	~0,2	~0,2	~0,2	~0,28	~0,2	~0,2	~0,2	~0,24	~0,24

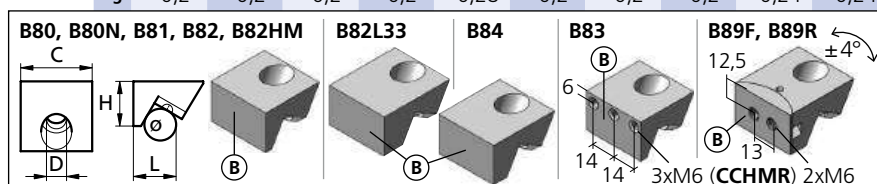




PS1F78N34-80		
1	1x TF140472	
PS1R78N34-80		
1	1x TF140473	
2	1x	
3	1x PCSP50R	
4	1x PCSP50L	
5	1x PCS14	
6	1x PCGU2049	
7	1x M6X8ISO7380	
8	2x M5X14ISO4762	
9	2x PCD005	
10	1x M10X25ISO4762	
11	2x FED0618	
12	2x M5X10ISO4762	
X	= 48	
H	= 34	
H1	= 15	
Y	= 50	
kg	~1,1	

PS1F78N49-80		
1	1x TF140474	
PS1R78N49-80		
1	1x TF140475	
3	1x PCSP60R	
4	1x PCSP60L	
X	= 78	
H	= 49	
H1	= 30	
Y	= 60	
kg	~1,8	

	Bestellbeispiel / Ordering example: 1x PS1R94N34-80 & 1x B80									
										
B80										
B80N										
B81										
B82										
B82L33										
B82HM										
B83										
B84										
B89F										
B89R										
C	40	40	40	40	40	40	40	40	40	40
H	25	25	25	25	25	25	25	25	25	25
L	22	22	22	22,2	33	22,2	22	26,3	29	29
D	11	11	11	11	11	11	11	11	11	11
e	15	15	15	15	15	15	15	15	15	15
i	56HRC	HV700	56HRC	*	*	56HRC	HV700	*	HV700	HV700
		x0,2mm					x0,2mm		x0,2mm	x0,2mm
kg	~0,2	~0,2	~0,2	~0,2	~0,28	~0,2	~0,2	~0,2	~0,24	~0,24



* = weicher Stahl / soft steel

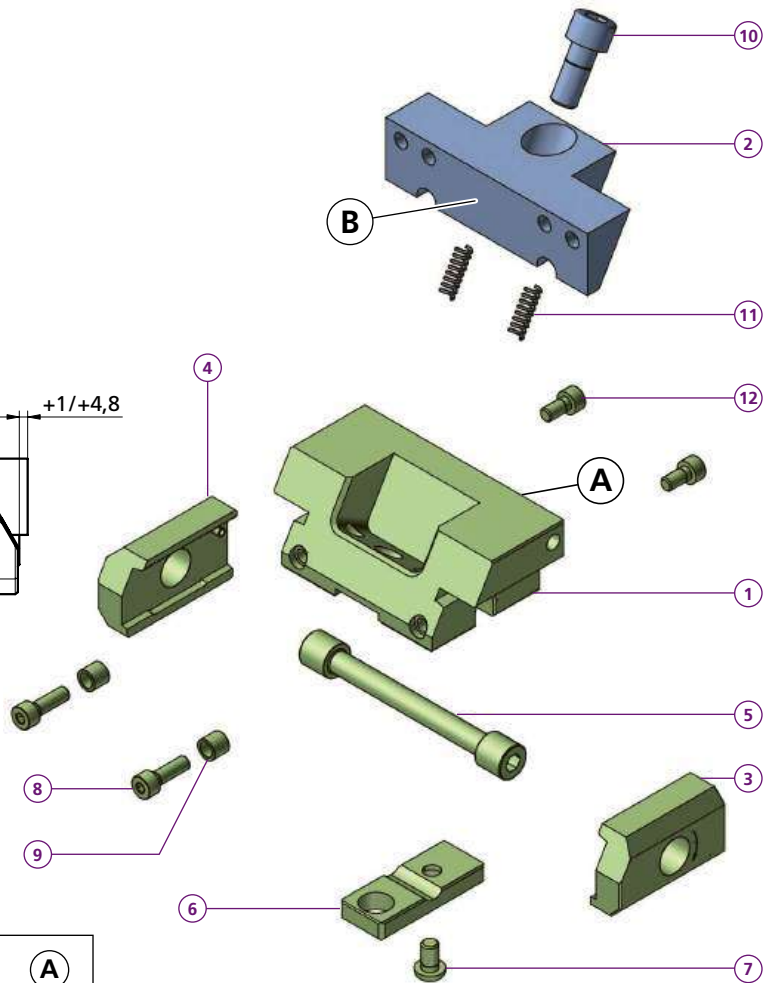
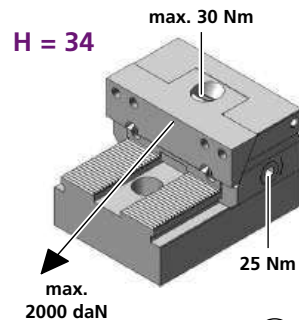
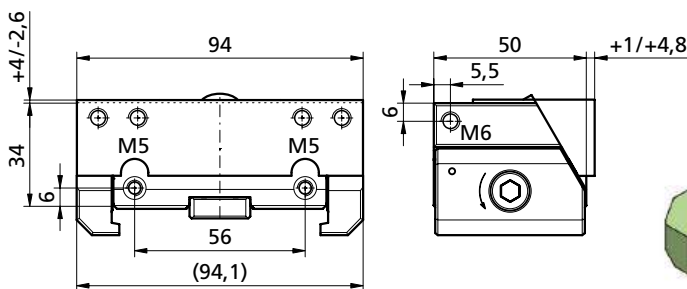
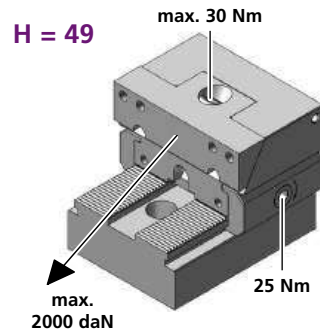
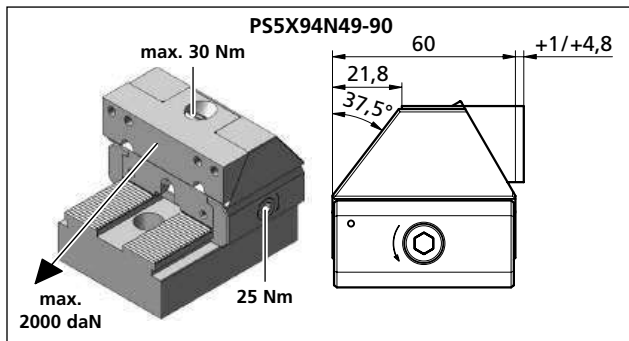
HM = Hartmetallbeschichtet / Carbide coated

PS1R/F94N34-90

PS1R/F94N49-90

PS5X94N49-90

5axes
powerCLAMP

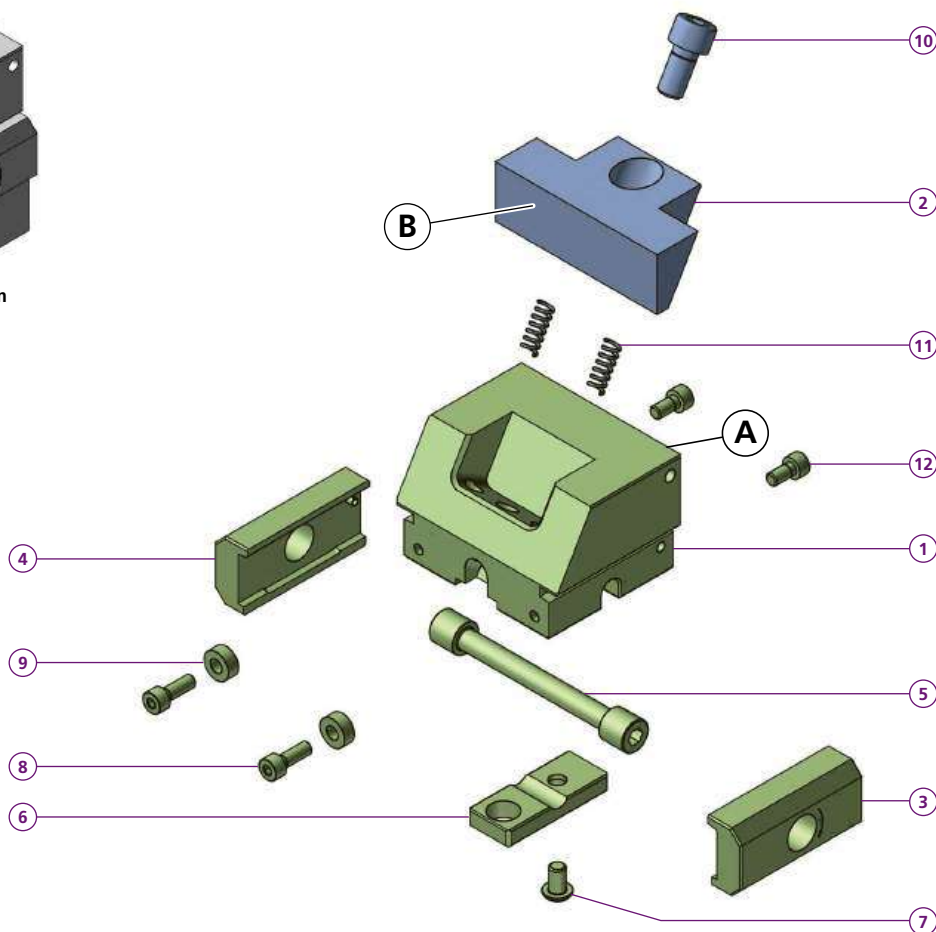
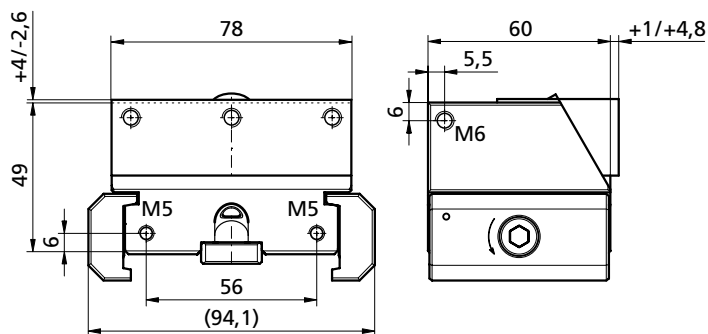
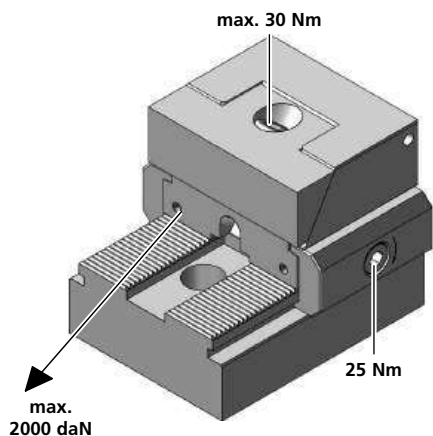


PS1F94N34-90		PS5X94N49-90	
1	1x TF140478	1	1x TF140482
2	1x	3	1x PCSP60R
3	1x PCSP50RF	4	1x PCSP60L
4	1x PCSP50LF	9	2x PCD005
5	1x PCS14	8	2x M5X14ISO4762
6	1x PCGU2049	kg	~1,8
7	1x M6X8ISO7380	PS1F94N49-90	
8	2x M5X16ISO4762	1	1x TF140480
9	2x PCD008	PS1R94N49-90	
10	1x M10X25ISO4762	1	1x TF140481
11	2x FED0618	2	1x
12	2x M5X10ISO4762	3	1x PCSP60R
H	= 34	4	1x PCSP60L
kg	~1,0	8	2x M5X14ISO4762
		9	2x PCD005
		H	= 49
		kg	~2,0

Bestellbeispiel / Ordering example:
1x PS1F94N34-90 & 1x B91

	B90	B91	B92	B93	B94
C	94	94	94	94	94
H	25	25	25	25	25
L	23	23	23	23	40
D	11	11	11	11	11
e	15	15	15	15	15
i	HV700 x0,2mm	HV700 x0,2mm	*	HV700 x0,2mm	*
kg	~0,33	~0,33	~0,33	~0,33	~0,64

B90, B91, B92, B93



PS1F78N49-90	
1	1x TH160490
PS1R78N49-90	
1	1x TH160490
2	1x
3	1x PCSP60R
4	1x PCSP60L
5	1x PCS14
6	1x PCGU2049
7	1x M6X8ISO7380
8	2x M5X14ISO4762
9	2x PCD005
10	1x M10X25ISO4762
11	2x FED0618
12	2x M5X10ISO4762
kg	~1,8

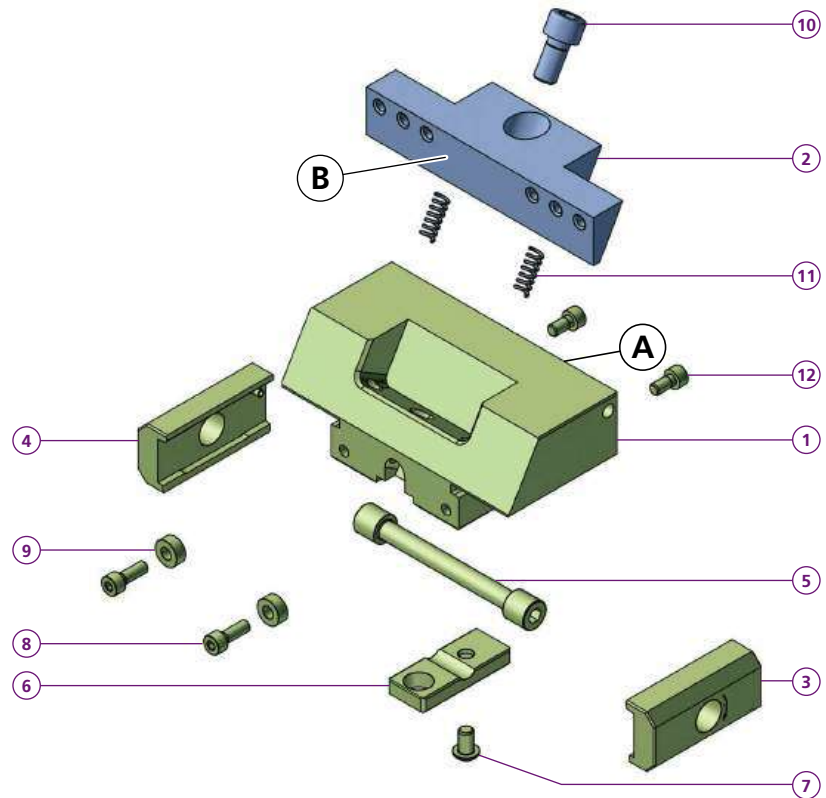
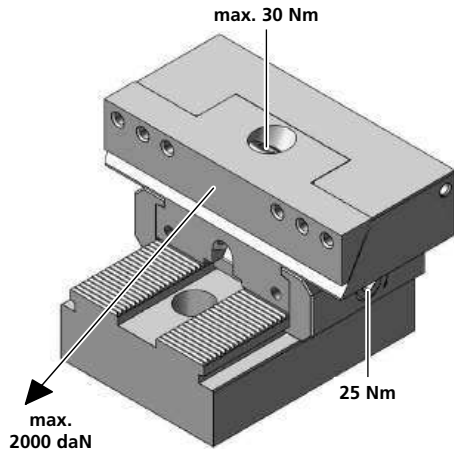
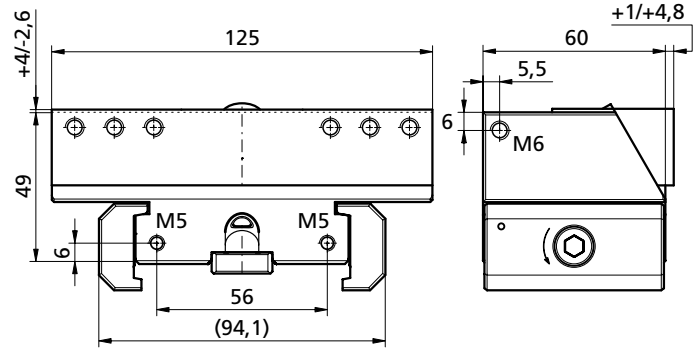
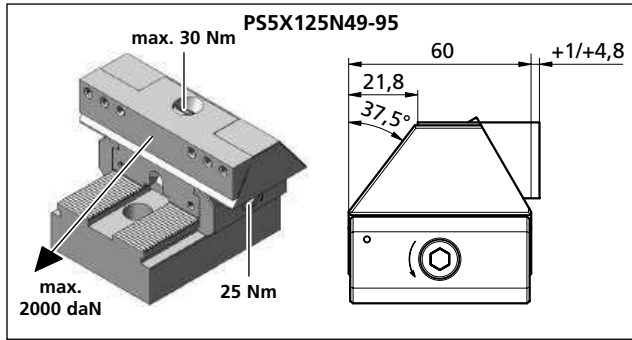
* = weicher Stahl / soft steel

Bestellbeispiel / Ordering example:
1x PS1F78N49-90 & 1x B90F78

	B90F78	B90W78	B90R78
C	78	78	78
H	25	25	25
L	23	28	23
D	11	11	11
e	15	15	15
i	HV700	*	HV700
	x0,2mm		x0,2mm
kg	~0,3	~0,37	~0,3

B90F78, B90W78

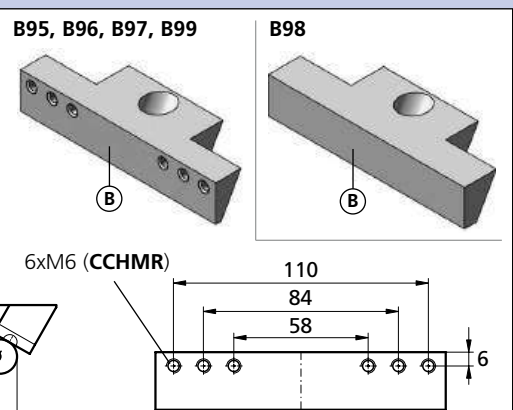
B90R78



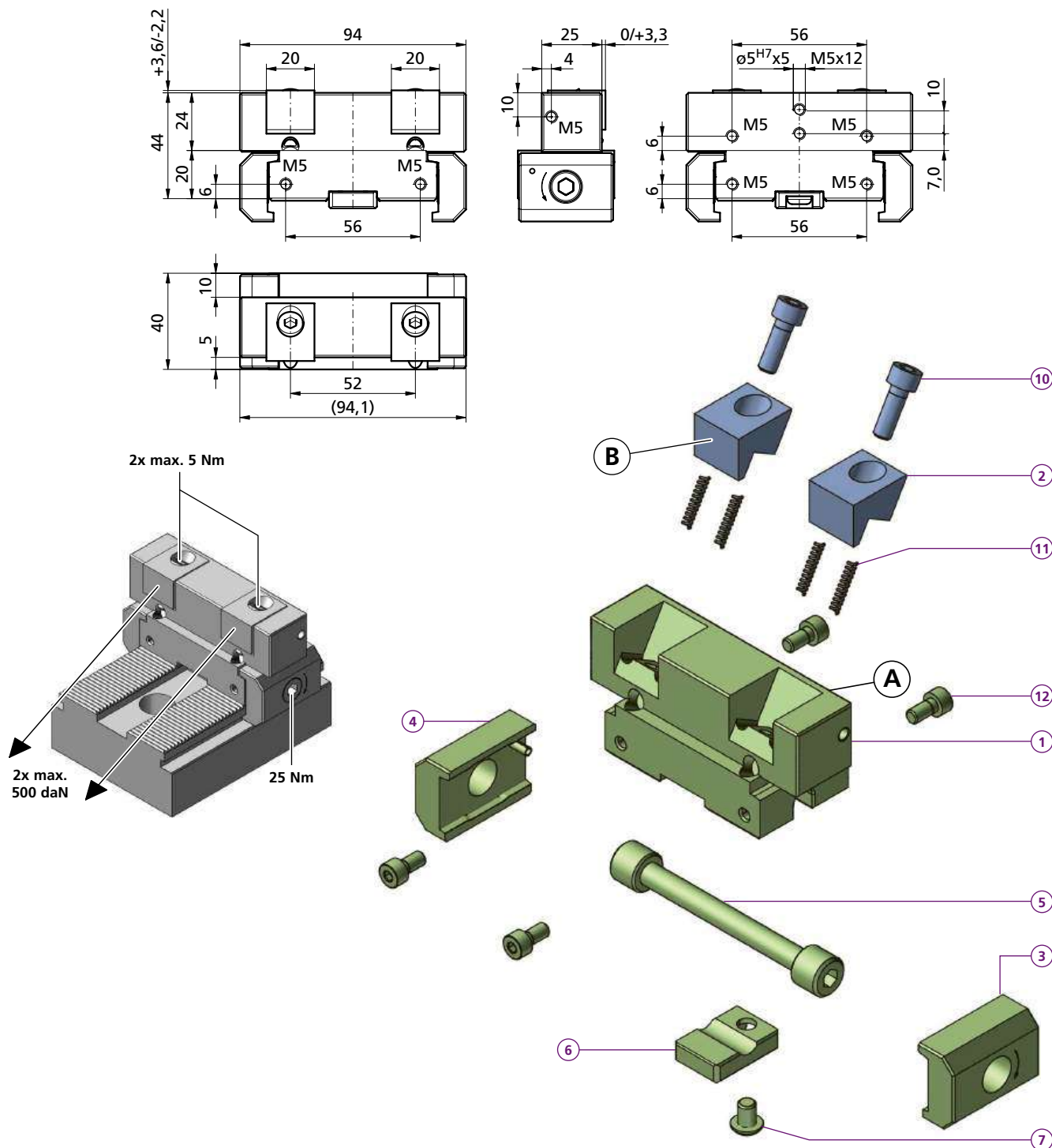
PS5X125N49-95	
1	1x TF140485
9	2x PCD005
8	2x M5X14ISO4762
kg	~2,0
PS1F125N49-95	
1	1x TF140483
PS1R125N49-95	
1	1x TF140484
2	1x
3	1x PCSP60R
4	1x PCSP60L
5	1x PCS14
6	1x PCGU2049
7	1x M6X8ISO7380
8	2x M5X14ISO4762
9	2x PCD005
10	1x M10X25ISO4762
11	2x FED0618
12	2x M5X10ISO4762
kg	~2,3

	B95	B96	B97	B98	B99
C	125	125	125	125	125
H	25	25	25	25	25
L	23	23	23	30	23
D	11	11	11	11	11
ø	15	15	15	15	15
i	HV700	HV700	*	*	HV700
	x0,2mm	x0,2mm			x0,2mm
kg	~0,46	~0,45	~0,46	~0,63	~0,45

Bestellbeispiel / Ordering example: 1x PS5X125N49-95 & 1x B95



Separat bestellen / Order separately



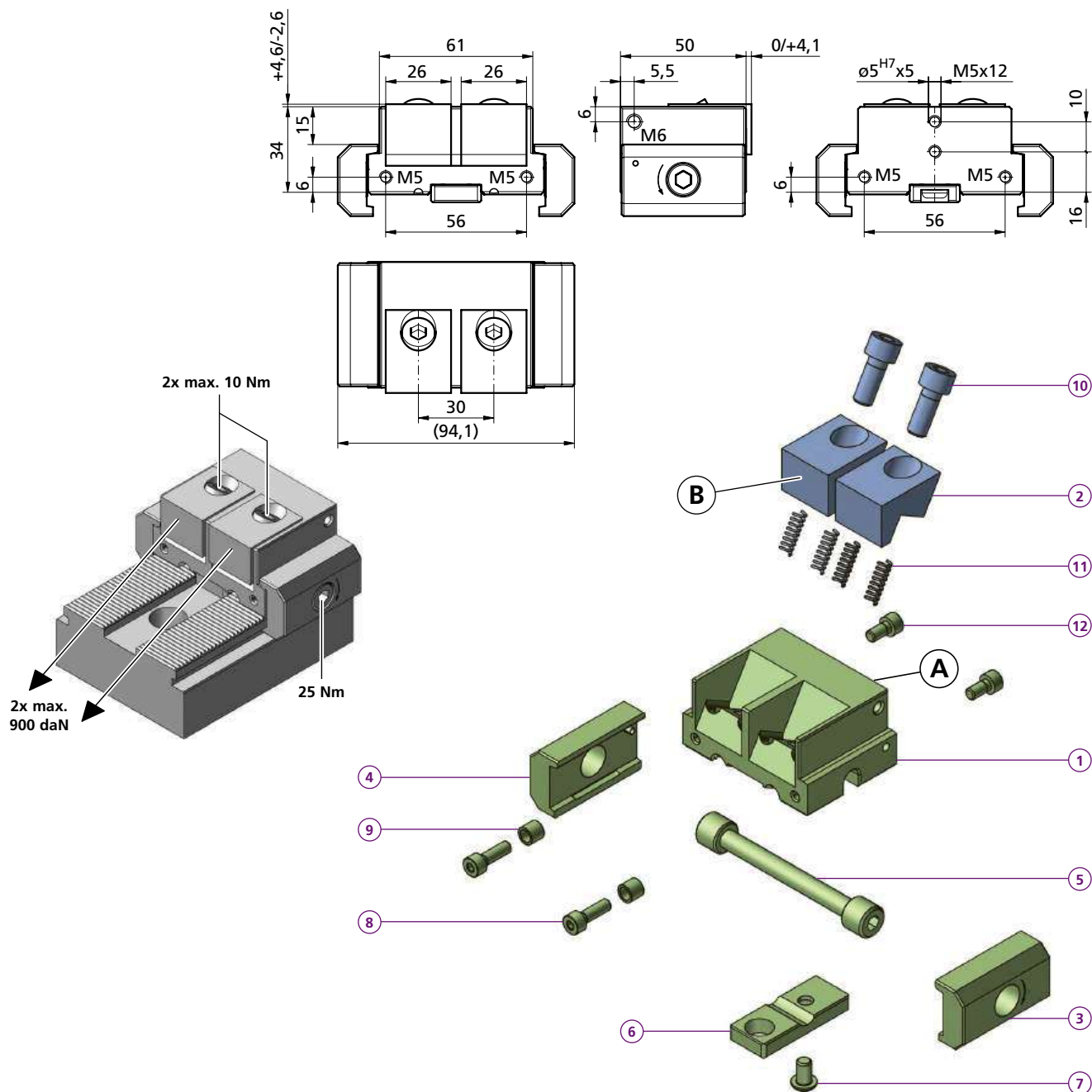
PS2G94N44-13		Bestellbeispiel / Ordering example: 1x PS2G94N44-13 & 2x B14			
		B13	B14	B15	B16
1	1x TF140486				
2	2x				
3	1x PCSP40R				
4	1x PCSP40L				
5	1x PCS14				
6	1x PCGU2030				
7	1x M6X8ISO7380				
10	2x M6X16ISO4762				
11	4x FED0318				
12	4x M5X10ISO4762				
kg	~1,0				

	B13	B14	B15	B16
C	20	20	20	20
H	16	16	16	16
L	13,8	13,8	13,8	19
D	6,5	6,5	6,5	6,5
ø	10	10	10	10
i	HV700	HV700	*	*
	x0,2mm	x0,2mm		
kg	~0,05	~0,05	~0,05	~0,06

	B13, B14, B15	B16

* = weicher Stahl / soft steel

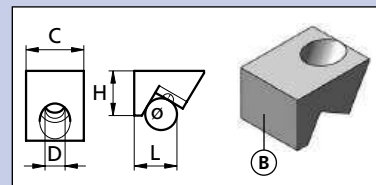
Separat bestellen / Order separately

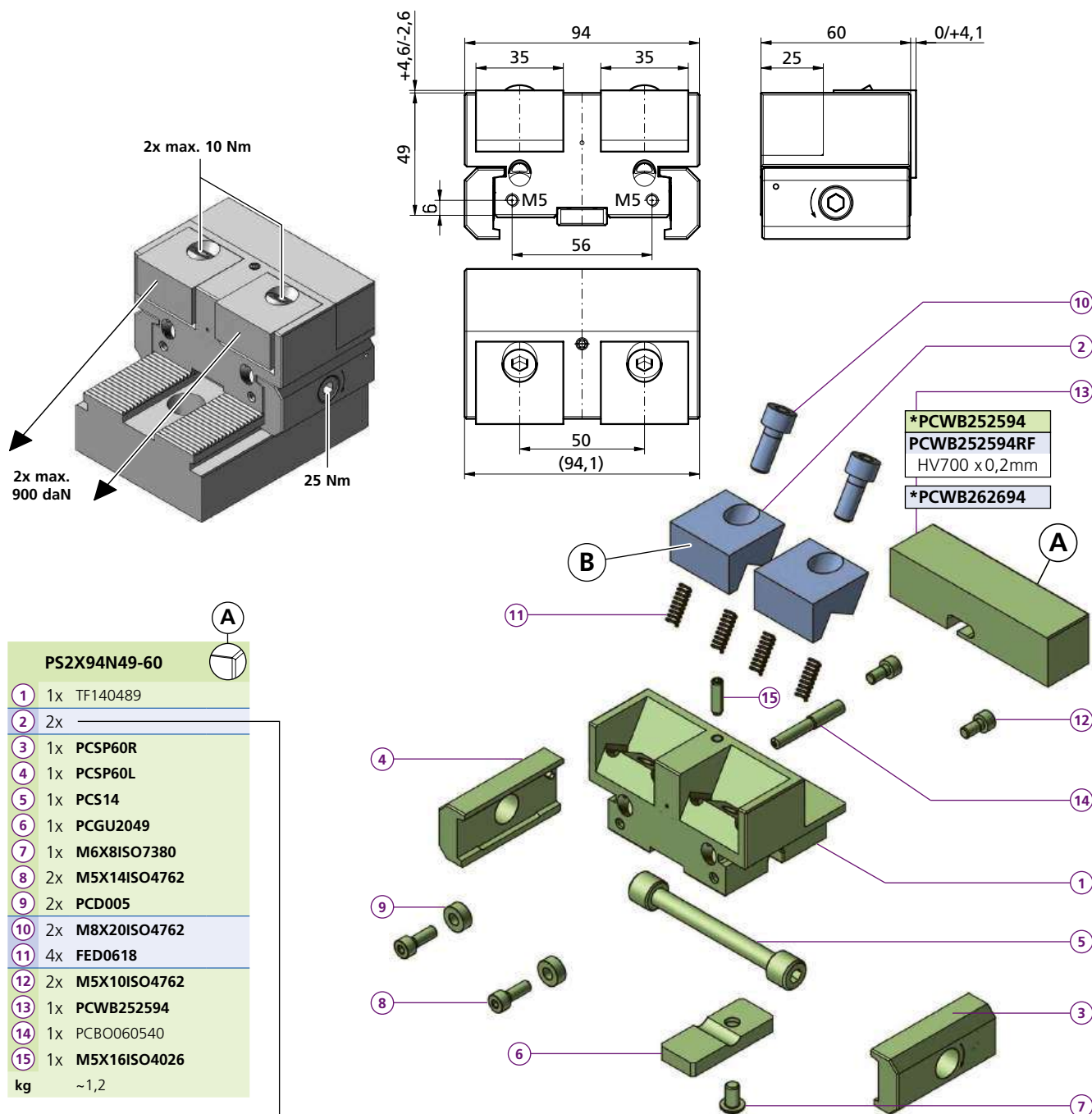


	PS2F61N34-45
1	1x TF140487
	PS2R61N34-45
2	2x
3	1x PCSP50R
4	1x PCSP50L
5	1x PCS14
6	1x PCGU2049
7	1x M6X8ISO7380
8	2x M5X16ISO4762
9	2x PCD008
10	2x M8X20ISO4762
11	4x FED0618
12	2x M5X10ISO4762
kg	~1,0

	B45	B46	B47	B47HM
C	26	26	26	26
H	20	20	20	20
L	19	19	19,1	19,1
D	9	9	9	9
e	12	12	12	12
i	HV700	HV700	*	HM
	x0,2mm	x0,2mm		
kg	~0,1	~0,1	~0,1	~0,1

Bestellbeispiel / Ordering example: 1x PS2R61N34-45 & 2x B47HM



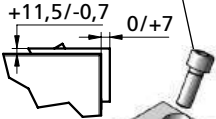


B

Bestellbeispiel / Ordering example: 1x **PS2X94N49-60** & 2x **B58**

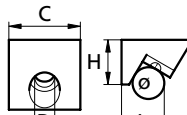
													
B58	B60	B61	B62	B62HM	B65	B66	B67	B68	B69	B77	B79F	B79R	
C	35	35	35	35	35	35	35	35	35	35	35	35	
H	20	20	20	20	20	20	20	20	25	20	20	20	
L	26	19	19	19	19	19	19	24	26	22	25	25	
D	9	9	9	9	9	9	9	9	9	9	9	9	
ø	12	12	12	12	12	12	12	12	12	12	12	12	
i	ALU	56HRC	56HRC	*	HM	HV700 x0,2mm	HV700 x0,2mm	HV700 x0,2mm	*	*	56HRC	HV700 x0,2mm	HV700 x0,2mm
kg	~0,07	~0,12	~0,12	~0,12	~0,12	~0,12	~0,12	~0,14	~0,15	~0,15	~0,12	~0,18	~0,18

B69
M5X10ISO4762



B

FED 0628



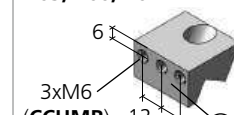
B58



B60, B61, B62, B62HM



B65, B66, B67

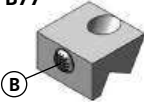


3xM6
(CCHMR)

B68

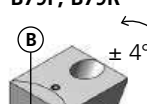


B77



Spannbacke mit CCPDR
Jaw with CCPDR

B79F, B79R



± 4°

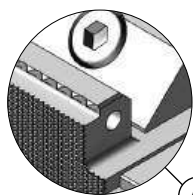
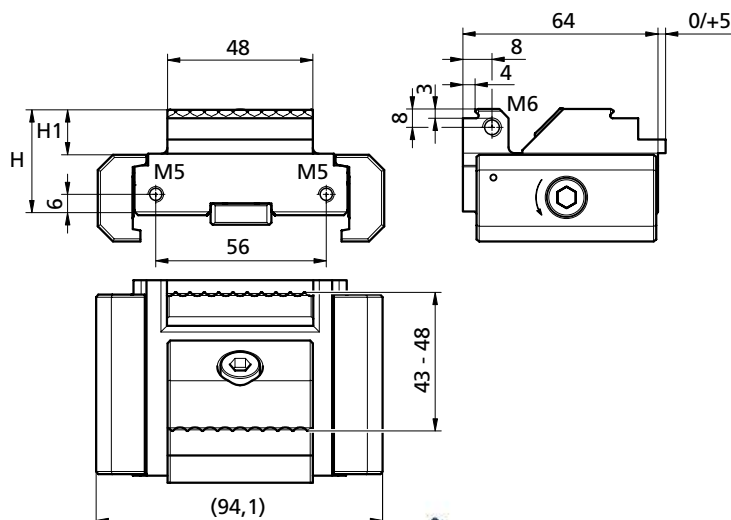
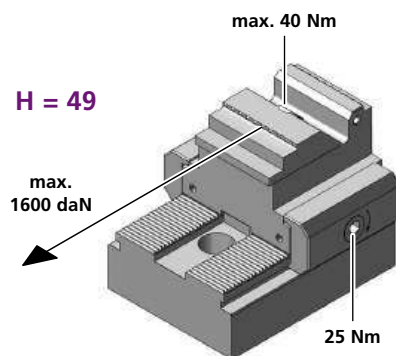
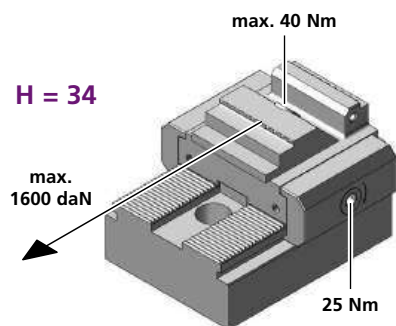
PS1P48L34-105

PS1P48L49-105

PS1PF48L49-105

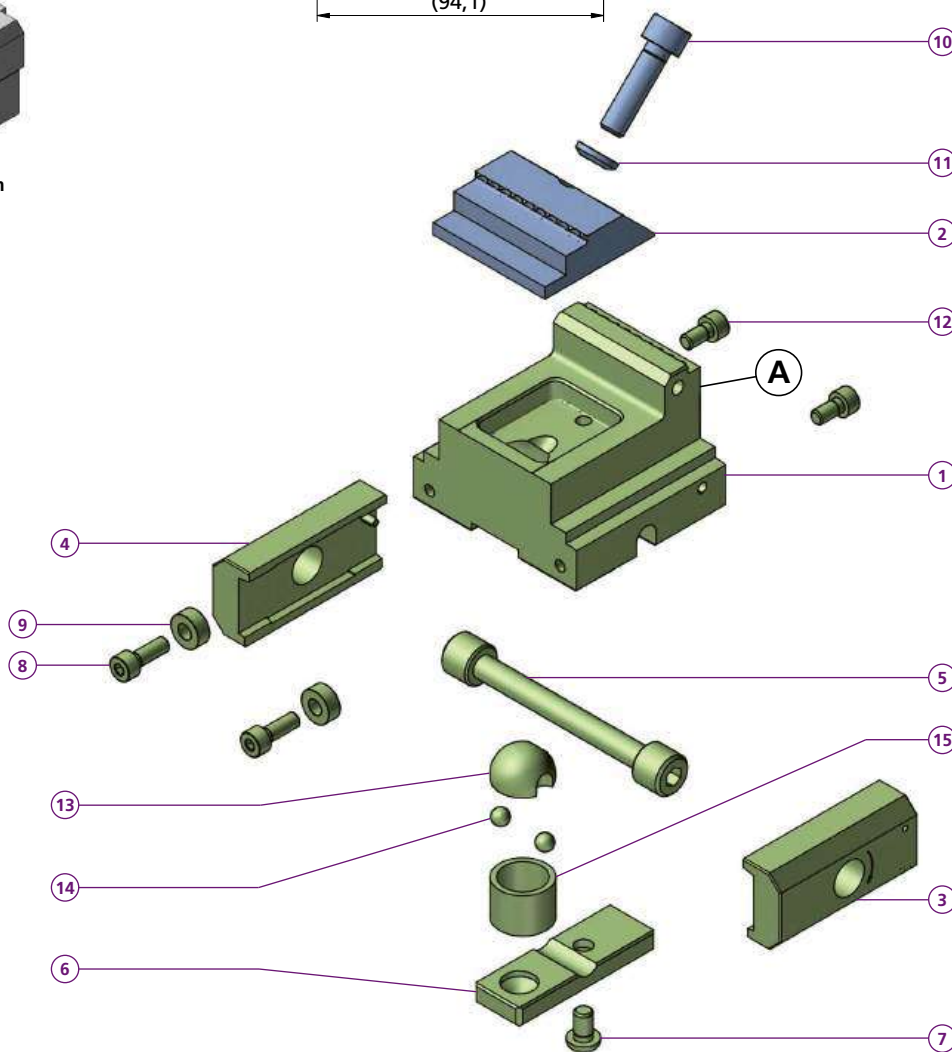
PS1PF48L34-105

powerCLAMP



PS1P48L34-105

- 1 1x TW100098-01
- 2 1x
- 3 1x PCSP60R
- 4 1x PCSP60L
- 5 1x PCS14
- 6 1x PCGU2059
- 7 1x M6X8ISO7380
- 8 2x M5X14ISO4762
- 9 2x PCD005
- 10 1x M8X28ISO4762
- 11 1x PCUSR16
- 12 2x M5X10ISO4762
- 13 1x PCKMR45M8
- 14 2x D=6 DIN 5401
- H = 34
- H1 = 15
- kg ~1,0



p. 84, 85

PS1PF48L34-105

- 1 1x TK140780
- H = 49
- H1 = 30
- kg ~1,0

PS1P48L49-105

- 1 1x TK120011
- 15 1x PCD20L15
- H = 49
- H1 = 30
- kg ~1,4

PS1PF48L49-105

- 1 1x TK140781
- 15 1x PCD20L15
- H = 49
- H1 = 30
- kg ~1,4

Bestellbeispiel / Ordering example:
1x PS1P48L34-105 & 1x B115

Drehmoment Torque		Spannkraft Workholding force			
Nm	(lb-ft)	~daN	~(lb)	~t	
10	7,4	= 400	880	0,4	
20	14,8	= 800	1'760	0,8	
30	22,2	= 1'200	2'650	1,2	
40	29,6	= 1'600	3'530	1,6	

Separat bestellen / Order separately

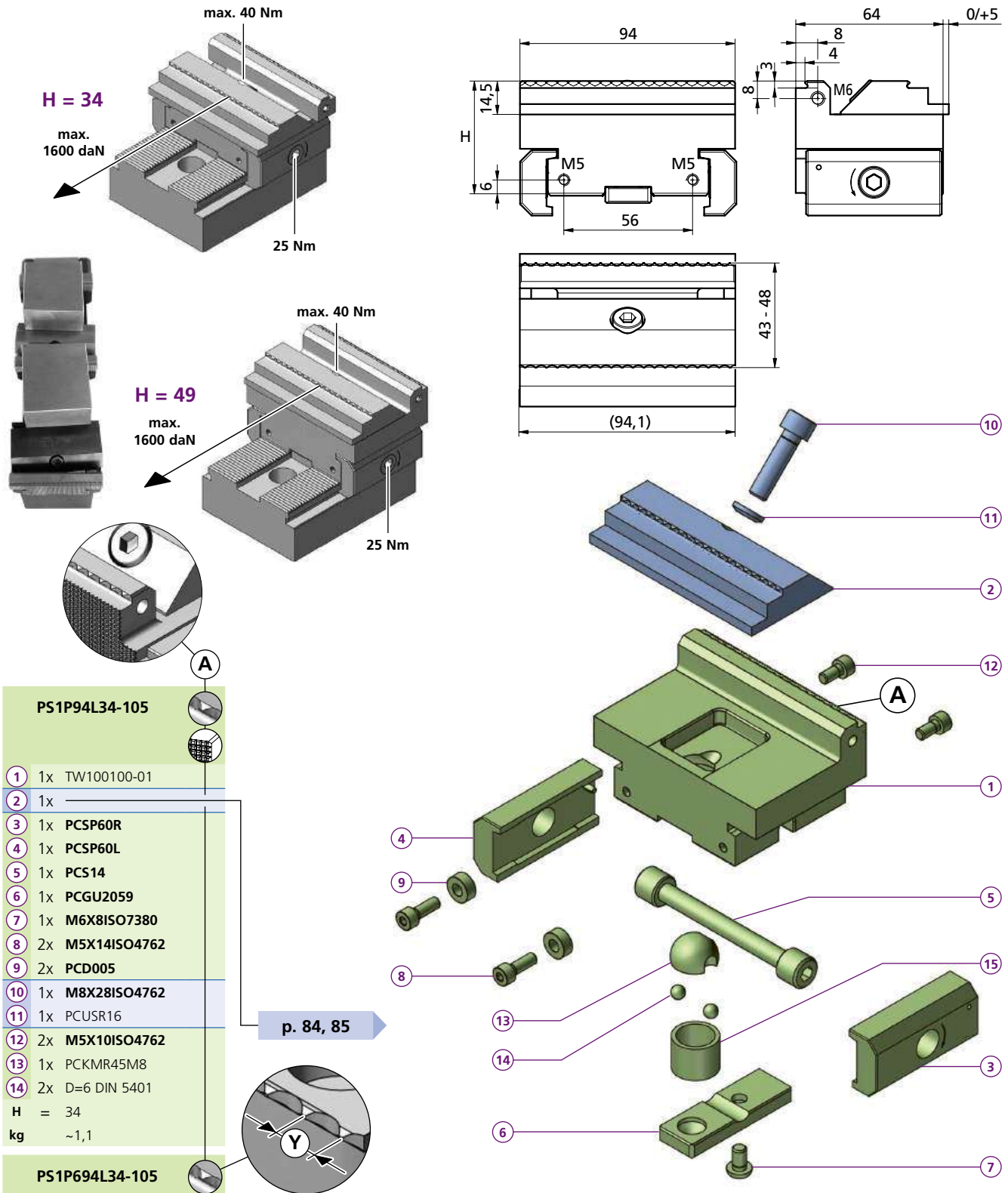
PS1P94L34-105

PS1P694L34-105

PS1P94L49-105

PS1PF94L49-105

PS1PF94L34-105



PS1P94L34-105

- 1 1x TW100100-01
- 2 1x
- 3 1x PCSP60R
- 4 1x PCSP60L
- 5 1x PCS14
- 6 1x PCGU2059
- 7 1x M6X8ISO7380
- 8 2x M5X14ISO4762
- 9 2x PCD005
- 10 1x M8X28ISO4762
- 11 1x PCUSR16
- 12 2x M5X10ISO4762
- 13 1x PCKMR45M8
- 14 2x D=6 DIN 5401
- H = 34
- kg ~1,1

p. 84, 85

PS1P694L34-105

- 1 1x TW100100-02
- Y 6,0 mm
- kg ~1,1

PS1PF94L34-105

- 1 1x TK140782
- H = 49
- kg ~1,1

PS1P94L49-105

- 1 1x TK120857
- 15 1x PCD20L15
- H = 49
- kg ~1,8

PS1PF94L49-105

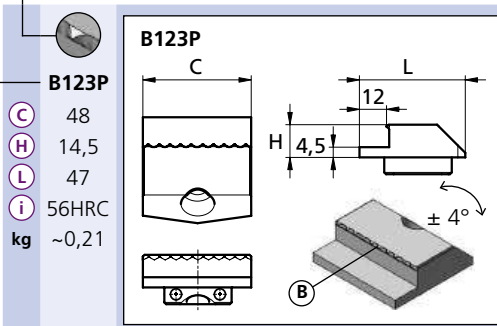
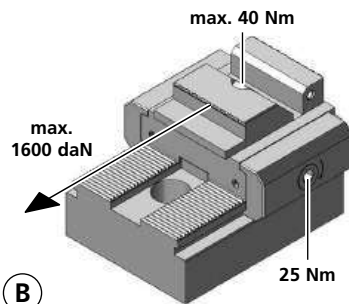
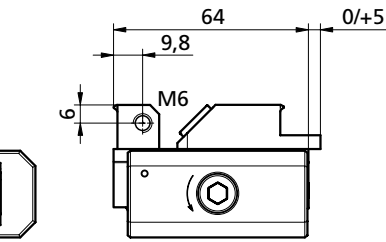
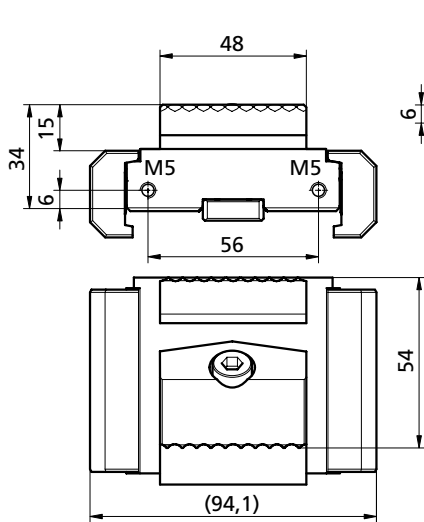
- 1 1x TK140783
- 15 1x PCD20L15
- H = 49
- kg ~1,8

Bestellbeispiel / Ordering example:
1x PS1P94L34-105 & 1x B120

Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
10	7,4	= 400	880	0,4
20	14,8	= 800	1'760	0,8
30	22,2	= 1'200	2'650	1,2
40	29,6	= 1'600	3'530	1,6

PS1PV48L34-105
PS1R/F48L34-105

Linear
powerCLAMP



PS1PV48L34-105

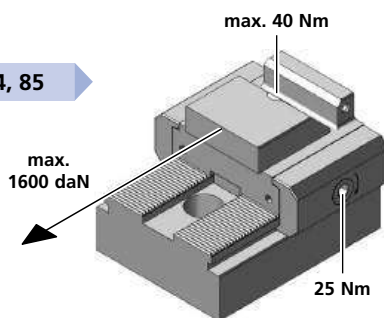
1	1x	TK140762
2	1x	
3	1x	PCSP60R
4	1x	PCSP60L
5	1x	PCS14
6	1x	PCGU2059
7	1x	M6X8ISO7380
8	2x	M5X14ISO4762
9	2x	PCD005
10	1x	M8X28ISO4762
11	1x	PCUSR16
12	2x	M5X10ISO4762
13	1x	PCKMR45M8
14	2x	D=6 DIN 5401
kg		~1,0

PS1R48L34-105

PS1F48L34-105

1	1x	TF140573
2	1x	
3	1x	PCSP60R
4	1x	PCSP60L
5	1x	PCS14
6	1x	PCGU2059
7	1x	M6X8ISO7380
8	2x	M5X14ISO4762
9	2x	PCD005
10	1x	M8X30ISO4762
11	1x	PCUSR14
12	2x	M5X10ISO4762
13	1x	PCKMR45M8
14	2x	D=6 DIN 5401
kg		~1,0

p. 84, 85



Bestellbeispiel / Ordering example:
1x PS1R48L34-105 & 1x B123P

Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
10	7,4	= 400	880	0,4
20	14,8	= 800	1'760	0,8
30	22,2	= 1'200	2'650	1,2
40	29,6	= 1'600	3'530	1,6

Separat bestellen / Order separately

H = 34

max.
1600 daN

max. 40 Nm

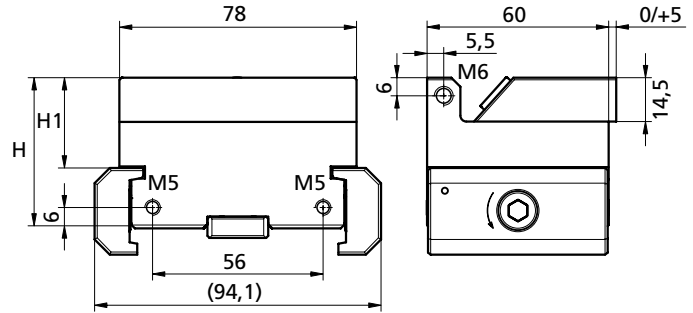
25 Nm

H = 49

max.
1600 daN

max. 40 Nm

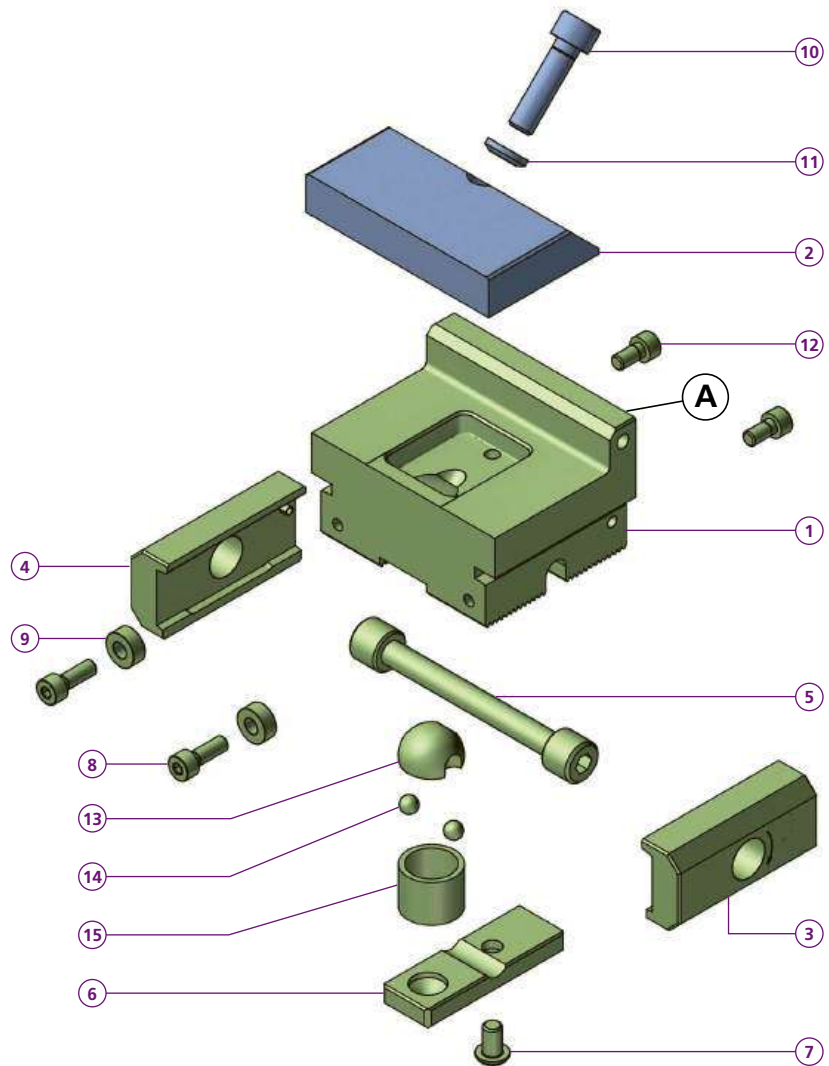
25 Nm



PS1R78L34-105	
1	1x TF140575
PS1F78L34-105	
1	1x TF140574
2	1x
3	1x PCSP60R
4	1x PCSP60L
5	1x PCS14
6	1x PCGU2059
7	1x M6X8ISO7380
8	2x M5X14ISO4762
9	2x PCD005
10	1x M8X30ISO4762
11	1x PCUSR14
12	2x M5X10ISO4762
13	1x PCKMR45M8
14	2x D=6 DIN 5401
H	= 34
H1	= 15
kg	~1,0

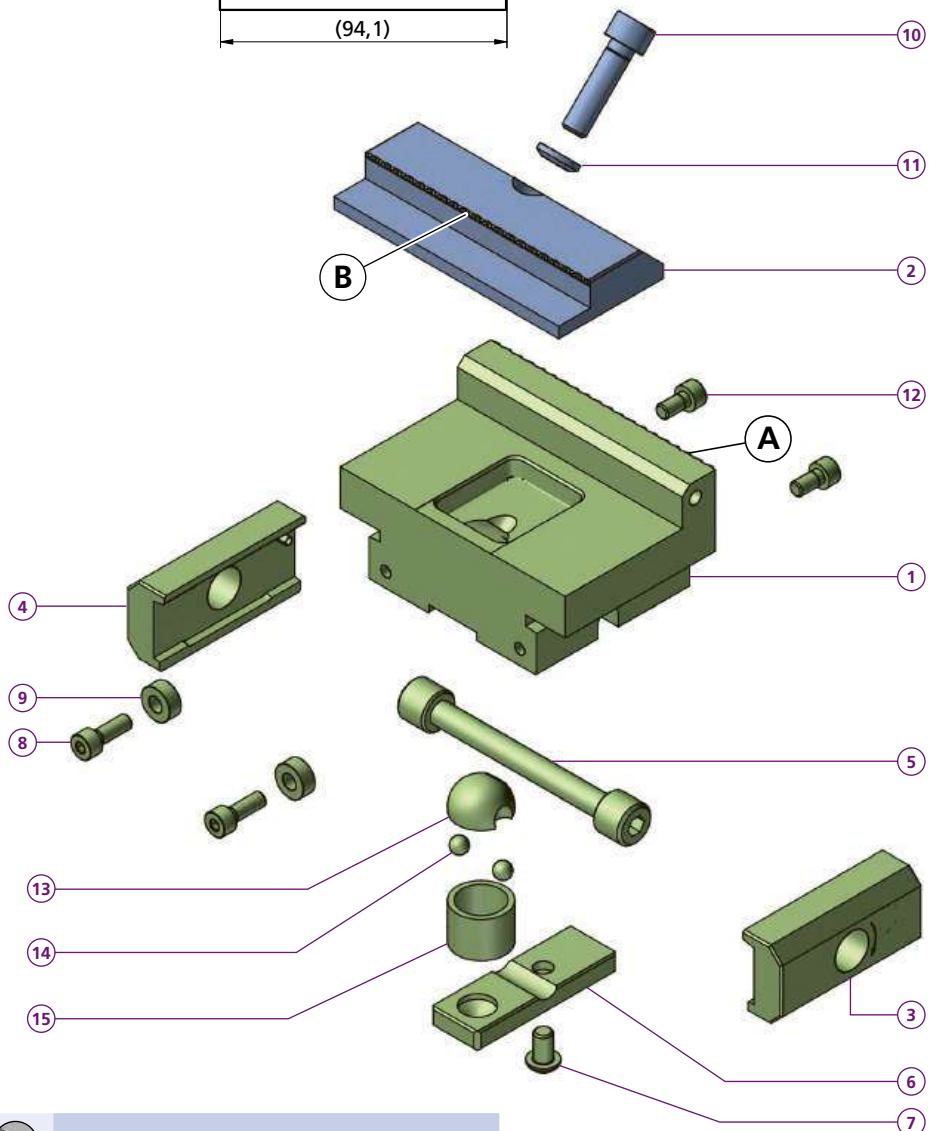
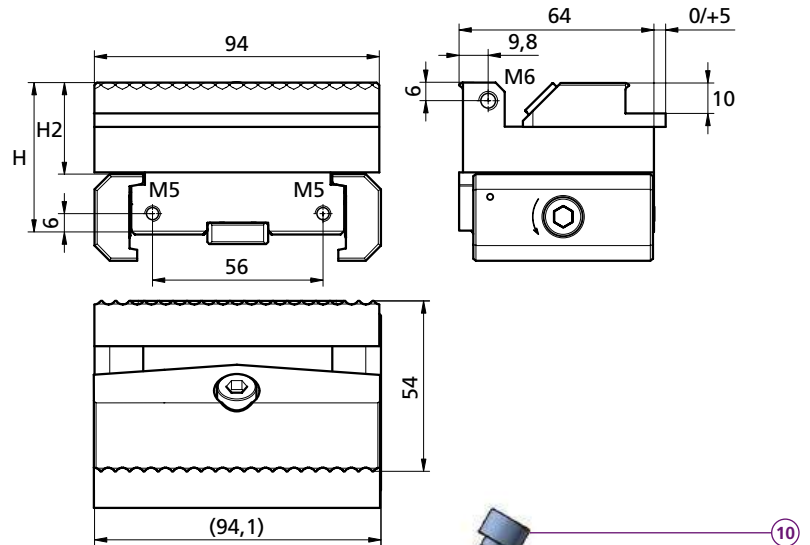
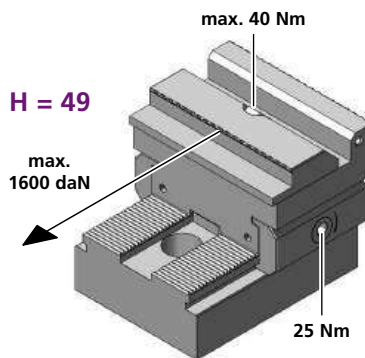
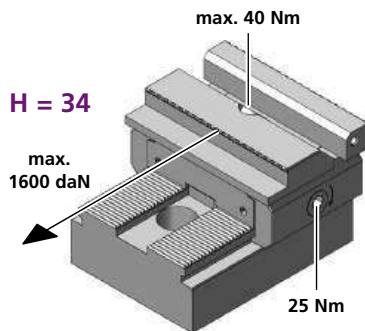
p. 84, 85

PS1R78L49-105	
1	1x TK110399
15	2x PCD20L15
PS1F78L49-105	
1	1x TK110400
15	2x PCD20L15
H	= 49
H1	= 30
kg	~1,5



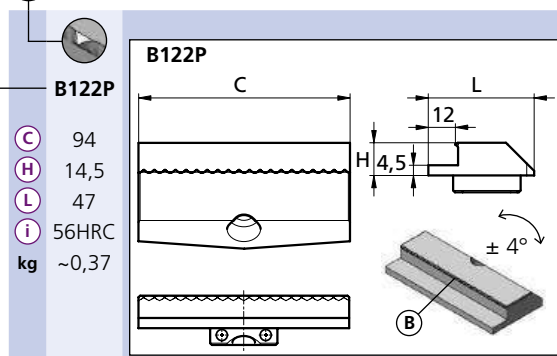
Bestellbeispiel / Ordering example:
1x PS1R48L34-105 & 1x B105

Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
10	7,4	= 400	880	0,4
20	14,8	= 800	1'760	0,8
30	22,2	= 1'200	2'650	1,2
40	29,6	= 1'600	3'530	1,6



PS1PV94L34-105	
1	1x TK120230
2	1x
3	1x PCSP60R
4	1x PCSP60L
5	1x PCS14
6	1x PCGU2059
7	1x M6X8ISO7380
8	2x M5X14ISO4762
9	2x PCD005
10	1x M8X28ISO4762
11	1x PCUSR16
12	2x M5X10ISO4762
13	1x PCKMR45M8
14	2x D=6 DIN 5401
H	= 34
H1	= 15
kg	~1,1

PS1PV94L49-105	
1	1x TK110250
15	1x PCD20L15
H	= 49
H1	= 30
kg	~1,8

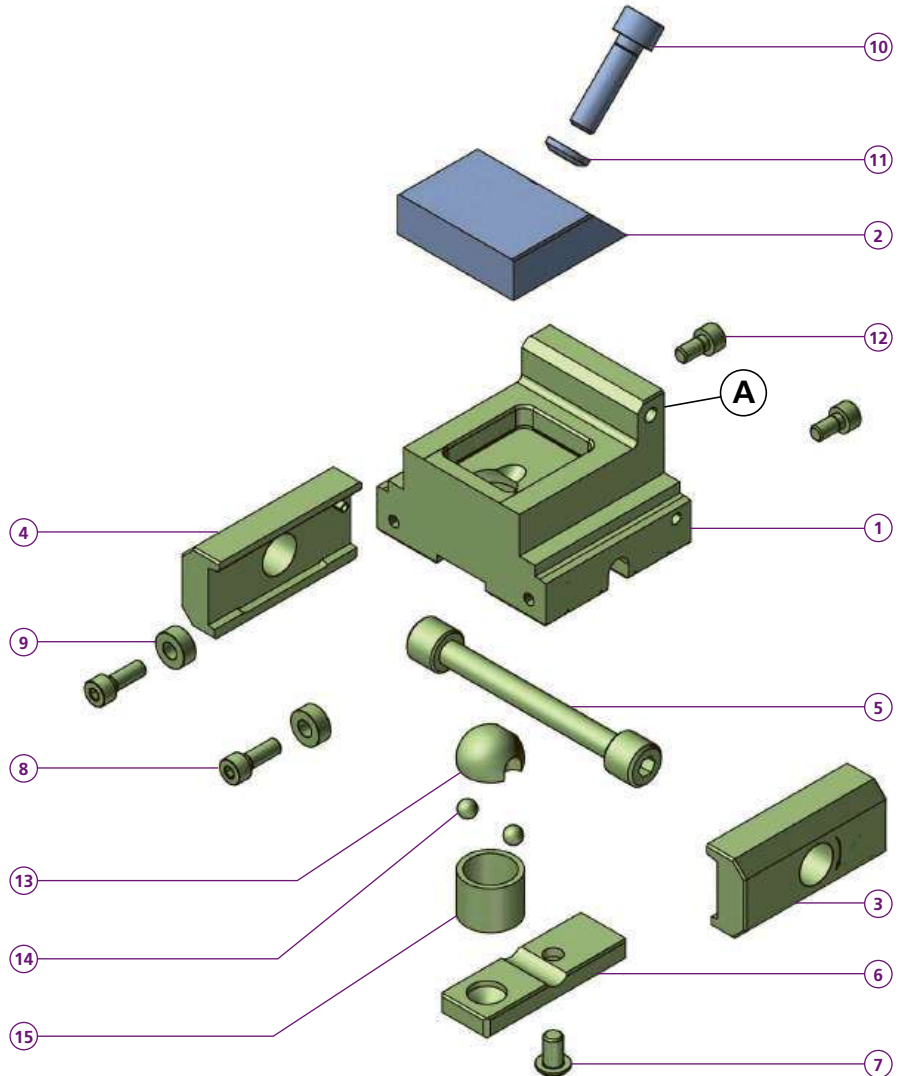
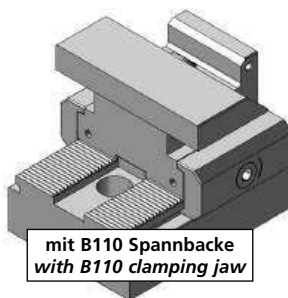
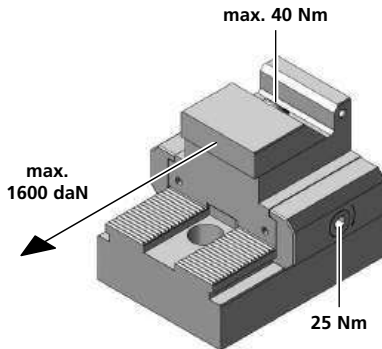
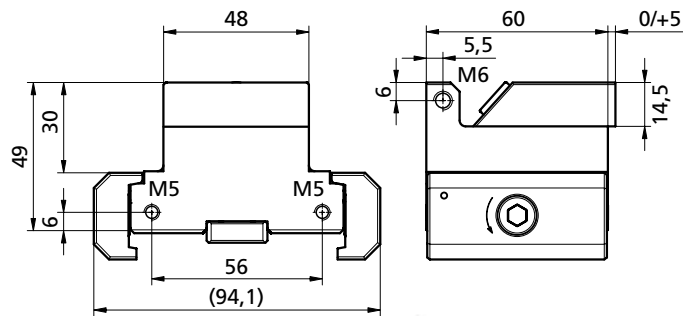
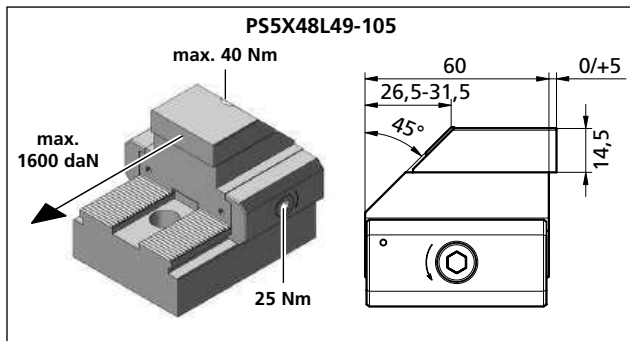


Bestellbeispiel / Ordering example:
1x PS1PV94L49-105 & 1x B122P

Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
10	7,4	= 400	880	0,4
20	14,8	= 800	1'760	0,8
30	22,2	= 1'200	2'650	1,2
40	29,6	= 1'600	3'530	1,6

PS1R/F48L49-105
PS5X48L49-105

Linear 5axes
powerCLAMP



45°	PS5X48L49-105
1	1x TF190651
9	2x PCD005
8	2x M5X14ISO4762
kg	~1,2
	PS1F48L49-105
1	1x TF140673
	PS1R48L49-105
1	1x TF140672
2	1x
3	1x PCSP60R
4	1x PCSP60L
5	1x PCS14
6	1x PCGU2059
7	1x M6X8ISO7380
8	2x M5X14ISO4762
9	2x PCD005
10	1x M8X30ISO4762
11	1x PCUSR14
12	2x M5X10ISO4762
13	1x PCKMR45M8
14	2x D=6 DIN 5401
15	1x PCD20L15
kg	~1,3

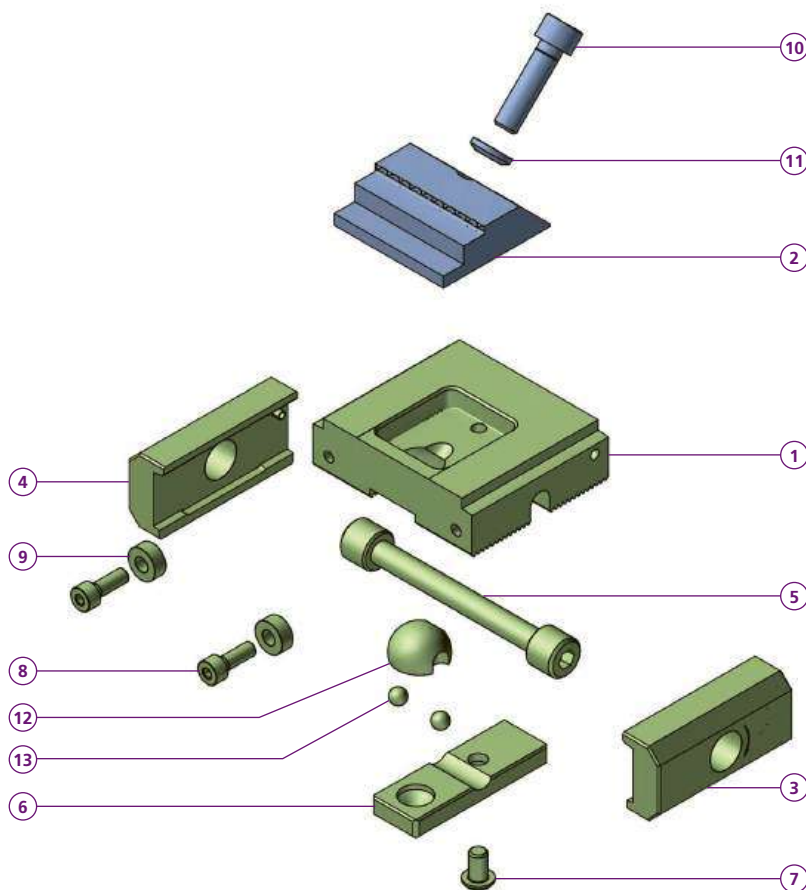
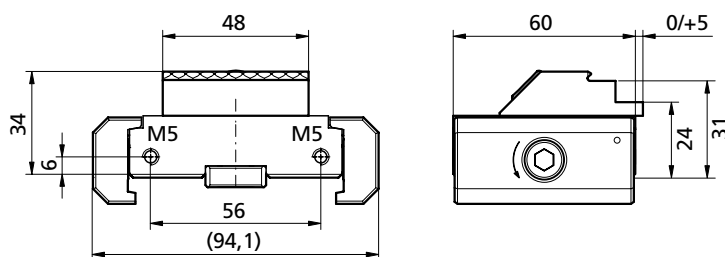
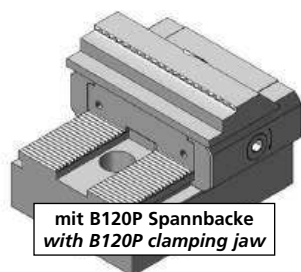
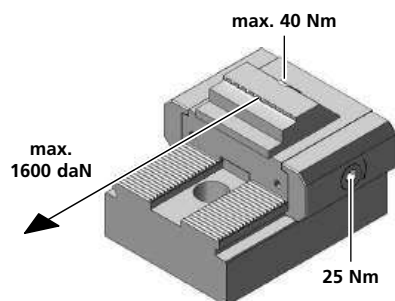
p. 84, 85



Bestellbeispiel / Ordering example:
1x PS1F48L49-105 & 1x B105

Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
10	7,4	= 400	880	0,4
20	14,8	= 800	1'760	0,8
30	22,2	= 1'200	2'650	1,2
40	29,6	= 1'600	3'530	1,6

Separat bestellen / Order separately



PS5X48L34-105

1	1x T00365
2	1x —
3	1x PCSP60R
4	1x PCSP60L
5	1x PCS14
6	1x PCGU2059
7	1x M6X8ISO7380
8	2x M5X14ISO4762
9	2x PCD005
10	1x M8X28ISO4762
11	1x PCUSR16
12	1x PCKMR45M8
13	2x D=6 DIN 5401
kg	~0,9

p. 84, 85

Bestellbeispiel / Ordering example:
1x PS5X48L34-105 & 1x B105

Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
10	7,4	= 400	880	0,4
20	14,8	= 800	1'760	0,8
30	22,2	= 1'200	2'650	1,2
40	29,6	= 1'600	3'530	1,6

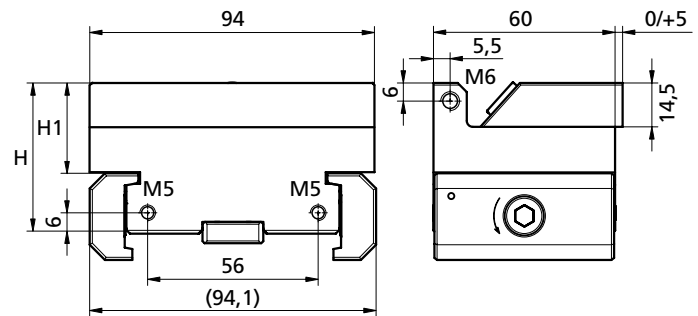
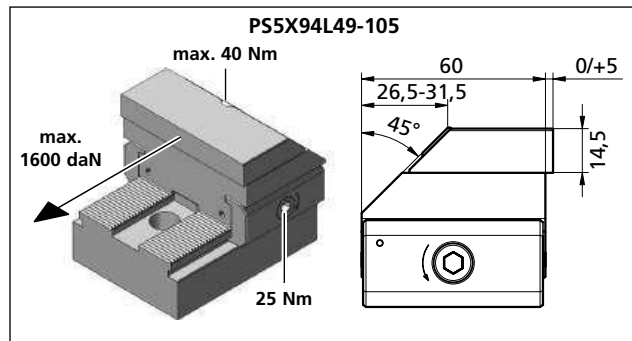
Separat bestellen / Order separately

PS1R/F94L34-105

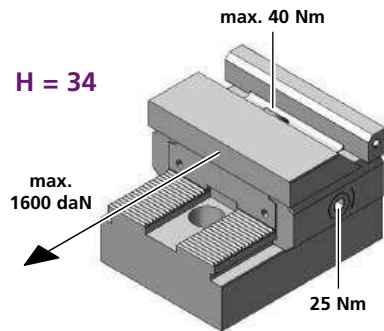
PS1R/F94L49-105

PS5X94L49-105

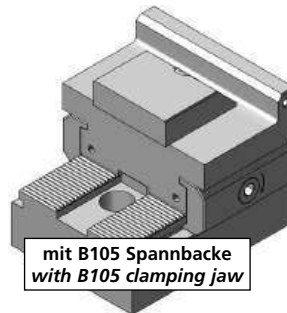
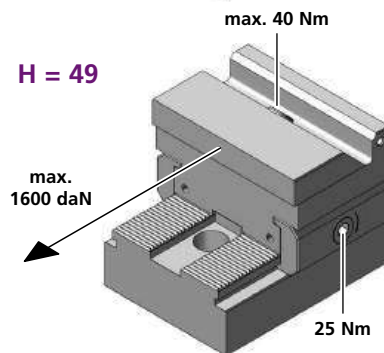
Linear
5axes
powerCLAMP



H = 34



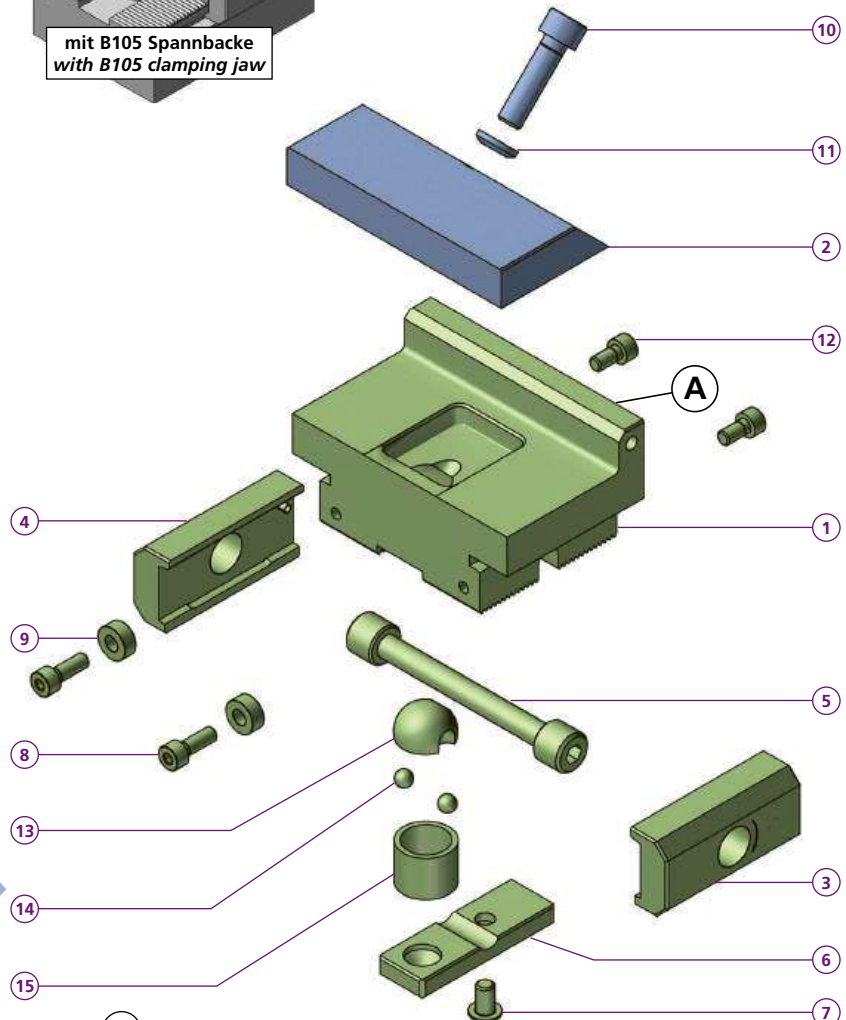
H = 49



PS5X94L49-105	
1x TW100186	
2x PCD20L15	
2x PCD005	
2x M5X14ISO4762	
kg ~1,5	
PS1F94L34-105	
1x TH130785	
PS1R94L34-105	
1x TH130786	
1x	
1x PCSP60R	
1x PCSP60L	
1x PCS14	
1x PCGU2059	
1x M6X8ISO7380	
2x M5X14ISO4762	
2x PCD005	
1x M8X30ISO4762	
1x PCUSR14	
2x M5X10ISO4762	
1x PCKMR45M8	
2x D=6 DIN 5401	
H = 34	
H1 = 15	
kg ~1,0	

p. 84, 85

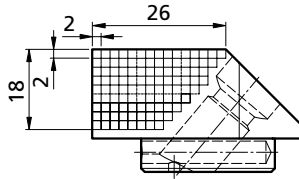
PS1F94L49-105	
1x TF140674	
2x PCD20L15	
PS1R94L49-105	
1x TF140675	
2x PCD20L15	
H = 49	
H1 = 30	
kg ~1,7	



Bestellbeispiel / Ordering example:
1x PS1R94L49-105 & 1x B105

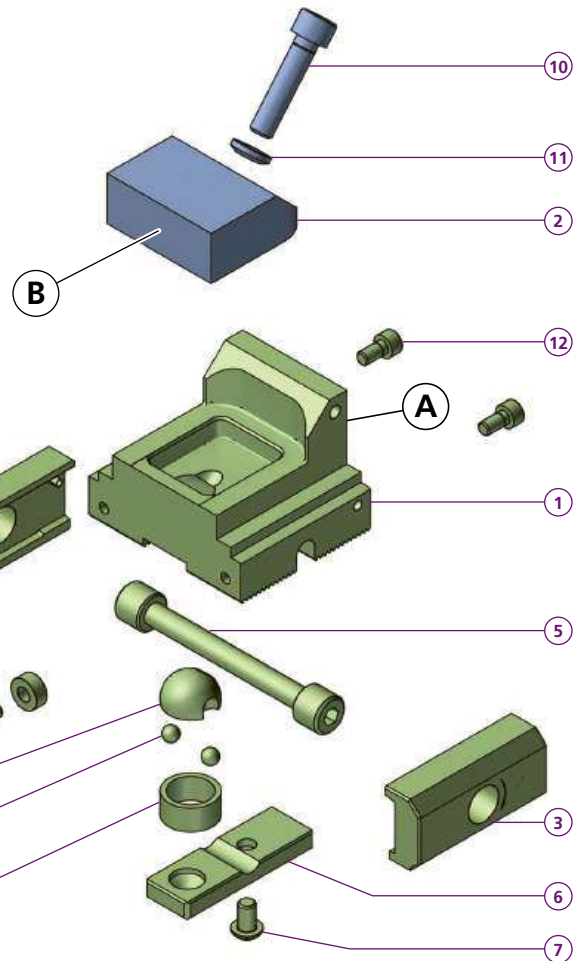
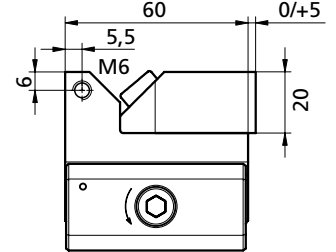
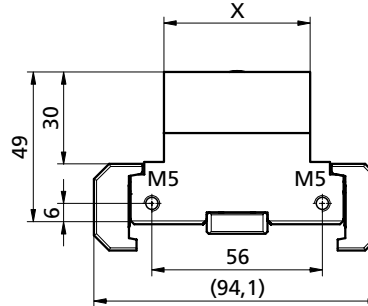
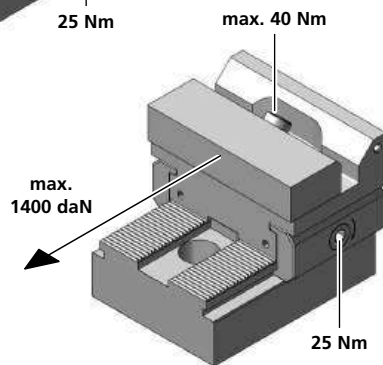
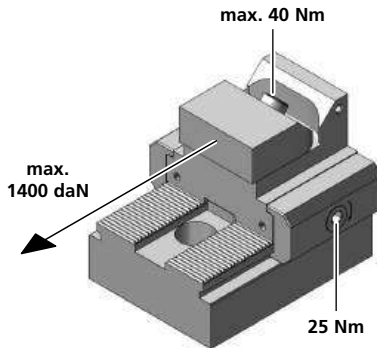
Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
10	7,4	= 400	880	0,4
20	14,8	= 800	1'760	0,8
30	22,2	= 1'200	2'650	1,2
40	29,6	= 1'600	3'530	1,6

Separat bestellen / Order separately



Zum Erstellen Ihrer individuellen Formbacke: If a dedicated jaw is being machined:

Schnittzeichnung zum Ermitteln der maximalen Bearbeitungsprofiltiefe
Sectional drawing to determine the maximum machining depth



PS1R48L49-105H20

- 1x TW100161-01
- 1x
- 1x PCSP60R
- 1x PCSP60L
- 1x PCS14
- 1x PCGU2059
- 1x M6X8ISO7380
- 2x M5X14ISO4762
- 2x PCD005
- 1x M8X35ISO4762
- 1x PCUSR14
- 2x M5X10ISO4762
- 1x PCKMR45M8
- 2x D=6 DIN 5401
- 1x PCD20L095
- X = 48
- kg ~1,2

PS1R94L49-105H20

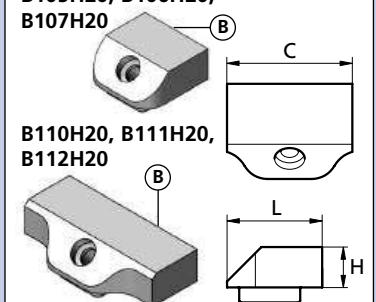
- 1x TW100161-07
- X = 94
- kg ~1,5

Bestellbeispiel / Ordering example: 1x PS1R48L49-105H20 & 1x B107H20

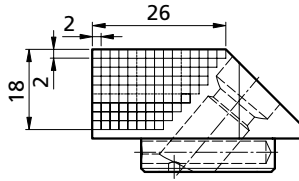
	B105H20	B106H20	B107H20	B110H20	B111H20	B112H20
C	48	48	48	94	94	94
H	20	20	20	20	20	20
L	47	47	47	47	47	47
i	HV700 x0,2mm	HV700 x0,2mm	*	HV700 x0,2mm	HV700 x0,2mm	*
kg	~0,38	~0,38	~0,38	~0,57	~0,56	~0,56

B105H20, B106H20,
B107H20

B110H20, B111H20,
B112H20

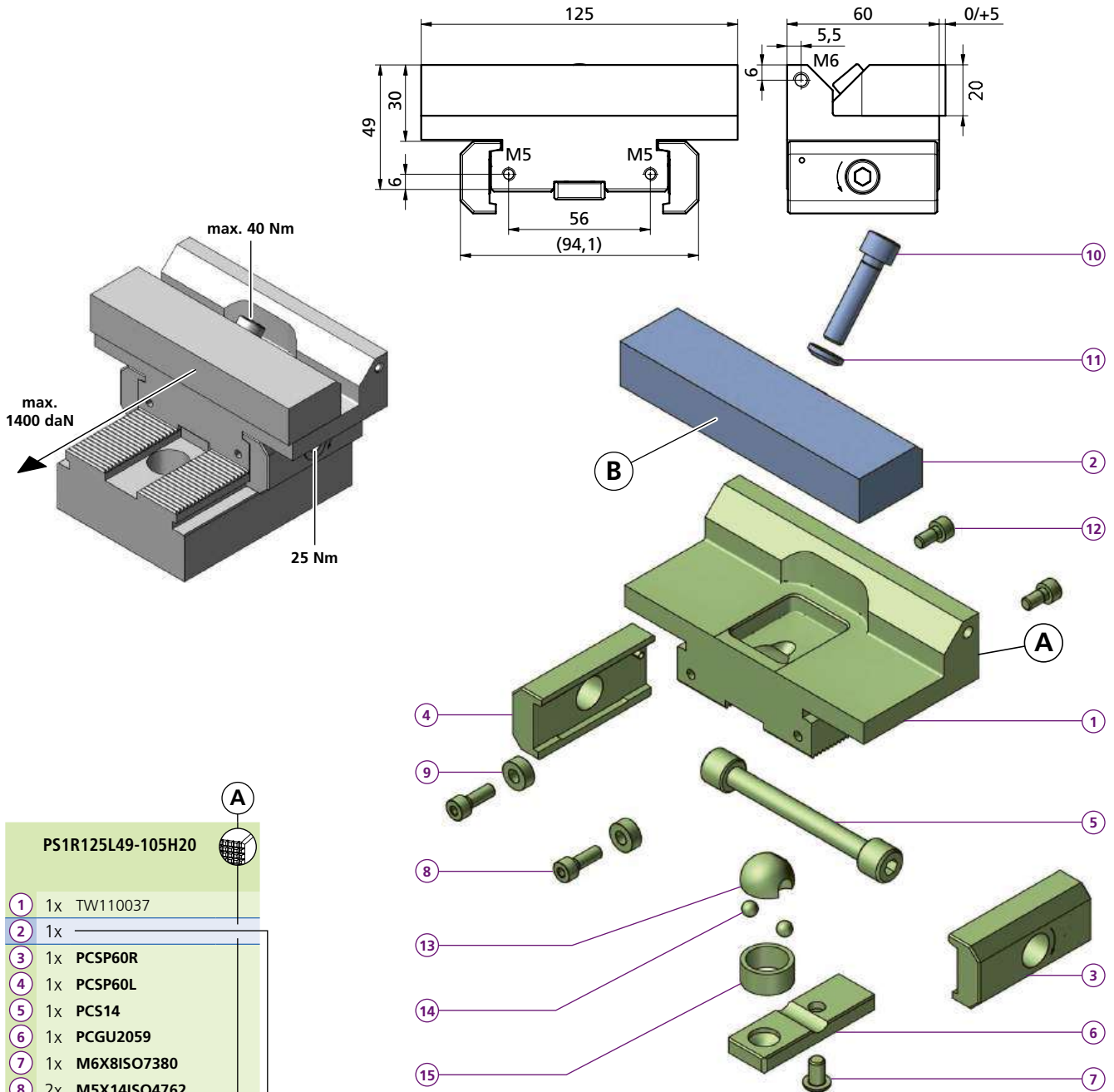


Separat bestellen / Order separately



Zum Erstellen Ihrer individuellen Formbacke: *If a dedicated jaw is being machined:*

Schnittzeichnung zum Ermitteln der maximalen Bearbeitungsprofiltiefe *Sectional drawing to determine the maximum machining depth*



PS1R125L49-105H20	
1	1x TW110037
2	1x
3	1x PCSP60R
4	1x PCSP60L
5	1x PCS14
6	1x PCGU2059
7	1x M6X8ISO7380
8	2x M5X14ISO4762
9	2x PCD005
10	1x M8X35ISO4762
11	1x PCUSR14
12	2x M5X10ISO4762
13	1x PCKMR45M8
14	2x D=6 DIN 5401
15	1x PCD20L095
kg	~1,7
PS1F125L49-105H20	
1	1x TH150895
X	= 125
kg	~1,7

Bestellbeispiel / Ordering example: 1x PS1R125L49-105H20 & 1x B132H20P			
	B130H20P	B131H20P	B132H20P
C	125	125	125
H	20	20	20
L	47	47	47
i	HV700 x0,2mm	HV700 x0,2mm	*
kg	~0,71	~0,71	~0,71

B130H20P, B131H20P, B132H20P

* = weicher Stahl / soft steel



zum Einsatz in unterschiedlichen Spannsituationen
for use in different clamping situations

Art. Nr.				kg
B110	HV700 x 0,2mm			~0,49
B110P	HV700 x 0,2mm	$\pm 4^\circ$		~0,49

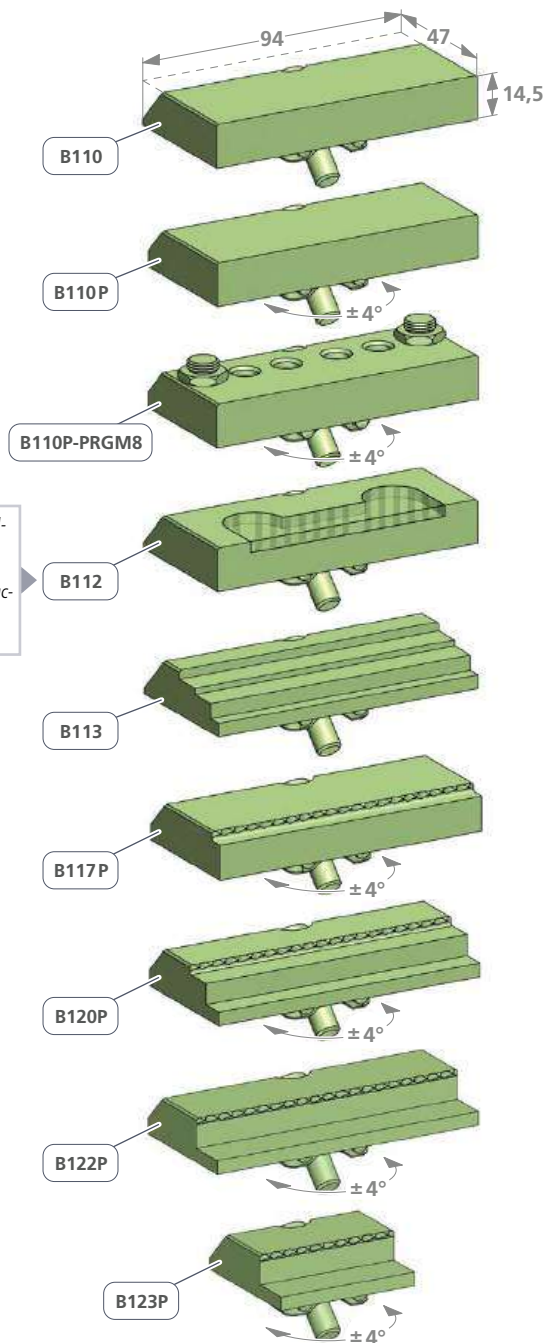


mit Prägeeinsätzen
with direct-stamping inserts

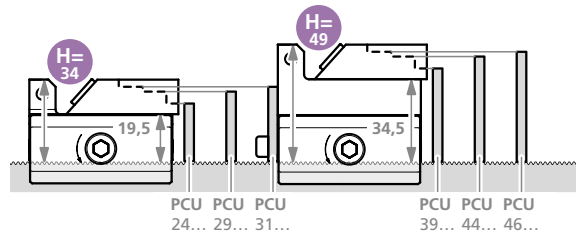
Art. Nr.			kg
B110P-PRGM8	HV700 x 0,2mm		~0,46

Art. Nr.				kg
B111	HV700 x 0,2mm			~0,48
B111P	HV700 x 0,2mm	$\pm 4^\circ$		~0,48
B112	weicher Stahl soft steel (1.2312)			~0,49
B112P	weicher Stahl soft steel (1.2312)	$\pm 4^\circ$		~0,49
B112HG	Hochgenau High-precision			~0,49
B112E	Einsatzstahl (1.5752) Case hardening steel			~0,49
B112EP	Einsatzstahl (1.5752) Case hardening steel	$\pm 4^\circ$		~0,47
B113	HV700 x 0,2mm			~0,39
B113P	HV700 x 0,2mm	$\pm 4^\circ$		~0,39
B117P	57HRC	$\pm 4^\circ$		~0,46
B120	57HRC			~0,4
B120P	57HRC	$\pm 4^\circ$		~0,4
B122P	57HRC	$\pm 4^\circ$		~0,37
B123P	57HRC	$\pm 4^\circ$		~0,21

Weich, zur Herstel-
lung individueller
Formbacke.
Soft, for the produc-
tion of individual
moulding jaw.



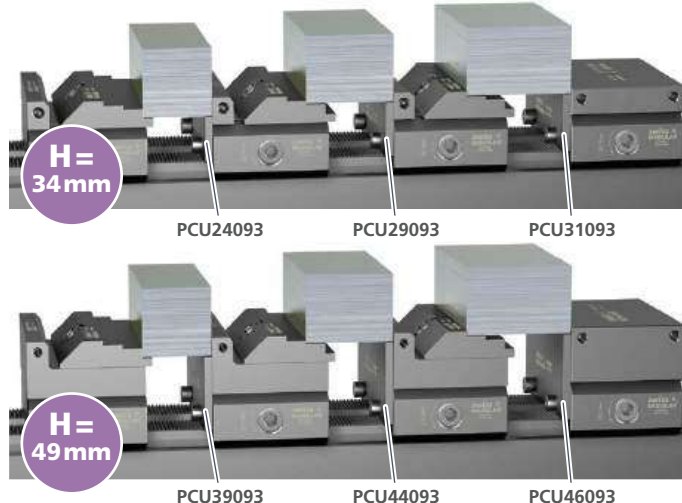
Modulhöhen / Module heights 34 / 49 mm



Beim Einsatz einer Stufenbacke, ist die richtige Modul-
spannhöhe 34 mm / 49 mm zu berücksichtigen. Die Werkstücke
auf der Anschlagseite werden mit den passenden Parallel-
unterlagen abgestützt.

When using a step jaw is applied, the correct module
clamping height 34 mm / 49 mm must be taken into account. The work-
pieces on the end module are supported with the appropriate
steel parallel.

Eingesetzte Stufenbacken / Inserted stepped jaws (B113)



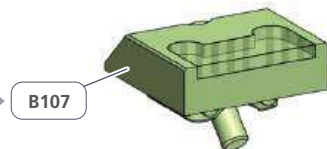
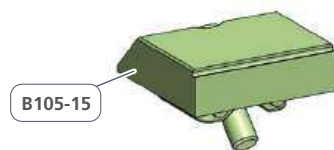
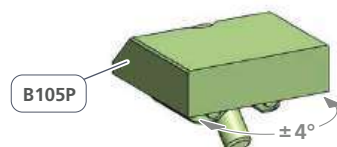
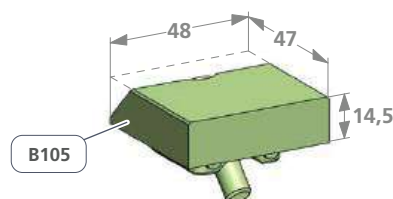
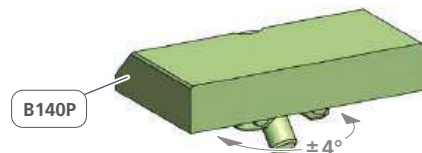
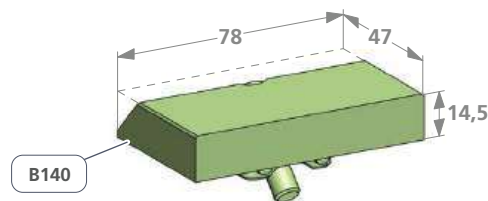
Linear- Spannbacken ... Linear clamping jaws ...



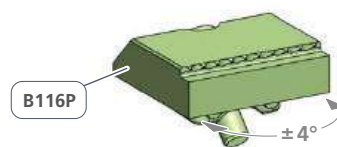
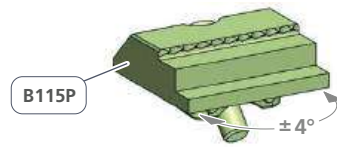
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zum Einsatz in unterschiedlichen Spannsituationen
for use in different clamping situations

Art.Nr.				kg
B140	HV700 x 0,2mm			~0,41
B140P	HV700 x 0,2mm	$\pm 4^\circ$		~0,41
B141	HV700 x 0,2mm			~0,41
B141P	HV700 x 0,2mm	$\pm 4^\circ$		~0,41
B105	HV700 x 0,2mm			~0,27
B105P	HV700 x 0,2mm	$\pm 4^\circ$		~0,27
B105-15	HV700 x 0,2mm			~0,27
B106	HV700 x 0,2mm			~0,27
B106P	HV700 x 0,2mm	$\pm 4^\circ$		~0,27
B107	weicher Stahl soft steel (1.2312)			~0,27
B107P	weicher Stahl soft steel (1.2312)	$\pm 4^\circ$		~0,27
B108	HV700 x 0,2mm			~0,22
B108P	HV700 x 0,2mm	$\pm 4^\circ$		~0,22
B115	57HRC			~0,21
B115P	57HRC	$\pm 4^\circ$		~0,21
B116P	57HRC	$\pm 4^\circ$		~0,25



Weich, zur Herstellung individueller Formbacken.
Soft, for the production of individual moulding jaw.



Für Prägebacken / For stamping jaws

PF-SET Kräfteerhaltung mit Nachfederung
Spring loaded mechanism to maintain clamping force

Bei allen Prägebacken kann die Kräfteerhaltung mit den nachfedernden Tellerfedern eingesetzt werden um ein Freiwigeln des Werkstücks zu verhindern.

On every spring loaded stamping jaw, the force retention with the disc springs can be used to prevent the workpiece from wiggling free.

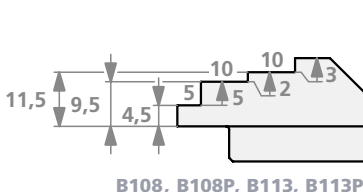


Die Tellerfedern werden gegenläufig montiert.

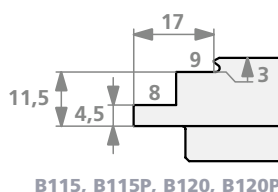
The disc springs are mounted in opposite directions.



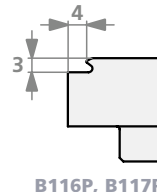
Detailvermessung der Stufenbacken / Detailed dimensioning of the stepped jaws



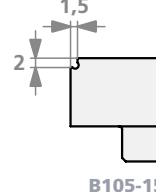
B108, B108P, B113, B113P



B115, B115P, B120, B120P



B116P, B117P



B105-15

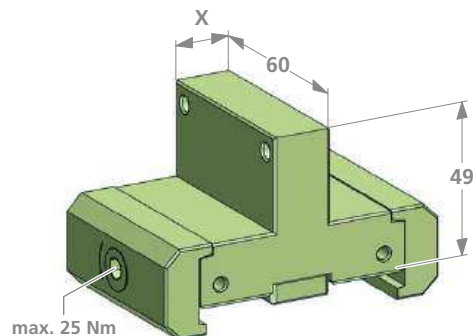
Anschlagmodule ... End module ...



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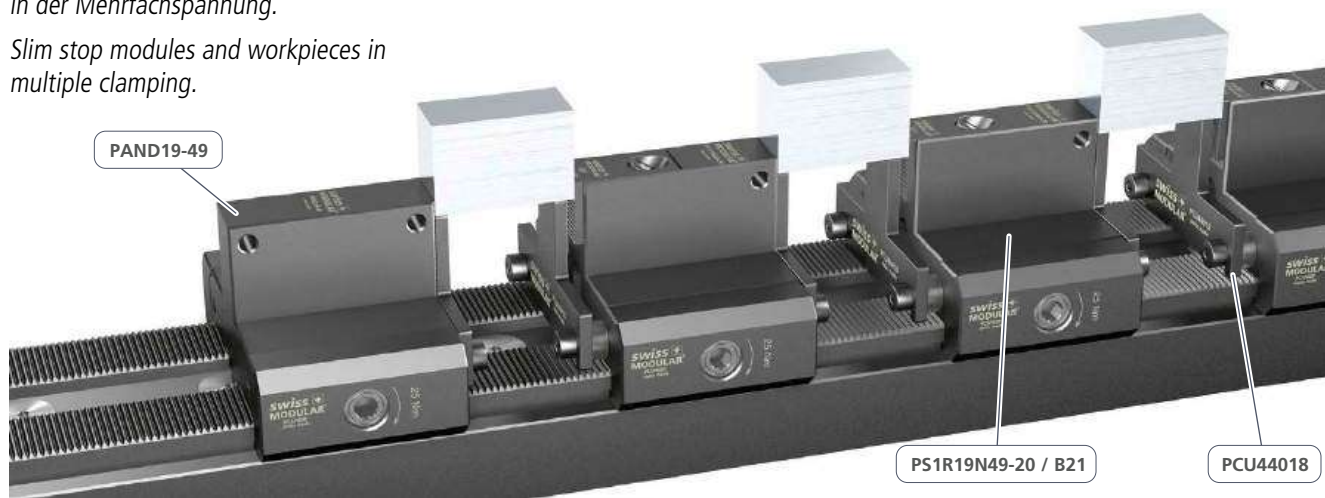
für die horizontale und vertikale Bearbeitung
for horizontal and vertical machining

Art. Nr.	kg	X
PAND19-49	~1,2	19
PAND26-49	~1,3	26
PAND34-49	~1,4	34



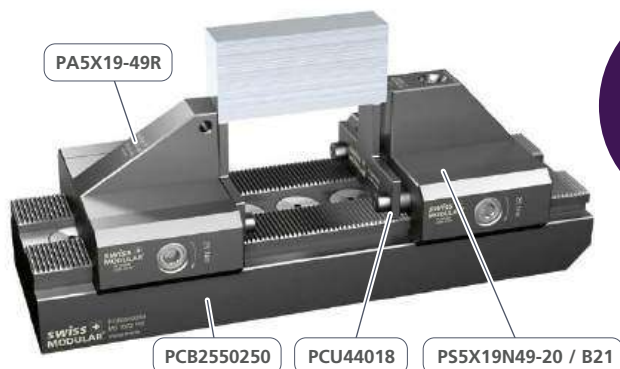
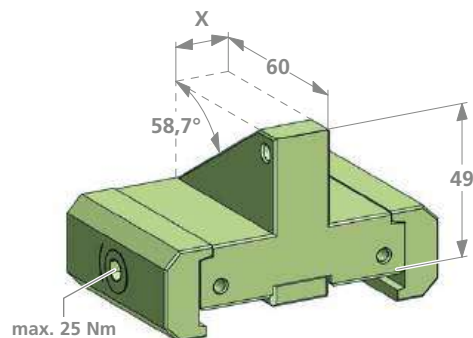
Schmale Anschlagmodule und Werkstücke
in der Mehrfachspannung.

Slim stop modules and workpieces in
multiple clamping.



für 5-Achs Bearbeitung
for 5-axis machining

Art. Nr.	kg	X
PA5X19-49F	~1,1	19
PA5X19-49R	~1,1	19
PA5X26-49F	~1,1	26
PA5X26-49R	~1,1	26
PA5X34-49F	~1,2	34
PA5X34-49R	~1,2	34



Module
einsetzbar auf
Zentrischspannern
oder Basisschienen.
Modules
can be used on self
centrig vises or
base rails.



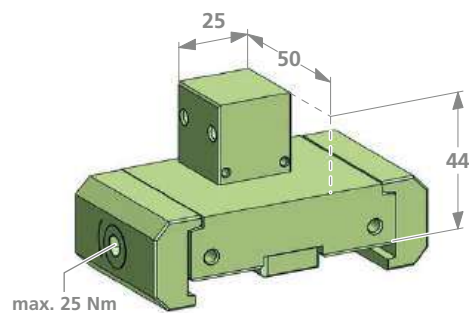
Anschlagmodule ... End module ...



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für die horizontale und vertikale Bearbeitung
for horizontal and vertical machining

Art. Nr.	kg
PAND25-44	~0,9

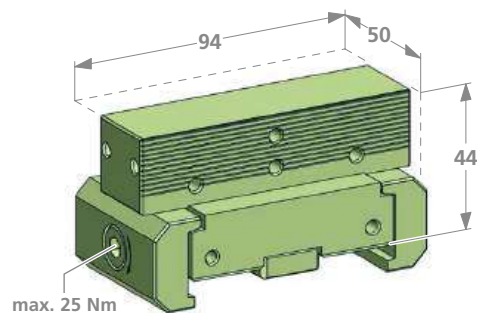


Schlankes und kurzes Anschlagmodul für
Kleinteil-Serien (Mehrfachspannung).

Slim and short end module for small part series
(Multiple workholding).



Art. Nr.	kg
PAND94-44	~1,3



Die Anschlagfläche enthält 2 Passbohrungen. Mit MS50 Passschrauben kann mittig ein Seitenanschlag präzise platziert werden.

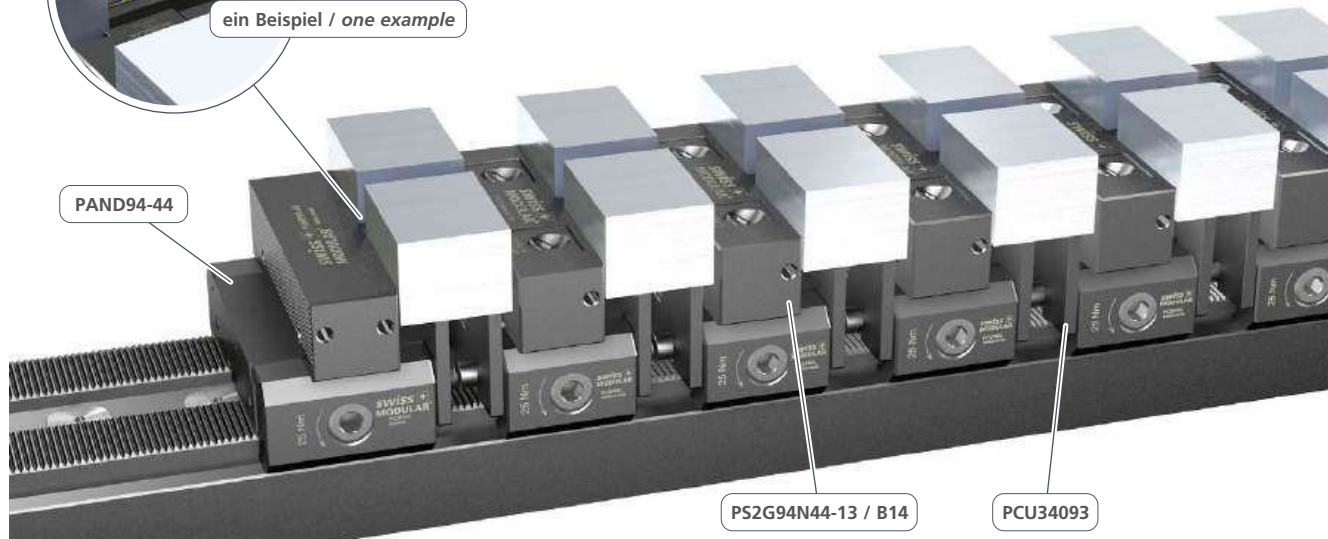
The stop surface contains 2 fitting holes. A side stop can be placed precisely in the centre with MS50 fitting screws.

Anschlagmodul mit Doppelspannfunktion. Verdoppelt die Anzahl Spannbereiche auf gleichbleibendem Raum.

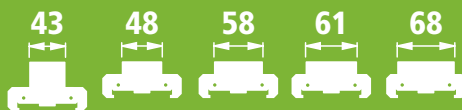
End module with double clamping function. Doubles the number of clamping areas in the same amount of working space.



ein Beispiel / one example



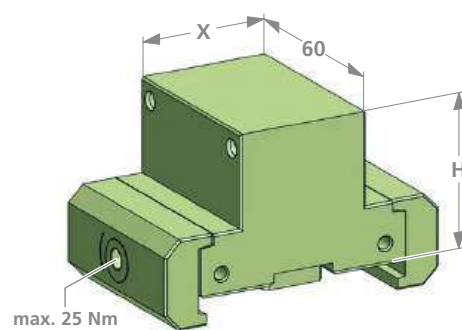
Anschlagmodule ... End module ...



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für die horizontale und vertikale Bearbeitung
for horizontal and vertical machining

Art. Nr.		kg	X	H
PAND43-49		~1,6	43	49
PAND48-34		~1,3	48	34
PAND48-49		~1,6	48	49
PAND48-75		~2,2	48	75
PAND58-34		~1,4	58	34
PAND58-49		~1,8	58	49
PAND61-34		~1,4	61	34
PAND68-34		~1,4	68	34



43 mm bis 68 mm breite Anschlagmodule
für die Einzel- und Mehrfachspannung.
43 mm to 68 mm wide end modules for
single and multiple clamping.

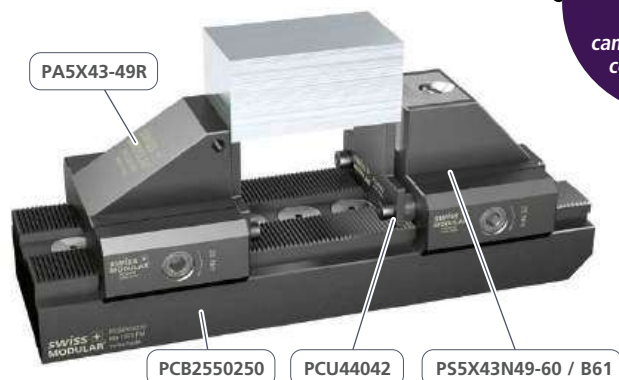
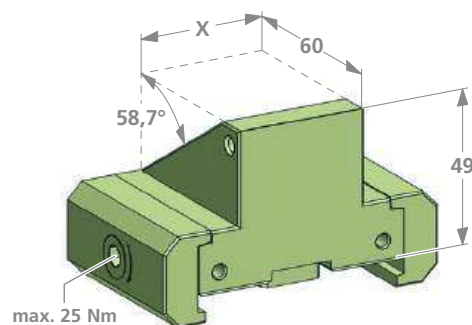


für 5-Achs Bearbeitung
for 5-axis machining

Art. Nr.		kg	X
PA5X43-49F		~1,3	43
PA5X43-49R		~1,3	43
PA5X48-49F		~1,4	48
PA5X48-49R		~1,4	48



Module
einsetzbar auf
Zentrischspannern
oder Basisschienen.
Modules
can be used on self
centrig vises or
base rails.



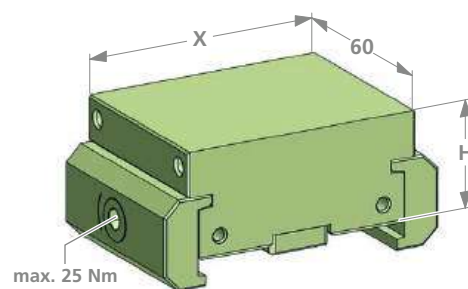
Anschlagmodule ... End module ...



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für die horizontale und vertikale Bearbeitung
for horizontal and vertical machining

Art. Nr.		kg	X	H
PAND78-34		~1,5	78	34
PAND78-49		~2,1	78	49
PAND94-34		~1,6	94	34
PAND94-49		~2,3	94	49
PAND125-49		~2,7	125	49



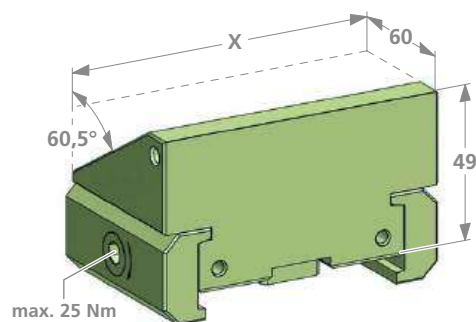
78 mm bis 125 mm breite Anschlagmodule
für die Einzel- und Mehrfachspannung.

78 mm to 125 mm wide end modules for
single and multiple clamping.



für 5-Achs Bearbeitung
for 5-axis machining

Art. Nr.		kg	X
PA5X94-49F		~1,8	94
PA5X94-49R		~1,8	94
PA5X125-49F		~2,0	125
PA5X125-49R		~2,0	125



Module
einsetzbar auf
Zentrischspannern
oder Basisschienen.
Modules
can be used on self
centrig vises or
base rails.



PAND48-34PRG/F-A1
PAND48-49PRG/F-A1
PAND94-34PRG/F-A1

PAND94-49PRG/F-A1
PAND125-49PRG-A1



prägen
stamping

5axes
powerCLAMP

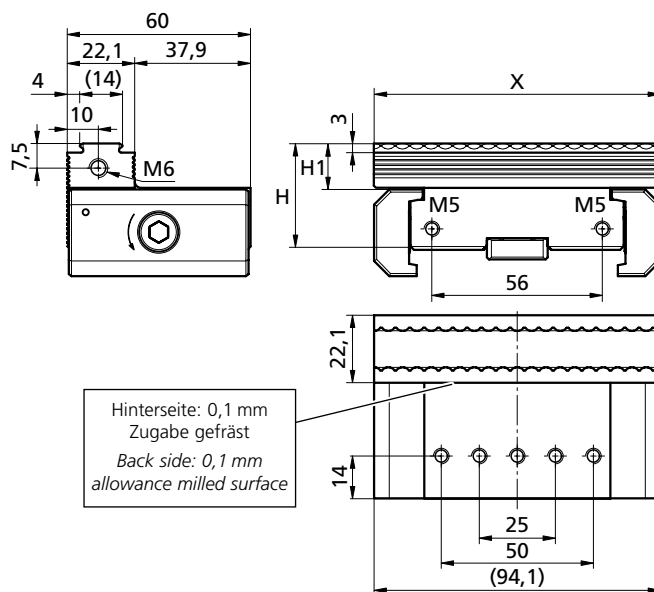
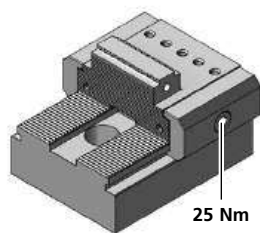
PAND48-34PRG-A1

1x TH120684

PAND48-34PRF-A1

1x TK140239
 3x PCSP60R
 4x PCSP60L
 5x PCS14
 6x PCGU2049
 7x M6X8ISO7380
 12x M5X10ISO4762

X = 48
 H = 34
 H1 = 15
 kg ~1,1



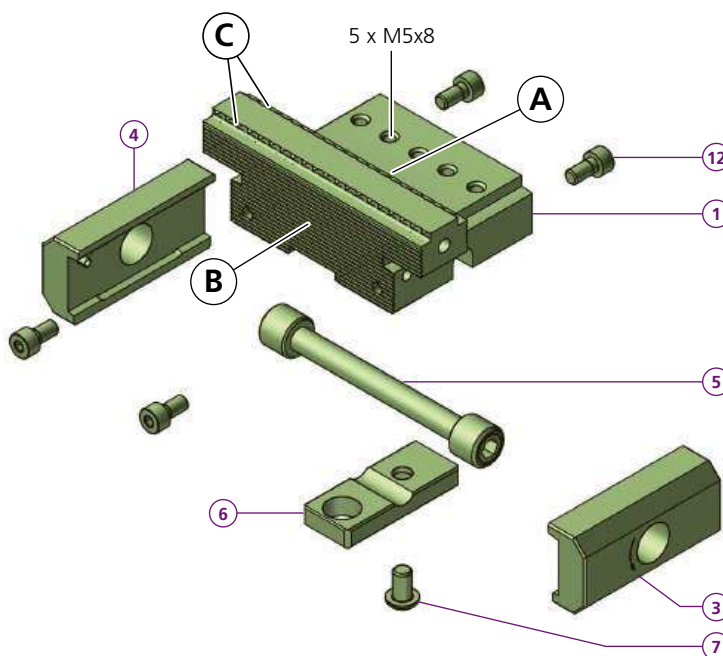
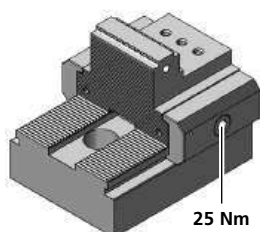
PAND48-49PRG-A1

1x TH120685

PAND48-49PRF-A1

1x TK140597

X = 48
 H = 49
 H1 = 30
 kg ~1,3



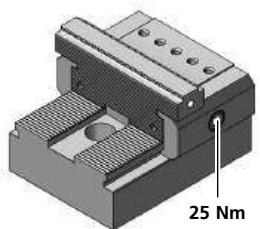
PAND94-34PRG-A1

1x TH120686

PAND94-34PRF-A1

1x TH140185

X = 94
 H = 34
 H1 = 15
 kg ~1,2



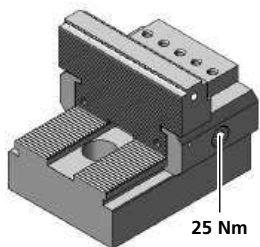
PAND94-49PRG-A1

1x TH120687

PAND94-49PRF-A1

1x TH130754

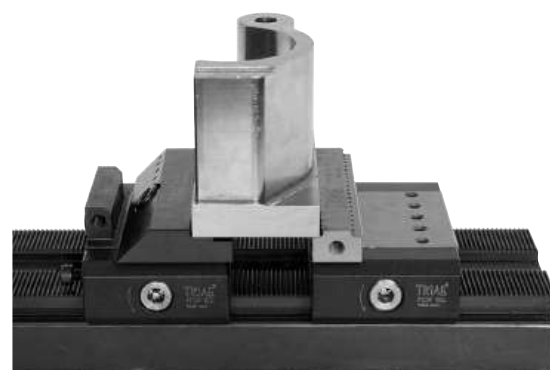
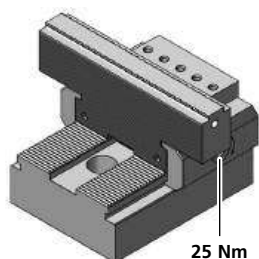
X = 94
 H = 49
 H1 = 30
 kg ~1,6



PAND125-49PRG-A1

1x TB160295

X = 125
 H = 49
 H1 = 30
 kg ~1,7



Bestellbeispiel / Ordering example: **PAND94-34PRG-A1**

PAND125-34PRG-A1

PAND150-34PRG-A1

PAND94-34PRGV

PAND94-49PRGV

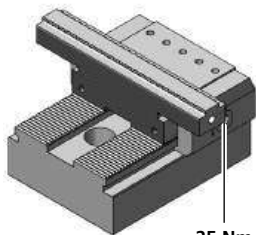


prägen
stamping

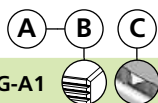
5axes

powerCLAMP

X = 125



25 Nm



PAND125-34PRG-A1

1x TB180899

X = 125

kg ~1,2

PAND150-34PRG-A1

1x TB160145

3x PCSP50R

4x PCSP50L

5x PCS14

6x PCGU2049

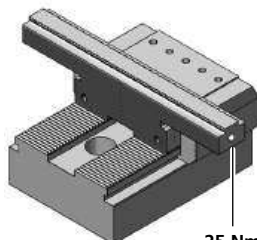
7x M6X8ISO7380

12x 4x M5X10ISO4762

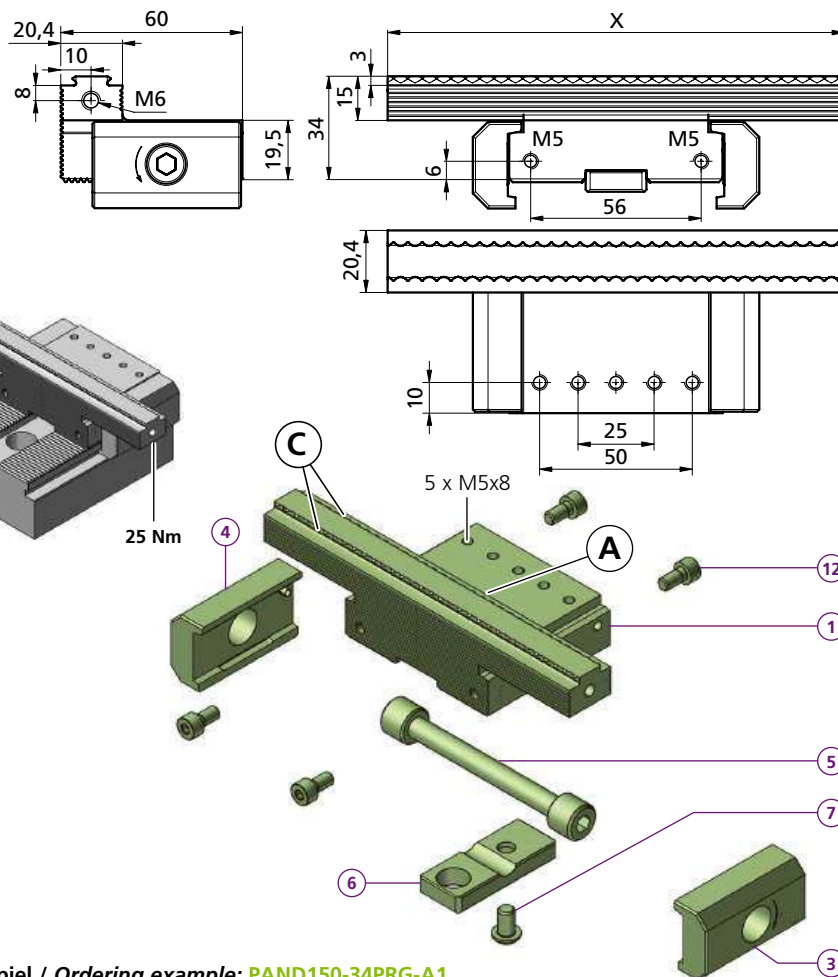
X = 150

kg ~1,2

X = 150

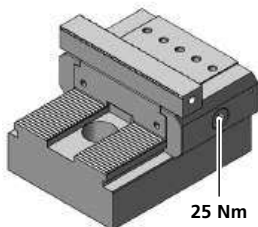


25 Nm



Bestellbeispiel / Ordering example: PAND150-34PRG-A1

H = 34



25 Nm



PAND94-34PRGV

1x TH171180

3x PCSP60R

4x PCSP60L

5x PCS14

6x PCGU2049

7x M6X8ISO7380

12x 4x M5X10ISO4762

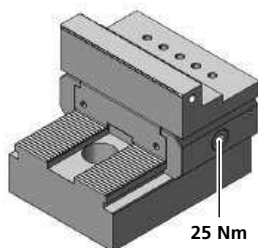
H = 34

H1 = 15

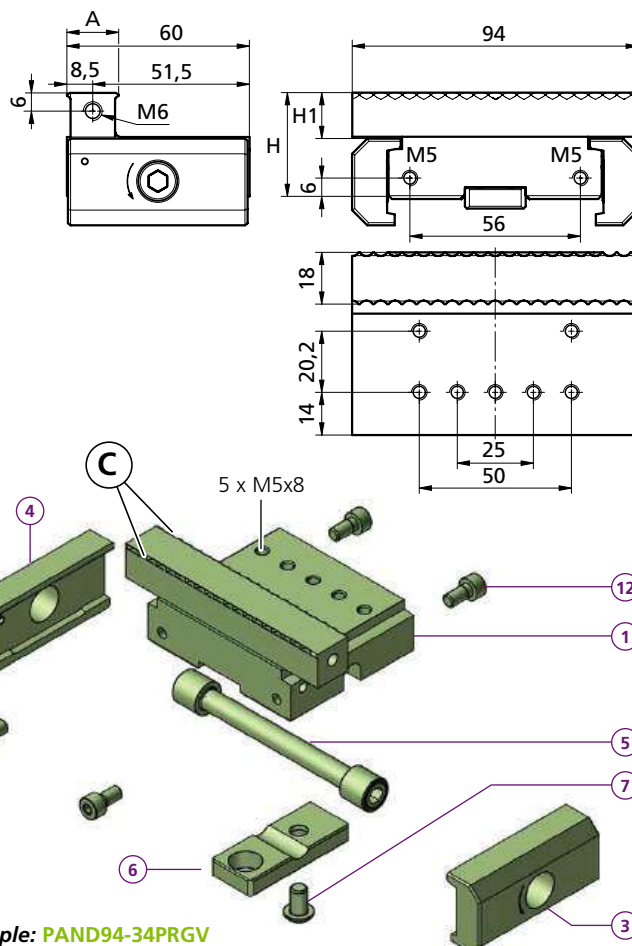
A = 17,5

kg ~1,2

H = 49



25 Nm



Bestellbeispiel / Ordering example: PAND94-34PRGV

PAND94-49PRGV

1x TH171179

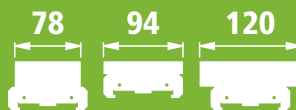
H = 49

H1 = 30

A = 17

kg ~1,6

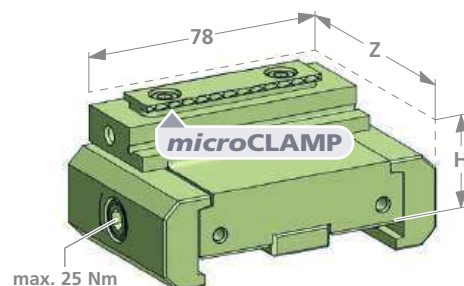
Anschlagmodule zum Prägen ... End modules for stamping ...



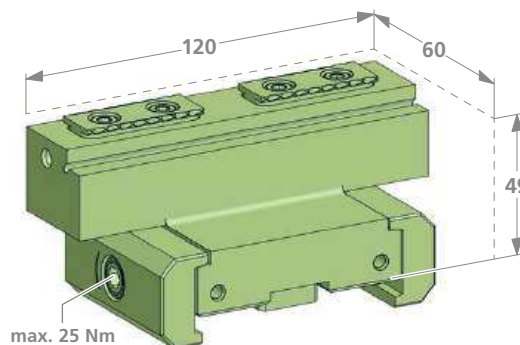
5axes
powerCLAMP

für die horizontale und vertikale Bearbeitung
for horizontal and vertical machining

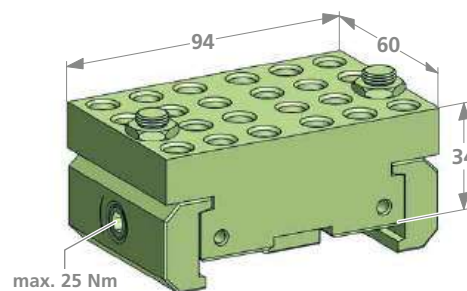
Art. Nr.		kg	Z	H
PAND78-34UPRG	 	~1,2	60	34
PAND78-49UPRG	 	~1,5	60	49
PAND78-34X50UPRG	 	~1,0	50	34



Art. Nr.		kg
PAND120-49UPRG	 	~1,8

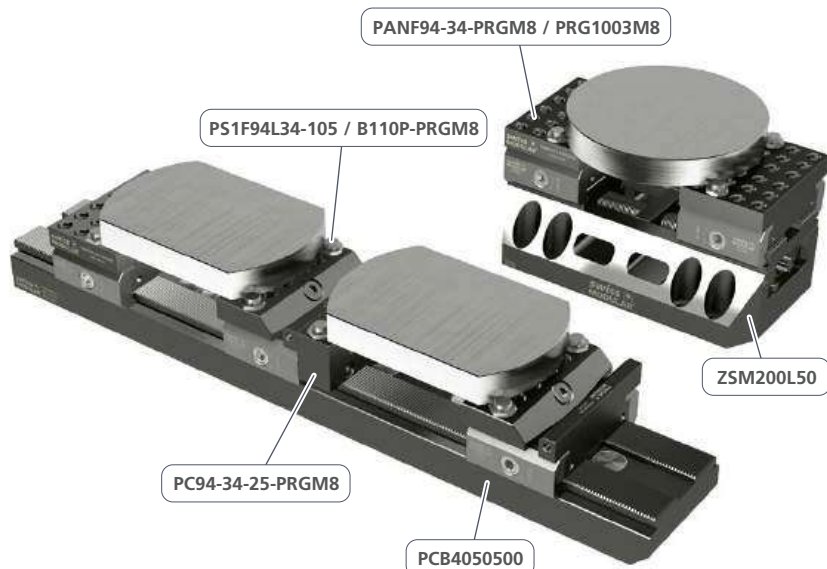
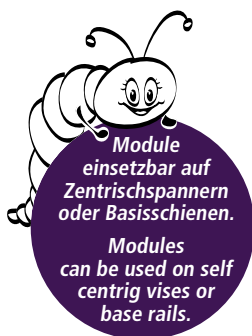


Art. Nr.		kg
PANF94-34PRGM8	 	~1,5



Der Einsatz dieser Spannmodule erweitert die Spannmöglichkeiten für runde und unförmige Werkstücke erheblich.

The use of these clamping modules expands the clamping possibilities for round and bulky workpieces considerably.



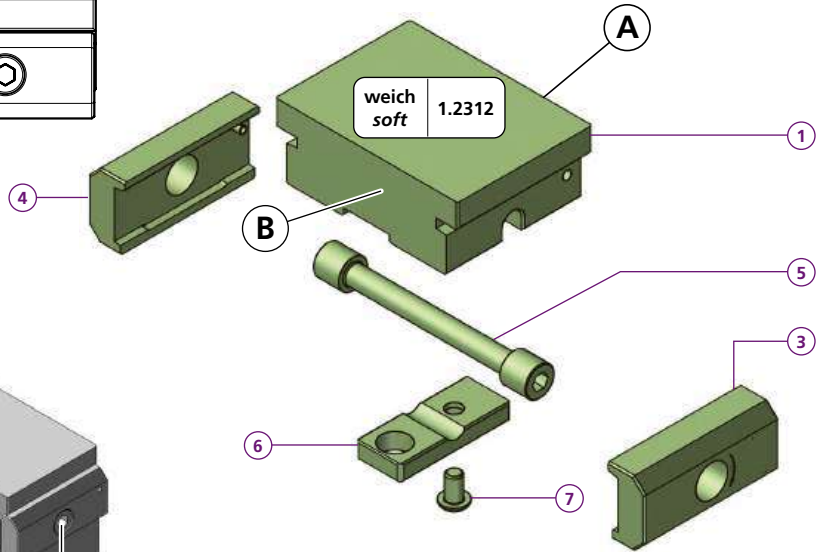
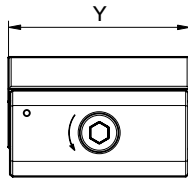
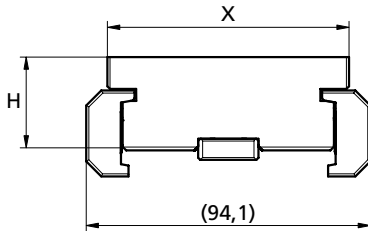
Bei knapp gespannten Werkstücken sind direkt-Prägebacken die ideale Wahl zum spannen.
For tight clamped workpieces, direct stamping jaws are the ideal choice for clamping.

Rohlingsmodule Blank module

PT-F80-30X60
PT-F80-30X60NS
PT-F80-30X30NS

PT-F61-25X60
PT-F61-25X50
PT-F61-25X30

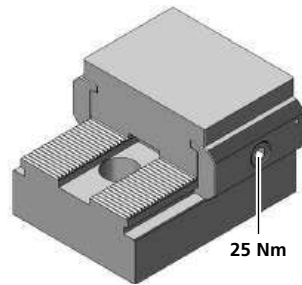
5axes
powerCLAMP



PT-F80-30X60

- 1x TF140637
- 1x PCSP60R
- 1x PCSP60L
- 1x PCS14
- 1x PCGU2049
- 1x M6X8ISO7380

X = 80
H = 30
Y = 60
kg ~1,4

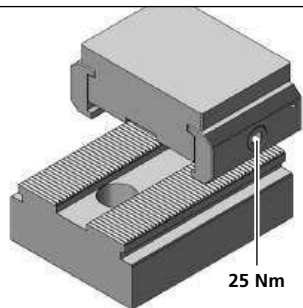


PT-F80-30X60NS

- 1x TF140635
- 1x PCSP60R
- 1x PCSP60L
- 1x PCS14
- 1x PCGU2049
- 1x M6X8ISO7380

X = 80
H = 30
Y = 60
kg ~1,4

NS = Rohlingsmodul freie Positionierung
ohne Verzahnung
Carrier module without positioning
serration for free positioning

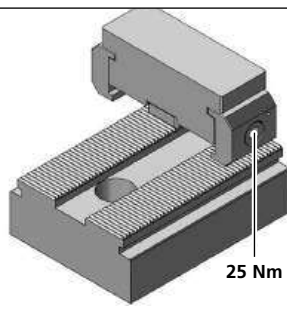


PT-F80-30X30NS

- 1x TF140749
- 1x PCSP30R
- 1x PCSP30L
- 1x PCS14
- 1x PCGU2030
- 1x M6X8ISO7380

X = 80
H = 30
Y = 30
kg ~0,7

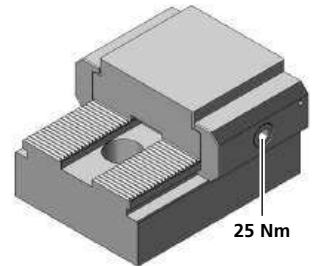
NS = Rohlingsmodul freie Positionierung
ohne Verzahnung
Carrier module without positioning
serration for free positioning



PT-F61-25X60

- 1x TF140638
- 1x PCSP60R
- 1x PCSP60L
- 1x PCS14
- 1x PCGU2049
- 1x M6X8ISO7380

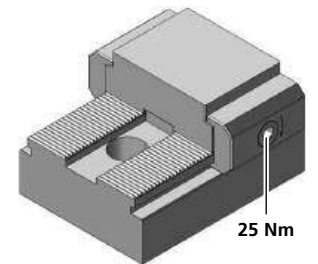
X = 61
H = 25
Y = 60
kg ~1,1



PT-F61-25X50

- 1x TF140750
- 1x PCSP50R
- 1x PCSP50L
- 1x PCS14
- 1x PCGU2049
- 1x M6X8ISO7380

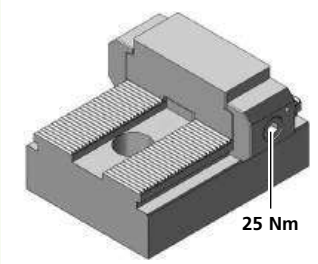
X = 61
H = 25
Y = 50
kg ~1,0



PT-F61-25X30

- 1x TF140636
- 1x PCSP30R
- 1x PCSP30L
- 1x PCS14
- 1x PCGU2049
- 1x M6X8ISO7380

X = 61
H = 25
Y = 30
kg ~0,6



Bestellbeispiel / Ordering example: PT-F80-30X60

Rohlingsmodule Blank module

PR94-49SET

PR125-49SETALU

PT-F132-34RDSET

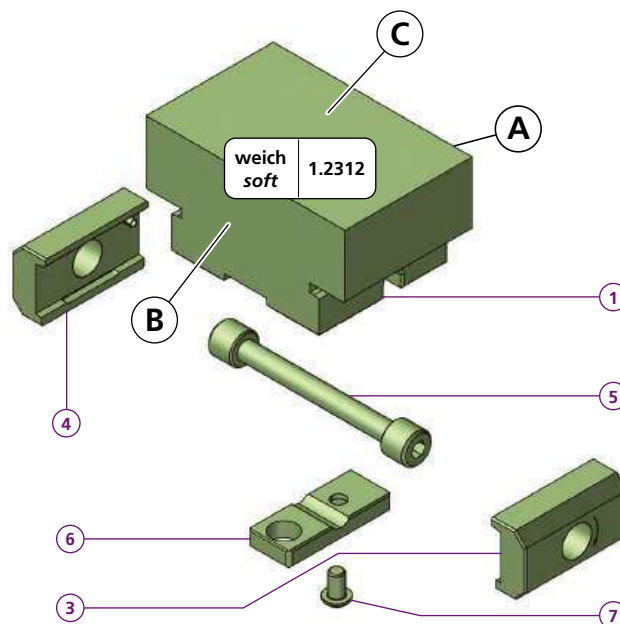
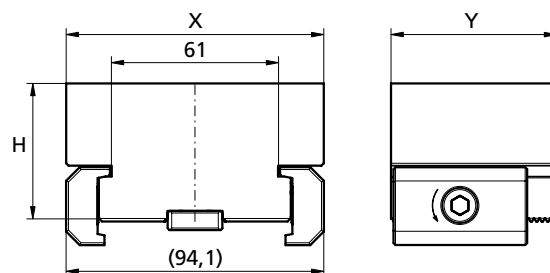
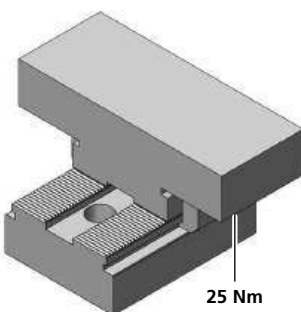
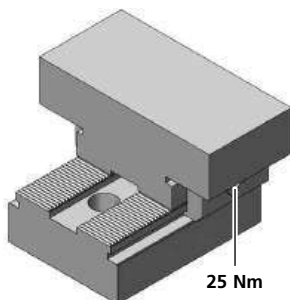
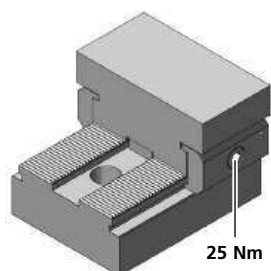
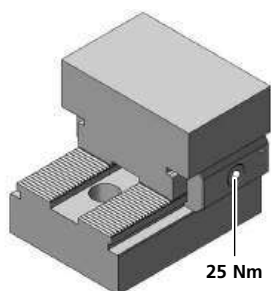
PR94-39-50SET

PR150-49SET

PR125-49SET

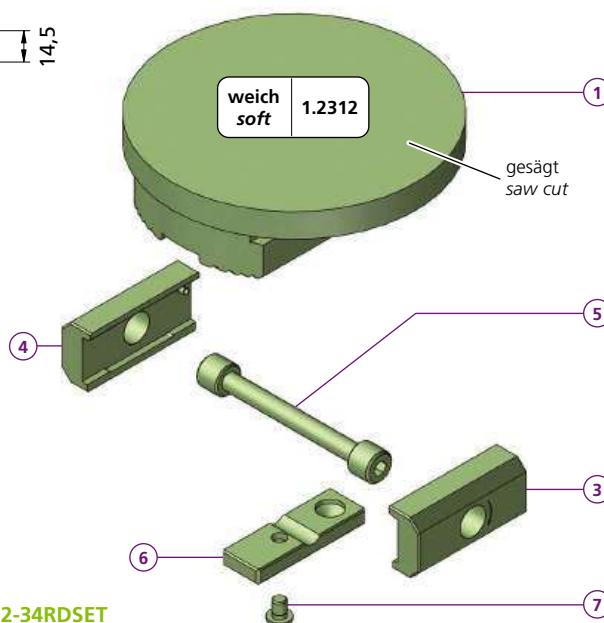
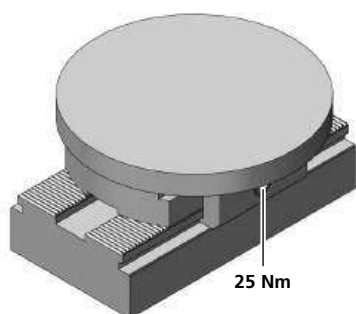
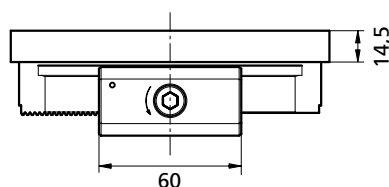
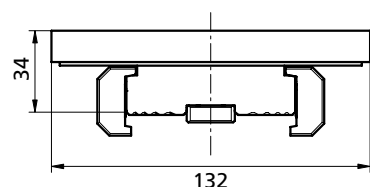
5axes powerCLAMP

	A	B	C
PR94-49SET			
1	1x	PR94-49	
3	1x	PCSP50R	
4	1x	PCSP50L	
5	1x	PCS14	
6	1x	PCGU2049	
7	1x	M6X8ISO7380	
X	=	94	
H	=	49	
Y	=	60,4	
kg	=	~2,3	
PR94-39-50SET			
1	1x	PR94-39-50	
X	=	94	
H	=	39	
Y	=	50,4	
kg	=	~1,6	
PR125-49SET			
1	1x	PR125-49	
X	=	125	
H	=	49	
Y	=	60,4	
kg	=	~2,7	
PR125-49SETALU			
1	1x	*PR125-49ALU	
X	=	125	
H	=	49	
Y	=	60,4	
kg	=	~0,83	
PR150-49SET			
1	1x	PR150-49	
X	=	150	
H	=	49	
Y	=	60,4	
kg	=	~3,1	



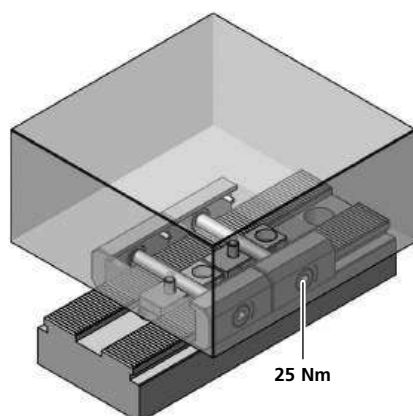
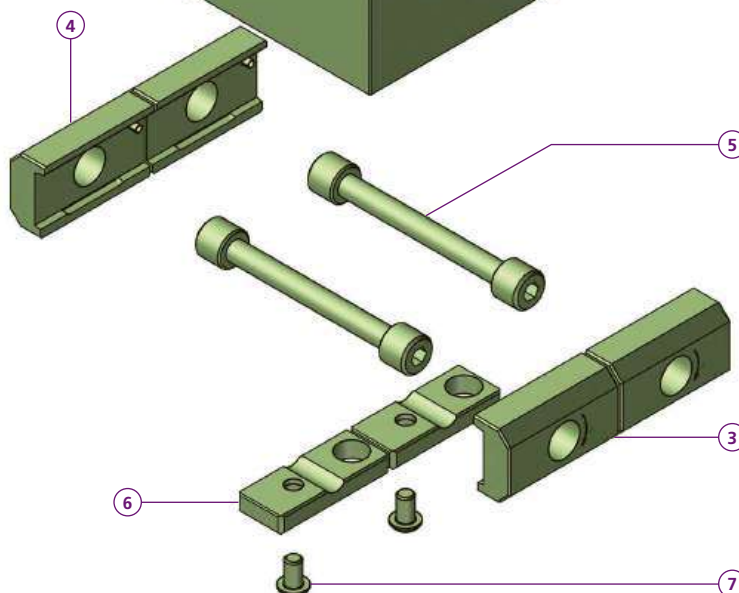
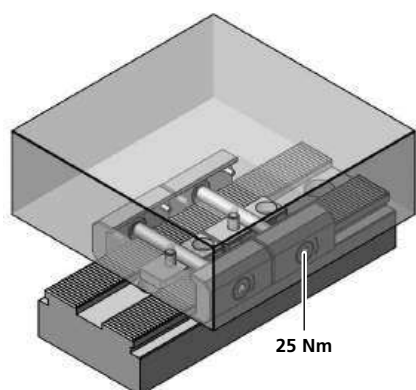
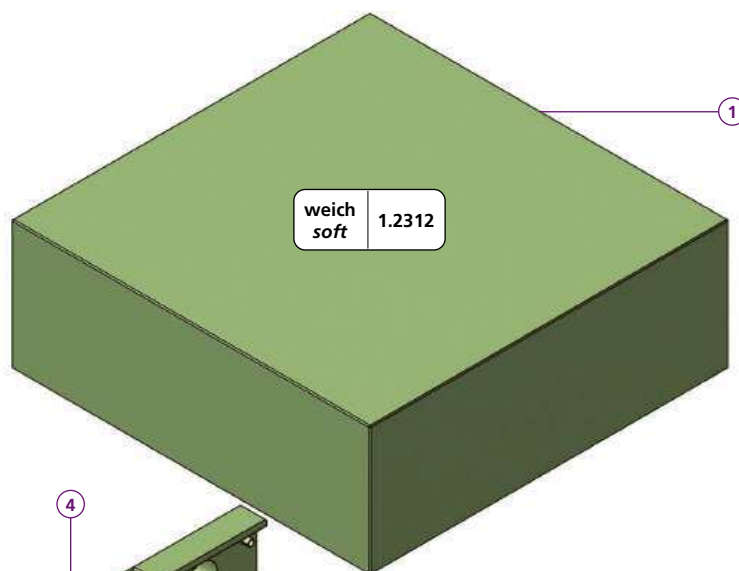
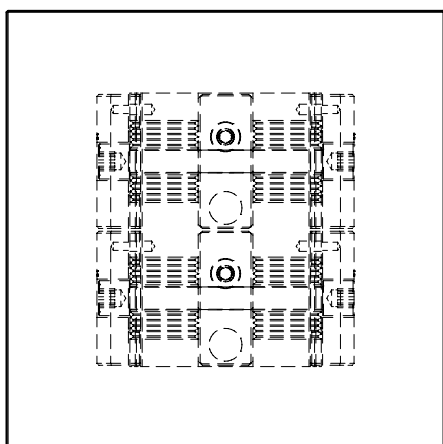
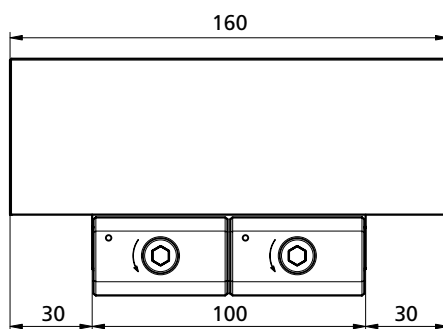
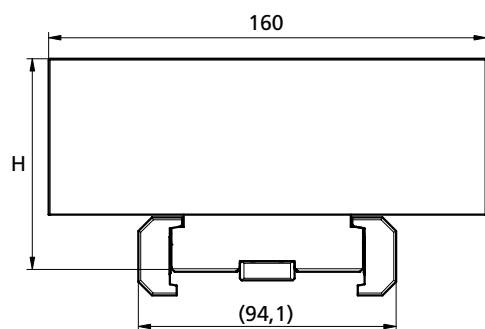
* ALU = ENAW-7022

Bestellbeispiel / Ordering example: PR94-49SET



PT-F132-34RDSET			
1	1x	PT-F132-34RD	
3	1x	PCSP60R	
4	1x	PCSP60L	
5	1x	PCS14	
6	1x	PCGU2059	
7	1x	M6X8ISO7380	
kg	=	~3,1	

Bestellbeispiel / Ordering example: PT-F132-34RDSET



PTX160-57S

- ① 1x TH130539
- ③ 2x PCSP50R
- ④ 2x PCSP50L
- ⑤ 2x PCS14
- ⑥ 2x PCGU2049
- ⑦ 2x M6X8ISO7380

H = 57

kg ~9

PTX160-77S

- ① 1x TH130723

H = 77

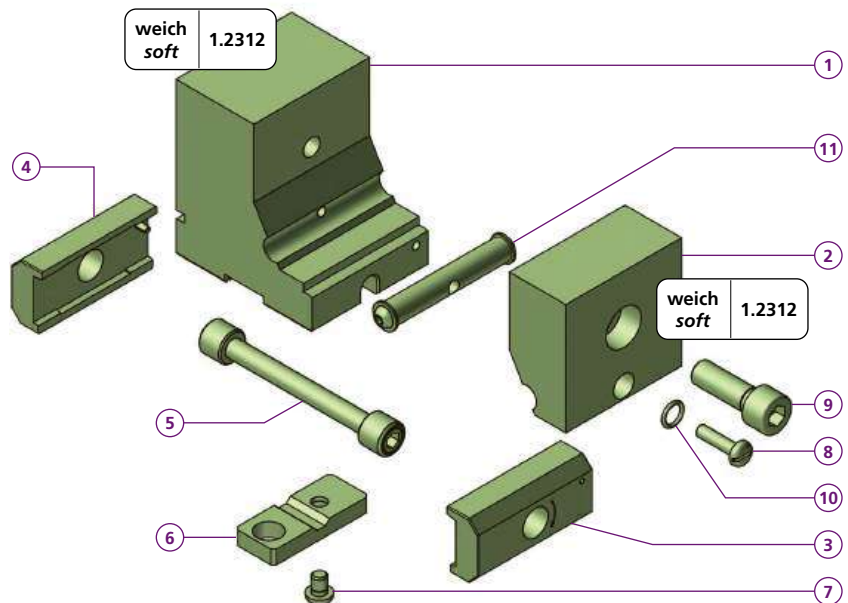
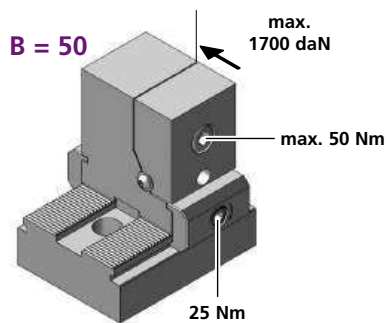
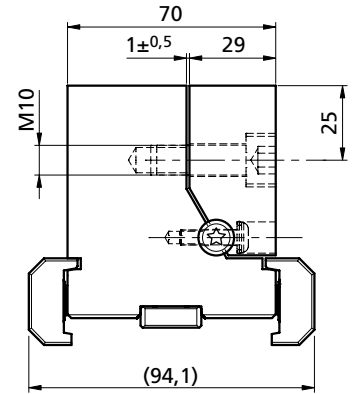
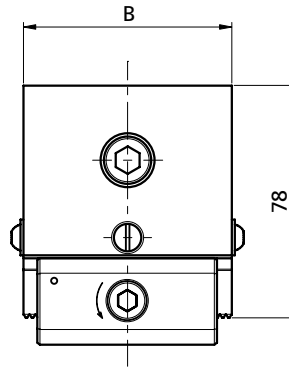
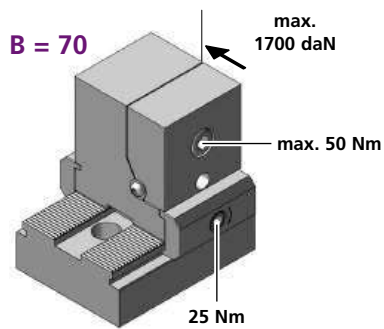
kg ~13

Bestellbeispiel / Ordering example: **PTX160-57S**

Schnellwechsel - Spannbacken - Rohling

Quick change - jaw blank

5axes
powerCLAMP



PS1X70L78ST

- 1x PRS7078AST
- 1x PRS7078SST
- 1x PCSP60R
- 1x PCSP60L
- 1x PCS14
- 1x PCGU2049
- 1x M6X8ISO7380
- 1x M5X20BN1362
- 1x M10X30ISO4762
- 1x OR Ø 8x1,5
- 1x PRS7078G
- B = 70
- kg ~3,2

PS1X50L78ST

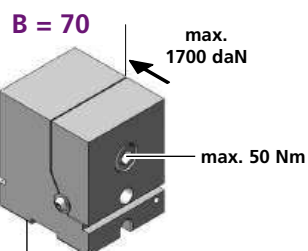
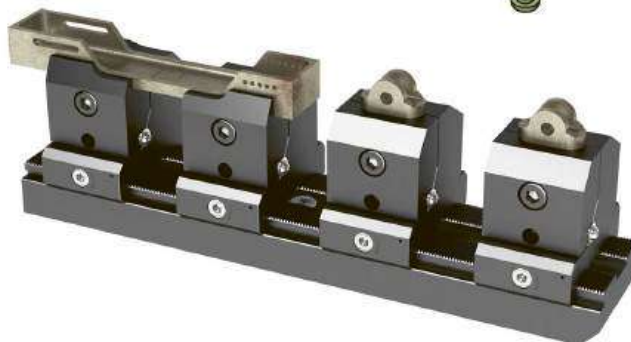
- 1x PRS5078AST
- 1x PRS5078SST
- 1x PCSP50R
- 1x PCSP50L
- 1x PRS5078G
- B = 50
- kg ~2,3

PRS70L78ST

- 1x PRS7078AST
- 1x PRS7078SST
- 1x PRS7078G
- B = 70
- kg ~2,8

PRS50L78ST

- 1x PRS5078AST
- 1x PRS5078SST
- 1x PRS5078G
- B = 50
- kg ~2,0



PRS = Rohlingsmodul ohne Spannpratzen
Blank module side clamp

Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
10	7,4	= 400	880	0,4
20	14,8	= 800	1'760	0,8
30	22,2	= 1'200	2'650	1,2
40	29,6	= 1'600	3'530	1,6



Spannbacken Rohling auf Kundenwunsch angepasst
Jaw blank machined to customer specification

Bestellbeispiel / Ordering example: **PS1X70L78ST**



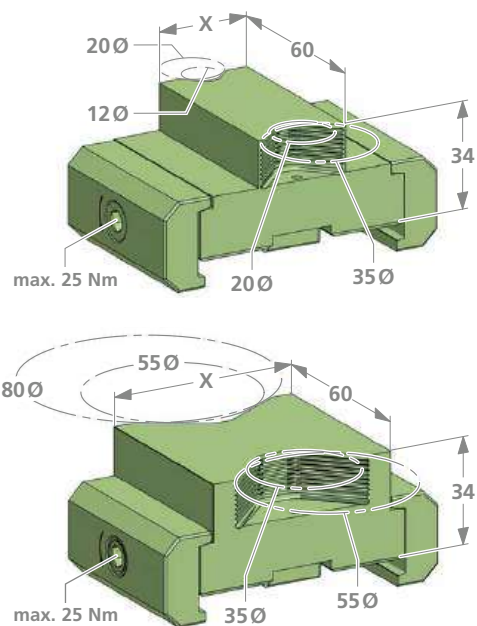
Anschlagmodul für runde Werkstücke Endmodule for round workpieces

Art. Nr.		Ø	X	kg
PAND30-34RV12-35		12 – 35	30	~1,1
PAND61-34RV35-80		35 – 80	61	~1,26

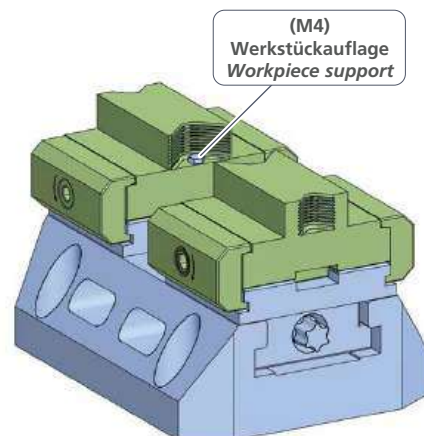


Runde Werkstücke, die einen Durchmesserbereich von 12 – 80 mm abdecken, können auf vielfältige Art gespannt werden.

Round workpieces covering a diameter range from 12 - 80 mm can be clamped in a variety of ways.



Module
einsetzbar auf
Zentrischspannern
oder Basisschienen.
Modules
can be used on self
centrig vises or
base rails.



Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
10	7,4	= 200	440	0,2
20	14,8	= 500	1'102	0,5
30	22,2	= 1'000	2'204	1,0
40	29,6	= 1'300	2'866	1,3
50	37,0	= 1'600	3'527	1,6

NUSS3/8"TX30E14

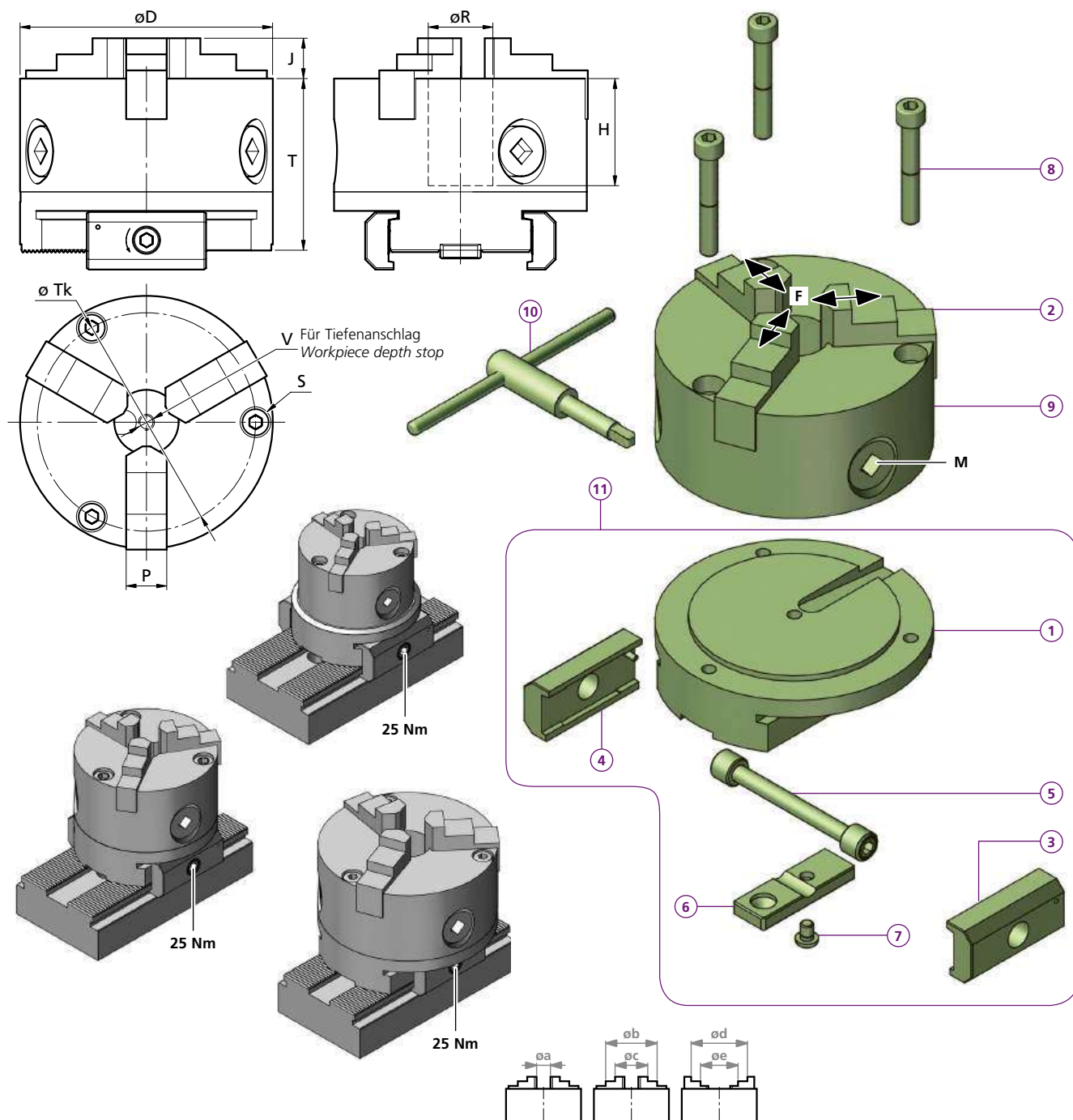
WICHTIG!
Bitte separat bestellen
IMPORTANT!
Please order separately



Dreibackenfutter Three jaw chuck

PS3X80L75BSET
PS3X100L82BSET
PS3X125L87BSET

5axes
powerCLAMP



	D	J	T	R	H	P	V	a mm	b mm	c mm	d mm	e mm	M (max.)	F (max.)	ø Tk	S
PS3X80L75BSET	80	13	75	15	42,5	10	M6	3...27	48...73	23...48	52...76	27...51	28 Nm	1300 daN	67	M6
PS3X100L82BSET	100	17	82	20	49,5	14	M8	3...39	58...94	24...60	64...100	30...66	38 Nm	1600 daN	83	M8
PS3X125L87BSET	125	19	87	32	55	16	M8	3...49	70...116	30...75	83...125	38...84	55 Nm	2600 daN	108	M8

PS3X80L75BSET	
1	1x TW090013_01
2	2x 3 Stk. / pcs
3	1x PCSP60R
4	1x PCSP60L
5	1x PCS14
6	1x PCGU2059
7	1x M6X8ISO7380
8	3x M6X45ISO4762
9	1x 243809.0083220
10	1x 243864.0080000
11	PTX80-30
kg	~2,8

PS3X100L82BSET	
1	1x TW090012_01
2	2x 3 Stk. / pcs
8	3x M8X50ISO4762
9	1x 243809.0103220
10	1x 243864.0100000
11	PTX100-30
kg	~4,3

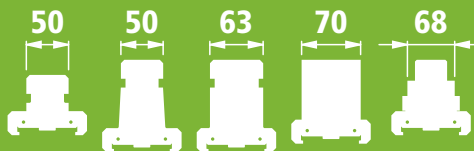
PS3X125L87BSET	
1	1x TW080027_01
2	2x 3 Stk. / pcs
8	3x M8X55ISO4762
9	1x 243809.0123220
10	1x 243864.0120000
11	PTX125-29
kg	~6,3

243849.0083200 243849.0103200 243849.0123200	243850.0083200 243850.0103200 243850.0123200	*243834.0083300 *243834.0103300 *243834.0123300
3x Ø 3 - 49	3x Ø 38 - 125	3x *Weich Soft 16MnCr5

Bestellbeispiel / Ordering example: PS3X125L87BSET

Separat bestellen / Order separately

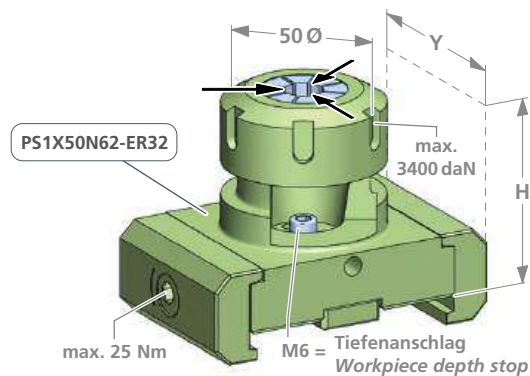
Spannzangenmodule Collet modules



**5axes
powerCLAMP**

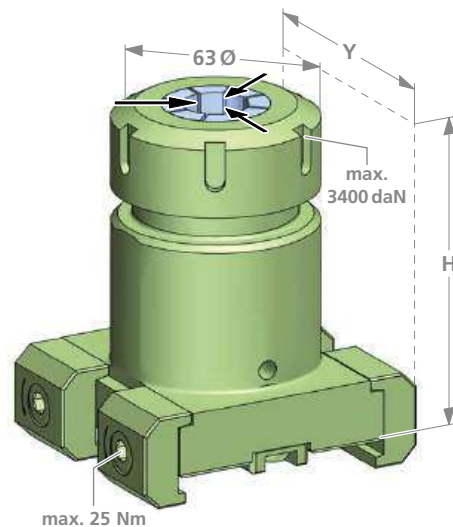
für die horizontale und vertikale Bearbeitung
for horizontal and vertical machining

Art. Nr.	kg	Ø	Y	H
PS1X50N62-ER32	~1,3	2-22	60	62
PS1X50N100-ER32	~2,2	2-22	60	100
PS1X63N100-ER40	~2,3	3-29	80	100



Diese Spannzangenmodule ermöglichen das ideale Spannen und Bearbeiten von Stangenmaterial.

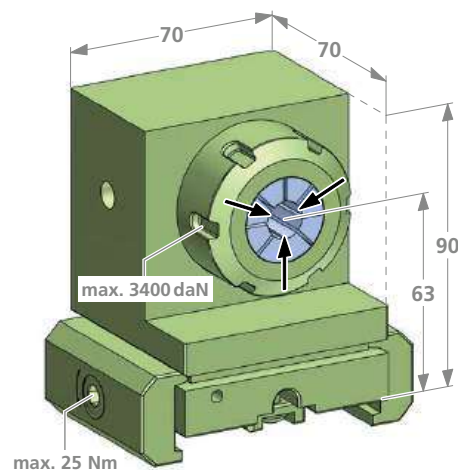
These collet modules enable ideal clamping and machining of bar material.



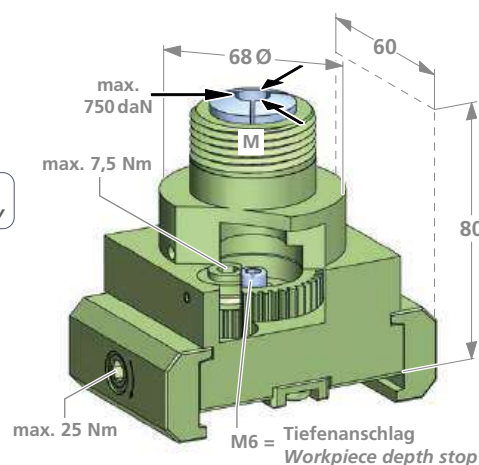
Art. Nr.	kg	Ø
PS1X50N70H-ER32-NS	~2,98	2-22

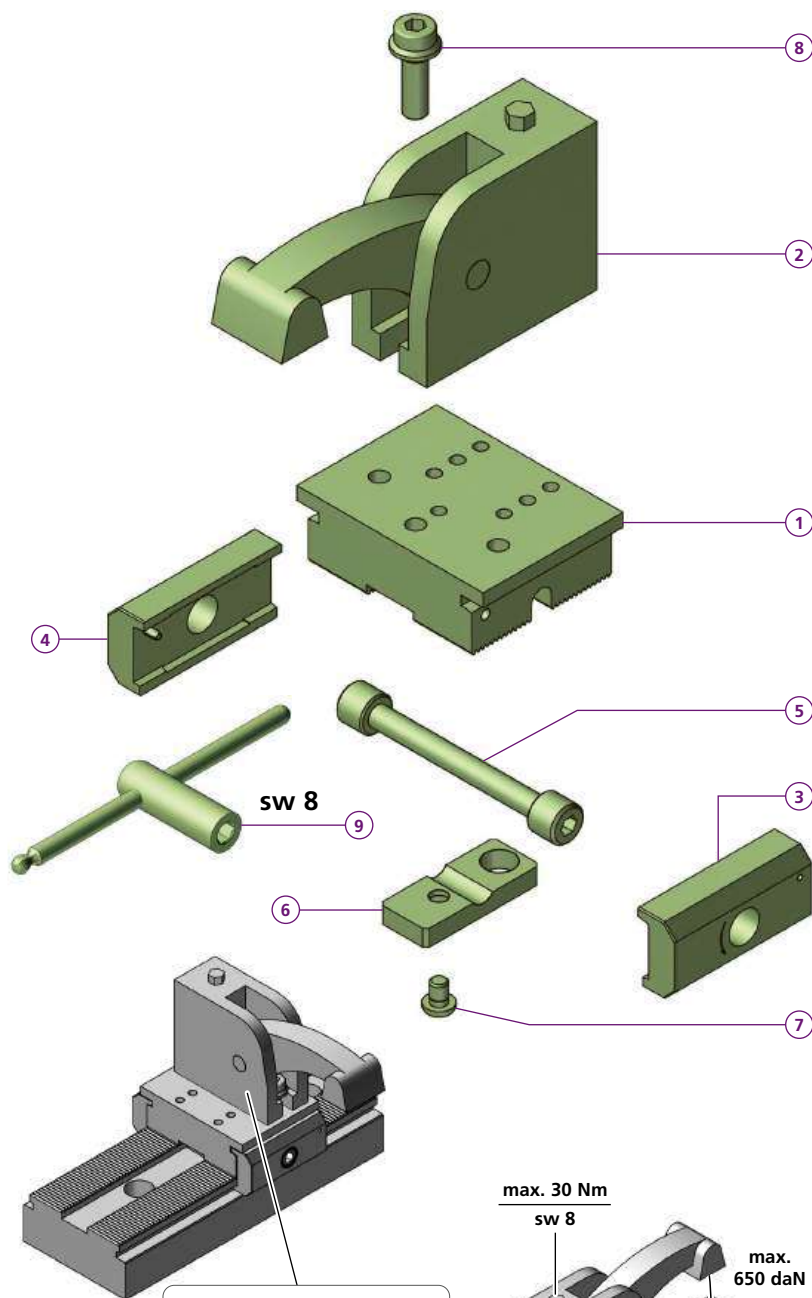
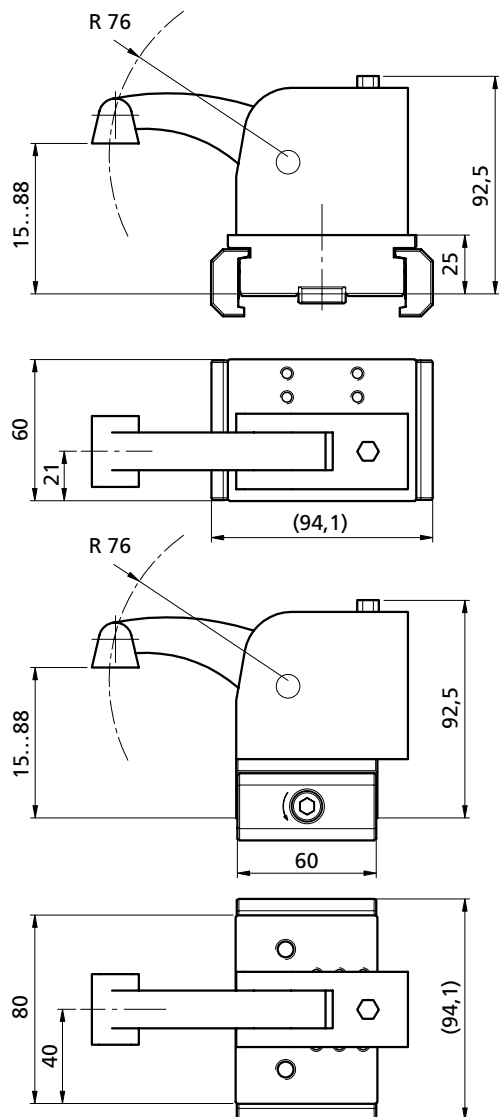
Die seitlichen Spannpratzen können um 90° gedreht werden, dadurch kann das Spannzangenmodul auch quer zur Schiene platziert werden.

The side clamps can be turned by 90°, the module can therefore be placed crosswise to the rail.

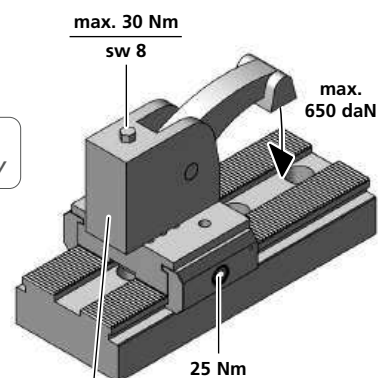


Art. Nr.	kg	Ø	M
PS1X68N80-W20	~1,8	0,5-20	M37,6x3





Spanner quer montiert
Clamp mounted transversely



Spanner längs montiert
Clamp mounted longitudinally



NS = Trägermodul freie Positionierung ohne Verzahnung
Carrier module without positioning serration for free positioning

PS1F-KLD1

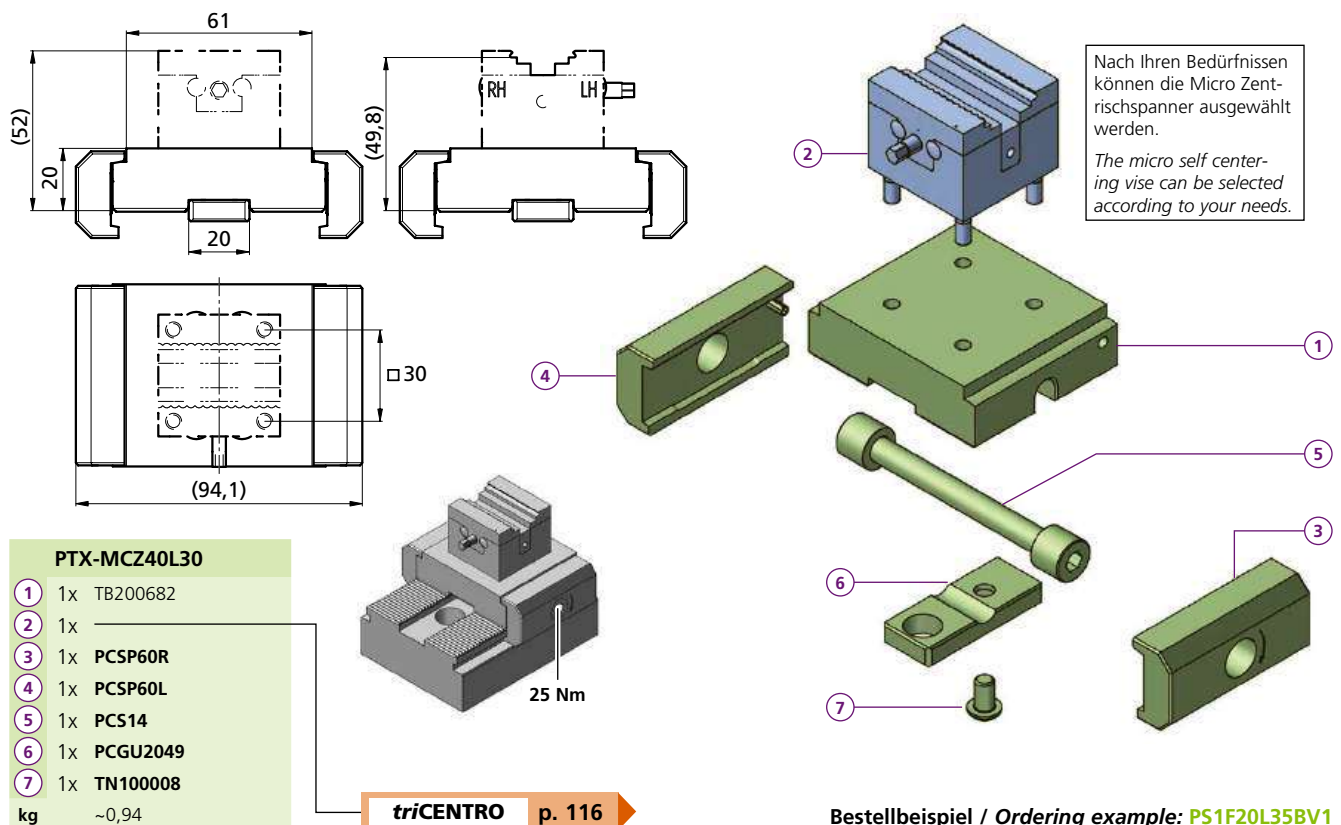
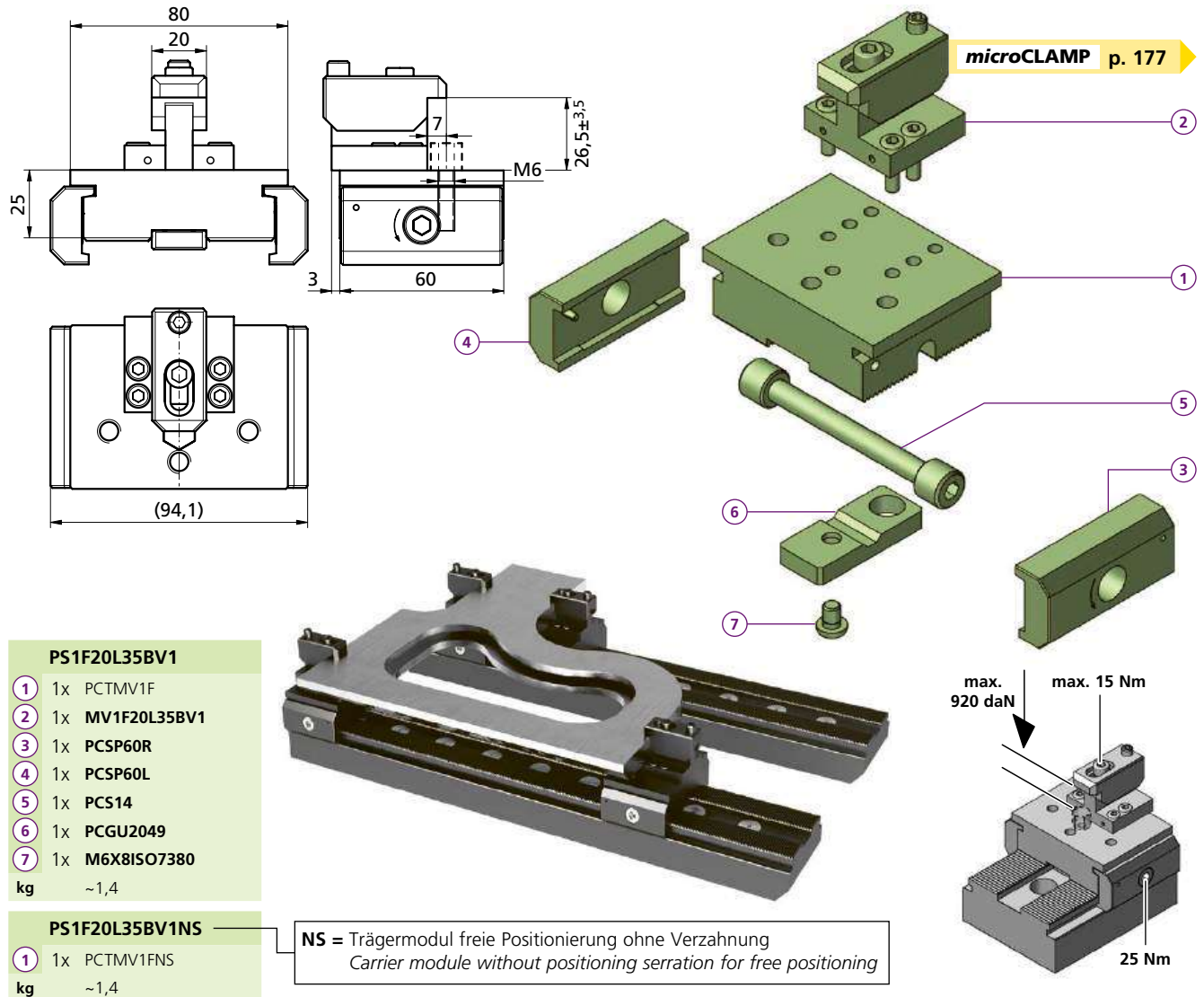
- 1x PCTMV1F
 - 1x 07-020
 - 1x PCSP60R
 - 1x PCSP60L
 - 1x PCS14
 - 1x PCGU2049
 - 1x M6X8ISO7380
 - 1x M8x25 TW080012-02
 - 1x 07-180
- kg ~2,1

PS1F-KLD1NS

- 1x PCTMV1FNS
- kg ~2,1

Bestellbeispiel / Ordering example: PS1F-KLD1NS

Plattenspanner / Plate clamping modul PS1F20L35BV1
Trägermodul für Micro Zentrischspanner PS1F20L35BV1NS
Support module for micro self centering vise PTX-MCZ40L30 powerCLAMP



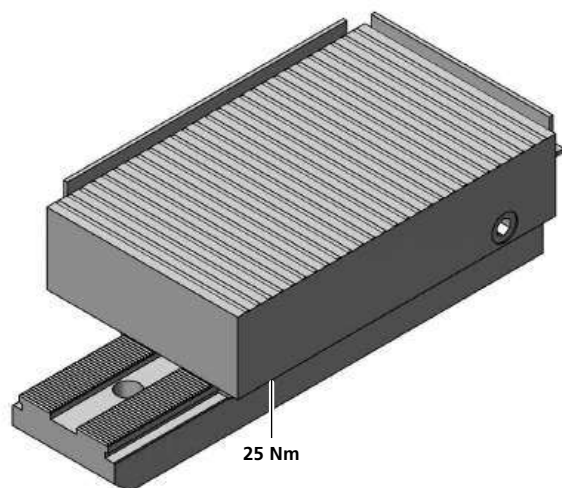
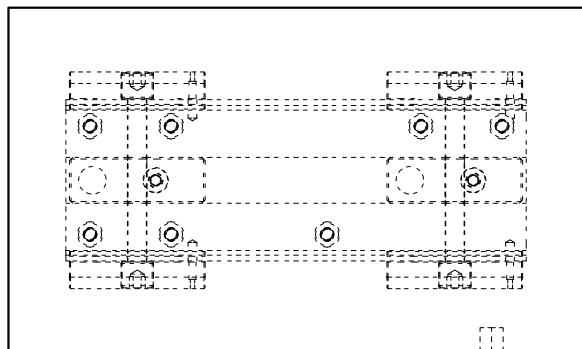
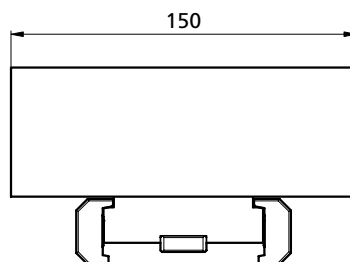
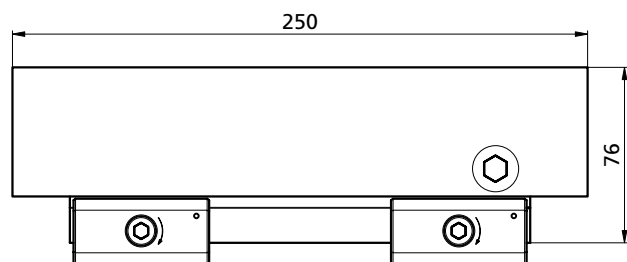
Bestellbeispiel / Ordering example: **PS1F20L35BV1**

Magnetspannplatte

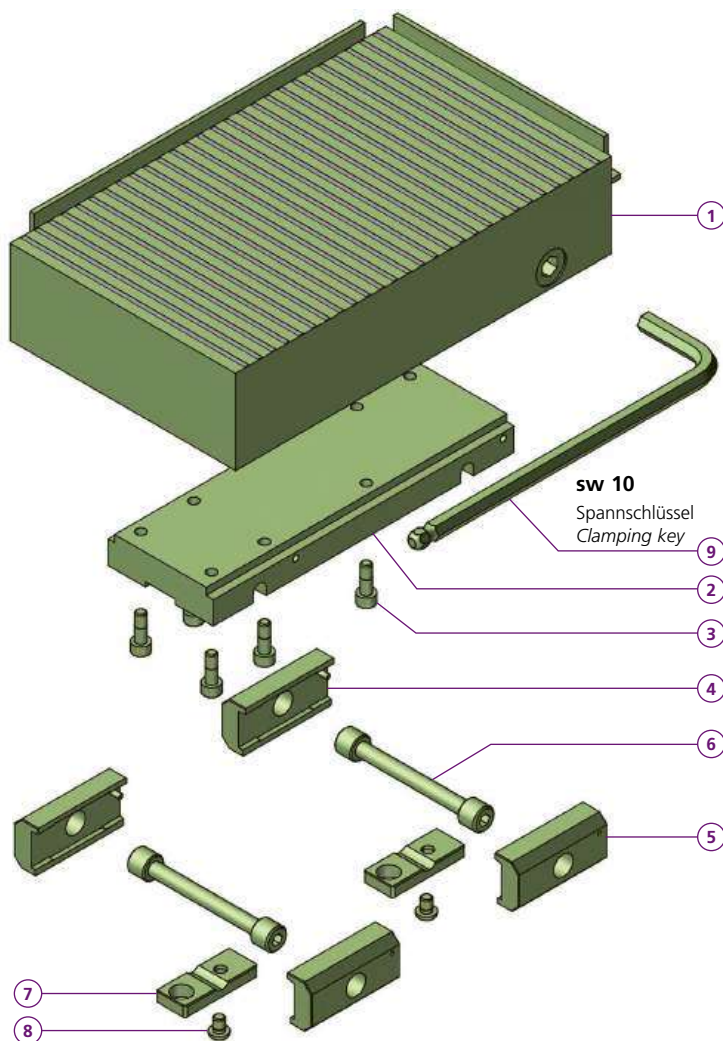
Magnetic chuck

PS1X150L60-250MAG11

powerCLAMP



25 Nm



sw 10

Spannschlüssel
Clamping key

PS1X150L60-250MAG11

- 1x XNeomill 250x150
- 1x TL110010-01
- 7x MS60
- 2x PCSP60L
- 2x PCSP60R
- 2x PCS14
- 2x PCGU2049
- 2x M6X8ISO7380
- 1x ISL10 DIN 911L

kg ~19,5

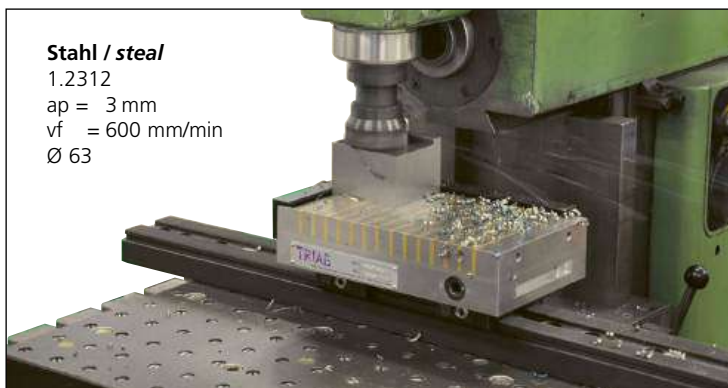
Stahl / steel

1.2312

ap = 3 mm

vf = 600 mm/min

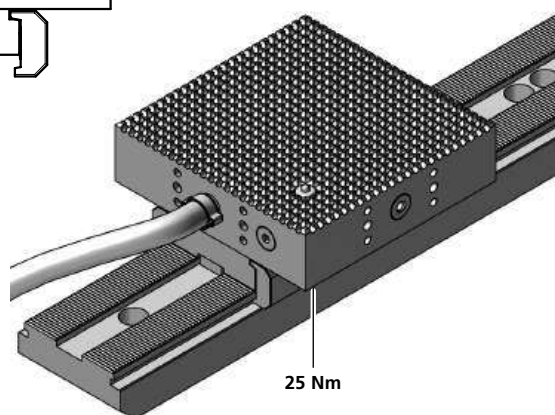
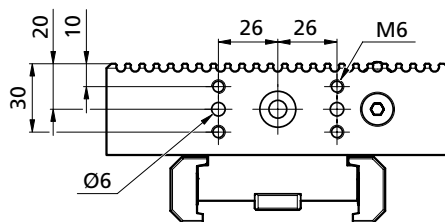
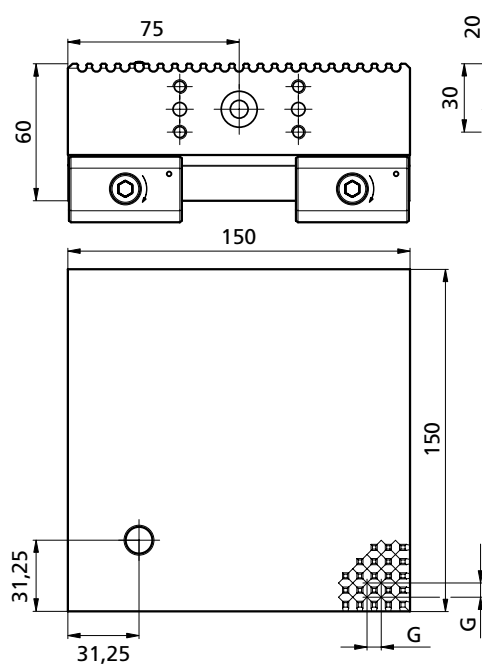
Ø 63



max. Haltekraft / max. holding force = 120 N/cm²

- Werkstücke ab 26 mm Länge und 6 mm Stärke werden optimal gespannt
- Workpieces from 26 mm length and 6mm thickness will be optimally hold

Bestellbeispiel / Ordering example: PS1X150L60-250MAG11



Bestellbeispiel / Ordering example: **PS1X150L60-VAC**

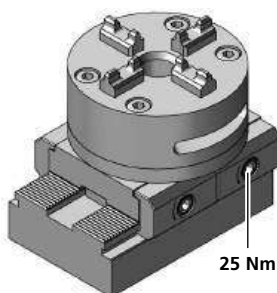
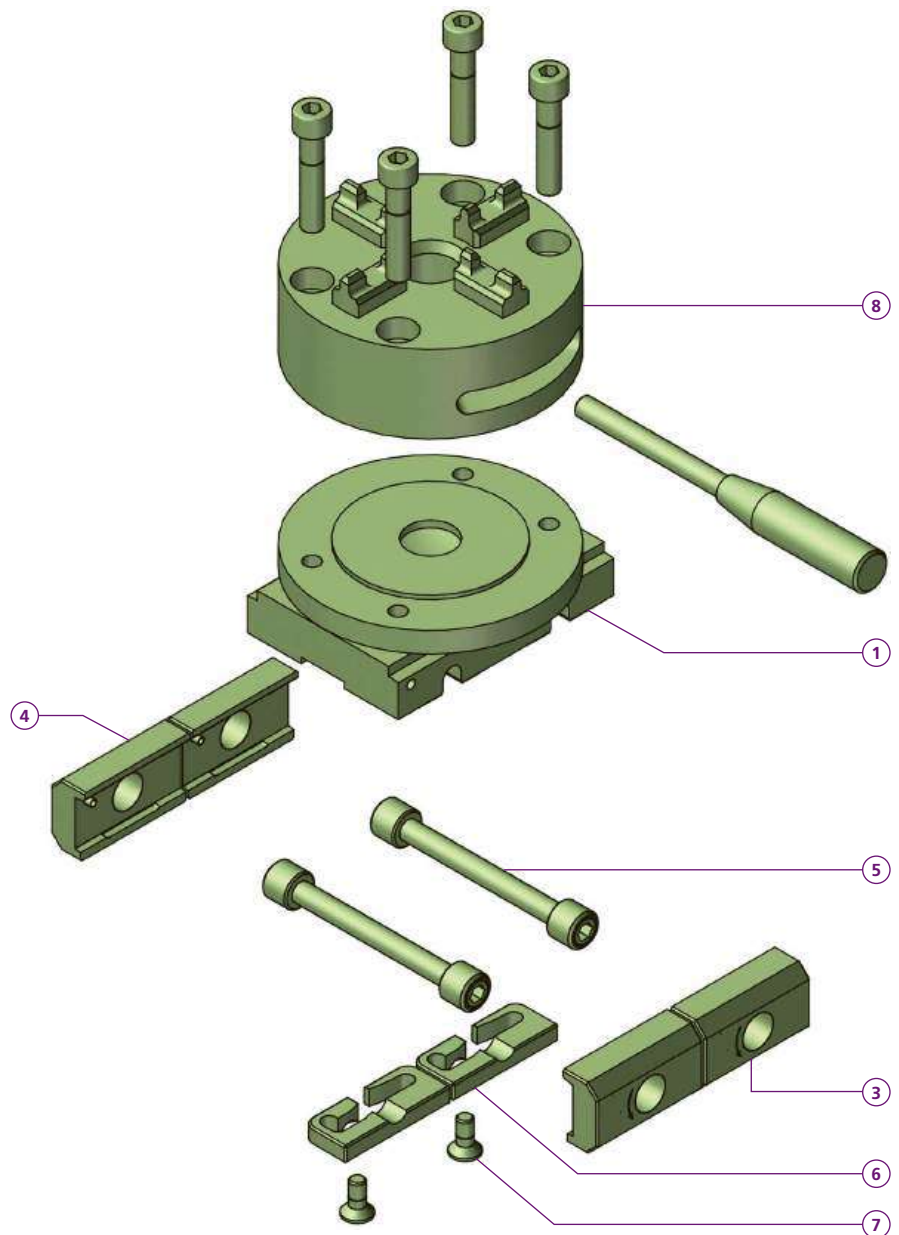
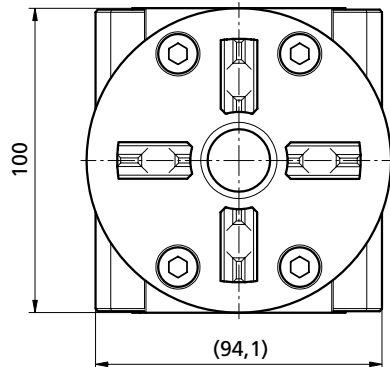
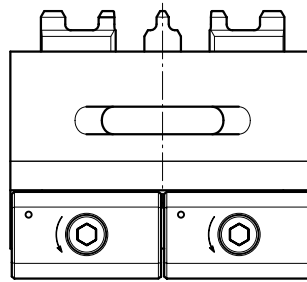
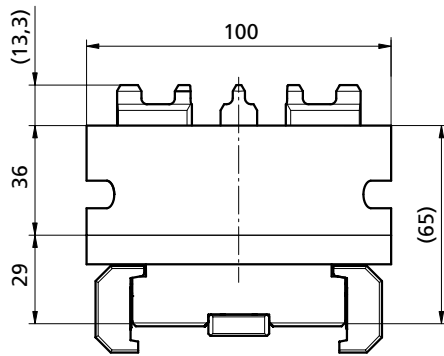
Mehr Informationen siehe Vacuum
 For more information check the vacuum workholding

trivaCLAMP p. 318



Mehr Informationen siehe Zentrischspanner
 For more information check the self centring vise p. 126 - 132

triCENTRO p. 113 - 152



PS1X100-65ER-036345

- 1x PTX100-29
- 2x PCSP50L
- 2x PCSP50R
- 2x PCS14
- 2x PCGU2049F
- 2x M6X14ISO10642
- 1x ER036345

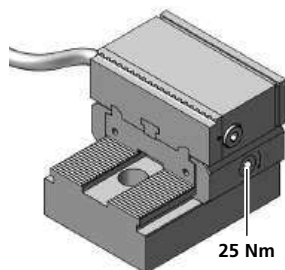
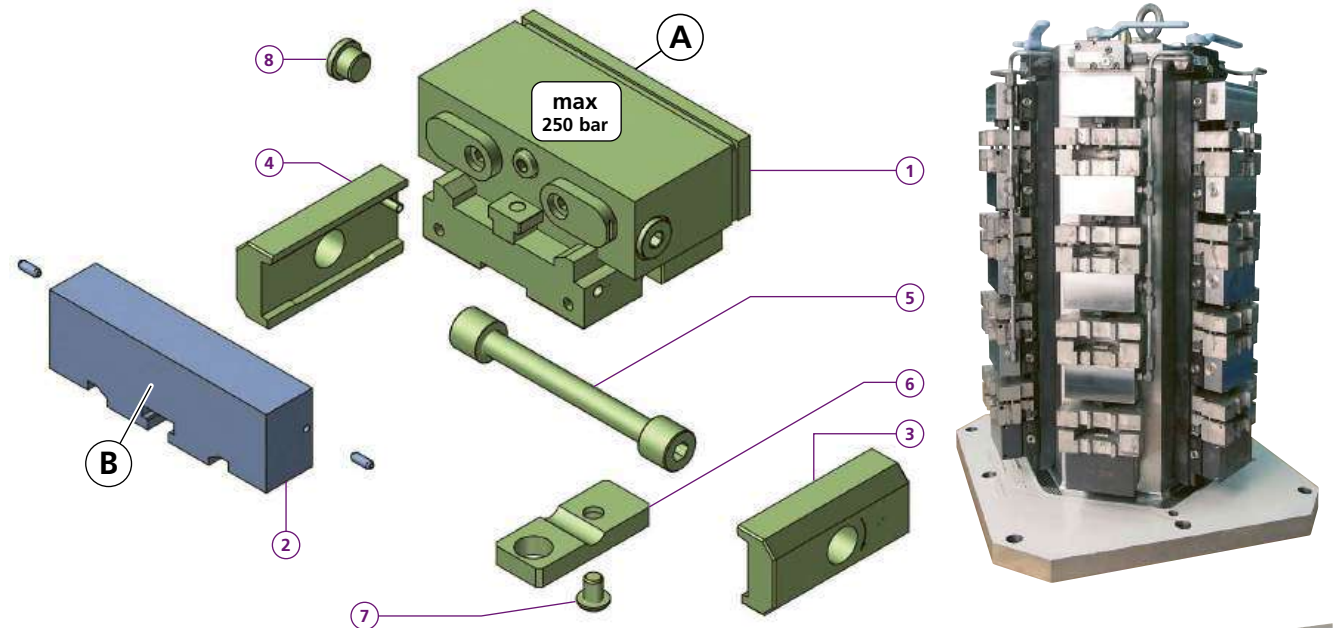
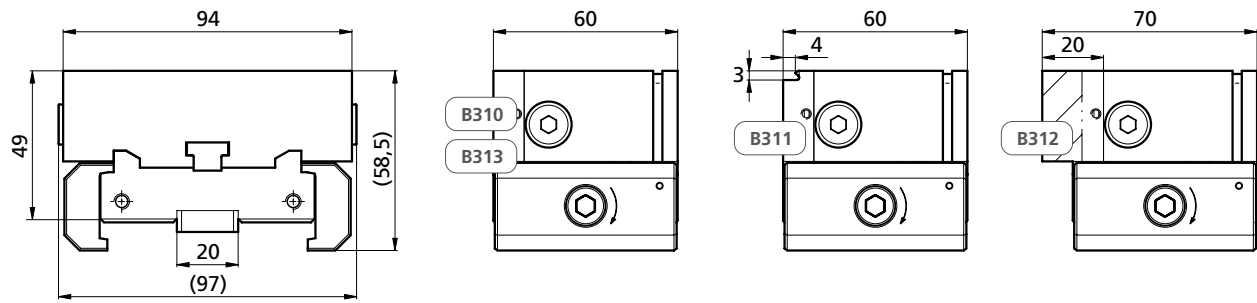
kg ~4,0

Bestellbeispiel / Ordering example: PS1X100-65ER-036345

Hydraulisches Spannmodul Hydraulic clamping module

PSH1X94L49-310

5axes
powerCLAMP



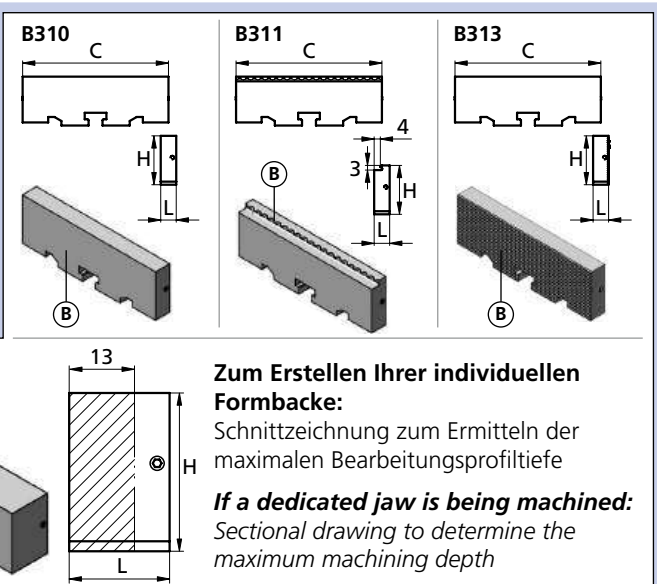
Ölvolumen / Oil volume			
Spannen / Clamping			
8 cm ³			
5 mm Hub / Stroke			
bar	~daN	~(lb)	~t
100	= 960	2116	0,96
150	= 1'440	3175	1,44
200	= 1'920	4233	1,92
250	= 2'400	5291	2,4



Bestellbeispiel / Ordering example: PSH1X94L49-310 & 1 x B310

PSH1X94L49-310				
	B310	B311	B312	B313
C	94	94	94	94
H	31,5	31,5	31,5	31,5
L	10	10	20	10
i	HV700 x0,2mm	57HRC	*	HV700 x0,2mm
kg	~0,18	~0,17	~0,39	~0,17

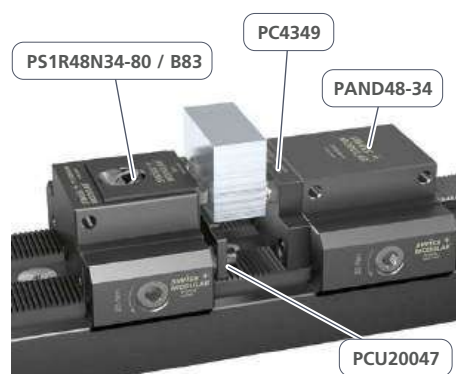
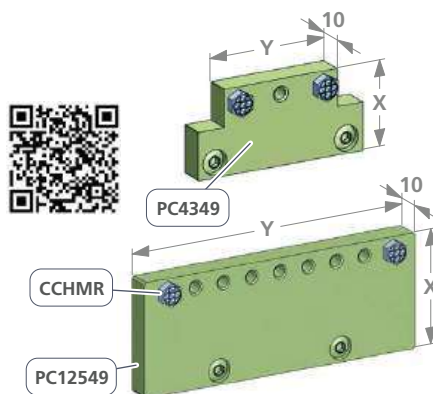
1	1x	ZF191349
2	1x	
3	1x	PCSP60R
4	1x	PCSP60L
5	1x	PCS14
6	1x	PCGU2049
7	1x	M6X8ISO7380
8	2x	TN100014
kg		~1,94



* = weich / soft (1.7225 Vergütungsstahl / Tempering steel)

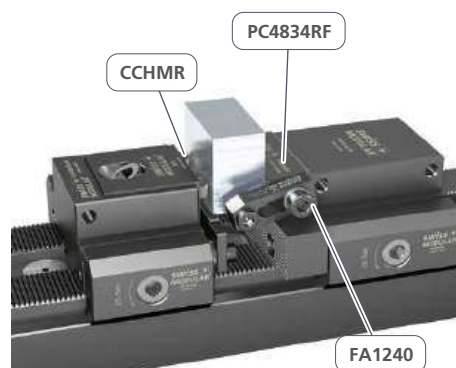
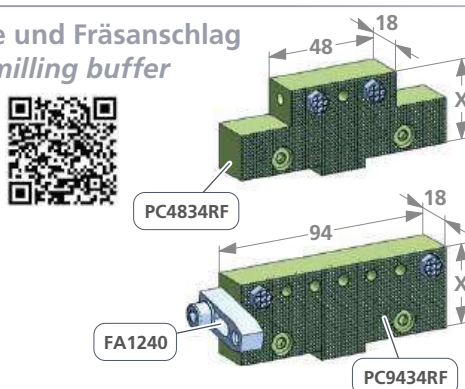
für Hartmetalldruckstücke
for carbide grippers

Art. Nr.		kg	Y	X
PC4349		~0,21	43	49
PC4834		~0,17	48	34
PC12549		~0,46	125	49



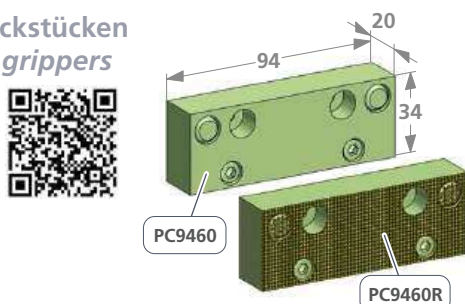
für Hartmetalldruckstücke und Fräsanschlag
for carbide grippers and milling buffer

Art. Nr.		kg	X
PC4834RF		~0,34	34
PC4849RF		~0,44	49
PC9434RF		~0,43	34
PC9449RF		~0,63	49



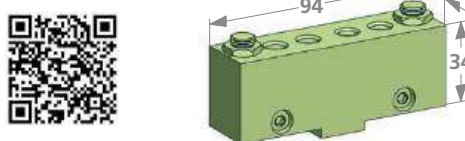
mit pendelnden Kugeldruckstücken
with swinging ball thrust grippers

Art. Nr.		kg
PC9460		~0,45
PC9460R		~0,45



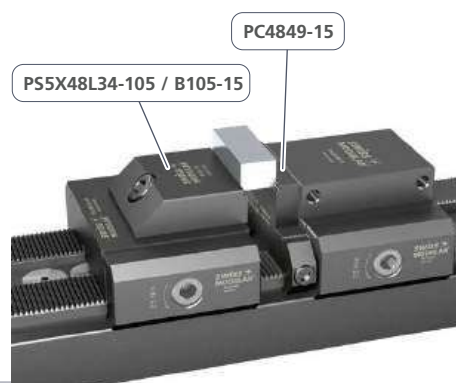
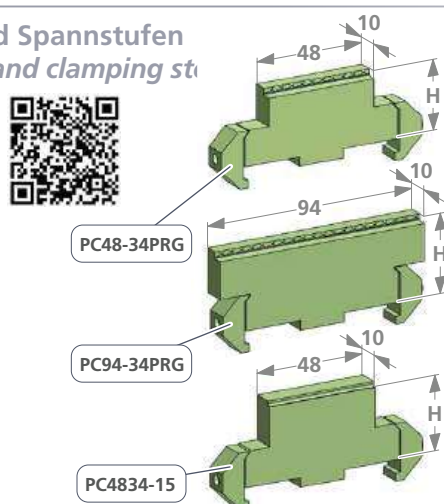
mit Prägeeinsätzen
with embossed inserts

Art. Nr.	kg
PC9434-25PRGM8	~0,64



mit direkt-Prägezähnen und Spannstufen
with direct stamping teeth and clamping steps

Art. Nr.		kg	H
PC48-34PRG		~0,18	34
PC48-49PRG		~0,24	49
PC94-34PRG		~0,25	34
PC94-49PRG		~0,48	49
PC4834-15		~0,19	34
PC4849-15		~0,24	49



mit Druckstiften
with pressure pins

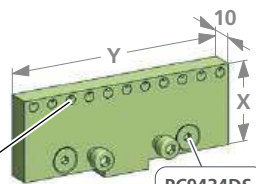
Art. Nr.	kg	Y	X
PC4349DS	~0,22	43	49
PC4834DS	~0,17	48	34
PC4849DS	~0,23	48	49
PC9434DS	~0,27	94	34
PC9449DS	~0,38	94	49
PC12549DS	~0,49	125	49



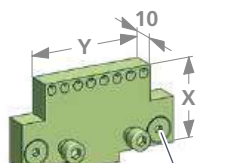
Druckstift
Pressure pin
DSE0402-60°



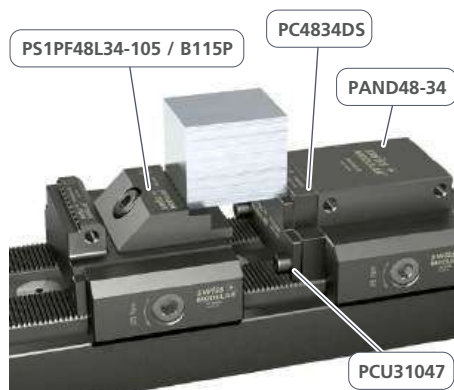
weitere Druckstücke
more gripping pens
p. 337



PC9434DS

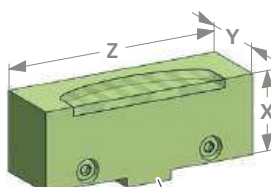


PC4834DS



aus weichem Stahl, zur Herstellung Ihrer individuellen Backe
made of soft steel, for the production of your individual clamping jaw

Art. Nr.	kg	Z	Y	X
PC943425W weicher Stahl (1.0570)	~0,64	94	25	34
PC943430W weicher Stahl (1.0570)	~0,77	94	30	34
PC944930W weicher Stahl (1.0570)	~1,10	94	30	49
PC1254930W weicher Stahl (1.0570)	~1,46	125	30	49

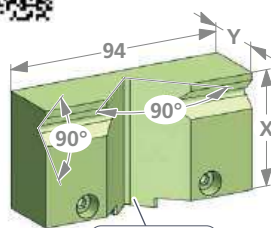


PC943425W

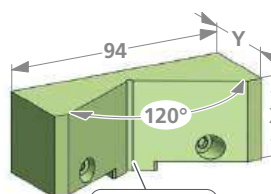


in Prismaform
in prism form

Art. Nr.	kg	Y	X
PC9434V90-2	~0,58	28	34
PC9449V90-2	~0,58	28	49
PC9434V120	~0,62	35	34
PC9449V120	~0,89	35	49



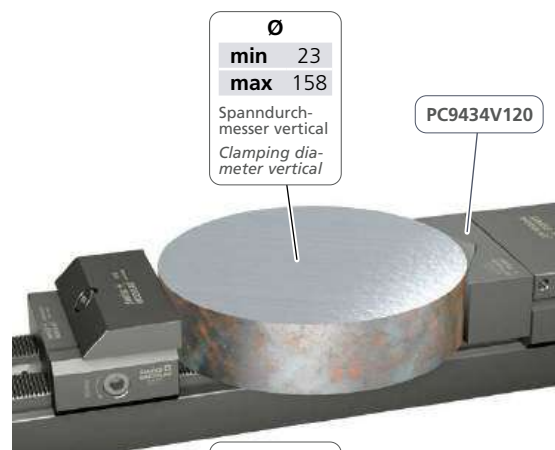
PC9434V90-2



PC9434V120

Ø
min 5
max 16
Spanndurchmesser horizontal
Clamping diameter horizontal

PC9449V90-2



Ø
min 23
max 158
Spanndurchmesser vertical
Clamping diameter vertical

PC9434V120

Ø
min 16
max 52
Spanndurchmesser vertical
Clamping diameter vertical

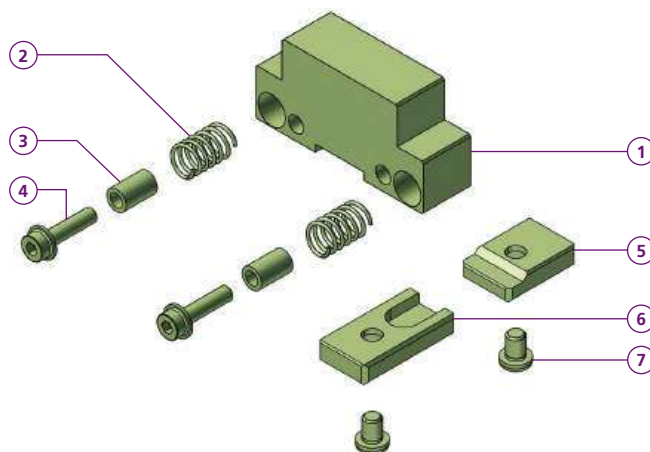
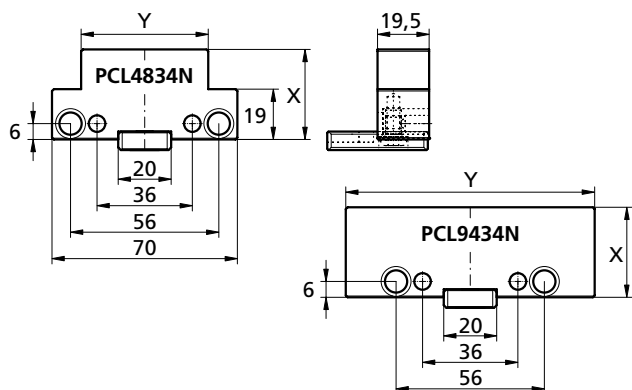
PAND94-49

PS1F94L49-105 / B110

PCU20047

Von Niederzug zu Linear!

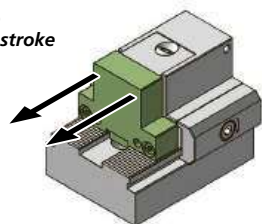
From pull down jaws to linear stroke!



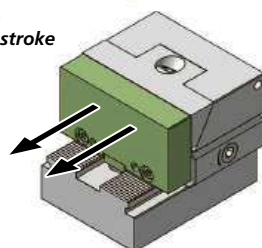
PCL4349N

- 1 1x TF140697
- 2 2x FED10175
- 3 2x PCD0813
- 4 2x M5X20BN1392
- 5 1x PCGU2028
- 6 1x PCGU2030LB
- 7 2x M6X8ISO7380
- X = 49
- Y = 43
- kg ~0,43

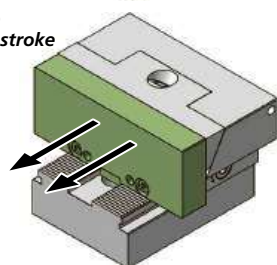
Spannhub
Clamping stroke
0/+3,8



Spannhub
Clamping stroke
0/+3,8



Spannhub
Clamping stroke
0/+4,8



PCL9449N

- 1 1x TF140700
- X = 49
- Y = 94
- kg ~0,74

PCL12549N

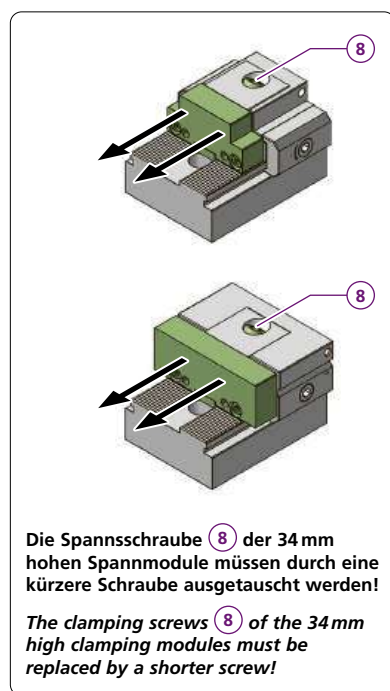
- 1 1x T00317
- X = 49
- Y = 125
- kg ~0,97

PCL4834N

- 1 1x TF140698
- 2 2x FED10175
- 3 2x PCD0813
- 4 2x M5X20BN1392
- 5 1x PCGU2028
- 6 1x PCGU2030LB
- 7 2x M6X8ISO7380
- 8 1x M10X22ISO4762
- X = 34
- Y = 48
- kg ~0,35

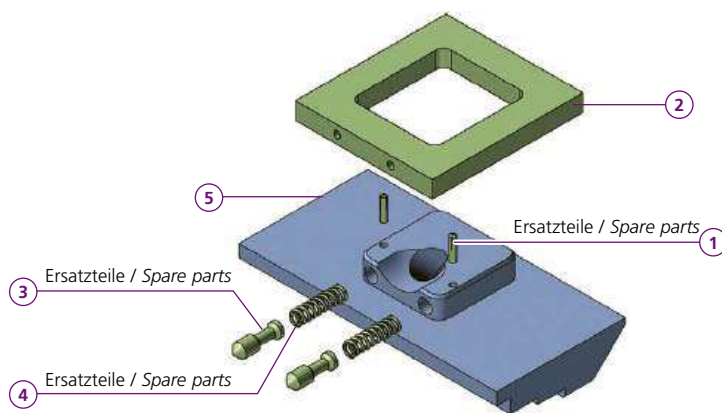
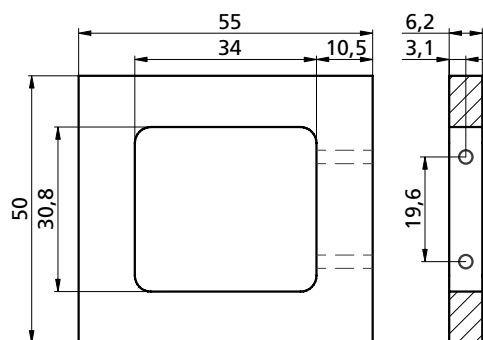
PCL9434N

- 1 1x TF140699
- X = 34
- Y = 94
- kg ~0,52



Bestellbeispiel / Ordering example: PCL4834N

Montagehilfe und Ersatzteile für Linearbacken
Assembling tool for linear jaws and spare parts



BL-SET

- 1 2x TN100823
- 2 1x TK160609
- 3 2x PCR80516
- 4 2x TN100614
- 5 1x
- kg ~0,08

p. 84, 85

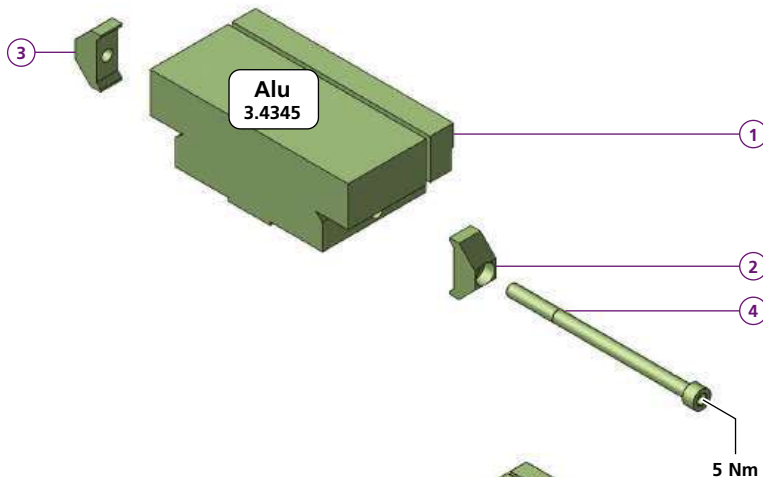
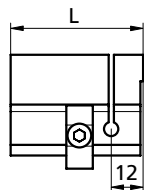
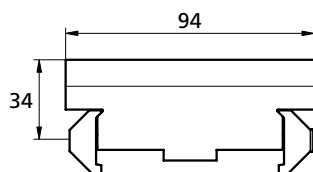
Alle Linearbacken
All linear jaws

Version mit Stiften / Version with pins
ab August / as of August 2018

Montageanleitung siehe Video
Assembly instructions see video

Version mit Kugeln / Version with balls
vor August / before August 2018



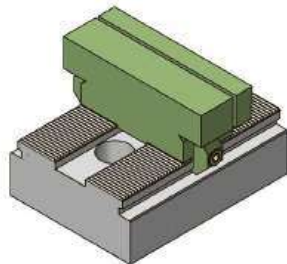
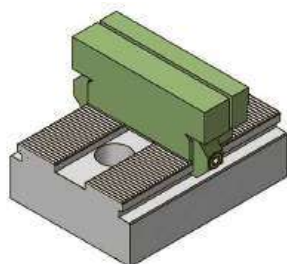
**PCFX30**

- ① 1x TF140702
- ② 1x PCSP10B
- ③ 1x PCSP10G
- ④ 1x M5X85ISO4762

L = 30
kg ~0,27

PCFX35

- ① 1x TF140703
- L = 35
kg ~0,31

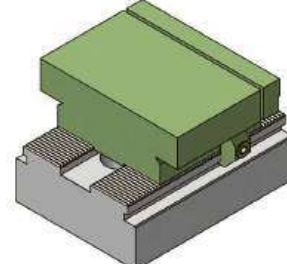
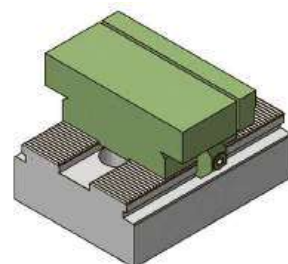
**PCFX50**

- ① 1x TF140704
- ② 1x PCSP10B
- ③ 1x PCSP10G
- ④ 1x M5X85ISO4762

L = 50
kg ~0,45

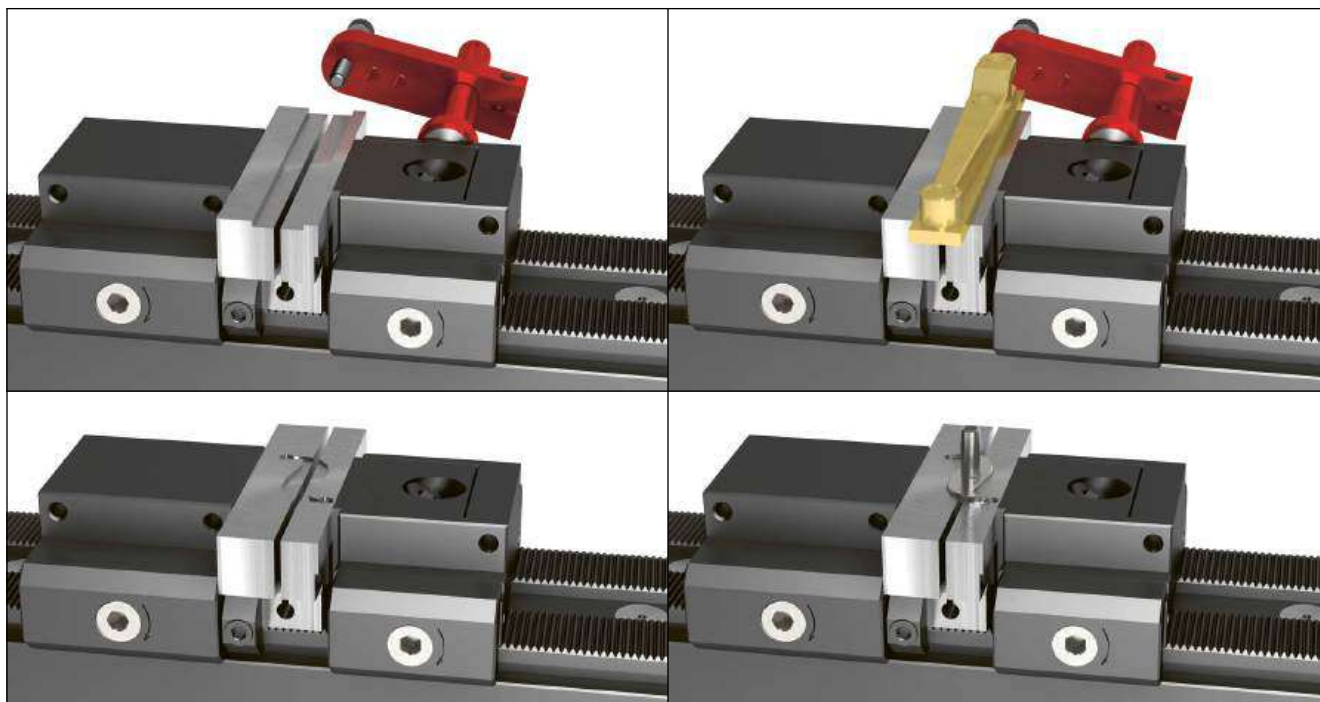
PCFX70

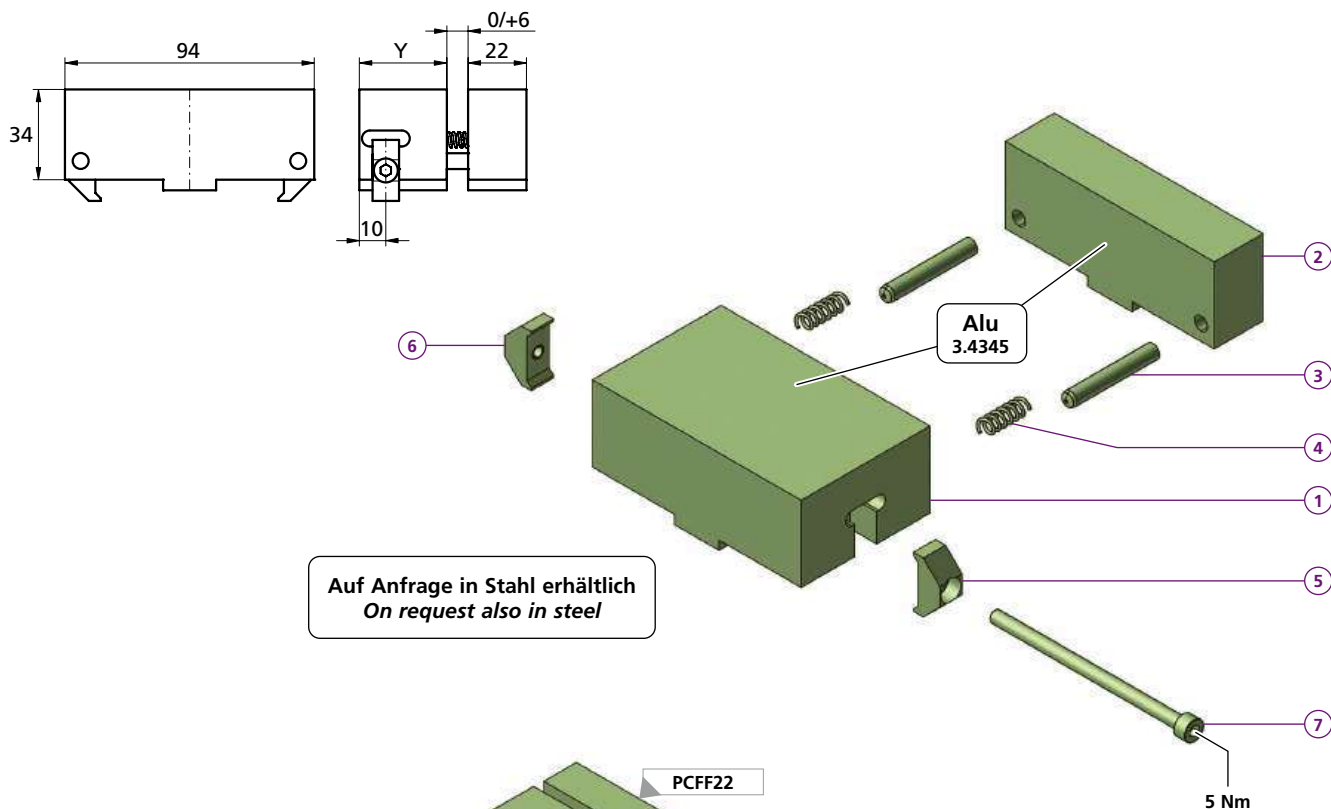
- ① 1x TF140705
- L = 70
kg ~0,62



Auf Anfrage in Stahl erhältlich
On request also in steel

Bestellbeispiel / Ordering example: **PCFX30**



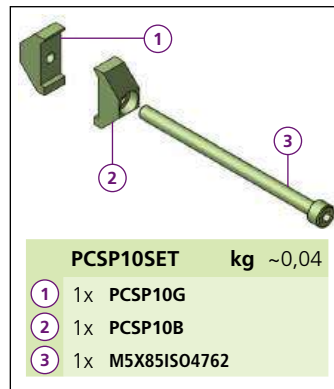
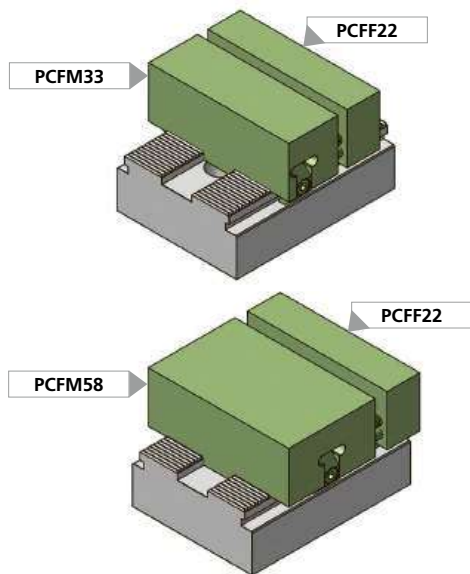
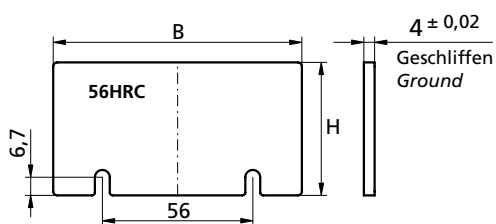
**PCFM3322**

- ① 1x PCFM33
- ② 1x PCFF22
- ③ 2x CCBO0801
- ④ 2x FED0618
- ⑤ 1x PCSP10B
- ⑥ 1x PCSP10G
- ⑦ 1x M5X85ISO4762

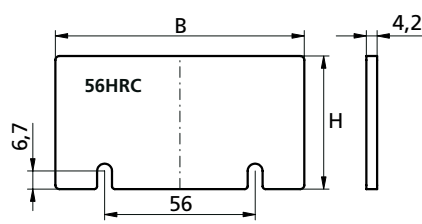
Y = 33
kg ~0,52

PCFM5822

- ① 1x PCFM58
- Y = 58
kg ~0,75

Bestellbeispiel / Ordering example: **PCFM3322****Anschlagbacke flach**
Jaw flat stop

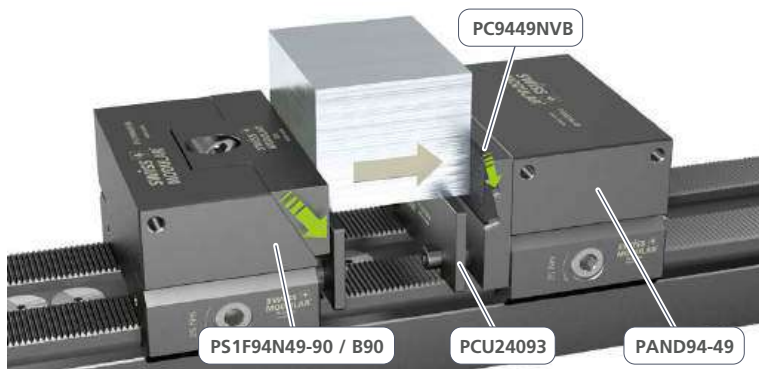
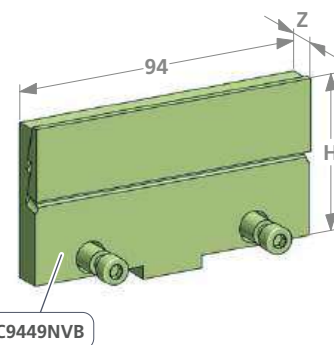
	B	H	kg
PCUD34093TG	93	34	~0,11
PCUD49093TG	93	49	~0,14

Unterlagen gehärtet und geschliffen
Parallels hardened and ground

	B	H	kg
PCUD14093	93	14	~0,05
PCUD20093	93	20	~0,06
PCUD24093	93	24	~0,08
PCUD29093	93	29	~0,09
PCUD31093	93	31	~0,10
PCUD34093	93	34	~0,11
PCUD39093	93	39	~0,12
PCUD44093	93	44	~0,14
PCUD46093	93	46	~0,14
PCUD47093	93	37	~0,15

Niederzugbacken für die Anschlagseite
Pull-down jaws for the solid reference face

Art. Nr.	kg	H	Z
PC9434NVB	~0,24	49,8 – 49	10,21 – 10
PC9449NVB	~0,35	34,8 – 34	10,21 – 10

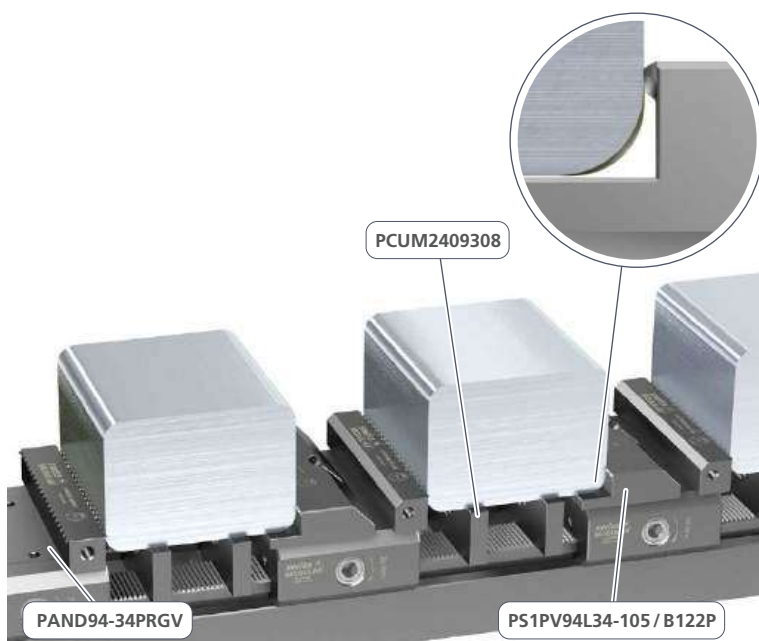
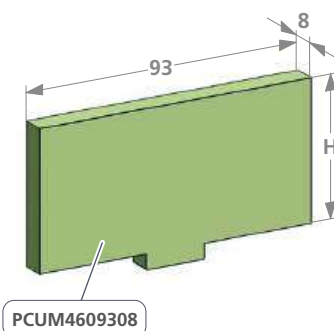


Die Niederzugbacke dient um einen zusätzlichen Niederzug-Klemmdruck auf der Anschlagseite zu erhalten.

The pull-down jaw is used to obtain an additional pull-down clamping pressure on the end module side.

Magnetische Parallelunterlagen
Magnetic steel parallels

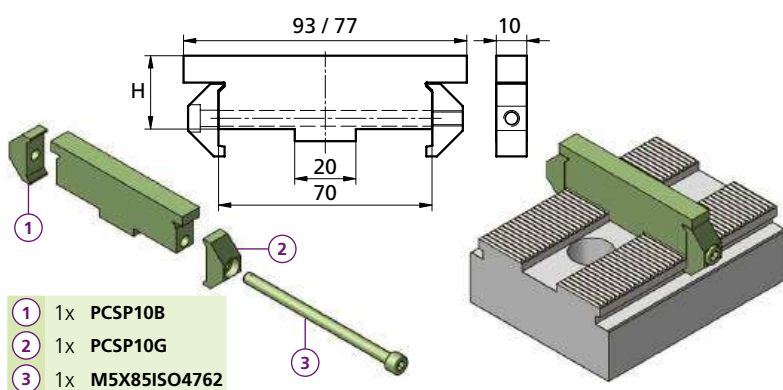
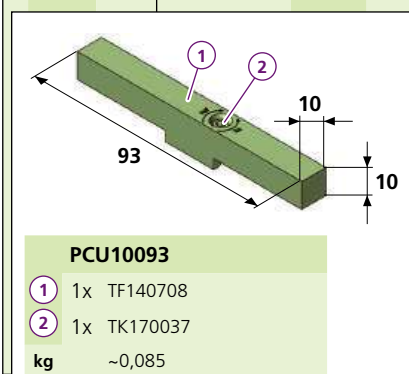
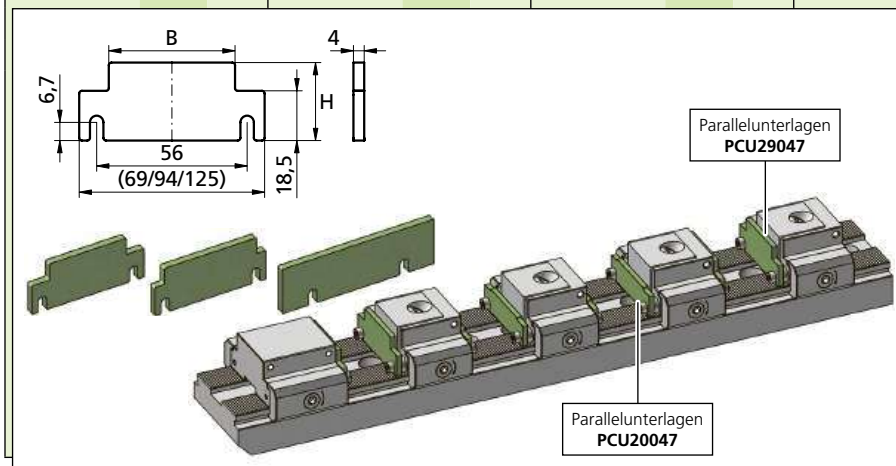
Art. Nr.	kg	H
PCUM1409308	~0,09	14
PCUM2009308	~0,13	20
PCUM2409308	~0,15	24
PCUM2909308	~0,18	29
PCUM3109308	~0,20	31
PCUM3409308	~0,21	34
PCUM3909308	~0,24	39
PCUM4409308	~0,27	44
PCUM4609308	~0,28	46



Mit diesen magnetischen Parallelunterlagen ist die Positionierung auf der Basisschiene frei wählbar. Bei Werkstücken mit grösseren Rundungen sind die Spannbacken B122P / B123P zusammen mit den Anschlagmodulen PAND94-34PRGV / PAND94-49PRGV bestens geeignet.

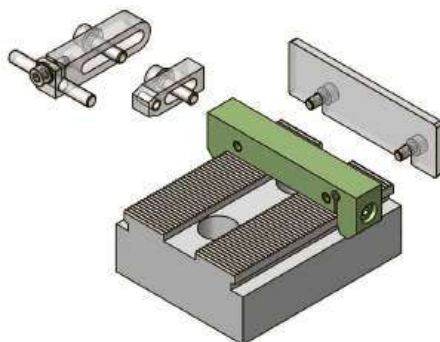
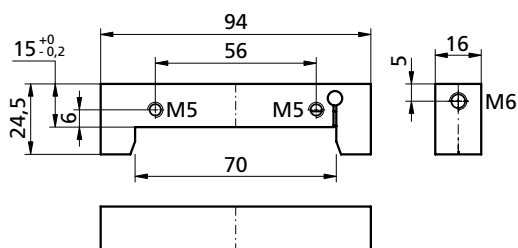
With these magnetic steel parallels, the positioning on the base rail is freely selectable. For workpieces with larger curves, the clamping jaws B122P / B123P together with the end modules PAND94-34PRGV / PAND94-49PRGV are best suited.

19mm	B	H	kg	34mm	B	H	kg	48mm	B	H	kg	61mm	B	H	kg	94mm	B	H	kg	
PCU20018	18	20	~0,04	PCU20033	33	20	~0,04	PCU20047	47	20	~0,04	PCU20060	60	20	~0,04	PCU14093	93	14	~0,04	
PCU24018	18	24	~0,04	PCU24033	33	24	~0,05	PCU24047	47	24	~0,05	PCU24060	60	24	~0,05	PCU20093	93	20	~0,06	
PCU29018	18	29	~0,05	PCU29033	33	29	~0,05	PCU29047	47	29	~0,05	PCU29060	60	29	~0,06	PCU24093	93	24	~0,07	
PCU31018	18	31	~0,05	PCU31033	33	31	~0,05	PCU31047	47	31	~0,05	PCU31060	60	31	~0,06	PCU29093	93	29	~0,09	
PCU34018	18	34	~0,05	PCU34033	33	34	~0,06	PCU34047	47	34	~0,07	68mm	B	H	kg	PCU31093	93	31	~0,09	
PCU39018	18	39	~0,05	PCU39033	33	39	~0,06	PCU39047	47	39	~0,07					PCU34093	93	34	~0,10	
PCU44018	18	44	~0,05	PCU44033	33	44	~0,07	PCU44047	47	44	~0,08					PCU39093	93	39	~0,11	
PCU46518	18	46,5	~0,06	PCU46033	33	46	~0,06	PCU46047	47	46	~0,08					PCU44093	93	44	~0,12	
				PCU46533	33	46,5	~0,07								PCU29067	67	29	~0,06	PCU46093	93
												PCU31067	67	31	~0,07	PCU47093	93	47	~0,14	
26mm	B	H	kg	43mm	B	H	kg	58mm	B	H	kg	78mm	B	H	kg	125mm	B	H	kg	
PCU20025	25	20	~0,04	PCU20042	42	20	~0,04	PCU20057	57	20	~0,04	PCU20077	77	20	~0,05	PCU20124	124	20	~0,08	
PCU24025	25	24	~0,05	PCU24042	42	24	~0,05	PCU24057	57	24	~0,05		PCU24077	77	24	~0,06	PCU24124	124	24	~0,09
PCU29025	25	29	~0,05	PCU29042	42	29	~0,05	PCU29057	57	29	~0,06		PCU29077	77	29	~0,07	PCU29124	124	29	~0,11
PCU31025	25	31	~0,05	PCU31042	42	31	~0,06	PCU31057	57	31	~0,06		PCU31077	77	31	~0,08	PCU31124	124	31	~0,12
PCU34025	25	34	~0,05	PCU34042	42	34	~0,06				PCU34077		77	34	~0,08	PCU34124	124	34	~0,13	
PCU39025	25	39	~0,06	PCU39042	42	39	~0,07				PCU39077		77	39	~0,09	PCU39124	124	39	~0,15	
PCU44025	25	44	~0,06	PCU44042	42	44	~0,07				PCU44077		77	44	~0,11	PCU44124	124	44	~0,17	
PCU46525	25	46,5	~0,06	PCU46042	42	46	~0,08									PCU46124	124	46	~0,18	
				PCU47042	42	47	~0,08													

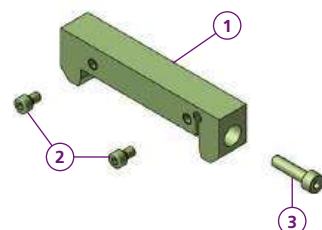


weich / soft		1.7225	hart / hardened		HV700 x0,2mm
H= +0,15 +0,25	H	kg	H= ± 0,005	H	kg
PCU20077B10-W	20	~0,15	PCU20077B10	20	~0,15
PCU24093B10-W	24	~0,19	PCU24093B10	24	~0,19
PCU39093B10-W	39	~0,29	PCU29093B10	29	~0,23
PCU44093B10-W	44	~0,33	PCU31093B10	31	~0,24
PCU46093B10-W	46	~0,34	PCU34093B10	34	~0,27
			PCU39093B10	39	~0,29
			PCU44093B10	44	~0,33
			PCU46093B10	46	~0,34

Unterlagen- und Fräsanschlaghalter
Holder for parallels and workpiece stop



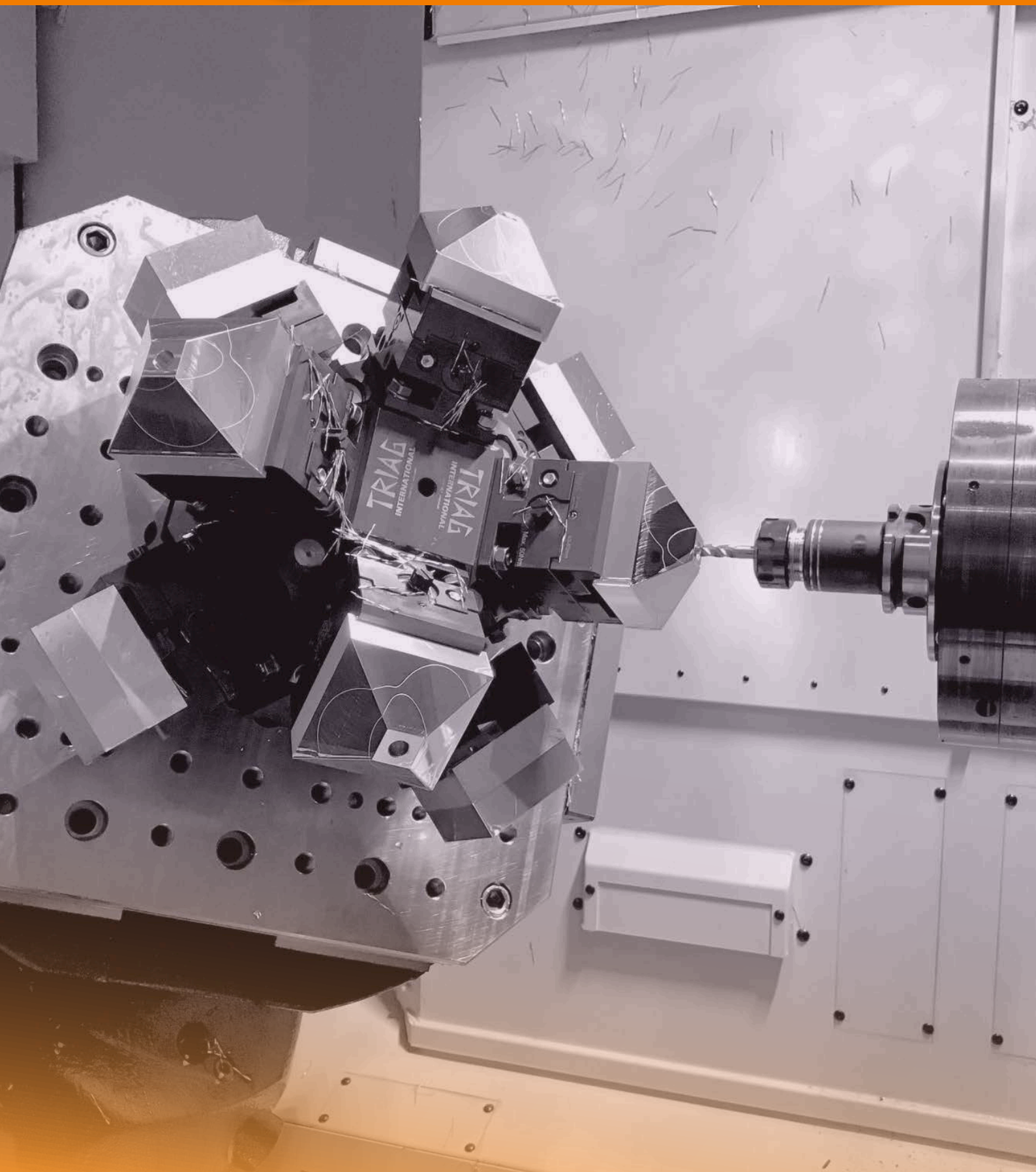
PCUH2594
1x TF140706
2x M5X8ISO4762
1x M5X22ISO4762
kg ~0,19



Bestellbeispiel / Ordering example: PCUH2594



triCENTRO

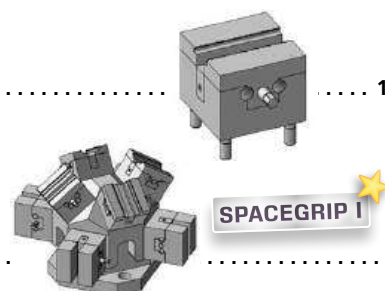




Einleitung und Anwendungsbeispiele <i>Introduction and examples of application</i>	115
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Micro - Zentrierspanner <i>Micro - self centering vise</i>	116 - 117
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5-Achs Pyramidenlösungen <i>5-axis pyramid solutions</i> 35° ...	118
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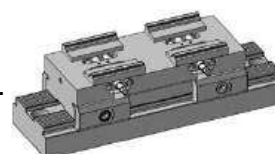
5-Achs Pyramidenlösungen <i>5-axis pyramid solutions</i> 45° ...	119
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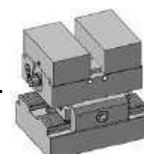
5-Achs Pyramidenlösungen <i>5-axis pyramid solutions</i> 20°	122
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Kompakter Zentrischspanner <i>Compact self centering vise</i>	123 - 124
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Mini Zentrierspanner <i>Mini - self centering vise</i>	126 - 129
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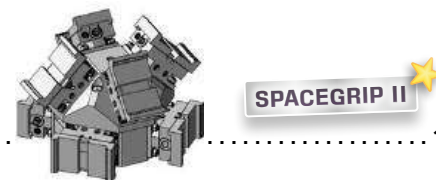


Zentrischspanner mit Anschlagbrücke <i>Self centering vise with center stop</i>	130 - 131
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Mini Zentrischspanner / <i>Spannvielfalt der Backen</i> <i>Mini - self centering vise / Clamping variety of jaws</i>	132
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5-Achs Pyramidenlösungen <i>5-axis pyramid solutions</i> 45° / 90°	133
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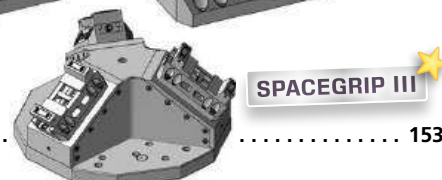
5-Achs Pyramidenlösungen <i>5-axis pyramid solutions</i> 45°	136
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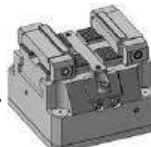
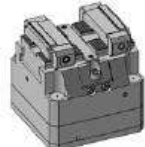
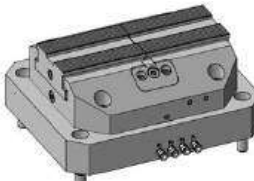


Zentrischspanner X M Q Serien <i>Self centering vises X M Q series</i>	137 - 149
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5-Achs Pyramidenlösungen <i>5-axis pyramid solutions</i> 35°-3	153 - 154
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ZSP Micro - Zentrischspanner ZSP Micro - self centering vise		 156
ZSP125 Mini - Pneumatischer Zentrischspanner (einfacher Kolben) ZSP125 Mini - Pneumatic self centering vise (single piston)		 157
ZSP125 Mini - Pneumatischer Zentrischspanner (Doppelkolben) ZSP125 Mini - Pneumatic self centering vise (Double piston)		 158
ZSP Grande - Pneumatischer Zentrierspanner ZSP Grande - Pneumatic self centering vise		 160 - 161

Triag International AG bietet ein breites Sortiment an Zentrischspannern an. Neben den Zentrischspannern, die auf die Schienensysteme Power Clamp das Nullpunktsystem oppSystem passen, sind auch Ausführungen für Lochraster erhältlich.

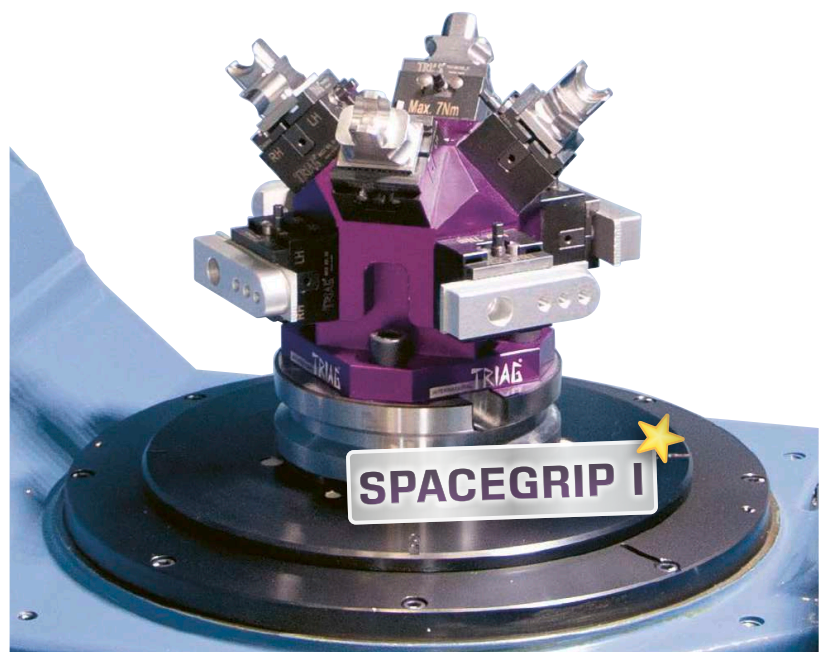
Mit unseren modularen Zentrischspannblöcken bieten wir eine optimale Lösung für die Mehrfachspannung in Ihrer 5-Achs Fräsmaschine an. Für alle Zentrischspanner sind verschiedene Aufsatz- und Prägebacken erhältlich.

Triag International AG offers a wide range of self centering vices. In addition to the self centering vise that fit into the rail systems Power Clamp the zero point system oppSystem, mechanical self centering vice are also available.

With our modular self centric vice blocks we offer an optimal solution for multiple workholding in your 5-axis milling machine. Different jaws and stamping jaws are available for all self centering vices.



ZSM140L50 & PAND94-49PRG-A1



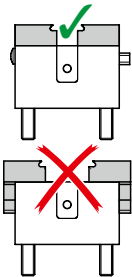
SPACEGRIP I

Für den Vorrichtungsbau
For dedicated fixtures

Art. Nr.			A mm	kg
MCZ40L30PRG13			3 – 13	~0,34
MCZ40L30PRG22			12 – 22	~0,33
MCZ40L30PRG31			21 – 31	~0,32
MCZ40L30W6		weicher Stahl soft steel (1.7225)	variabel	~0,33
MCZ40L30W10		weicher Stahl soft steel (1.7225)	variabel	~0,37
MCZ40L30W20		weicher Stahl soft steel (1.7225)	variabel	~0,47
MCZ40L30W30		weicher Stahl soft steel (1.7225)	variabel	~0,57

NUSS 1/4" 4.5MM

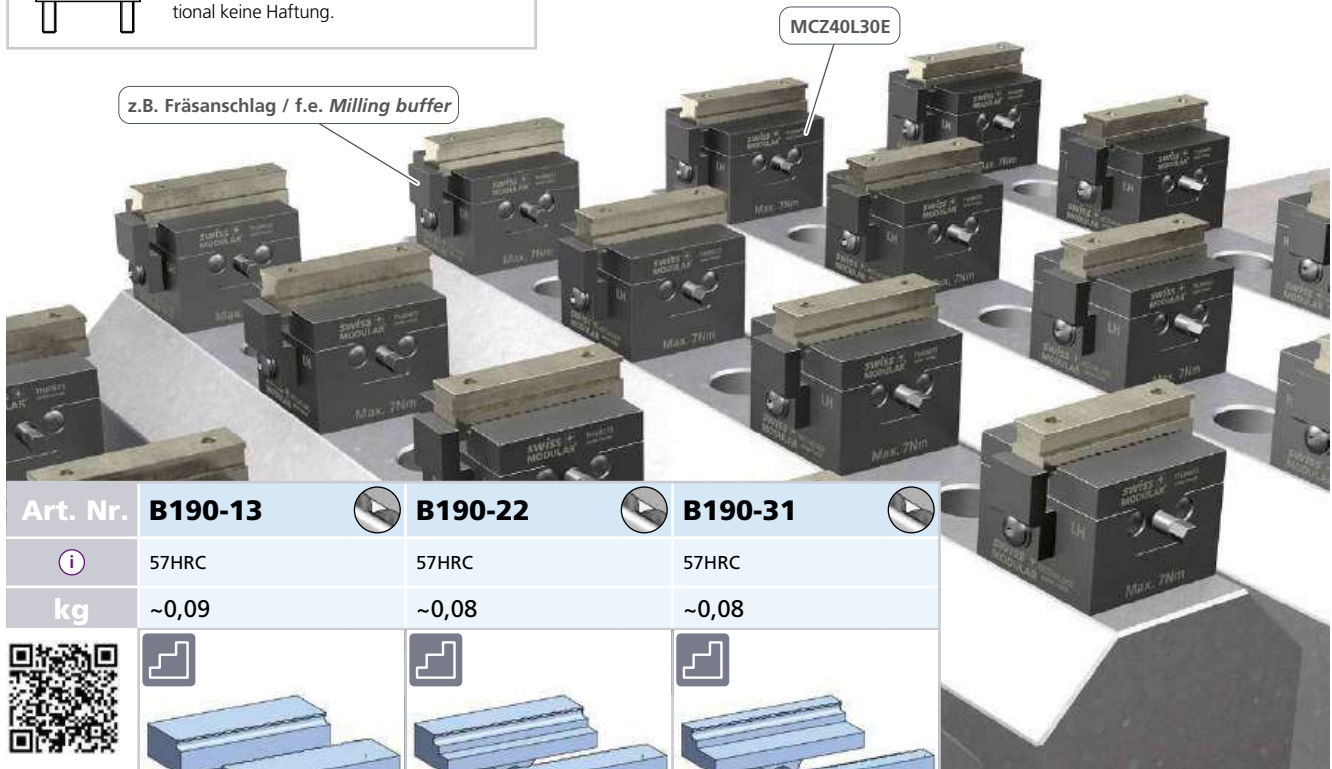
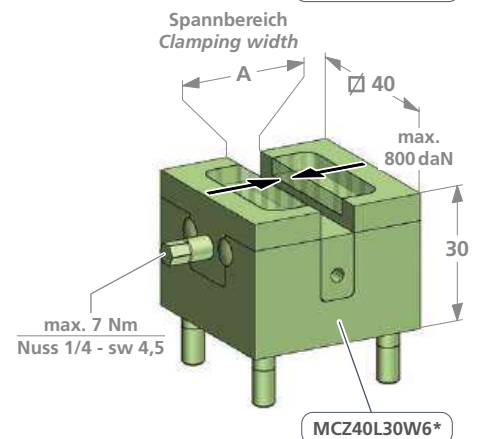
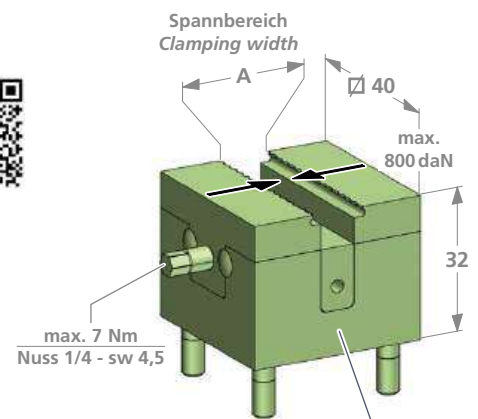
WICHTIG!
Bitte separat bestellen
IMPORTANT!
Please order separately



ACHTUNG / CAUTION

Die Angaben der Spannbereiche bei den verschiedenen Backen sind unbedingt zu beachten und einzuhalten! Bei unsachgemäßer Anwendung übernimmt TRIAG International keine Haftung.

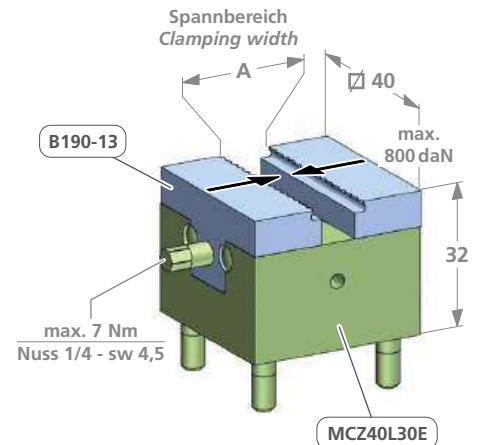
The details of the clamping ranges for the different jaws must be strictly followed! In case of improper use, TRIAG International assumes no liability.



Art. Nr.	B190-13	B190-22	B190-31
	57HRC	57HRC	57HRC
	~0,09	~0,08	~0,08

Für den Vorrichtungsbau / Mit einstellbarem Mittellager
For dedicated fixtures / With adjustable center position

Art. Nr.	Backen Jaws	A mm	kg
MCZ40L30E	B190-13	3 – 13	~0,24
	B190-22	12 – 22	
	B190-31	21 – 31	
	B190W6-40	variabel	
	B190W10-40	variabel	
	B190W20-40	variabel	
	B190W30-40	variabel	



Das Zentrum kann durch das Mittellager um +/- 0,5 mm
verstellt werden. Eine schwimmende
Werkstückspannung ist auch möglich.

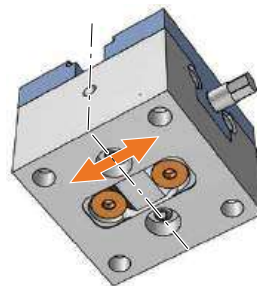
Lieferzustand:

Zentriert mit einer Toleranz von +/- 0,03 mm

The center can be adjusted by +/- 0,5 mm through the center
support. A floating fixture is also possible.

Delivery condition:

Centered with a tolerance of +/- 0,03 mm

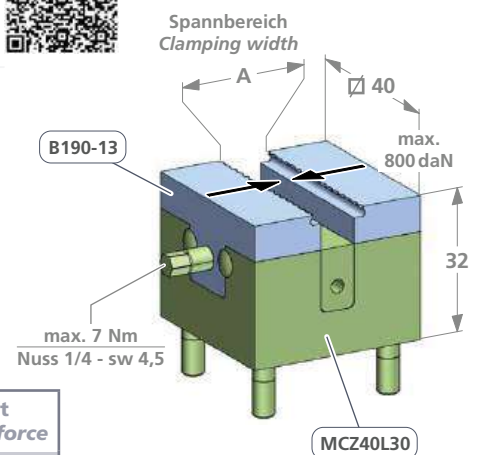


Bedienungsanleitung Operating instruction



Ohne einstellbares Mittellager
Without adjustable center position

Art. Nr.	Backen Jaws	A mm	kg
MCZ40L30	B190-13	3 – 13	~0,24
	B190-22	12 – 22	
	B190-31	21 – 31	
	B190W6-40	variabel	
	B190W10-40	variabel	
	B190W20-40	variabel	
	B190W30-40	variabel	



Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
4	3	= 457	1'007	0,46
5	3,7	= 571	1'259	0,57
6	4,4	= 686	1'512	0,69
7	5,2	= 800	1'764	0,8

B190W6-40	B190W10-40	B190W20-40	B190W30-40
weicher Stahl soft steel (1.7225)	weicher Stahl soft steel (1.7225)	weicher Stahl soft steel (1.7225)	weicher Stahl soft steel (1.7225)
~0,08	~0,012	~0,22	~0,32

Weich, zur Herstellung individueller Formbacke. / Soft, for the production of individual moulding jaw.



SEPARAT BESTELLEN
ORDER SEPARATELY

spaceGRIP I

Die spaceGRIP Baureihe wurde speziell für die effizientere Nutzung von 5-Achsen Maschinen entwickelt. Dabei zeichnen sich alle drei Baureihen der spaceGRIP Serie mit unterschiedlichen Merkmalen aus.

Sehr kompakte Bauweise zur Aufnahme von 4 oder 8 Micro Zentrischspannmodulen. Für die Rohteilebearbeitung gibt es drei Bausätze Prägebacken (3–13 mm, 12–22 mm und 21–31 mm).

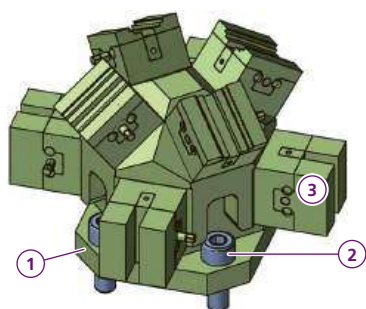
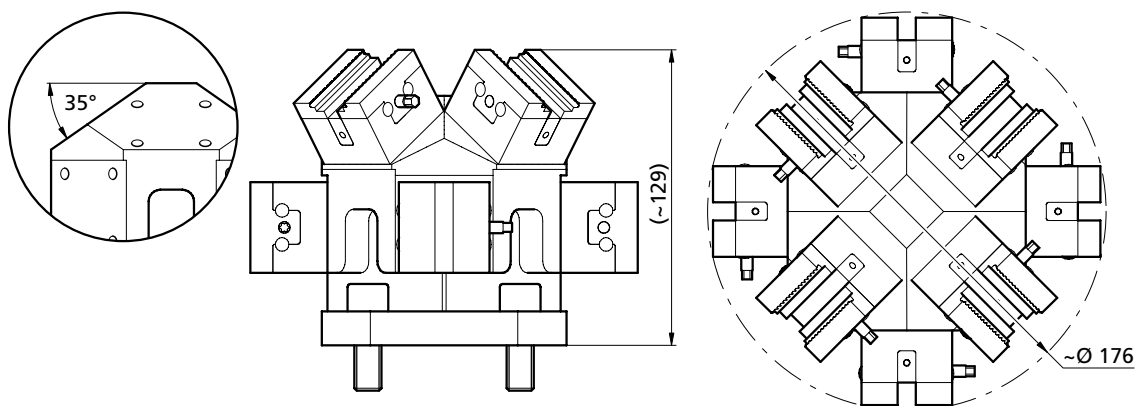
Für die zweite Spannung gibt es vier Sätze unterschiedlicher Backenrohlinge für die Einarbeitung einer Kontur. Die Spannkraft liegt bei 7 Nm 0,8 t 800 daN.

spaceGRIP I

The spaceGRIP series was specially developed to improve the out puts of 5-axis machines. All three types of the spaceGRIP series have different features.

Very compact design to hold 4 or 8 micro self centering clamping modules. There are three assembly kits of stamping jaws (3–13 mm, 12–22 mm and 21–31 mm) for raw part machining.

For the second clamping, there are four sets of different jaw blanks to integrate any shapes. The clamping force is at 7 Nm 0.8 t 800 daN.



UB5AXMCZ4035SET8

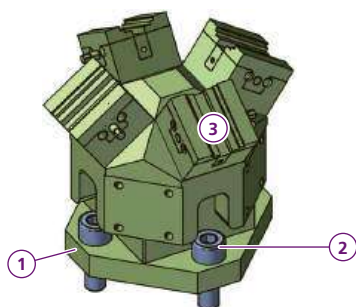
- 1x TB170676
- 4x M12X35ISO4762
- 8x Ihre Wahl / Your choice

kg ~5,1



Detailzeichnung zu dieser Schnittstelle
Detail drawing to interface

p. 116 - 117



UB5AXMCZ4035SET4

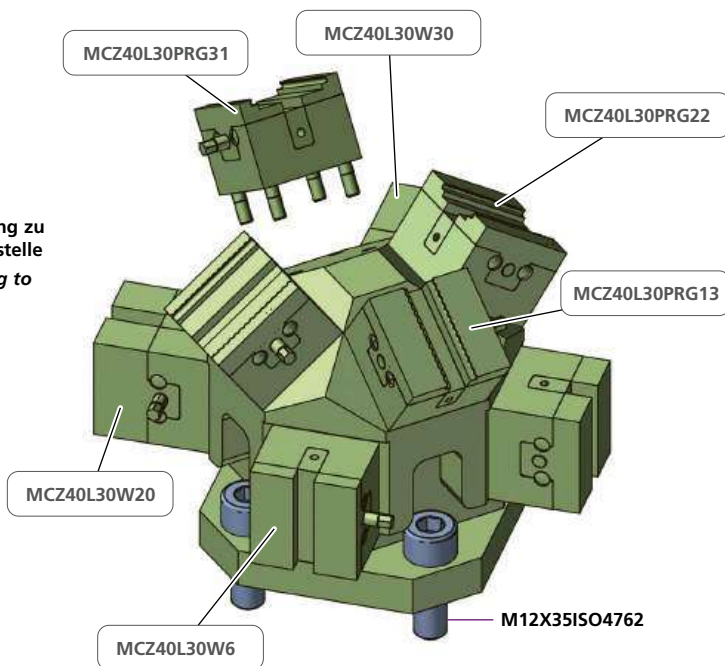
- 1x TB170676
- 4x M12X35ISO4762
- 4x Ihre Wahl / Your choice

kg ~3,2



Detailzeichnung zu dieser Schnittstelle
Detail drawing to interface

p. 116 - 117

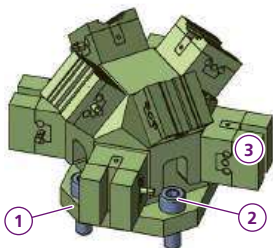


NUSS 1/4" 4.5MM

WICHTIG!
Bitte separat bestellen
IMPORTANT!
Please order separately



Bestellbeispiel / Ordering example:
2 x UB5AXMCZ40-35SET8 & 8 x MCZ40L30W10 &
8 x MCZ40L30PRG22 & 1 x Nuss 1/4 - sw 4,5



UB5AXMCZ40-45SET8

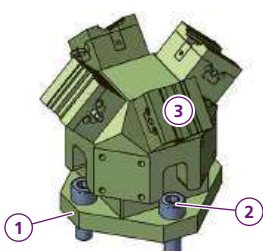
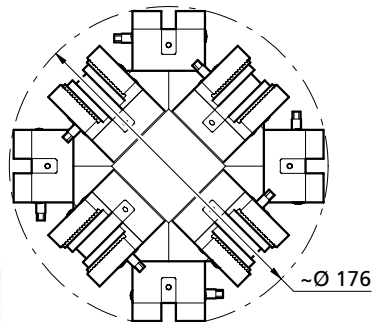
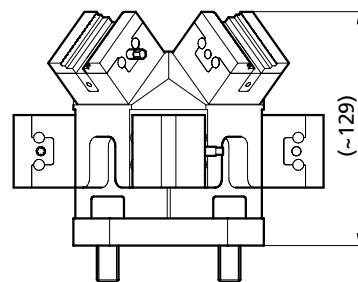
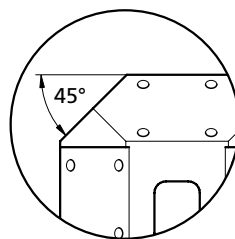
- 1x TK140867
- 4x M12X35ISO4762
- 8x Ihre Wahl / Your choice

kg ~5,2



Detailzeichnung zu dieser Schnittstelle
Detail drawing to interface

p. 116 - 117



UB5AXMCZ4045SET4

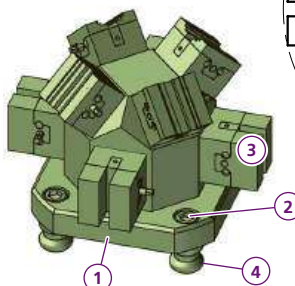
- 1x TK140867
- 4x M12X35ISO4762
- 4x Ihre Wahl / Your choice

kg ~4,2



Detailzeichnung zu dieser Schnittstelle
Detail drawing to interface

p. 116 - 117



UB5AXMCZ4045SET8-OPBM

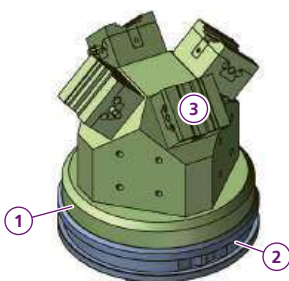
- 1x TK160869
- 4x M12X20ISO4762
- 8x Ihre Wahl / Your choice
- 4x OPBM18M12

kg ~6,2



Detailzeichnung zu dieser Schnittstelle
Detail drawing to interface

p. 116 - 117



UB5AXMCZ4045SET4-ER

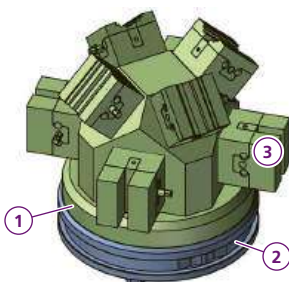
- 1x TB161062
- 1x ER-129663 EROWA ITS-Palette
- 4x Ihre Wahl / Your choice

kg ~4,1



Detailzeichnung zu dieser Schnittstelle
Detail drawing to interface

p. 116 - 117



UB5AXMCZ40-45SET8-ER

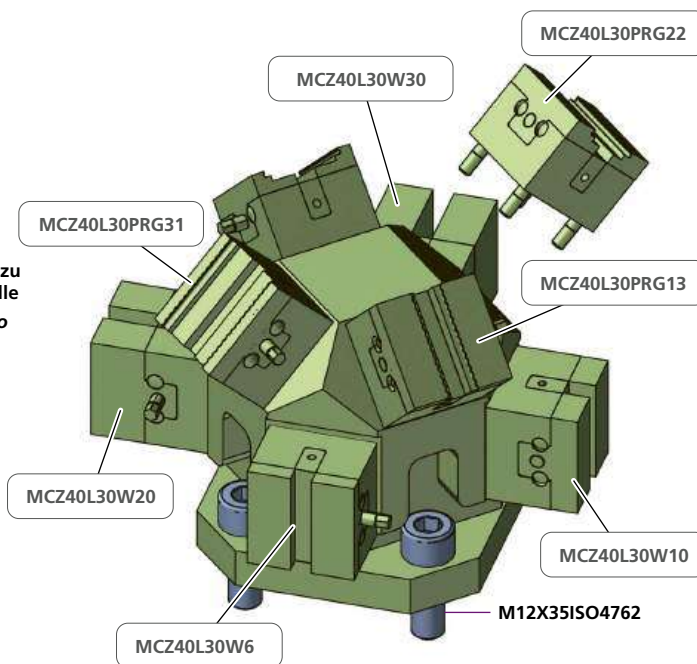
- 1x TB161062
- 1x ER-129663 EROWA ITS-Palette
- 8x Ihre Wahl / Your choice

kg ~6,1



Detailzeichnung zu dieser Schnittstelle
Detail drawing to interface

p. 116 - 117

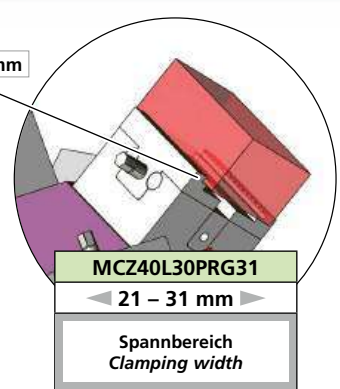
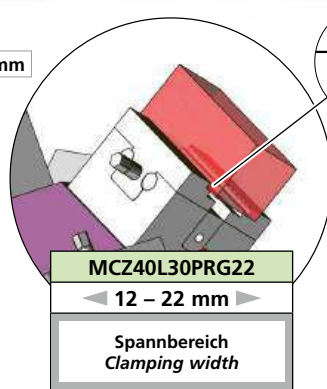
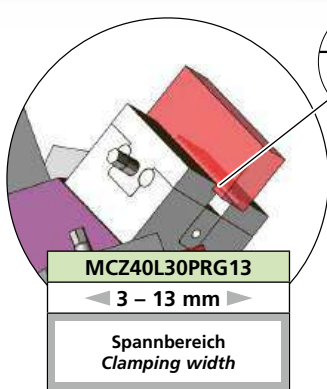


NUSS1/4"4.5MM

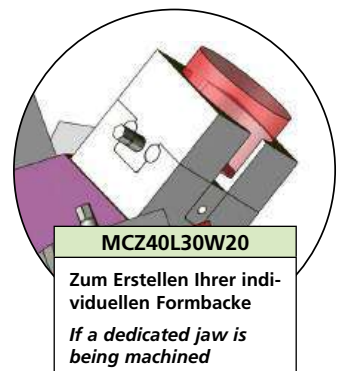
WICHTIG!
Bitte separat bestellen
IMPORTANT!
Please order separately



Bestellbeispiel / Ordering example:
2 x UB5AXMCZ40-45SET8 & 8 x MCZ40L30W20 &
8 x MCZ40L30PRG22 & 1 x Nuss 1/4 - sw 4,5



p. 116 Micro Zentrischspanner / Micro - self centering vise

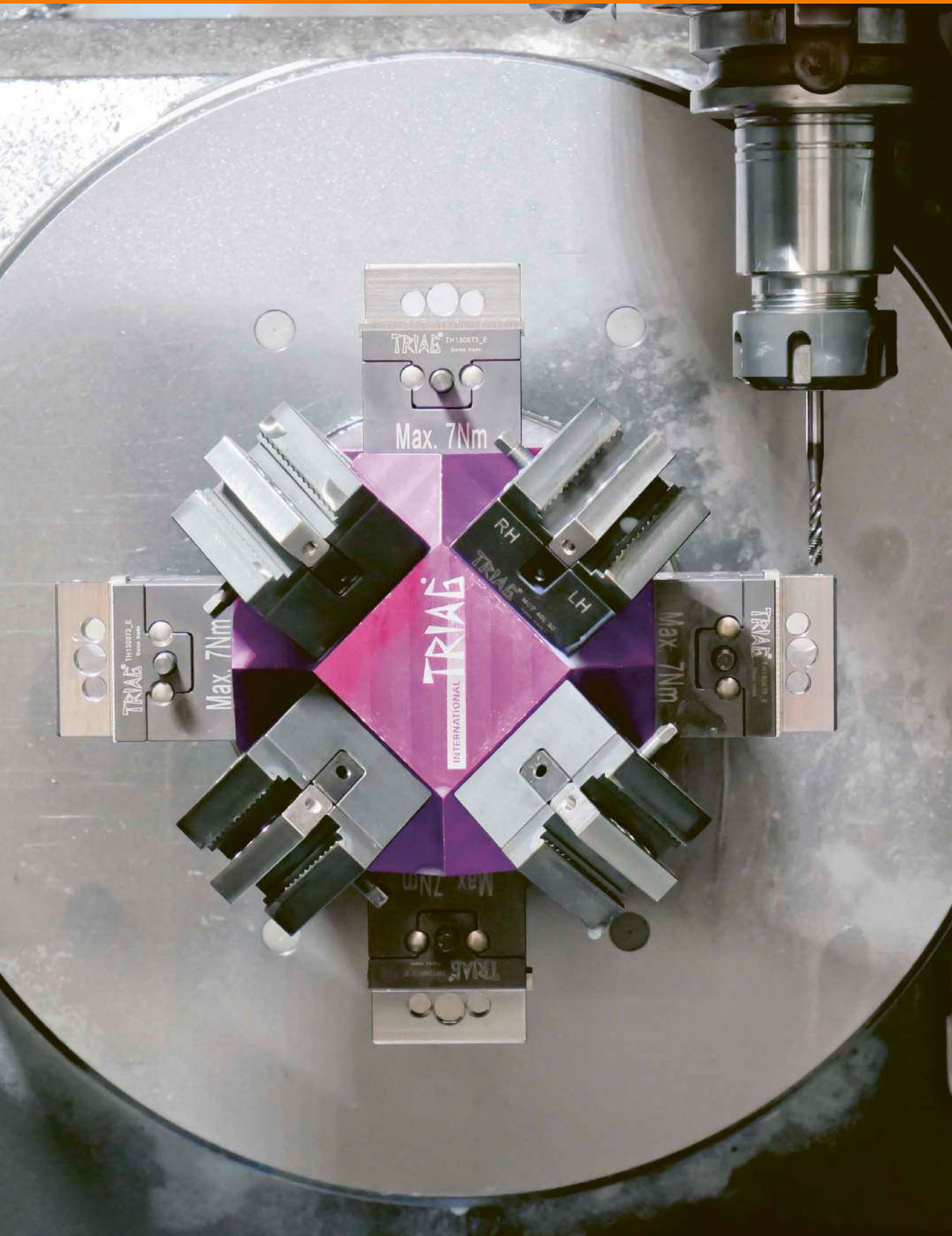


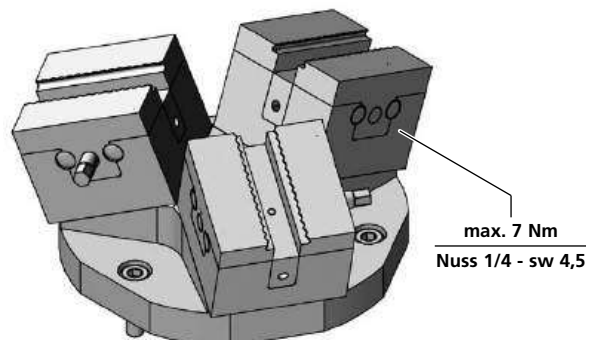
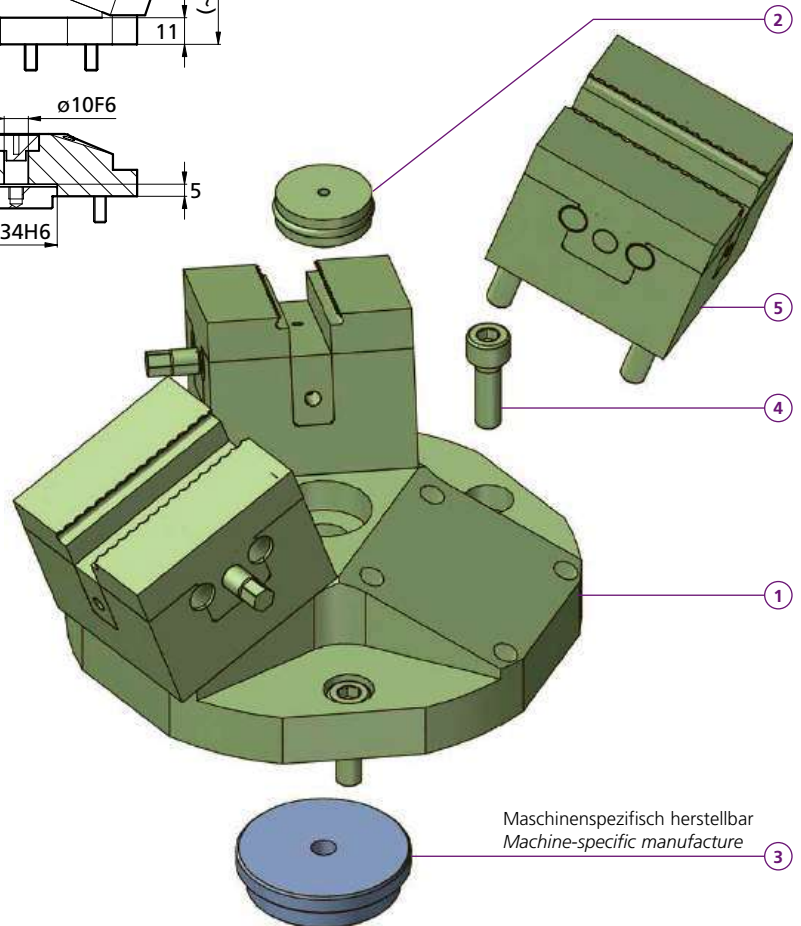
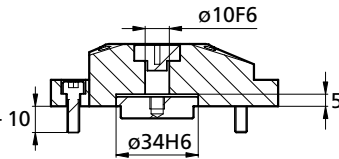
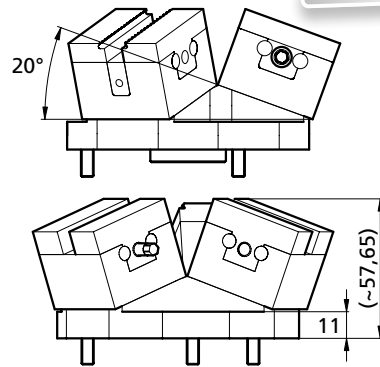
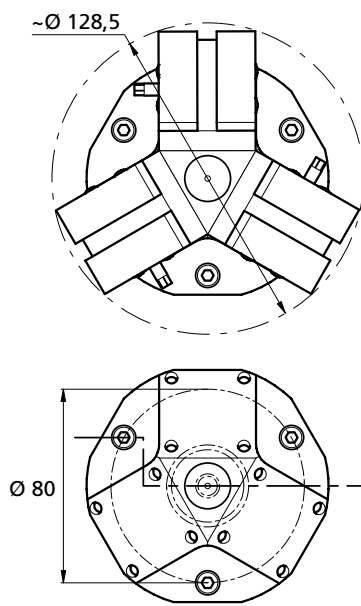
p. 116 Micro Zentrischspanner / Micro - self centering vise

Anwendungsbilder
Pictures of application to

MICRO

Zentrischspanner
self centering vise





20° UB5AXSET18-3

- ① 1x TH170934
- ② 1x PCPF16L6
- ③ 1x TH171176
- ④ 3x M5X16ISO4762
- ⑤ 3x Ihre Wahl / Your choice

p. 116 - 117

kg ~1,45

Drehmoment und Spannkraft siehe Seite
 Torque and clamping force see page

117

NUSS 1/4"4.5MM

WICHTIG!
 Bitte separat bestellen
IMPORTANT!
 Please order separately



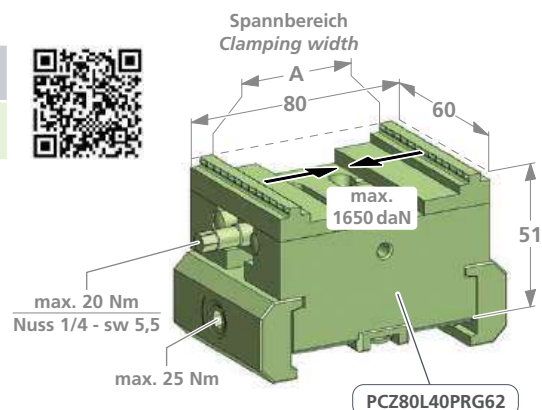
Bestellbeispiel / Ordering example : 1 x UB5AXSET18-3 & 1x TH171176 & 3x M5x16

Separat bestellen / Order separately

Kompakter Zentrischspanner Compact self centering vise

triCENTRO

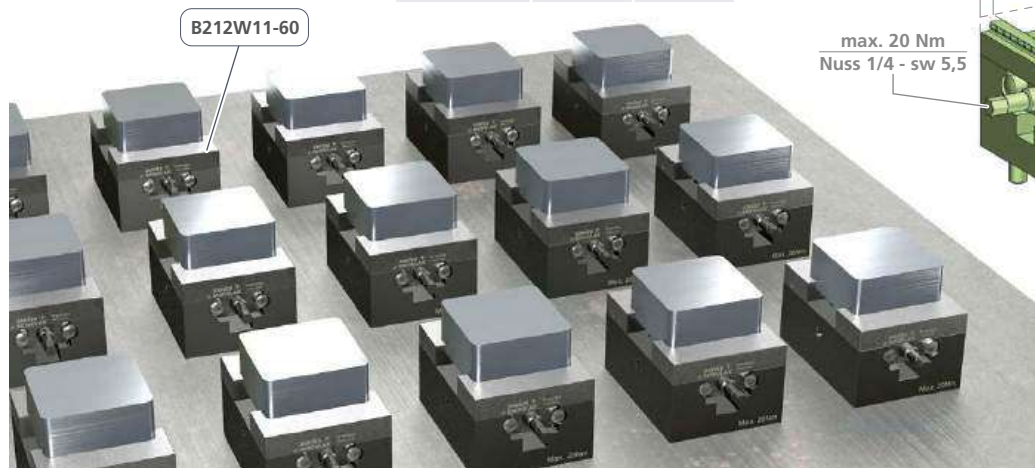
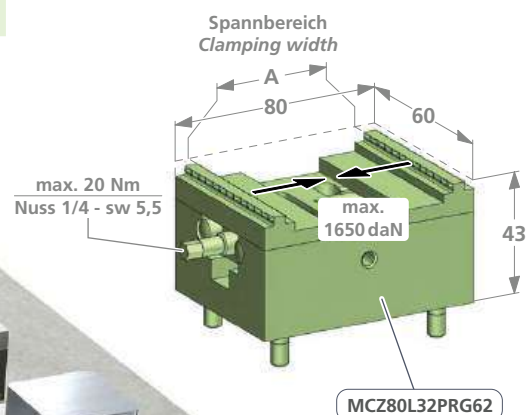
Art. Nr.		Backen Jaws	A mm	B mm	kg
PCZ80L40PRG62		B210-26	32 – 62	6 – 35	~1,71
		B210W11-60	variabel	variabel	
		B210W20-60	variabel	variabel	



Für den Vorrichtungsbau
For dedicated fixtures

Art. Nr.		Backen Jaws	A mm	B mm	kg
MCZ80L32PRG62		B210-62	32 – 62	6 – 35	~1,39
		B210W11-60	variabel	variabel	
		B210W20-60	variabel	variabel	

Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
5	3,7	= 410	900	0,41
10	7,4	= 830	1'830	0,83
15	11,0	= 1'250	2'760	1,25
20	14,8	= 1'650	2'640	1,65



Linear- Spannbacke / Linear clamping jaw ➔

Art. Nr.	B210-62	B212W11-60	B212W20-60
	57HRC	Vergütungsstahl Tempering steel (1.7225)	Vergütungsstahl Tempering steel (1.7225)
kg	~0,31	~0,31	~0,52

NUSS 1/4" 5.5MM

WICHTIG!
Bitte separat bestellen
IMPORTANT!
Please order separately



Weich, zur Herstellung individueller Formbacke. / Soft, for the production of individual moulding jaw.



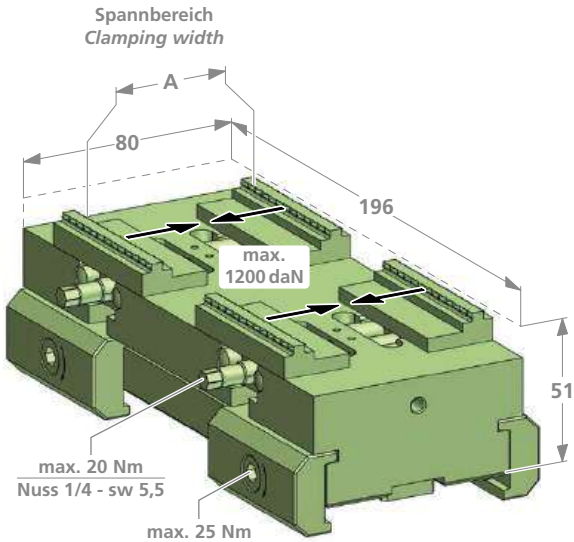
**SEPARAT BESTELLEN
ORDER SEPARATELY**

Kompakter doppelter Zentrischspanner

Compact double self centering vise

triCENTRO

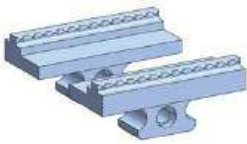
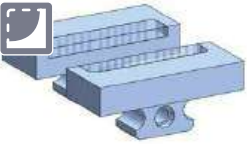
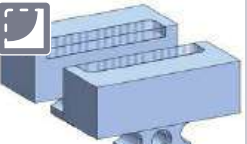
Art. Nr.		Backen Jaws	A mm	B mm	kg
PC2Z80L40PRG62	 	B210-26	32 – 62	6 – 35	~4,7
		B210W11-60	variabel	variabel	
		B210W20-60	variabel	variabel	



Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
5	3,7	= 410	900	0,41
10	7,4	= 830	1'830	0,83
15	11,0	= 1'250	2'760	1,25
20	14,8	= 1'650	2'640	1,65



Linear- Spannbacke / Linear clamping jaw

Art. Nr.	B210-62		B212W11-60		B212W20-60	
	57HRC		Vergütungsstahl Tempering steel (1.7225)		Vergütungsstahl Tempering steel (1.7225)	
kg	~0,31		~0,31		~0,52	
						

Weich, zur Herstellung individueller Formbacke. / Soft, for the production of individual moulding jaw.

NUSS1/4"5.5MM

WICHTIG!
Bitte separat bestellen
IMPORTANT!
Please order separately

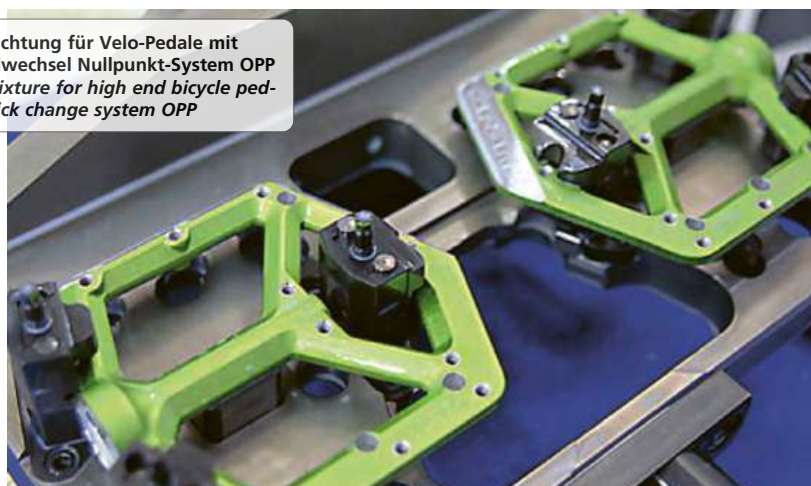




Zwei Mini - Zentrischspanner mit Direktprägebacken halten verschieden lange Titanbleche. Um die verschiedenen Längen zu adaptieren, können die Spanner in 2 mm schritten seitlich versetzt werden.

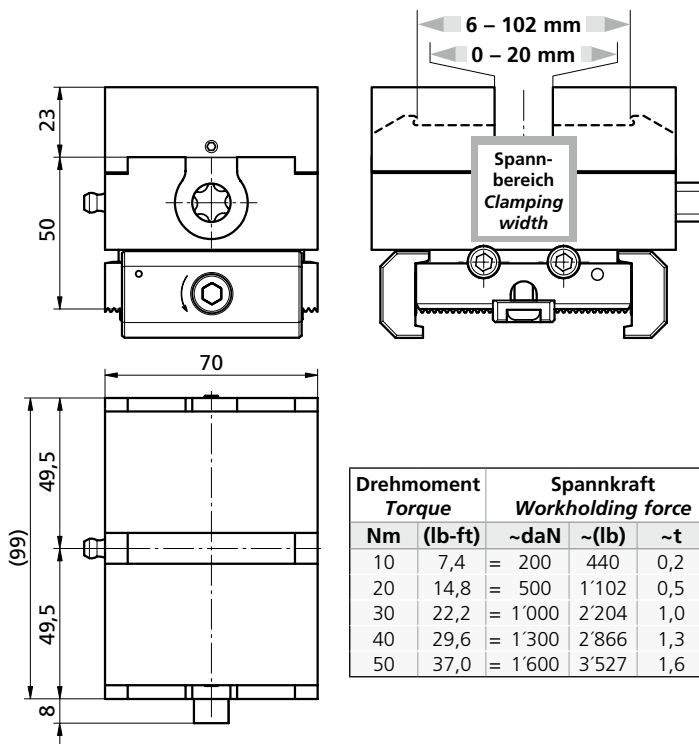
Two mini - self centering vises with direct stamping jaws holding titanium sheets in different length. To adapt the different length's the vises can be moved side words in 2 mm steps.

Sondervorrichtung für Velo-Pedale mit dem schnellwechsel Nullpunkt-System OPP
Dedicated fixture for high end bicycle pedals with quick change system OPP



siehe Video
see video





Drehmoment Torque		Spannkraft Workholding force			
Nm	(lb-ft)	~daN	~(lb)	~t	
10	7,4	= 200	440	0,2	
20	14,8	= 500	1'102	0,5	
30	22,2	= 1'000	2'204	1,0	
40	29,6	= 1'300	2'866	1,3	
50	37,0	= 1'600	3'527	1,6	

Innenspannung-Set / Inner clamping set

Mit diesem Set ist es möglich das Werkstück von innen zu spannen. With this set it is possible to clamp the workpiece from the inside.

ACHTUNG / CAUTION

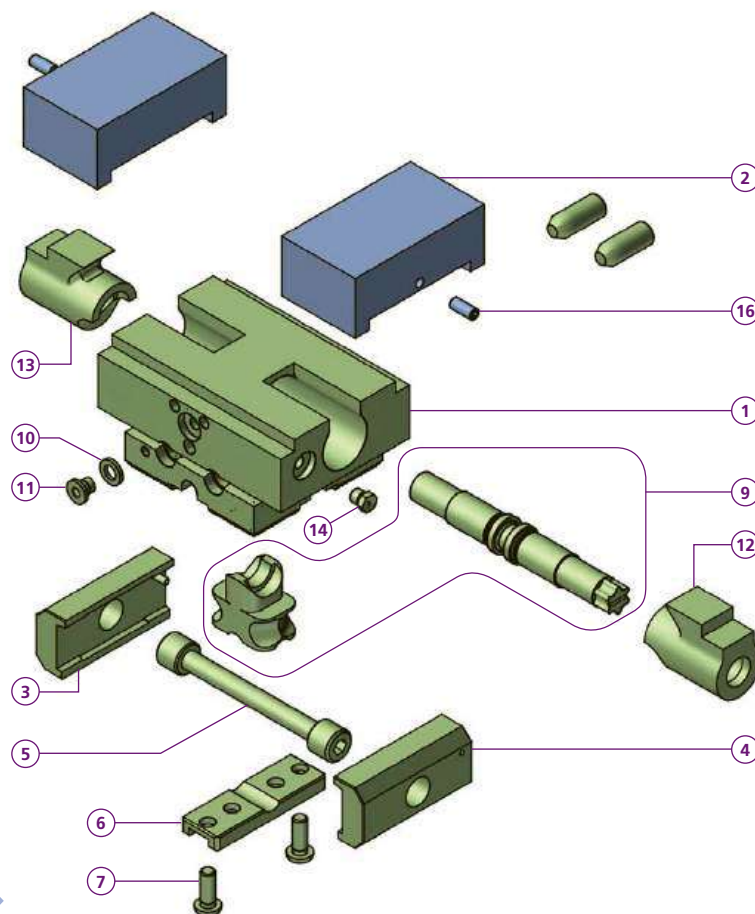
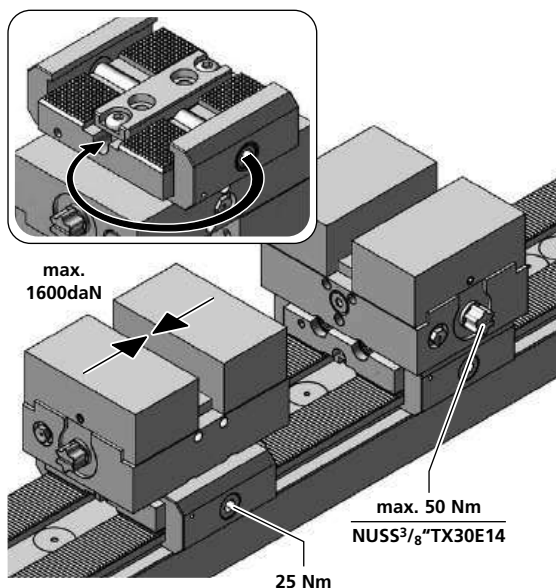
Folgende Spannbacken sind dazu nicht geeignet.

The following clamping jaws are not suitable for this purpose.

B175-102, B175-121, B173-102

PCZS2439-ID-SET

Nullpunkt des Zentrischspanners neu einstellen
How to readjust the zero point adjustment



PCZ100L50	
1	1x PCZ100L50M
2	2x
3	1x PCSP60L
4	1x PCSP60R
5	1x PCS14
6	1x PCGUW20
7	2x M6X16ISO7380
9	1x PCS14M107SET
10	1x BN726 ISO 7092 M6
11	1x BN1206 M6x6
12	1x PCZS2439L
13	1x PCZS2439R
14	1x PCZSNP
15	4x PCZ1025
16	2x TN100140
kg	~2,5

p. 128 - 129

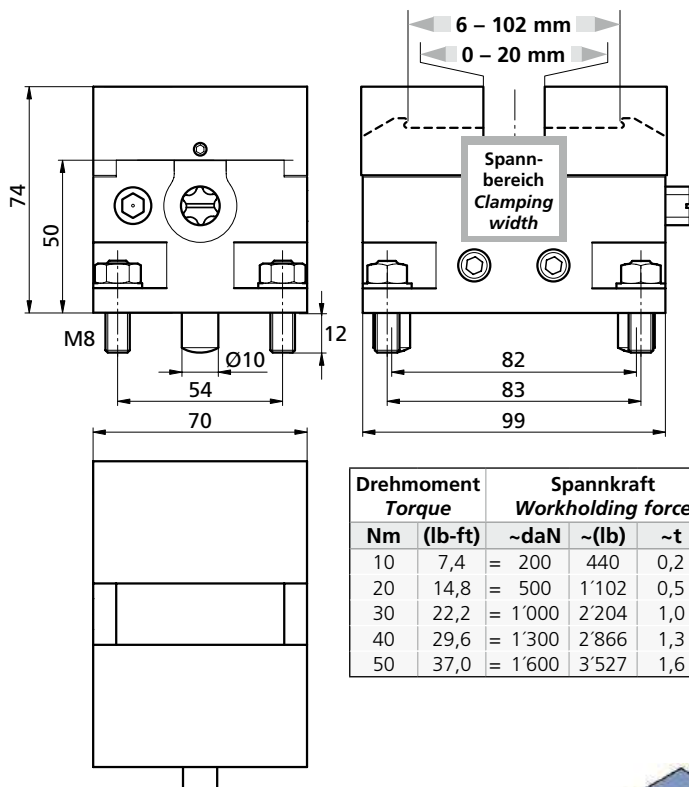
NUSS3/8"TX30E14

WICHTIG!
Bitte separat bestellen

IMPORTANT!
Please order separately



Bestellbeispiel / Ordering example:
3 x PCZ100L50 & 6 x B170 & 1 x NUSS3/8"TX30E14



Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
10	7,4	= 200	440	0,2
20	14,8	= 500	1'102	0,5
30	22,2	= 1'000	2'204	1,0
40	29,6	= 1'300	2'866	1,3
50	37,0	= 1'600	3'527	1,6

Innenspannung-Set / Inner clamping set

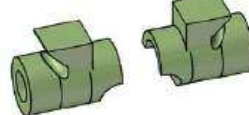
Mit diesem Set ist es möglich das Werkstück von innen zu spannen. With this set it is possible to clamp the workpiece from the inside.

ACHTUNG / CAUTION

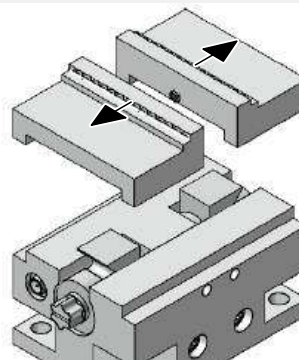
Folgende Spannbacken sind dazu nicht geeignet.

The following clamping jaws are not suitable for this purpose.

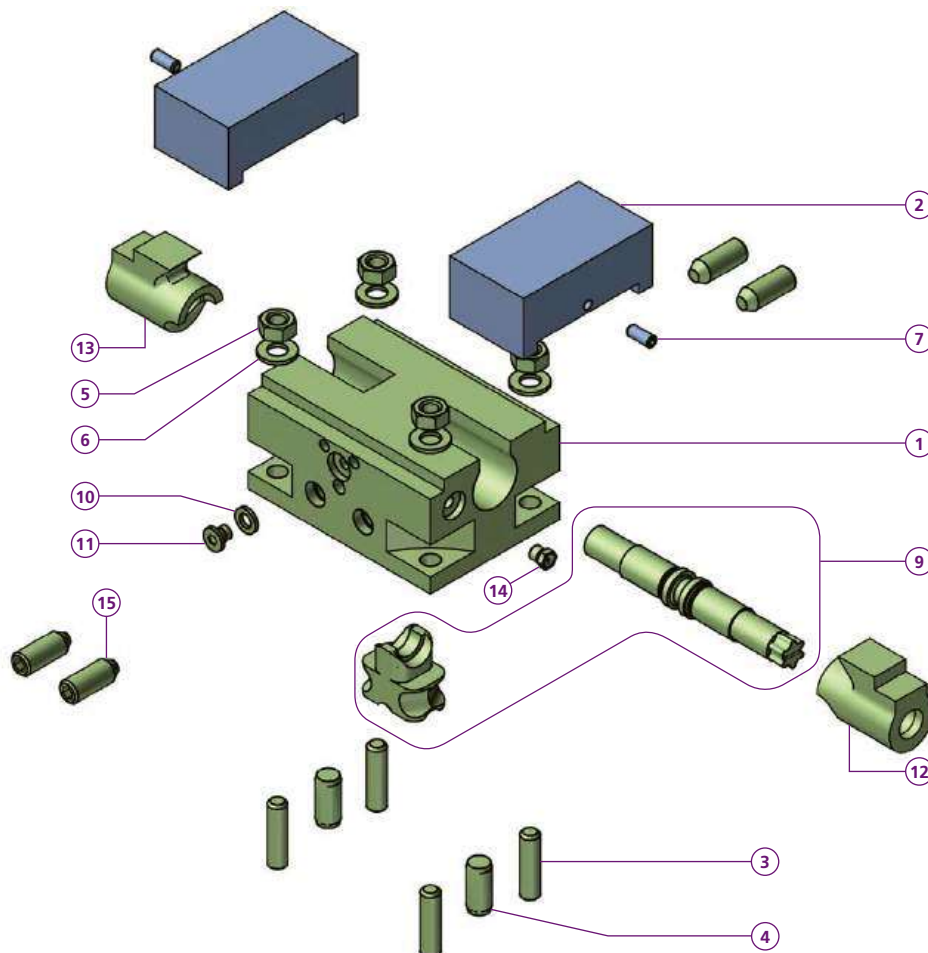
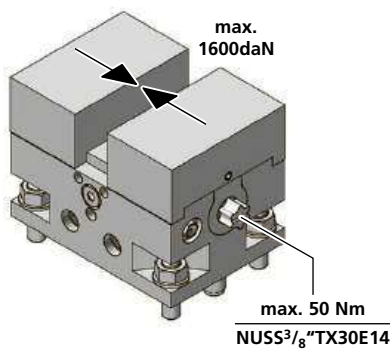
B175-102, B175-121, B173-102



PCZS2439-ID-SET



Nullpunkt des Zentrischspanners neu einstellen
How to readjust the zero point adjustment



MCZ100L50	
1	1x MCZ100L50M
2	2x
3	2x 10m6x22 ISO 8734
4	4x M8X30DIN913
5	4x M8 DIN 934
6	4x 8,4 DIN 125 A
7	2x TN100140
9	1x PCS14M107SET
10	1x BN726 ISO 7092 M6
11	1x BN1206 M6x6
12	1x PCZS2439L
13	1x PCZS2439R
14	1x PCZSNP
15	4x PCZJ1025
kg	~2,6

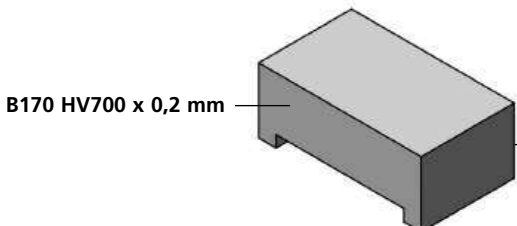
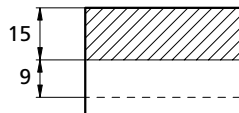
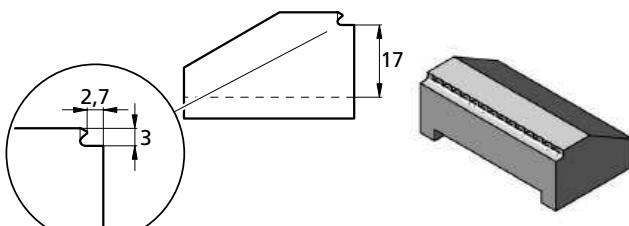
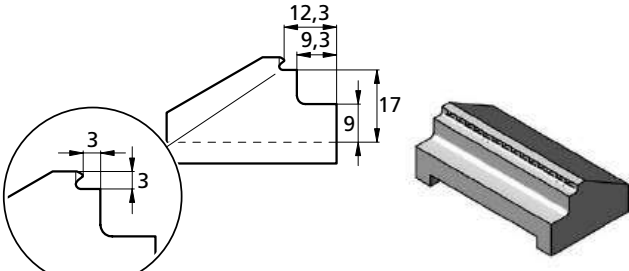
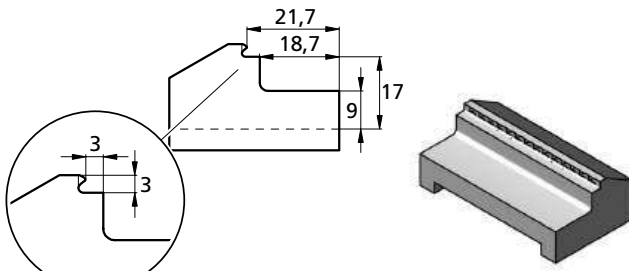
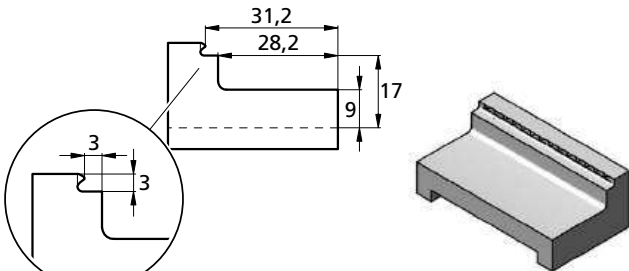
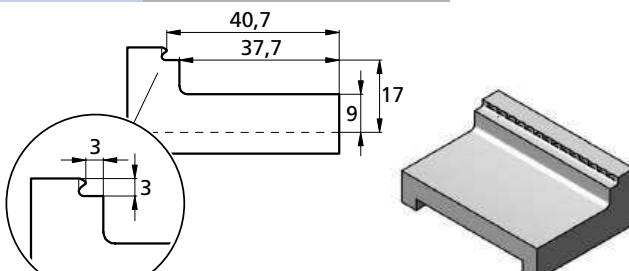
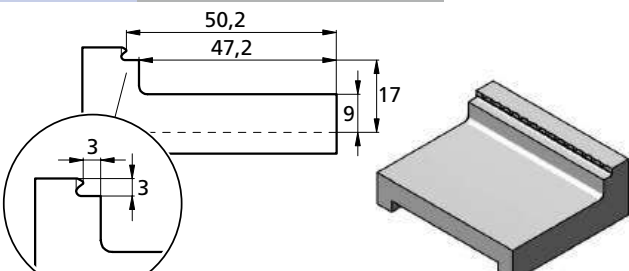
p. 128 - 129

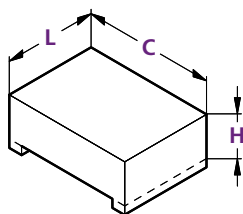
NUSS3/8"TX30E14

WICHTIG!
Bitte separat bestellen
IMPORTANT!
Please order separately



Bestellbeispiel / Ordering example:
3 x MCZ100L50 & 6 x B170 & 1 x NUSS3/8"TX30E14

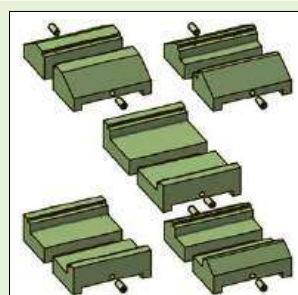
B170, B172	Spannbereich / Clamping width	◀ 0 – 20 mm ▶	Zum Erstellen Ihrer individuellen Formbacke: Schnittzeichnung zum Ermitteln der maximalen Bearbeitungsprofiltiefe If a dedicated jaw is being machined: Sectional drawing to determine the maximum machining depth   für / for B170, B172
B175-26	Spannbereich / Clamping width	◀ 6 – 26 mm ▶	
B175-45	Spannbereich / Clamping width	◀ 25 – 45 mm ▶	
B175-64	Spannbereich / Clamping width	◀ 44 – 64 mm ▶	
B175-83	Spannbereich / Clamping width	◀ 63 – 83 mm ▶	
B175-102	Spannbereich / Clamping width	◀ 82 – 102 mm ▶	
B175-121	Spannbereich / Clamping width	◀ 101 – 121 mm ▶	



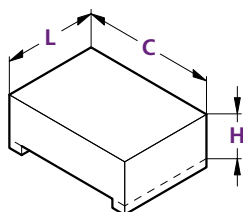
B

Bestellbeispiel / Ordering example: 2 x B170

	B170	B172	B175-26	B175-45	B175-64	B175-83	B175-102	B175-121	B175SET
C	70	70	70	70	70	70	70	70	2x B175-26
H	24	24	20	20	20	20	20	20	2x B175-45
L	40	40	40	40	40	40	50	60	2x B175-64
i	HV700	*	57HRC	57HRC	57HRC	57HRC	57HRC	57HRC	2x B175-83
	x0,2mm								2x B175-102
kg	~0,5	~0,5	~0,34	~0,29	~0,28	~0,25	~0,31	~0,37	

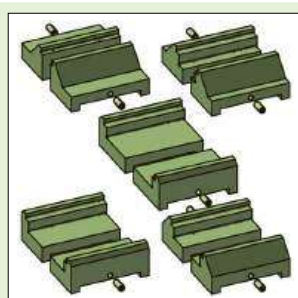


B173-26 Spannereich / Clamping width ◀ 6 – 26 mm ▶ 	B173-45 Spannereich / Clamping width ◀ 25 – 45 mm ▶
B173-64 Spannereich / Clamping width ◀ 44 – 64 mm ▶ 	B173-83 Spannereich / Clamping width ◀ 63 – 83 mm ▶
B173-102 Spannereich / Clamping width ◀ 82 – 102 mm ▶ 	B176-80 Spannereich / Clamping width ◀ 8 – 80 mm ▶ 2x Inklusive /Included PRG1003M8
ZK160798M5 Extra Zubehör: Schraube zum schnellen Wechseln der Backen Additional accessories: Screw for quick change of jaws 	PRG1003M8 Bohrbild Hole pattern



Bestellbeispiel / Ordering example: 2 x **B173-26**

B	B173-26	B173-45	B173-64	B173-83	B173-102	B176-80	B173SET
C	70	70	70	70	70	70	2x B173-26
H	24	24	24	24	24	20	2x B173-45
L	40	40	40	40	50	40	2x B173-64
i	HV700	HV700	HV700	HV700	HV700	HV700	2x B173-83
	x0,2mm	x0,2mm	x0,2mm	x0,2mm	x0,2mm	x0,2mm	2x B173-102
kg	~0,31	~0,32	~0,32	~0,28	~0,34	~0,4	



Doppelte Spannung – doppelt effizient
Twice the clamping – twice the efficiency

Art. Nr.	kg	Backen Jaws	A = 2 x
B172-MB	~0,3	B172	variabel

weicher Stahl
soft steel (1.7225)

B173-MB	~0,3	B173-45	10 – 17 mm
	HV700 x 0,2mm	B173-64	17 – 27 mm

B173-83 27 – 37 mm

B173-102 36 – 46 mm

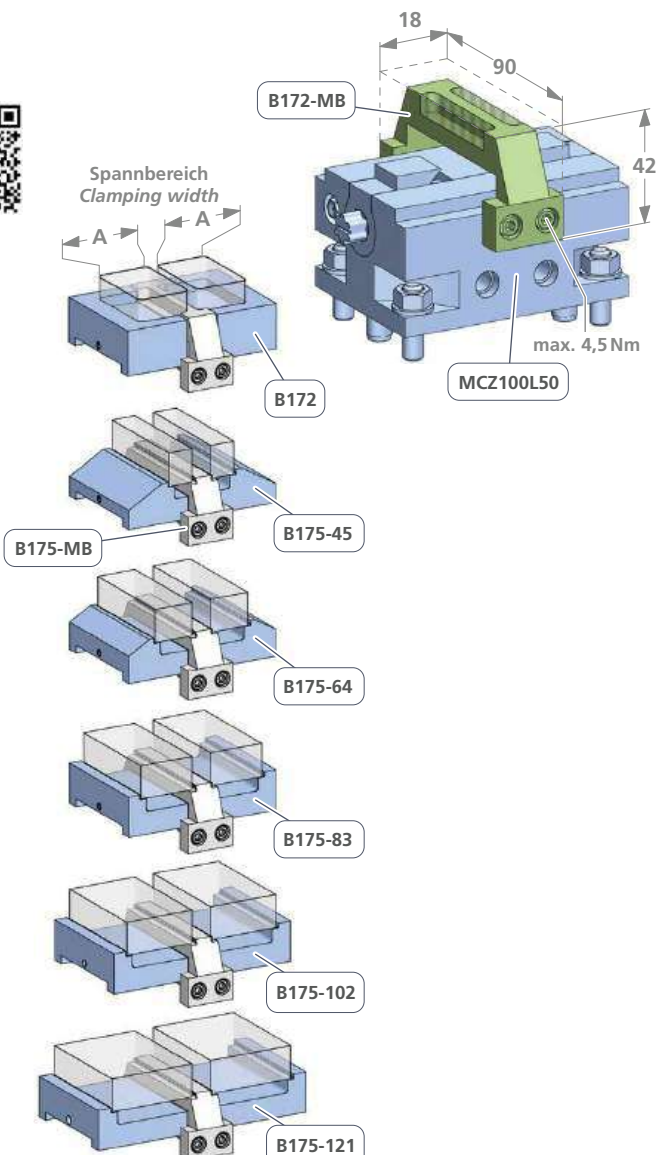
B175-121 46 – 55 mm

B175-MB	~0,3	B175-45	8 – 16 mm
	57HRC	B175-64	16 – 26 mm

B175-83 25 – 35 mm

B175-102 35 – 45 mm

B175-121 45 – 54 mm



Die Anschlagbrücken **B172-MB**, **B173-MB** und **B175-MB** können in Kombination mit den Zentrischspannern PCZ100L50 / MCZ100L50 als Doppelspanner eingesetzt werden.

The **B172-MB**, **B173-MB**, and **B175-MB** stop bridges can be used as double clamps in combination with the PCZ100L50 / MCZ100L50 self centering vise.



ACHTUNG / CAUTION

Beim Einsatz der Anschlagbrücke muss der Spanner schwimmend eingestellt werden, dabei werden die vier Zentrierschrauben entfernt.

When using the stop bridge, the tensioner must be adjusted to float, removing the four centring screws in the process.

Folgende Spannbacken sind dazu nicht geeignet.

The following clamping jaws are not suitable for this purpose.

B170, B173-26, B175-26, B176-80

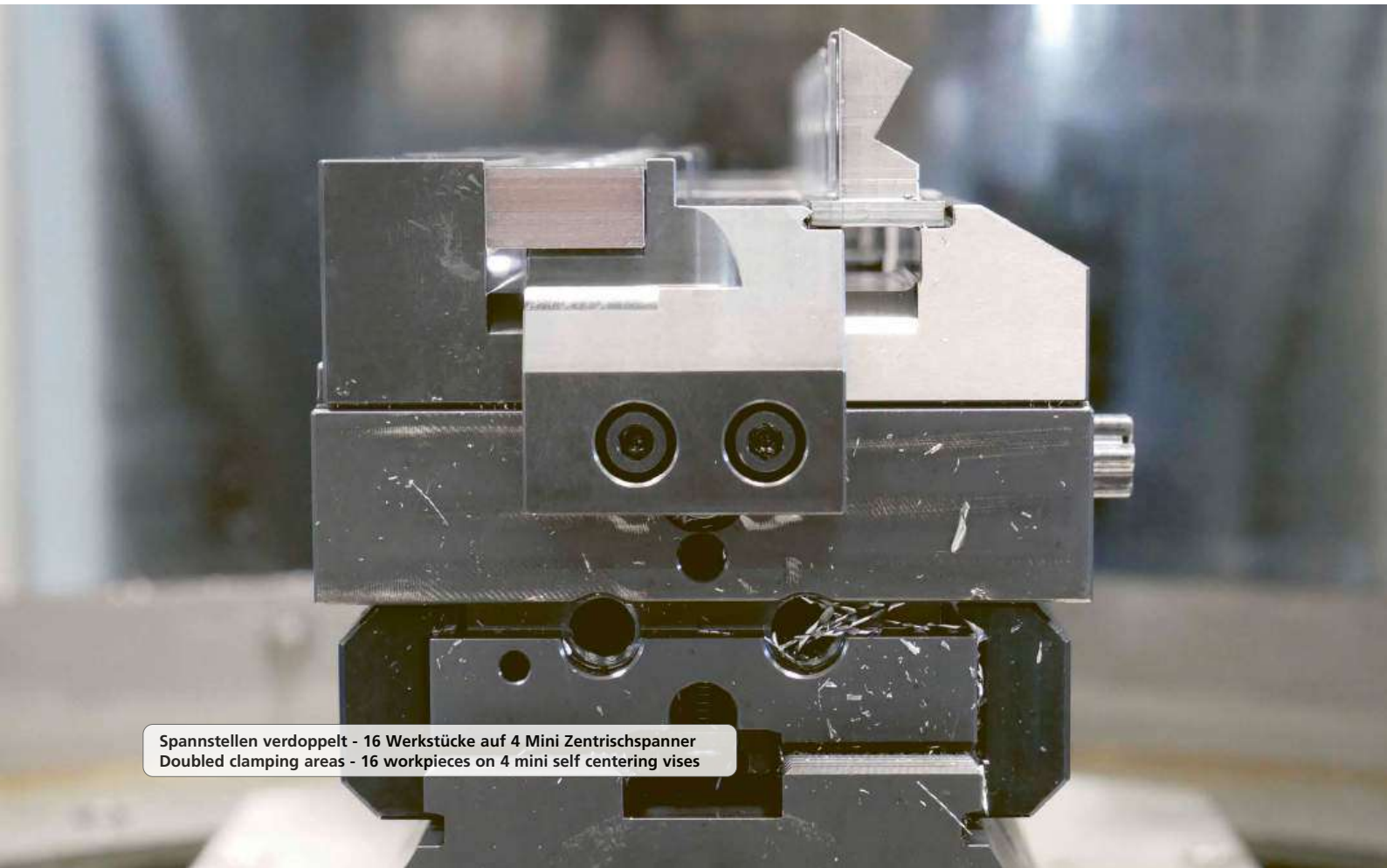
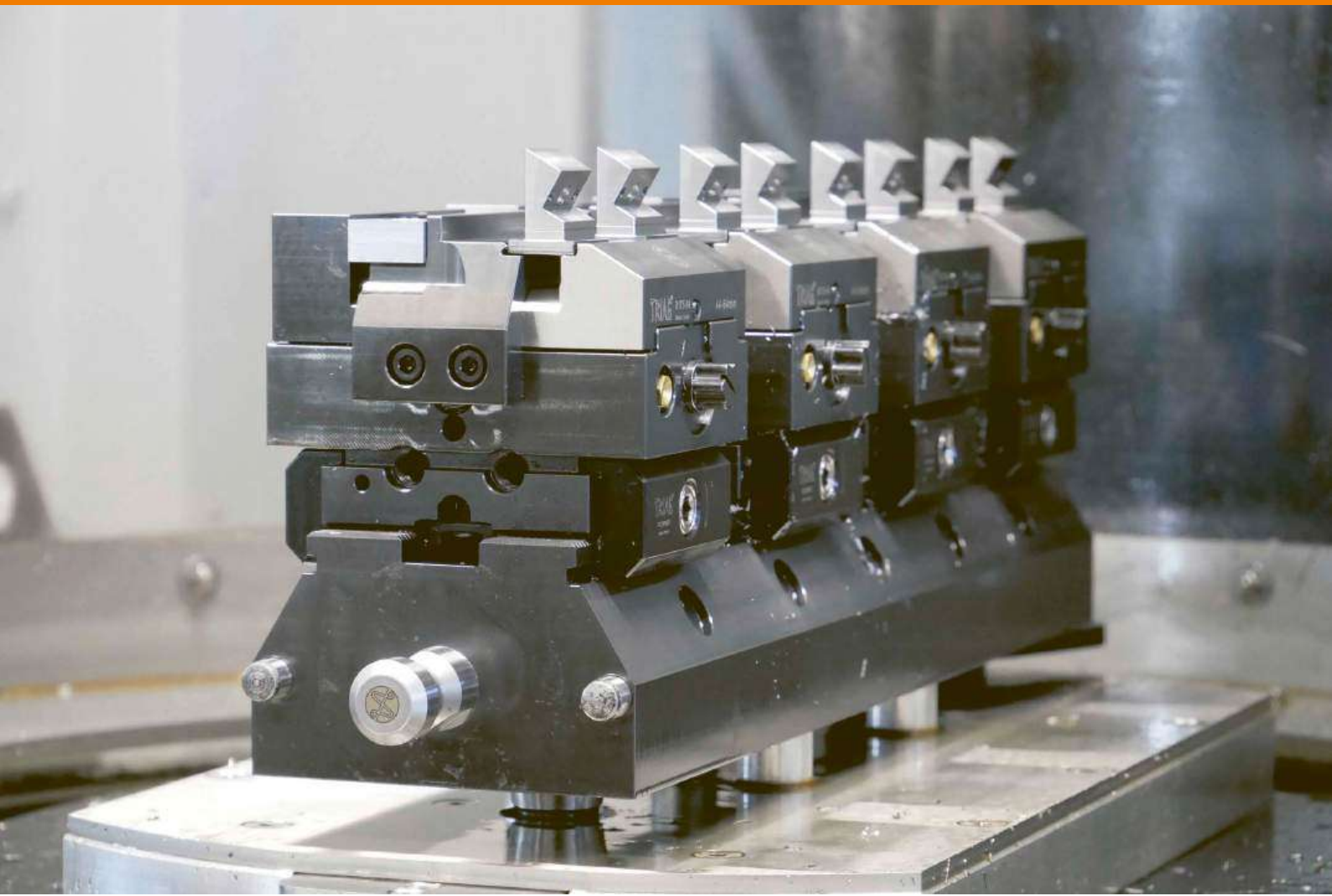
Montageanleitung der Anschlagbrücke auf dem Mini-Zentrischspanner
Operating instructions for this self centering vise



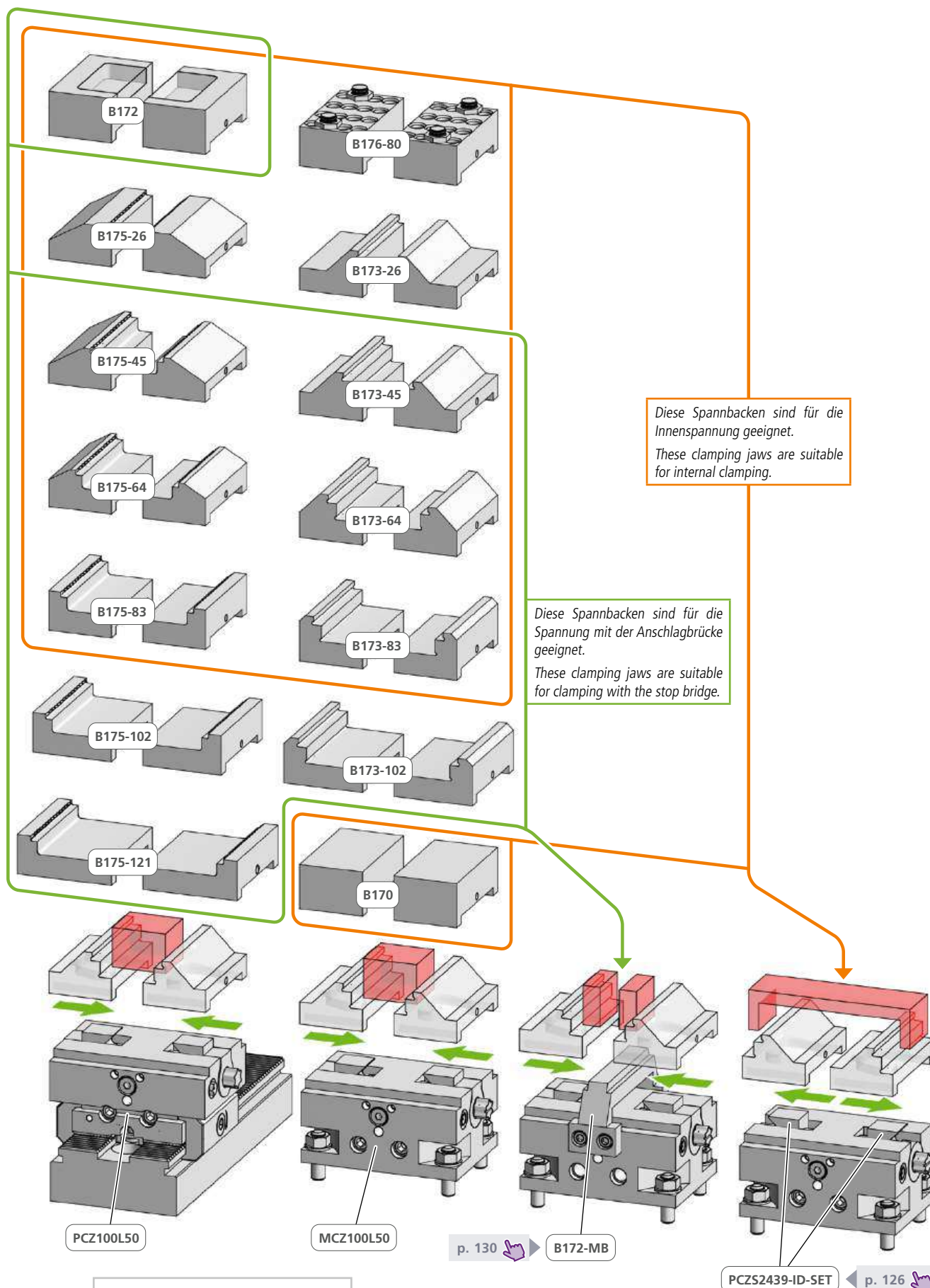
MINI

Zentrischspanner mit Anschlagbrücke
Self centering vise with center stop

triCENTRO



Spannstellen verdoppelt - 16 Werkstücke auf 4 Mini Zentrischspanner
Doubled clamping areas - 16 workpieces on 4 mini self centering vises



SPACEGRIP II

spaceGRIP II

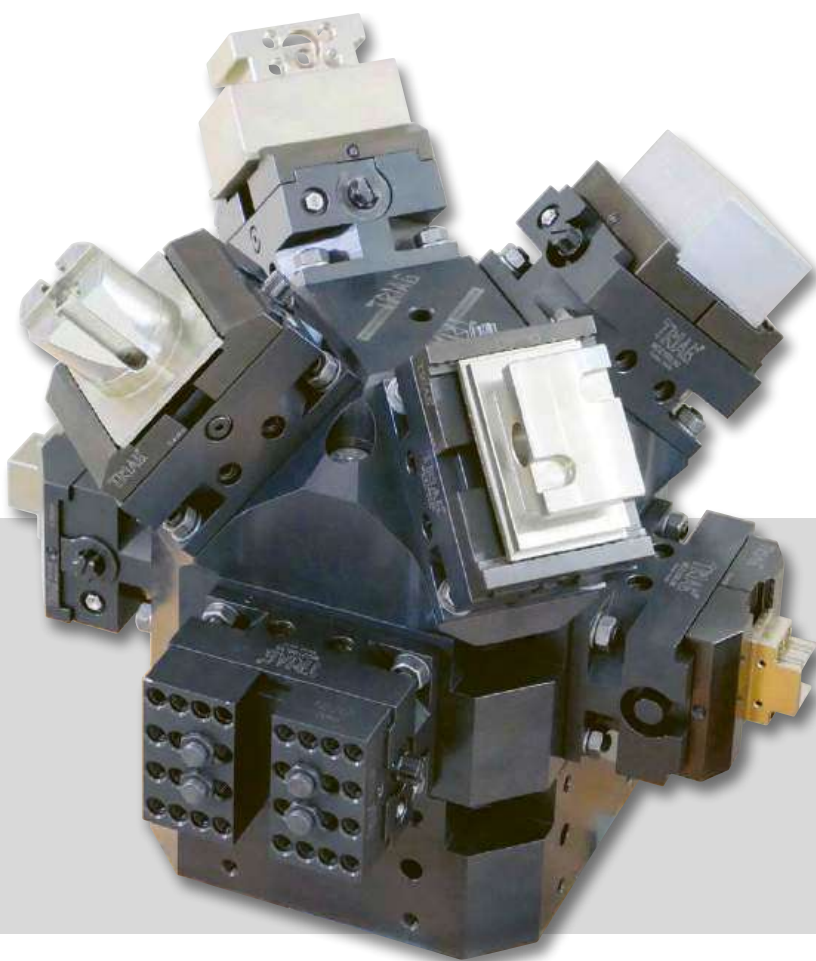
Ein einzigartig auf Modulbauweise ausgelegtes Spannkonzzept für den Einsatz der Zentrischspanner **MCZ100L50**.

Es können 4, 8 oder gar 12 Spanner, je nach Wunsch, eingesetzt werden. Das Ganze ist so modular wie ein «Lego»-Baukasten-System. Wieder stehen Prägebacken, weiche Backen und zusätzlich Stufen- und Universalbacken zur Verfügung. Sogar das Zentrum der einzelnen Spannstöcke kann eingestellt werden.

spaceGRIP II

*A unique clamping concept with modular construction design for using the self-centering vice **MCZ100L50**.*

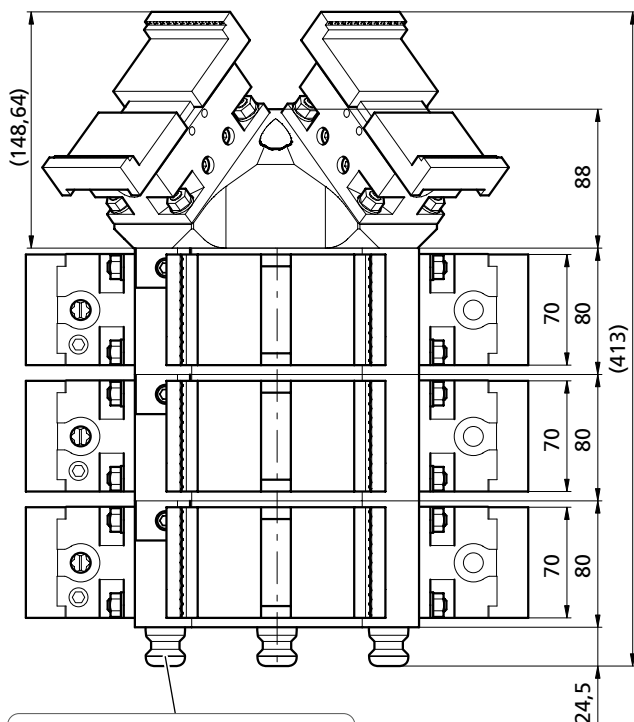
Four, eight or even twelve clamping vices can be used as needed. The whole system is modular like a «Lego» building kit. Again, stamping jaws, soft jaws and universal as well as stepped jaws are available. Even the centre of the individual vices can be adjusted.



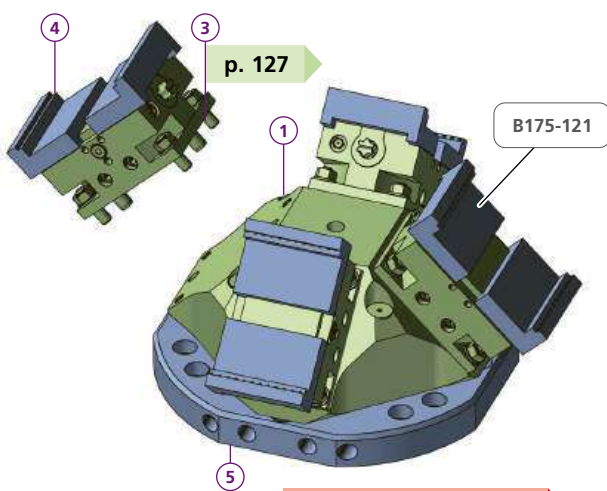
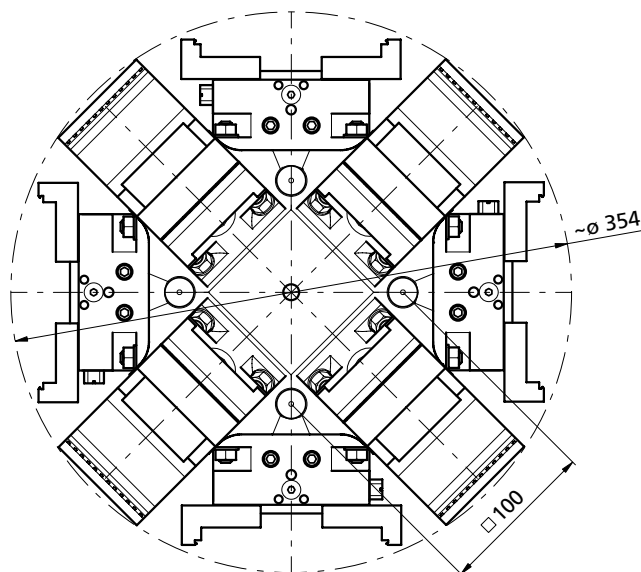
SPACEGRIP II



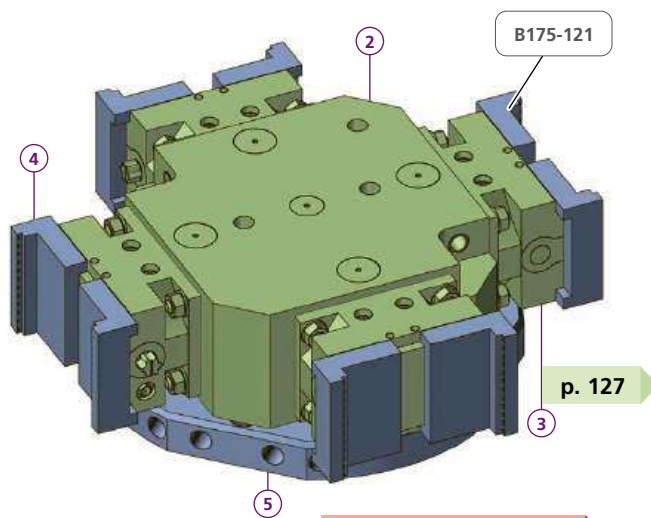
SPACEGRIP II



OPP-Schnittstelle Nullpunkt-System
OPP interface Zero-point system



oppSystem p. 289



oppSystem p. 289

5AXMCZ100-45-4

- 1x TS160110
- 4x MCZ100L50
- 8x —————
- 1x TB160379

kg ~22,8



Detailzeichnung
zu dieser
Schnittstelle
Detail drawing
to interface

p. 128 - 129

5AXMCZ100-90-4

- 1x TS160111
- 4x MCZ100L50
- 8x —————
- 1x TB160379

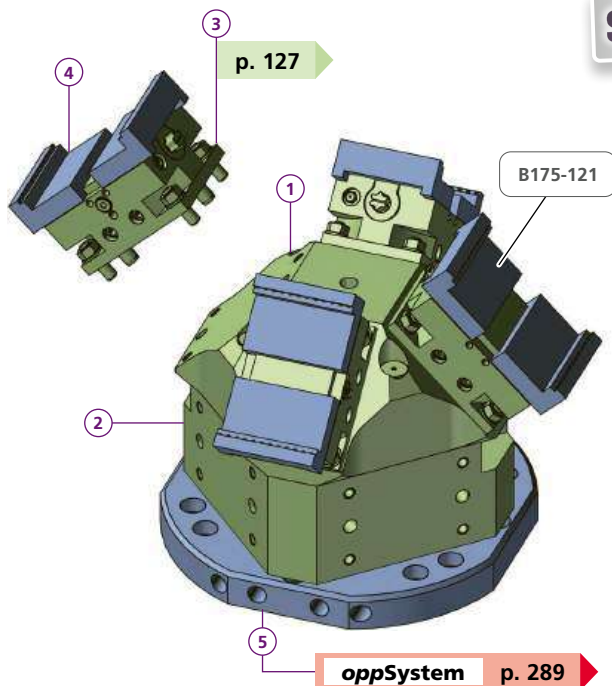
kg ~25,5



Detailzeichnung
zu dieser
Schnittstelle
Detail drawing
to interface

p. 128 - 129

SPACEGRIP II



5AXMCZ100-45-4H

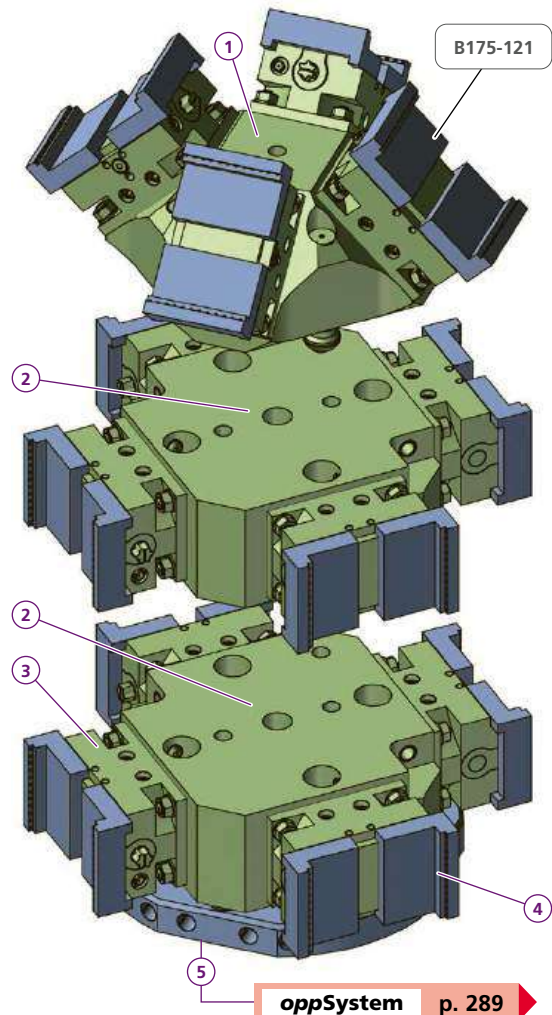
- 1 1x TS160110
- 2 1x TS160111
- 3 4x MCZ100L50
- 4 8x —
- 5 1x TB160379



Detailzeichnung
zu dieser
Schnittstelle
Detail drawing
to interface

p. 128 - 129

kg ~38,1



5AXMCZ100-45-12

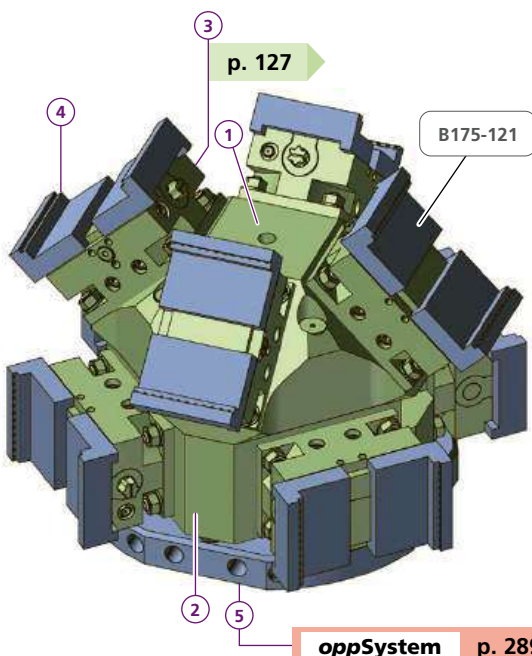
- 1 2x TS160110
- 2 1x TS160111
- 3 12x MCZ100L50
- 4 24x —
- 5 1x TB160379



Detailzeichnung
zu dieser
Schnittstelle
Detail drawing
to interface

p. 128 - 129

kg ~73,8



5AXMCZ100-45-8

- 1 1x TS160110
- 2 1x TS160111
- 3 8x MCZ100L50
- 4 16x —
- 5 1x TB160379



Detailzeichnung
zu dieser
Schnittstelle
Detail drawing
to interface

p. 128 - 129

kg ~48,3

Bestellbeispiel / Ordering example: 1 x 5AXMCZ100-45-8 & 16 x B175-121

SPACEGRIP II-3

Art. Nr.	kg
5AXMCZ100-45-3	~18
5AXMCZ100-45-3H	~35
5AXMCZ100-45-6	~43

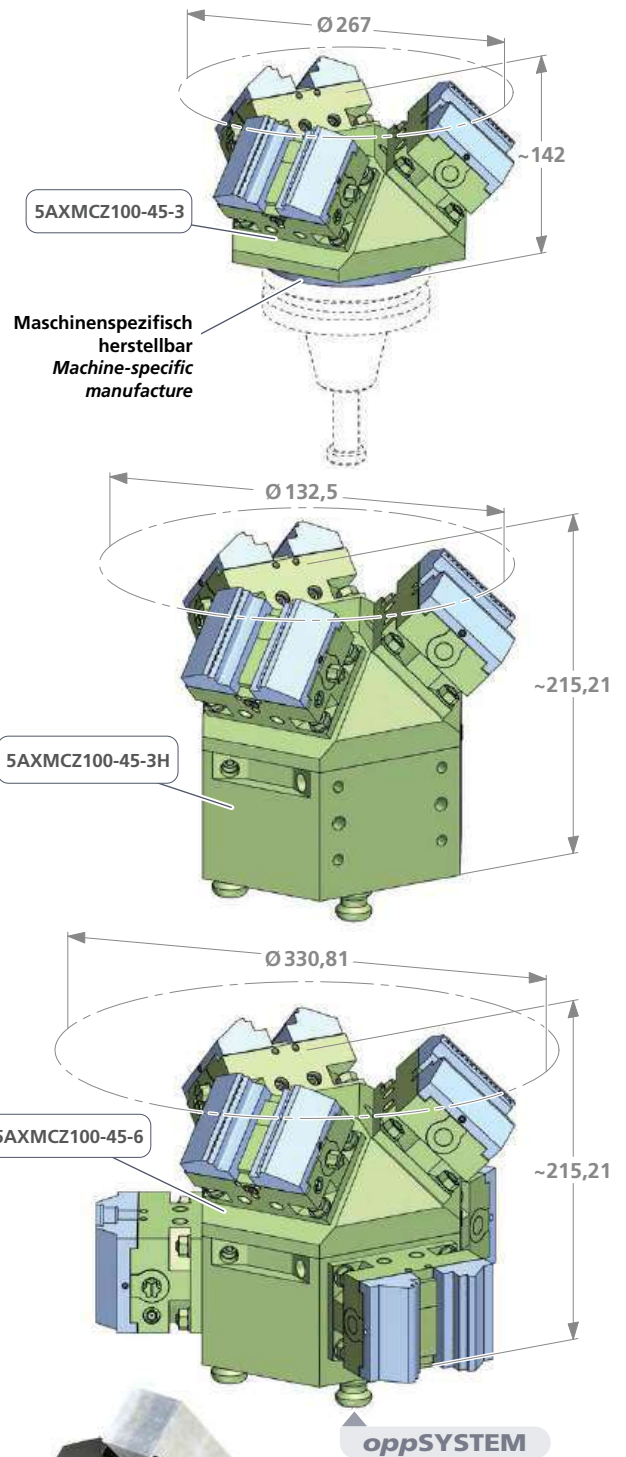


Bei dieser Pyramidenlösung ist die Zugänglichkeit der Spindel beim Bearbeiten von Werkstücken sehr gut.

With this pyramid solution, the accessibility of the spindle is very good when machining workpieces.

Anschlagbrücke
Center stop

p. 130



Durchgehend modular!

Clevere Zentrischspanner passen sich der Maschine, den Werkstücken und den Anforderungen an.

Throughout modular!

Clever self centering vises which adapts to the machine, the workpiece and the requirements.

X

**Spannkrafterhaltung
und Nachfederung**

*Spring loaded
mechanism to maintain
clamping force*

M

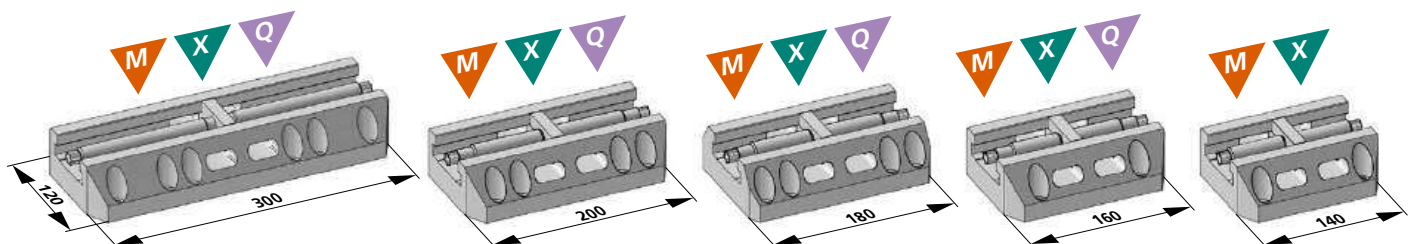
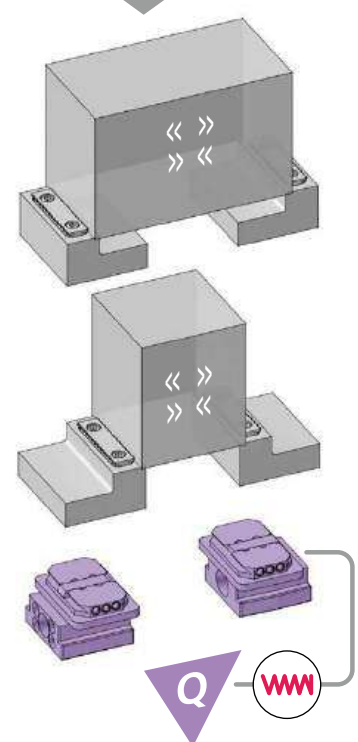
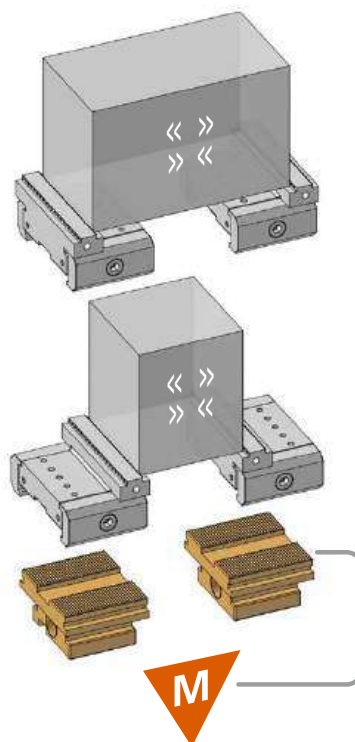
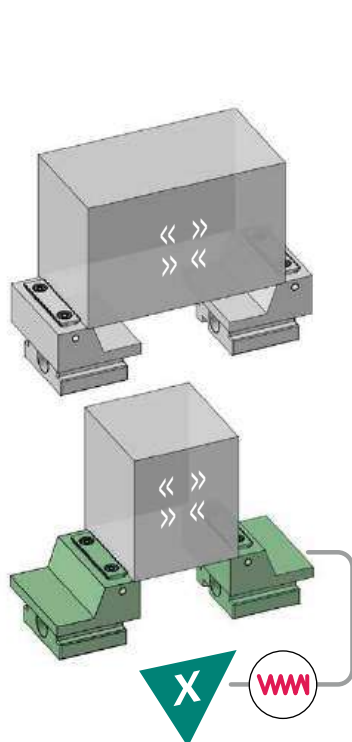
Mehr als **64** verschiedene
Backenvarianten passend
zu dieser Schnellwechsel-
schnittstelle.

*More than **64** different
jaw modules to match this
rapidly changing interface.*

Q

**Schnellwechselbacken
Spannkrafterhaltung
und Nachfederung**

*Quick-change jaws
Spring loaded
mechanism to maintain
clamping force*



Art. Nr.	kg
ZS X 300L50UPRG	~10,65
ZS X 200L50UPRG	~8,8
ZS X 180L50UPRG	~8,1
ZS X 160L50UPRG	~7,7
ZS X 140L50UPRG	~7,1

Art. Nr.	kg
ZS M 300L50UPRG	~10,5
ZS M 200L50UPRG	~7,4
ZS M 180L50UPRG	~6,9
ZS M 160L50UPRG	~6,4
ZS M 140L50UPRG	~5,7

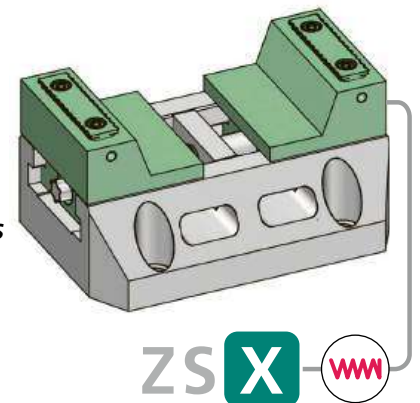
Art. Nr.	kg
ZS Q 300L50UPRG	~11,1
ZS Q 200L50UPRG	~8,1
ZS Q 200L50UPRG	~8,1
ZS Q 180L50UPRG	~7,5
ZS Q 160L50UPRG	~7,0

Zentrischspanner mit Spannkrafterhaltung und Direkt-Prägebacken

- ✓ für die erste Aufspannung mittels Direkt-Prägebacken ab 3 mm
- ✓ Einzigartiges integriertes Federpaket
- ✓ Beste Zugangs-Möglichkeit
- ✓ für OP10 und OP20 ausgelegt
- ✓ Bestens geeignet für 5-Achsen Maschinen mit kleinerem Tisch
- ✓ Bestens geeignet für den Einsatz auf Rundtischen

Self-centering vise with spring loaded mechanism and direct stamping jaws

- ✓ for the first clamping using direct stamping jaws from 3 mm
- ✓ Unique integrated spring package
- ✓ Best access option
- ✓ Designed for OP10 and OP20
- ✓ Ideally suited for 5-axis machines with smaller tables
- ✓ Ideally suited for use on rotary tables

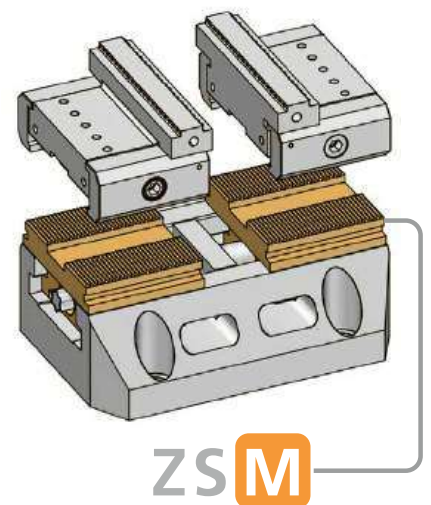


Zentrischspanner für den Einsatz mit Power Clamp Modulen

- ✓ Höchste Modularität, alle Power Clamp Module können eingesetzt werden
- ✓ Schneller Backenwechsel (eine Schraube lösen und Modul nach oben abheben)
- ✓ Backen von 19 bis 150 mm
- ✓ weiche Backen
- ✓ Direktprägebacken und Bearbeitung ab 3 mm

Self-centering vice for use with Power Clamp modules

- ✓ Highest modularity, all Power Clamp modules can be used
- ✓ Quick jaw change (loosen one screw and lift the module up)
- ✓ Jaws from 19 to 150 mm
- ✓ soft jaws
- ✓ Direct stamping jaws, machining from 3 mm

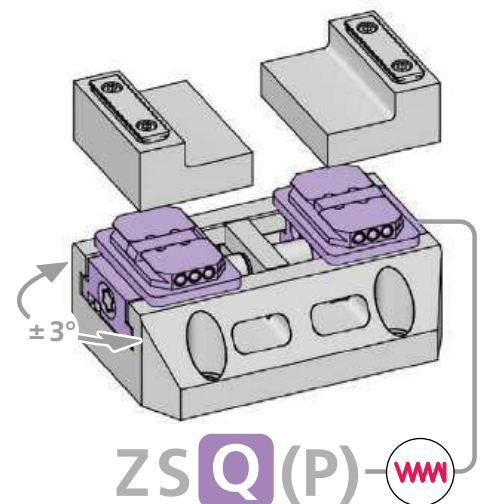


Zentrischspanner für den Einsatz von Schnellwechselbacken

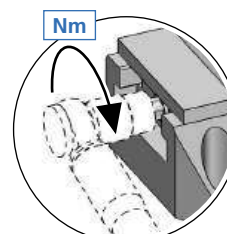
- ✓ Schnellwechselbacken (werden per Hand auf dem Spanner eingeklinkt)
- ✓ Weiche Backen zum selbst bearbeiten
- ✓ Direktprägebacken für OP10
- ✓ Einzigartiges integriertes Federpaket
- ✓ Für Rohteile können pendelnde Schlitten (P) eingesetzt werden

Self-centering vice for the use of quick-change jaws

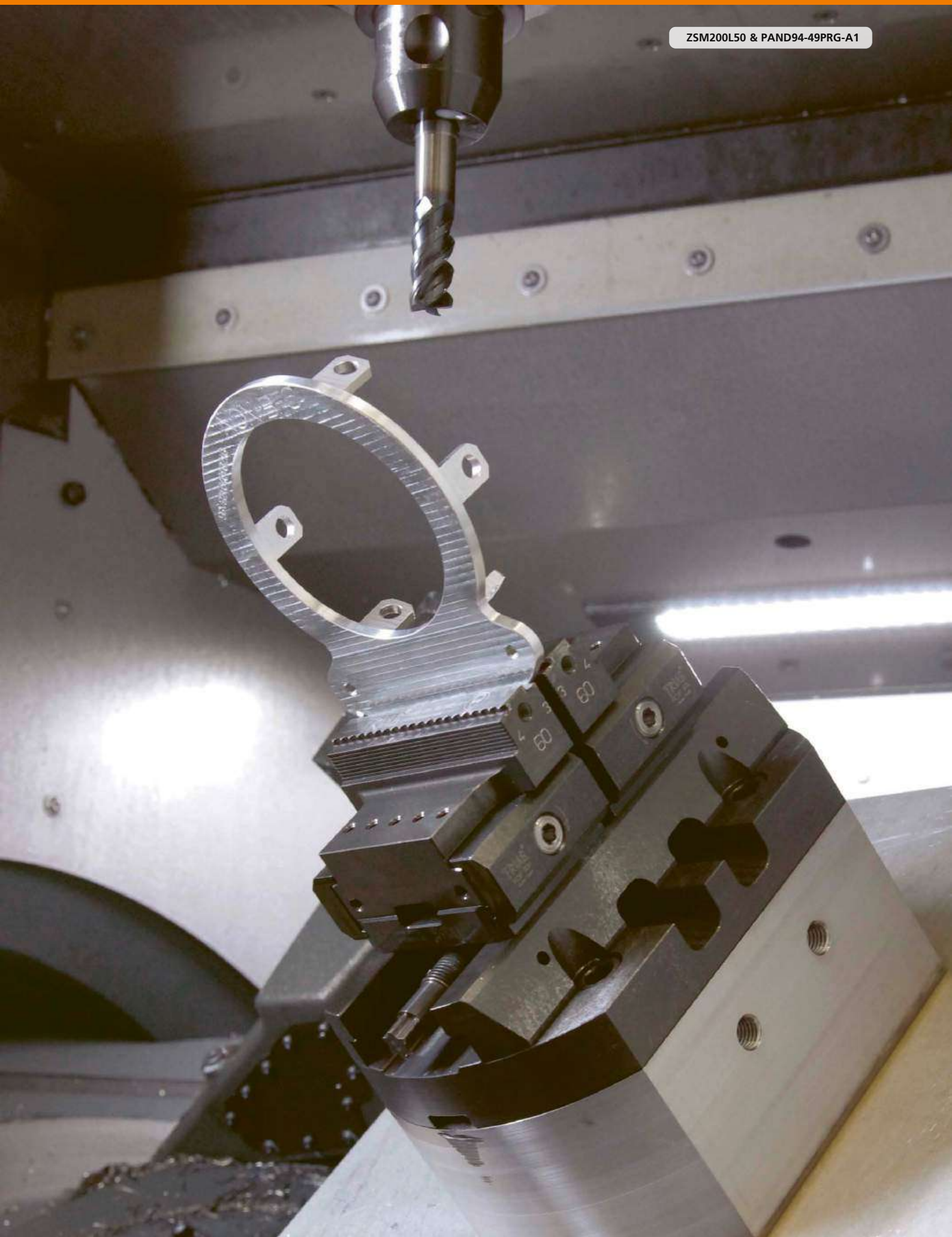
- ✓ Quick-change jaws (clicked on the vise by hand)
- ✓ Soft jaws for individual machining
- ✓ Direct stamping jaws for OP10
- ✓ Unique integrated spring package
- ✓ Pendulum slides (P) can be used for unmachined parts



Drehmoment Torque		Spannkraft Workholding force			Gut zu Wissen Good to know
Nm	(lb-ft)	~daN	~(lb)	~t	
10	7,4	= 200	440	0,2	Diese Spannkraften werden für den Dauerbetrieb empfohlen! These clamping forces are recommended for continuous operation!
20	14,8	= 500	1'102	0,5	
30	22,2	= 1'000	2'204	1,0	
40	29,6	= 1'300	2'866	1,3	
50	37,0	= 1'600	3'527	1,6	
60	44,4	= 1'800	3'968	1,8	Für kurzfristige Anwendung For short-term application
70	51,8	= 2'100	4'629	2,1	



ZSM200L50 & PAND94-49PRG-A1



Direkt-Prägebacken

Bei knapp gespannten Werkstücken, speziell in weichen Materialien, wie Alu und Rostfrei aber auch in praktisch allen anderen Materialien, besteht das Problem, dass sich die Werkstücke freiwiegeln! Dies vor allem bei weit auskragenden Werkstücken bei der 5-Achsen Bearbeitung, selbst wenn vorgeprägt wird.

Triag International hat deshalb einen nachfedernden Zentrisch Spannstock entwickelt, welcher ein Freiwiegeln der Werkstücke mittels Nachfederung verhindert.

Bei diesem patentiertem System wird mittels Tellerfedern eine Backe des Zentrischspannstockes nachgeschoben. So wird der Spanndruck aufrechterhalten. Die Einspanntiefe ist im Normalfall 3 mm, kann aber verstellt werden von ca. 1,8 bis 6 mm. Das Werkstück kann sich so praktisch nicht freiwiegeln.

Das heisst, man hat durchwegs die gleichen Bedingungen und das Werkstück hat während der Bearbeitung weniger Vibrationen und bewegt sich nicht. Oberfläche und Genauigkeit verbessern sich und sind konstanter.

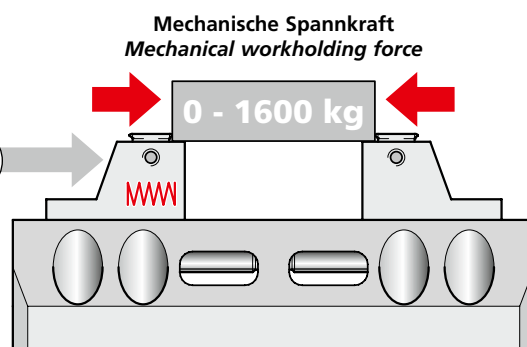
Direct spring loaded stamping jaws

This patented self centering vise is unique, as it can be used for direct stamping the blanks. It is different to others as the teeth bite into the raw material and even under vibrations, one of the two jaws will continuously move forward. This will hold the workpiece with the same force and strength as in the beginning.

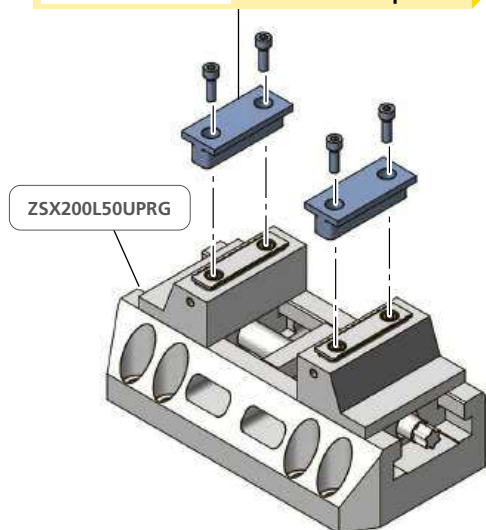
The problem in the past was that the other systems in the market were getting loose during heavy machining and accuracy was difficult to achieve.

Especially in soft materials such as alu and soft steels it has a great performance. Usually the workpiece is clamped only 3 mm but this hight can be changed from 1,8 to 6 mm if necessary.

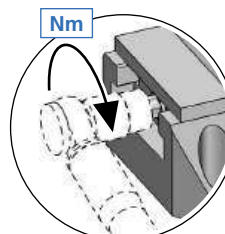
Spannkrafterhaltung und Nachfederung
Spring loaded mechanism to maintain clamping force

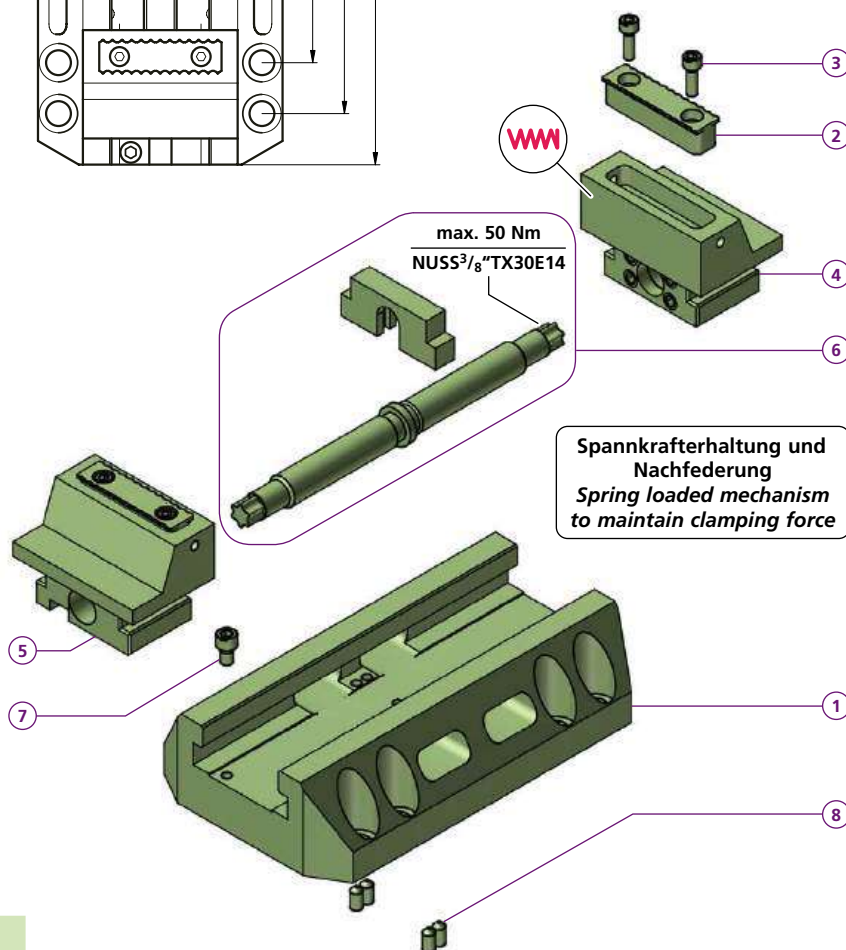
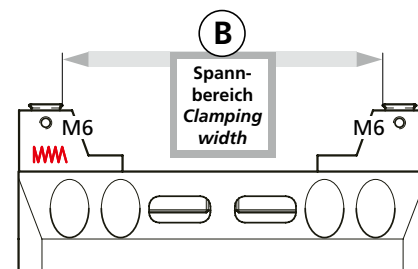
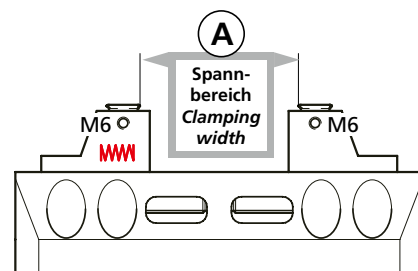
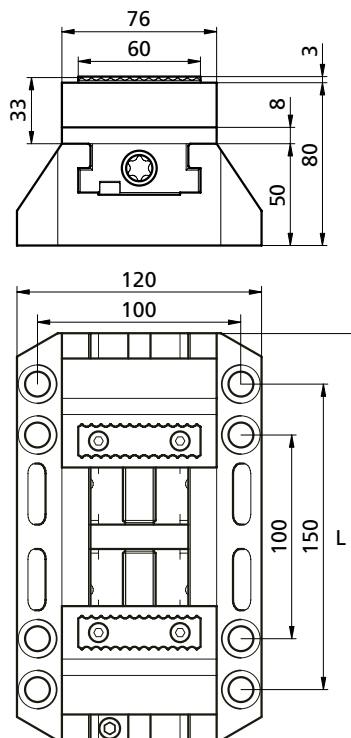
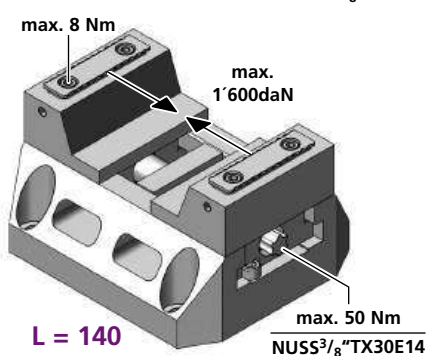
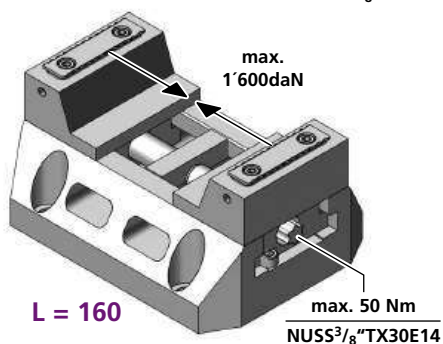
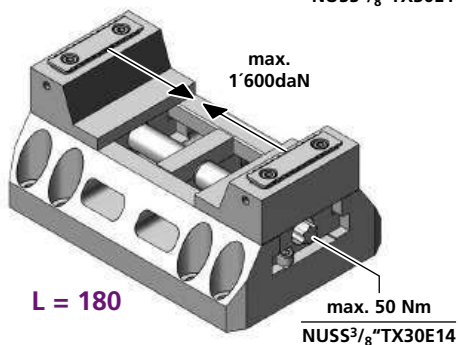
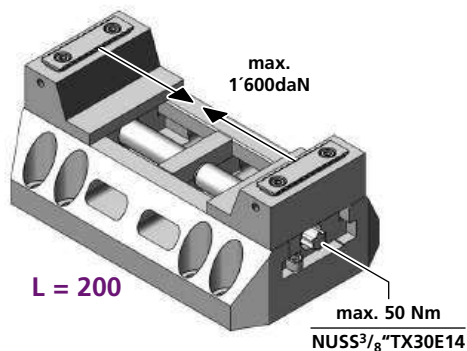


MANF58-14W25 microCLAMP p. 176



Drehmoment Torque		Spannkraft Workholding force			Gut zu Wissen Good to know
Nm	(lb-ft)	~daN	~(lb)	~t	
10	7,4	= 200	440	0,2	Diese Spannkräfte werden für den Dauerbetrieb empfohlen! These clamping forces are recommended for continuous operation!
20	14,8	= 500	1'102	0,5	
30	22,2	= 1'000	2'204	1,0	
40	29,6	= 1'300	2'866	1,3	
50	37,0	= 1'600	3'527	1,6	
60	44,4	= 1'800	3'968	1,8	Für kurzfristige Anwendung For short-term application
70	51,8	= 2'100	4'629	2,1	





ZSX200L50UPRG	
1	1x TK150025
2	2x MAND58-14PRG
3	4x M5X16ISO4762
4	1x ZB150787
5	1x ZB150786
6	1x PCS16TR200SET
7	1x M6X10ISO4762
8	4x M6X12DIN914
L = 200	
A	10 – 124 mm
B	62 – 178 mm
kg	~8,8

ZSX180L50UPRG	
1	1x TK150523
6	1x PCS16TR180SET
L = 180	
A	10 – 104 mm
B	62 – 158 mm
kg	~8,1
ZSX160L50UPRG	
1	1x TK150522
6	1x PCS16TR160SET
L = 160	
A	10 – 84 mm
B	62 – 138 mm
kg	~7,7

ZSX140L50UPRG	
1	1x TK150521
6	1x PCS16TR140SET
L = 140	
A	10 – 64 mm
B	62 – 118 mm
kg	~7,1

Drehmoment und Spannkraft siehe Seite
Torque and clamping force see page

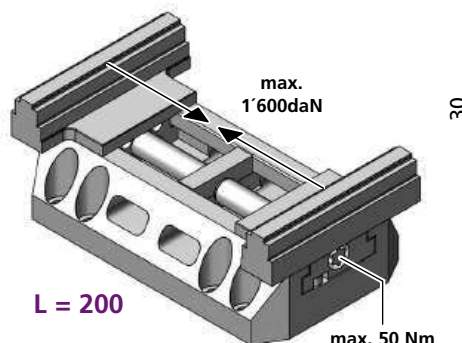
140

NUSS3/8"TX30E14

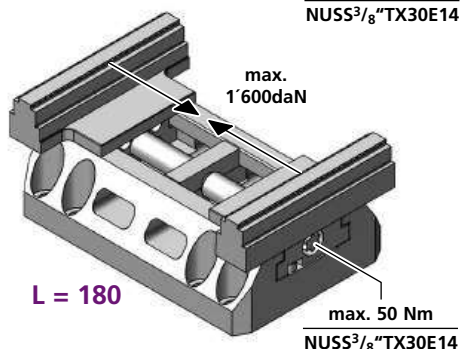
WICHTIG!
Bitte separat bestellen

IMPORTANT!
Please order separately

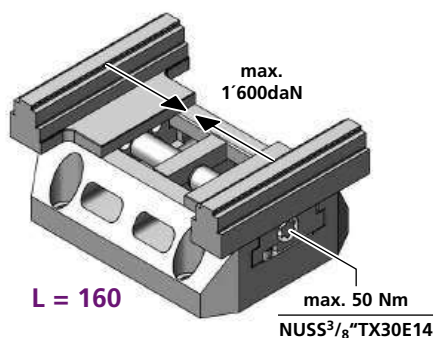
Bestellbeispiel / Ordering example:
3 x ZSX200L50UPRG & 1 x NUSS3/8"TX30E14



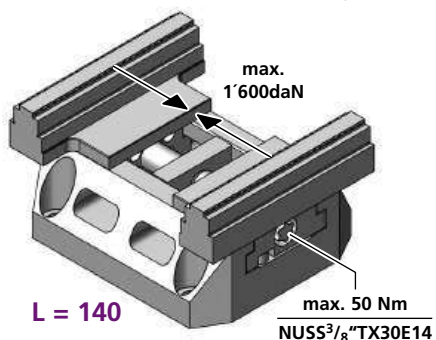
L = 200



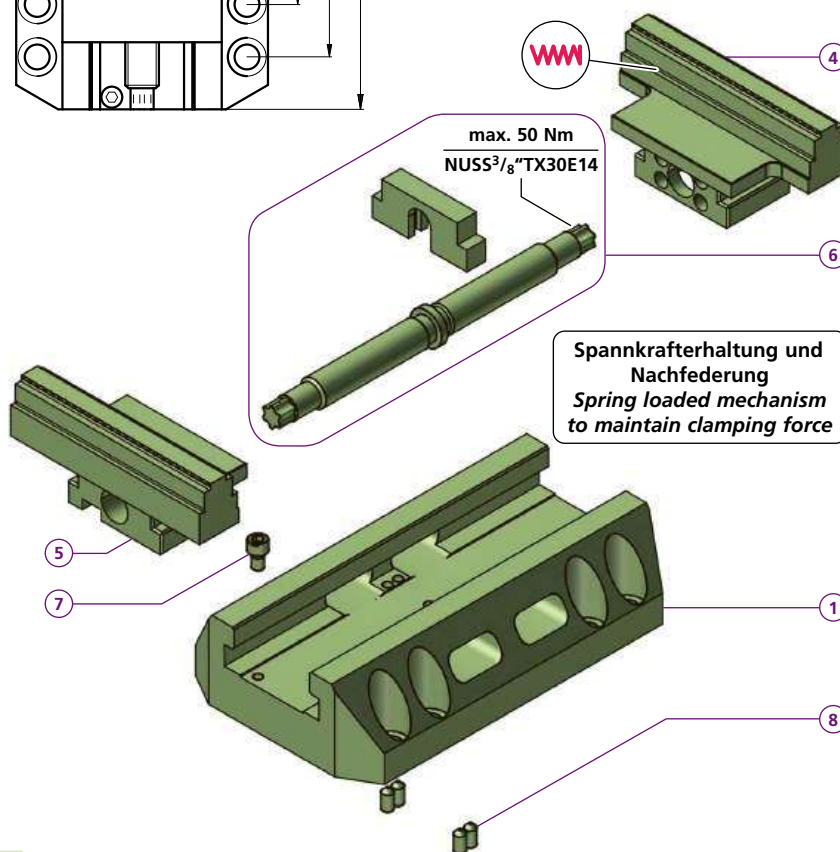
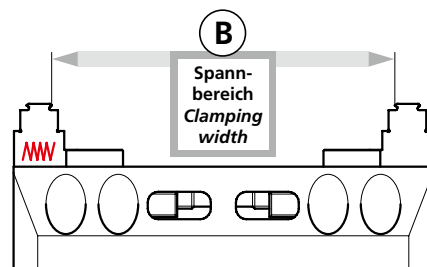
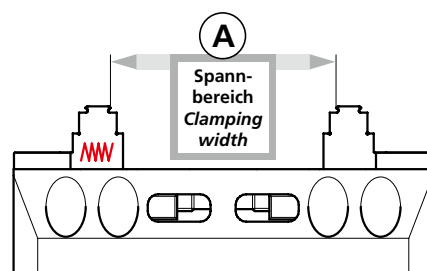
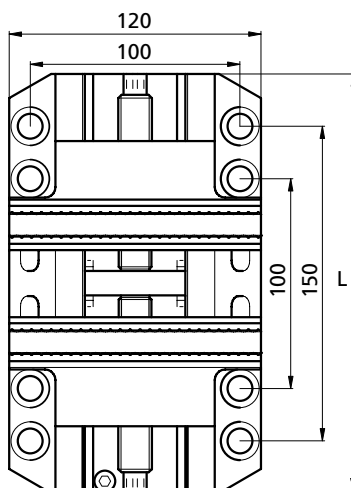
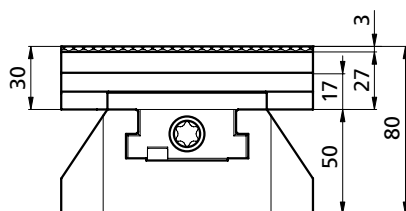
L = 180



L = 160



L = 140



ZSX200L50PRG120

- 1 1x TK150025
- 4 1x ZB170050
- 5 1x TB170051
- 6 1x PCS16TR200SET
- 7 1x M6X10ISO4762
- 8 4x M6X12DIN914
- L = 200

(A) 14 – 130 mm

(B) 70 – 186 mm

kg ~7,7

ZSX180L50PRG120

- 1 1x TK150523
- 6 1x PCS16TR180SET
- L = 180
- (A) 14 – 110 mm
- (B) 70 – 166 mm

kg ~7,2

ZSX160L50PRG120

- 1 1x TK150522
- 6 1x PCS16TR160SET
- L = 160
- (A) 14 – 90 mm
- (B) 70 – 146 mm

kg ~6,6

ZSX140L50PRG120

- 1 1x TK150521
- 6 1x PCS16TR140SET
- L = 140
- (A) 14 – 70 mm
- (B) 70 – 126 mm

kg ~6,0

Drehmoment und Spannkraft siehe Seite
Torque and clamping force see page

140

NUSS3/8"TX30E14

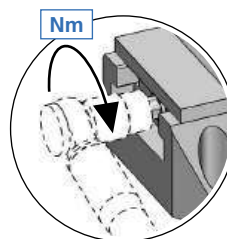
WICHTIG!
Bitte separat bestellen

IMPORTANT!
Please order separately


Bestellbeispiel / Ordering example:

3 x ZSX200L50PRG120 & 1 x NUSS3/8"TX30E14

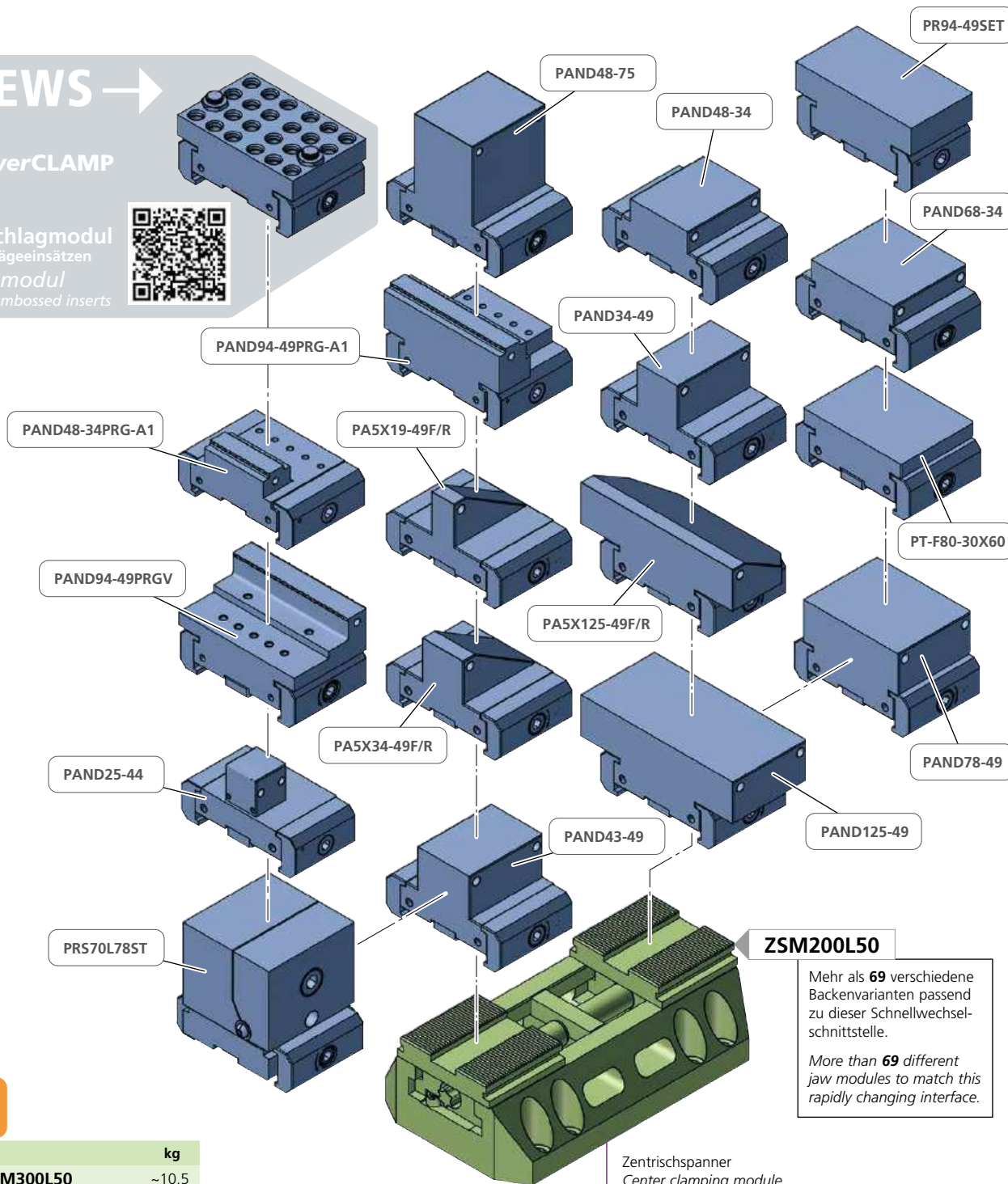
Drehmoment Torque		Spannkraft Workholding force			Gut zu Wissen Good to know
Nm	(lb-ft)	~daN	~(lb)	~t	
10	7,4	= 200	440	0,2	Diese Spannkraften werden für den Dauerbetrieb empfohlen! <i>These clamping forces are recommended for continuous operation!</i>
20	14,8	= 500	1'102	0,5	
30	22,2	= 1'000	2'204	1,0	
40	29,6	= 1'300	2'866	1,3	
50	37,0	= 1'600	3'527	1,6	
60	44,4	= 1'800	3'968	1,8	Für kurzfristige Anwendung <i>For short-term application</i>
70	51,8	= 2'100	4'629	2,1	



NEWS →

PowerCLAMP

Anschlagmodul
mit Prägeeinsätzen
End modul
with embossed inserts



ZSM200L50

Mehr als **69** verschiedene Backenvarianten passend zu dieser Schnellwechsel-schnittstelle.

More than **69** different jaw modules to match this rapidly changing interface.

Zentrischspanner
Center clamping module



	kg
1 ZSM300L50	~10,5
1 ZSM200L50	~7,4
ZSM180L50	~6,9
ZSM160L50	~6,4
ZSM140L50	~5,7
2x	

powerCLAMP p. 86 - 96

Bestellbeispiel / Ordering example: 1 x **ZSM200L50** & 2 x **PAND94-49PRG-A1**

Zentrischspanner mit powerCLAMP Schnittstelle Self centering vise with powerCLAMP interface

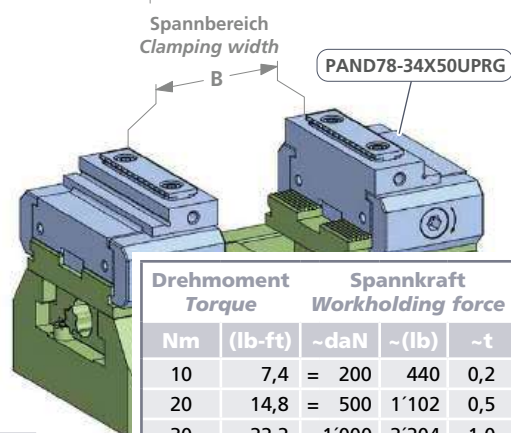
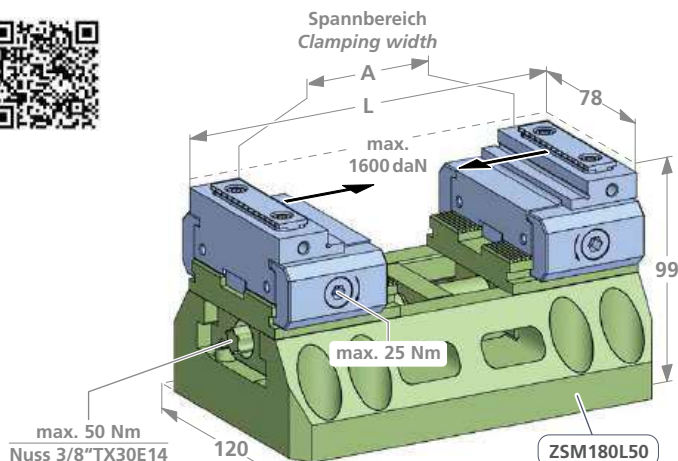
Art. Nr.	A	B	kg	L
ZSM140L50	60 – 120 mm	10 – 68 mm	~5,7	140
ZSM160L50	60 – 140 mm	10 – 88 mm	~6,4	160
ZSM180L50	60 – 160 mm	10 – 108 mm	~6,9	180
ZSM200L50	60 – 180 mm	10 – 128 mm	~7,4	200
ZSM300L50	60 – 280 mm	10 – 228 mm	~10,5	300



Werkstückauflage
Workpiece supports

PAND94-34PRGV

ZSM300L50



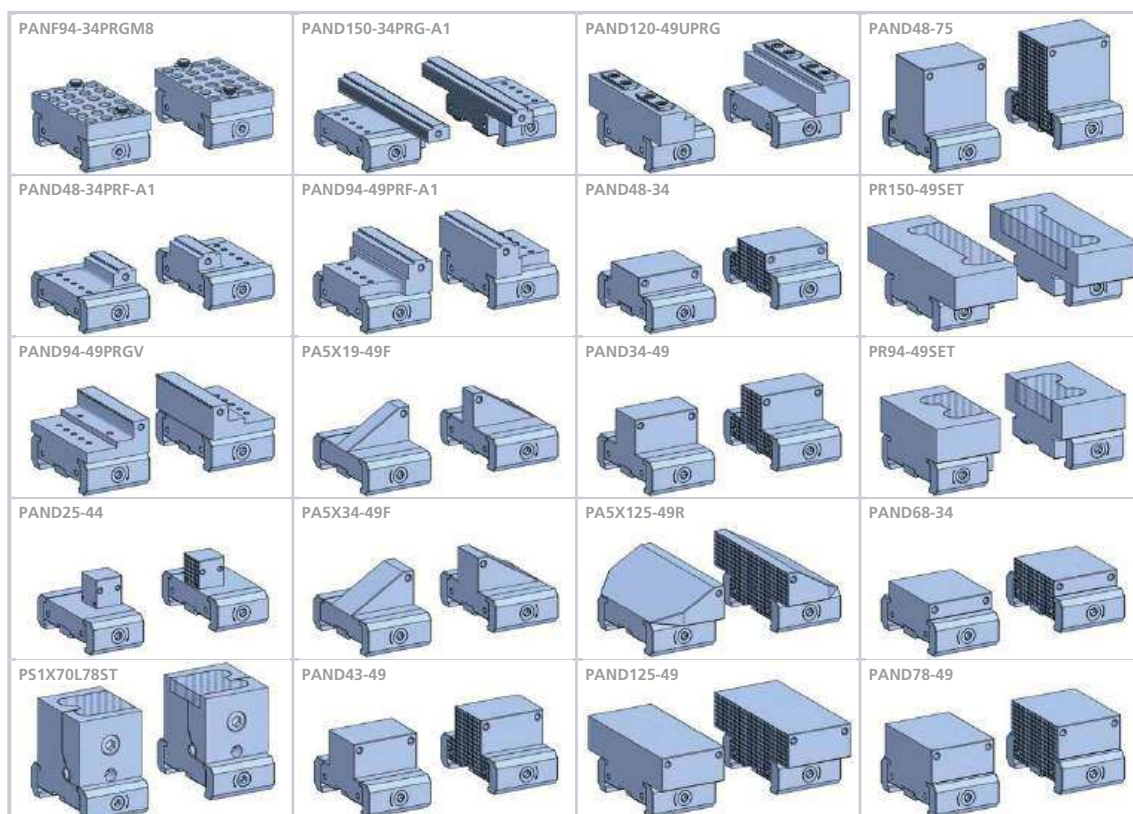
Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
10	7,4	= 200	440	0,2
20	14,8	= 500	1'102	0,5
30	22,2	= 1'000	2'204	1,0
40	29,6	= 1'300	2'866	1,3
50	37,0	= 1'600	3'527	1,6

Mehr als 60 verschiedene Backenvarianten
passend zu dieser Schnellwechselschnittstelle.

More than 60 different jaw modules
to match this rapidly changing interface.

NUSS3/8"TX30E14

WICHTIG!
Bitte separat bestellen
IMPORTANT!
Please order separately



Seitlich verstellbarer Zentrischspannstock

Passend auf alle Power Clamp Basisschienen können mehrere dieser Zentrischspanner, seitlich aneinander gereiht, lange Werkstücke spannen und sind dabei flexibel in 2 mm Schritten seitlich verschiebbar.

Auch können diese für Mehrfachspannung genutzt werden und mehrere Einzelteile an fixen Punkten gespannt werden.

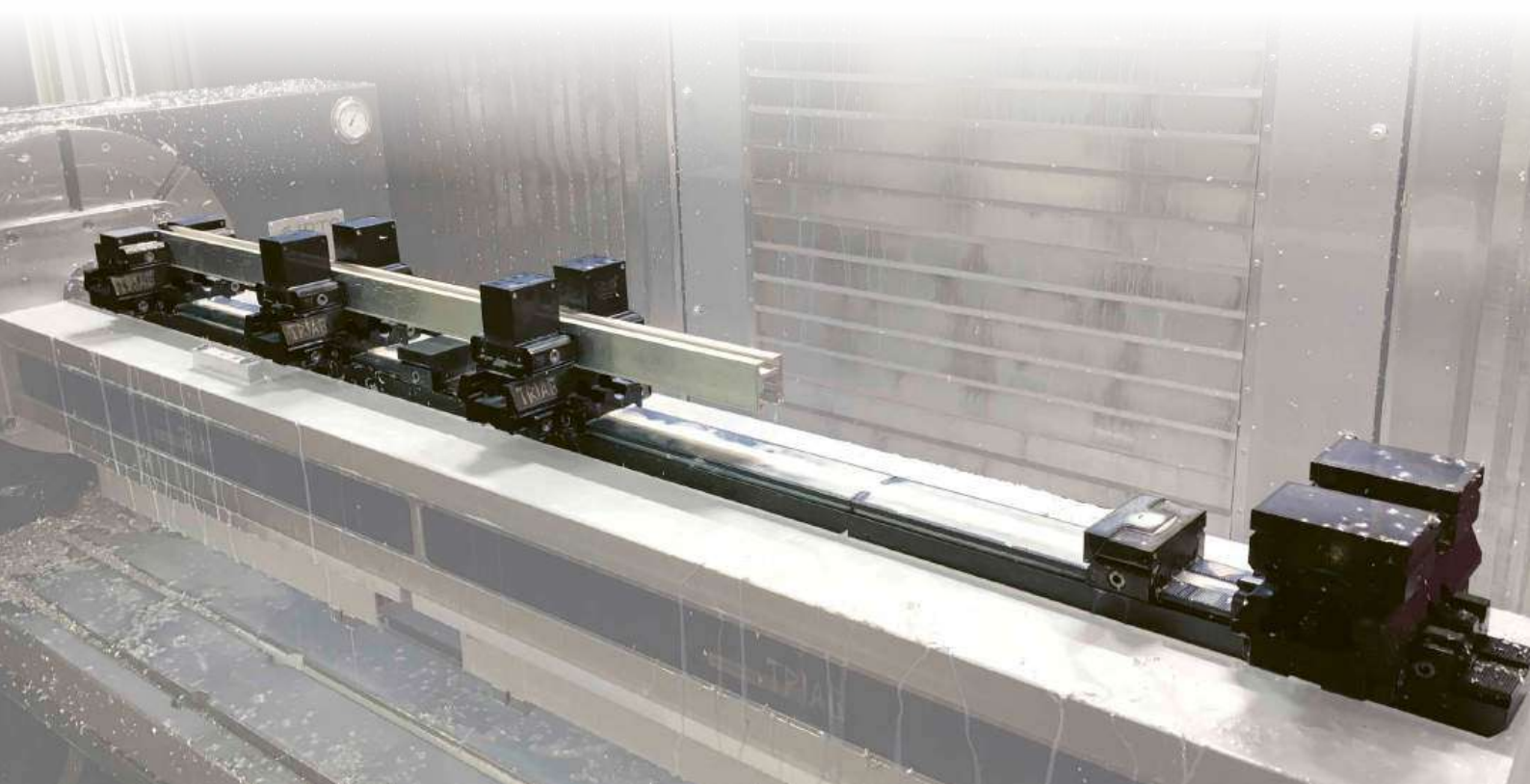
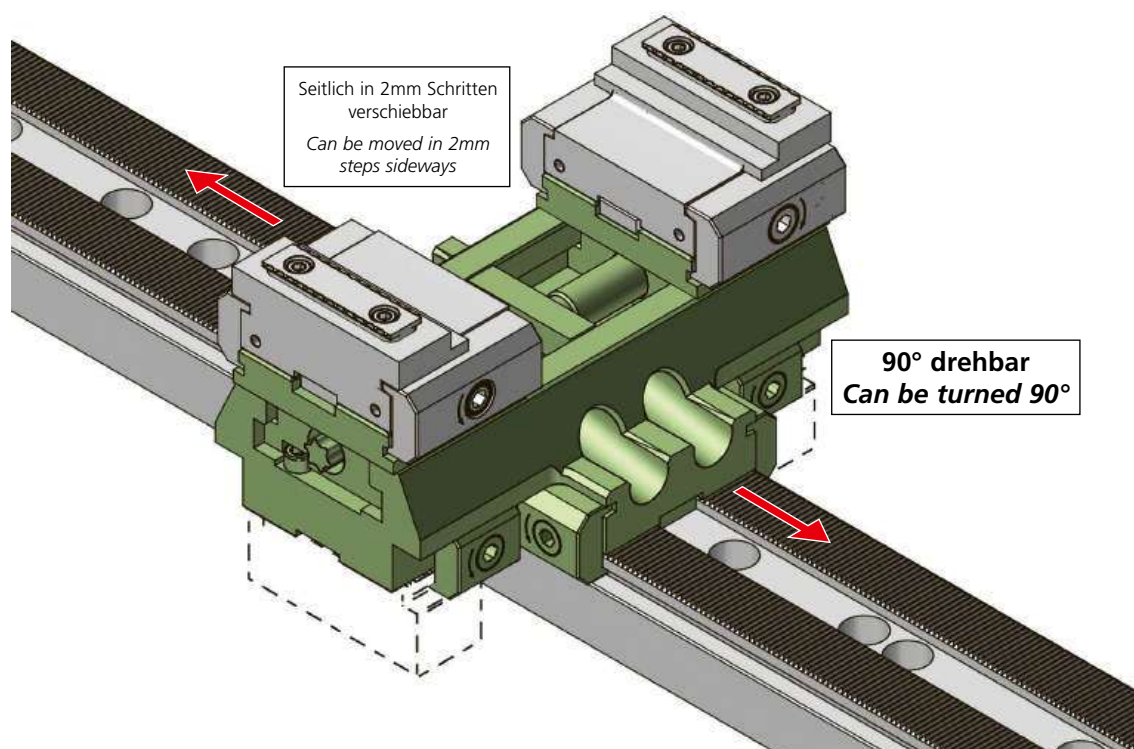
Einsatzgebiet für lange Profile, Stangen und Bleche aber auch Mehrfachspannung von fast allen Materialien.

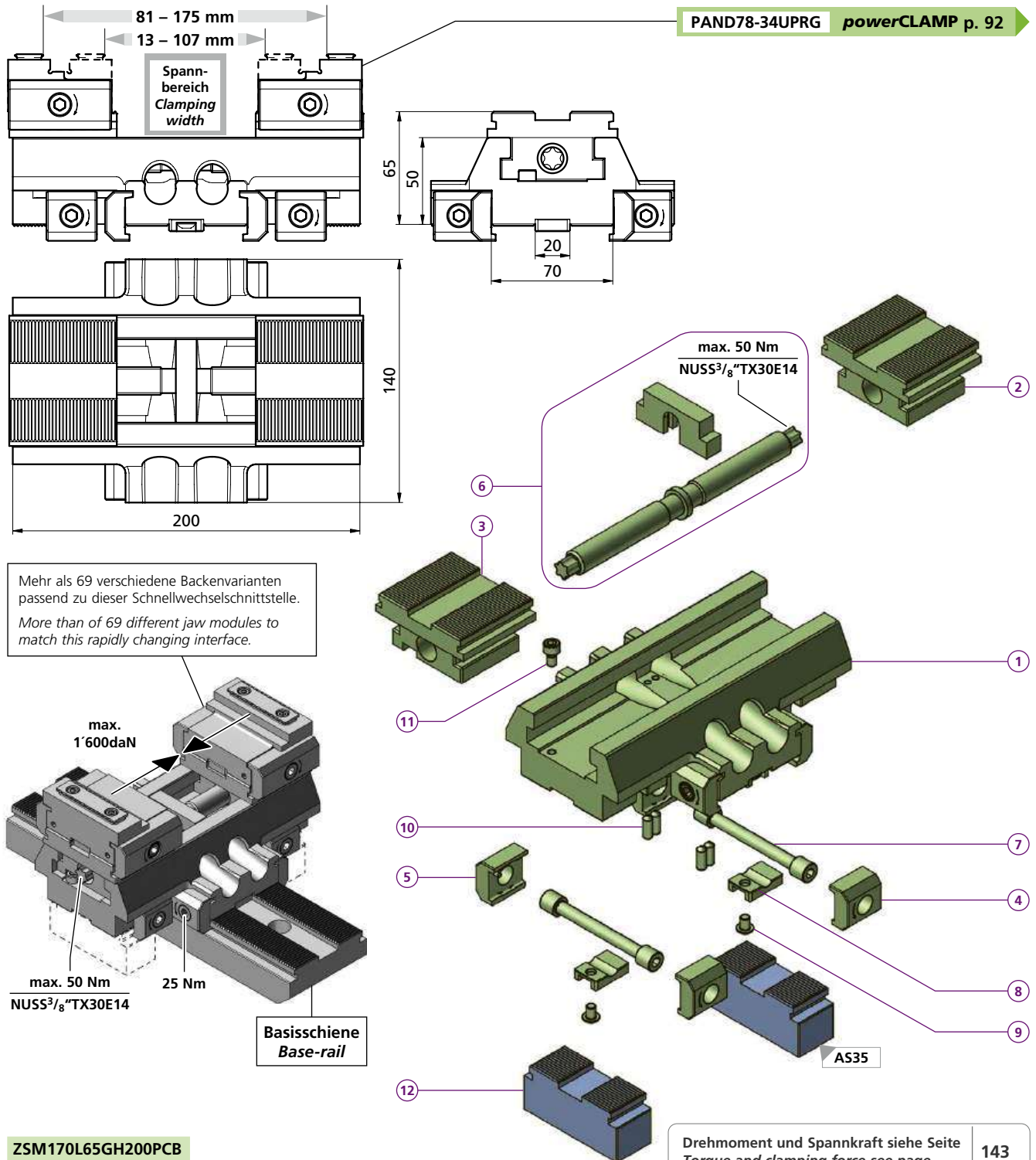
Laterally adjustable centric vice

Fitting all Power Clamp basic rails, several of these self-centering vices can, arranged laterally in rows, clamp long work pieces and can hereby be flexibly shifted sideways in 2 mm steps.

They can also be used for multi clamping and several individual parts clamped at fixed points.

The field of application for long sections, rods and sheets but also multi clamping of almost all materials.



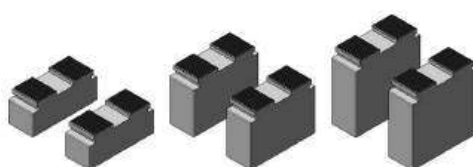

ZSM170L65GH200PCB

- 1x TB140566
- 1x TB150092
- 1x TB150091
- 4x PCSP30L
- 4x PCSP30R
- 1x PCS16TR200SET
- 4x PCS14
- 4x PCGU2030
- 4x M6X8ISO7380
- 4x M6X12DIN914
- 1x M6X10ISO4762
- 2x

kg ~8,6

Schienenhöhe / Rail height

AS35	kg	AS60	kg	AS80	kg
(H = 35)	~0,6	(H = 60)	~1,1	(H = 80)	~1,5


Seitliche Stützen

Bei Gebrauch der Querschienen 90°, werden je nach Höhe der Basisschiene auf dessen sie aufgesetzt sind, zwei seitliche Stützen AS35 / AS60 / AS80 unterlegt.

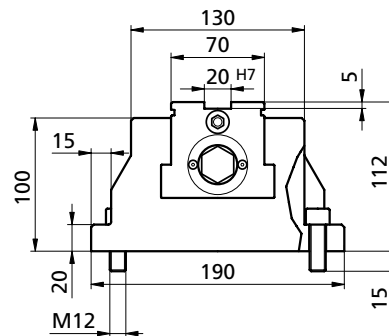
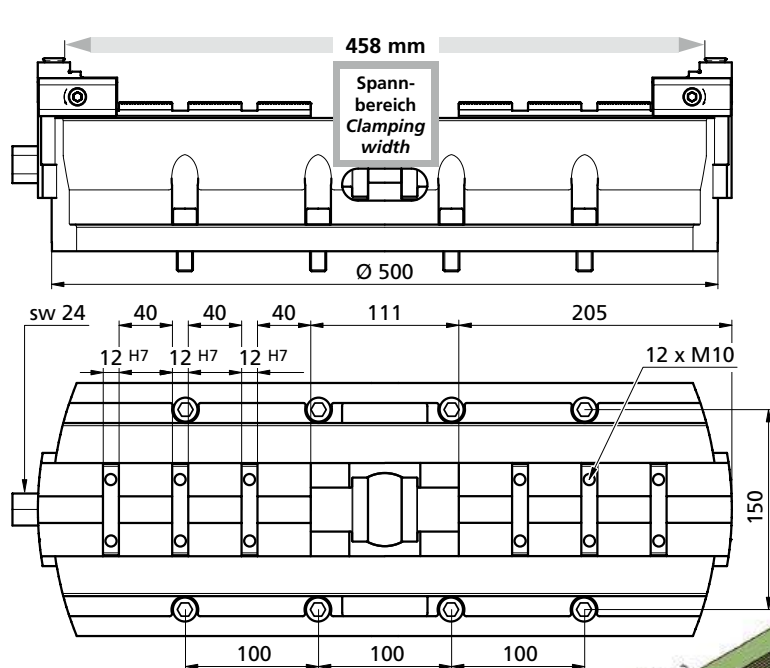
Side support

When using the cross rail 90°, a side support AS35 / AS60 / AS80 is underlaid, depending on the height of the base rail on which it is placed.

NUSS3/8\"TX30E14

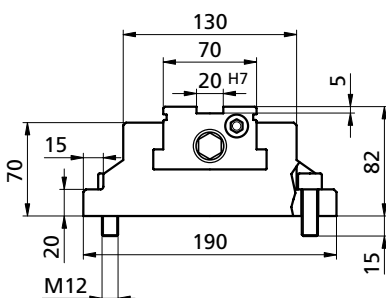
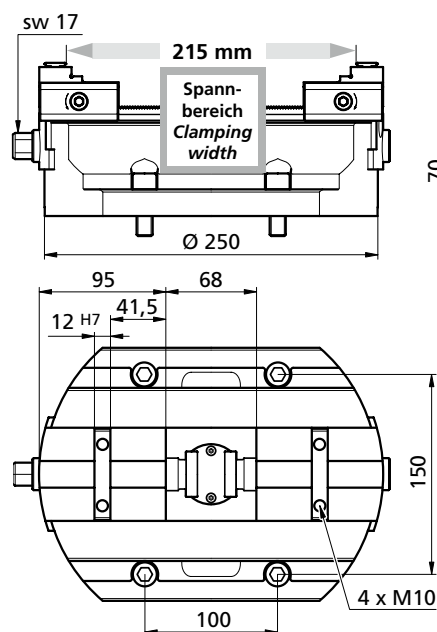
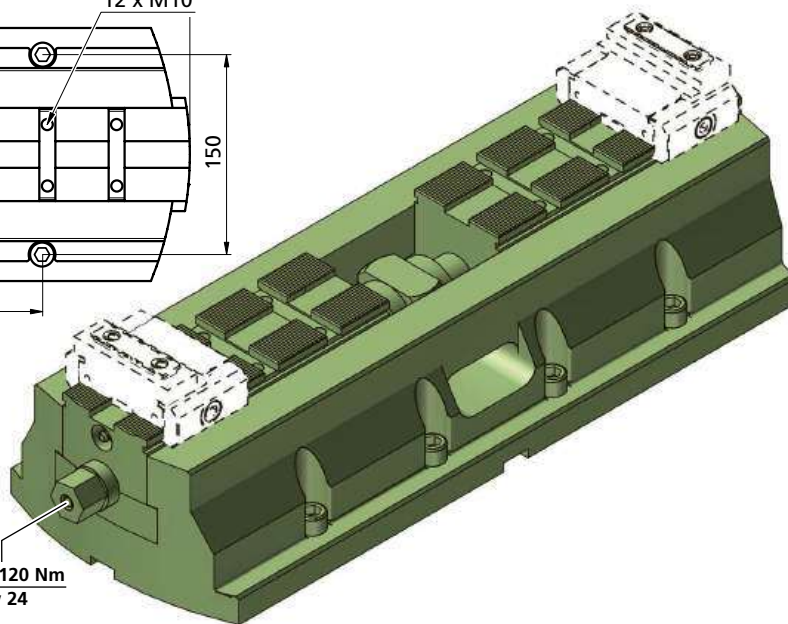
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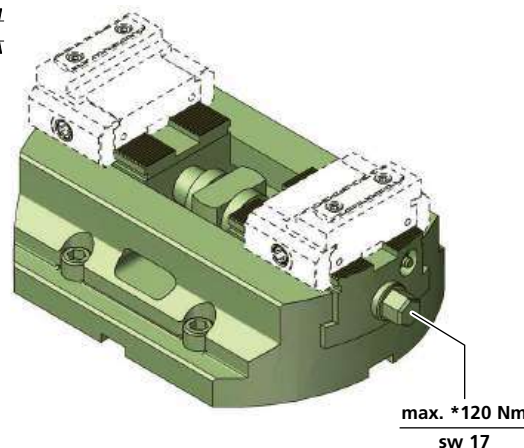


ZSMB500L112 kg = ~59
Backenhub (pro Backe)
Stroke of clamping (each jaw)
55 mm

max. *120 Nm
sw 24



ZSMB250L82 kg = ~19
Backenhub (pro Backe)
Stroke of clamping (each jaw)
35 mm



max. *120 Nm
sw 17

Drehmoment Torque		Spannkraft Workholding force			Gut zu Wissen Good to know
Nm	(lb-ft)	~daN	~(lb)	~t	
40	29,5	= 800	1798	0,8	Diese Spannkraften werden für den Dauerbetrieb empfohlen! These clamping forces are recommended for continuous operation!
60	44,26	= 1200	2697	1,2	
80	59	= 1600	3597	1,6	
100	73,75	= 2000	4496	2	
*120	88,5	= 2400	5395	2,4	Für kurzfristige Anwendung For short-term application

! Für längerfristige Anwendung ab 140 – 250 Nm müssen **geschraubte Backen** eingesetzt werden!
For longer-term use from 140 – 250 Nm the **screwed jaws** must be used!

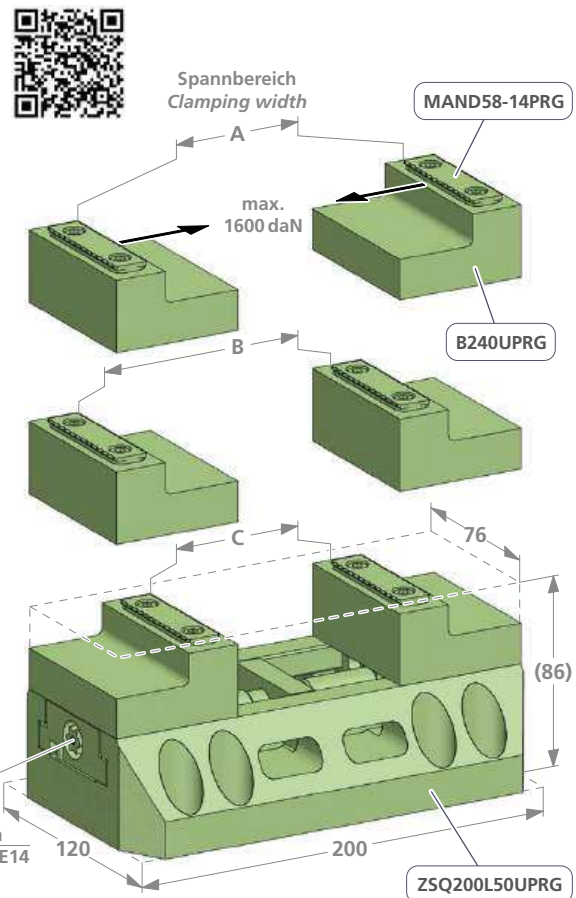
Bestellbeispiel / Ordering example : ZSMB500L112

Zentrischspanner mit Schnellwechselbacken

Self centering vise with quick-change jaws

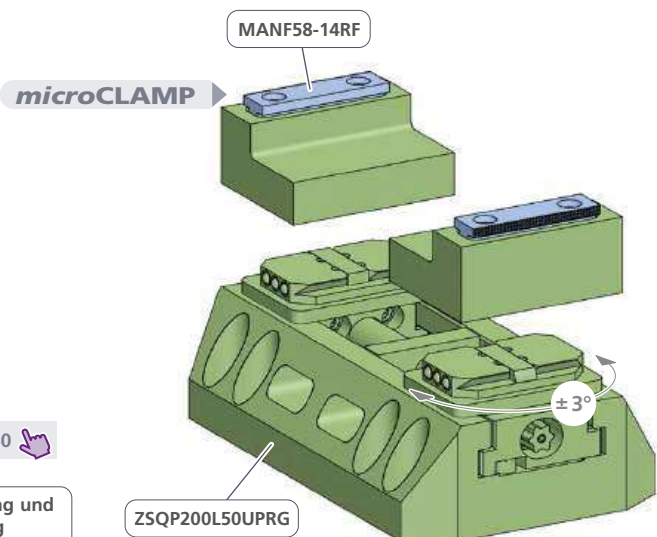
Zentrischspanner mit Spannkrafterhaltung und Nachfederung
Self centering vise with spring loaded mechanism to maintain clamping force

Art. Nr.	www	A mm	B mm	C mm		kg
ZSQ300L50UPRG		80 – 260		8 – 188		~11,10
ZSQP300L50UPRG		80 – 260		8 – 188	± 3°	~11,10
ZSQ200L50UPRG		80 – 160	44 – 124	8 – 88		~8,1
ZSQP200L50UPRG		80 – 160	44 – 124	8 – 88	± 3°	~8,1
ZSQ180L50UPRG		80 – 140	44 – 104	8 – 68		~7,55
ZSQP180L50UPRG		80 – 140	44 – 104	8 – 68	± 3°	~7,5
ZSQ160L50UPRG		80 – 120	44 – 84	8 – 48		~7,1
ZSQP160L50UPRG		80 – 120	44 – 84	8 – 48	± 3°	~7,0



Für die Montage der Backen B240UPRG wird kein Werkzeug benötigt, diese werden per Hand auf dem Spanner eingeklinkt.

No tools are required for mounting the B240UPRG jaws, which are clipped onto the clamp by hand.



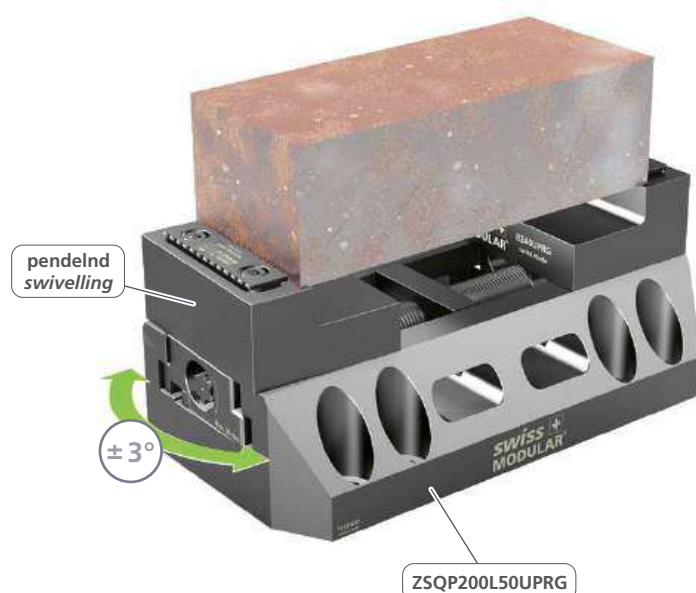
Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
10	7,4	= 200	440	0,2
20	14,8	= 500	1'102	0,5
30	22,2	= 1'000	2'204	1,0
40	29,6	= 1'300	2'866	1,3
50	37,0	= 1'600	3'527	1,6

NUSS3/8"TX30E14

WICHTIG!
Bitte separat bestellen
IMPORTANT!
Please order separately



Zentrischspanner mit Schnellwechselbacken Self centering vise with quick-change jaws



Mit diesen
Zentrischspannern
sind Ihre Werkstücke
in festem Griff.
With these self
centering vises your
workpieces are in
a firm grip.



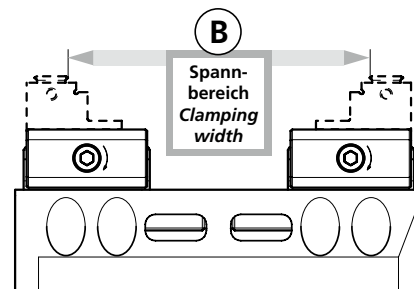
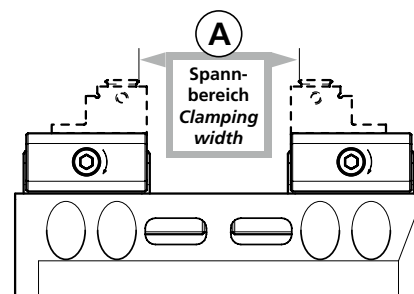
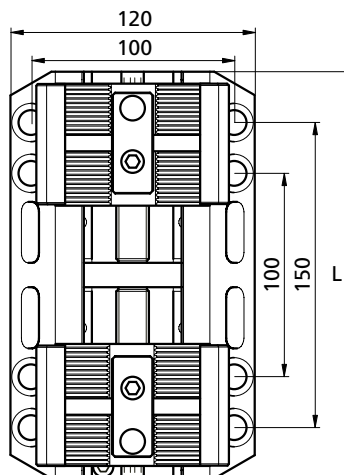
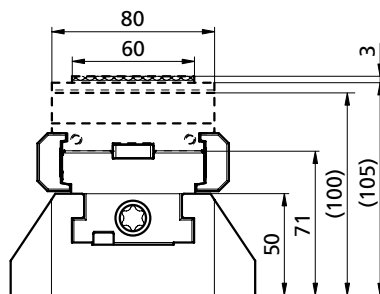
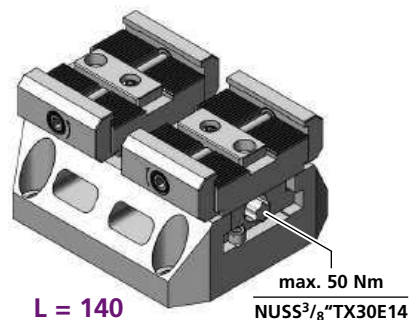
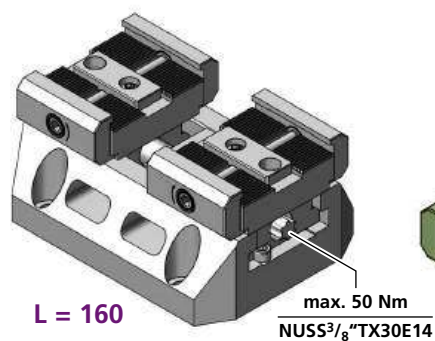
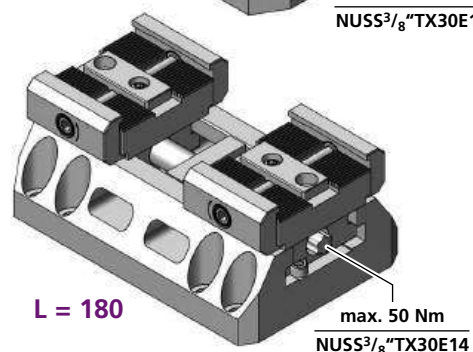
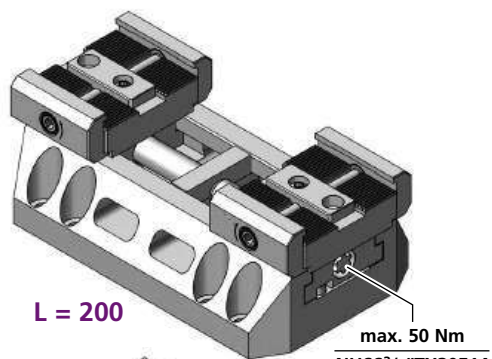
Spannbacke / Clamping jaw

Art. Nr.	B242W50-100	B240UPRG
	Vergütungsstahl Tempering steel (1.7225)	57HRC
kg	~2	~0,52

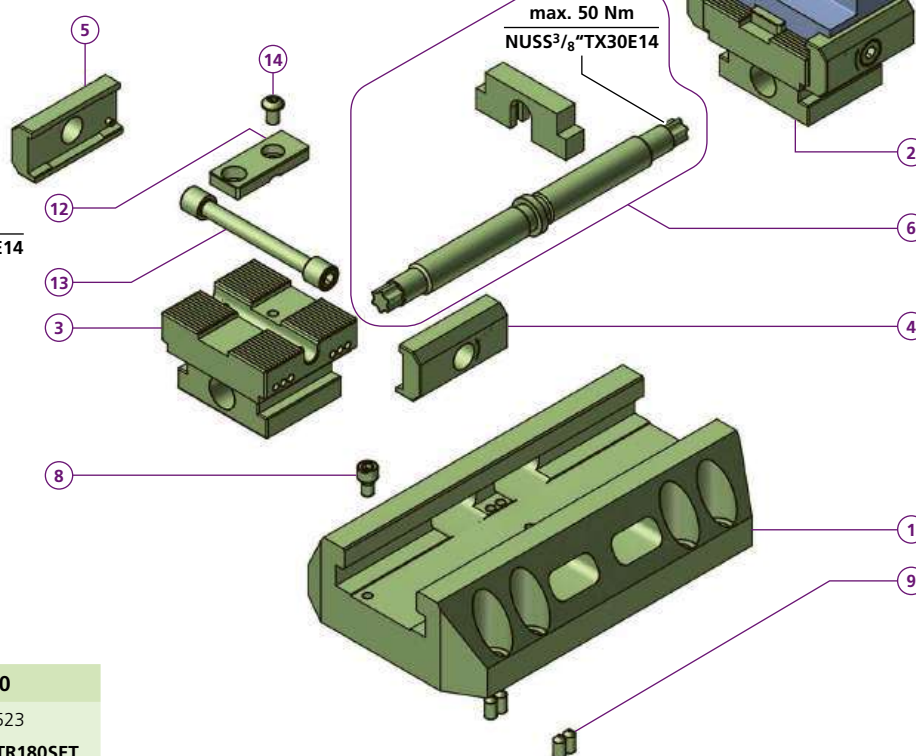
Weich, zur Herstellung individueller Formbacke. / Soft, for the production of individual moulding jaw.



SEPARAT BESTELLEN
ORDER SEPARATELY



PCZB8050UPRG p. 152


ZSB200L50

1	1x TK150025
2	1x ZB150791
3	1x ZB150792
4	2x PCSP60RG
5	2x PCSP60LG
6	1x PCS16TR200SET
8	1x M6X10ISO4762
9	4x M6X16DIN914
12	2x PCGU2049
13	2x PCS14
14	2x M6X8ISO7380
L	= 200
A	10 – 126 mm
B	58 – 174 mm
kg	~8,4

ZSB180L50

1	1x TK150523
6	1x PCS16TR180SET
L	= 180
A	10 – 104 mm
B	58 – 154 mm
kg	~7,9

ZSB160L50

1	1x TK150522
6	1x PCS16TR160SET
L	= 160
A	10 – 86 mm
B	58 – 134 mm
kg	~7,4

ZSB140L50

1	1x TK150521
6	1x PCS16TR140SET
L	= 140
A	10 – 65 mm
B	58 – 113 mm
kg	~6,7

Drehmoment und Spannkraft siehe Seite
Torque and clamping force see page

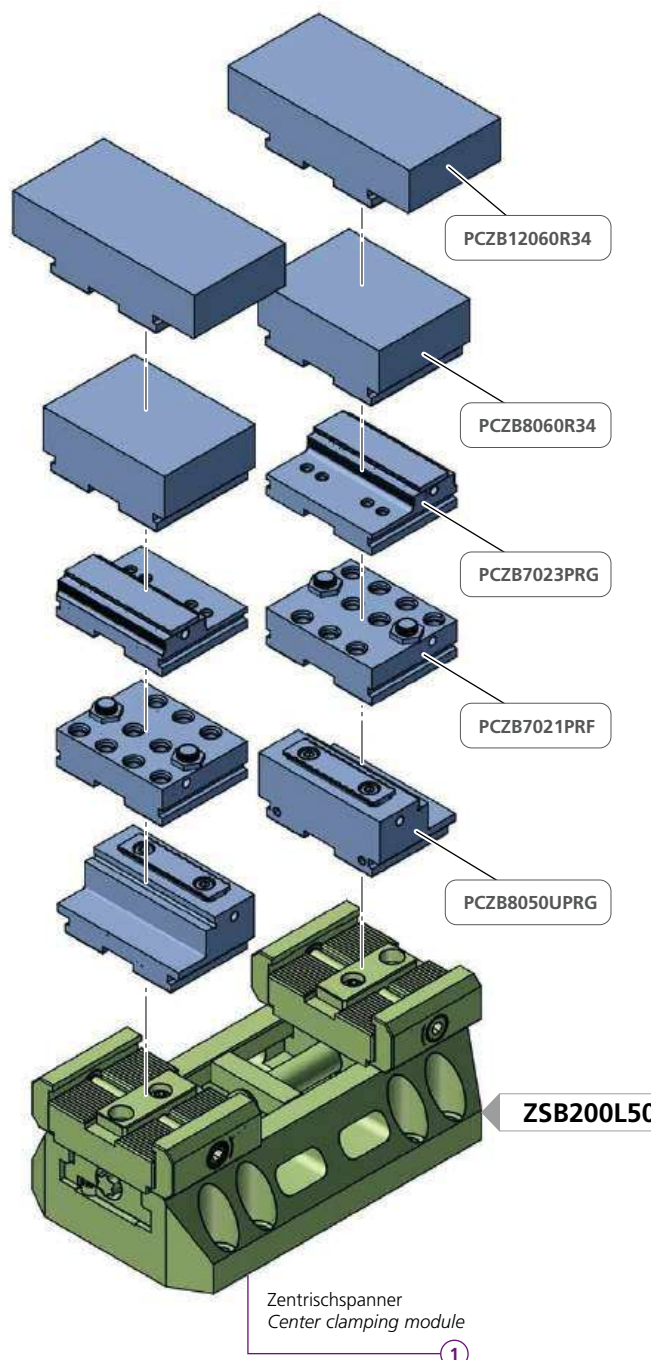
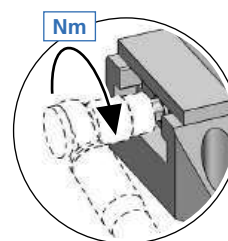
151

NUSS^{3/8}"TX30E14

WICHTIG!
Bitte separat bestellen
IMPORTANT!
Please order separately


Bestellbeispiel / Ordering example: 3 x ZSB200L50 & 6 x PCZB8050UPRG & 1 x NUSS^{3/8}"TX30E14

Drehmoment Torque		Spannkraft Workholding force			Gut zu Wissen Good to know
Nm	(lb-ft)	~daN	~(lb)	~t	
10	7,4	= 200	440	0,2	Diese Spannkräfte werden für den Dauerbetrieb empfohlen! <i>These clamping forces are recommended for continuous operation!</i>
20	14,8	= 500	1'102	0,5	
30	22,2	= 1'000	2'204	1,0	
40	29,6	= 1'300	2'866	1,3	
50	37,0	= 1'600	3'527	1,6	
60	44,4	= 1'800	3'968	1,8	Für kurzfristige Anwendung <i>For short-term application</i>
70	51,8	= 2'100	4'629	2,1	



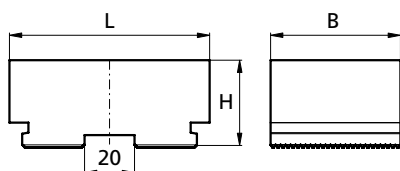
Mehr als **8** verschiedene Backenvarianten passend zu dieser Schnellwechsel-schnittstelle.

More than 8 different jaw modules to match this rapidly changing interface.

	kg
1 ZSB200L50	~8,4
ZSB180L50	~7,9
ZSB160L50	~7,4
ZSB140L50	~6,7
2x	

p. 152

Bestellbeispiel / Ordering example: 1 x ZSM200L50 & 2 x PCZB8050UPRG



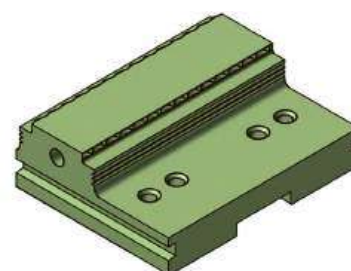
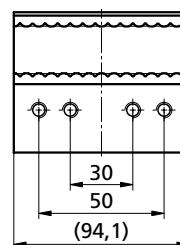
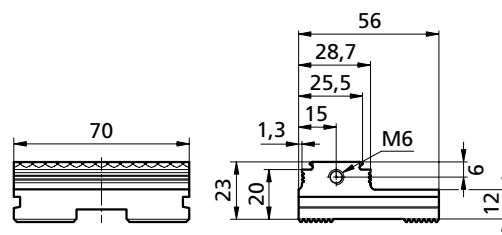
PCZB8060R34

PCZB12060R34

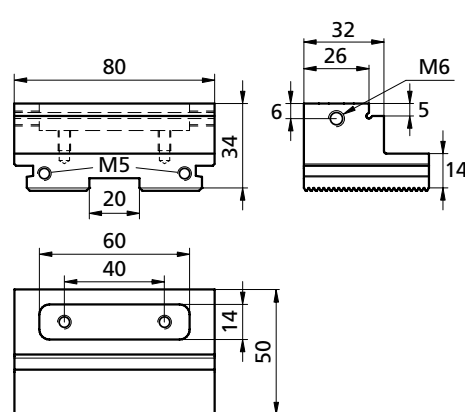
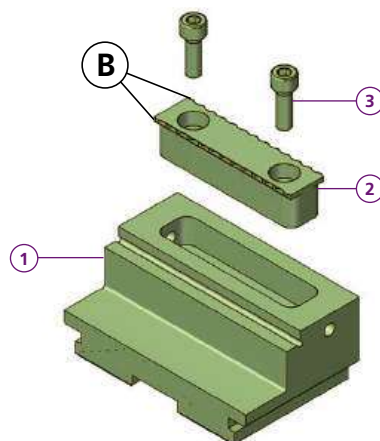
PCZB10060R50ST

PCZB8060R40ALU

		L	B	H	kg
PCZB8060R34	(Stahl/Steel)	80	60	34	~1,2
PCZB12060R34	(Stahl/Steel)	120	60	34	~1,7
PCZB10060R50ST	(Stahl/Steel)	101	60	50	~2,2
PCZB8060R40ALU	ALU	80	60	40	~0,52
PCZB10060R50	ALU	101	60	50	~0,76



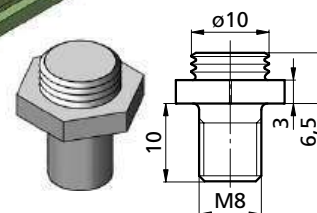
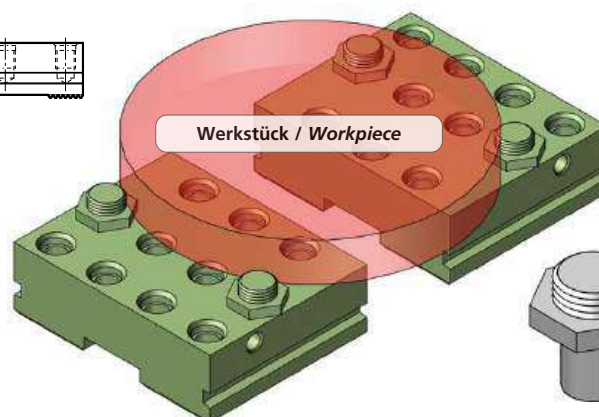
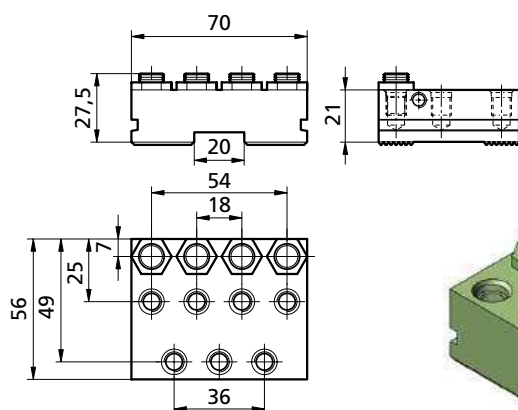
PCZB7023PRG kg ~0,54



PCZB8050UPRG

- ① 1x TB161200
- ② 1x MAND58-14PRG
- ③ 1x M5X16ISO4762

kg ~0,75



PCZB7021PRF kg ~0,6

PRG1003M8

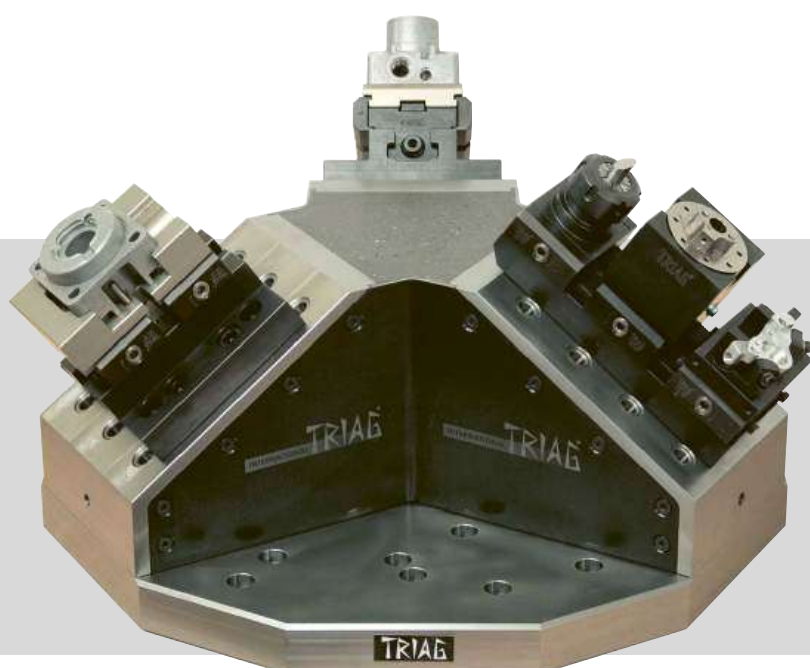
Bestellbeispiel / Ordering example: 2 x PCZB7021PRF & 4 x PRG1003M8

spaceGRIP III

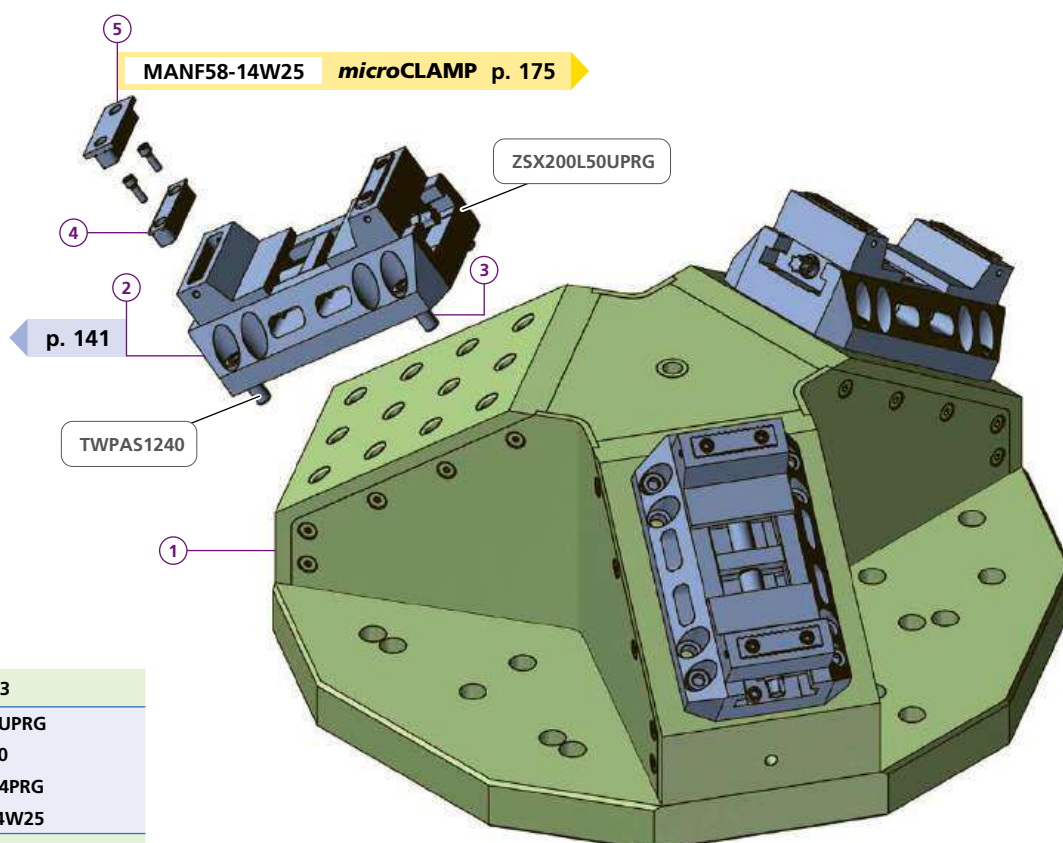
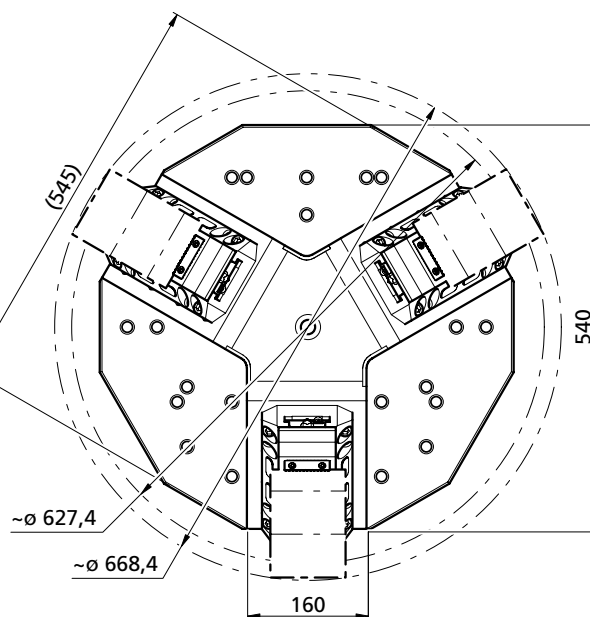
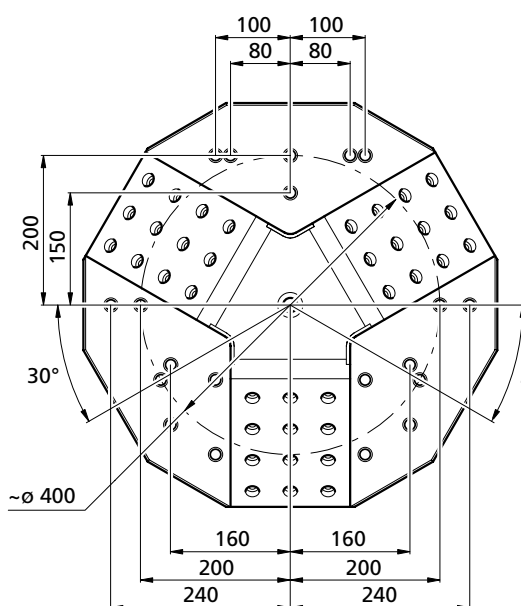
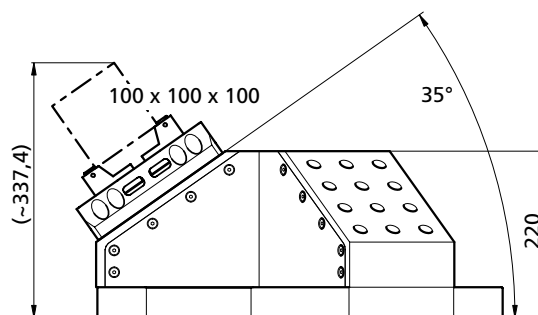
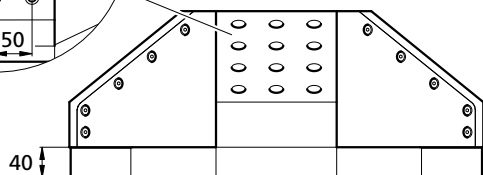
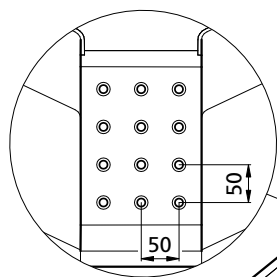
Spannbereich bis 180 mm, Spannkraft bei 70 Nm, 2,1 t/2100 daN. Hier kommen die «Grossen» unserer Zentrischspanner zum Einsatz. Speziell ist der Aufbau auf einer Stahl-Mineralgusspyramide um beste Verhältnisse bezüglich Vibrationsdämpfung zu bieten. Die Zentrischspanner dazu gibt es in vier Gehäuselängen (140, 160, 180 und 200 mm) und bis zu 60 Backenvarianten.

spaceGRIP III

Spans of up to 180 mm, clamping force at 70 Nm, 2.1 t/2100 daN. Here the «big ones» of our self-centering vices go into action. And there is the special setup of a steel mineral casting pyramid to provide the best conditions for vibration dampening. The self-centering vice for this is available with four housing lengths (140, 160, 180 and 200 mm) and up to 60 jaw versions.

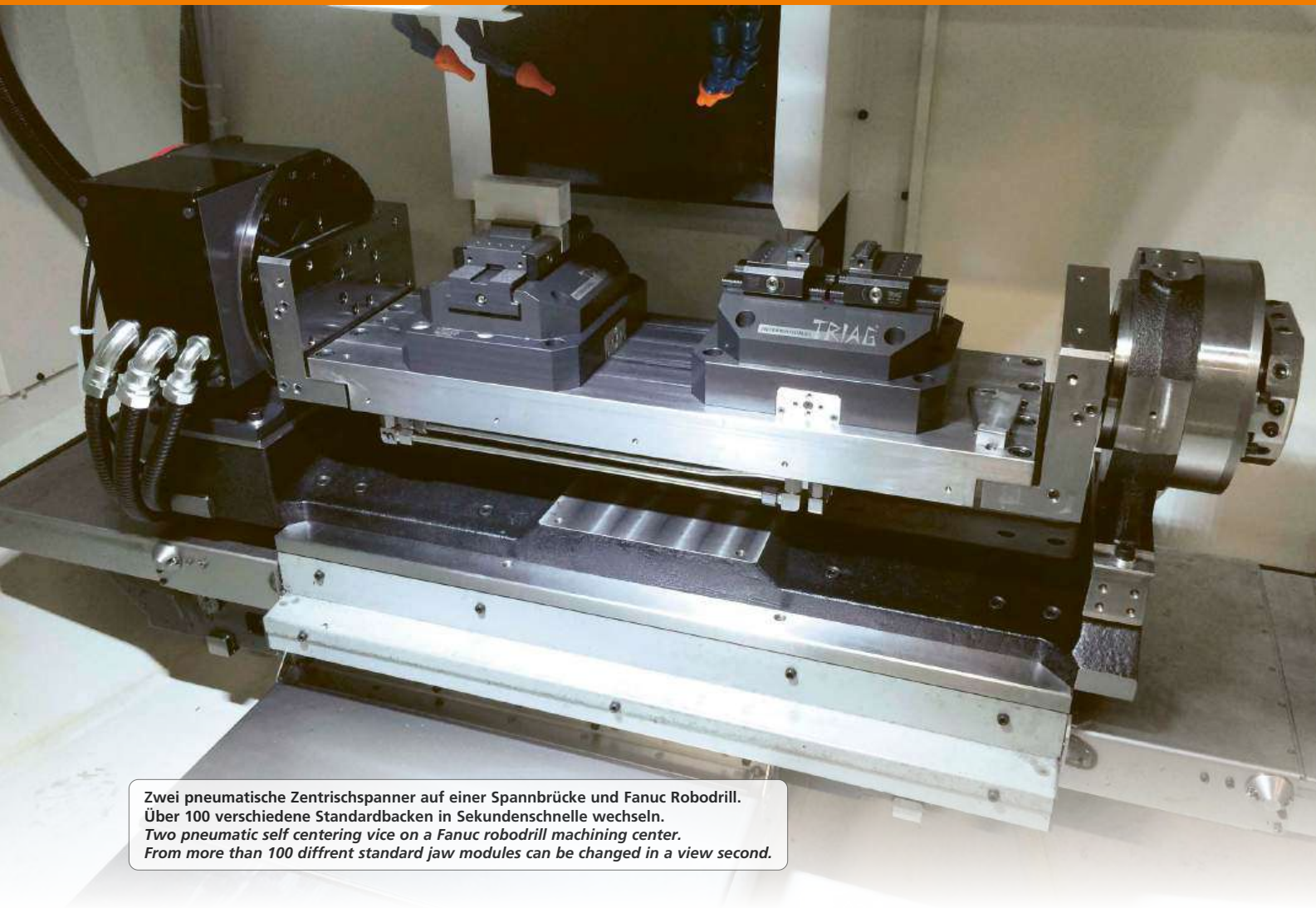


SPACEGRIP III



1	1x	5AXZSX35-3
2	3x	ZSX200L50UPRG
3	12x	TWPAS1240
4	6x	MAND58-14PRG
5	6x	MANF58-14W25
kg		~135

Bestellbeispiel / Ordering example: 1 x **5AXZSX35-3** & 3 x **ZSX200L50UPRG** & 6 x **MANF58-14W25**

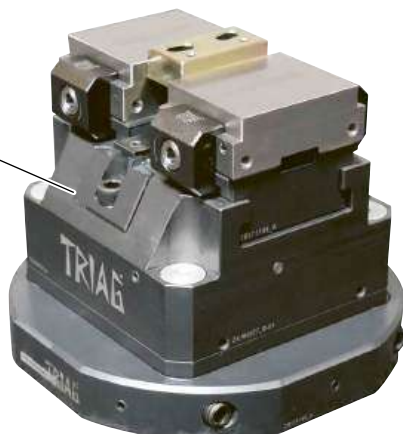


Zwei pneumatische Zentrischspanner auf einer Spannbrücke und Fanuc Robodrill.
 Über 100 verschiedene Standardbacken in Sekundenschnelle wechseln.
*Two pneumatic self centering vise on a Fanuc robodrill machining center.
 From more than 100 different standard jaw modules can be changed in a view second.*

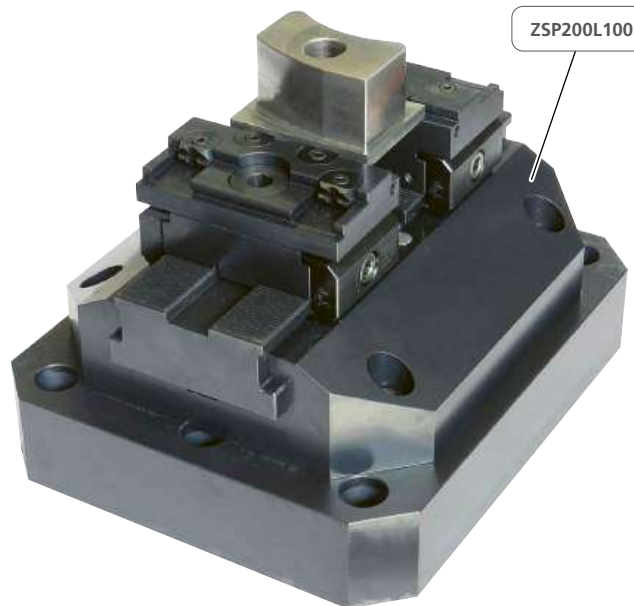
ZSP40L38SET-ZO



ZSP125L85-1



ZSP200L100



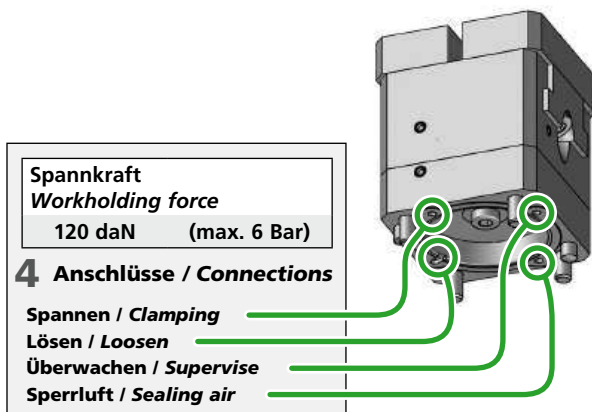
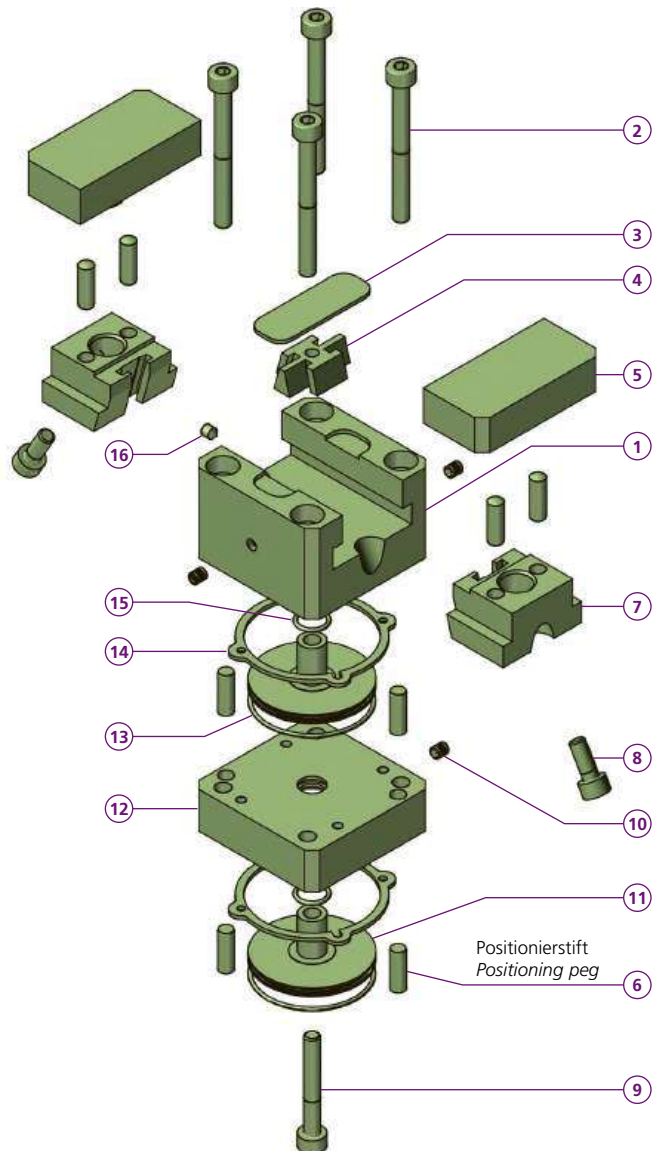
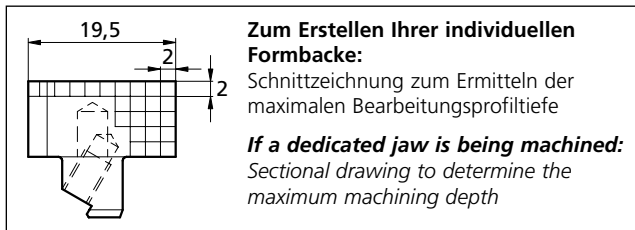
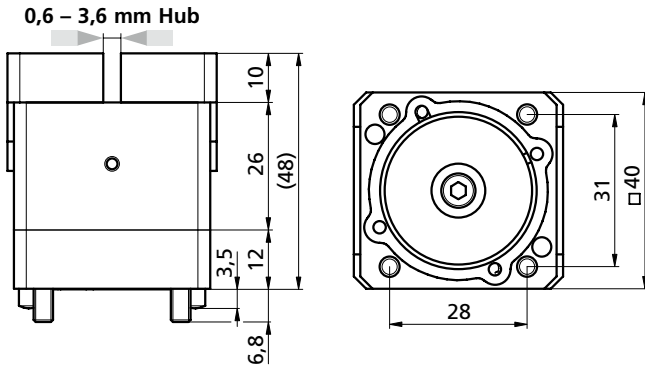
ZSP Micro

Pneumatischer Zentrischspanner

Pneumatic self centering vise

SET18ZSP40L38-2 ZSP40L38-2

triCENTRO



Spannkraft
Workholding force
120 daN (max. 6 Bar)

4 Anschlüsse / Connections

Spannen / Clamping

Lösen / Loosen

Überwachen / Supervise

Sperrluft / Sealing air

Positionierstift
Positioning peg

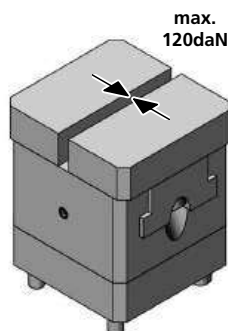
SET18ZSP40L38-2

- 1 1x TF180166
- 2 4x TN100865
- 3 1x TF180169
- 4 1x TF180168
- 5 2x B222
- 6 8x TN100428
- 7 2x TF180167
- 8 2x TN100321
- 9 1x TB180316
- 10 3x TN100824
- 11 2x TF180170
- 12 1x TF180171
- 13 2x TN100819
- 14 2x TB180306
- 15 2x TN100818
- 16 1x TN10091
- kg ~0,52

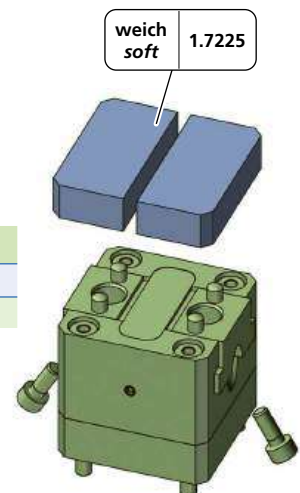
Luftvolumen / Air volume	
Spannen / Clamping	Lösen / Loosen
8,2cm ³	8,4cm ³



Bedienungsanleitung zu diesem pneumatischen Zentrischspanner
Operating instructions for this pneumatic self centering vise

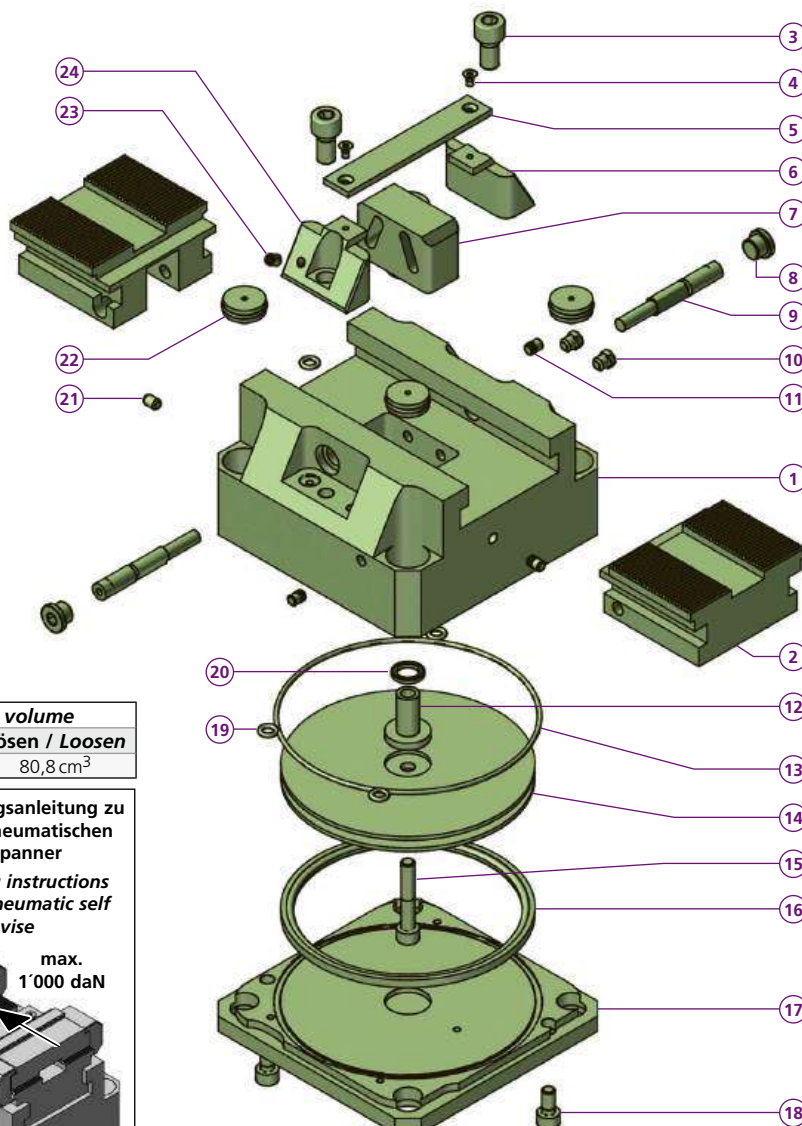
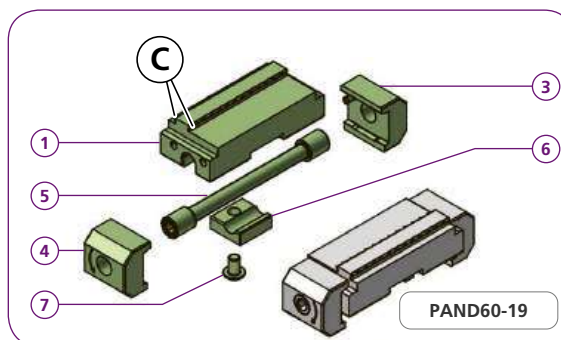
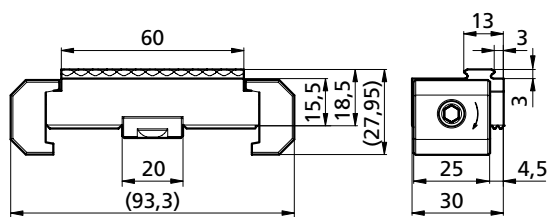
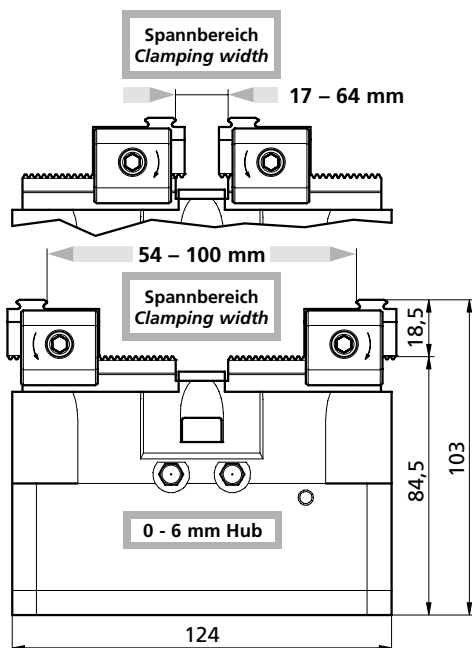


ZSP40L38-2	
5	2x B222
kg	~5,2



Bestellbeispiel / Ordering example: SET18ZSP40L38-2

Separat bestellen / Order separately



ZSP125L85-1

- 1 1x TB180474
 - 2 2x TB180476
 - 3 2x M8X16ISO4762
 - 4 2x M3X6DIN7991
 - 5 1x TB171140
 - 6 1x TB171141
 - 7 1x TB180477
 - 8 2x TN100014
 - 9 2x TB170530
 - 10 2x TN100021
 - 11 3x TN100009
 - 12 1x TK160467
 - 13 1x TN100012
 - 14 1x TK160075
 - 15 1x M6X35ISO4762
 - 16 1x TN100020
 - 17 1x TB180475
 - 18 2x TN100015
 - 19 4x TN100013
 - 20 1x TN100027
 - 21 1x TB180268
 - 22 4x PCPF16L6
 - 23 1x M5X6DIN913
 - 24 1x TB180478
- kg ~7,4

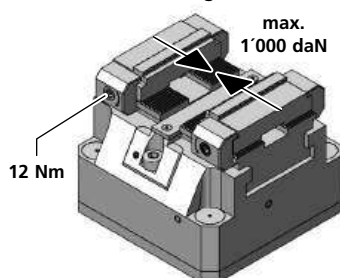
PAND60-19

- 1 1x TB171149
 - 3 1x PCSP25L
 - 4 1x PCSP25R
 - 5 1x PCS10
 - 6 1x PCGU2019
 - 7 1x M5X8ISO7380
- kg ~0,4

Luftvolumen / Air volume	
Spannen / Clamping	Lösen / Loosen
80,1 cm ³	80,8 cm ³



Bedienungsanleitung zu
diesem pneumatischen
Zentrischspanner
Operating instructions
for this pneumatic self
centering vise

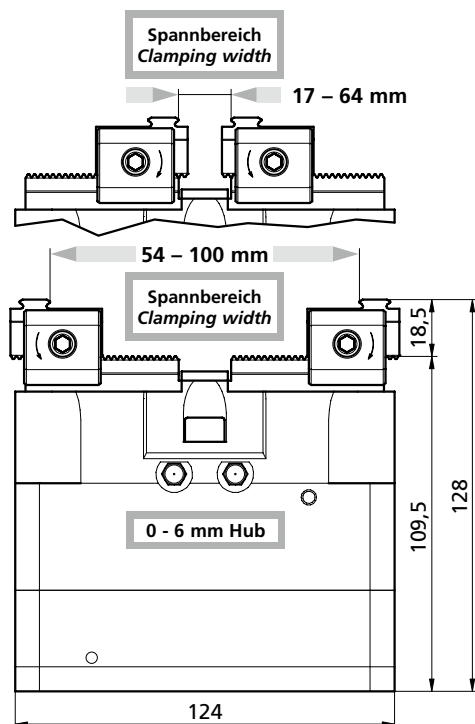


SET18ZSP125L85-1

- 1x ZSP125L85-1
 - 2x PAND60-19
- kg ~8,2

	Druck Pressure		Spannkraft Clamping force		
	Bar	~daN	~(lb)	~t	
Einfacher Kolben Single piston	8	= 600	1'320	0,6	
	10	= 800	1'760	0,8	
	12	= 1'000	2'650	1,0	

Bestellbeispiel / Ordering example: SET18ZSP125L85-1



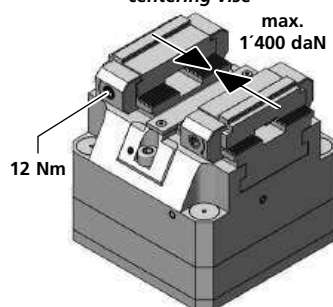
ZSP125L110-2

- 1x TB180474
 - 2x TB180476
 - 2x **M8X16ISO4762**
 - 2x M3X6DIN7991
 - 1x TB171140
 - 1x TB171141
 - 1x TB180477
 - 2x TN100014
 - 2x TB170530
 - 2x TN100021
 - 6x TN100009
 - 2x TK160467
 - 2x TN100012
 - 1x TB170147
 - 2x TN100020
 - 1x TB180480
 - 1x TK160075
 - 1x **M6X60ISO4762**
 - 1x TB180475
 - 2x **M6X40ISO4762**
 - 7x TN100013
 - 2x TN100027
 - 1x TB180268
 - 4x PCPF16L6
 - 1x M5X16DIN913
 - 1x TB180478
- kg ~9,4

Luftvolumen / Air volume	
Spannen / Clamping	Lösen / Loosen
160,2 cm ³	160,9 cm ³



Bedienungsanleitung zu diesem pneumatischen Zentrischspanner
 Operating instructions for this pneumatic self centering vise



SET18ZSP125L110-2

- 1x ZSP125L110-2
 - 2x PAND60-19
- kg ~11,3

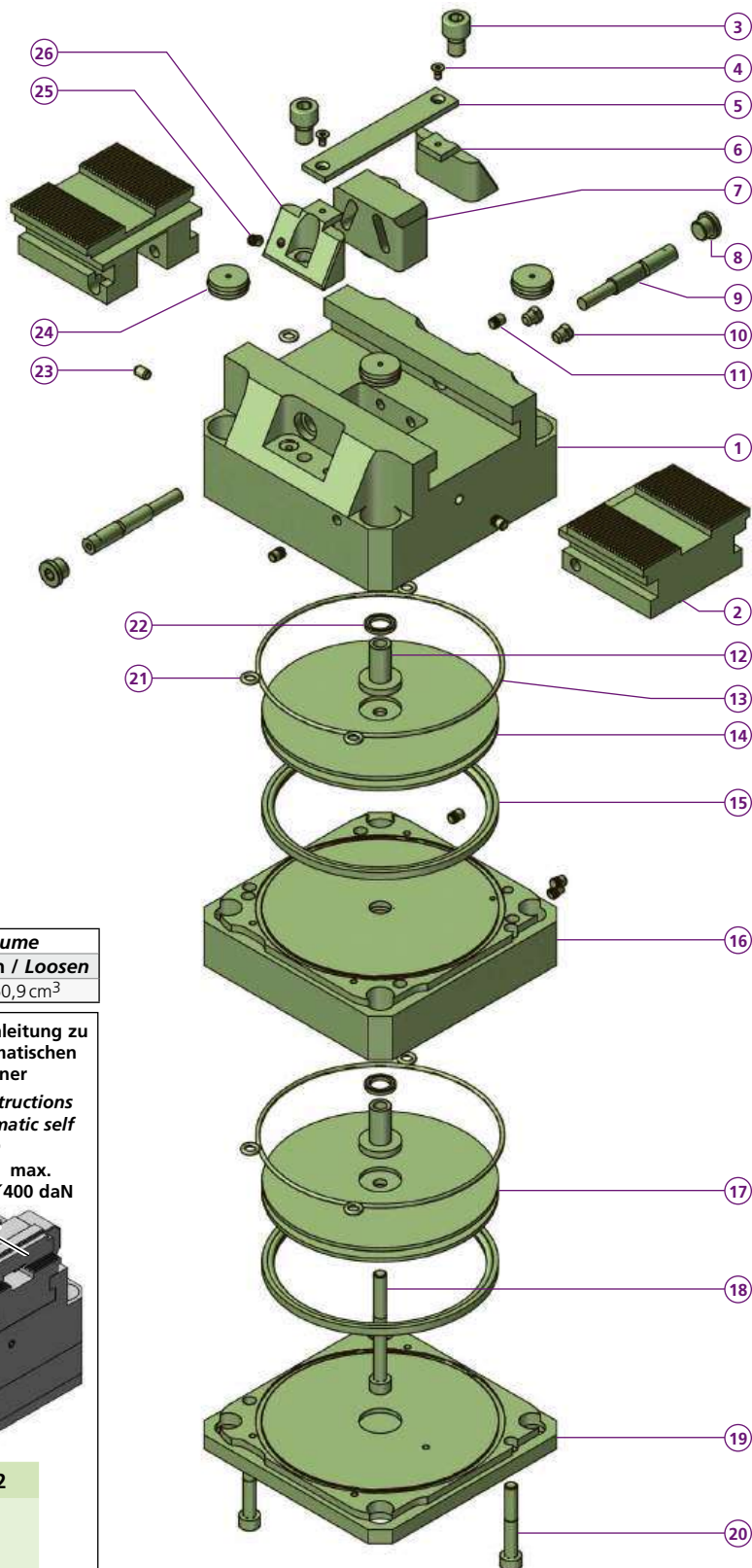
PAND60-19

- 1x TB171149
 - 1x PCSP25L
 - 1x PCSP25R
 - 1x PCS10
 - 1x PCGU2019
 - 1x **M5X8ISO7380**
- kg ~0,4

Masszeichnung &
Isometrische Darstellung:

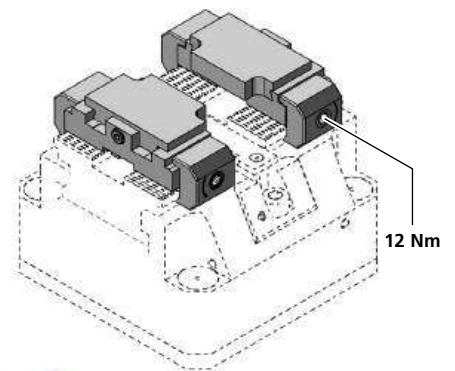
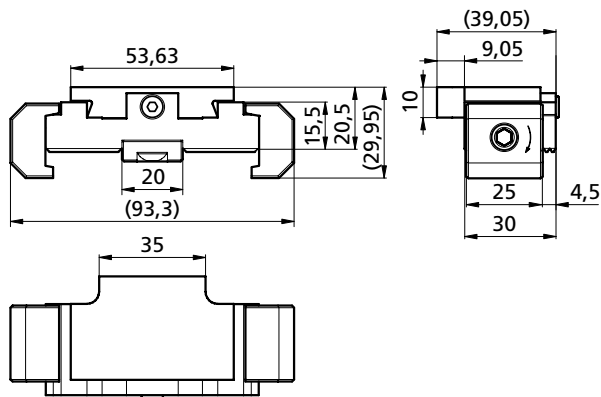
Siehe Seite | See page **p. 159**

Dimensional drawing &
Isometric representation:

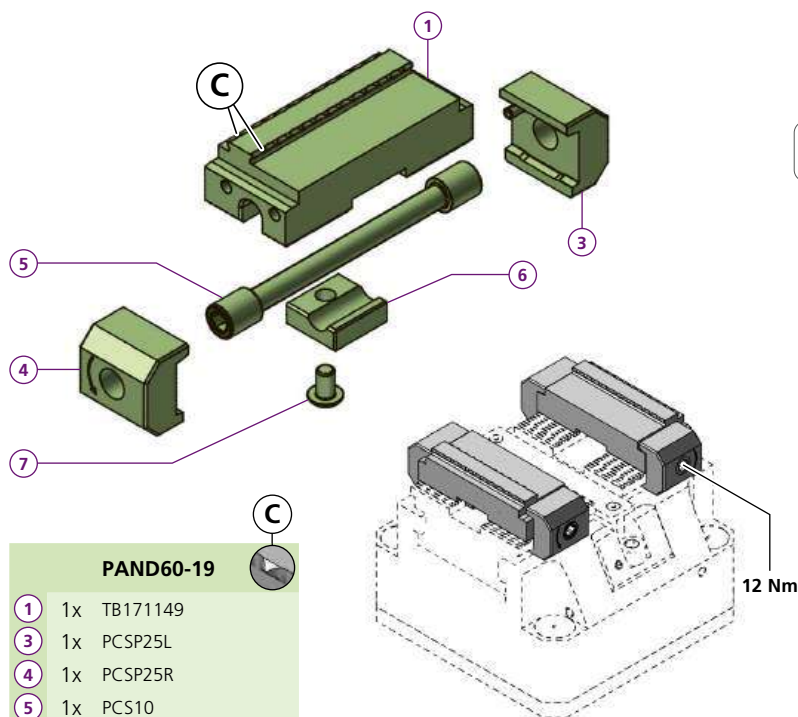
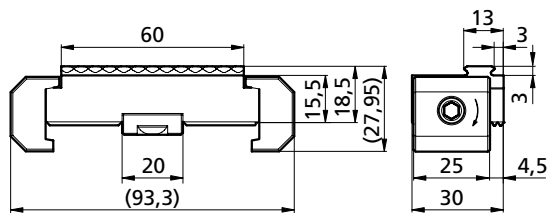
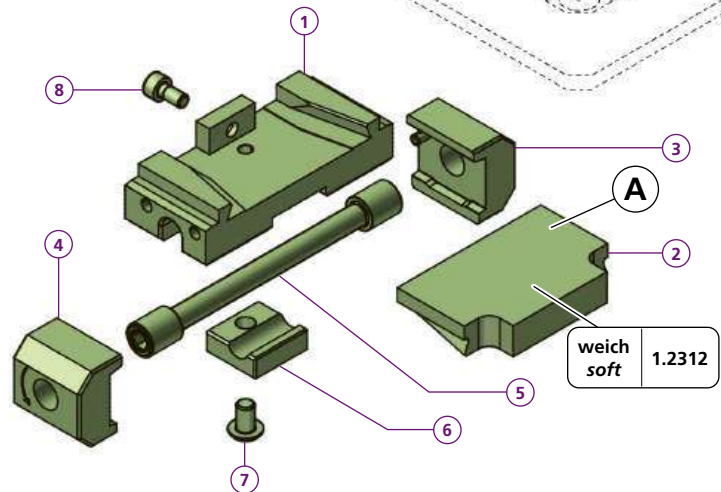


Druck Pressure	Spannkraft Clamping force			
	Bar	~daN	~(lb)	~t
Doppelkolben Double piston	8	= 1'000	2'200	1,0
	10	= 1'400	3'090	1,4

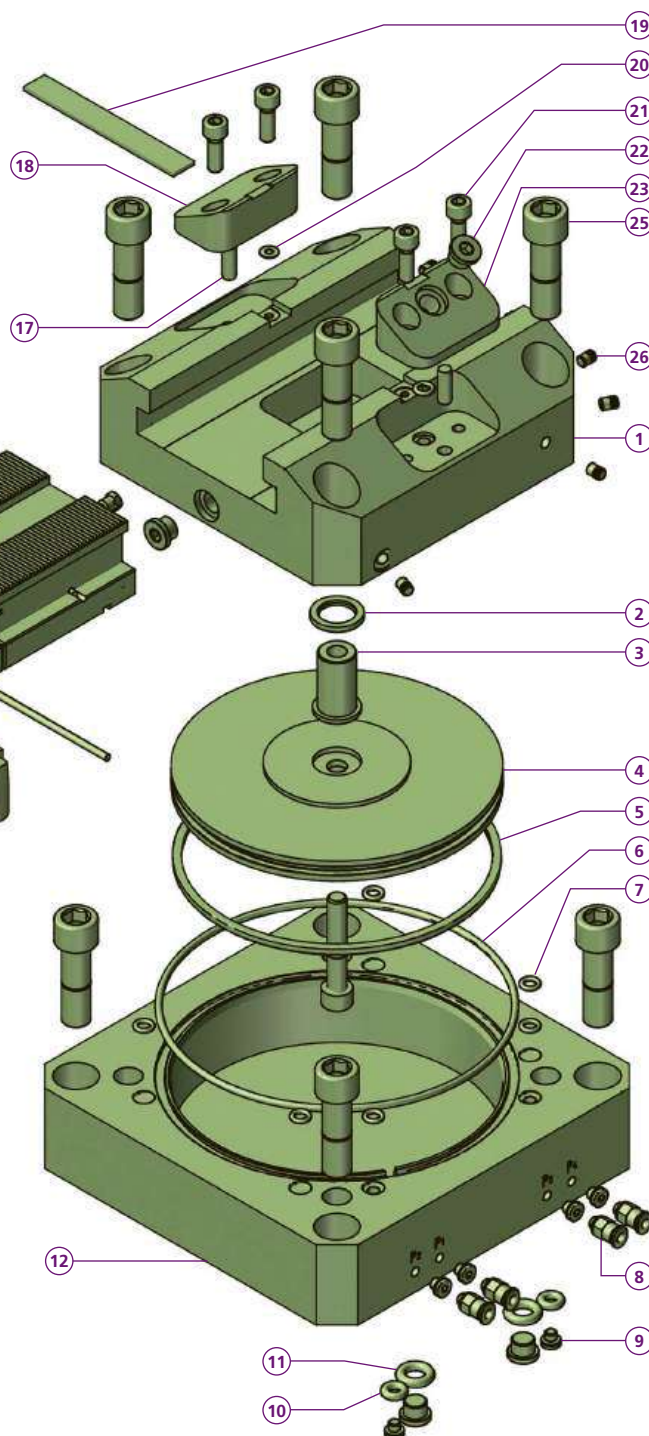
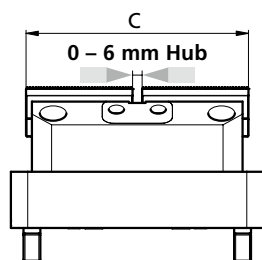
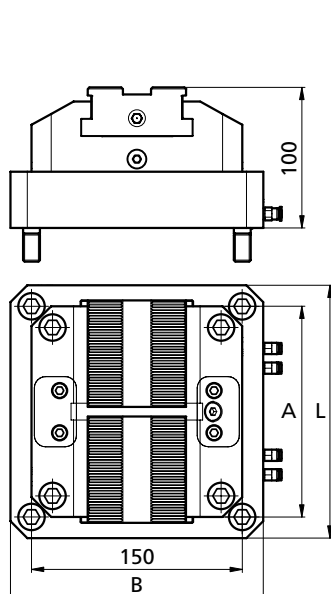
Bestellbeispiel / Ordering example : **SET18ZSP125L110-2**



PAND60-20.5UWB	
1x	TK171294
1x	TK180360
1x	PCSP25L
1x	PCSP25R
1x	PCS10
1x	PCGU2019
1x	M5X8ISO7380
1x	M4X8ISO4762
kg	~0,3



PAND60-19	
1x	TB171149
1x	PCSP25L
1x	PCSP25R
1x	PCS10
1x	PCGU2019
1x	M5X8ISO7380
kg	~0,4

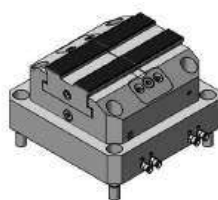


ZSP150L100

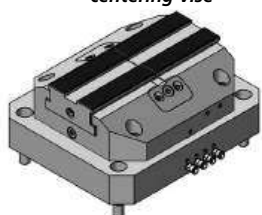
1	1x	TB190122
2	1x	TN100525
3	1x	TB140209
4	1x	TB190092
5	1x	TN100595
6	1x	TN100894
7	7x	TN100013
8	4x	TN100596
9	6x	TN100914
10	2x	TN100917
11	2x	TN100592
12	1x	TB190125
13	2x	TB190087
14	1x	TB190085
15	2x	TN100021
16	2x	TB190123
17	2x	TN100453
18	1x	TB190095
19	1x	TB190086
20	2x	TN100916
21	4x	M6X18ISO4762
22	5x	TN100014
23	1x	TB190094
24	8x	TWPAS1240
25	5x	TN100009
A	=	150
L	=	180
B	=	180
kg	=	~16



Bedienungsanleitung zu diesem pneumatischen Zentrischspanner
Operating instructions for this pneumatic self centering vise



Bedienungsanleitung zu diesem pneumatischen Zentrischspanner
Operating instructions for this pneumatic self centering vise

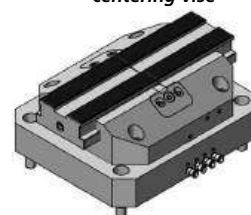


ZSP250L100

1	1x	TB190083
12	1x	TB190091
16	2x	TF190780
A	=	200
L	=	240
B	=	200
C	=	250
kg	=	~25,5



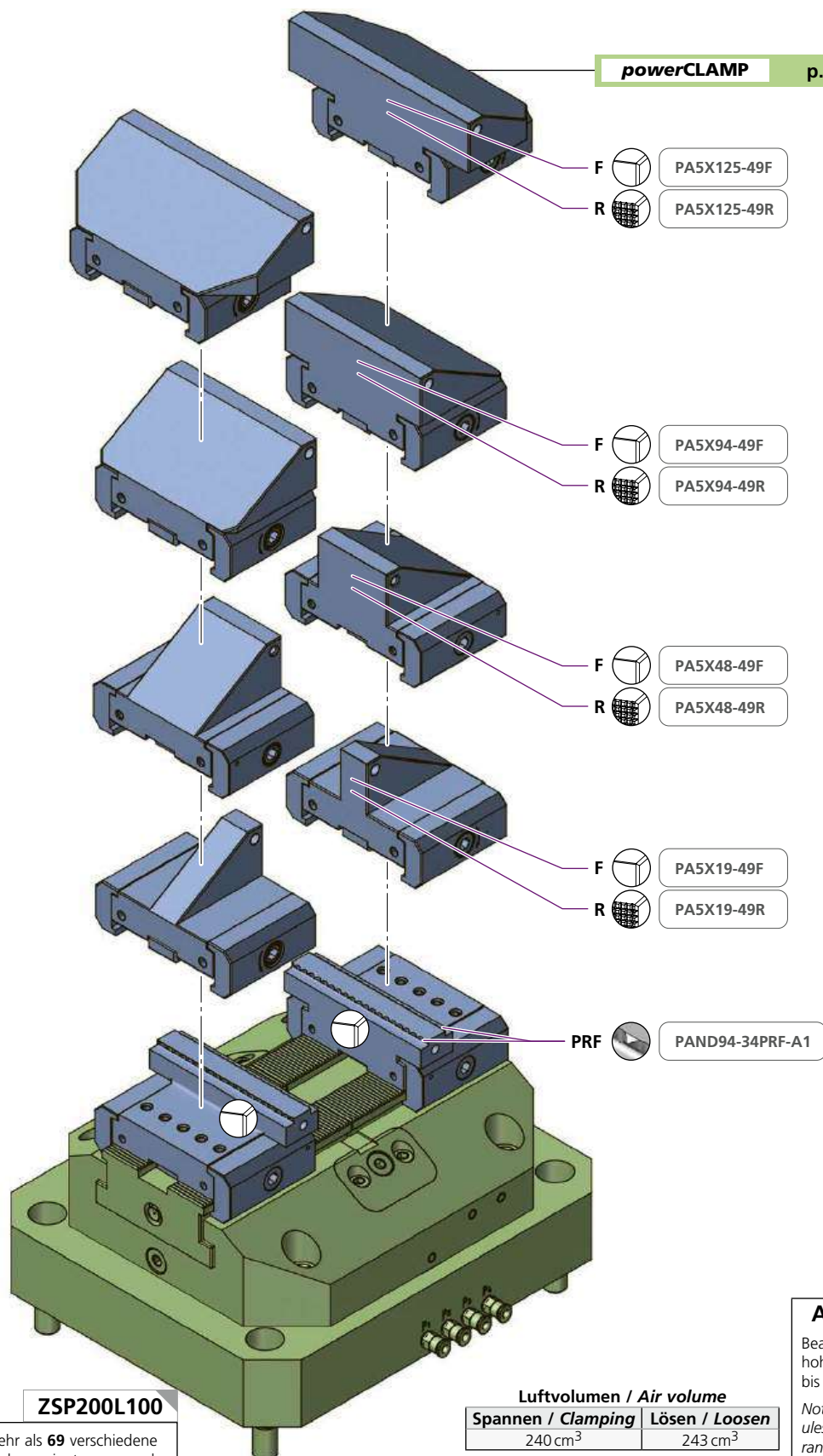
Bedienungsanleitung zu diesem pneumatischen Zentrischspanner
Operating instructions for this pneumatic self centering vise



Spannkraft siehe Seite
Clamping force see page

161

Bestellbeispiel / Ordering example: ZSP150L100

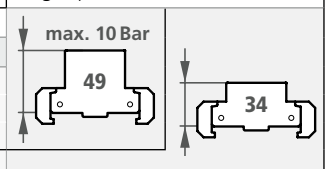


ACHTUNG / CAUTION

Beachten Sie, dass nur die 34 mm hohen Module für den Druckbereich bis 12 Bar eingesetzt werden dürfen.

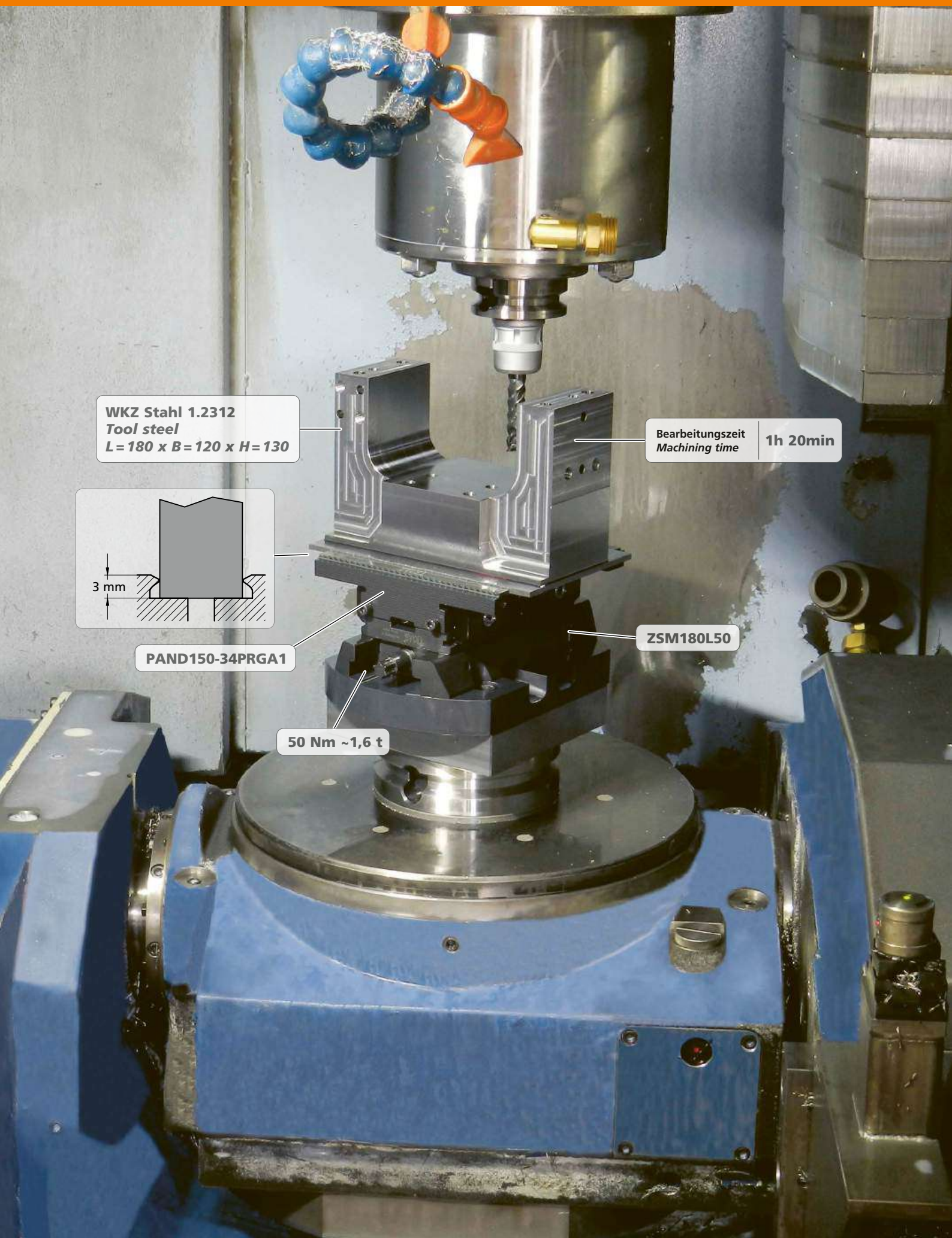
Note that only the 34 mm high modules may be used for the pressure range up to 12 bar.

Druck / Pressure	Spannkraft / Clamping force			
	Bar	~daN	~(lb)	~t
Druckübersetzer Pressure intensifier 1:2	5	= 1'100	2'420	1,1
	8	= 1'500	3'300	1,5
	10	= 2'000	4'400	2,0
	12	= 2'400	5'290	2,4



Bestellbeispiel / Ordering example: 1 x **ZSP200L100** & 2 x **PA5X48-49F**

Separat bestellen / Order separately



WKZ Stahl 1.2312
Tool steel
L = 180 x B = 120 x H = 130

Bearbeitungszeit
Machining time 1h 20min

3 mm

PAND150-34PRGA1

ZSM180L50

50 Nm ~1,6 t



***micro*CLAMP**



compactCLAMP

Mehrfachspannsystem / Multiple workholding system

**Nur noch Ersatzteile und
Nachlieferungen!
Keine Compact Clamp
Neuentwicklungen mehr!**

Beim Compact Clamp lassen sich die Spannmodule auf einer Basisschiene mittels Passstiften massgenau positionieren. Die Schienen sind mit einem Lochraster mit 7,5 mm Teilung, die Spannmodule mit einer 10 mm-Teilung versehen. Dank Anwendung des Nonius-Prinzips entsteht ein kleinstmöglicher Positionierschritt von 2,5 mm. Bei einem Backenhub von 4 mm ist es somit möglich, an jedem beliebigen Punkt der Schiene nullpunktbezogen zu spannen. Ab 20 mm ist die Bearbeitung von drei Seiten möglich. Da das Spannmodul mit vier Schrauben in den T-Nuten verankert wird, ist es sinngemäss auch möglich, an Stelle der Original-Spannmodule individuelle Vorrichtungen und Sonderbacken zu befestigen. Das Compact Clamp Spannsystem ist ein System für Tüftler. Praktisch keine Spannprobleme bleiben damit ungelöst. Dafür sind die Umrüstzeiten etwas länger als beim Power Clamp. Compact Clamp-Basisschienen sind in den Längen 113 - 750 mm lieferbar. Die angebotenen Befestigungsrastrer sind 40 und 50 mm. Neben den Stahlschienen werden für leichte Arbeiten auch Schienen aus Aluminium hergestellt.

**Only spare parts and
additional deliveries! No
more new Compact Clamp
developments!**

In the Compact Clamp, the vise modules are positioned precisely on a base rail by means of alignment pins. On the base rail, positioning holes are located on a 7,5 mm grid, while on the vise module there is one with a 10 mm spacing. Following the vernier principle, the smallest possible positioning step is therefore 2,5 mm. With a jaw movement of 4 mm it is therefore possible to clamp the workpiece in any desired position with a known distance to program Zero (original datum face). From 20 mm up, three sided machining is possible. Special jaws or dedicated fixtures may easily be bolted onto the rails in place of standard vise modules if the need arises. They may be anchored in the T-slots and located by using alignment pins in the positioning holes. Hence the Compact Clamp is the ideal workholding system for "do it yourself" customers. Change over times are longer than with the Power Clamp, though. Available Compact Clamp base rails lengths: 113 - 750 mm. The fastening grids on the rails are 40 and 50 mm. In addition those made of steel we also produce rails made of aluminum for light work.



Sie können den
Katalog unter der
folgenden Link herunter-
laden!

You can download the
catalogue at the fol-
lowing download
link!



Einleitung <i>Introduction</i>	166 - 167
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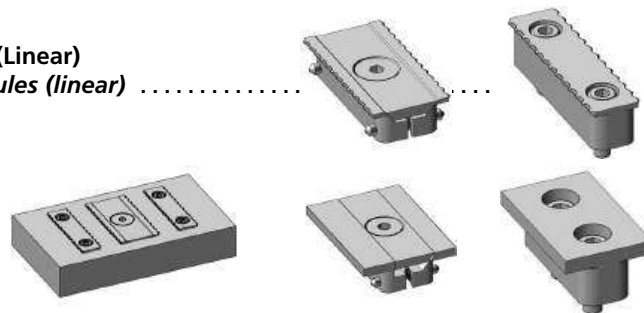
Anwendungsbeispiele <i>Examples of application</i>	168 - 171
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Spannkraft und Drehmoment <i>Workholding force and torque</i>	173
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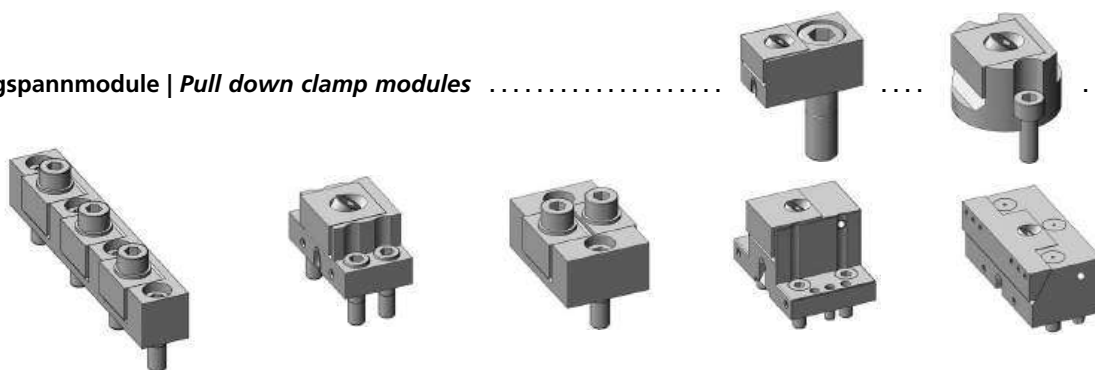
Vorrichtungsbau - Präge- und Anschlagmodule (Linear)

<i>For dedicated fixture - stamping- and end modules (linear)</i>	174 - 176
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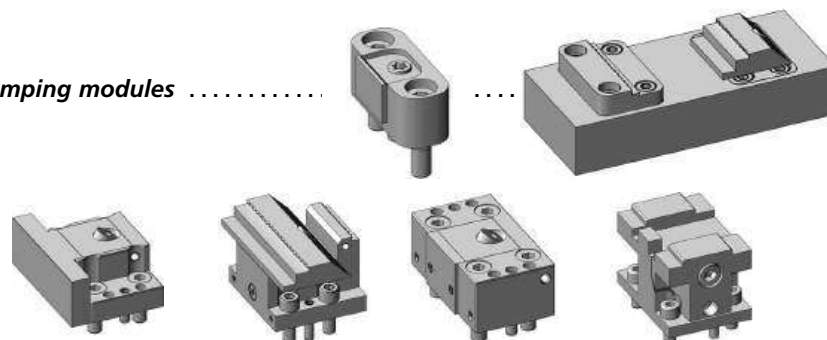
Niederzugspannmodule | *Pull down clamp modules*

.....	177 - 195
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Linearspannmodule | *Linear clamping modules*

.....	196 - 203
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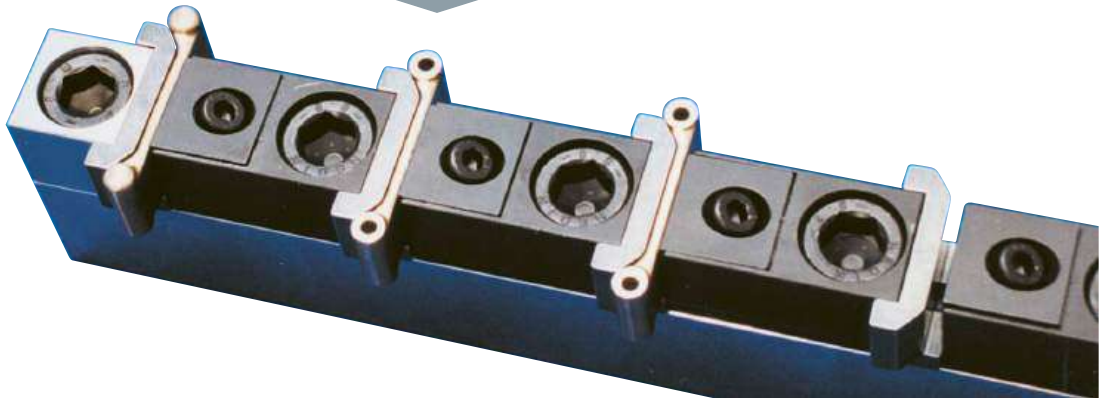
Zubehör | *Accessories*

.....	204 - 205
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Zum Aufbau kundenspezifischer Sondervorrichtungen für höchste Werkstückdichte im Arbeitsraum von Bearbeitungszentren ist das Spannsystem Micro Clamp ausgelegt (Spezielle Anschlagbacken, siehe Bild). Sehr kompakte Spannmodule mit Prägebacken verwirklichen eine zuverlässige Aufspannung bei nur etwa 2 mm Verlust an Rohmaterial

Clams for dedicated fixtures for high density to get your best output from your machine. Clamping modules in different sizes and shapes and jaws with serrations also flat and carbide coated are available.



Kleinst-Spannmodule für den Vorrichtungsbau. *Extremely small clamping modules for dedicated fixtures.*

Hohe Spanndichte

Die Spannmodule haben auf der Vorderseite eine Spannbacke, die Rückseite ist zu den Befestigungsbohrungen massgenau geschliffen oder gefräst. Damit kann diese Anschlagfläche für das folgende Werkstück genutzt werden. Diese Anordnung lässt eine sehr hohe Spanndichte zu. Beim kleinsten Micro Clamp-Modul sind nur 15 mm Spannabstand erforderlich.

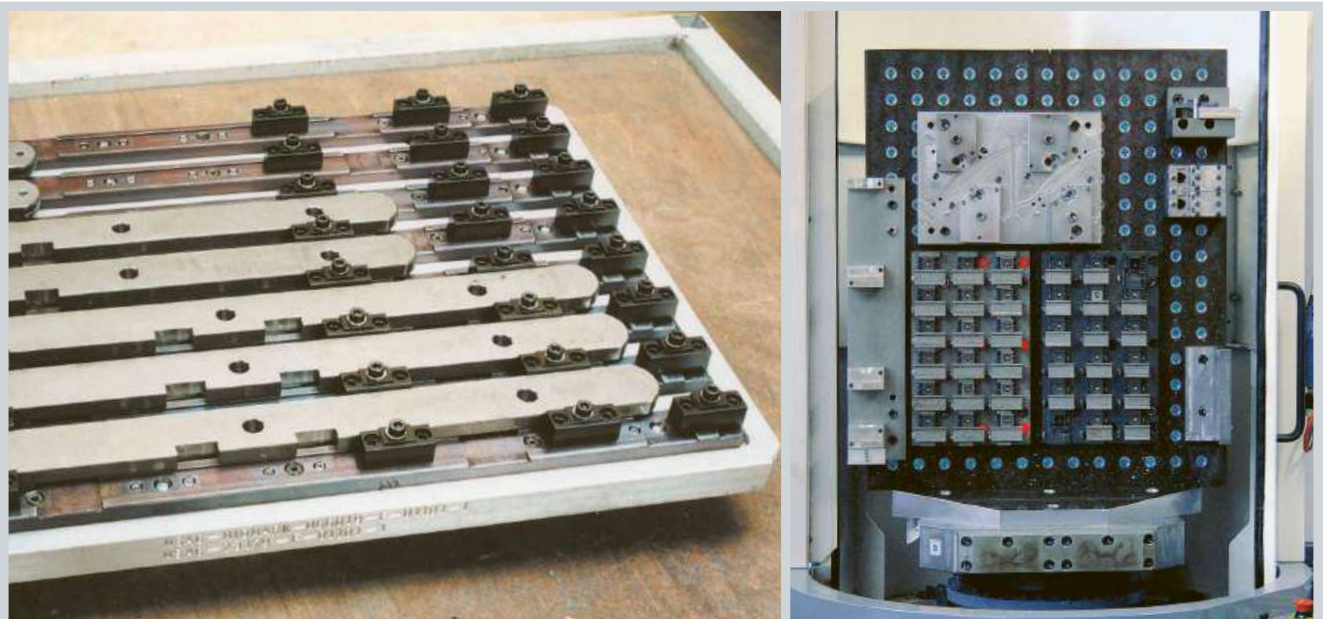
High workholding density

These clamping modules have a clamping jaw on the front, while rear is precisely ground or milled with reference to the fixing holes. This means that it can be used as a datum face for the following workpiece. This arrangement allows very high clamping densities. Only 15 mm clamping clearance is needed between workpieces using the smallest Micro Clamp module.

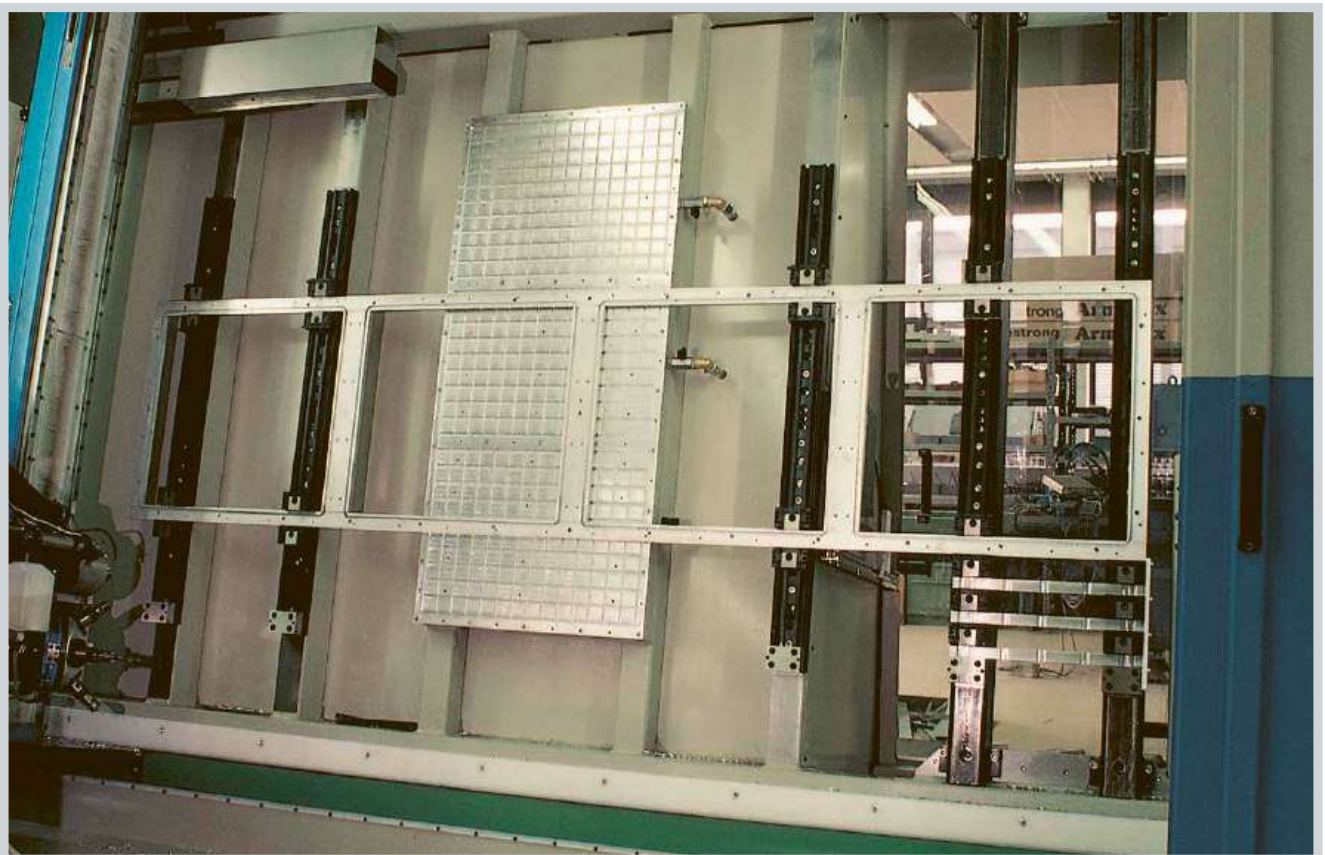
- Maximale Spannkraft der Module 2,8t (28'000N)
- Benötigter Platz zwischen den Werkstücken ab 15 mm
- Spannhub ab 1,5 mm
- Genaue Positionierung durch Passschrauben und Positionierstifte
- *Clamping force up to 2,8t (28'000N)*
- *Space between workpieces only 15 mm*
- *Stroke of jaw from 1,5 mm*
- *Precise positioning by ground shoulder screws or dowel pins*

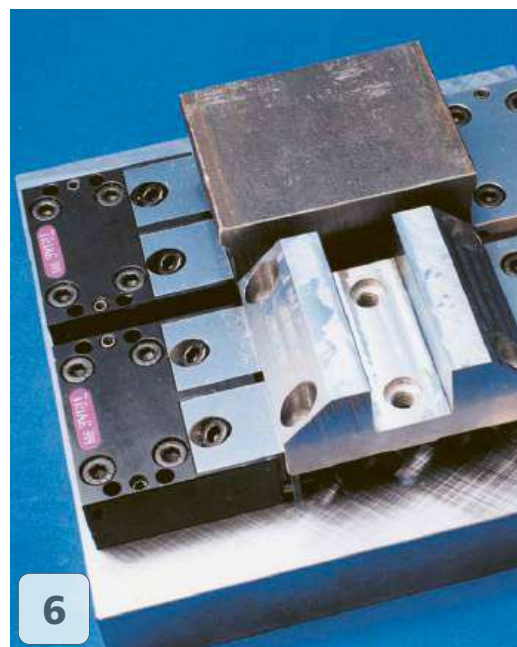
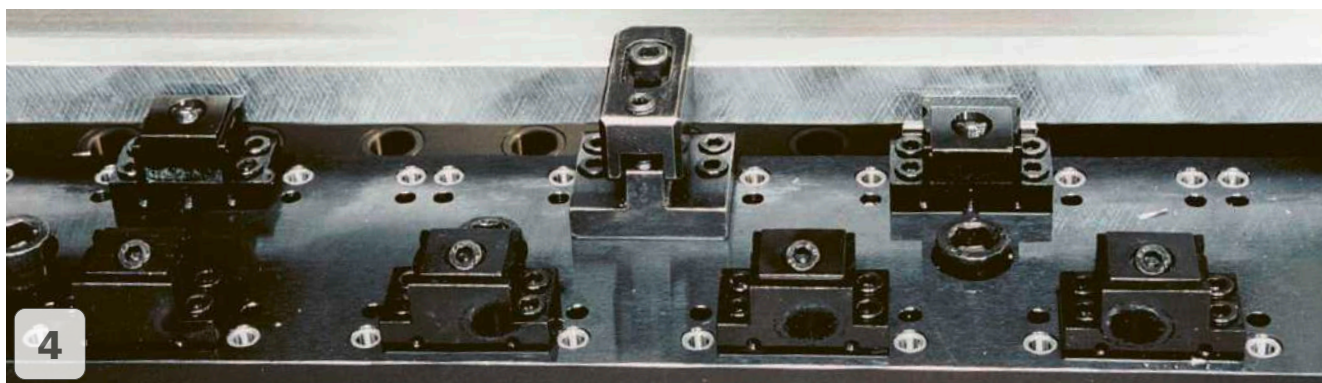
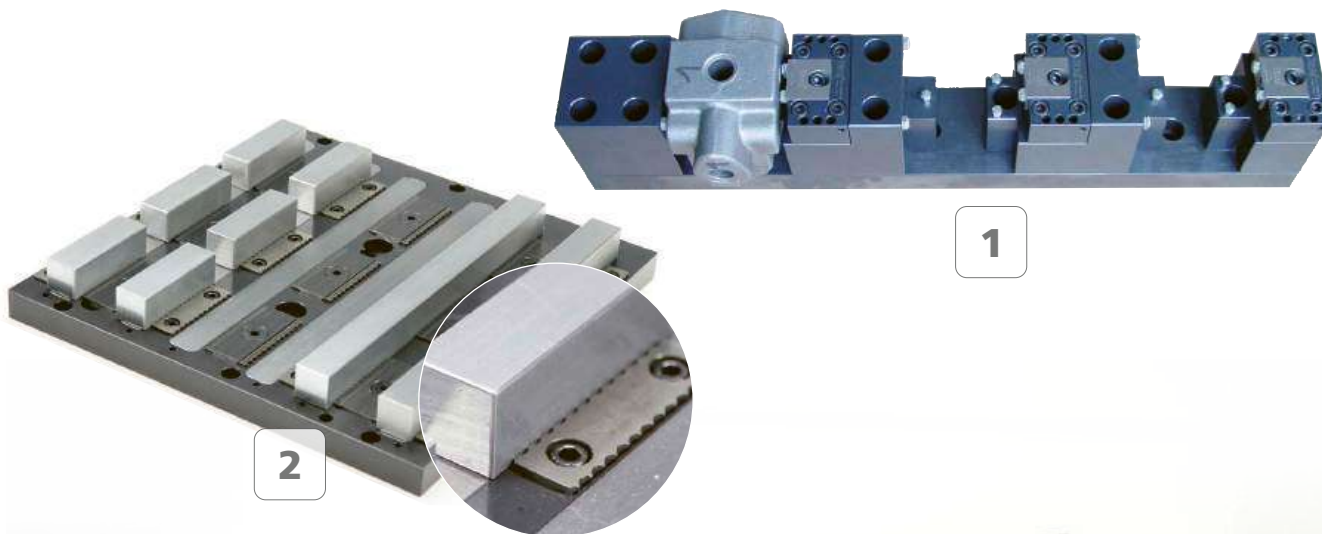


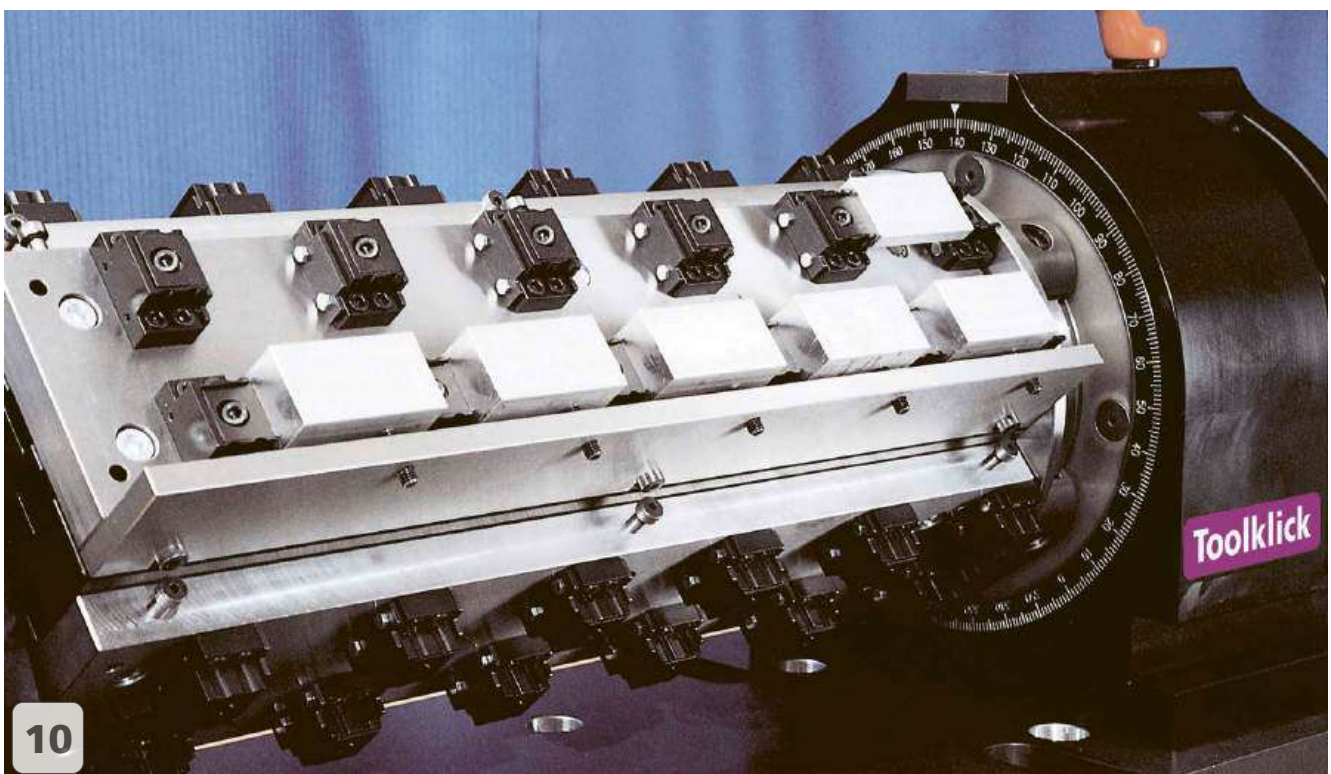
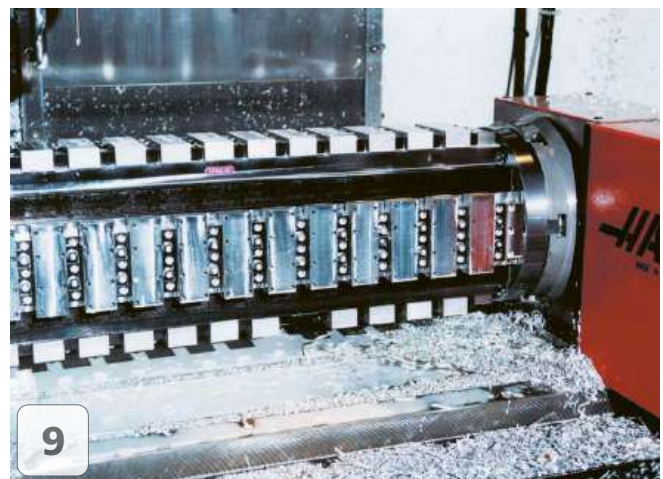
Ein grosses Angebot an verschiedensten Spannmodulen.
A wide range of clamp modules in different sizes are available

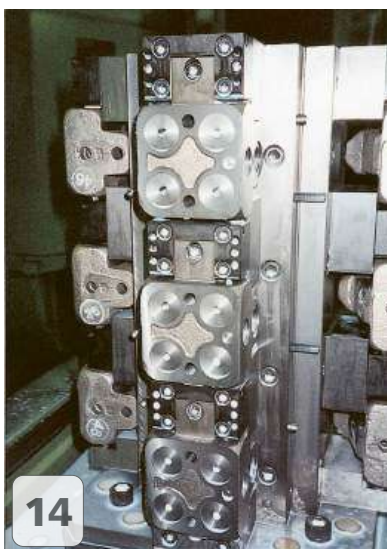
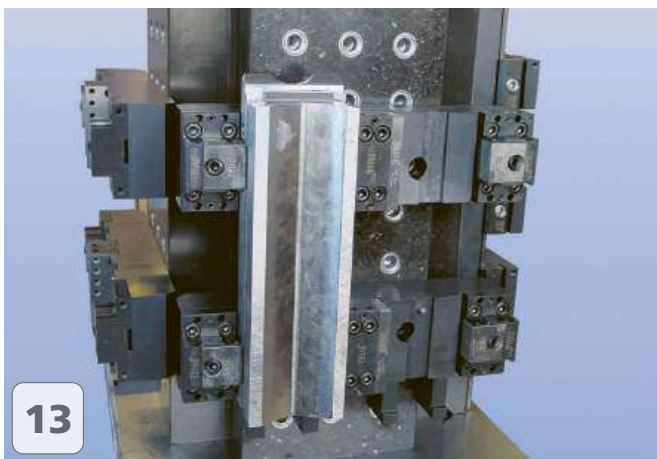


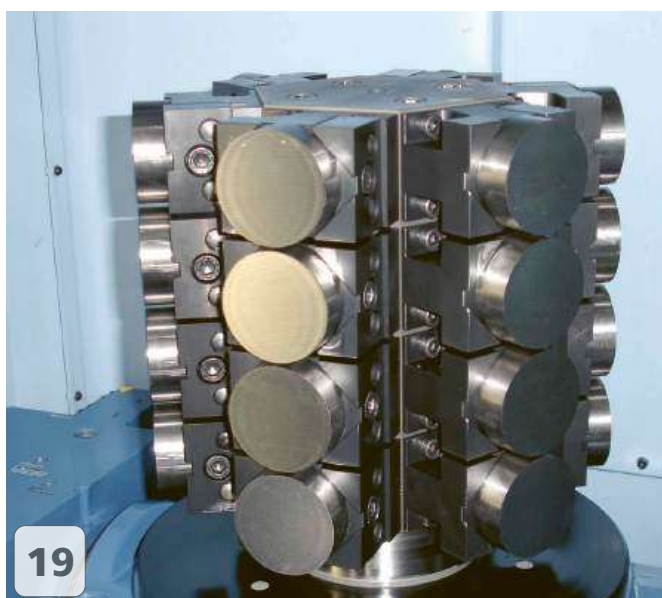
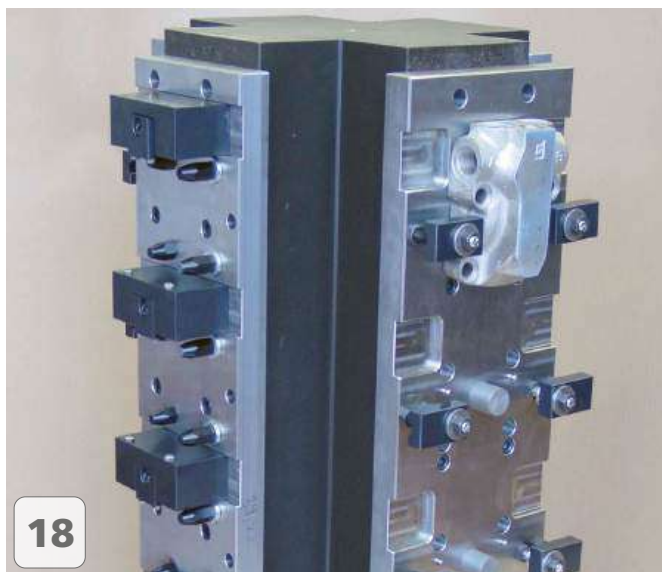
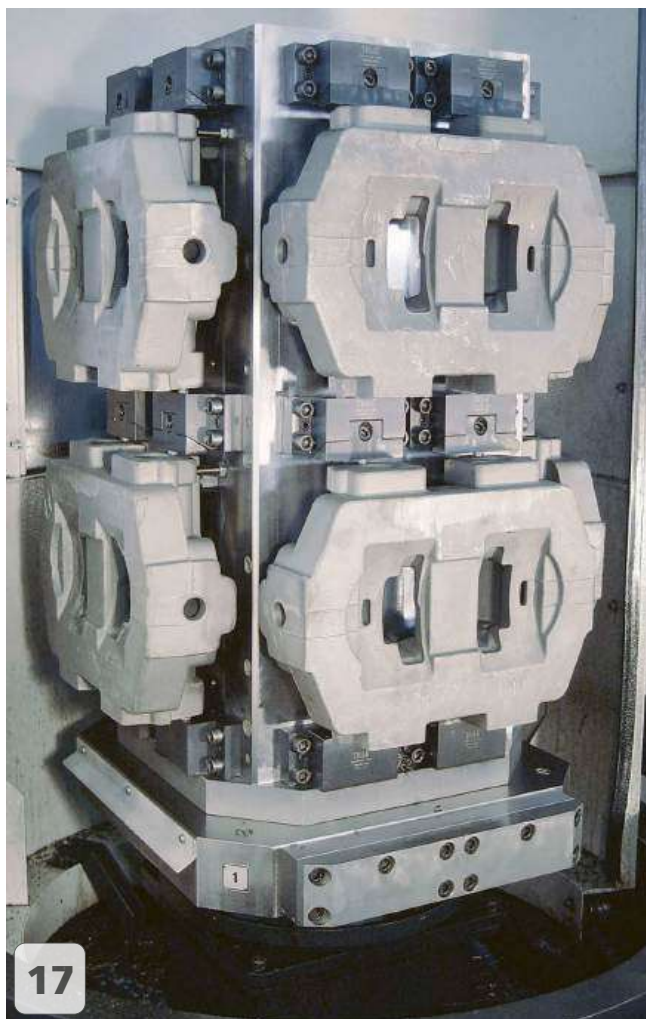
Hohe Spanndichte für Werkstücke in grossen Stückzahlen.
High density fixture plates for repeating orders in high quantities

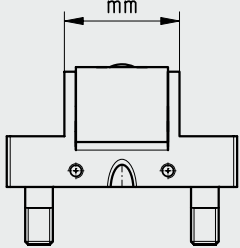
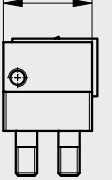
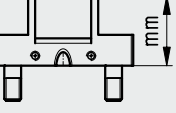










System System		bei Anschlagmodulen for end module		Modulnutzbreite Module clamping width		Modulnutztiefe / -höhe Module clamping depth or height	
A	Apto Clamp	N	nitriert nitrided	19		MS: Tiefe Depth	
P	Power Clamp	D	durchgehärtet through hardened	25			
C	Compact Clamp	bei Spannmodulen for vice modules		26			
M	Micro Clamp	1	Anzahl Spannbacken Number of jaws	34			
V	Vorrichtungsbau module Workholding modules for dedicated fixtures	2		43			
		3		48			
		-	keine Spannbacke no clamping jaw	58		VS: Höhe Height	
				61			
				68			
				78			
				94			
				125			

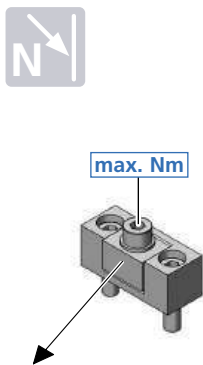
M S 1 F 35 N 14 -01

Modultyp Type of module		Anschlagfläche der Module Datum face		Backenhub Stroke of clamping jaw		Spannbackentyp Type of clamping jaw	
A	Anschlagmodul End module	F	Anschlagfläche glatt Datum face flat	N	Niederzug Pull down	B01	Spannbacke Clamping jaw
S	Spannmodul Clamping module	R	Anschlagfläche geriffelt Datum face double serrated	L	linear / parallel linear / parallel	B151	Modul ohne Spannbacken Module without clamping jaw
T	Trägermodul Supporting module	D	eine Seite glatt, eine Seite geriffelt one face flat, one face double serrated	-	ohne Spannbacke no clamping jaw	-01	
R	Rohling / Rundes Modul Blank / Round module	G	Anschlagfläche gerillt Datum face serrated			-150	
V	Vertikalspannmodul Vertical clamp	X	spezielle Ausführung special execution				
		5X	5axes Clamp				
		P	prägen stamping				

ACHTUNG / CAUTION

WICHTIG: Die im Micro Clamp Kapitel angegebenen Drehmomente sind die absoluten Maximalwerte. Über die Spannkraften gibt die untenstehende Tabelle Auskunft.

IMPORTANT: The torque numbers specified in the Micro Clamp chapter represent the absolute maximum. The table at the bottom of this page provides further information on the workholding forces.

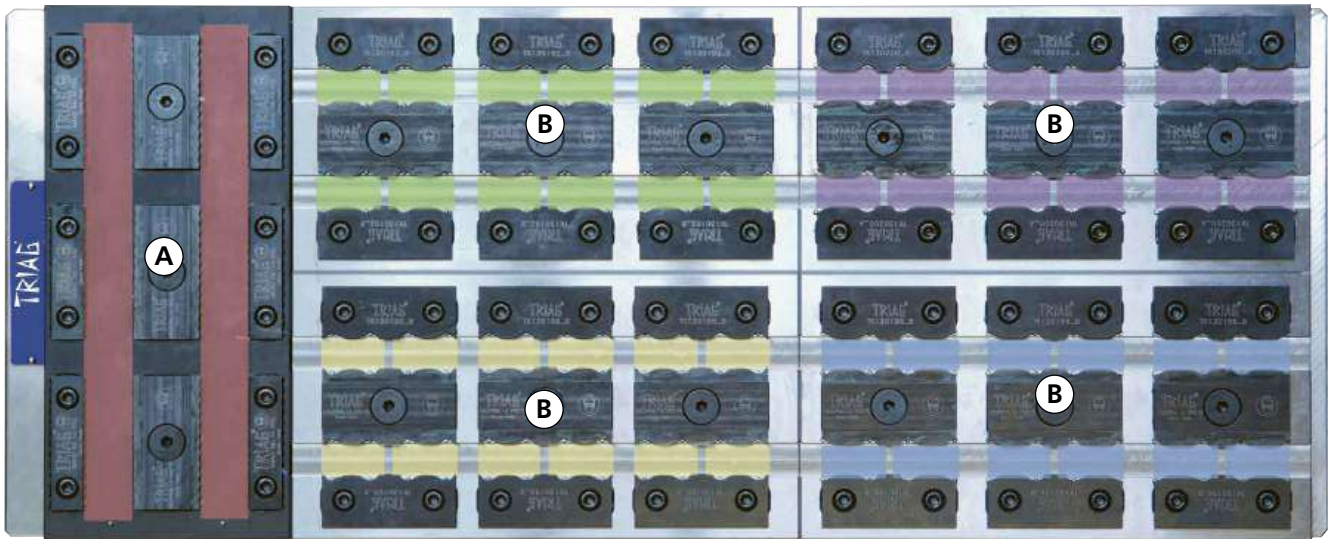
Niederzug-Spannmodule Pull down module	MC-Module	Schraube Screw	Drehmoment Torque		Spannkraft Workholding force		
			Nm	(lb-ft)	~daN	~(lb)	~t
	MR1F 30N23 -07	M5	10	7,4	= 1020	2250	1,02
	MS1F 22N40 -07		10	7,4	= 1020	2250	1,02
	MS1F 24N22 -07		10	7,4	= 1020	2250	1,02
	MS1R/F 25N25 -13	M6	15	11	= 1520	3350	1,52
	MS1F 35N14 -01	M5	10	7,4	= 1020	2250	1,02
	MS1F 35N22 -01		10	7,4	= 1020	2250	1,02
	MS2X 35N23 -01		10	7,4	= 1020	2250	1,02
	MS2F 60N14 -01		10	7,4	= 1020	2250	1,02
	MS3F 85N14 -01		10	7,4	= 1020	2250	1,02
	VS1R 19N35 -20	M6	15	11	= 1520	3350	1,52
	VS1R 26N35 -26	M8	25	18,4	= 2100	4630	2,10
	VS1R 38N50 -60		25	18,4	= 2100	4630	2,10
	VS1R/F 41N30 -60		25	18,4	= 2100	4630	2,10
	VS1R/F 80N30 -36		25	18,4	= 2100	4630	2,10
	VS1R 80N50 -36		25	18,4	= 2100	4630	2,10
	VS1R/F 80N30 -60		25	18,4	= 2100	4630	2,10
	VS1R 80N50 -60		25	18,4	= 2100	4630	2,10
	VS1R/F 125N49 -95	M10	40	29,5	= 2800	6170	2,80
	VS2R 80N30 -60		25	18,4	= 2100	4630	2,10
	VS2F 90N30 -60		25	18,4	= 2100	4630	2,10
Linear-Spannmodule Linear module	MS1F (MS1R) 35L14 -152	M6x0,5	10	7,4	= 570	1260	0,57
	MS2P (MS1P) 58L14 PRG15	M8	15	11	= 600	1320	0,6
	MS2F (MS1F) 58L14 W251		15	11	= 600	1320	0,6
	VS1R 26L35 -31		25	18,4	= 2100	4630	2,10
	VS1R/F 41L30 -51		25	18,4	= 2100	4630	2,10
	VS1R/F 80L30 -51		25	18,4	= 2100	4630	2,10
	VS1X 68L20 -105		40	29,6	= 1600	3530	1,60
	VS1X 59L60 K	M10	50	37	= 1880	4140	1,88
	VS1X 59L60 H5		50	37	= 1640	3620	1,64



Schraube Screw	Drehmoment Torque		Spannkraft Workholding force		
M5 + M6	4	3	= 500	1100	0,50
	5	3,7	= 580	1280	0,58
	6	4,4	= 690	1520	0,69
	7	5,2	= 780	1720	0,78
	8	5,9	= 880	1940	0,88
	9	6,6	= 980	2160	0,98
M6	10	7,4	= 1020	2250	1,02
	12	8,9	= 1220	2690	1,22
	14	10,4	= 1450	3200	1,45
M8	15	11	= 1520	3350	1,52
	4	3	= 410	900	0,41
	5	3,7	= 490	1080	0,49
	6	4,4	= 560	1250	0,56
	7	5,2	= 660	1460	0,66
	8	5,9	= 730	1610	0,73
	9	6,6	= 810	1790	0,81
	10	7,4	= 900	1980	0,90
M10	15	11	= 1520	3350	1,52
	20	14,8	= 1810	3990	1,81
	25	18,4	= 2100	4630	2,10
	10	7,4	= 400	880	0,40
	20	14,8	= 1400	3090	1,40
M10	30	22,1	= 2000	4410	2,00
	40	29,5	= 2800	6170	2,80

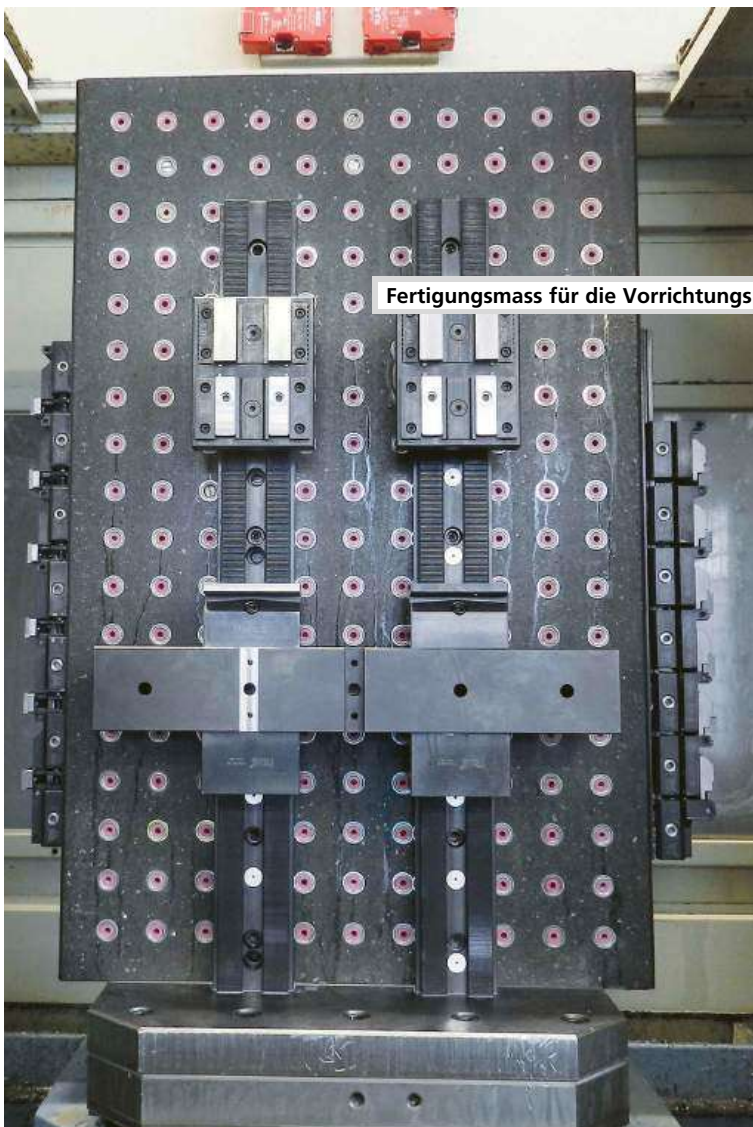
Keilspanner in weicher Ausführung zum Bearbeiten von Formbacken.

Double angle clamps with soft jaws for making shaped forms.



A Prägebacken Spanntiefe 1,8 mm
 12 Werkstücke werden hergestellt
*First clamp 12 parts with stamping jaws
 clamping depth 1,8 mm*

B 4 x 12 verschiedene Teile werden in der
 2. Spannung bearbeitet
*4 times 12 different parts are machined
 in the second operation*



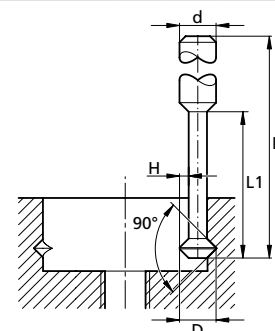
Fertigungsmass für die Vorrichtungsplatte: / Machining data for the fixture plate: p. 175

Fräser / Milling cutter

Der abgebildete Fräser benötigt man für die Herstellung der «Kerben».
 Siehe Fertigungsmasse für die Vorrichtungsplatte Seite 175.

*The illustrated milling cutter is required for the production of "notches".
 Manufacturing drawing for the fixture plate on page 175.*

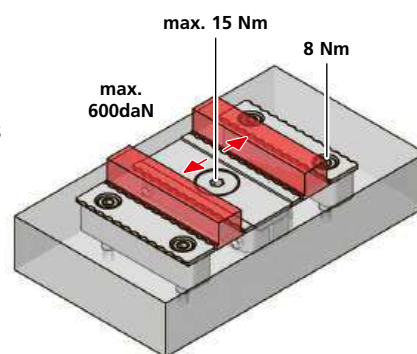
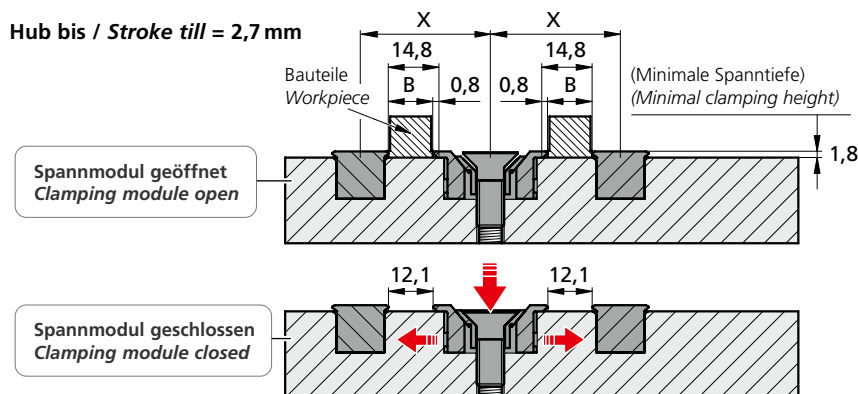
45°	d	D	L1	H	z	L
TK150057	6	6,0	24,0	1,5	3	58



Fertigungsmasse für die Vorrichtungplatte / Machining data for the fixture plate

MS2P/F 58L14... Mass X (X1) = B + 24 mm Beispiel: Bauteilbreite = 14 mm Taschenabstand X = 14 + 24 = 38 Das ergibt eine Einlegeluft von 0,8 mm (Hub bis 2,7 mm)	Dimension X (X1) = B + 24 mm Example: Width of component part = 14 mm Distance of pocket X = 14 + 24 = 38 This makes a play of 0,8 mm (stroke till 2,7 mm)
MS1P/F 58L14... Mass X2 = B + 33,5 mm Beispiel: Bauteilbreite = 14 mm Taschenabstand X = 14 + 33,5 = 47,5 Das ergibt eine Einlegeluft von 0,8 mm (Hub bis 2,7 mm)	Dimension X2 = B + 33,5 mm Example: Width of component part = 14 mm Distance of pocket X = 14 + 33,5 = 47,5 This makes a play of 0,8 mm (stroke till 2,7 mm)

Hub bis / Stroke till = 2,7 mm



MS2P58L14PRG15

- 1 2x TK120225
- 2 1x TK120227
- 3 1x M8X22DIN7991
- Y 4,7 mm
- i 57HRC
- kg ~0,12

MS1P58L14PRG15

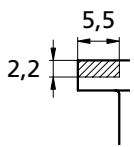
- 1 1x TK120225
- 2 1x TK120721
- 3 1x M8X22DIN7991
- 4 1x TK120720
- Y 4,7 mm
- i 57HRC
- kg ~0,12

MAND58-14PRG

- 1 1x TK120226
- 3 2x M5X16ISO4762
- Y 4,7 mm
- i 57HRC
- kg ~0,08

MAND58-14PRG6

- 1 1x TB150282
- 3 2x M5X16ISO4762
- Y 6,0 mm
- i 57HRC
- kg ~0,08



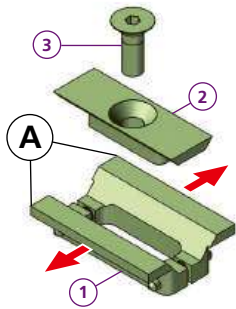
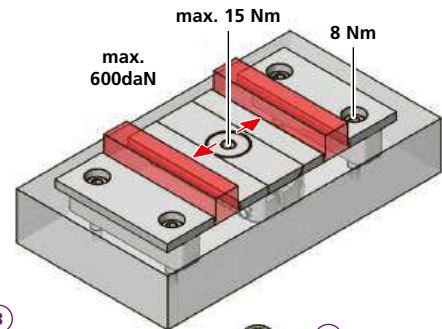
Zum Erstellen Ihrer individuellen Formbacke:

Schnittzeichnung zum Ermitteln der maximalen Bearbeitungsprofiltiefe

If a dedicated jaw is being machined:

Sectional drawing to determine the maximum machining depth

für / for TK120531 | TK120531 | TK120529 | TK160554

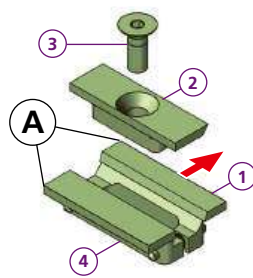


MS2F58L14W251

- 1 2x TK120531
- 2 1x TK120227
- 3 1x M8X22DIN7991

i *

kg ~0,12

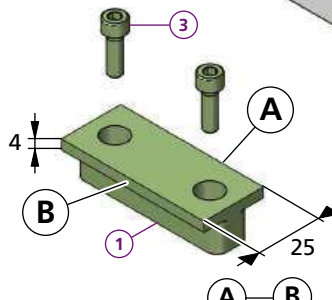


MS1F58L14W251

- 1 1x TK120531
- 2 1x TK120721
- 3 1x M8X22DIN7991
- 4 1x TH130566

i *

kg ~0,12



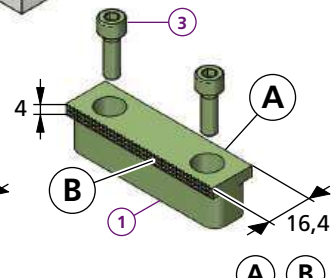
MANF58-14W25

- 1 1x TK120529
- 3 2x M5X16ISO4762
- i *

MANF58-14F25

- 1 1x TK150033
- 3 2x M5X16ISO4762
- i HV700 x 0,2mm

kg ~0,11



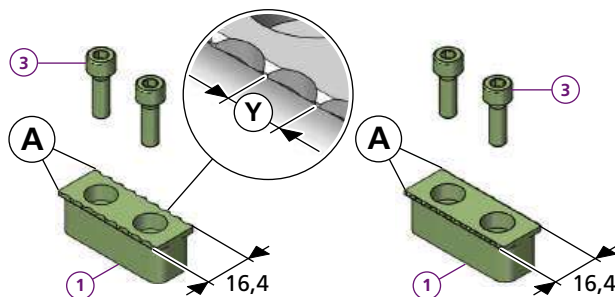
MANF58-14RF

- 1 1x TB160563
- 3 2x M5X16ISO4762

i HV700 x 0,2mm

kg ~0,11

p. 175 Fertigungsmass für die Vorrichtungplatte: / Machining data for the fixture plate:

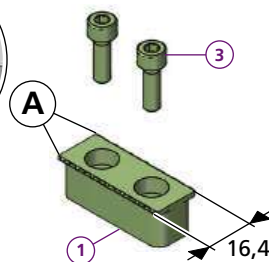


MAND38-14PRG

- 1 1x TK150234
- 3 2x M5X16ISO4762
- Y 4,7 mm

i 57HRC

kg ~0,08

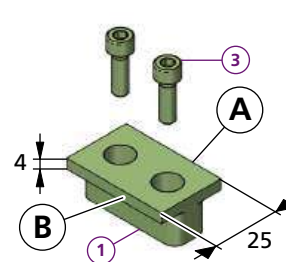


MAND38-14PRG6

- 1 1x TB150283
- 3 2x M5X16ISO4762
- Y 6,0 mm

i 57HRC

kg ~0,08



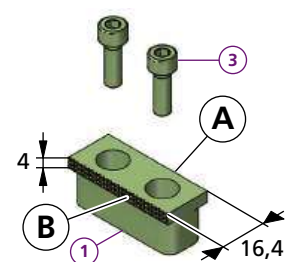
MANF38-14W25

- 1 1x TK160554
- 3 2x M5X16ISO4762
- i *

MANF38-14F25

- 1 1x TK160553
- 3 2x M5X16ISO4762
- i HV700 x 0,2mm

kg ~0,08



MANF38-14RF

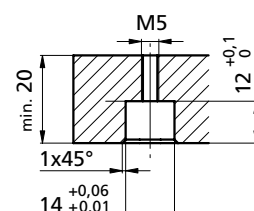
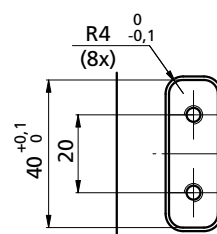
- 1 1x TB170062
- 3 2x M5X16ISO4762

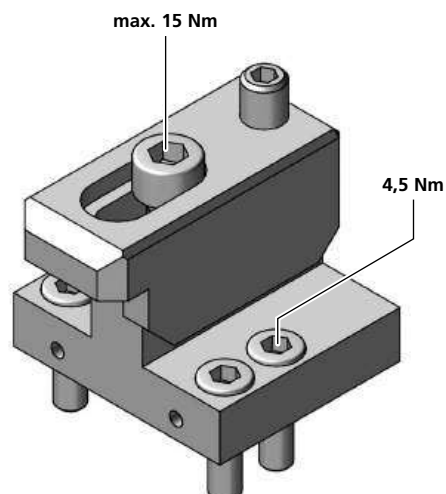
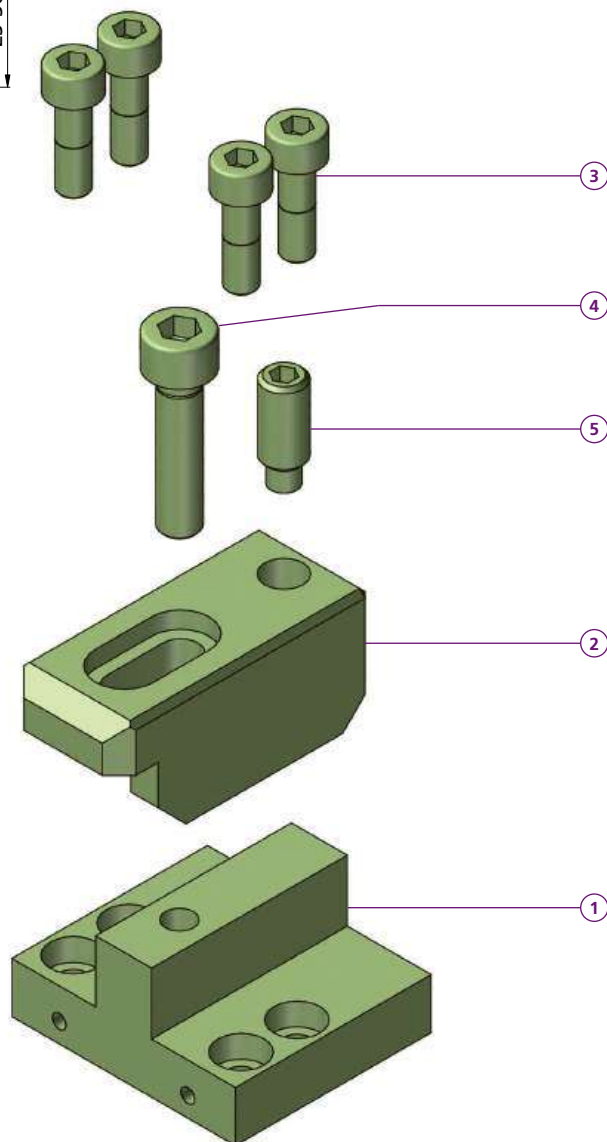
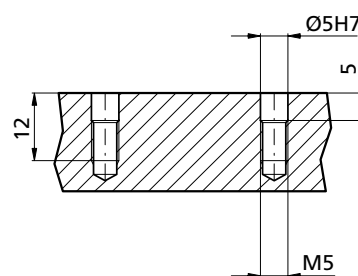
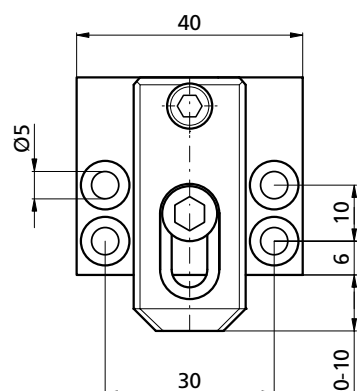
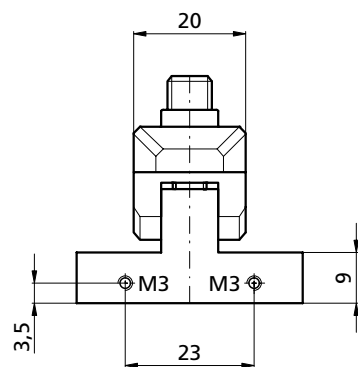
i HV700 x 0,2mm

kg ~0,08

Fertigungsmass für die Vorrichtungplatte
Machining data for the fixture plate

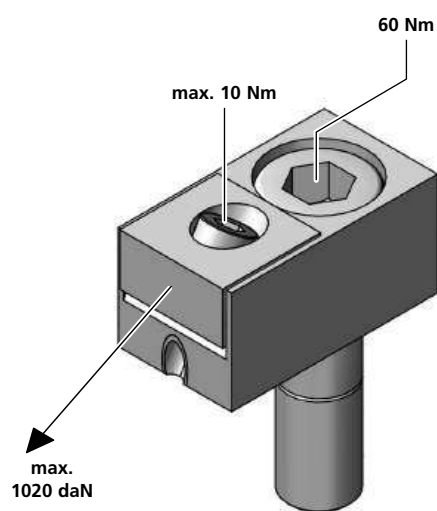
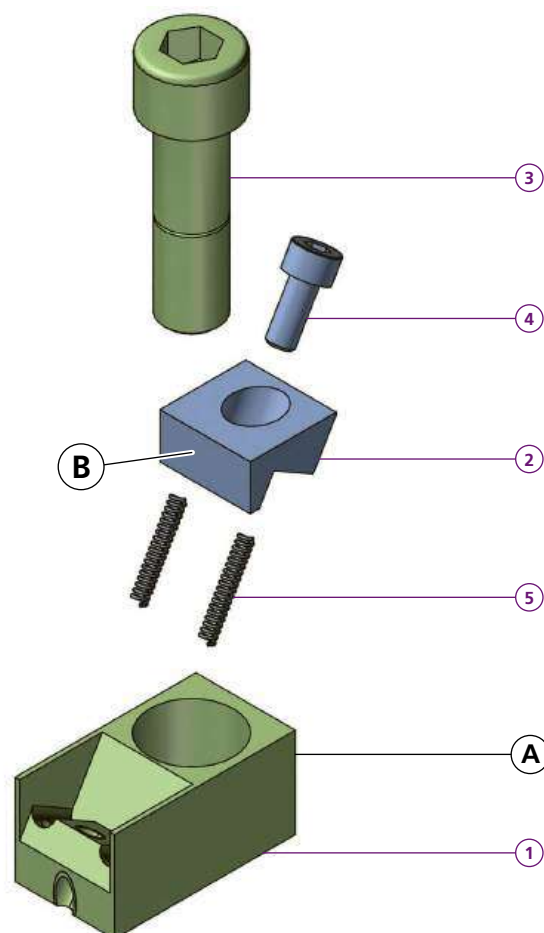
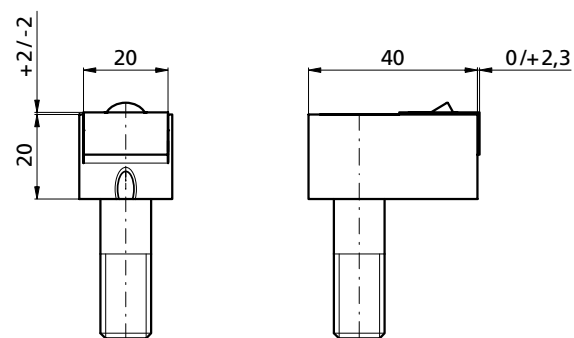
für / for TB150234 | TB150283 | TK160554 | TK160553 | TB170062





MV1F20L35BV1

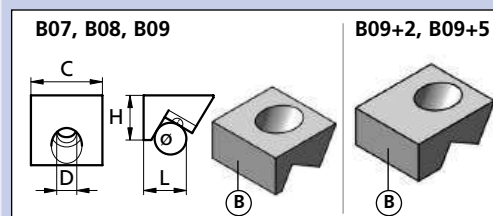
- 1 1x TF140710
 - 2 1x BV1
 - 3 4x M5S0
 - 4 1x M6X25ISO4762
 - 5 1x M8x20ISO4028
- kg ~0,225



MS1F22N40-07	
1	1x TF140712
2	1x
3	1x TWPAS1240
4	1x M5X12ISO4762
5	2x FED03018
kg	~0,15

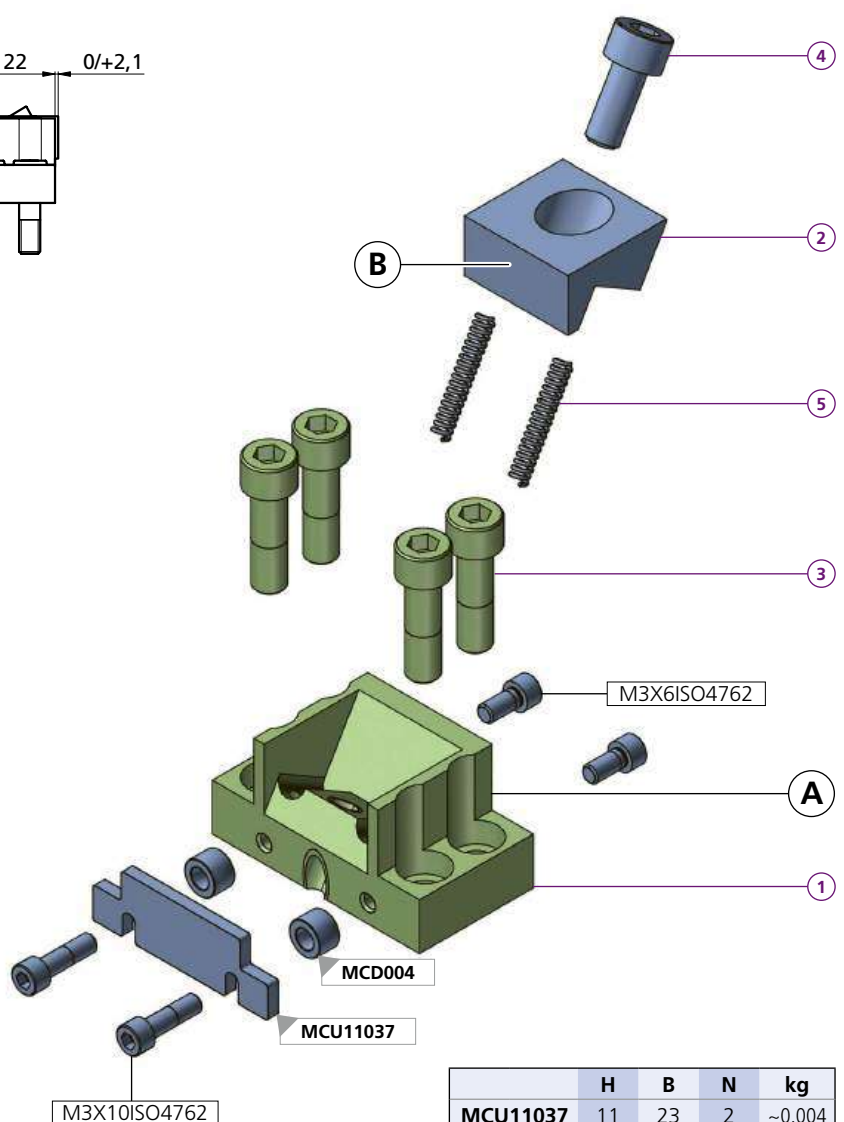
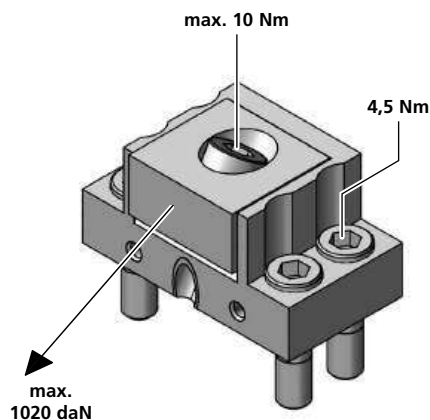
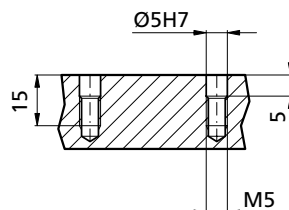
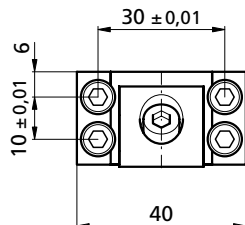
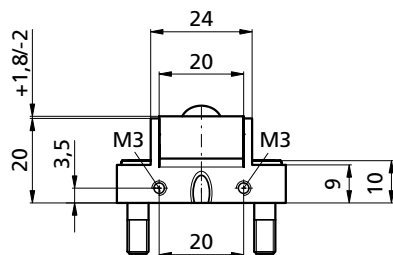
	B07	B08	B09	B09+2	B09+5
C	20	20	20	20	20
H	10	10	10	10	10
L	9,5	9,5	9,5	11,5	14,5
D	5,5	5,5	5,5	5,5	5,5
ø	6	6	6	6	6
i	HV700 x0,2mm	HV700 x0,2mm	*	*	*
kg	~0,02	~0,02	~0,02	~0,02	~0,02

Bestellbeispiel / Ordering example: 1x MS1F22N40-07 & 1x B08



* = weicher Stahl / soft steel

Separat bestellen / Order separately



	H	B	N	kg
MCU11037	11	23	2	~0,004
MCU15037	15	23	2	~0,006
MCU18037	18	23	2	~0,008
MCU20037	20	23	2	~0,008
MCU22537	22,5	23	2	~0,008

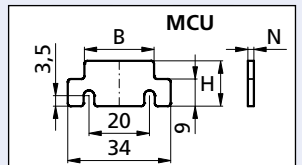
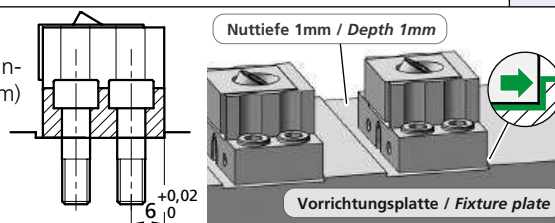
2x M3X10ISO4762

2x M3X6ISO4762

2x MCD004

Achtung: Bei Spannkraften über 400 daN (0,4t) muss das Spannmodul in eine Nut eingelassen werden (Nuttiefe mindestens 1mm)

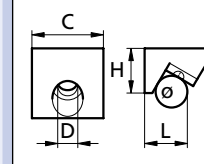
Remark: Using forces higher than 400 daN, clamps must be mounted into a slot (depth minimum 1mm)



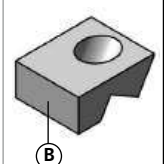
MS1F24N22-07	
1	1x TF140713
MS1R24N22-07	
1	1x TW100172-01
2	1x
3	4x MS50
4	1x M5X12ISO4762
5	2x FED03018
kg	~0,125

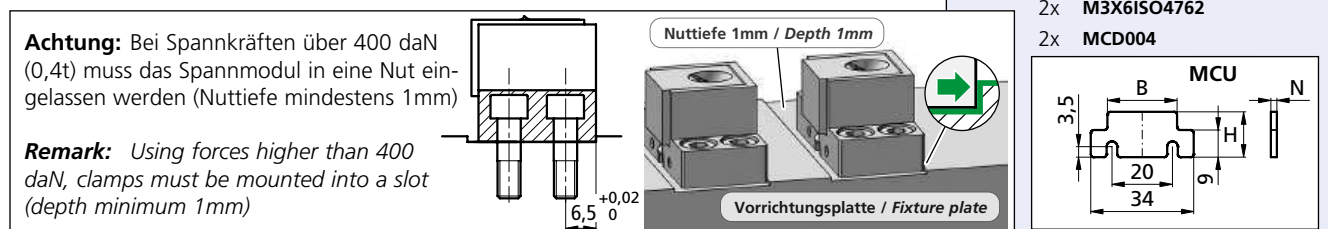
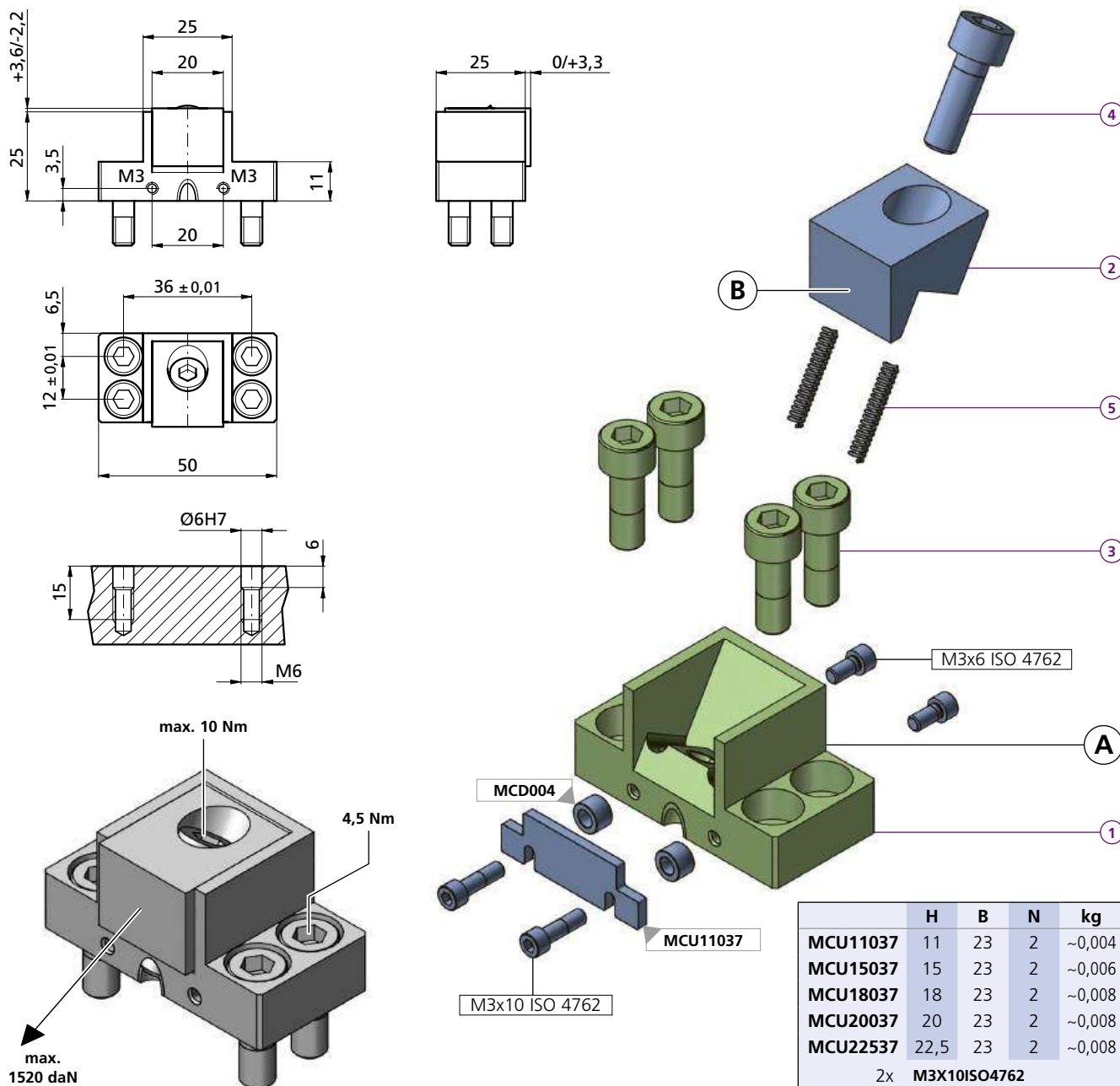
Bestellbeispiel / Ordering example: 1x MS1F24N22-07 & 1x B08					
	B07	B08	B09	B09+2	B09+5
C	20	20	20	20	20
H	10	10	10	10	10
L	9,5	9,5	9,5	11,5	14,5
D	5,5	5,5	5,5	5,5	5,5
ø	6	6	6	6	6
i	HV700	HV700	*	*	*
	x0,2mm	x0,2mm			
kg	~0,02	~0,02	~0,02	~0,02	~0,02

B07, B08, B09



B09+2, B09+5

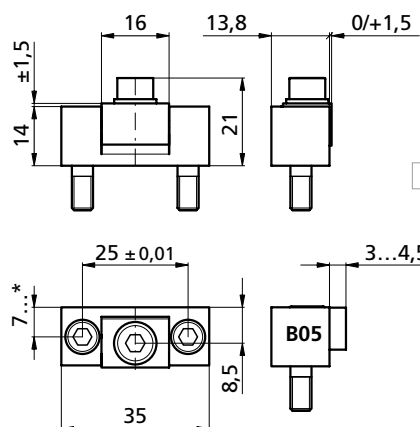




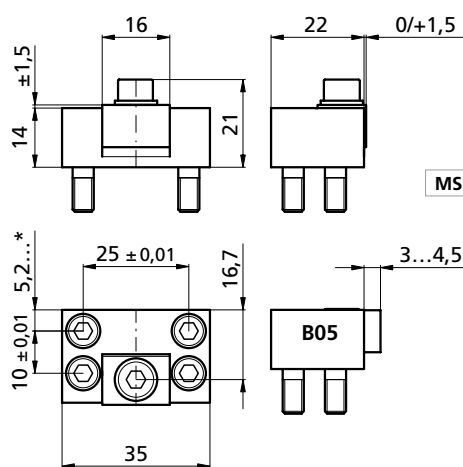
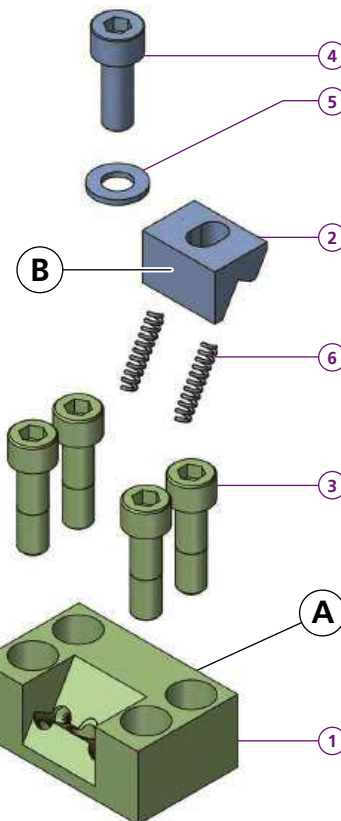
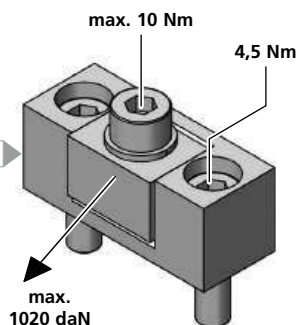
MS1F25N25-13		Bestellbeispiel / Ordering example: 1x MS1F25N25-13 & 1x B14			
1	1x TF140714	B13	B14	B15	B16
1	1x TF140715	C	20	20	20
2	1x	H	16	16	16
3	4x MS60	L	13,8	13,8	19
4	1x M6X16ISO4762	D	6,5	6,5	6,5
5	2x FED03018	e	10	10	10
		i	HV700	HV700	*
			x0,2mm	x0,2mm	*
kg	~0,165	kg	~0,05	~0,05	~0,05

* = weicher Stahl / soft steel

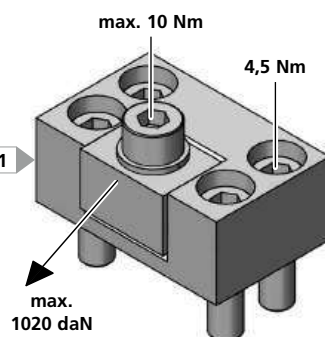
Diagram showing dimensions C, H, D, L for the clamps B13, B14, B15, and B16.



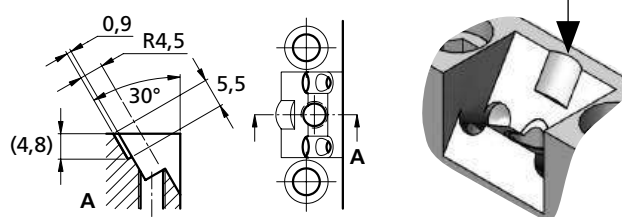
MS1F35N14-01



MS1F35N22-01

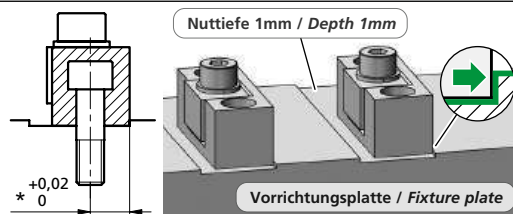
**Beim Einsatz der Backe B05(R) Jaw B05(R) in use**

Nachbearbeitung am Modul, falls der gesamte Backenhub (1,1mm bis 1,5mm) benötigt wird.
If a stroke of 1,1mm to 1,5mm is required the module must be machined according to this sketch.



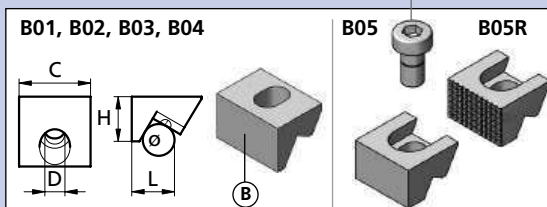
Achtung: Bei Spannkraften über 400 daN (0,4t) muss das Spannmodul in eine Nut eingelassen werden (Nuttiefe mindestens 1mm)

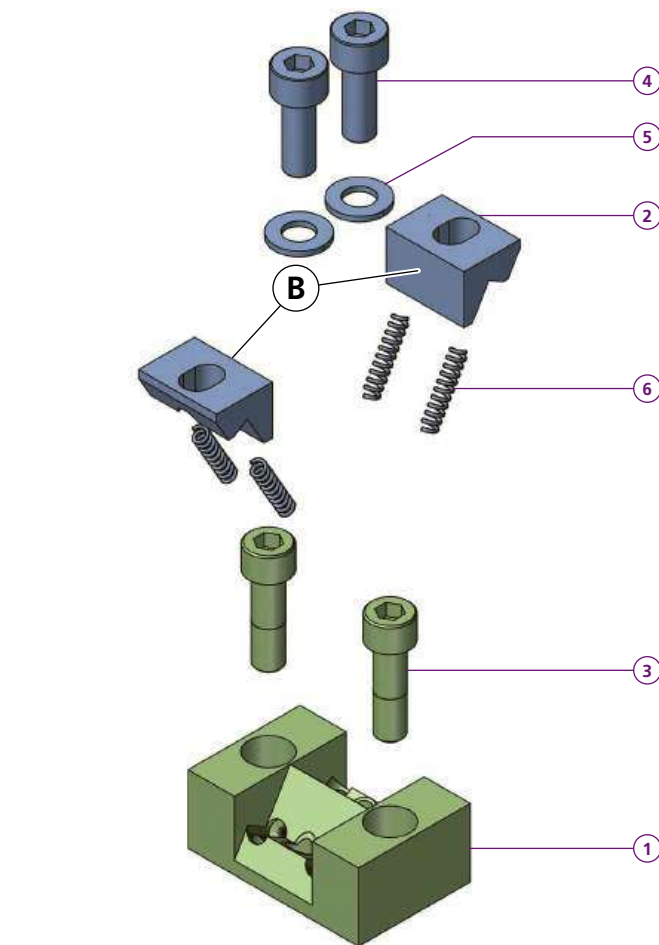
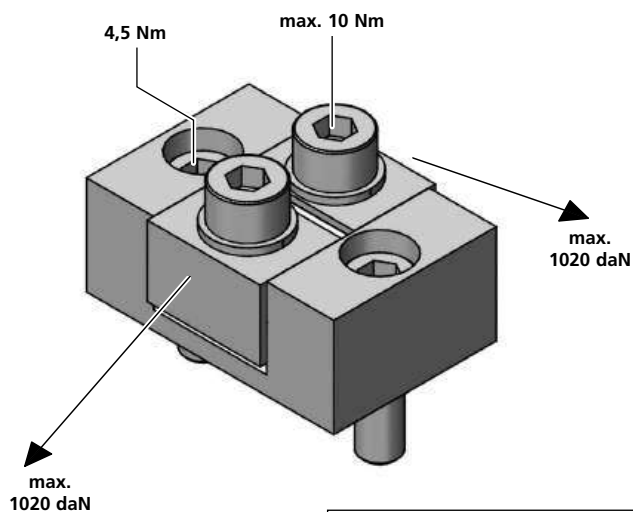
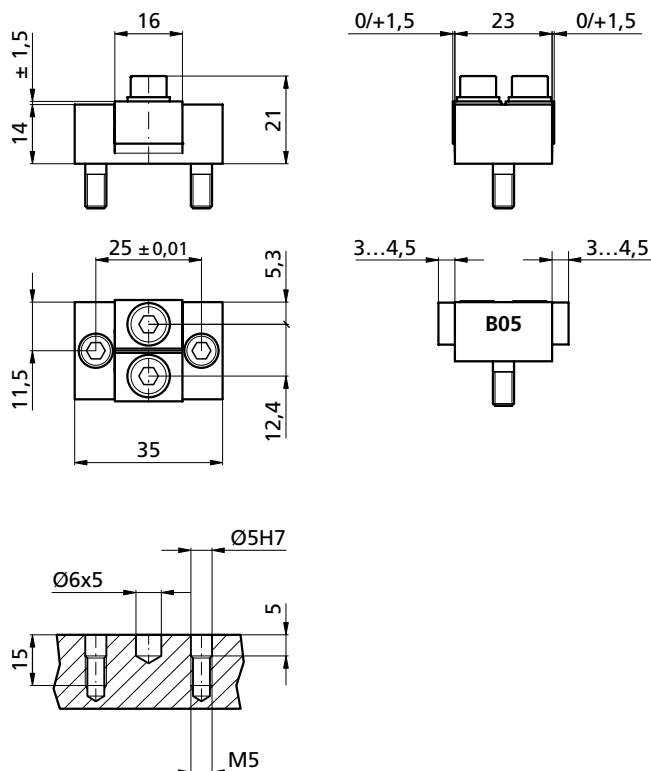
Remark: Using forces higher than 400 daN, clamps must be mounted into a slot (depth minimum 1mm)



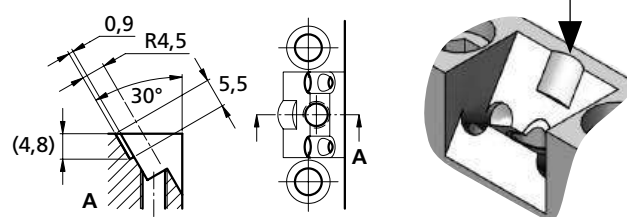
MS1F35N14-01	
1	1x TF140718
MS1R35N14-01	
1	1x TK190150
2	1x
3	2x MS50
4	1x M5X14ISO4762
5	1x 5x10x1DIN125A
6	2x FED02813
kg	~0,05
MS1F35N22-01	
1	1x TF140719
3	4x MS50
kg	~0,08

Bestellbeispiel / Ordering example: 1x MS1F35N14-01 & 1x B02						
	B01	B02	B03	B04	B05	B05R
(C)	16	16	16	16	16	16
(H)	10	10	10	10	10	10
(L)	8	8	11	8	10	10
(D)	5,5	5,5	5,5	5,5	5,2	5,2
(e)	4	4	4	4	4	4
(i)	HV700	HV700	*	Messing	HV700	HV700
	x0,2mm	x0,2mm		Laiton	x0,2mm	x0,2mm
kg	~0,01	~0,01	~0,014	~0,012	~0,014	~0,014



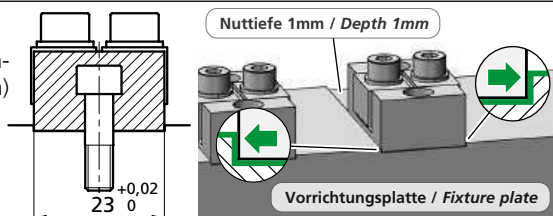
**Beim Einsatz der Backe B05(R) Jaw B05(R) in use**

Nachbearbeitung am Modul, falls If a stroke of 1,1mm to 1,5mm der gesamte Backenhub (1,1mm bis is required the module must be 1,5mm) benötigt wird. machined according to this sketch.



Achtung: Bei Spannkraften über 400 daN (0,4t) muss das Spannmodul in eine Nut eingelassen werden (Nuttiefe mindestens 1mm)

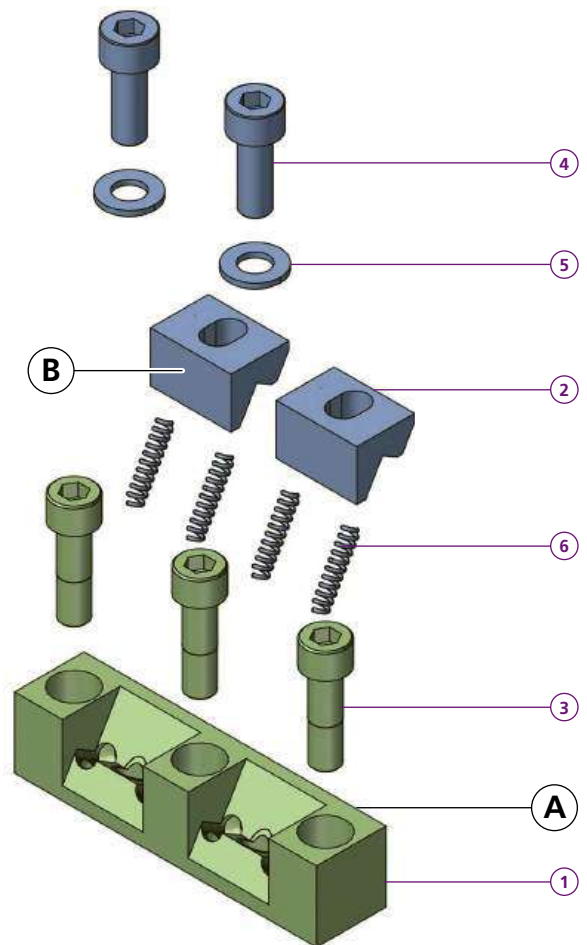
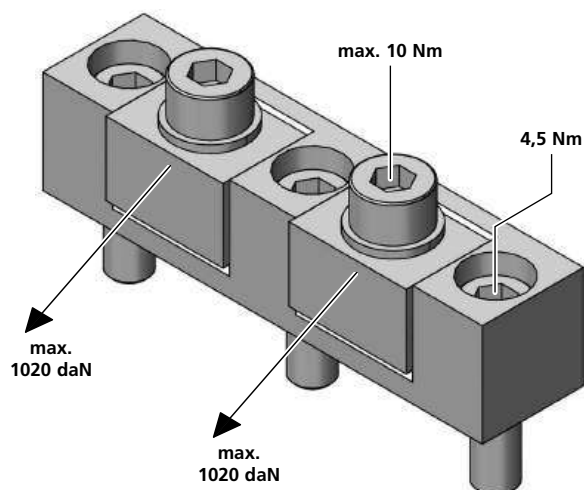
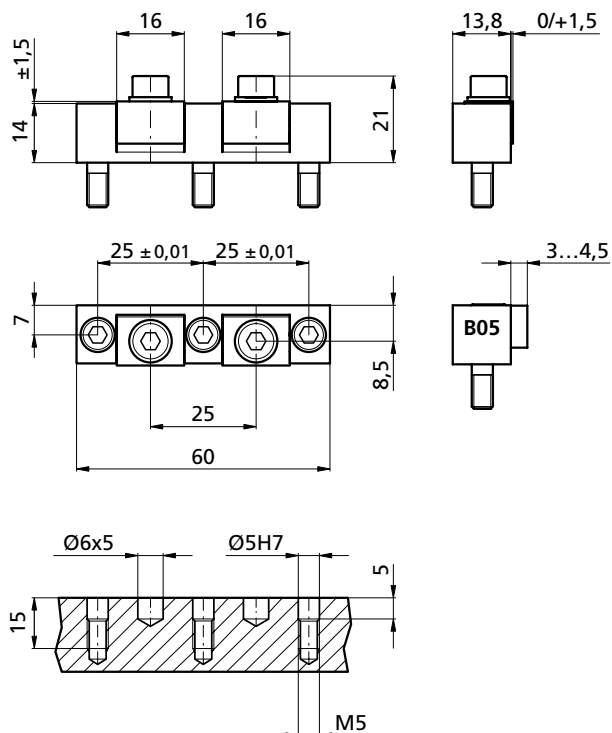
Remark: Using forces higher than 400 daN, clamps must be mounted into a slot (depth minimum 1mm)



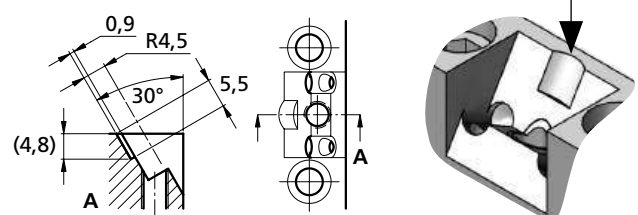
MS2X35N23-01	
1	1x TF140720
2	2x —
3	2x MS50
4	2x M5X14ISO4762
5	2x 5x10x1DIN125A
6	4x FED02813
kg	~0,085

Bestellbeispiel / Ordering example: 1x MS2X35N23-01 & 2x B02						
	B01	B02	B03	B04	B05	B05R
(C)	16	16	16	16	16	16
(H)	10	10	10	10	10	10
(L)	8	8	11	8	10	10
(D)	5,5	5,5	5,5	5,5	5,2	5,2
(e)	4	4	4	4	4	4
(i)	HV700	HV700	*	Messing	HV700	HV700
	x0,2mm	x0,2mm		Laiton	x0,2mm	x0,2mm
kg	~0,01	~0,01	~0,014	~0,012	~0,014	~0,014

* = weicher Stahl / soft steel

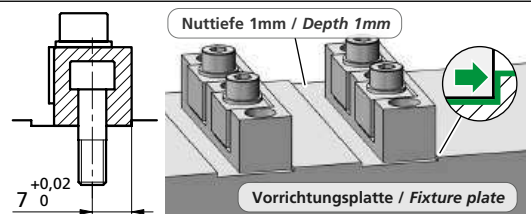
**Beim Einsatz der Backe B05(R) Jaw B05(R) in use**

Nachbearbeitung am Modul, falls If a stroke of 1,1mm to 1,5mm der gesamte Backenhub (1,1mm bis is required the module must be 1,5mm) benötigt wird. machined according to this sketch.



Achtung: Bei Spannkraften über 400 daN (0,4t) muss das Spannmodul in eine Nut eingelassen werden (Nuttiefe mindestens 1mm)

Remark: Using forces higher than 400 daN, clamps must be mounted into a slot (depth minimum 1mm)

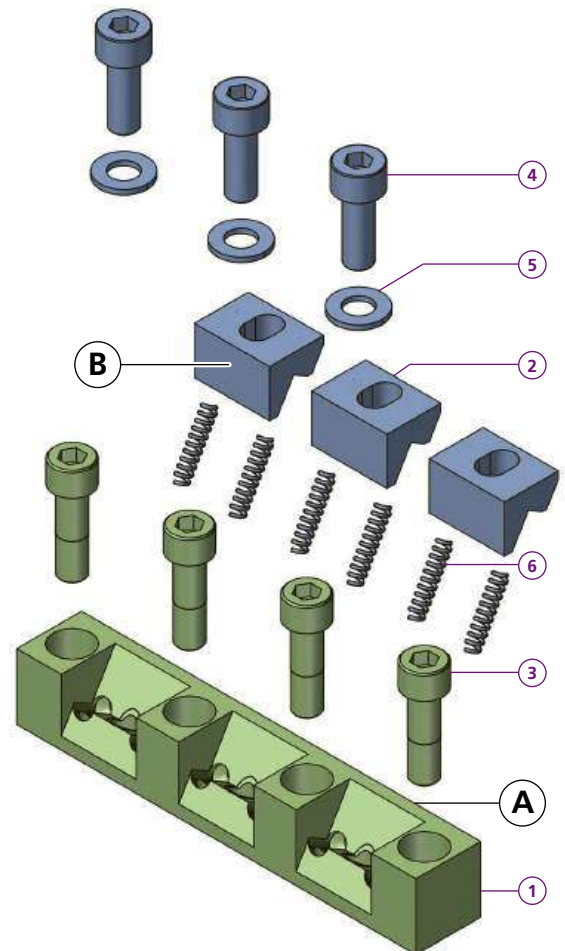
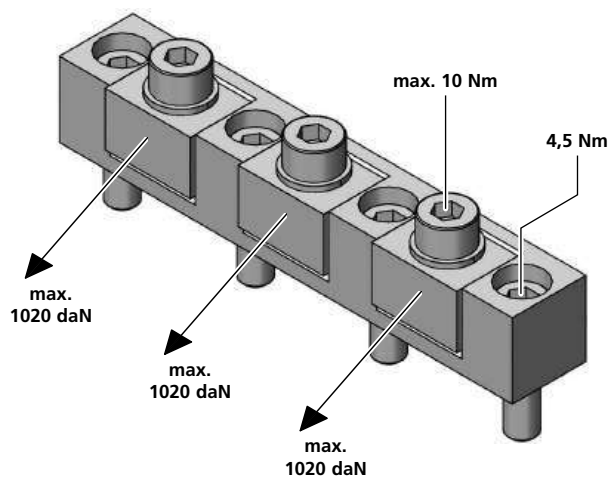
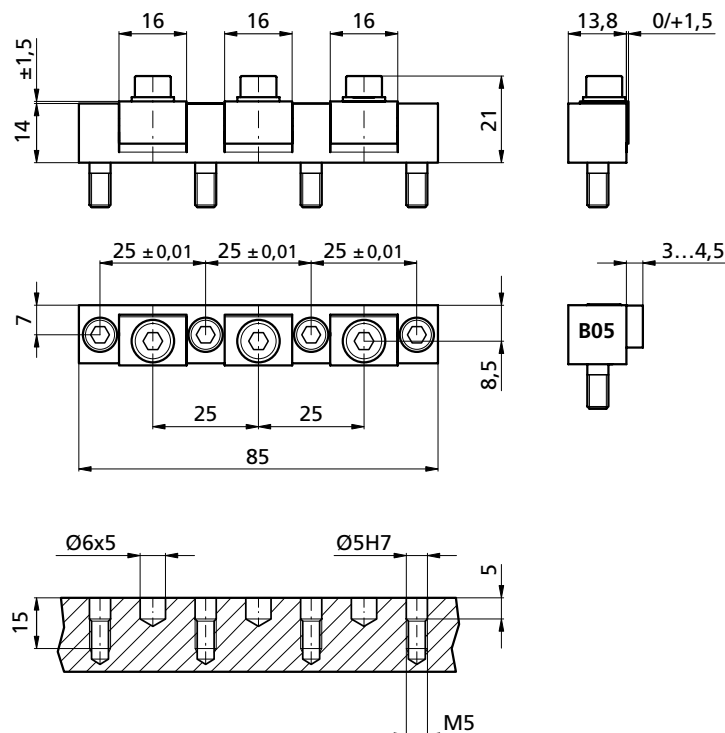


Bestellbeispiel / Ordering example: 1x MS2F60N14-01 & 2x B02

MS2F60N14-01							
1	1x TF140721						
2	2x						
3	3x MS50						
4	2x M5X14ISO4762						
5	2x 5x10x1DIN125A						
6	4x FED02813						
kg	~0,09						

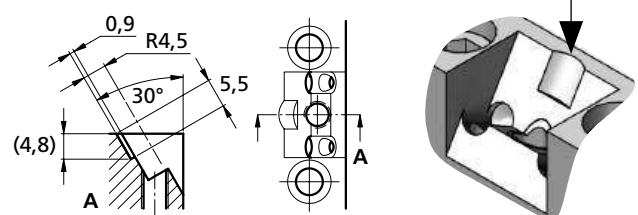
	B01	B02	B03	B04	B05	B05R
C	16	16	16	16	16	16
H	10	10	10	10	10	10
L	8	8	11	8	10	10
D	5,5	5,5	5,5	5,5	5,2	5,2
ø	4	4	4	4	4	4
i	HV700	HV700	*	Messing	HV700	HV700
	x0,2mm	x0,2mm		Laiton	x0,2mm	x0,2mm
kg	~0,01	~0,01	~0,014	~0,012	~0,014	~0,014

B01, B02, B03, B04		B05, B05R	
C	H	C	H
D	L	D	L



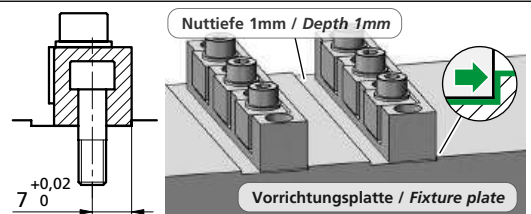
Beim Einsatz der Backe B05(R) Jaw B05(R) in use

Nachbearbeitung am Modul, falls If a stroke of 1,1mm to 1,5mm der gesamte Backenhub (1,1mm bis is required the module must be 1,5mm) benötigt wird. machined according to this sketch.



Achtung: Bei Spannkraften über 400 daN (0,4t) muss das Spannmodul in eine Nut eingelassen werden (Nuttiefe mindestens 1mm)

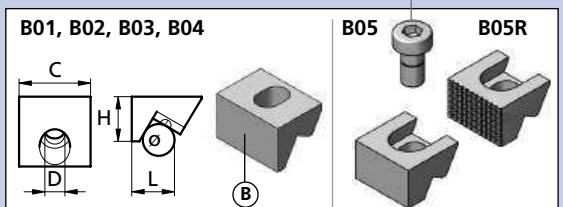
Remark: Using forces higher than 400 daN, clamps must be mounted into a slot (depth minimum 1mm)

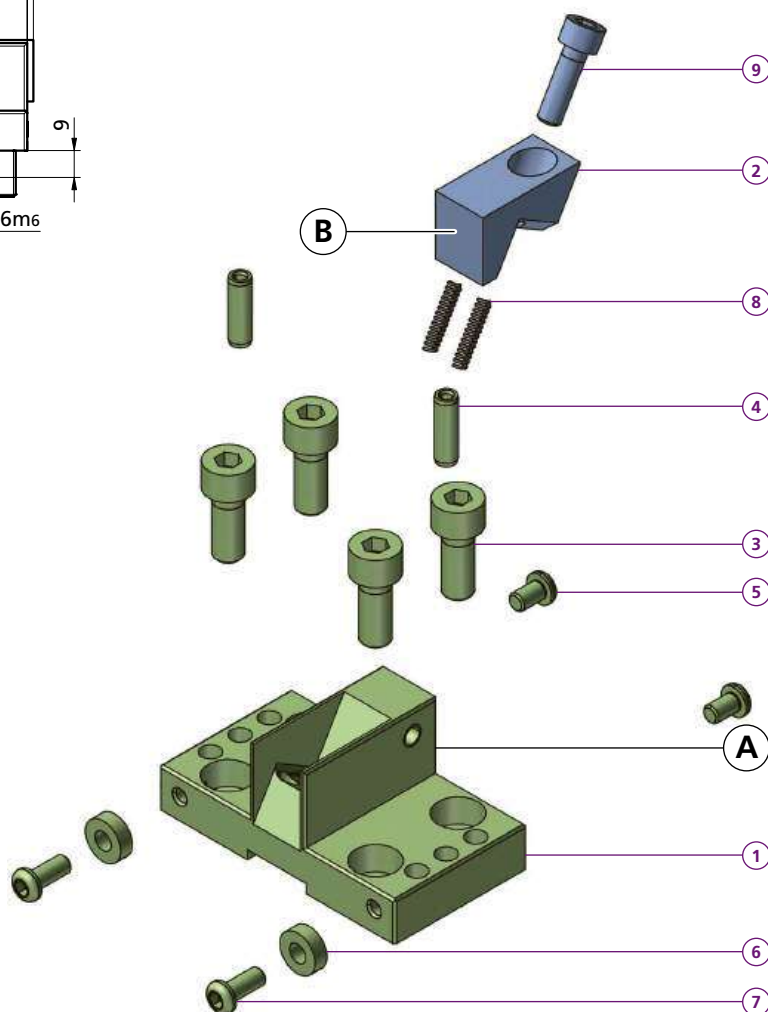
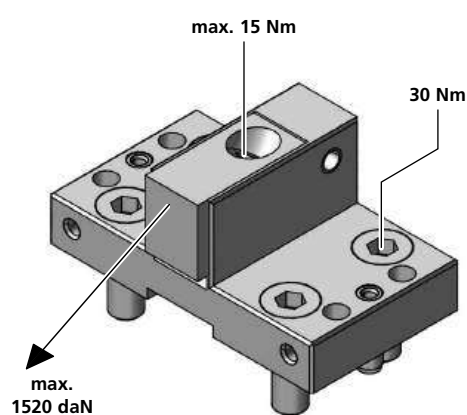
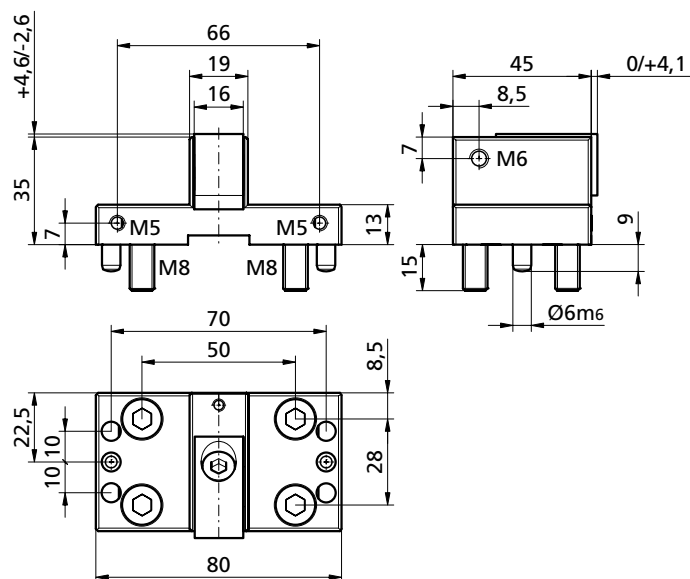


Bestellbeispiel / Ordering example: 1x MS3F85N14-01 & 3x B02

MS3F85N14-01							
1	1x TH160579						
2	3x	B01	B02	B03	B04	B05	B05R
3	4x MS50	16	16	16	16	16	16
4	3x M5X14ISO4762	10	10	10	10	10	10
5	3x 5x10x1DIN125A	8	8	11	8	10	10
6	6x FED02813	5,5	5,5	5,5	5,5	5,2	5,2
		4	4	4	4	4	4
		HV700	HV700	*	Messing	HV700	HV700
		x0,2mm	x0,2mm		Laiton	x0,2mm	x0,2mm
kg	~0,125	kg	~0,01	~0,01	~0,014	~0,012	~0,014

* = weicher Stahl / soft steel

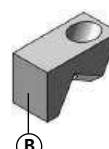
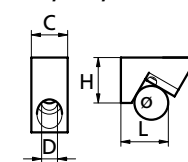




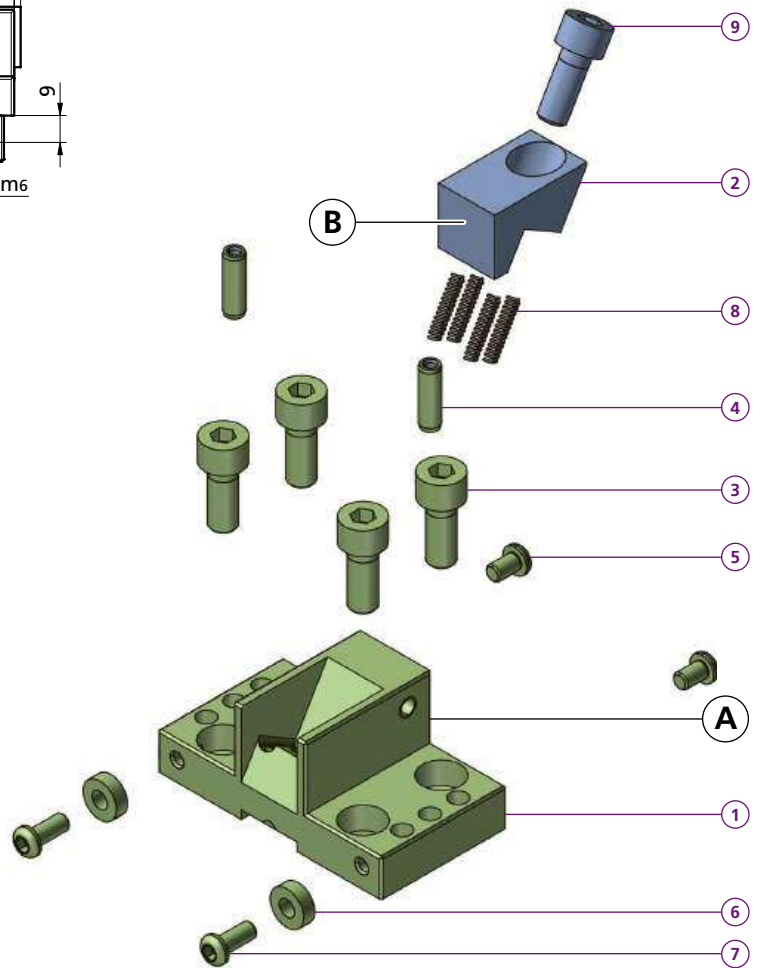
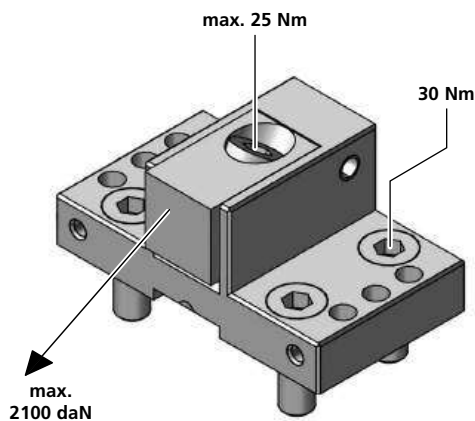
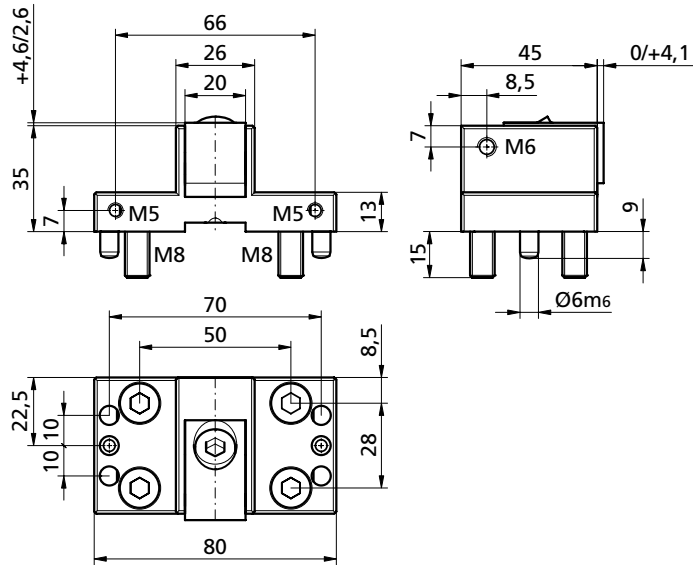
VS1F19N35-20	
1	1x TF150029
VS1R19N35-20	
1	1x TF140723
2	1x
3	4x M8X20ISO4762
4	2x CCBO0802
5	2x M5X8ISO7380
6	2x CCD004
7	2x M5X12ISO7380
8	2x FED0418
9	1x M6X20ISO4762
kg	~0,505

Bestellbeispiel / Ordering example: 1x VS1R19N35-20 & 1x B21			
	B20	B21	B22
C	16	16	16
H	20	20	20
L	19	19	19
D	6,5	6,5	6,5
o	12	12	12
i	HV700 x0,2mm	HV700 x0,2mm	*
kg	~0,011	~0,011	~0,011

B20, B21, B22



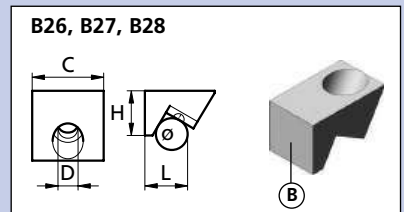
Separat bestellen / Order separately

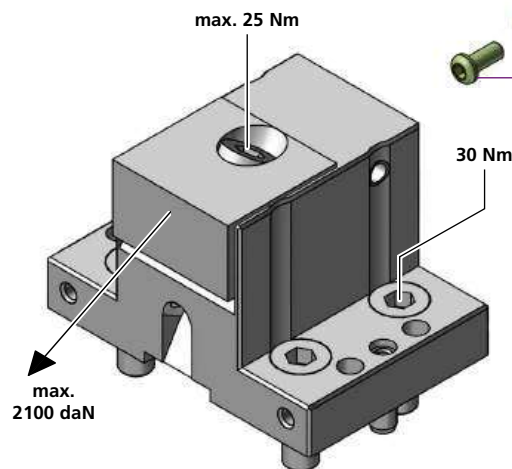
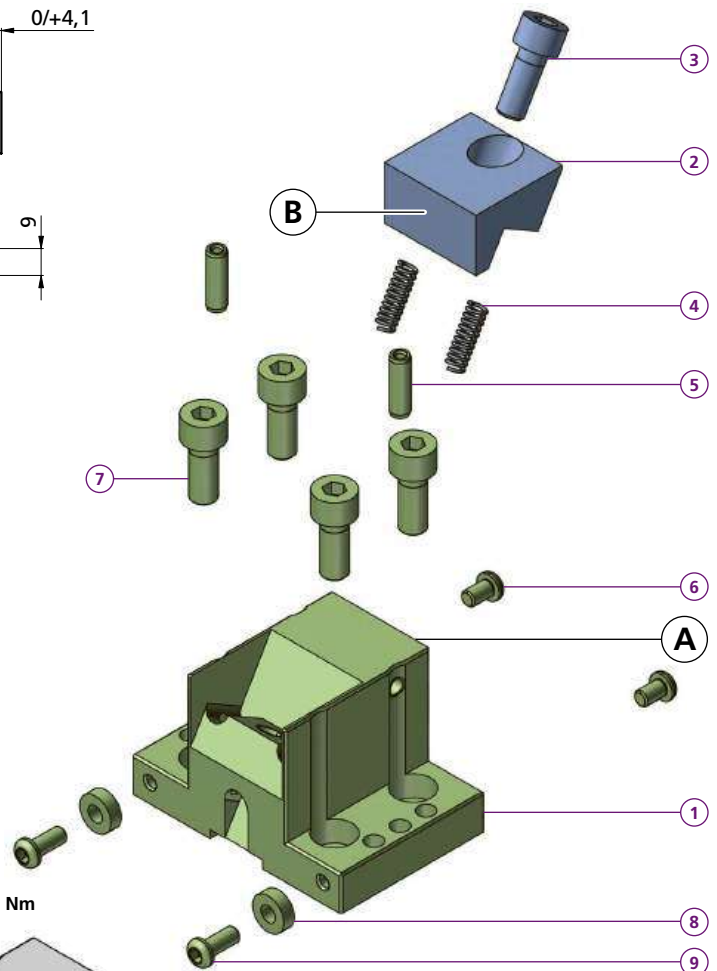
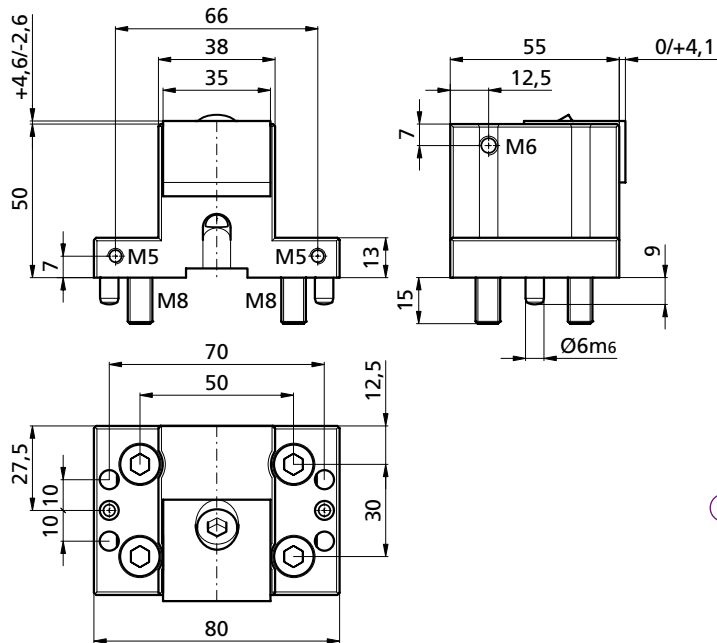


VS1R26N35-26	
1	1x TF140725
2	1x
3	4x M8X20ISO4762
4	2x CCBO0802
5	2x M5X8ISO7380
6	2x CCD004
7	2x M5X12ISO7380
8	4x FED0418
9	1x M8X20ISO4762
kg	~0,55

* = weicher Stahl / soft steel

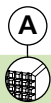
Bestellbeispiel / Ordering example: 1x VS1R26N35-26 & 1x B27			
	B26	B27	B28
C	20	20	20
H	20	20	20
L	19	19	19
D	9	9	9
ø	12	12	12
i	HV700	HV700	*
	x0,2mm	x0,2mm	
kg	~0,064	~0,064	~0,064



**VS1R38N50-60**

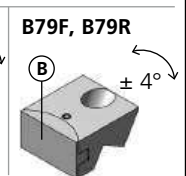
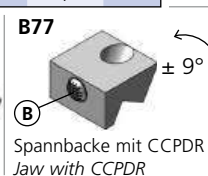
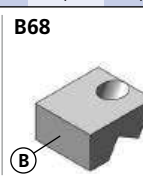
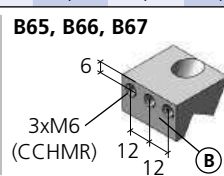
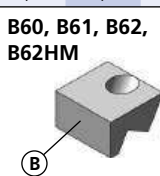
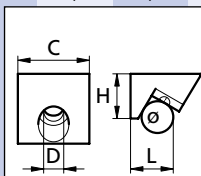
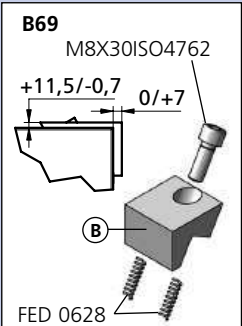
- | | | |
|---|----|--------------|
| 1 | 1x | TF140726 |
| 2 | 1x | _____ |
| 3 | 1x | M8X20ISO4762 |
| 4 | 2x | FED0618 |
| 5 | 2x | CCBO0802 |
| 6 | 2x | M5X8ISO7380 |
| 7 | 4x | M8X20ISO4762 |
| 8 | 2x | CCD004 |
| 9 | 2x | M5X12ISO7380 |

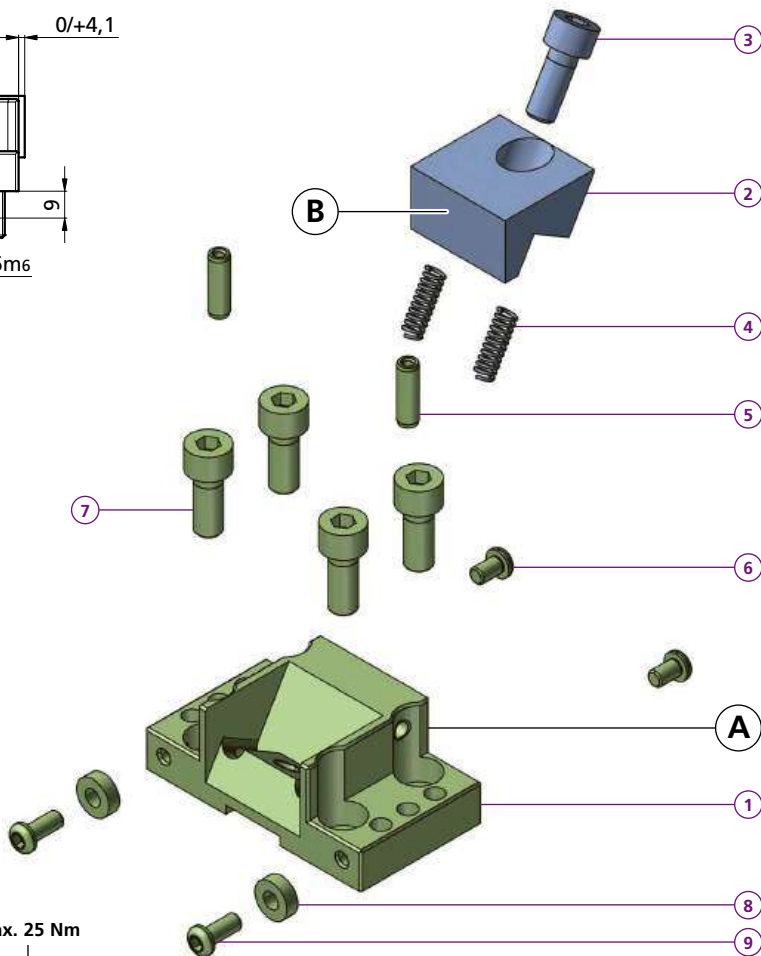
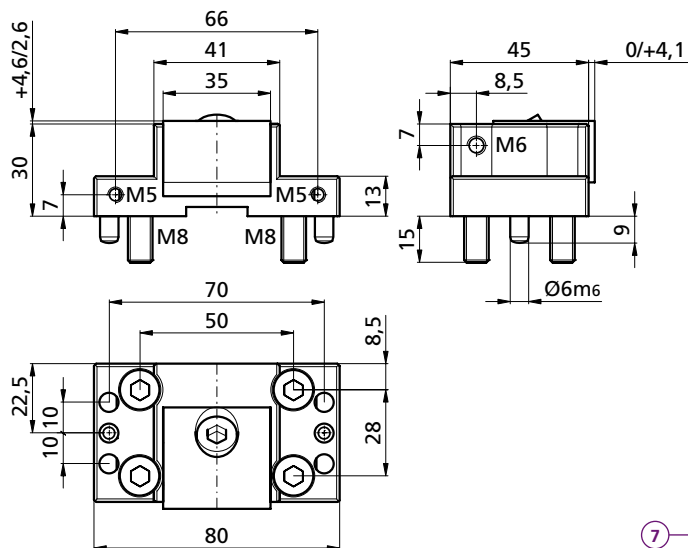
kg ~1,01



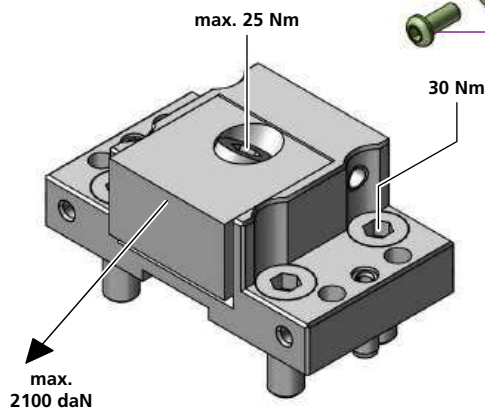
													
	B58	B60	B61	B62	B62HM	B65	B66	B67	B68	B69	B77	B79F	B79R
(C)	35	35	35	35	35	35	35	35	35	35	35	35	35
(H)	20	20	20	20	20	20	20	20	20	25	20	20	20
(L)	26	19	19	19	19	19	19	24	26	22	22	25	25
(D)	9	9	9	9	9	9	9	9	9	9	9	9	9
(e)	12	12	12	12	12	12	12	12	12	12	12	12	12
(i)	ALU	56HRC	56HRC	*	HM	HV700 x0,2mm	HV700 x0,2mm	HV700 x0,2mm	*	*	56HRC	HV700 x0,2mm	HV700 x0,2mm
kg	~0,07	~0,12	~0,12	~0,12	~0,12	~0,12	~0,12	~0,14	~0,15	~0,15	~0,12	~0,18	~0,18

Bestellbeispiel / Ordering example: 1x **VS1R38N50-60** & 1x **B61**



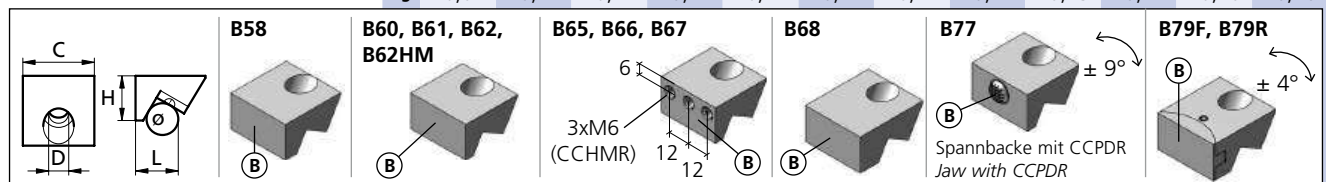


VS1F41N30-60	
1	1x TF140729
VS1R41N30-60	
1	1x TF140730
2	1x
3	1x M8X20ISO4762
4	2x FED0618
5	2x CCBO0802
6	2x M5X8ISO7380
7	4x M8X20ISO4762
8	2x CCD004
9	2x M5X12ISO7380
kg	~0,58



Bestellbeispiel / Ordering example: 1x VS1R41N30-60 & 1x B61

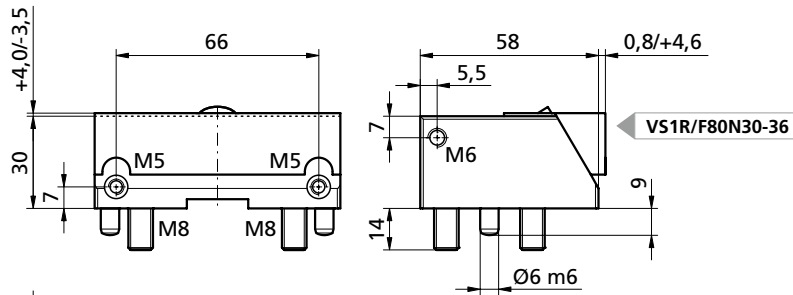
	B58	B60	B61	B62	B62HM	B65	B66	B67	B68	B77	B79F	B79R
C	35	35	35	35	35	35	35	35	35	35	35	35
H	20	20	20	20	20	20	20	20	20	20	20	20
L	26	19	19	19	19	19	19	24	26	22	25	25
D	9	9	9	9	9	9	9	9	9	9	9	9
o	12	12	12	12	12	12	12	12	12	12	12	12
i	ALU	56HRC	56HRC	*	HM	HV700 x0,2mm	HV700 x0,2mm	HV700 x0,2mm	*	56HRC	HV700 x0,2mm	HV700 x0,2mm
kg	~0,07	~0,12	~0,12	~0,12	~0,12	~0,12	~0,12	~0,14	~0,15	~0,12	~0,18	~0,18



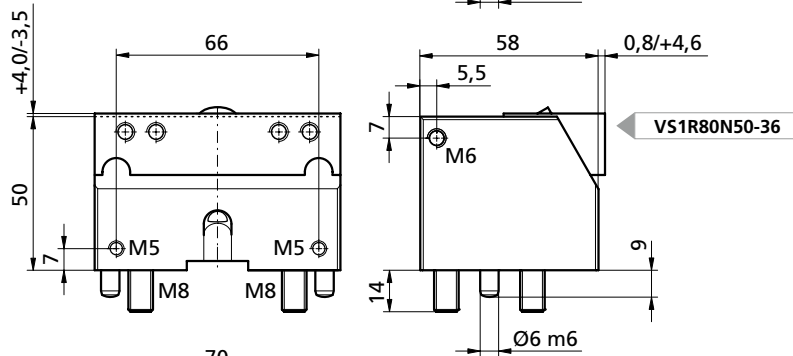
* = weicher Stahl / soft steel

HM = Hartmetallbeschichtet / Carbide coated

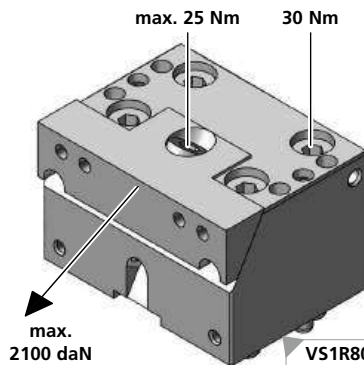
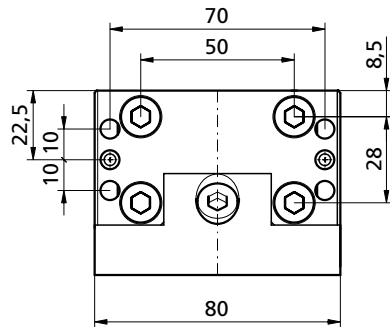
ALU = ENAW-7022



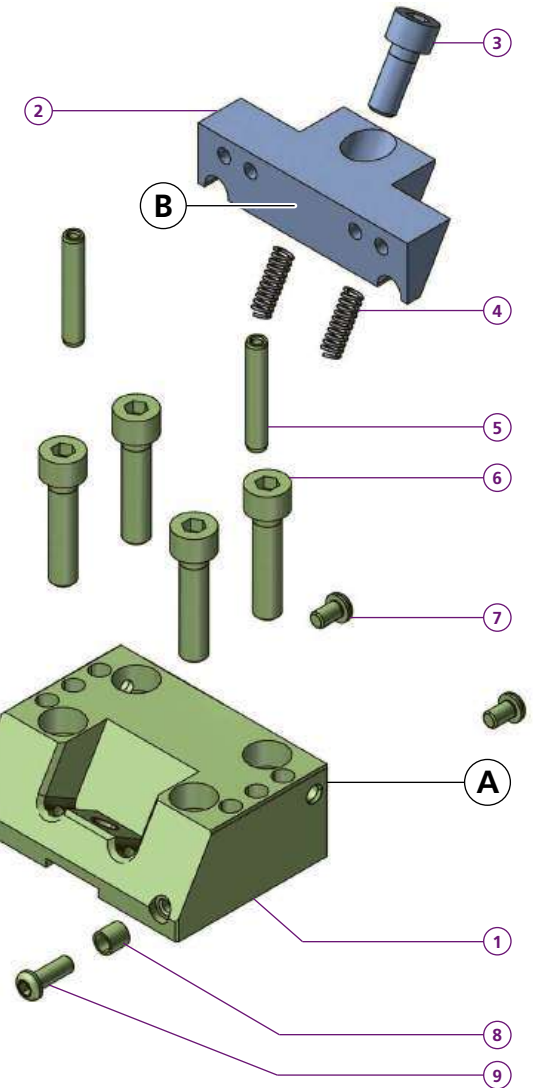
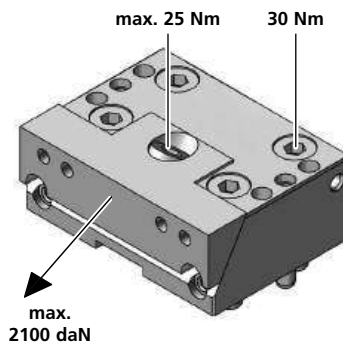
VS1R/F80N30-36



VS1R80N50-36



VS1R80N50-36



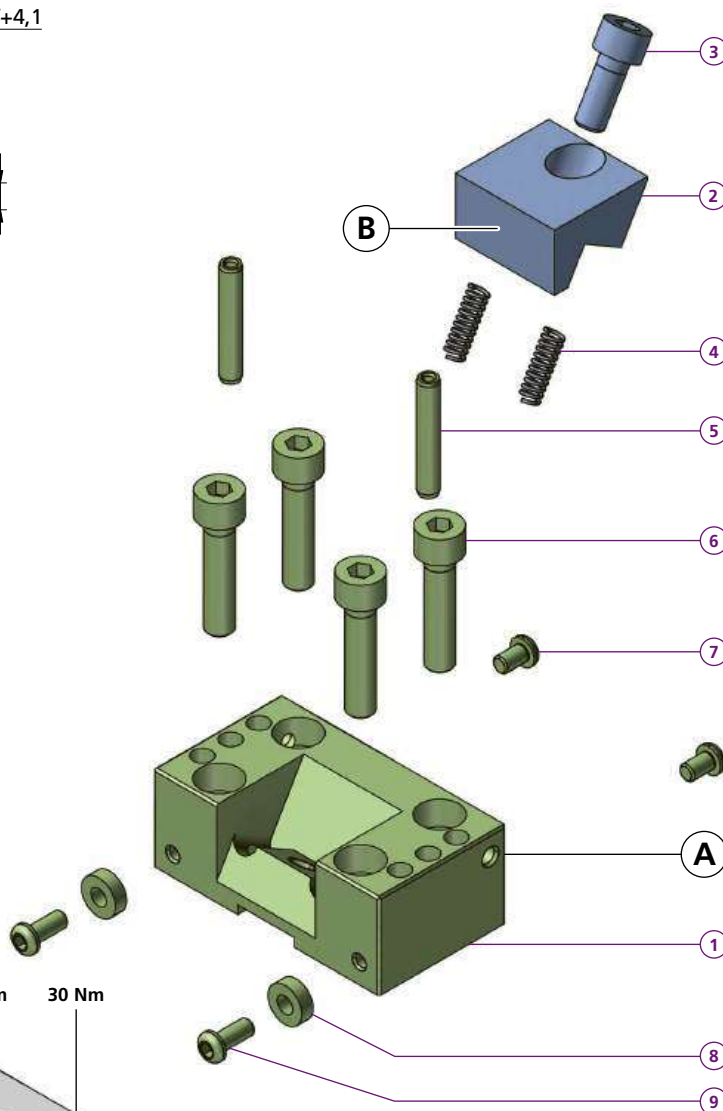
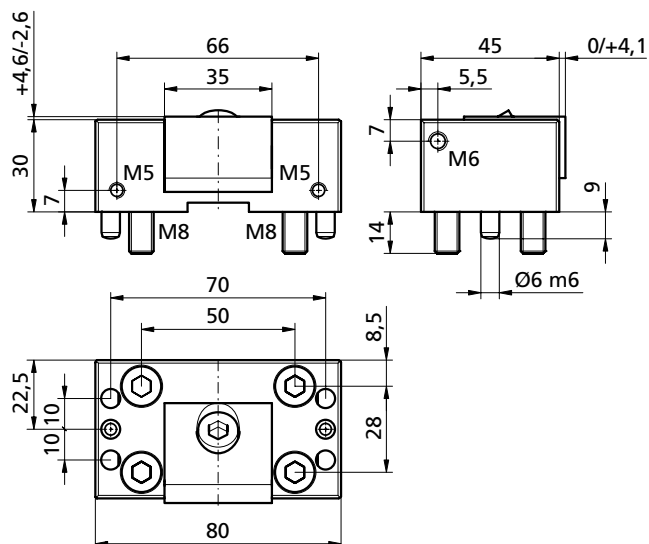
Bestellbeispiel / Ordering example: 1x VS1R80N30-36 & 1x B37

VS1F80N30-36	
1	1x TF140733
VS1R80N30-36	
1	1x TF140734
2	1x
3	1x M8X20ISO4762
4	4x FED0618
5	2x CCBO0801
6	4x M8X35ISO4762
7	2x M5X8ISO4762
8	2x CCD007
9	2x M5X16ISO7380
kg	~1,2

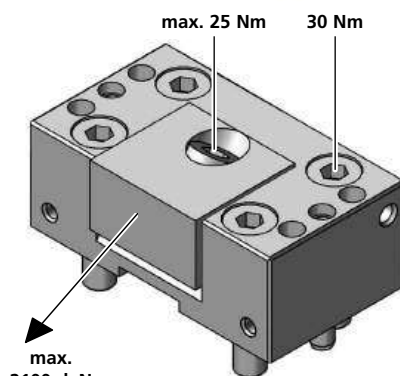
VS1R80N50-36	
1	1x TF140742
2	1x
5	2x CCBO0803
6	4x M8X55ISO4762
8	2x CCD007
9	2x M5X12ISO7380
kg	~1,9

	B36	B37	B38
C	80	80	80
H	20	20	20
L	19	19	19
D	9	9	9
ø	12	12	12
i	HV700	HV700	*
	x0,2mm	x0,2mm	
kg	~0,18	~0,18	~0,18

B36, B37, B38



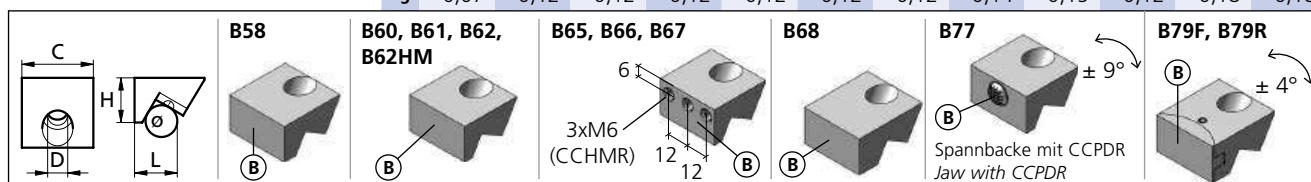
VS1F80N30-60	
1	1x TF140735
VS1R80N30-60	
1	1x TF140736
2	1x
3	1x M8X20ISO4762
4	2x FED0618
5	2x CCBO0801
6	4x M8X35ISO4762
7	2x M5X8ISO7380
8	2x CCD004
9	2x M5X12ISO7380
kg	~0,74



max.
2100 daN

Bestellbeispiel / Ordering example: 1x VS1F80N30-60 & 1x B61

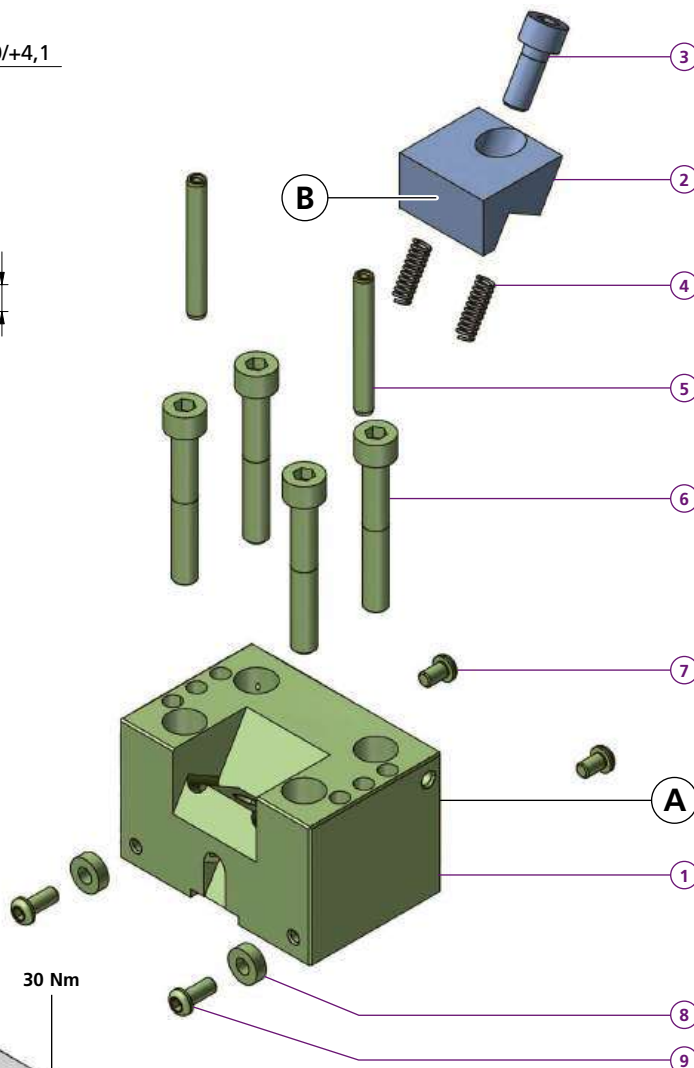
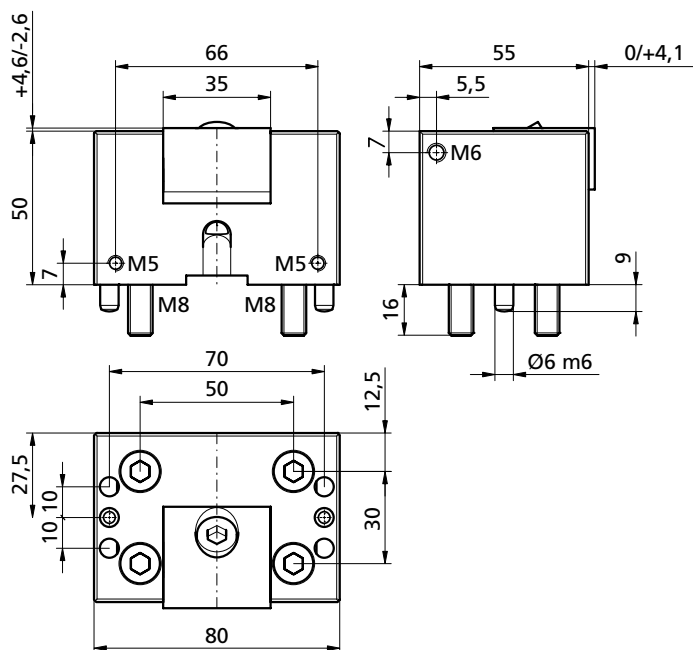
	B58	B60	B61	B62	B62HM	B65	B66	B67	B68	B77	B79F	B79R
C	35	35	35	35	35	35	35	35	35	35	35	35
H	20	20	20	20	20	20	20	20	20	20	20	20
L	26	19	19	19	19	19	19	24	26	22	25	25
D	9	9	9	9	9	9	9	9	9	9	9	9
ø	12	12	12	12	12	12	12	12	12	12	12	12
i	ALU	56HRC	56HRC	*	HM	HV700 x0,2mm	HV700 x0,2mm	HV700 x0,2mm	*	56HRC	HV700 x0,2mm	HV700 x0,2mm
kg	~0,07	~0,12	~0,12	~0,12	~0,12	~0,12	~0,12	~0,14	~0,15	~0,12	~0,18	~0,18



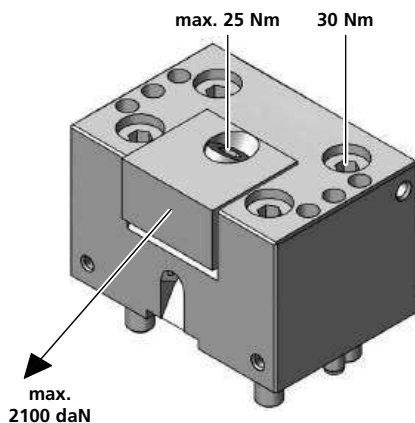
* = weicher Stahl / soft steel

HM = Hartmetallbeschichtet / Carbide coated

ALU = ENAW-7022

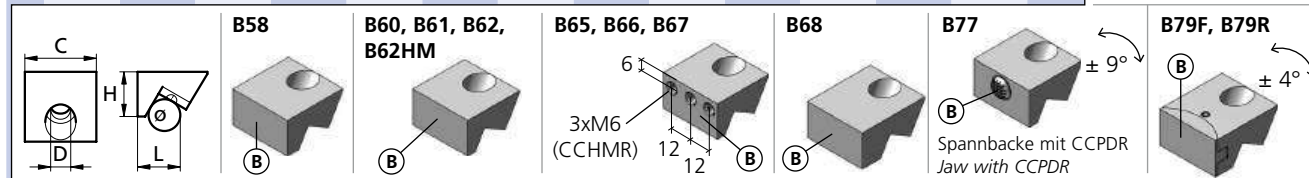
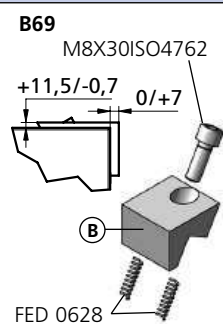


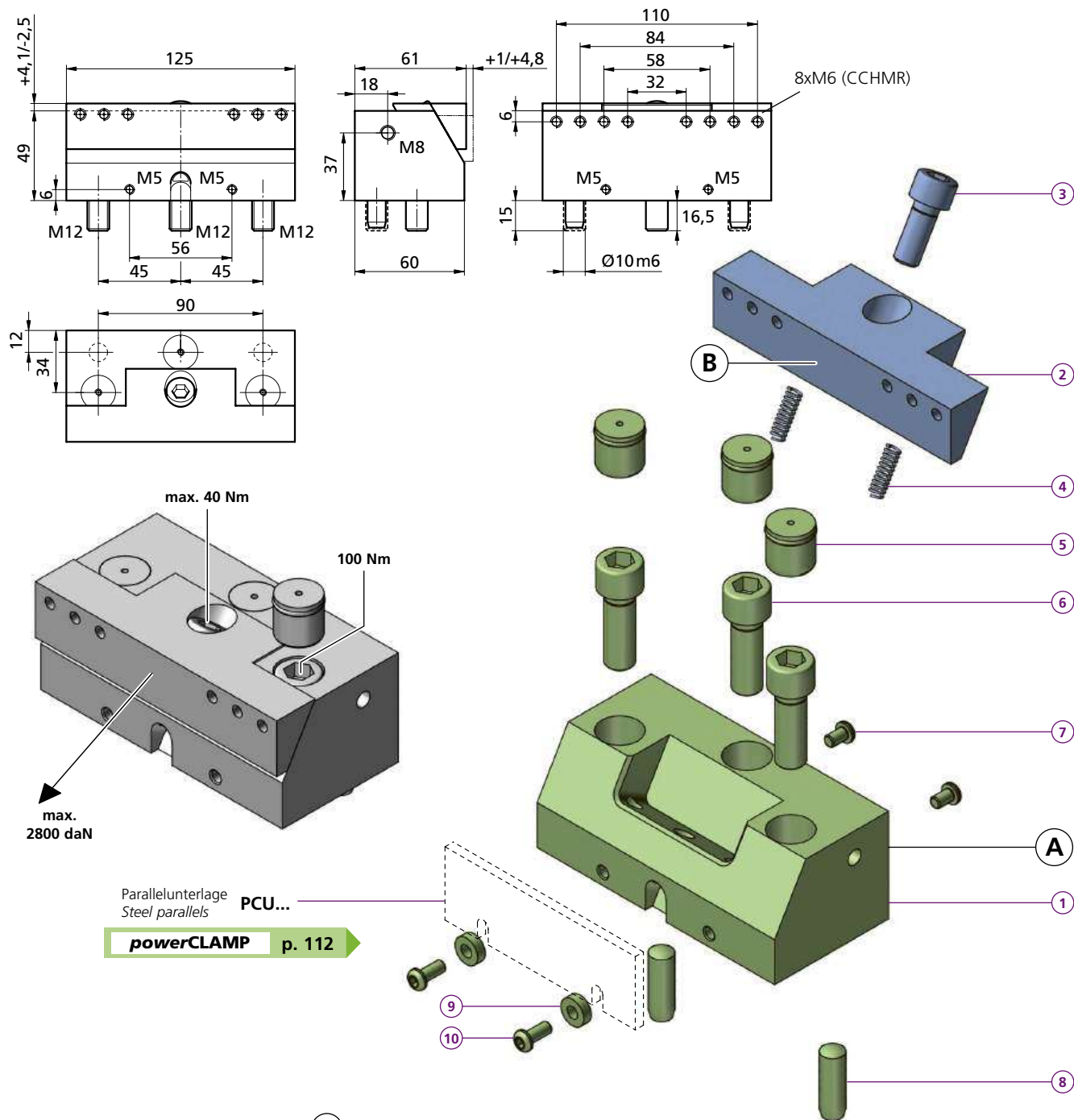
VS1R80N50-60	
1	1x TF140737
2	1x
3	1x M8X20ISO4762
4	2x FED0618
5	2x CCBO0803
6	4x M8X55ISO4762
7	2x M5X8ISO7380
8	2x CCD004
9	2x M5X12ISO7380
kg	~1,6



Bestellbeispiel / Ordering example: 1xVS1R80N50-60 & 1x B61

	B58	B60	B61	B62	B62HM	B65	B66	B67	B68	B69	B77	B79F	B79R
C	35	35	35	35	35	35	35	35	35	35	35	35	35
H	20	20	20	20	20	20	20	20	20	25	20	20	20
L	26	19	19	19	19	19	19	24	26	22	22	25	25
D	9	9	9	9	9	9	9	9	9	9	9	9	9
o	12	12	12	12	12	12	12	12	12	12	12	12	12
i	ALU	56HRC	56HRC	*	HM	HV700 x0,2mm	HV700 x0,2mm	HV700 x0,2mm	*	*	56HRC	HV700 x0,2mm	HV700 x0,2mm
kg	~0,07	~0,12	~0,12	~0,12	~0,12	~0,12	~0,12	~0,14	~0,15	~0,15	~0,12	~0,18	~0,18

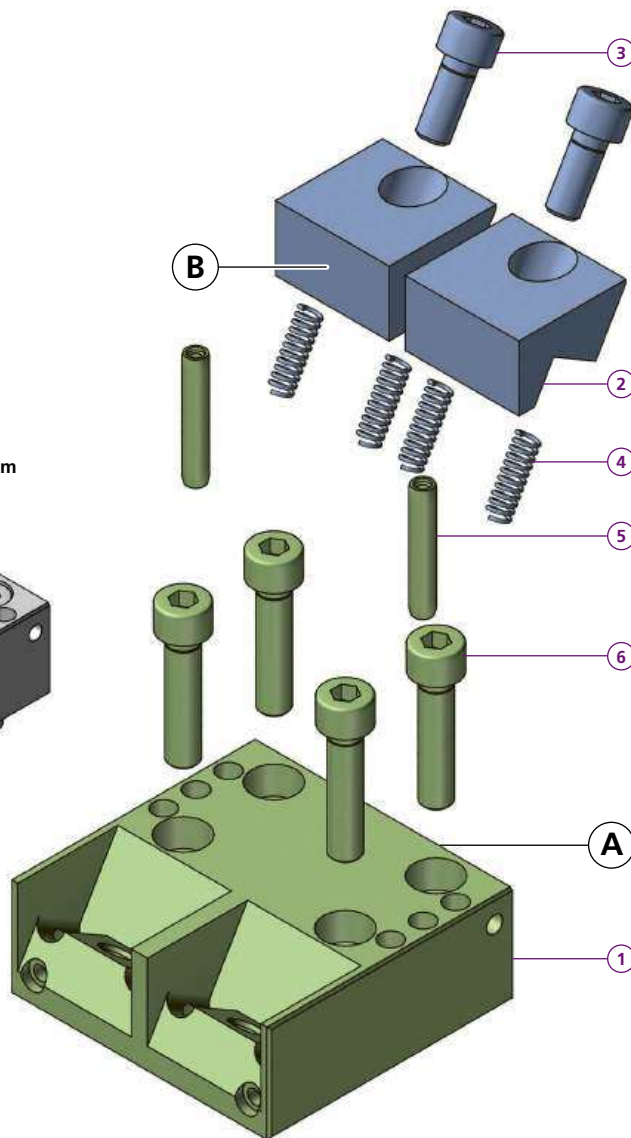
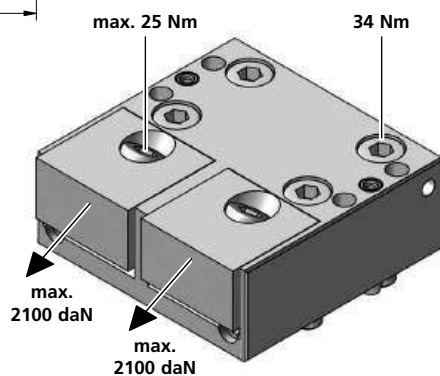
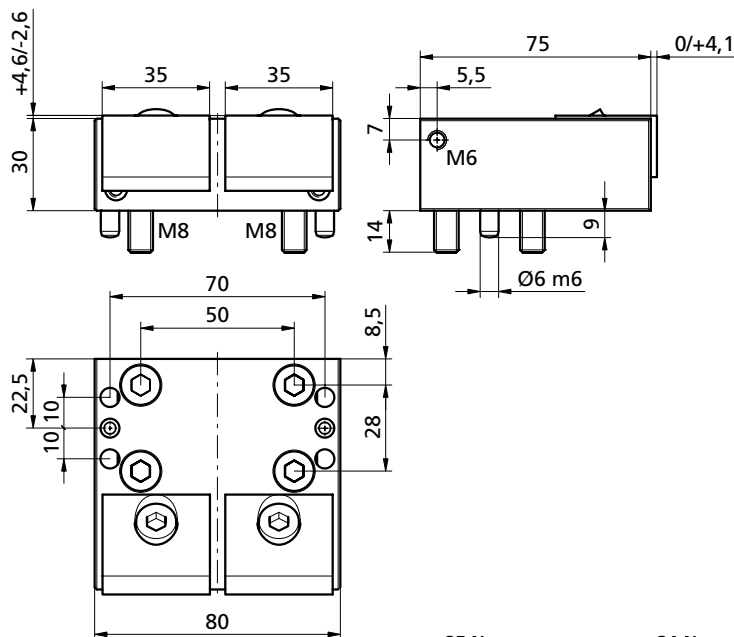




Bestellbeispiel / Ordering example: 1x VS1R125N49-95 & 1x B96

	B95	B96	B97	B98	B99
1x TF140738	125	125	125	125	125
1x TF140739	25	25	25	25	25
1x	23	23	23	30	23
1x	11	11	11	11	11
1x	15	15	15	15	15
2x M10X25ISO4762	HV700	HV700	*	*	HV700
2x FED0618	x0,2mm	x0,2mm			x0,2mm
3x PCPF16L18Alu	kg	~0,45	~0,45	~0,63	~0,45
3x M12X35ISO4762					
3x M5X8ISO7380					
2x 10m6x30 DIN6325					
2x CCD004					
2x M5X12ISO7380					
kg					~2,6

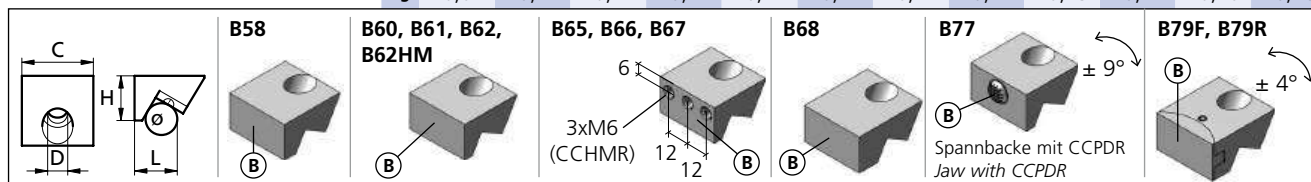
* = weicher Stahl / soft steel

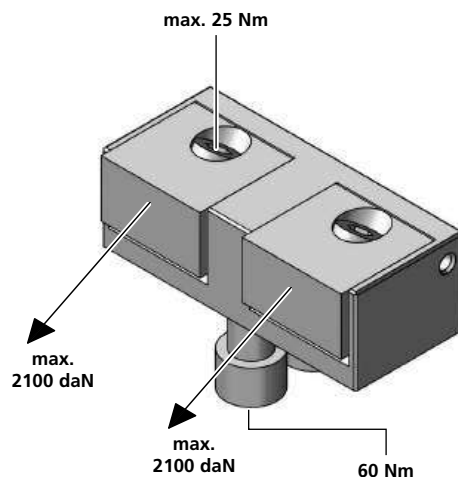
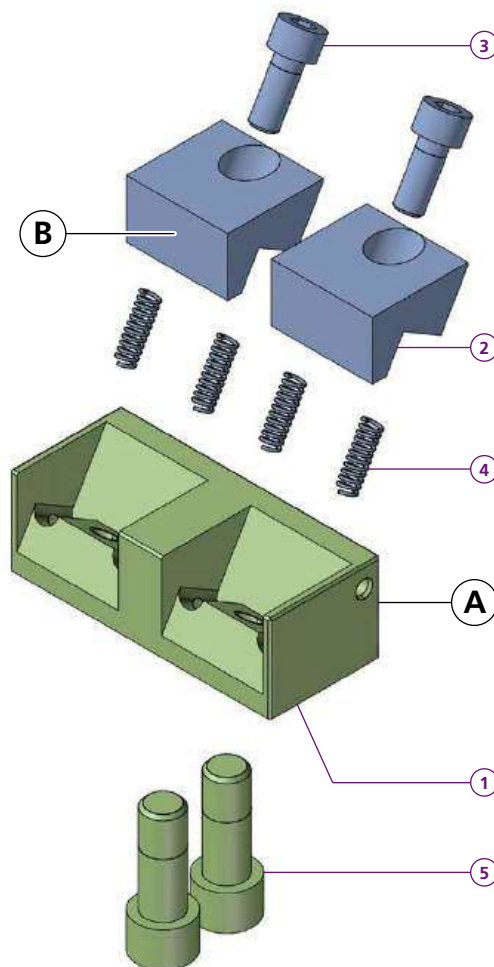
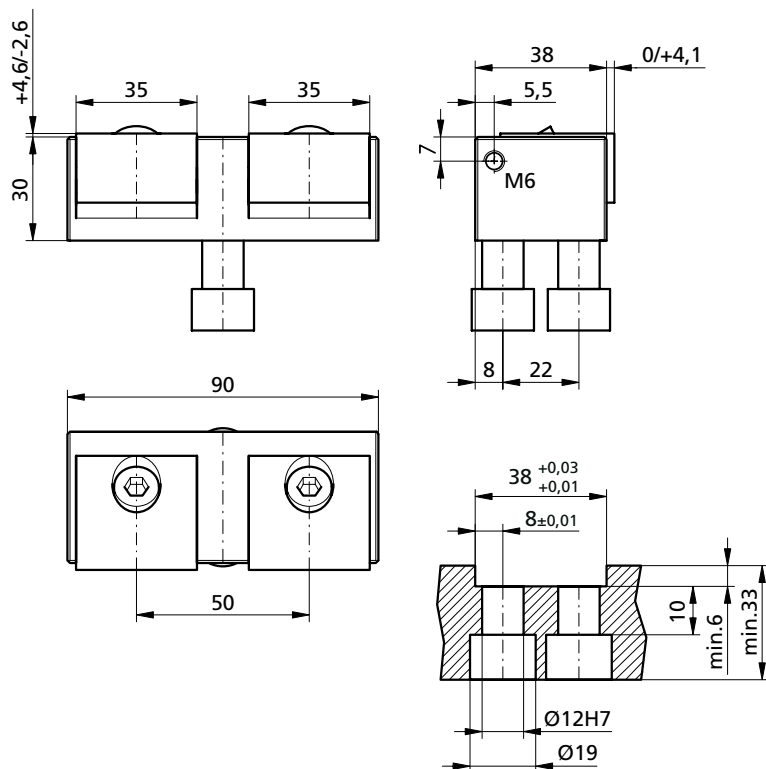


VS2R80N30-60	
1	1x TF140740
2	2x
3	2x M8X20ISO4762
4	4x FED0618
5	2x CCBO0801
6	4x M8X35ISO4762
kg	~1,3

Bestellbeispiel / Ordering example: 1x VS2R80N30-60 & 2x B61

	B58	B60	B61	B62	B62HM	B65	B66	B67	B68	B77	B79F	B79R
C	35	35	35	35	35	35	35	35	35	35	35	35
H	20	20	20	20	20	20	20	20	20	20	20	20
L	26	19	19	19	19	19	19	24	26	22	25	25
D	9	9	9	9	9	9	9	9	9	9	9	9
o	12	12	12	12	12	12	12	12	12	12	12	12
i	ALU	56HRC	56HRC	*	HM	HV700	HV700	HV700	*	56HRC	HV700	HV700
						x0,2mm	x0,2mm	x0,2mm			x0,2mm	x0,2mm
kg	~0,07	~0,12	~0,12	~0,12	~0,12	~0,12	~0,12	~0,14	~0,15	~0,12	~0,18	~0,18

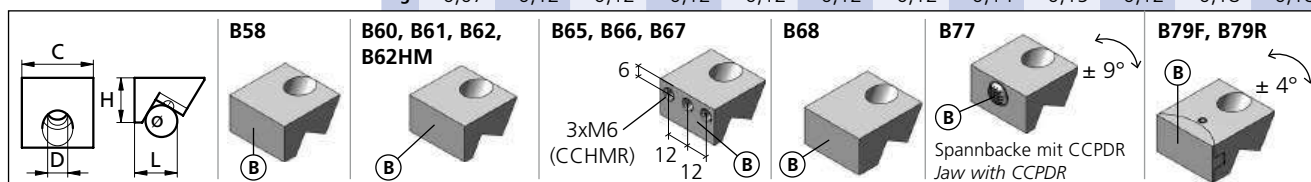




VS2F90N30-60	
1x	TF140741
2x	
2x	M8X20ISO4762
4x	FED0618
2x	TWPAS1232
kg	~0,85

Bestellbeispiel / Ordering example: 1x VS2F90N30-60 & 2x B61

	B58	B60	B61	B62	B62HM	B65	B66	B67	B68	B77	B79F	B79R
C	35	35	35	35	35	35	35	35	35	35	35	35
H	20	20	20	20	20	20	20	20	20	20	20	20
L	26	19	19	19	19	19	19	24	26	22	25	25
D	9	9	9	9	9	9	9	9	9	9	9	9
ø	12	12	12	12	12	12	12	12	12	12	12	12
i	ALU	56HRC	56HRC	*	HM	HV700 x0,2mm	HV700 x0,2mm	HV700 x0,2mm	*	56HRC	HV700 x0,2mm	HV700 x0,2mm
kg	~0,07	~0,12	~0,12	~0,12	~0,12	~0,12	~0,12	~0,14	~0,15	~0,12	~0,18	~0,18



* = weicher Stahl / soft steel

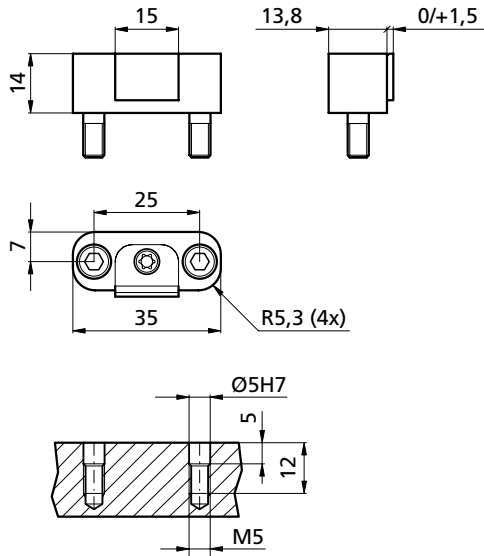
HM = Hartmetallbeschichtet / Carbide coated

ALU = ENAW-7022

MS1R/F35L14-152

MS1R/F35L14-150 (Alte Version / Old Version)

microCLAMP

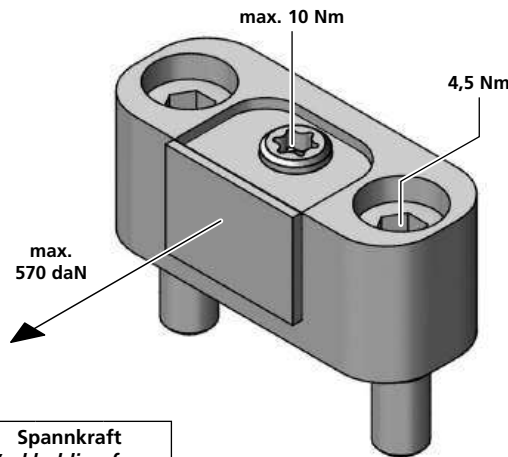
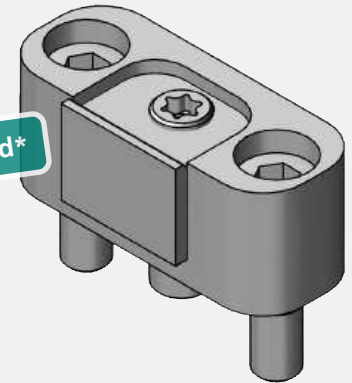


MS1R/F35L14-150

Semi Standard



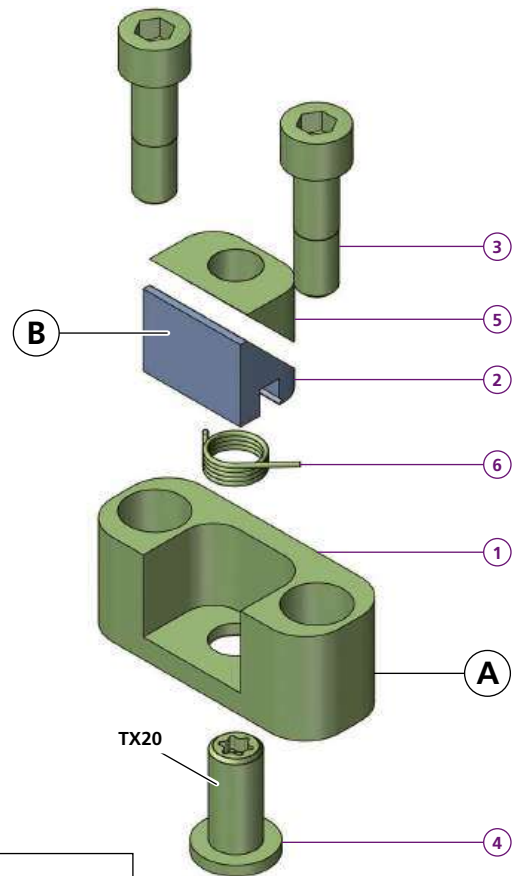
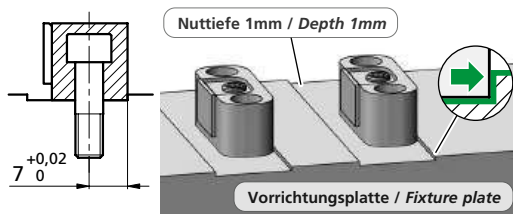
Alte Version
Old Version



Drehmoment Torque		Spannkraft Workholding force		
Nm	(lb-ft)	~daN	~(lb)	~t
7	5,18	= 390	860	0,39
8	5,92	= 450	990	0,45
9	6,66	= 510	1120	0,51
10	7,4	= 570	1250	0,57

Achtung: Bei Spannkraften über 400 daN (0,4t) muss das Spannmodul in eine Nut eingelassen werden (Nuttiefe mindestens 1mm)

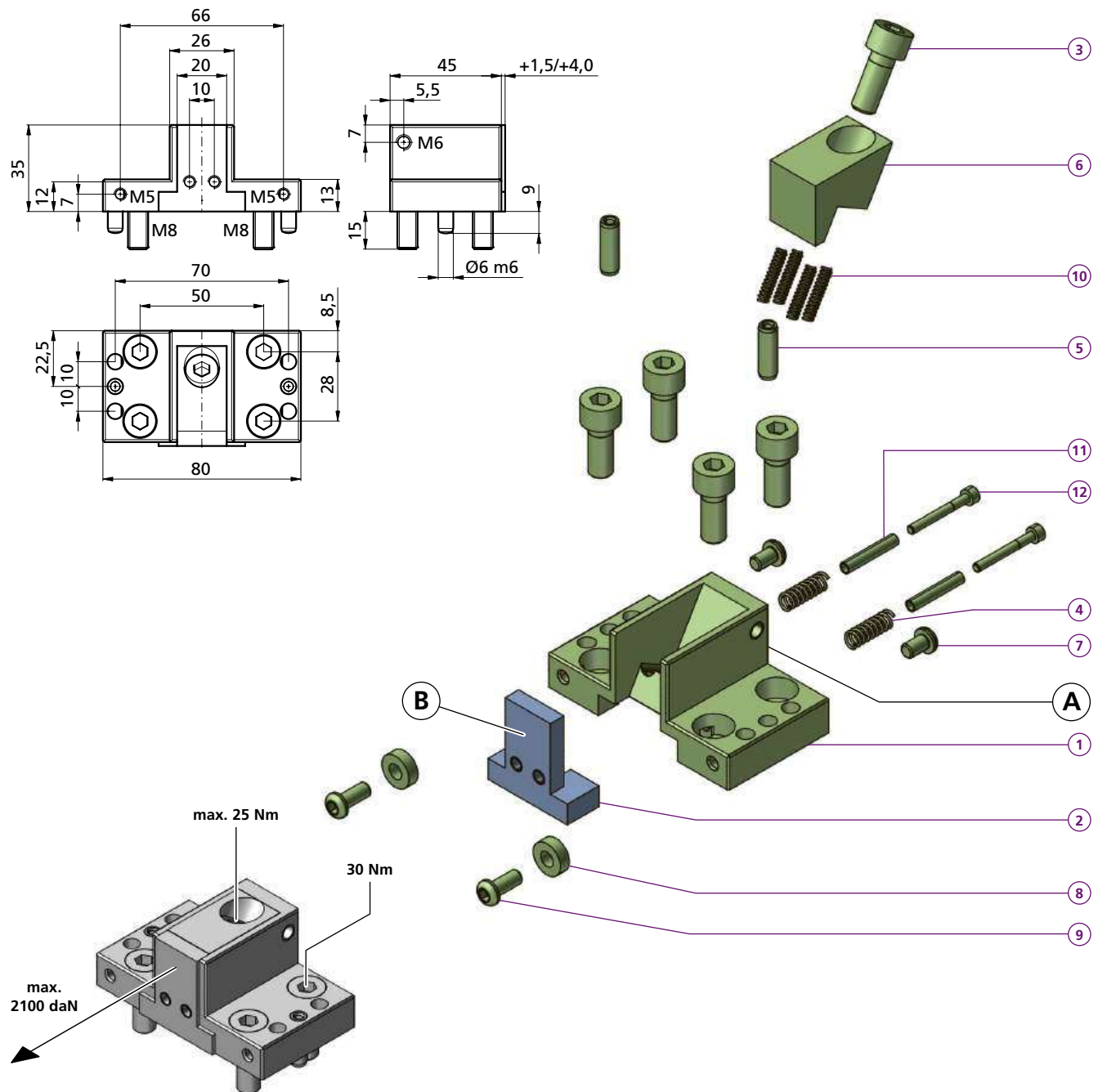
Remark: Using forces higher than 400 daN, clamps must be mounted into a slot (depth minimum 1mm)



MS1F35L14-152	
1	1x TK181266
MS1R35L14-152	
1	1x TF190596
2	1x
3	2x MS50
4	1x GEWST6L14
5	1x MSK15W45
6	1x SFED6W90
kg	~0,03

Bestellbeispiel / Ordering example: 1x MS1F35L14-152 & 1x B151	
B150	B151
C	15
H	11
L	40,3
ø	40
i	HV700
	x0,2mm x0,2mm
kg	~0,004

B150, B151

VS1R26L35-31

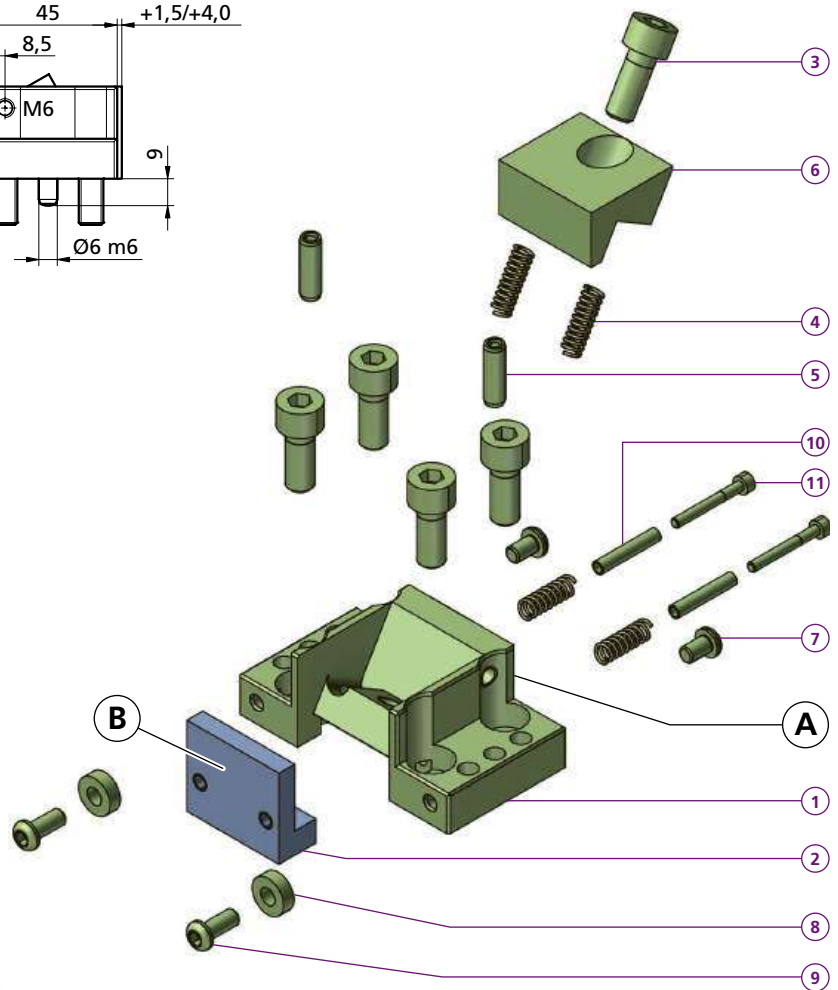
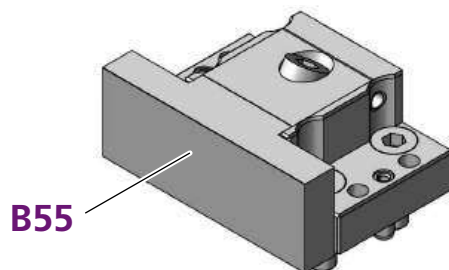
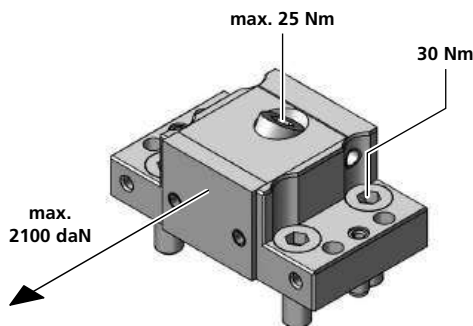
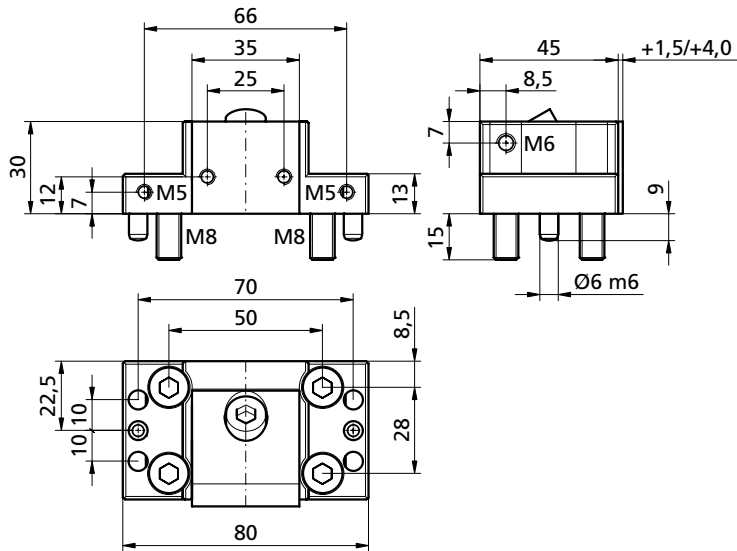
VS1R26L35-31	
1	1x TF140724
2	1x —
3	5x M8X20ISO4762
4	2x FED0618
5	2x CCBO0802
6	1x B30
7	2x M5X8ISO7380
8	2x CCD004
9	2x M5X12ISO7380
10	4x FED0418
11	2x CCD422
12	2x M3X25ISO4762
kg	~0,55

Bestellbeispiel / Ordering example: 1x VS1R26L35-31 & 1x B32			
	B31	B32	B33
C	20	20	20
H	35	35	35
L	6	6	6
D	-	-	-
e	-	-	-
i	HV700	HV700	*
	x0,2mm	x0,2mm	
kg	~0,046	~0,046	~0,046

* = weicher Stahl / soft steel

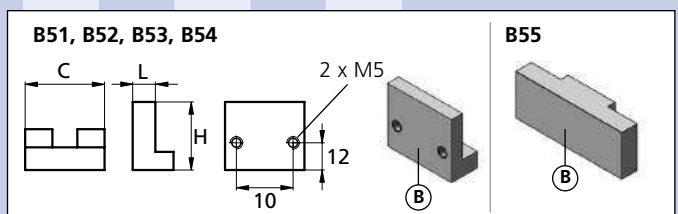
Separat bestellen / Order separately

VS1R/F41L30-51



B Bestellbeispiel / Ordering example: 1x VS1R41L30-51 & 1x B52

					
	B51	B52	B53	B54	B55
	35	35	35	35	80
	30	30	30	35	30
	6	6	10	10	11,5
	-	-	-	-	-
	-	-	-	-	-
	HV700 x0,2mm	HV700 x0,2mm	*	*	*
kg	~0,06	~0,06	~0,06	~0,12	~0,27



Separat bestellen / Order separately

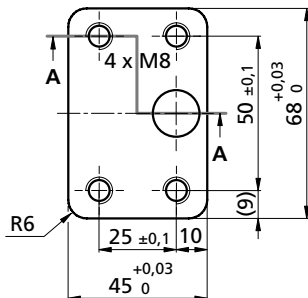
Vorrichtungsbau-Modul für Linearbacken

Alle bestehenden Linearbacken passen auf dieses Modul
(**powerCLAMP** Seite 84 - 85). In die Vorrichtungsplatte wird eine Tasche gefräst um das Modul zu positionieren. Gut geeignet sind die Anschlagbacken **MAND** und **MANF** um als Gegenbacke zu dienen.

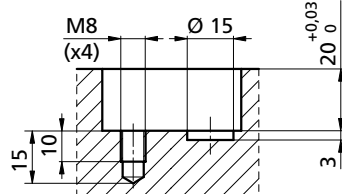
Fixture clamp module for linear jaws

All of our standard linear jaws fit to this clamp module
(**powerCLAMP** Page 84 - 85). All to do is milling a pocket to fit and positioning the clamp modules. To use the **MAND** and **MANF** as datum stop will make a perfect match. (Seite / Page 175 - 176)

Fertigungsmasse für die Vorrichtungsplatte Machining data for the fixture plate

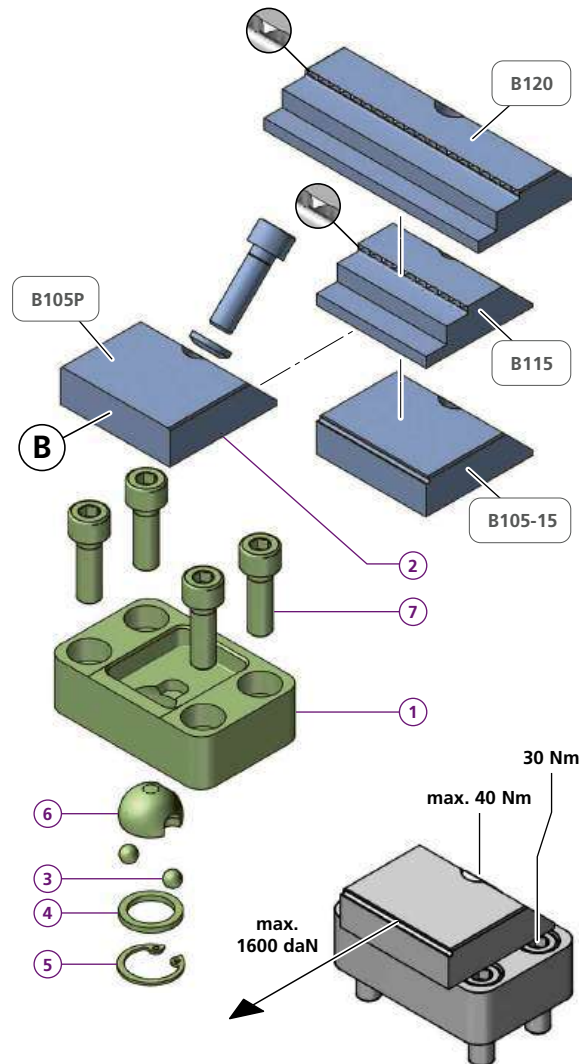
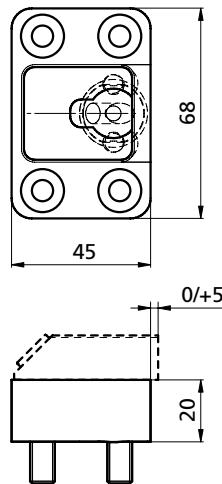


Schnitt / Section A-A

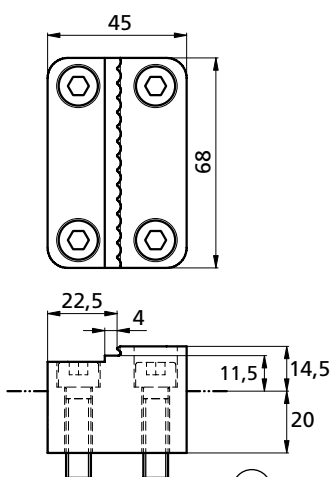


Das Fertigungsmass gilt auch für das Anschlagmodul.
The production dimension is also valid for the end module.

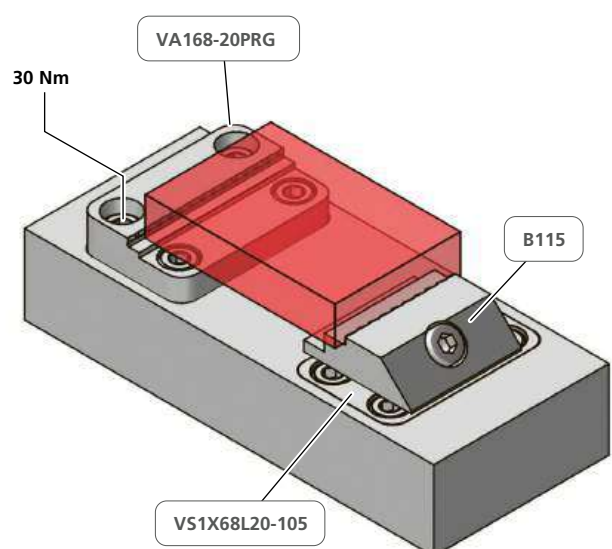
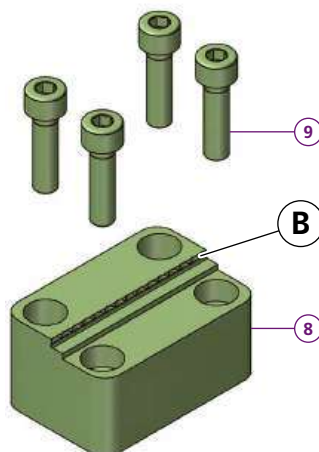
(VA168-20PRG)



VS1X68L20-105	
1x	TB150170
1x	powerCLAMP p 84 - 85
1x	BN869d=6
1x	TN100747
1x	TN100779
1x	PCKMR45M8
4x	M8X20ISO4762
kg	~0,42



VA168-20PRG	
1x	TH160280
4x	M8X30ISO4762
kg	~0,75

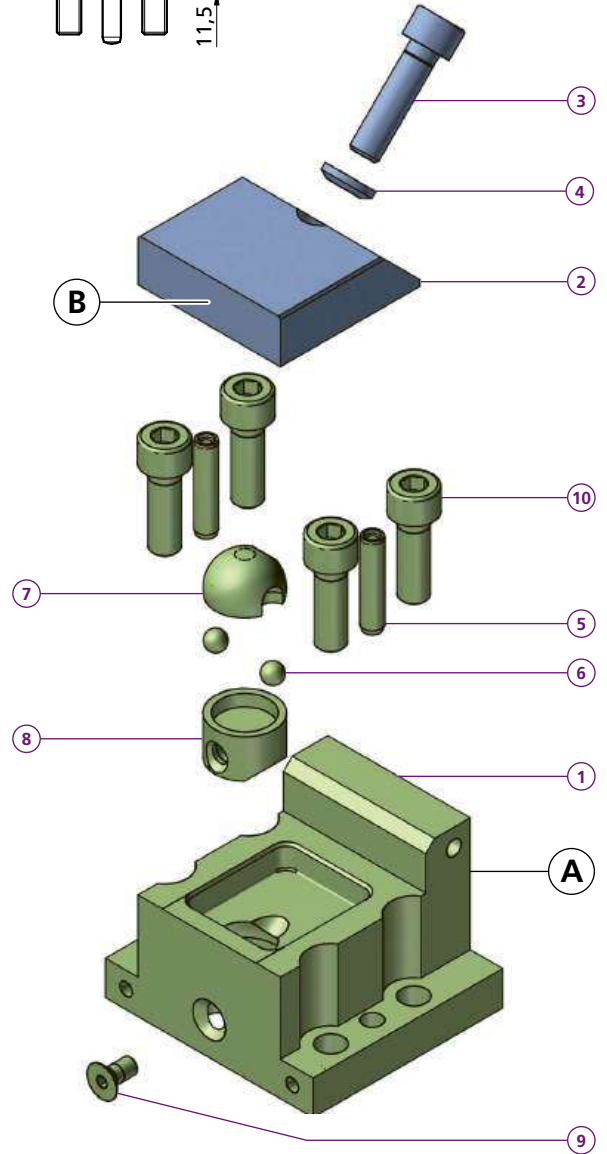
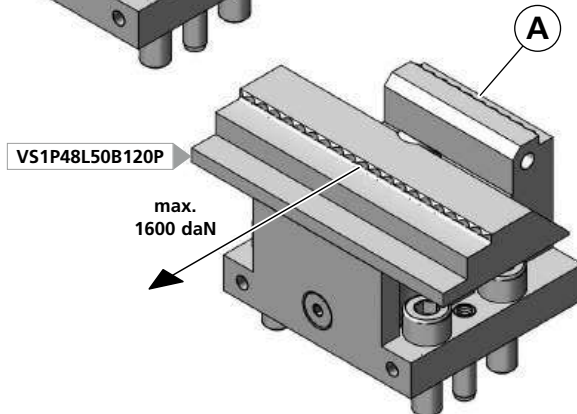
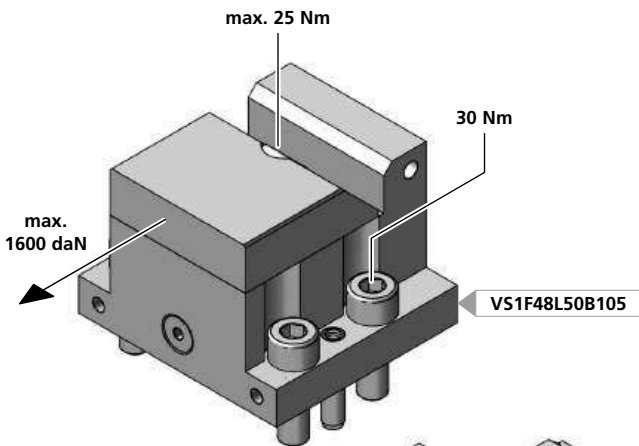
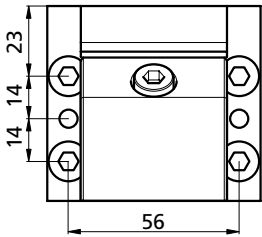
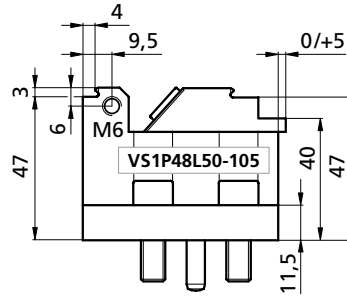
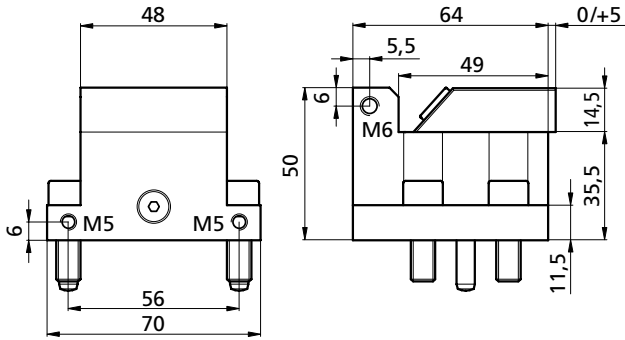


VS1F48L50-105

VS1P48L50-105

Linear

microCLAMP



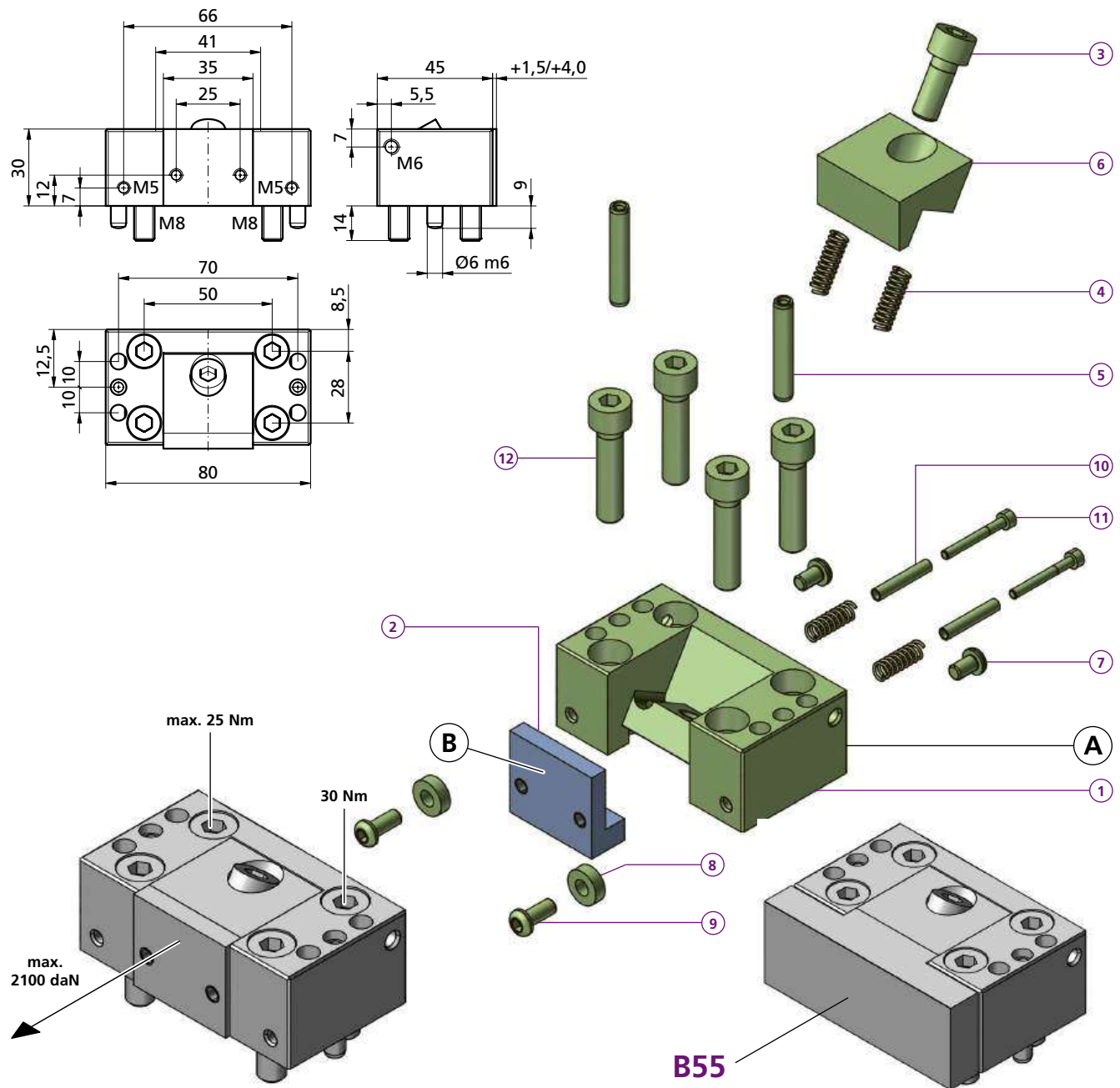
VS1F48L50-105	
1	1x TK120807
VS1P48L50-105	
1	1x TK120761
2	1x
3	1x M8X30ISO4762
4	1x PCUSR14
5	1x 6-m6x26 DIN 79790
6	2x BN869d=6
7	1x PCKMR45M8
8	1x TS120001-04
9	1x M5X10DIN7991
10	4x M8X25ISO4762
kg	~1,21

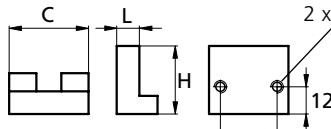
powerCLAMP p. 84 - 85

Bestellbeispiel / Ordering example: 1x VS1F48L50-105 & 1x B105

Separat bestellen / Order separately

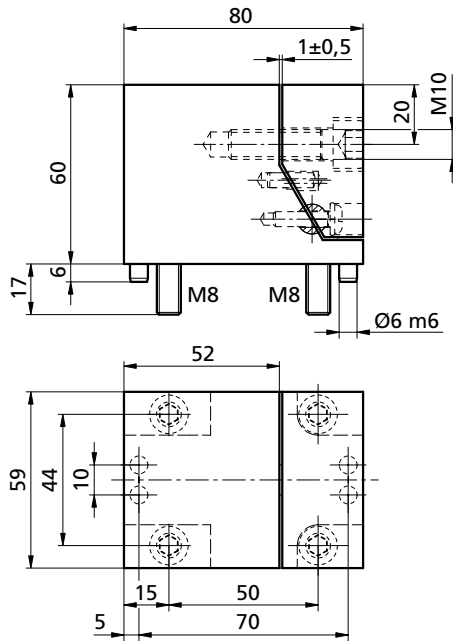
VS1R/F80L30-51



		Bestellbeispiel / Ordering example: 1x VS1R80L30-51 & 1x B52				
						
		B51	B52	B53	B54	B55
1	1x TF140731	35	35	35	35	80
1	1x TF140732	30	30	30	35	30
2	1x	6	6	10	10	11,5
3	1x M8X20ISO4762	-	-	-	-	-
4	4x FED0618	-	-	-	-	-
5	2x CCBO0801	HV700	HV700	*	*	*
6	1x B78	x0,2mm	x0,2mm			
7	2x M5X8ISO7380	kg ~0,06	kg ~0,06	kg ~0,06	kg ~0,12	kg ~0,27
8	2x CCD004					
9	2x M5X12ISO7380					
10	2x CCD422					
11	2x M3X25ISO4762					
12	4x M8X35ISO4762					
kg	~0,74					

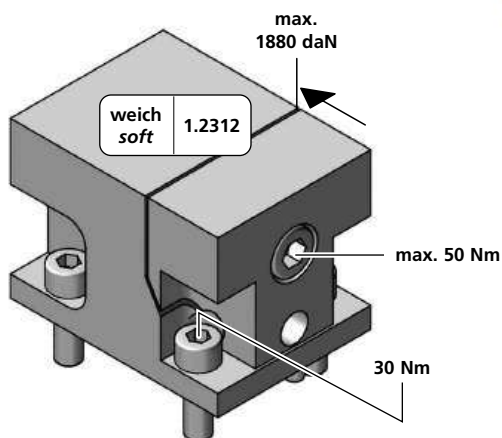
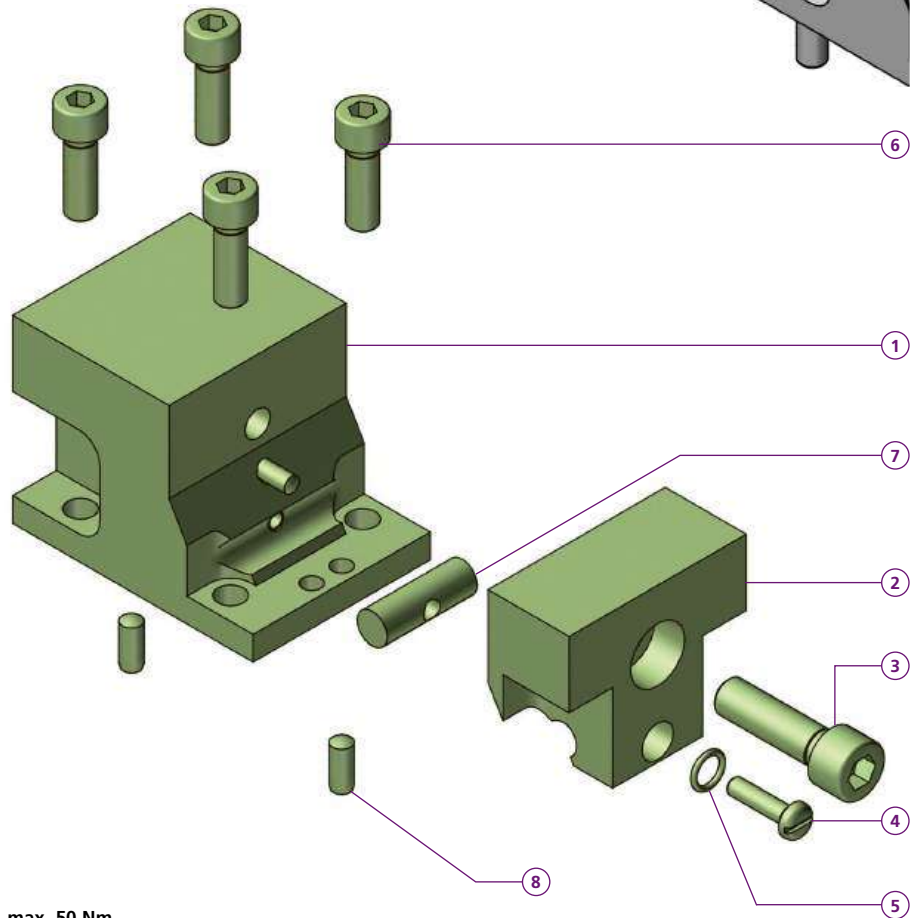
* = weicher Stahl / soft steel

VS1X59L60K

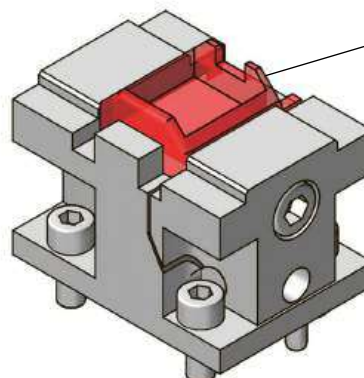


Empfohlener Sechskantschlüssel
Recommended hexagon wrench
PB2212L/6

100°



Spannstelle an Werkstück
angepasst und nitriert.
Clamping face machined to
the shape of the workpiece
and nitrided.



*VS1X59L60K

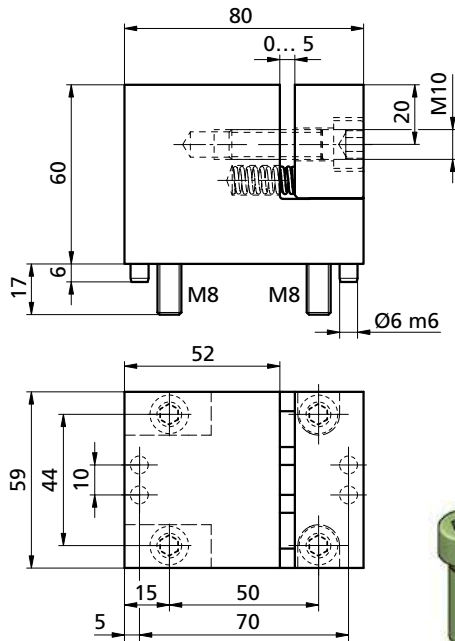
- ① 1x VS1X59L60H5KA
- ② 1x VS1X59L60H5KS
- ③ 1x M10X35ISO4762
- ④ 1x M5X20DIN85A
- ⑤ 1x ORØ8x1,5
- ⑥ 4x **M8X25ISO4762**
- ⑦ 1x VS1X59L60H5KG
- ⑧ 2x 6m6x14 DIN 6325

kg ~1,89

* = Stahl / steel 1.2312

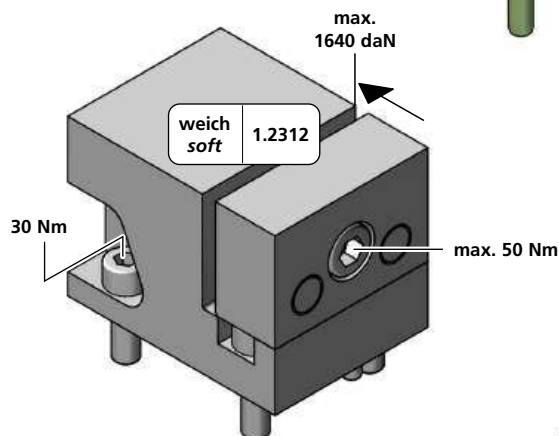
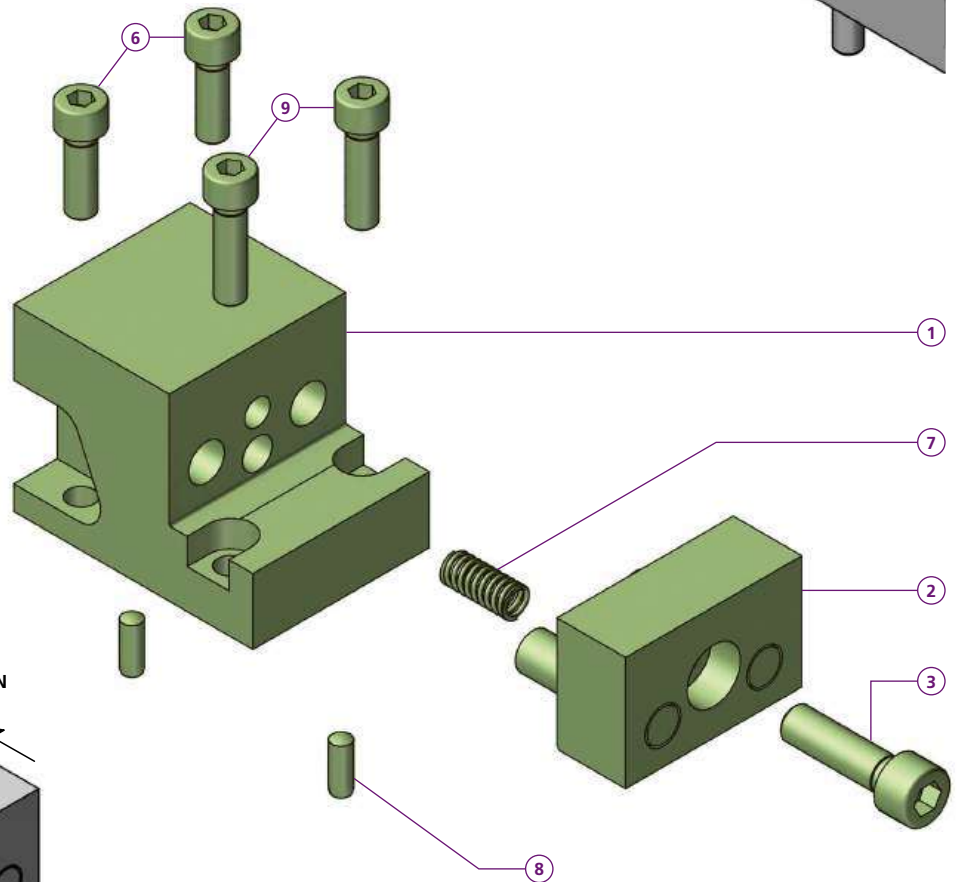
Bestellbeispiel / Ordering example : **VS1X59L60K**

VS1X59L60H5

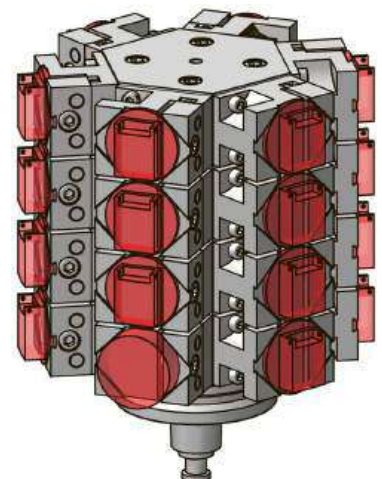
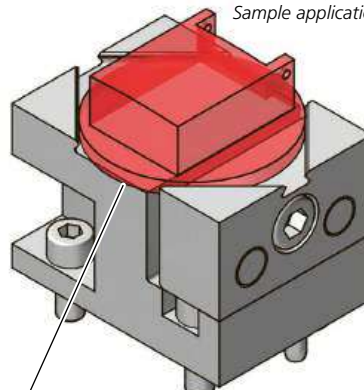


Empfohlener Sechskantschlüssel
Recommended hexagon wrench
PB2212L/6

100°



Anwendungsbeispiele
Sample applications



Spannstelle an Werkstück angepasst und nitriert.
Clamping face machined to the shape of the workpiece and nitrided.

*VS1X59L60H5

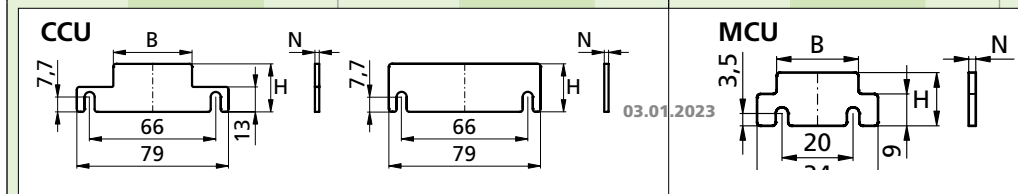
1	1x	VS1X59L60H5A
2	1x	VS1X59L60H5S
3	1x	M10X35ISO4762
6	2x	M8X25ISO4762
7	1x	FED0833
8	2x	6m6x14 DIN 6325
9	2x	M8X30ISO4762
kg		~1,94

* = Stahl / steel 1.2312

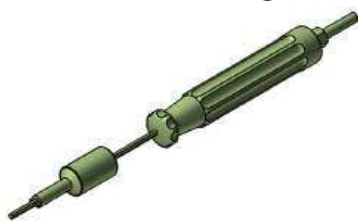
Bestellbeispiel / Ordering example : VS1X59L60H5

Separat bestellen / Order separately

durchgehärtet / through hardened										nitriert / nitrated									
26mm	B	H	N	kg	41mm	B	H	N	kg	23mm	B	H	N	kg	41mm	B	H	N	kg
CCU15026	26	15	2,2	~0,017	CCU15081	41	15	2,2	~0,018	MCU11037	23	11	2	~0,004	CCU15083	41	15	3	~0,025
CCU20026	26	20	2,2	~0,02	CCU20081	41	20	2,2	~0,022	MCU15037	23	15	2	~0,006	CCU20083	41	20	3	~0,029
CCU25026	26	25	2,2	~0,022	CCU25081	41	25	2,2	~0,025	MCU18037	23	18	2	~0,008	CCU25083	41	25	3	~0,034
CCU30026	26	30	2,2	~0,025	CCU27581	41	27	2,2	~0,027	MCU20037	23	20	2	~0,008	CCU27583	41	27,5	3	~0,036
CCU32526	26	32,5	2,2	~0,026	CCU30081	41	30	2,2	~0,029	MCU22537	23	22,5	2	~0,008					
38mm	B	H	N	kg	80mm	B	H	N	kg	26mm	B	H	N	kg	80mm	B	H	N	kg
CCU30039	38	30	2,2	~0,028	CCU15080	79	15	2,2	~0,019	CCU15027	26	15	3	~0,024	CCU15082	79	15	3	~0,026
CCU35039	38	35	2,2	~0,031	CCU20080	79	20	2,2	~0,027	CCU20027	26	20	3	~0,027	CCU20082	79	20	3	~0,036
CCU40039	38	40	2,2	~0,035	CCU25080	79	25	2,2	~0,035	CCU25027	26	25	3	~0,03	CCU25082	79	25	3	~0,045
CCU45039	38	45	2,2	~0,039	CCU27580	79	27,5	2,2	~0,039	CCU30027	26	30	3	~0,033	CCU27582	79	27,5	3	~0,049
					CCU30080	79	30	2,2	~0,043	CCU32527	26	32,5	3	~0,034					
					CCU35080	79	35	2,2	~0,05										
					CCU40080	79	40	2,2	~0,057										
					CCU45080	79	45	2,2	~0,063										

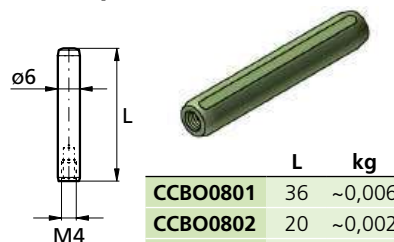


Schraubenzieher mit Konterung für
Screwdriver with holding sleeve for



CCBXSK

Positionsbolzen
Position pin

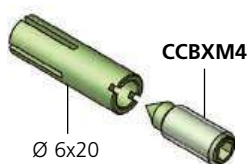


Bolzen-Auszieher
Pin puller

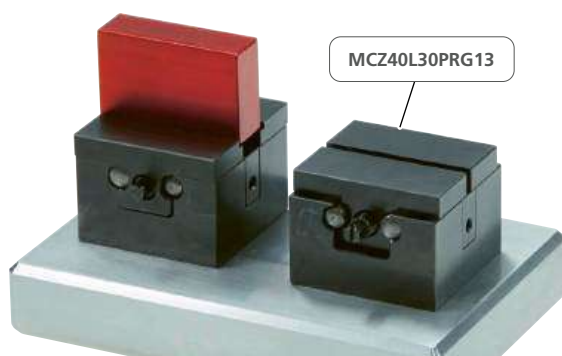


CCAZ1050

Positionierstift (spreizbar)
Locating pin (expandable)



CCBX0802



Mehr Informationen siehe Zentrischspanner
For more information check the self centring vise

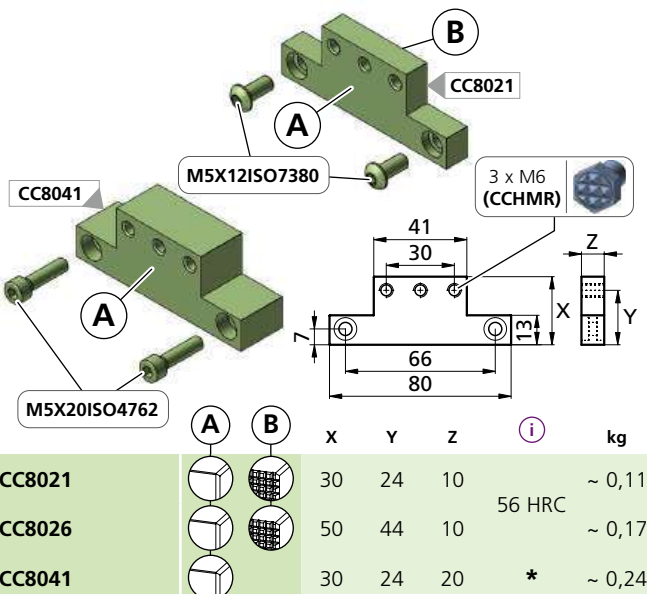
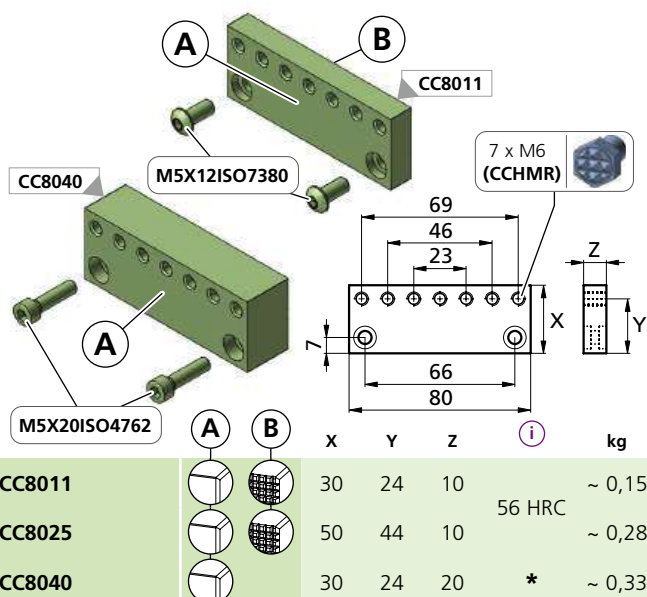
p. 116



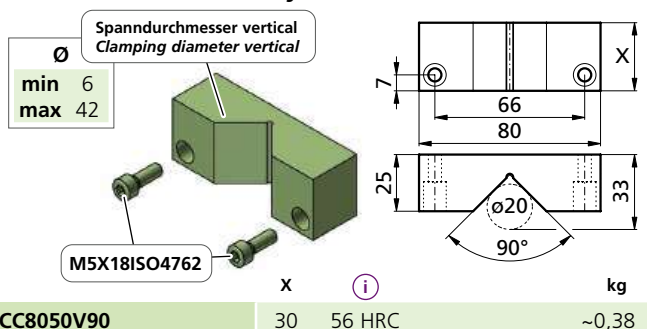
Mehr Informationen siehe Zentrischspanner
For more information check the self centring vise

p. 127

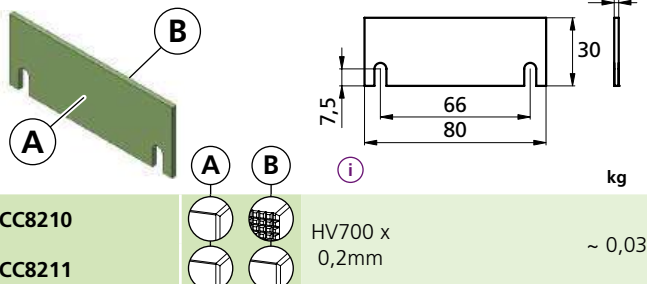
Universalbacke / Universal jaw



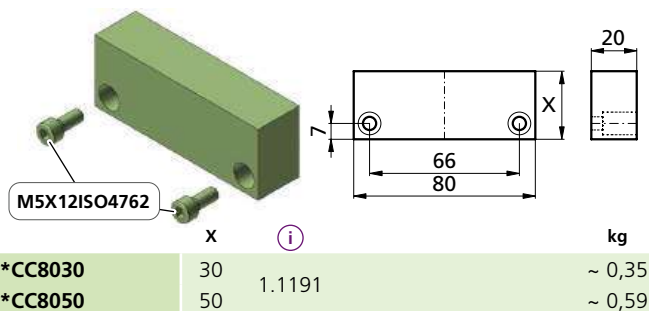
Prismabacke / Prismatic jaw



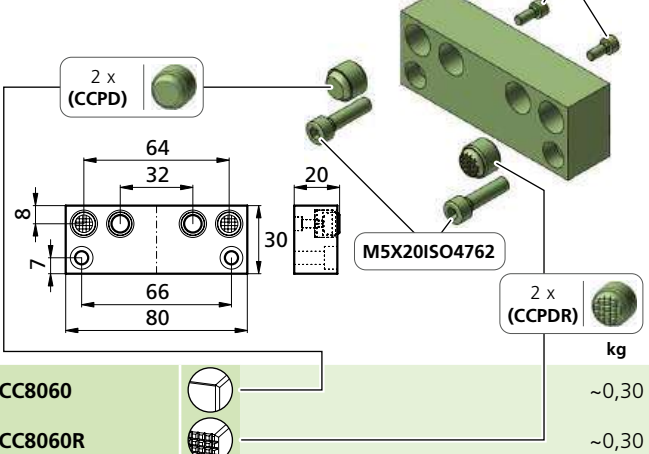
Backe / Jaw



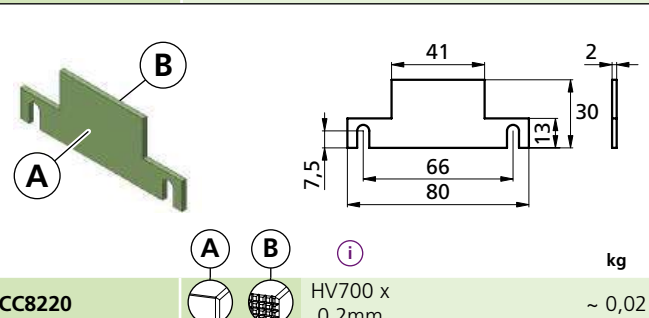
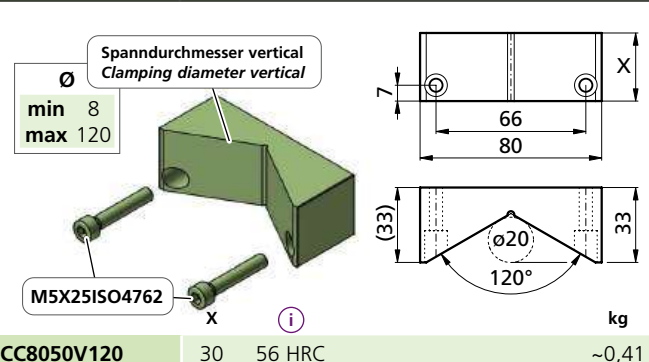
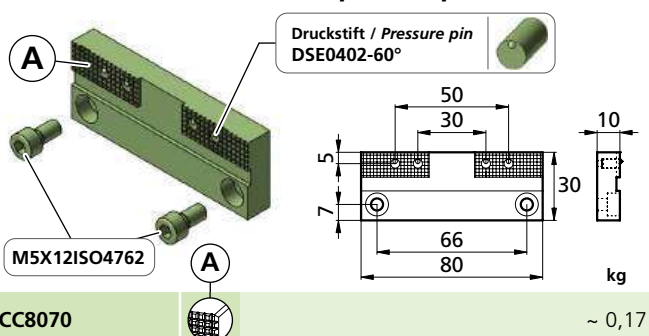
Weiche Backe / Soft jaw



Backe mit 2 Pendeldruckstücken / Jaw with 2 swivelling balls



Backe für Druckstift / Jaw for pressure pin



* = weicher Stahl / soft steel

Bestellbeispiel / Ordering example: CC8011

Separat bestellen / Order separately

Mechanischer Bohrungsspanner

Mechanical hole clamping

microCLAMP

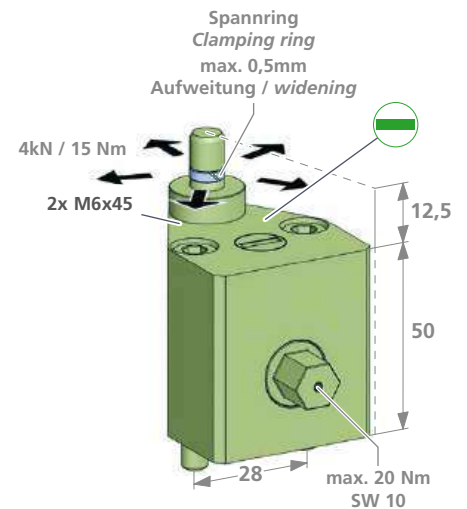
Bohrungsgrößen ab
Bore sizes from

Ø6 mm

Art. Nr.		Ø max. Aufweitung Widening	QR-Code
VB1-21-XXXX	+	0,5	
VB1-22-XXXX	-		
VB1-23-XXXX	+		
VB1-24-XXXX	+		
VB1-41-XXXX	+	0,5	
VB1-42-XXXX	-		
VB1-43-XXXX	+		
VB1-44-XXXX	+		

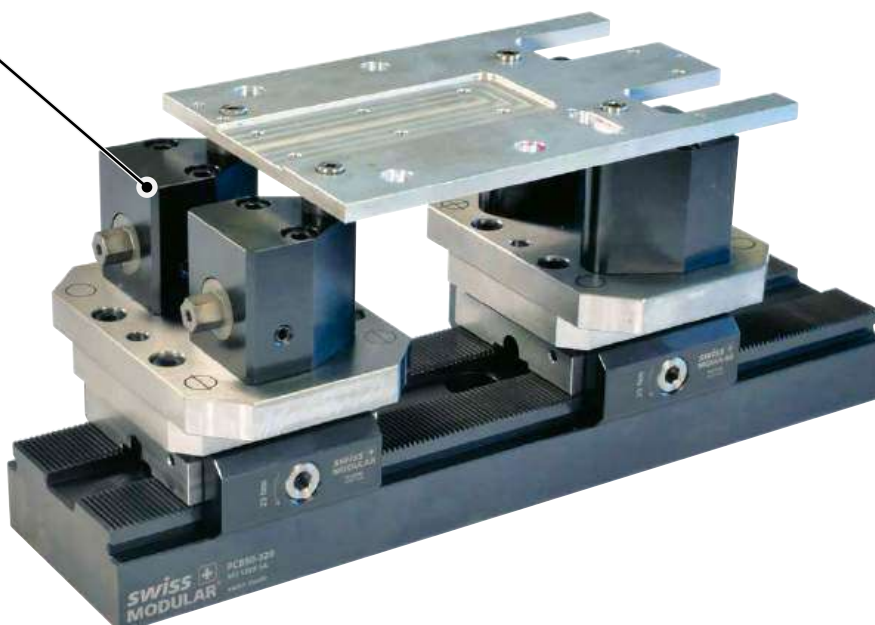
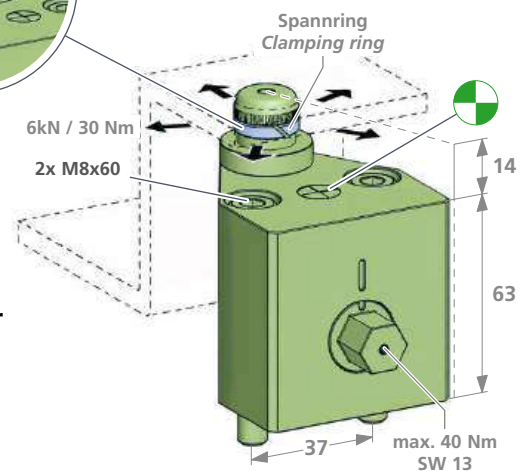
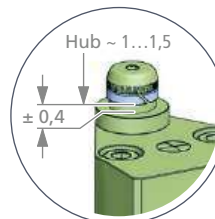
Bestellbeispiel / Order example:
Bohrung Werkstück = ø15,7 mm
XXXX = 1570

Artikelnummer	VB1-41-1570
Article number	VB1-42-1570
Article number	VB1-43-1570
Article number	VB1-44-1570



Spannringe werden für den gewünschten Spanndurchmesser geliefert.
Clamping rings are supplied for the required clamping diameter.

- ✓ 2 Baugrößen
2 sizes
- ✓ Bohrungsgrößen ab Ø 6 - 30 mm
bore sizes from
- ✓ Wiederholgenauigkeit <0,02 mm
repeat accuracy
- ✓ selbsthemmende Spannschraube
self-locking clamping spiral
- ✓ gute Werkstück Zugänglichkeit
good workpiece accessibility
- ✓ einfache Anpassung an verschiedene Spanndurchmesser
simple adaptation to different clamping diameters
- ✓ kombinierbar mit powerCLAMP
can be combined with powerCLAMP



mit Nullpunkt
with zero point

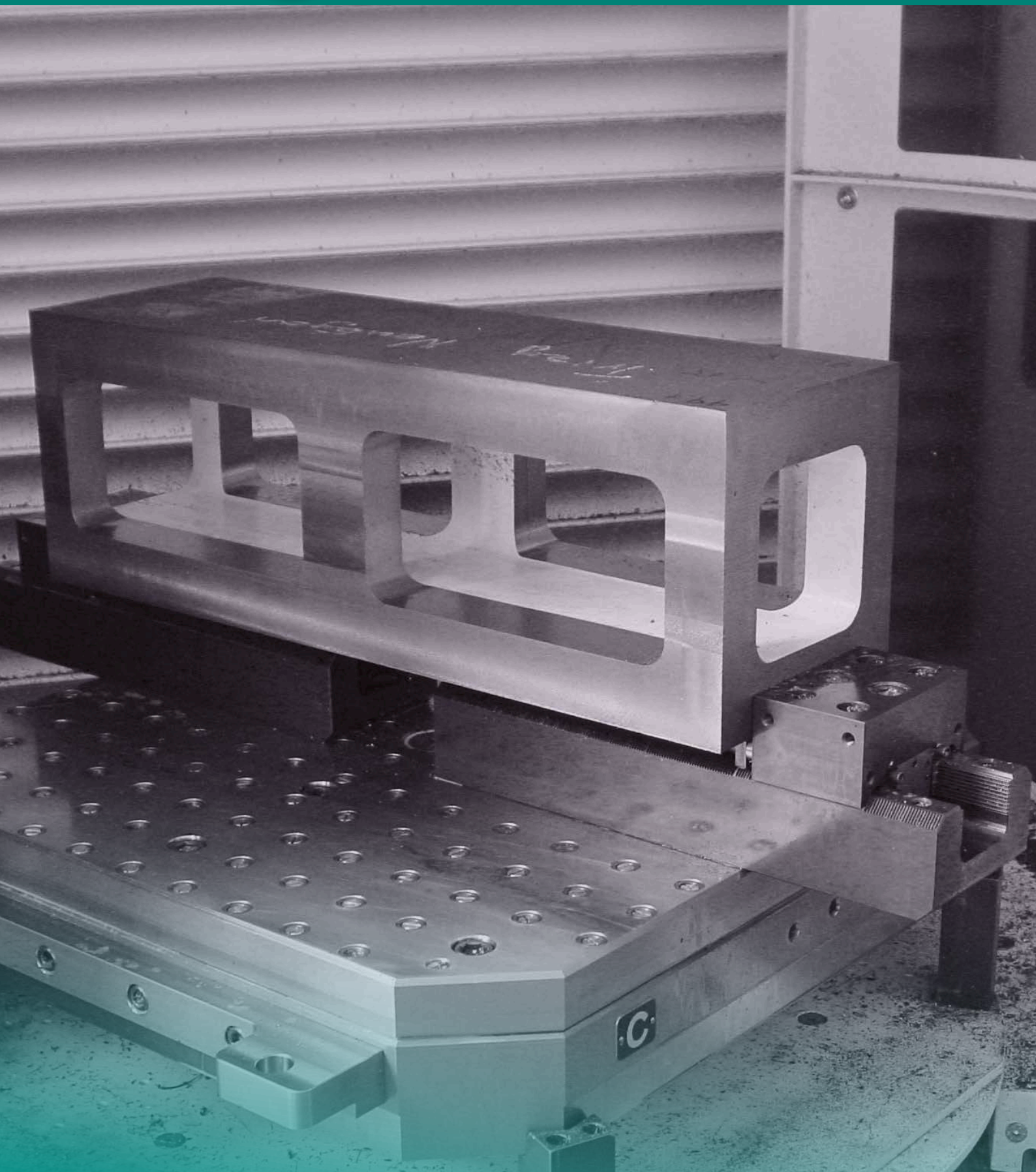
mit Ausgleich
with equalisation

ohne Nullpunkt
without zero point

ohne Nullpunkt / Niederzug
without zero point / pull down



*apto*CLAMP & *5axes*





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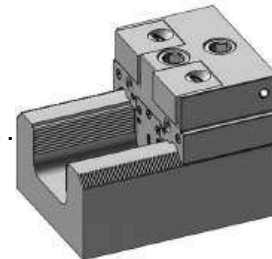
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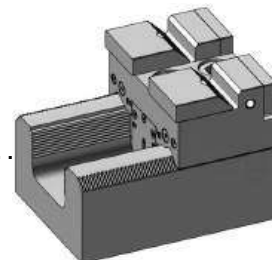
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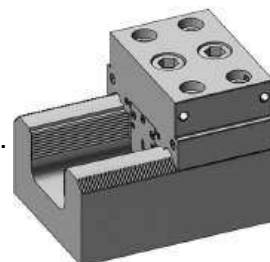
Niederzugspannmodule | *Pull down clamp modules* 223 - 226



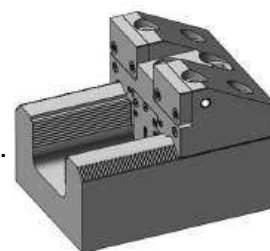
Linearspannmodule mit Präge- und Linearbacken
Linear clamping modules with stamping and linear jaws 227



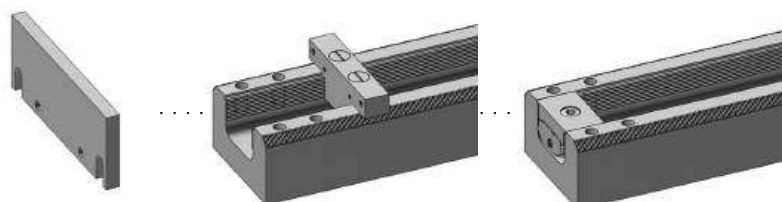
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5-Achs Linearanschlagmodule mit Präge- und Linearbacken
5-axis linear clamping modules with stamping and linear jaws 231



Zubehör | *Accessories* 232 - 233



Die Idee des Mehrfachspannens The idea of multiple workholding

Schwerstzerspanung / Heavy duty machining

aptoCLAMP

Die hohe Spannkraft dieses Systems ermöglicht den Einsatz für schwere Zerspanung.

Mit stabilen Kraftspannern können auf den Basisschienen auch grosse, bis zu mehrere tausend Kilogramm schwere Platten und Blöcke gespannt werden.

The high clamping force of the Apto Clamp enables heavy cuts. You achieve maximum rigidity with our Apto Clamp modular system! Even if your workpiece is thousands of kilograms you don't have to worry to clamp big parts and big plates.

Elefantenstark und anwenderfreundlich Powerful and user-friendly



Zur Positionierung der Spannmodule hat das Apto Clamp neben einer Querverzahnung zusätzlich ein Ankersystem zur Arretierung an einer Längsverzahnung in der Basischiene. Durch die rechtwinklige Verteilung wird eine von Mitbewerbern unerreichte Stabilität gewährleistet. Die Spannmodule liegen auf der genau geschliffenen Auflagefläche der Basis auf. Durch das Ankersystem und die geschliffene Auflagefläche wird das Spannmodul an der Basischiene extrem kraftschlüssig und präzise fixiert. Trotzdem können die Spannmodule völlig ungehindert entlang der Basis verstellt (verschoben) werden. Auch das Auswechseln der Module ist einfach, müssen doch diese nicht aus der Schiene ausgefahren, sondern können abgehoben werden.

For positioning the clamp modules on the base rails, has the Apto Clamp system next to a positioning serration a horizontal anchor system for locking with enornes force produced by two M16 screws. The end modules have additionally 4 M12 screws to give extra rigidity.



Schnelligkeit / Quickness



Zwei Schraube lösen
Loosen two screws



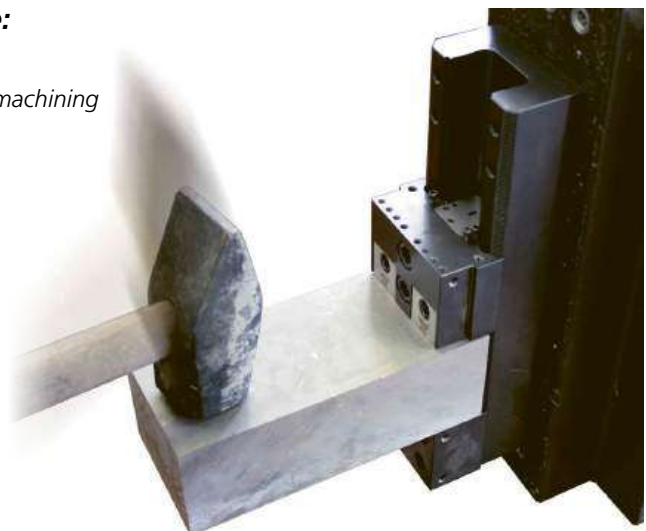
Abheben und neu platzieren
Lift and change position

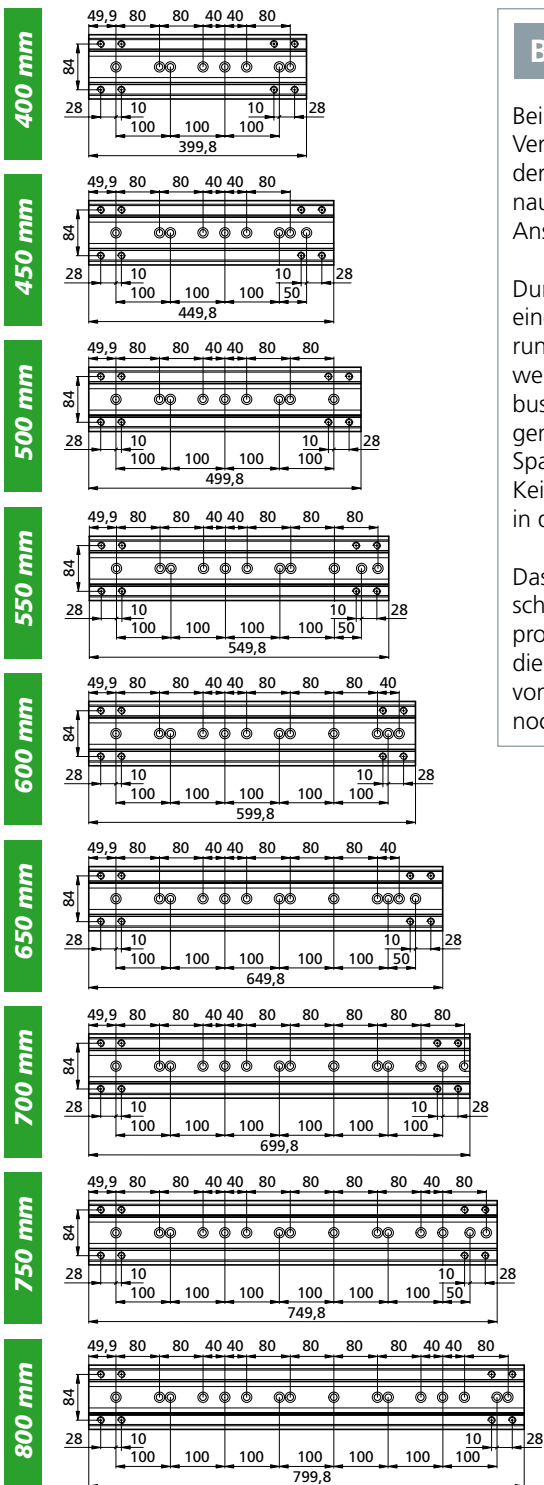


Zwei Schrauben anziehen
Fasten two screws

Vorteile auf einen Blick / Benefits at a glance:

- ➔ Sehr stabil, robuste Bauweise, dadurch hohe Präzision
Very stable, robust design allows high precision and heavy machining
- ➔ Module nach oben abhebbar, kein Ausfahren nötig
Modules can be lifted up, no extension needed
- ➔ Keine verschmutzbaren T-Nuten: Formschlüssig positioniert
No chip loading T-slots grooves: Positively positioned
- ➔ Verzahnung nicht dem Werkstück ausgesetzt
The teeth are not exposed to the workpiece
- ➔ Niederzug- und Linearspannung möglich
Pull-down and linear clamping possible
- ➔ Spannkraft bis 7000 daN pro Modul
Clamping force up to 7000 daN per module





Basisschiene / Base rail

Beim Apto Clamp ermöglicht eine Verzahnung mit 2 mm-Teilung auf der Basisschiene ein schnelles und genaues Positionieren der Spann- und Anschlagmodule.

With the new Apto Clamp a serration of 2mm pitch on the base rail allows a rapid and accurate positioning of the modules.

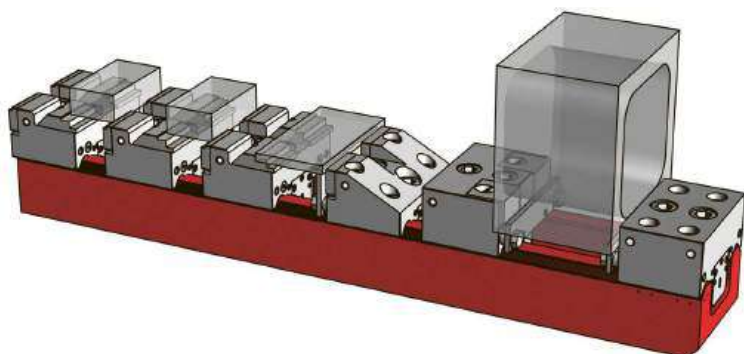
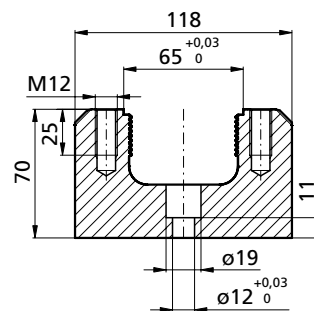
Durch gezielte elastische Deformation einer Lippe erfolgt eine spielfreie Paarung. Spann- und Bearbeitungskräfte werden einerseits an der ebenen, robusten Oberseite der Basisschiene aufgenommen, während andererseits das Spannmodul durch einen spreizenden Keil mit robustem Rundgewindeprofil in der Schiene verankert wird.

The outstanding development is that through elastic deformation of a lip, the engagement between the modules and the base rail is without play. Clamping and machining forces are absorbed on the upper surface of the base rail whereas the vice module is fixed to the rail by an expandable anchor which engages the round serration inside the base rail.

Das Einfügen zusätzlicher Module zwischen bestehenden Spannstellen ist problemlos möglich. Apto Clamp ist die konsequente Weiterentwicklung vom Power Clamp zur Bearbeitung noch grösserer Werkstücke.

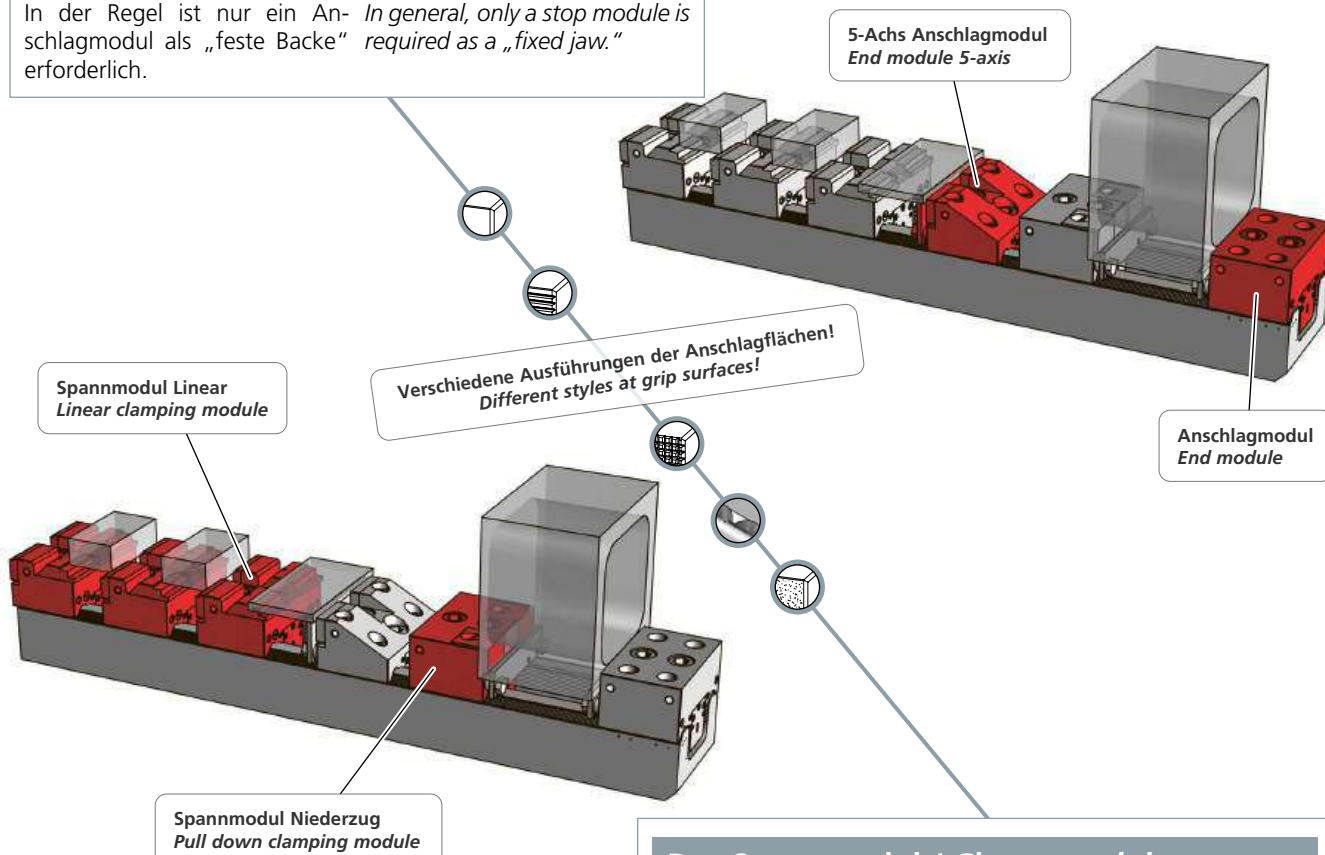
The insertion of additional vice modules can be accomplished without problems. Apto Clamp is the logical development of Power Clamp to handle even larger work pieces.

Schnittzeichnung Sectional view of the base rail



Das Anschlagmodul / End modules

In der Regel ist nur ein Anschlagmodul als „feste Backe“ erforderlich.
In general, only a stop module is required as a „fixed jaw.“

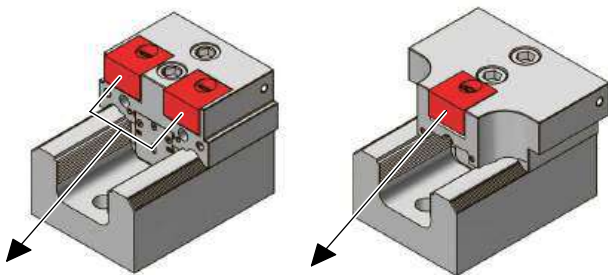


Das Spannmodul / Clamp modules

Die «beweglichen Backen» gibt es in zwei Ausführungen. Zum einen für das Niederzugspannsystem und zum anderen für das Linearspannsystem. Dabei dient das Spannmodul bei den Systemen wiederum als Anschlagmodul für die nächste Aufspannung.
Clampe modules have movable jaws (linear or pull down) in the front to clamp the part and on the back there is the datum face for the next work piece stop. Positioning step on the base rail is 2mm every.



Niederzugspannmodule Pull down clamp modules



Die Fakten beim Niederzugspannsystem

Verstellbereich: 0- 3,8 mm
Spannkraft: Bis 7'000 daN

Vorteile beim Niederzugspannsystem:

- Höhere Haltekräfte
- Hohe Wiederholgenauigkeit
- Optimale Spannmethode für Kleinteile
- Mit Schnellwechselbacken
- Doppelspannsystem in einer Backe zum Spannen und Bearbeiten von zwei Kleinteilen

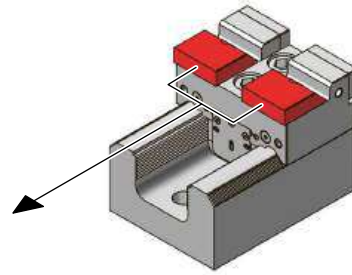
Facts for pull down clamp modules

Jaw range: 0- 3,8 mm
Clamping force: up to 7'000 daN

Advantages pull down jaws:

- Higher holding force
- With linear adaptable jaws
- Also with pull down jaws for the stop side available
- With adapter set can be changed to linear
- Also pull down jaws for datum face

Linearspannmodule Linear clamp modules



Die Fakten beim Linearspannsystem

Verstellbereich: 0- 5,0 mm
Spannkraft: Bis 3'200 daN

Vorteile beim Linearspannsystem:

- Spannstockähnliches Spannen
- Prozesssichere Positionierung der zweiten Aufspannung
- Gut geeignet für die Erstellung von individuellen Formbacken
- Sicherer Halt mit Prägetechnik

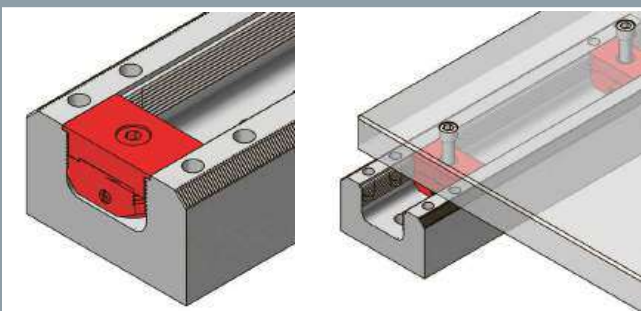
Facts for linear clamp modules

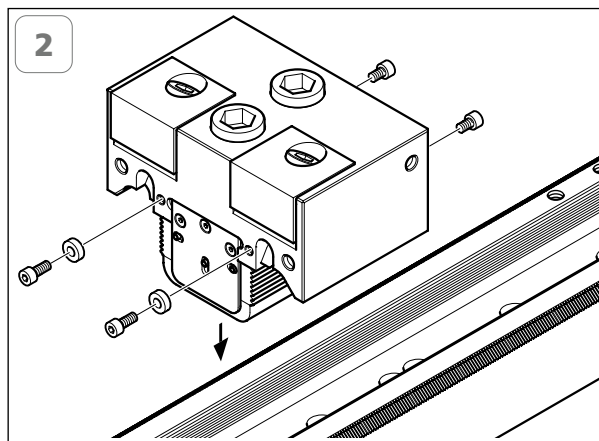
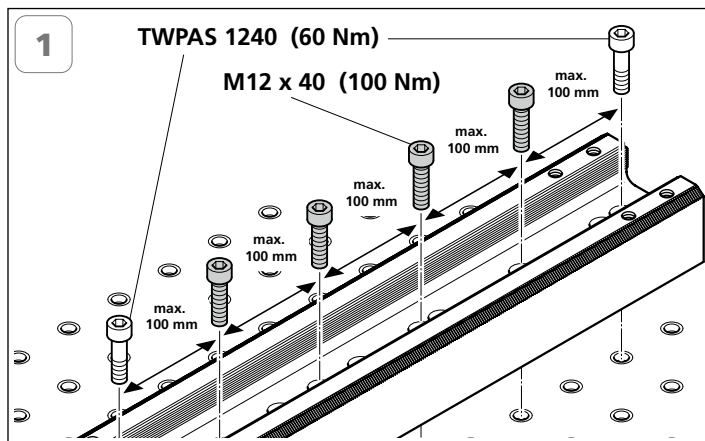
Jaw range: 0- 5,0 mm
Clamping force: up to 3'200 daN

Advantages linear jaws:

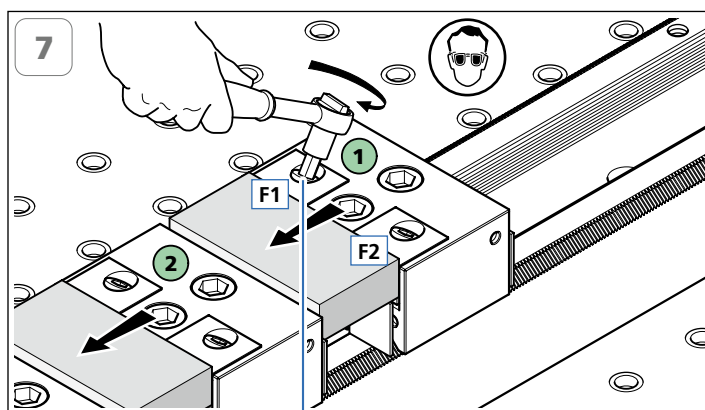
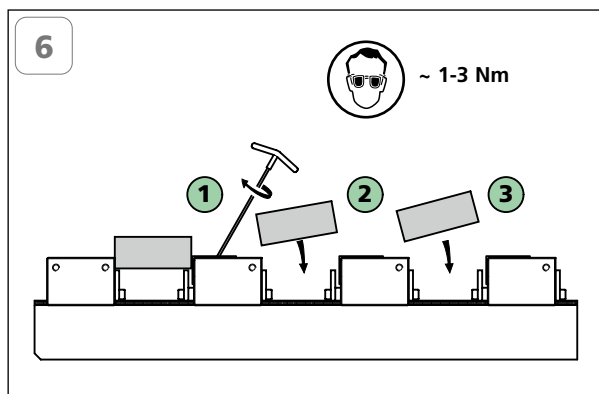
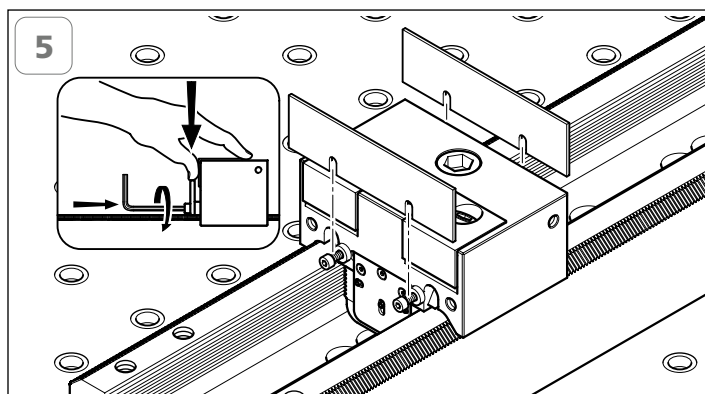
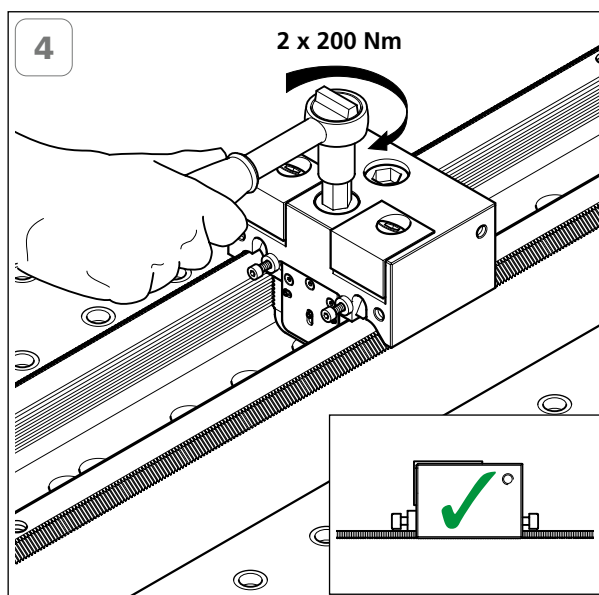
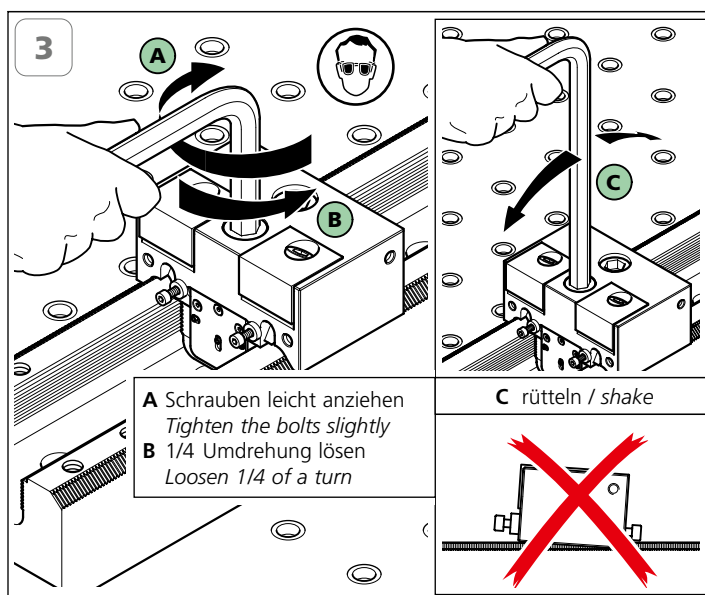
- Similar clamp as conventional vise
- Good for shaped jaws
- Secure clamped with direct stamping jaws
- Higher accuracy

Universalnutenstein Universal nut





Ineinandergreifen der Verzahnung prüfen
Check matching of the teeth



max. Drehmoment beachten
Observe max. torque

Schraube Screw	Drehmoment Torque		Spannkraft (F1 & F2) Workholding force (F1 & F2)		
	Nm	(lb-ft)	~daN	~(lb)	~t
M10	10	7,4	= 1200	2'650	1,2
	20	14,8	= 2700	5'950	2,7
	30	22,2	= 4100	9'040	4,1
	40	29,5	= 5600	12'350	5,6
	50	37,0	= 7000	15'430	7,0

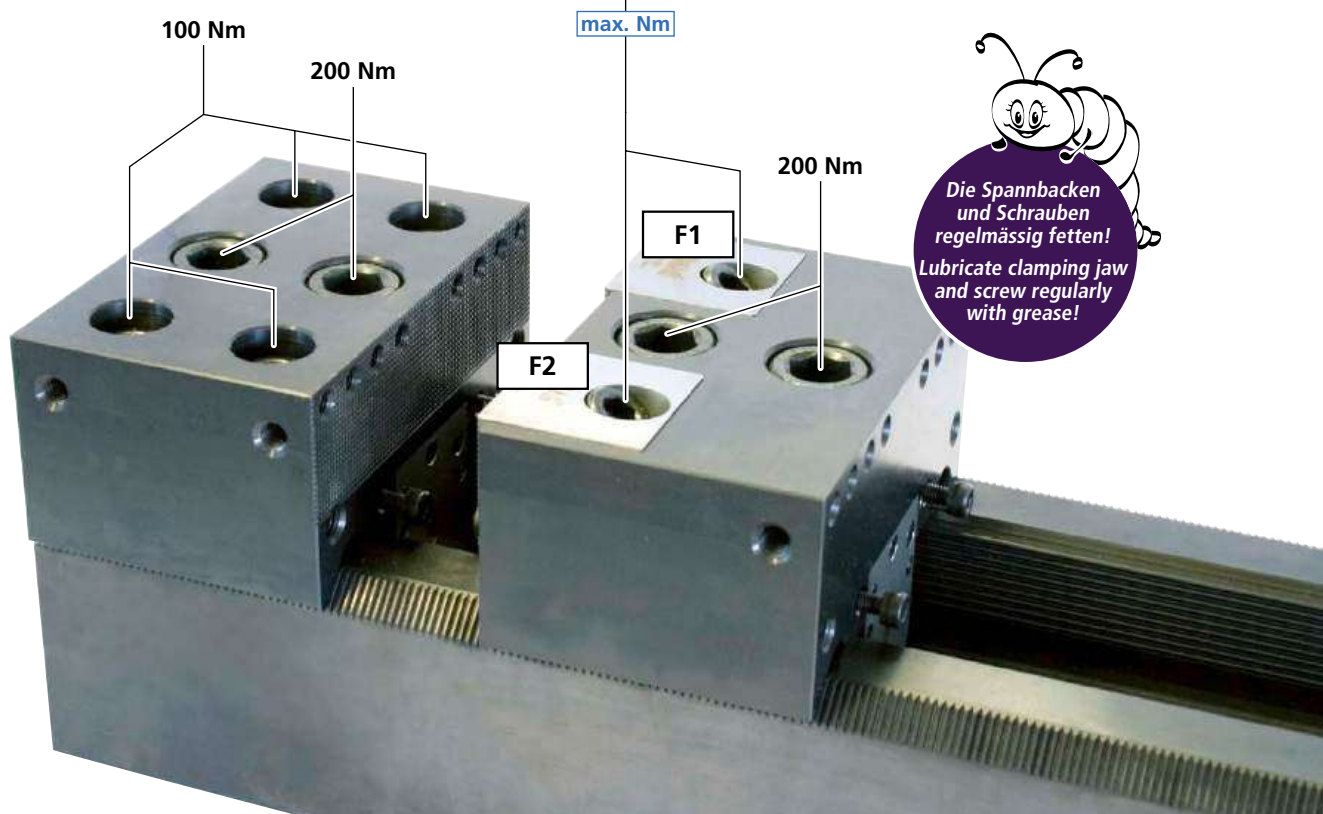
max. Nm

ACHTUNG / CAUTION

WICHTIG: Die angegebenen Drehmomente sind die absoluten Maximalwerte. Über die Spannkräfte gibt die untenstehende Tabelle Auskunft.

IMPORTANT: The torque numbers specified represent the absolute maximum. The table at the bottom of this page provides further information on the workholding forces.

Schraube Screw	Drehmoment Torque		Spannkraft (F1 & F2) Workholding force (F1 & F2)		
	Nm	(lb-ft)	~daN	~(lb)	~t
M10	10	7,4	= 1200	2'650	1,2
	20	14,8	= 2700	5'950	2,7
	30	22,2	= 4100	9'040	4,1
	40	29,5	= 5600	12'350	5,6
	50	37,0	= 7000	15'430	7,0

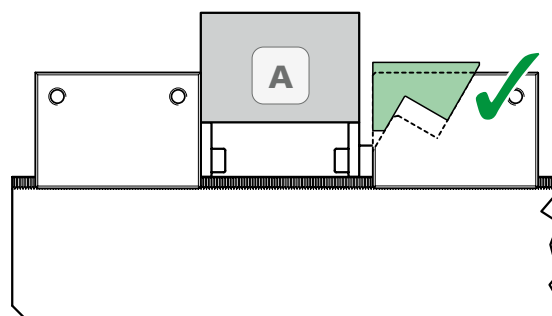
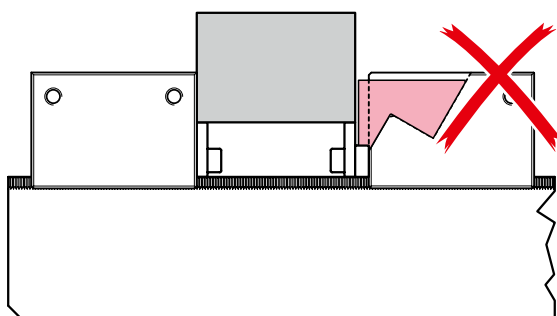


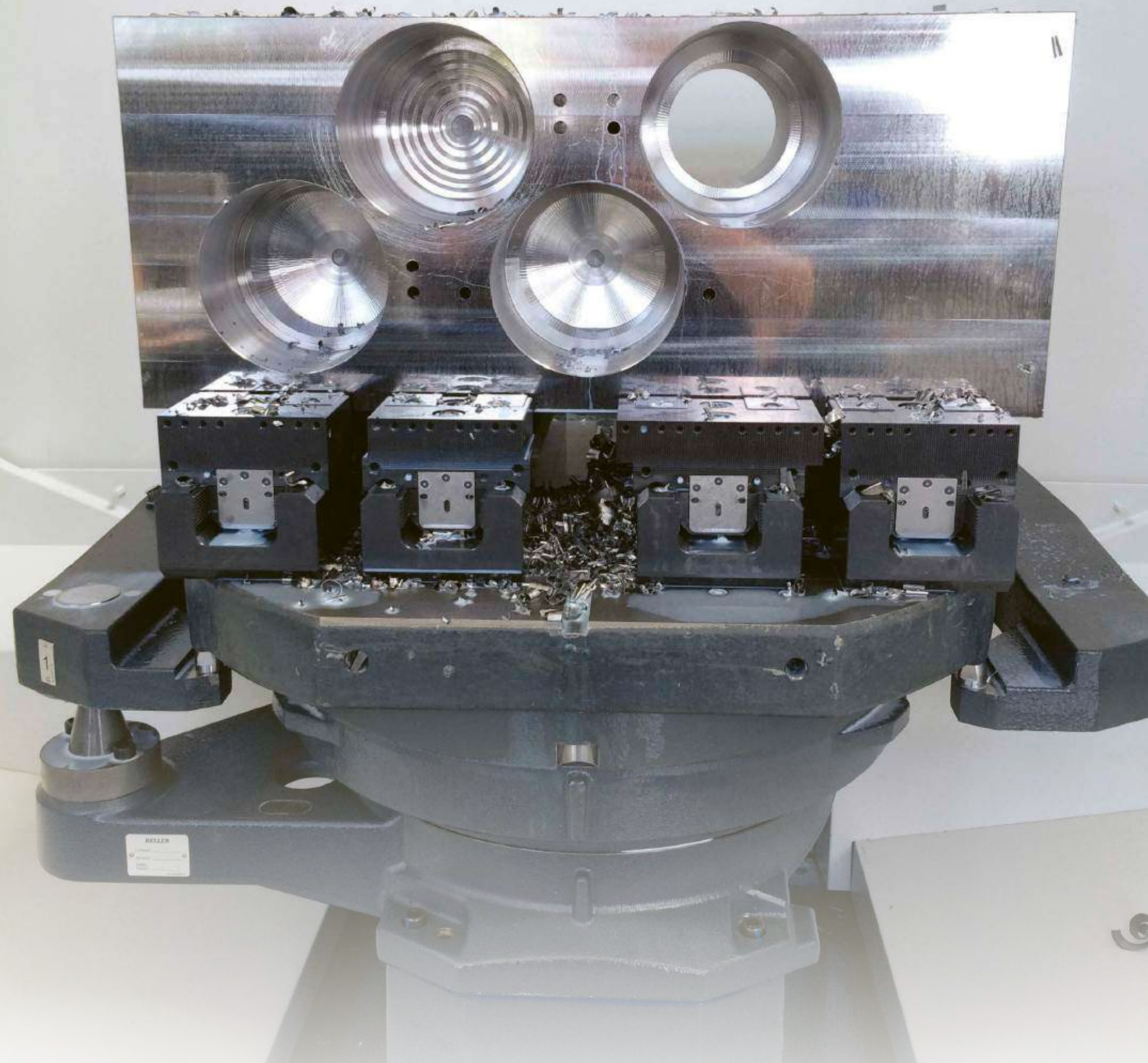
WICHTIG:

Vor dem Positionieren der Spannmodule für ein neues Werkstück ist die Spannbacke ganz zurück zu stellen, dies gewährleistet eine sichere Spannung (siehe Bild A)!

IMPORTANT:

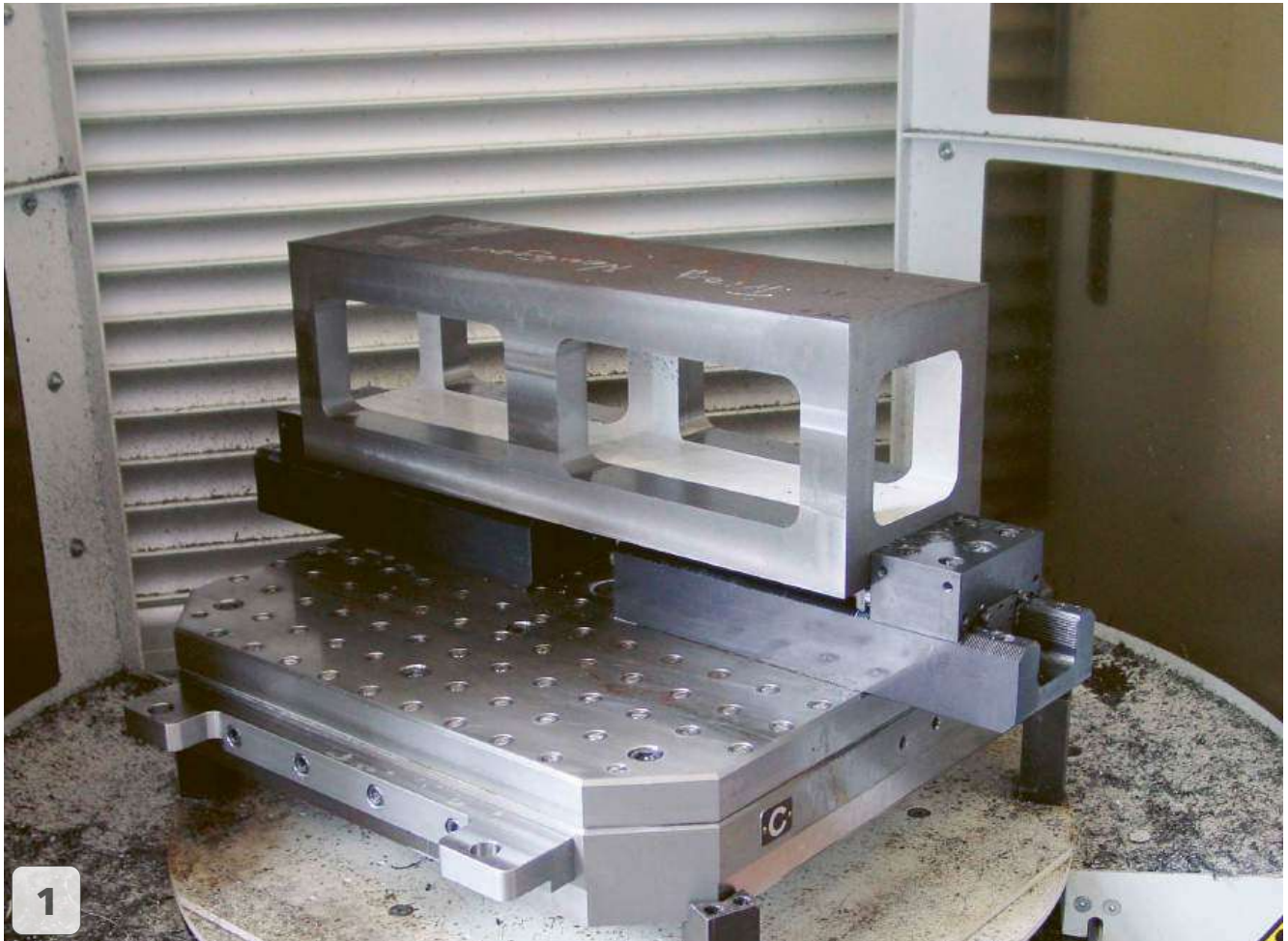
Prior to setting up a new clamping module the clamping jaw of the vice module must be retracted all the way (see picture A)! This guarantees proper clamping of the new workpiece.

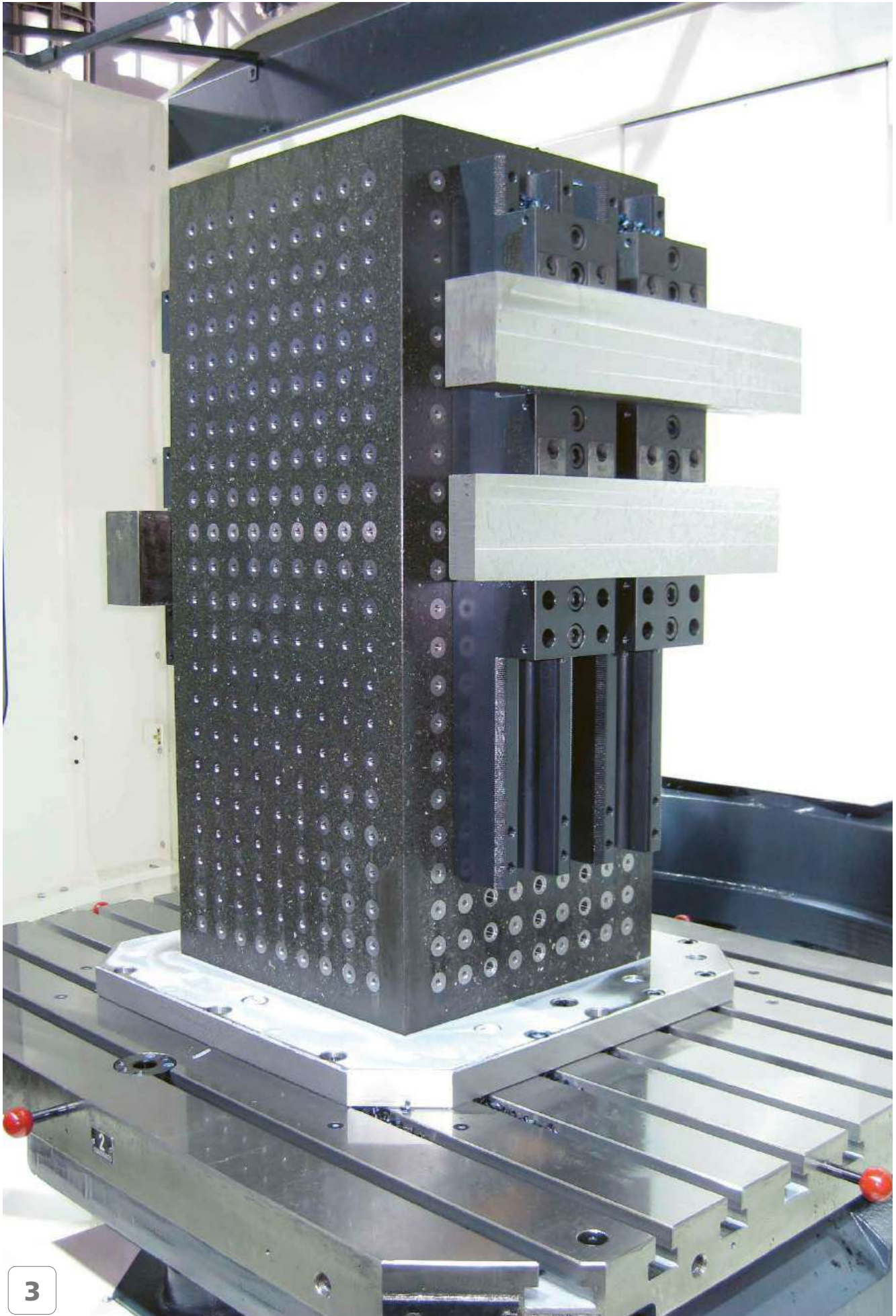


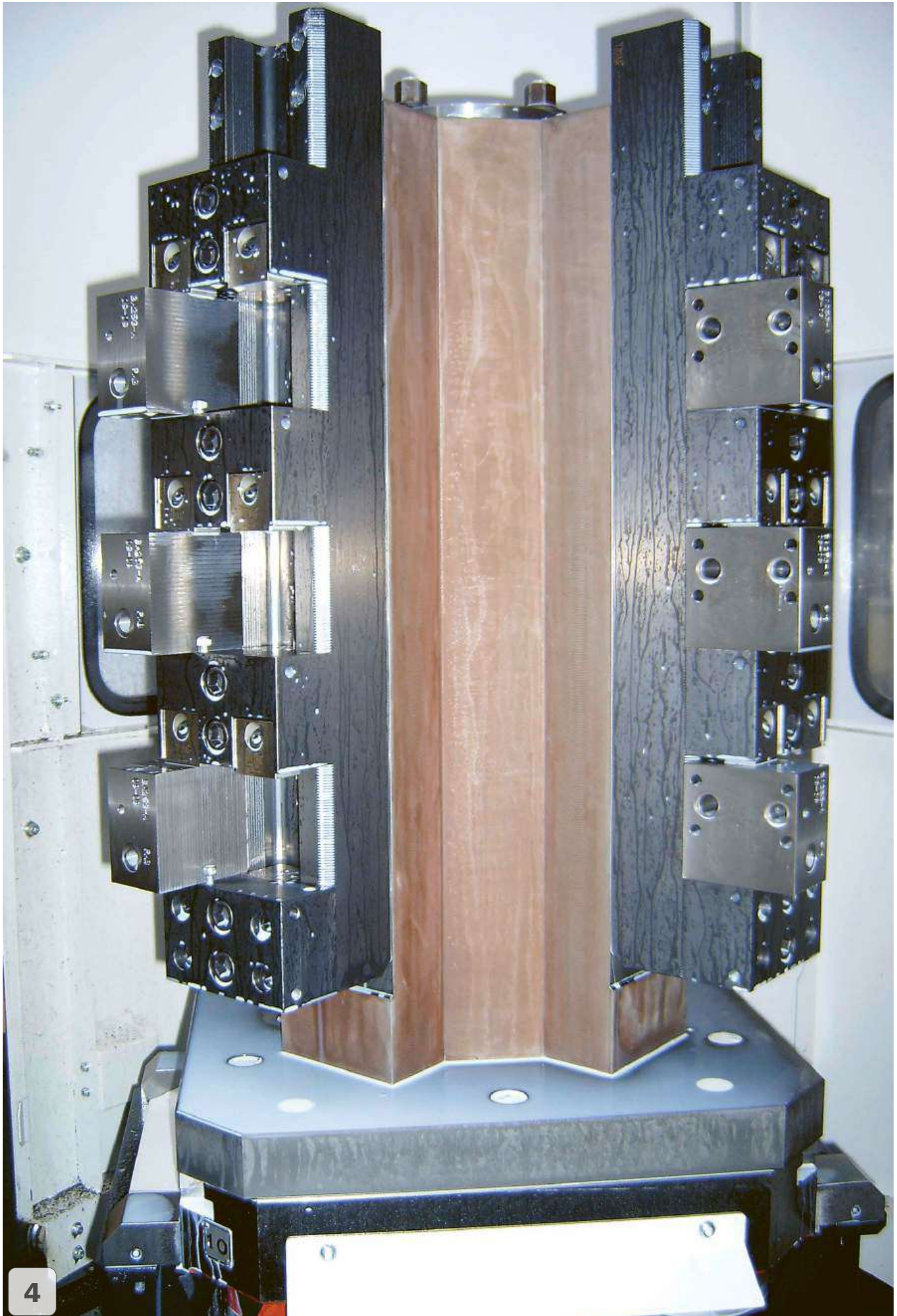


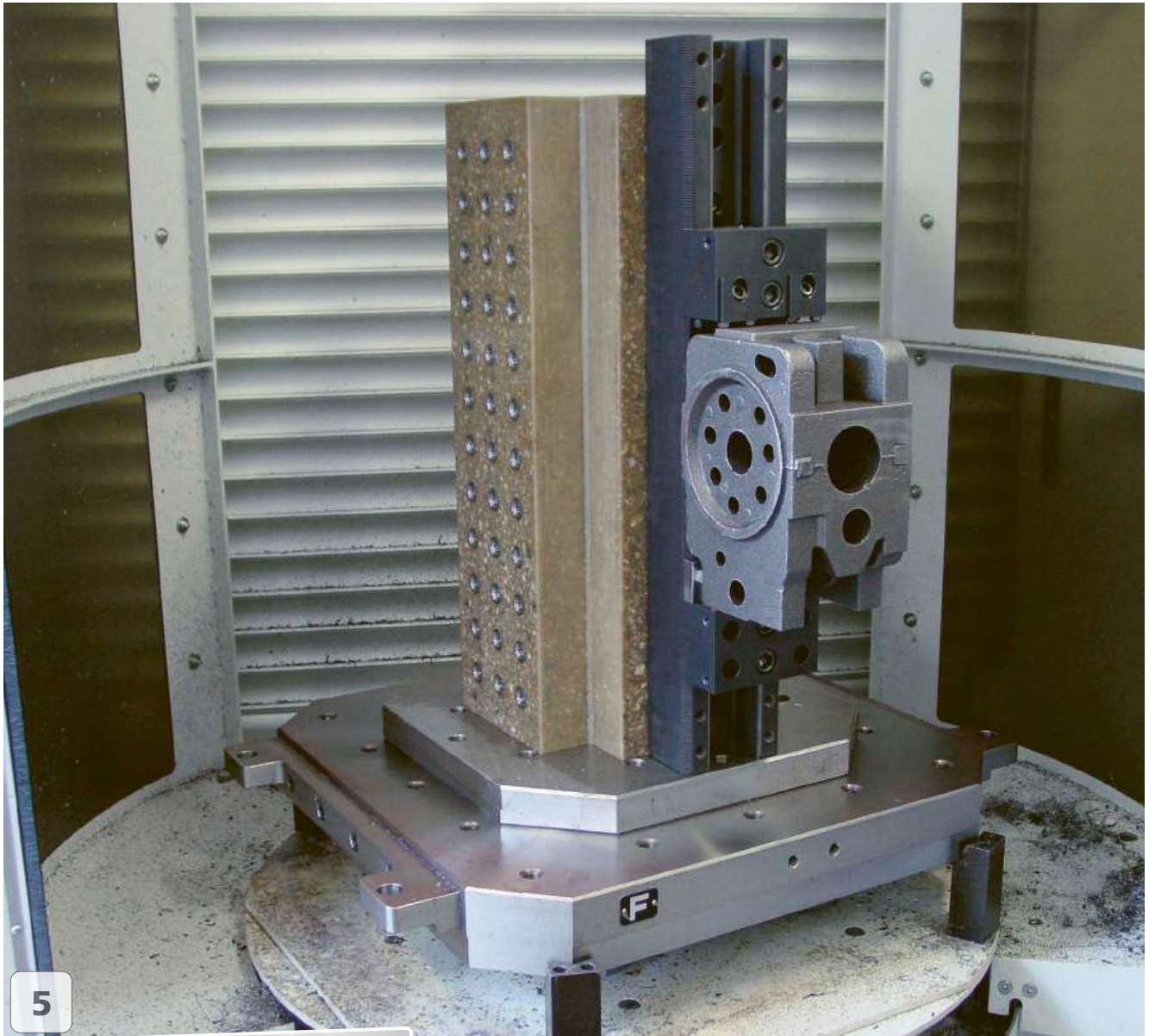
Material	42Cr Mo4
Bearbeitung mit Fräskopf	Ø 200
<i>Machining with milling head</i>	
Bohrer / Drills	Ø 124
Einspanntiefe / Clamping depth	24mm

Apto Clamp in der Schwerzerspannung auf Heller 5-Achsen-Maschine
Apto Clamp for heavy duty machining on a 5-axis machine



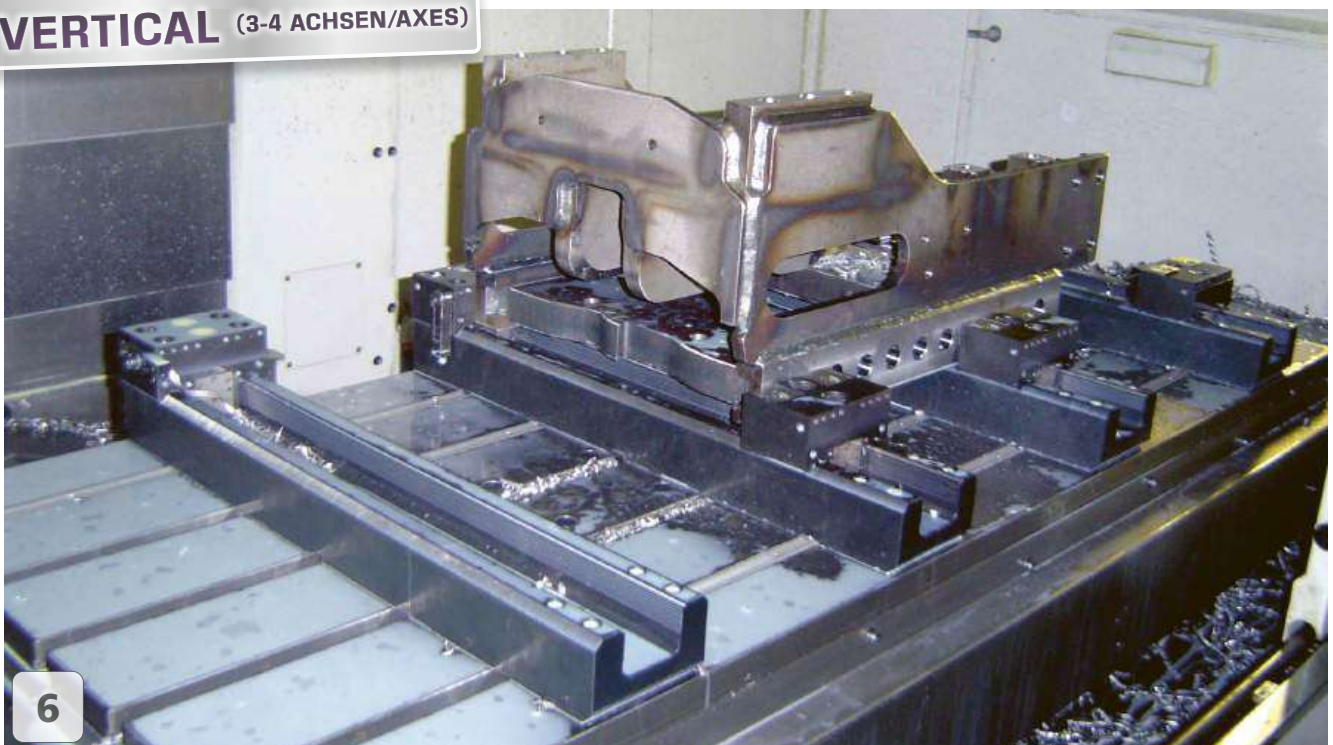






5

VERTICAL (3-4 ACHSEN/AXES)



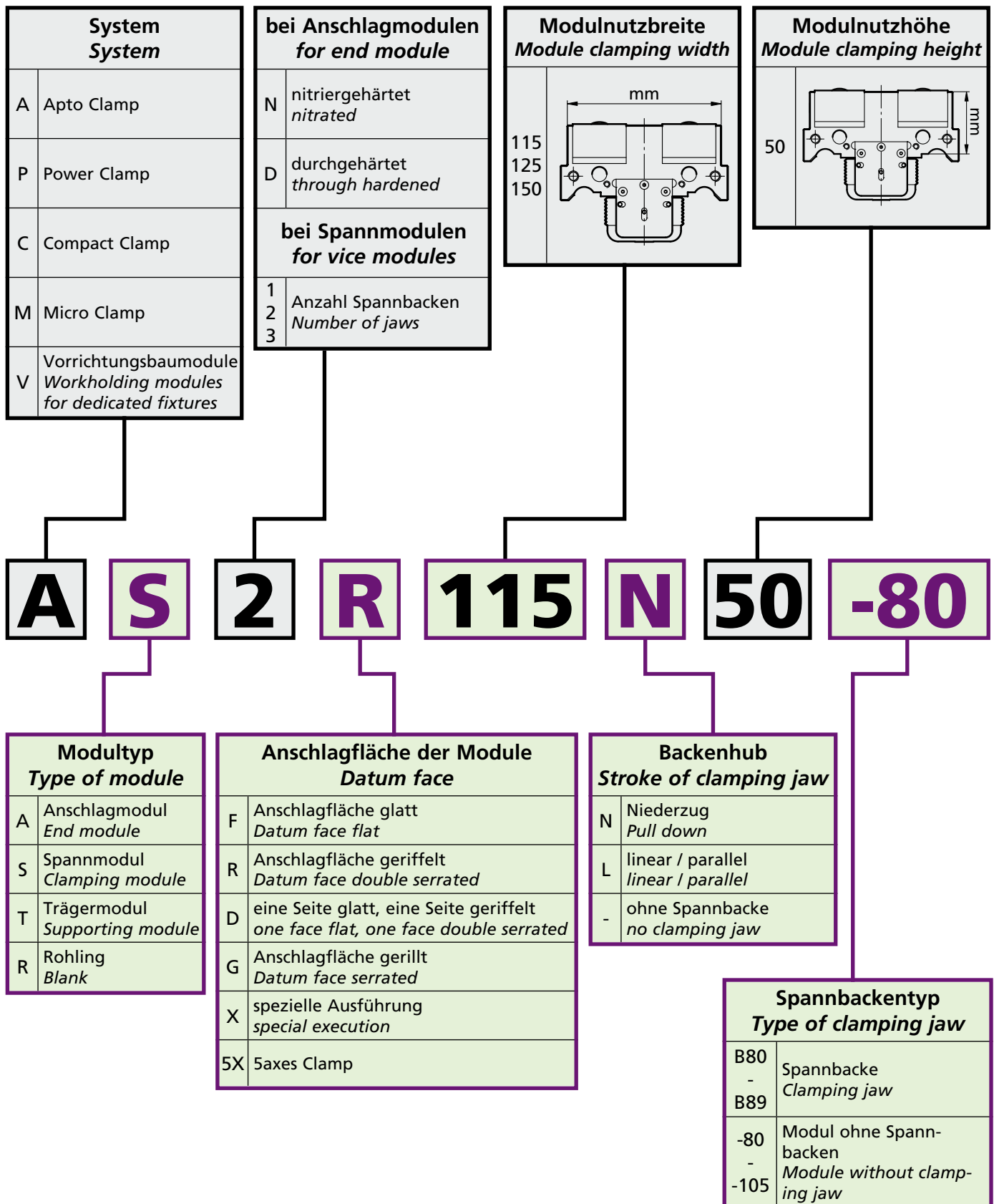
6

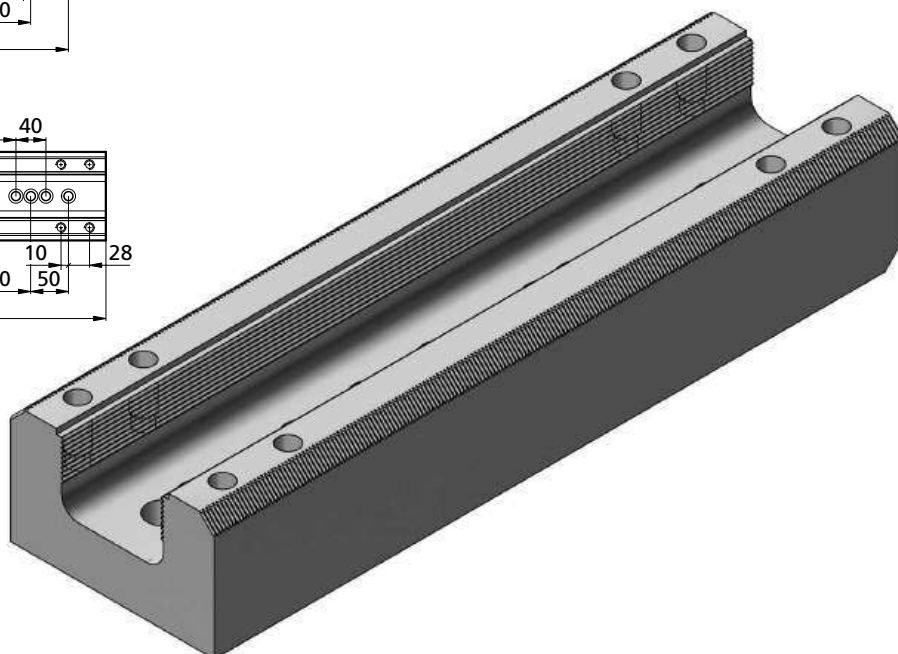
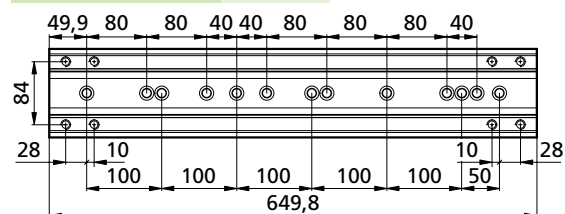
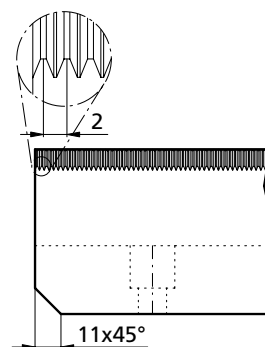
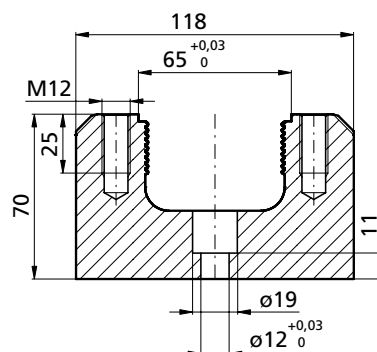
Es gibt zusätzlich Apto Clamp Module in angeschrägter Ausführung. Damit kann ein optimaler Zugang zum Werkstück bei der 5-Achsenmaschine gewährleistet werden. Die Spannmodule produzieren bis zu 7000daN (7 Tonnen) Spannkraft und sind für die Schwerzerspannung empfohlen.

We offer Apto Clamp modules in slanted version. That ensures an optimal access to the workpieces on 5-axis machines. The clamping modules produce up to 7000daN (7 tons) clamping force and are recommended for heavy roughing workholding.



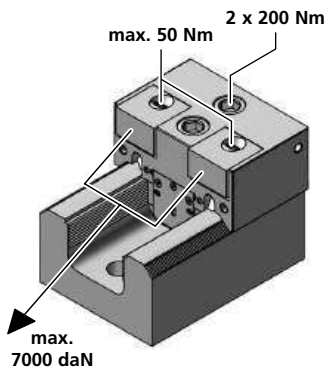
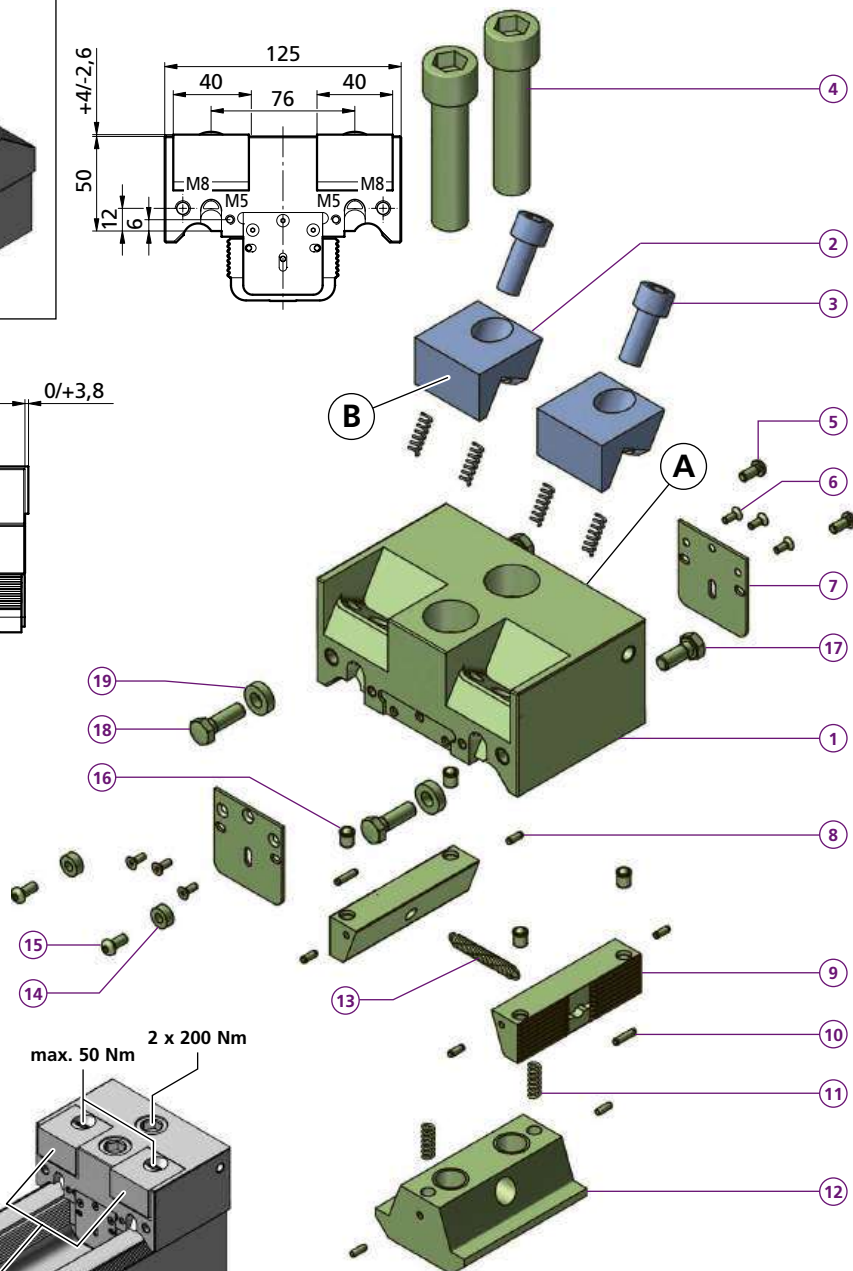
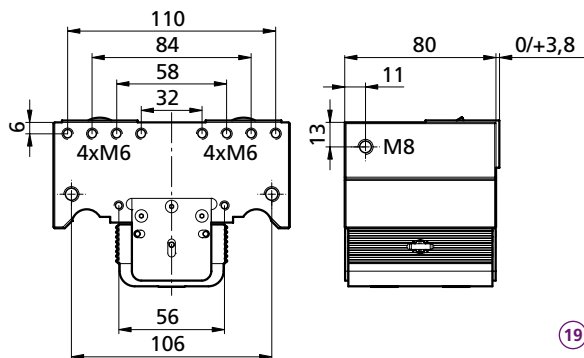
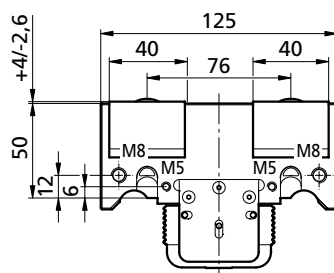
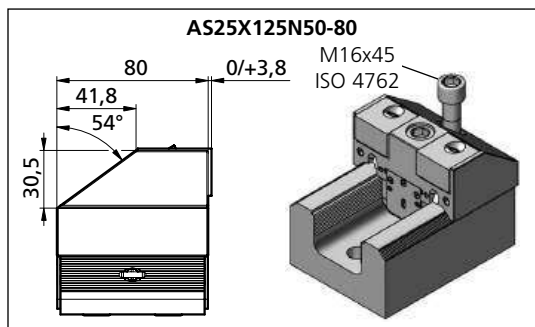
Gute Zugänglichkeit auf 5-Achs Maschine, gespannt mit 2 x 7 Tonnen!
Fast setup fast clamping and perfect for short tool holders!





AS2R/F125N50-80 AS25X125N50-80

5axes
aptoCLAMP



AS25X125N50-80

- 1x TF140682
- 1x M16X45ISO4762
- 1x M16X70ISO4762
- 2x M8X20ISO4017
- 2x ACD005
- kg ~4,3

AS2F125N50-80

- 1x TF140680

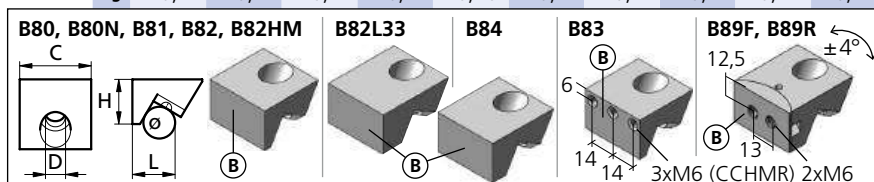
AS2R125N50-80

- 1x TF140681

- 2x
- 2x M10X25ISO4762
- 2x M16X70ISO4762
- 2x M5X10ISO7380-1
- 6x M3X6DIN7991
- 2x ACBL4243
- 6x Ø 3x8 BN 879
- 2x ACSP7620
- 2x Ø 3h 8x12 ISO 2338
- 6x FED0618
- 1x ACD005
- 1x FED Ø 5,5x39
- 2x PCD005
- 2x M5X14ISO7380-1
- 4x Ø 6-Niro SM1275-3
- 2x M8X16ISO4017
- 2x M8X20ISO4017
- 2x ACD005
- kg ~4,9

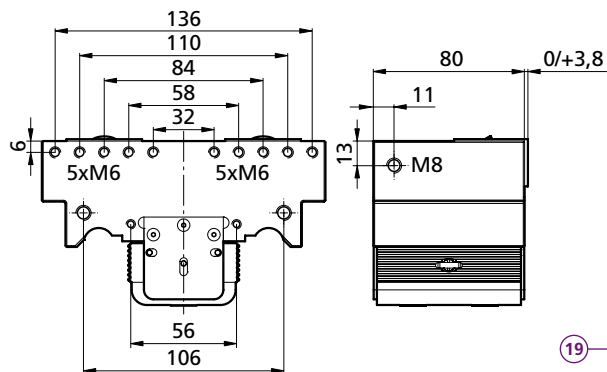
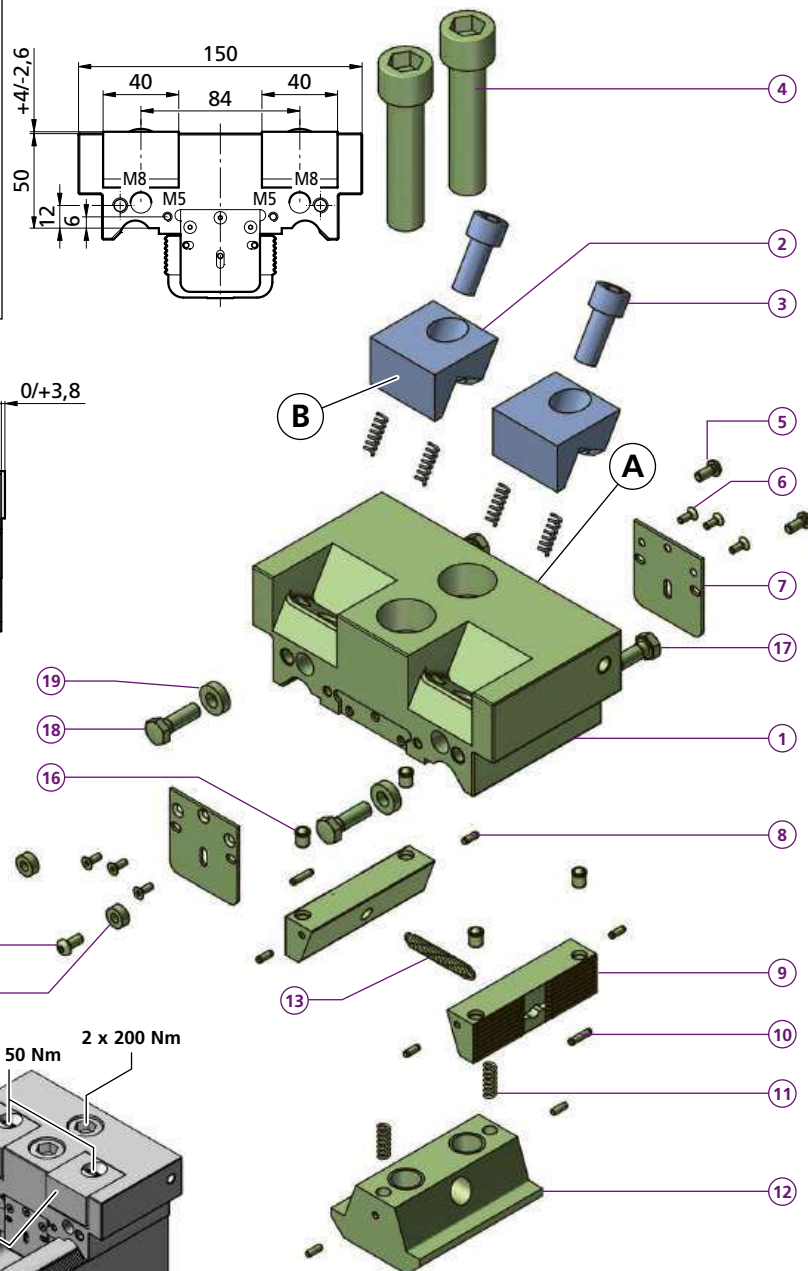
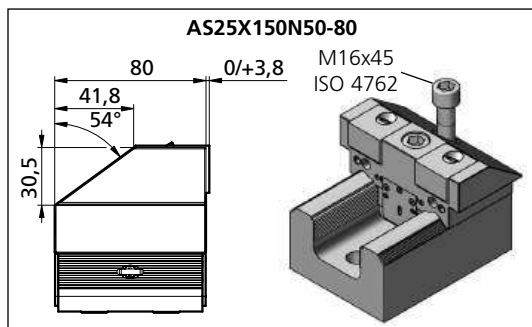
Bestellbeispiel / Ordering example: 1x AS2R125N50-80 & 2x B80

	B80	B80N	B81	B82	B82L33	B82HM	B83	B84	B89F	B89R
C	40	40	40	40	40	40	40	40	40	40
H	25	25	25	25	25	25	25	25	25	25
L	22	22	22	22,2	33	22,2	22	26,3	29	29
D	11	11	11	11	11	11	11	11	11	11
e	15	15	15	15	15	15	15	15	15	15
i	56HRC	HV700 x0,2mm	56HRC	*	*	56HRC	HV700 x0,2mm	*	HV700 x0,2mm	HV700 x0,2mm
kg	~0,2	~0,2	~0,2	~0,2	~0,28	~0,2	~0,2	~0,2	~0,24	~0,24

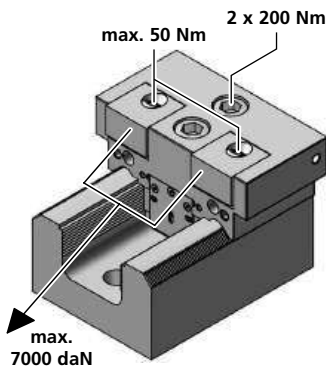


AS2R/F150N50-80 AS25X150N50-80

5axes
aptoCLAMP

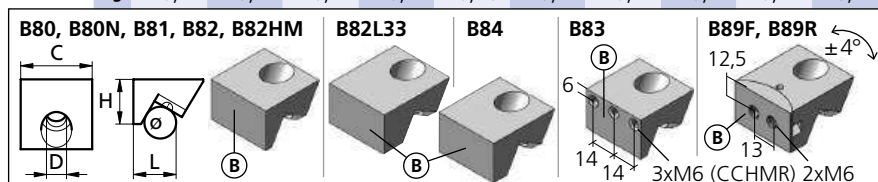


AS25X150N50-80	
1	1x TF140687
4	1x M16X45ISO4762
18	1x M16X70ISO4762
19	2x M8X20ISO4017
kg	~4,7
AS2F150N50-80	
1	1x TF140685
AS2R150N50-80	
1	1x TF140686
2	2x
3	2x M10X25ISO4762
4	2x M16X70ISO4762
5	2x M5X10ISO7380-1
6	6x M3X6DIN7991
7	2x ACBL4243
8	6x Ø 3x8 VSM 12785
9	2x ACSP7620
10	2x Ø 3h 8x12 ISO 2338
11	6x FED0618
12	1x ACD005
13	1x FED Ø 5,5x39
14	2x PCD005
15	2x M5X14ISO7380-1
16	4x Ø 6-Niro SM1275-3
17	2x M8X16ISO4017
18	2x M8X20ISO4017
19	2x ACD005
kg	~5,4



Bestellbeispiel / Ordering example: 1x AS2R150N50-80 & 2x B80

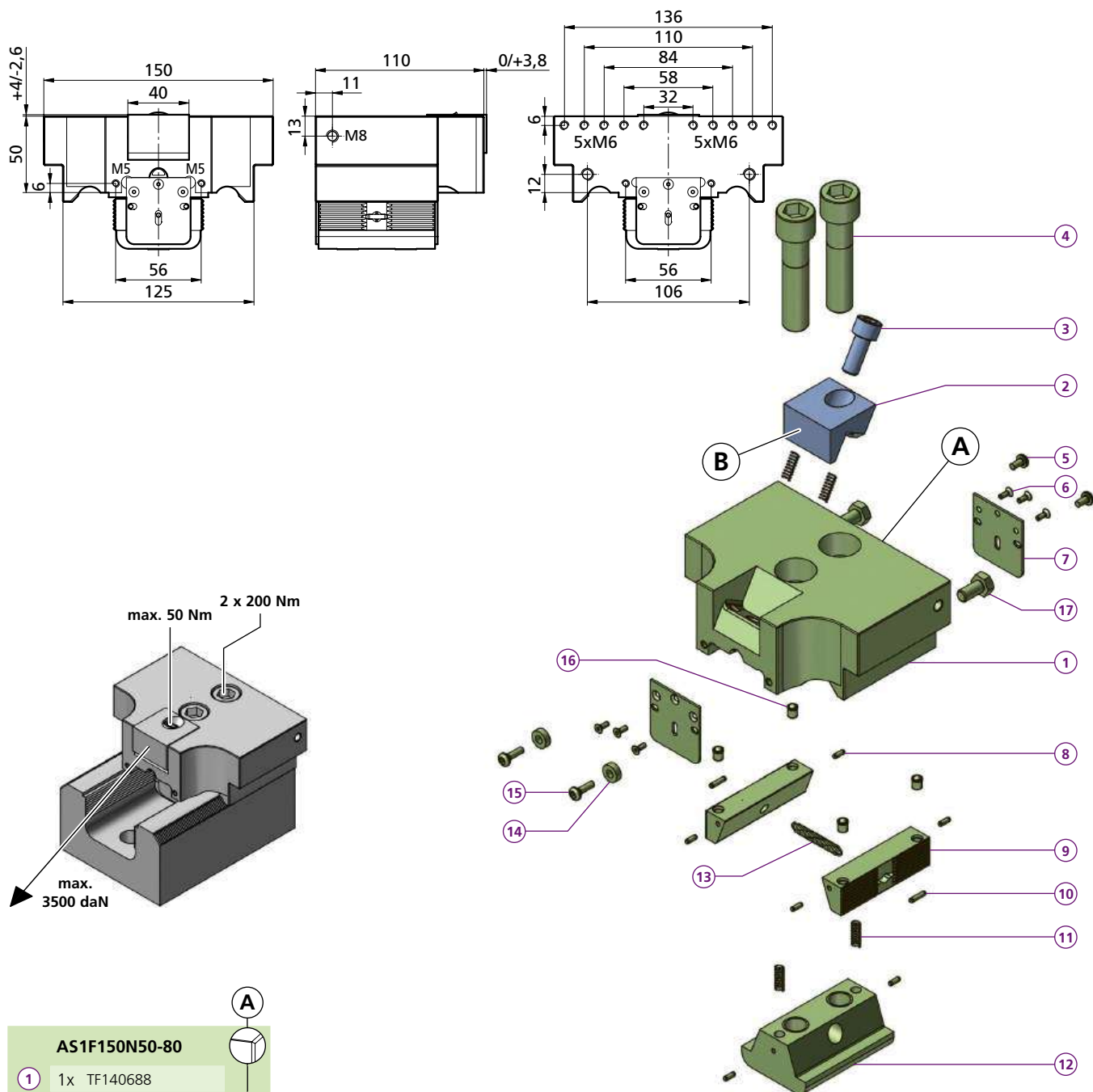
	B80	B80N	B81	B82	B82L33	B82HM	B83	B84	B89F	B89R
C	40	40	40	40	40	40	40	40	40	40
H	25	25	25	25	25	25	25	25	25	25
L	22	22	22	22,2	33	22,2	22	26,3	29	29
D	11	11	11	11	11	11	11	11	11	11
e	15	15	15	15	15	15	15	15	15	15
i	56HRC	HV700 x0,2mm	56HRC	*	*	56HRC	HV700 x0,2mm	*	HV700 x0,2mm	HV700 x0,2mm
kg	~0,2	~0,2	~0,2	~0,2	~0,28	~0,2	~0,2	~0,2	~0,24	~0,24



* = weich / soft

HM = Hartmetallbeschichtet / Carbide coated

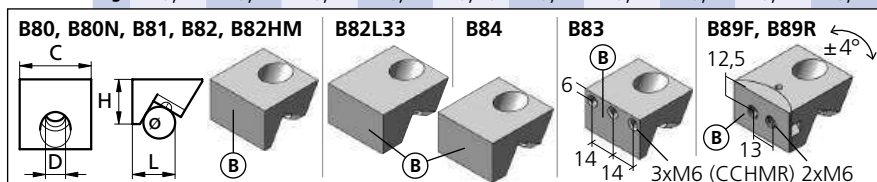
Separat bestellen / Order separately



AS1F150N50-80	
1	1x TF140688
AS1R150N50-80	
1	1x TF140689
2	2x
3	1x M10X25ISO4762
4	2x M16X70ISO4762
5	2x M5X10ISO7380-1
6	6x M3X6DIN7991
7	2x ACBL4243
8	6x Ø 3x8 VSM 12785
9	2x ACSP7620
10	2x Ø 3h 8x12 ISO 2338
11	4x FED0618
12	1x ACSK7632M16
13	1x FED Ø 5,5x39
14	2x PCD005
15	2x M5X14ISO7380-1
16	4x Ø 6-Niro SM1275-3
17	2x M8X16ISO4017
kg	~6,6

Bestellbeispiel / Ordering example: 1x AS1R150N50-80 & 1x B80

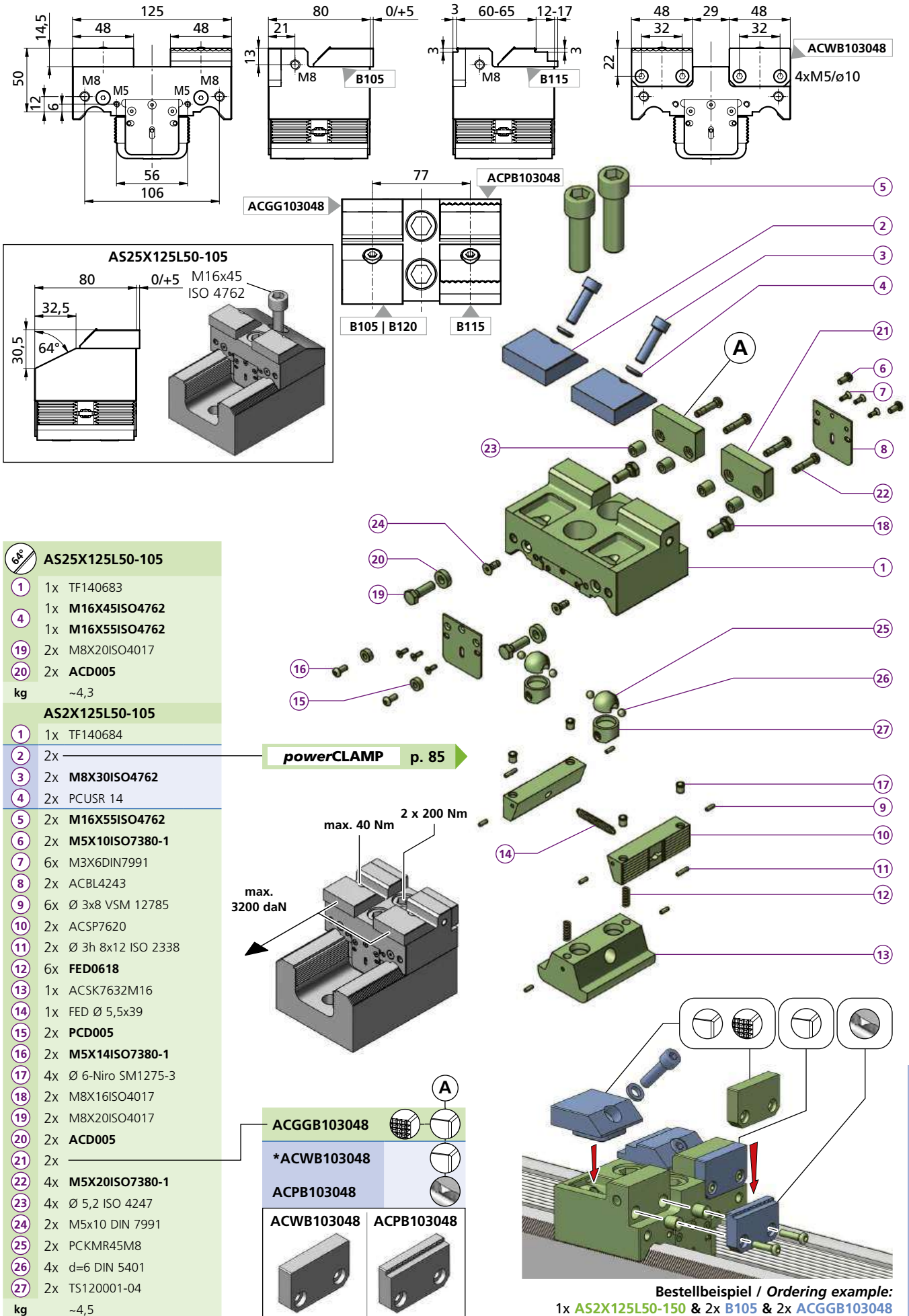
	B80	B80N	B81	B82	B82L33	B82HM	B83	B84	B89F	B89R
C	40	40	40	40	40	40	40	40	40	40
H	25	25	25	25	25	25	25	25	25	25
L	22	22	22	22,2	33	22,2	22	26,3	29	29
D	11	11	11	11	11	11	11	11	11	11
e	15	15	15	15	15	15	15	15	15	15
i	56HRC	HV700 x0,2mm	56HRC	*	*	56HRC	HV700 x0,2mm	*	HV700 x0,2mm	HV700 x0,2mm
kg	~0,2	~0,2	~0,2	~0,2	~0,28	~0,2	~0,2	~0,2	~0,24	~0,24

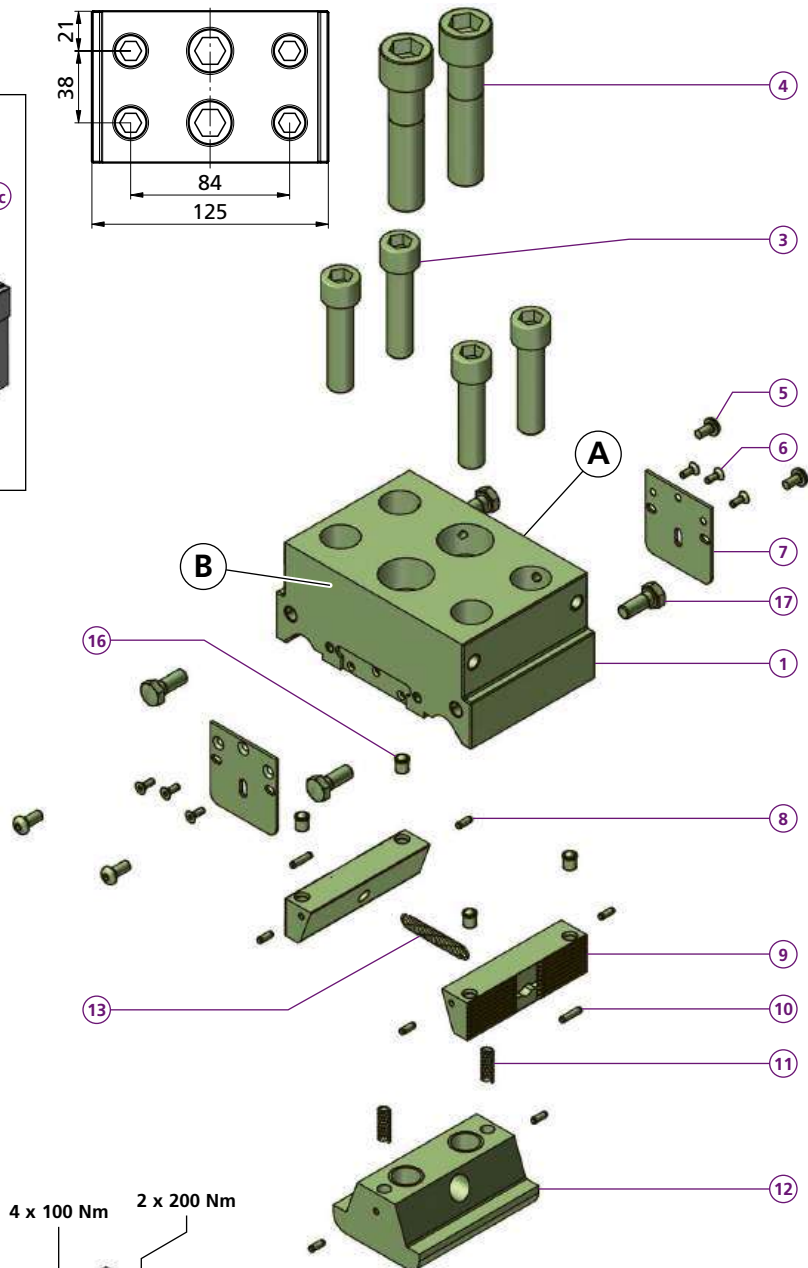
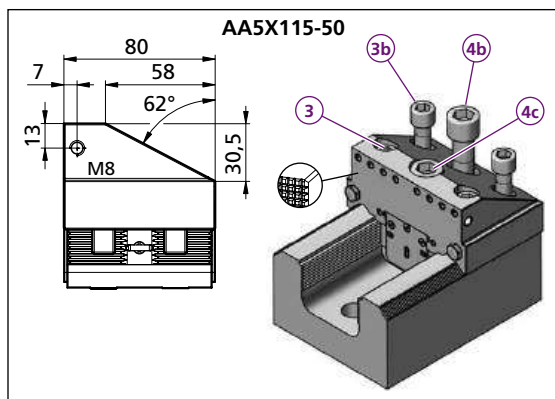
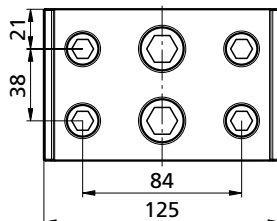
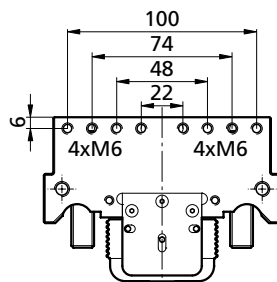
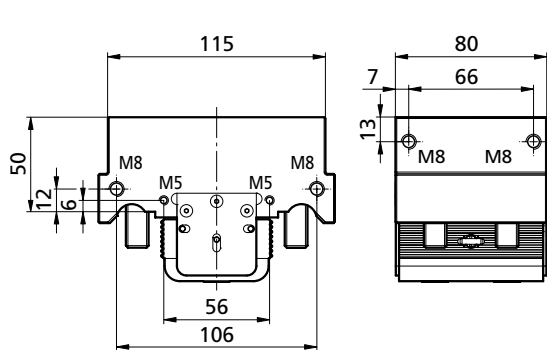


HM = Hartmetallbeschichtet / Carbide coated

AS2X125L50-105 AS25X125L50-105

5axes
aptoCLAMP





AAND115-50

- 1x TF140690
- 4x M12X50ISO4762
- 2x M16X70ISO4762
- 4x M5X10ISO7380-1
- 6x M3X6DIN7991
- 2x ACBL4243
- 6x Ø 3x8 VSM 12785
- 2x ACSP7620
- 2x Ø 3h 8x12 ISO 2338
- 2x FED0618
- 1x ACSK7632M16
- 1x FED Ø 5,5x39

- 4x Ø 6-Niro SM1275-3
- 4x M8X16ISO4017

kg

~4,7

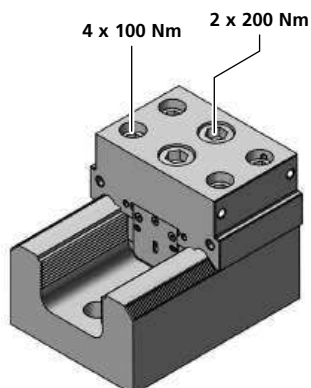
AA5X115-50

- 1x TF140691
- 2x M12X50ISO4762
- 2x M12X30ISO4762
- 1x M16X65ISO4762
- 1x M16X45ISO4762
- 2x M5X10ISO7380-1

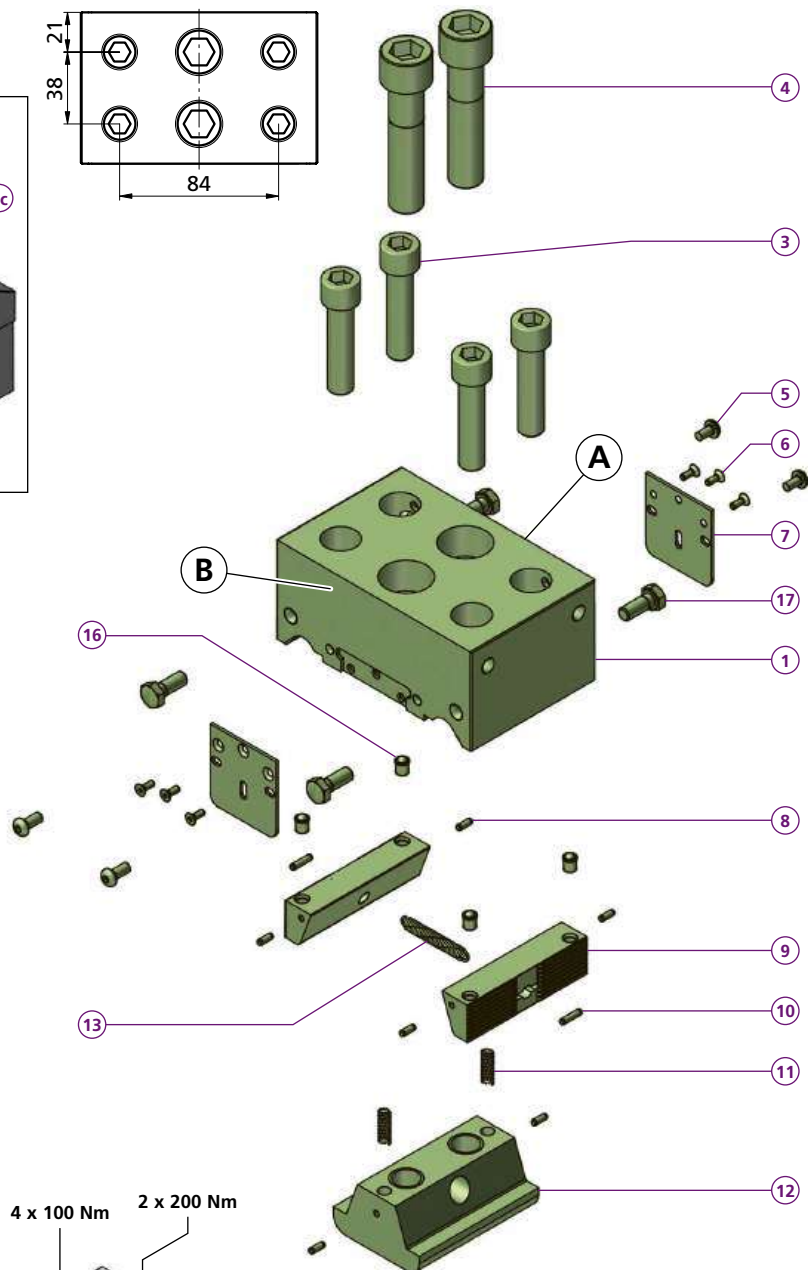
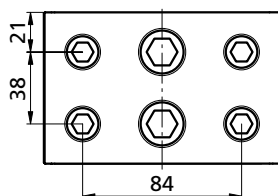
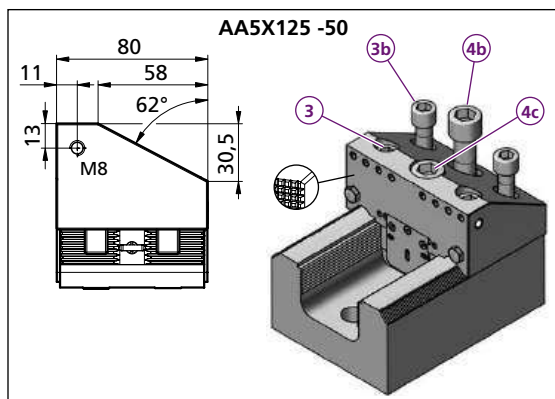
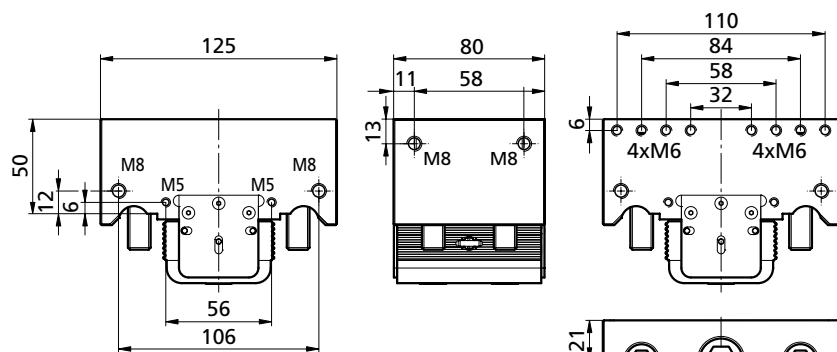
- 2x M8X16ISO4017

kg

~4,6



Bestellbeispiel / Ordering example: **AAND115-50**



AAND125-50

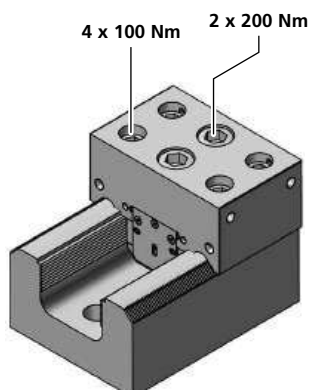
- 1x TF140692
- 4x M12X50ISO4762
- 2x M16X70ISO4762
- 4x M5X10ISO7380-1
- 6x M3X6DIN7991
- 2x ACBL4243
- 6x Ø 3x8 VSM 12785
- 2x ACS P7620
- 2x Ø 3h 8x12 ISO 2338
- 2x FED0618
- 1x ACSK7632M16
- 1x FED Ø 5,5x39

- 4x Ø 6-Niro SM1275-3
 - 4x M8X16ISO4017
- kg ~4,8

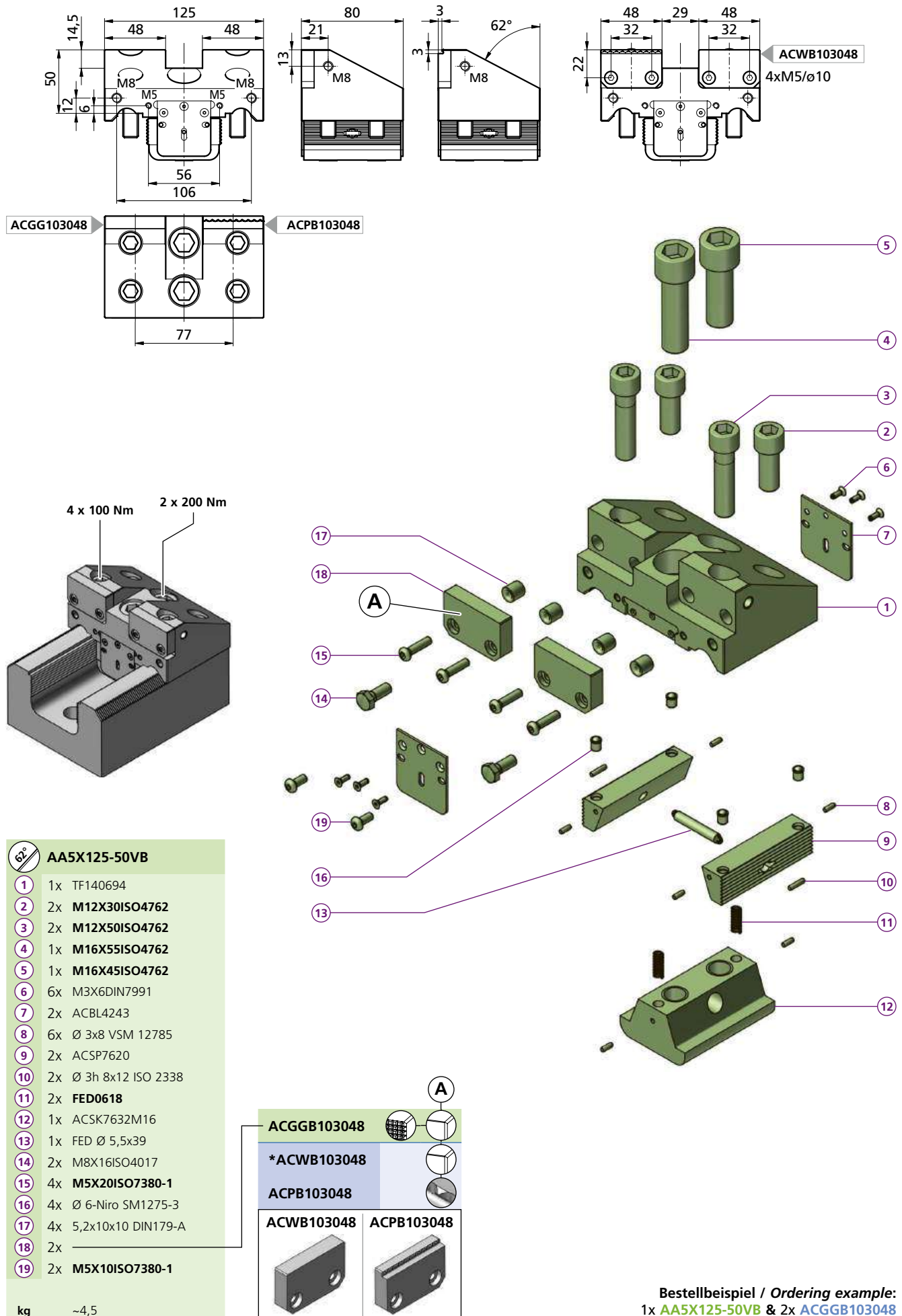
AA5X125-50

- 1x TF140693
- 2x M12X50ISO4762
- 2x M12X30ISO4762
- 1x M16X65ISO4762
- 1x M16X45ISO4762
- 2x M5X10ISO7380-1

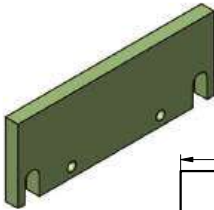
- 2x M8X16ISO4017
- kg ~4,6



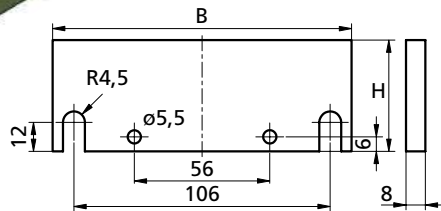




Parallelunterlage
Steel parallels

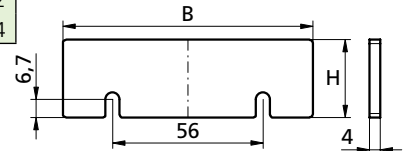


124mm	B	H	kg
ACU21124	124	21	~0,138
ACU36124	124	36	~0,250
ACU41124	124	41	~0,294
ACU46124	124	46	~0,328

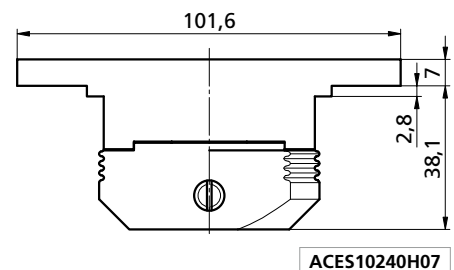
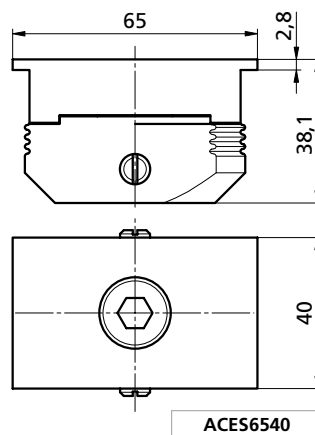
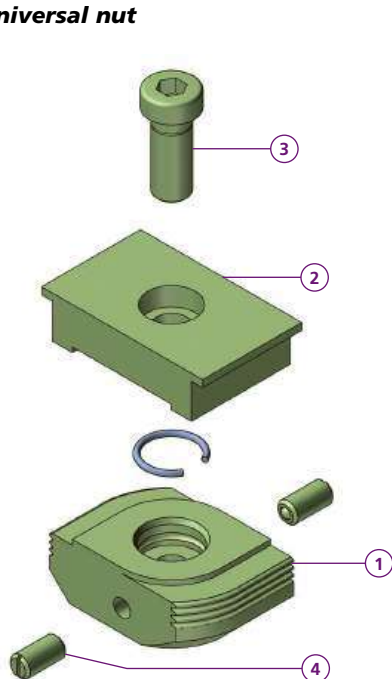


94mm	B	H	kg
PCU14093	93	14	~0,04
PCU20093	93	20	~0,06
PCU24093	93	24	~0,07
PCU29093	93	29	~0,09
PCU31093	93	31	~0,09
PCU34093	93	34	~0,10
PCU39093	93	39	~0,11
PCU44093	93	44	~0,12
PCU46093	93	46	~0,14

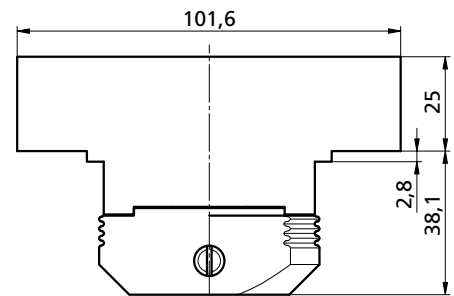
125mm	B	H	kg
PCU20124	124	20	~0,08
PCU24124	124	24	~0,09
PCU29124	124	29	~0,11
PCU31124	124	31	~0,12
PCU34124	124	34	~0,13
PCU39124	124	39	~0,15
PCU44124	124	44	~0,17



Universalnutenstein
Universal nut



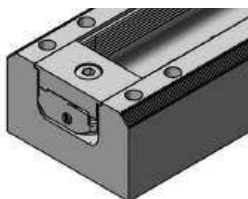
ACES10240H07



ACES10040H25W

ACES6540

- ① 1x ACZS6540
 - ② 1x ACES6540
 - ③ 1x M12X30DIN7984
 - ④ 2x SM1275-1KSM8
- kg ~ 0,67



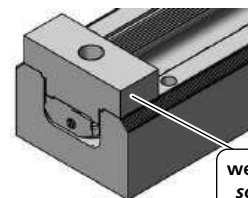
ACES10240H07

- ① 1x ACZS6540
 - ② 1x ACES10240H07
 - ③ 1x M12X30DIN7984
 - ④ 2x SM1275-1KSM8
- kg ~ 0,88

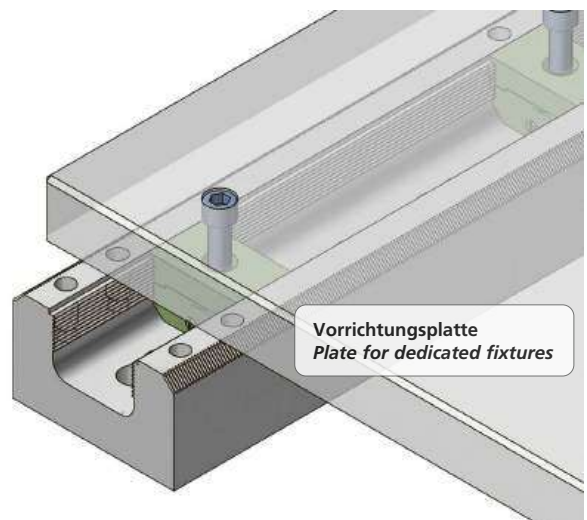


ACES10040H25W

- ① 1x ACZS6540
 - ② 1x ACES10040H25W
 - ③ 1x M12X30DIN7984
 - ④ 2x SM1275-1KSM8
- kg ~ 1,42



weich
soft 1.2312



Vorrichtungsplatte
Plate for dedicated fixtures

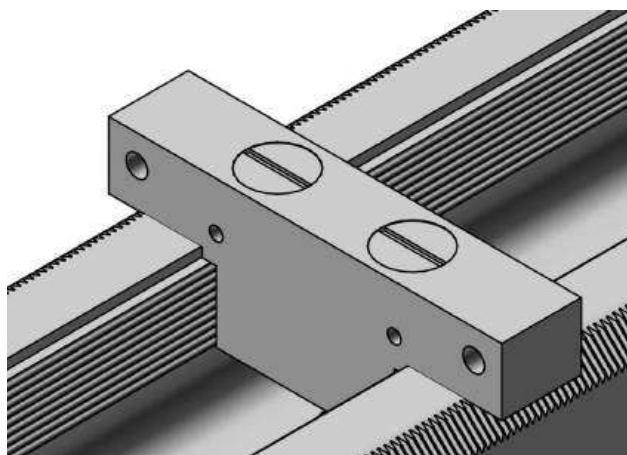
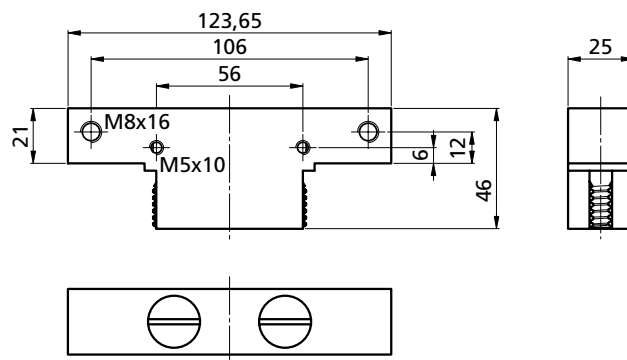
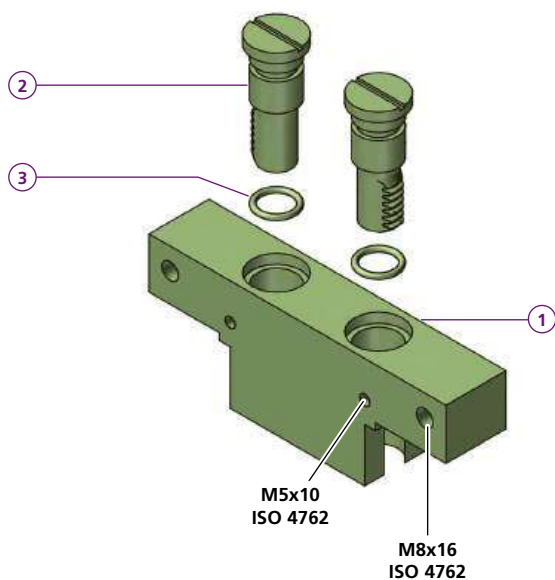
Bestellbeispiel / Ordering example: **ACES6540**

Separat bestellen / Order separately

Universal - Unterlagenhalter

Universal holder for steel parallels

aptoCLAMP

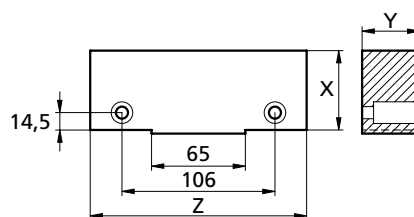
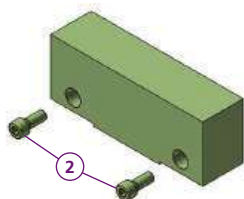


Bestellbeispiel / Ordering example: **ACUH21-124**

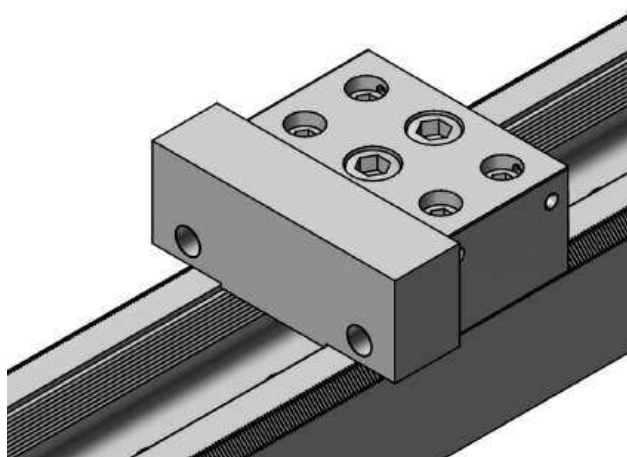
ACUH21-124

- ① 1x TW090086-02
 - ② 2x ACBS1646
 - ③ 2x OR Ø 12X2
- kg ~ 0,74

weiche Backe soft jaw



		X	Y	Z	kg
AC1505520W	②	55	20	150	~ 1,28
AC1505540W	M8X20ISO4762	55	40	150	~ 2,55



Bestellbeispiel / Ordering example: **AC1505520W**

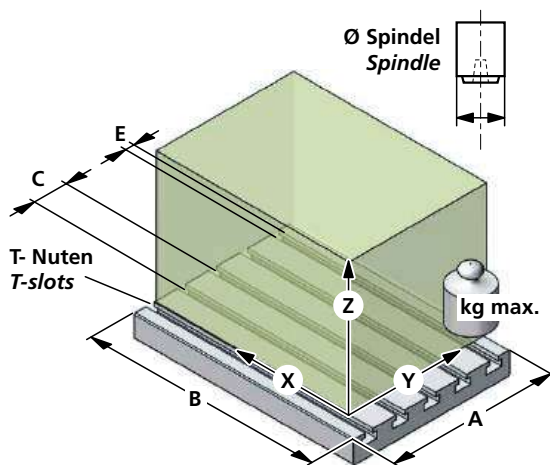
Maschinenplan für Angebot

Machines plan for offer

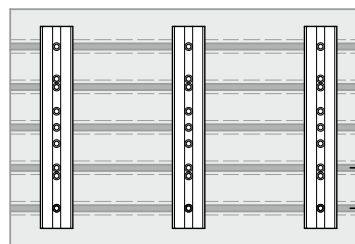
VERTICAL

Kunde Customer			
Maschine Machine		Werkstoff, Halbzeug, Rohteil-Nr., Modell- oder Gesenk-Nr. Raw material, blank or casting-Nr.	
X	Verfahrweg Traverse		mm
Y	Verfahrweg Traverse		mm
Z	Verfahrweg Traverse		mm
Z min.	kleinster Abstand von der Tischoberfläche zur Spindelnase smallest distance from table surface to spindle gauge line		mm
Z max.	grösster Abstand von der Tischoberfläche zur Spindelnase greatest distance from table surface to spindle gauge line		mm
Ø Spindel Spindle	Spindeldurchmesser Spindle diameter		mm
kg max.	Maximale Tischbelastung Maximum loading capacity		kg
A x B	Tischgrösse Size of the table		mm
E	T-Nuten Grösse T-slots size		mm
C	T-Nuten Abstand T-slots distance		mm
Rasterplatte Grid plate	H Raster Abstand Grid distance	mm	G Gewinde & Passungsdurchmesser Ø Thread & Precision Bohre
Anzahl Werkstücke pro Los Number of workpieces per lot			Stück Pieces

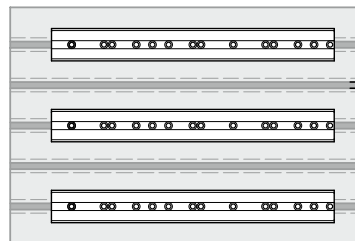
Maximal mögliche Bearbeitungsgrösse



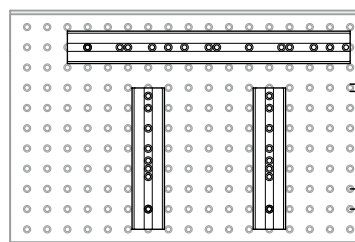
Montage der PC-Basisschiene auf dem Maschinentisch Assembly of the PC base-rail on the machine table



- 1**
Positionierung der
Basisschiene quer zur Nute
Positioning of the base-rail
crosswise to the nut



- 2**
Positionierung der
Basisschiene längs zur Nute
Positioning of the base-rail
lengthwise to the nut

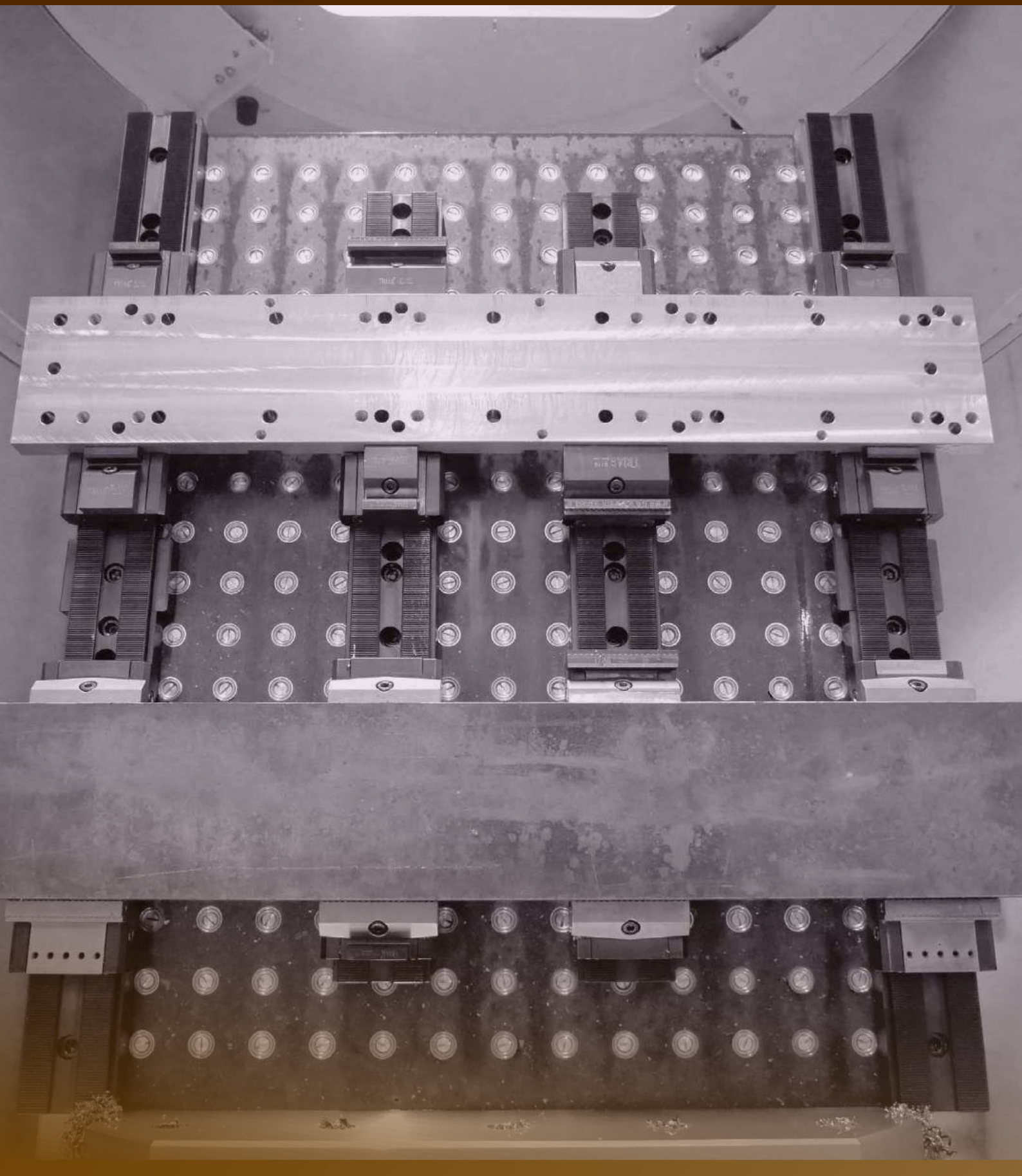


- 3**
Positionierung der
Basisschiene auf einer
Rasterplatte
Positioning of the base-rail
on a grid plate

Bitte Werkstückzeichnung beilegen und Bearbeitungsfolge markieren
Enclose drawing of workpiece and mark processing sequence, please



tripoxyMINERAL





Einleitung | *Introduction* 238 - 243

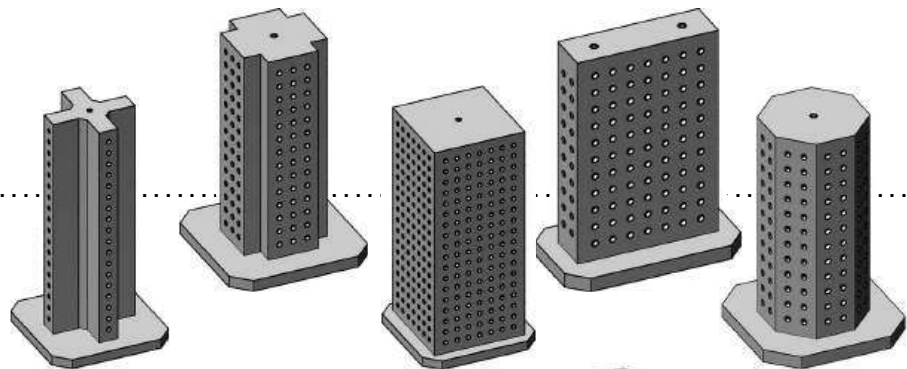


Bedienungsanleitung | *Operating manual* 244

Reparaturanleitung für Mineralguss | *How to repair epoxy mineral casting* 245

Anwendungsbeispiele | *Examples of application* 247 - 248

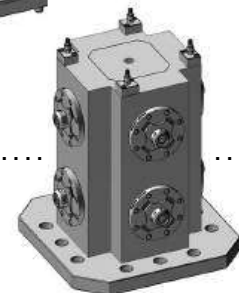
Mineralguss | *Epoxy mineral* 251



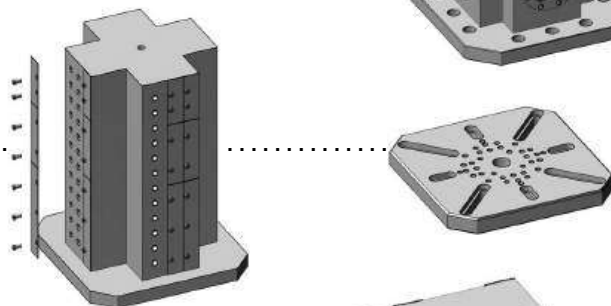
Mineralgusserhöhung für 5-Achsenmaschinen
Epoxy mineral riser for 5-axis machines 270



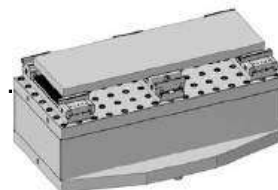
Stahl Mineralguss | *Steel epoxy mineral tombstones* 271 - 272



Zubehör | *Accessories* 273 - 274



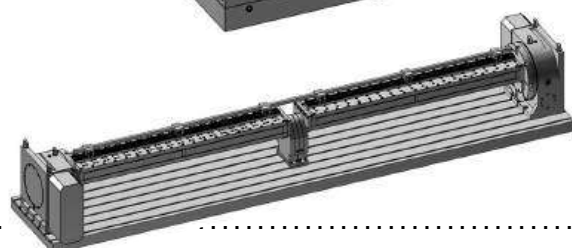
Stahl Mineralgusserhöhungen / *Steel-epoxy riser* 275



Stahl Mineralgusserhöhungen mit integriertem Vakuum Anschluss
Steel-epoxy riser with integrated vacuum 276

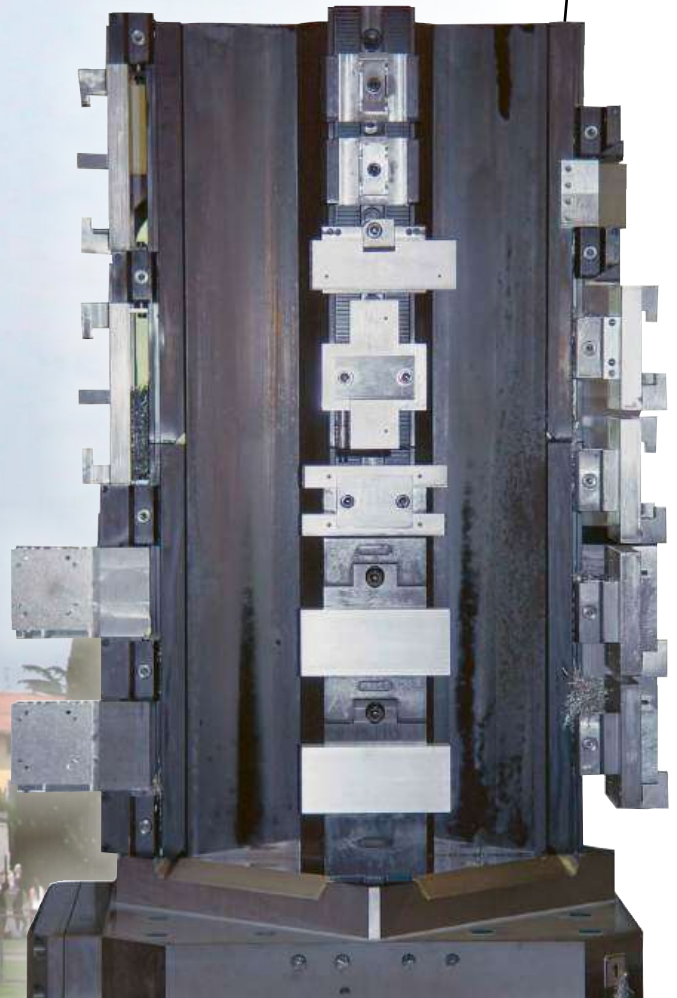


Balken und Würfel aus Stahl-Mineralguss
Trunion and cubes made from steel epoxy 277



Es ist ein Versprechen!
Unsere Mineralgusstürme stehen gerade!

*It's a promise!
Our epoxy tomb stones stand upright!*



Maschinenschonend und leicht, in fast allen Formen herstellbar

Bei den immer schneller werdenden Horizontalbearbeitungszentren ist Gewichtsreduktion der Zuladung ein wichtiger Faktor. Unsere Spanntürme aus Mineralguss haben ein kleineres spezifisches Gewicht als Alu.

Zudem werden Vibrationen derart reduziert, dass auch bei einer Bearbeitung im oberen Turmbereich präzise bearbeitet werden kann. In gewissen Fällen, z.B. bei Werkstückspannungen (ohne Basisschienen) direkt auf den Turm, kann auch ein stahlummantelter Mineralgussturm eine Ergänzung sein.

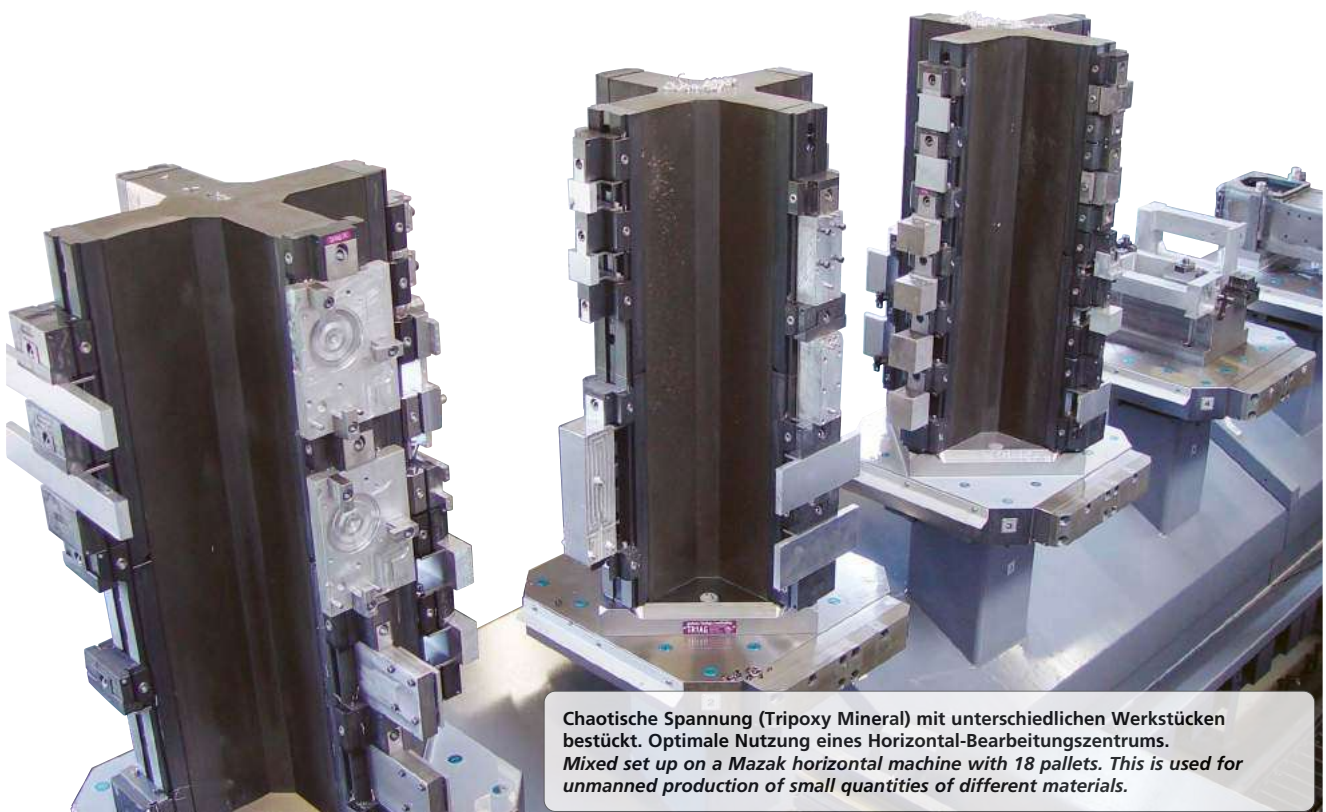
Reduces machine wear due to low specific weight - can be produced in all sorts of shapes

As the rapid traverse on modern horizontal machining centres is constantly increasing, the weight of the payload becomes obviously an important point. Our tombstones made of epoxy mineral casting are lighter in their specific weight than aluminium.

In addition, vibrations are greatly reduced in a way that even in the upper end of the tombstone high accuracy is guaranteed. In certain cases, as for instance when the fixture is designed without the base rail, that means directly mounted on the cube, the tombstone can be improved by a steel jacket.

- Leicht und stabil
- Vibrationsdämpfung 10 x besser als Grauguss und 100 x besser als Alu!
- Spezifisches Gewicht leichter als Aluminium
- Seitenflächen geschliffen mit Bohrungen (M12 / 12F7)
- Grundplatten nach Maschinenspezifikation
- Andere Formen auf Anfrage

- *Lightweight and rigid*
- *Damping effect 10 x better than cast iron 100 x better than alu!*
- *Specific weight lighter than aluminum*
- *Faces ground, hardened bushings (M12/12F7)*
- *Base plate made to machine specifications*
- *Other dimensions on request*



Chaotische Spannung (Tripoxy Mineral) mit unterschiedlichen Werkstücken bestückt. Optimale Nutzung eines Horizontal-Bearbeitungszentrums.
Mixed set up on a Mazak horizontal machine with 18 pallets. This is used for unmanned production of small quantities of different materials.

Mineralguss (auch Polymerbeton genannt) ist ein Kunststein, bestehend aus Quarzkies, Quarzsand und Gesteinsmehl. Als Binder dient ein hochwertiges Epoxidharz. Das gemischte Material wird in Giessformen gefüllt.

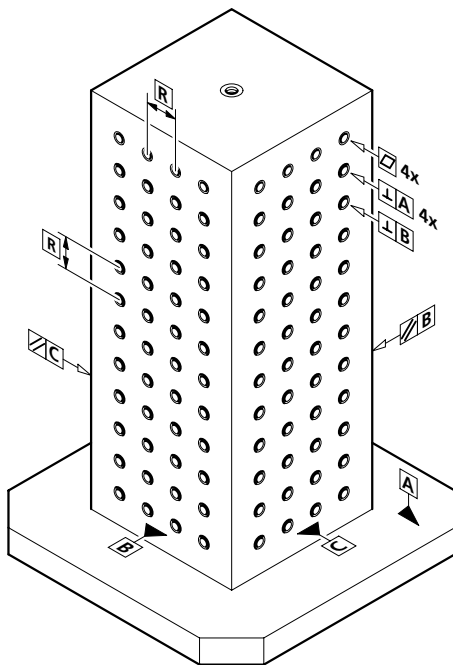
Während dem Giessprozess wird die Form, mittels Vibrations-tisch ständig vibriert, was zur Verdichtung und Entlüftung der Giessmasse führt. Das spezifische Gewicht ist mit 2,4 kg / dm³ geringer als das von Aluminium und die Vibrationsdämpfung ist 10 mal besser als bei Grauguss, 100 mal besser als Aluminium. Neben den guten Dämpfungseigenschaften ist auch die Temperaturstabilität (geringe Wärmeleitfähigkeit und hohe Wärmekapazität) zu erwähnen.

Das Material ist ausserdem chemisch beständig gegen Öle, Laugen, Säuren und die üblichen Kühlschmierstoffe. Im ausgegossenen Zustand sind die Türme «Umweltneutral».

Mineral casting (also called polymer concrete) is a stone composed of quartz gravel, silica sand and crushed rock. The binder is a high quality epoxy resin. The mixed material is filled into molds.

During the casting process, the form, constantly vibrating. Is resulting in the compaction and extraction of the casting mass. The specific weight is 2,4 kg / dm³ is lower than that of aluminum, and the vibration attenuation is 10 times better than that of cast iron 100 times better than alu. Besides the good damping properties, the temperature stability is to be mentioned (low thermal conductivity and high heat capacity).

The material is also chemically resistant to oils, alkalis, acids and the usual cooling lubricants.



Eigenschaften Caractéristiques	Mineralguss Epoxy mineral	GG20	hochfestes Alu high density Alu
Dichte / Density [kg/dm ³]	ca. 2,4	ca. 7,1-7,3	ca. 2,76
Logarithmisches Dekrement grösser als (Vibrationsdämpfung) Logarithmic Decrement (damping)	0,035	0,004	0,0004
Längenausdehnungs-koeffizient Coefficient of linear expansion [1/K]	ca. 12x10 ⁻⁶	ca. 10x10 ⁻⁶	ca. 23x10 ⁻⁶
Zugfestigkeit / Tensile strength [N/mm ²]	15 - 20	200 - 400	470 - 520
Wärmeleitfähigkeit Thermal conductivity [W/mK]	ca. 2	ca. 50	ca. 140

Lagetoleranz der Rasterbohrungen Positioning tolerance of the holes	R	0 - 500 mm ± 0,01 501 - 1000 mm ± 0,02
Ebenheit Flatness		0,01 mm / 300 mm
Parallelität Parallelism		0,01 mm / 300 mm
Winkligkeit Deviation of angle		0,01 mm / 200 mm

Mineralguss wird unter anderem für folgende Anwendungen eingesetzt: Cast mineral is among other things the following Applications used:

- ➔ Maschinenbetten
Machine beds
- ➔ Maschinenständer und -portale
Machine column and portals
- ➔ Als Alternative zu Grauguss (Kosten, Umweltfreundlichkeit)
As an alternative to cast iron (cost, environmental friendliness)
- ➔ Als Alternative zu Schweisskonstruktionen
As an alternative to welded constructions
- ➔ Als Alternative zu Natursteinanwendungen (z.B. Messtische, Reinraumtechnologie)
As an alternative to natural stone applications (eg, measuring tables, clean room technology)
- ➔ Generell steifigkeits- und festigkeitsdimensionierte Strukturbauteile
General stiffness and strength-scale structural components
- ➔ Integrierte Funktionalität möglich (Schläuche, Ventile, Elektrik, Lastanker etc.), auch nachträgliches Eingiessen möglich
Integrated functionality possible (hoses, valves, electrical, anchor load, etc.), and subsequent pouring possible
- ➔ Füllung von Mineralguss in Blechmantelkonstruktionen (z.B. unsere Stahl-Mineralguss-Basissschienen)
Filling of mineral cast in metal shell constructions (eg, our steel rails with epoxy mineral cast base)

tripoxyMINERAL

Die Gewichtsreduktion der Zuladung ist bei den immer schneller werdenden Horizontalbearbeitungszentren ein wichtiger Faktor. Die Spanntürme aus Mineralguss haben ein kleineres spezifisches Gewicht als Aluminium. Diese verfügen über eine so hohe Vibrationsdämpfung, dass dadurch im oberen Bereich der Türme sehr präzise gearbeitet werden kann und dabei exzellente Oberflächengüten erreicht werden.

Seit Jahren bietet die Triag International AG aus eigener Produktion mit den Tripoxy Mineral-Spanntürmen eine sehr gute Alternative zu Spanntürmen aus anderen Materialien (z.B. Grauguss- oder Aluminium) an.

The weight reduction of the load is an important factor in the increasingly rapid horizontal machining centers. The tombstones of mineral casting have a lower specific weight than aluminum. Another big advantage is the vibration clamping which helps to achieve excellent surfaces on your workpieces, even on top of your tombstone. Beside that there are another two good reasons for epoxy mineral tombstones. One is the materials is not getting rusty and the slow thermal expansion.

For years, the Triag International AG offers its own production with the Tripoxy mineral tombstones, a very good alternative to tombstones made of other materials (such as cast iron or aluminum) to.

**Mineralgusstürme samt
Spannsystem aus einer Hand!**

**Epoxy mineral tombstones including
clamping system from one source!**



Mineralgussturm kombiniert bestückt mit Power Clamp und Magneten.
 Epoxy cube equipped with magnet and Power Clamp



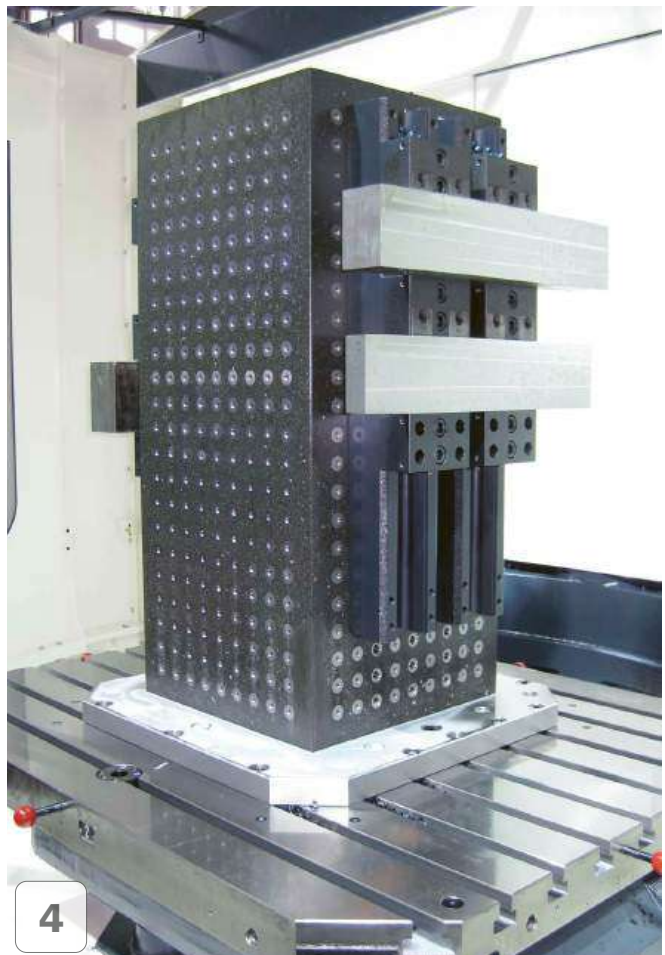
Grosse Platte auf einem rechteckigen
Mineralgussturm.
 Large plates on epoxy tombstone.



Chaotische Fertigung auf einem
Mineralgussturm in Kreuzform.
 Mixed set up on cross epoxy tombstone.



Spezielle Vorrichtung mit Micro Clamp
Modulen auf einem Mineralgussturm.
 Dedicated fixture on epoxy tombstone



Stahl-Mineralguss seit 2004 - das ideale Material für Spanntürme

Die Firma Triag International AG hat seit 2004 diese stahlummantelten Türme mit sehr guten Ergebnissen bei Kunden im Einsatz. In den meisten Fällen können optimale Lösungen durch Standardangebote kostengünstig und modular eingerichtet werden.

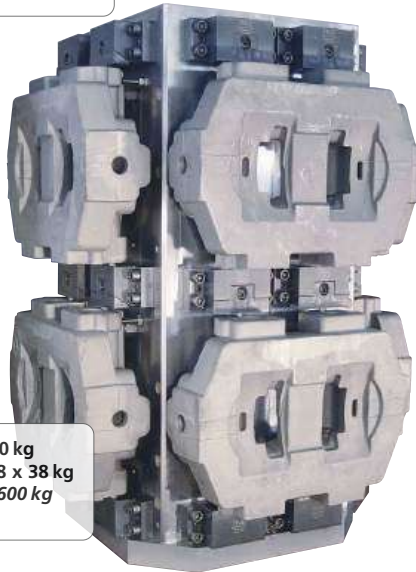
Steel-epoxy combinations since 2004 - the ideal material for tombstones and ricer cubes

Triag International AG customers are employing successfully tombstones with steel jackets since 2004. In most cases optimal solutions can be found with standard Triag clamping devices.

Stahl-Mineralguss für die perfekte Vibrationsdämpfung
Steel epoxy tombstone for perfect vibration dampening

Max. Palettenzuladung auf Mazak H BZ
Max pallet load on this Mazak application
= 600kg H = 800

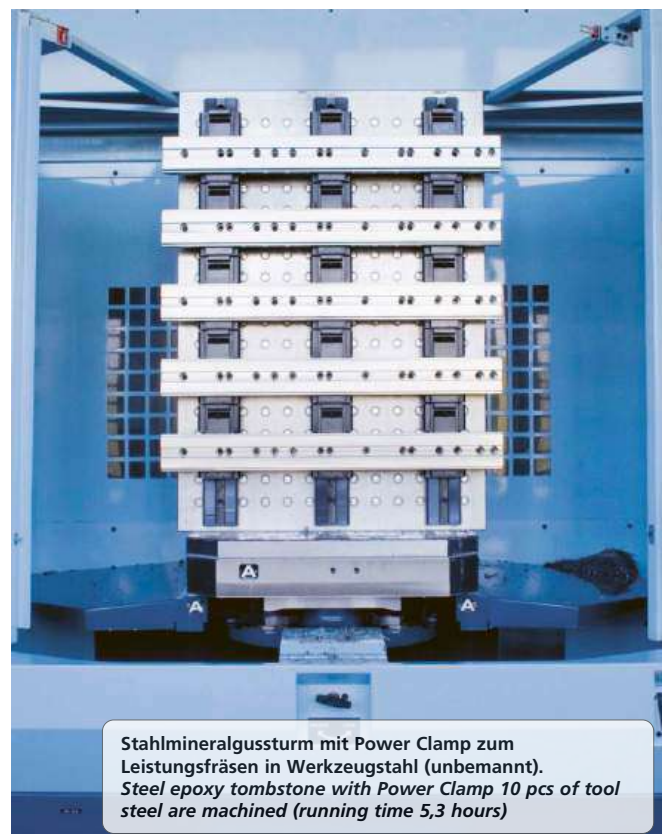
Komplettes Gewicht 600 kg inkl. Werkstücke WS = 8 x 38 kg
Complete load weighs 600 kg incl-parts



Stahl-Mineralguss Dreieck-Turm
Steel epoxy triangle cube



Stahl-Mineralguss Pyramide
Steel epoxy pyramid stomp

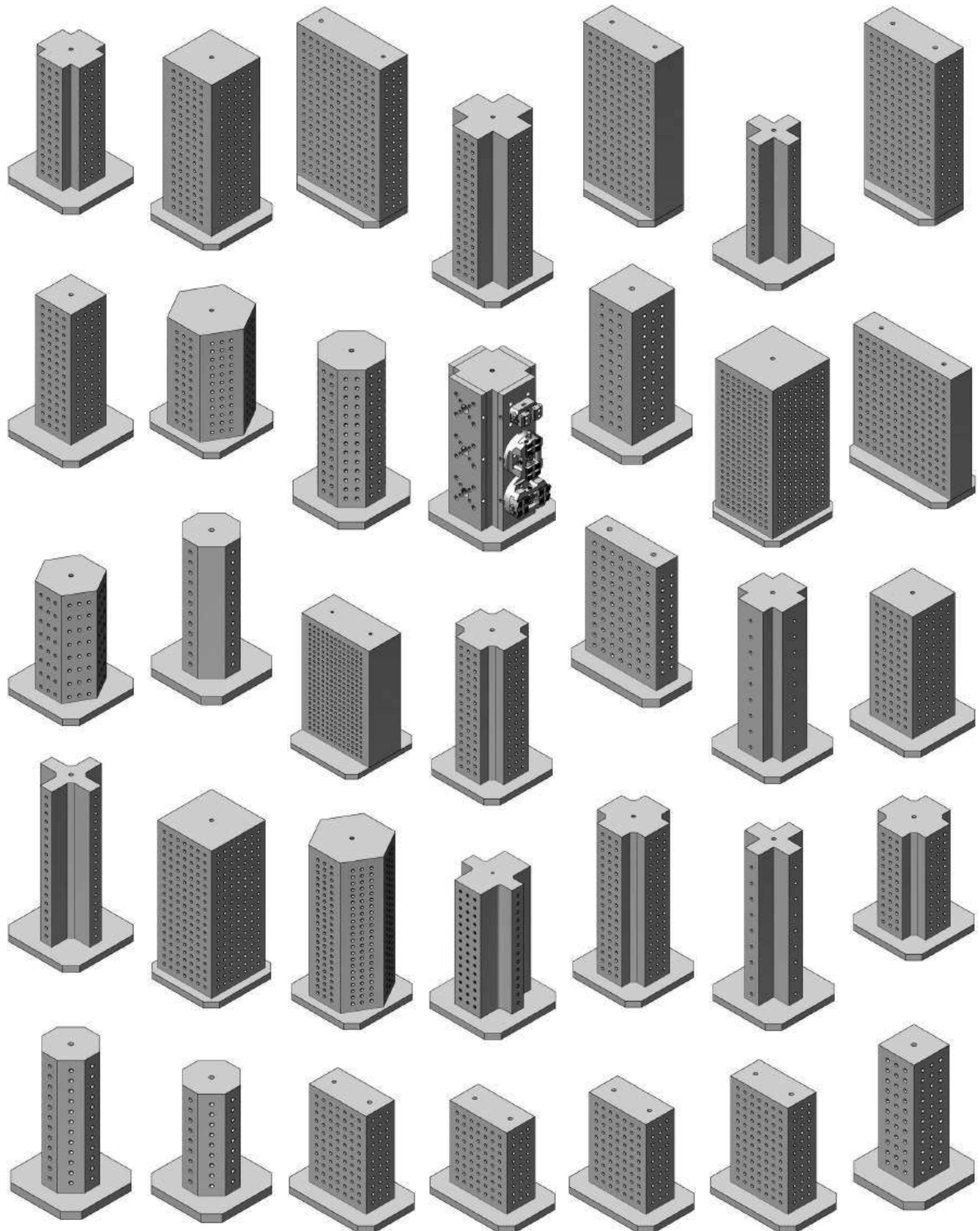


Es gibt eine Vielzahl von Standardformen

There are a variety of standard forms

tripoxyMINERAL

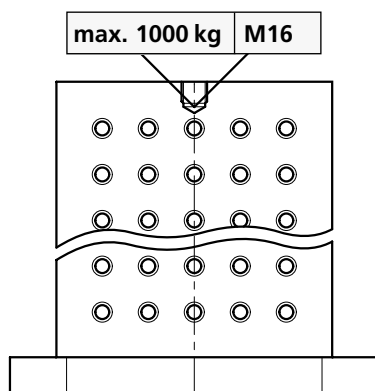
Die Mineralgusstürme können in fast allen Formen hergestellt werden. *The epoxy mineral tombstones can be manufactured in almost any shape.*



Andere Größen, Formen und Raster, welche nicht im Katalog sind, können nach Kundenwunsch produziert werden.
Other sizes, forms and grid which are not in the catalogue can be produced on customer's request.

ACHTUNG / CAUTION

Bevor Mineralgusstürme eingesetzt werden, beachten Sie bitte die folgenden Punkte! *Prior to inserting the tombstones please note the following points!*



Höchstlast des angehängten Stücks / Maximum load of the affixed piece		
Drahtseil Steel rope	Bei fest angezogener Schraube For tightened screw	Bei zwei Schrauben insgesamt For two tightened screws
MRD 12 = 500 kg MRD 16 = 1000 kg	M12 = 340 kg M16 = 700 kg (DIN 580)	M12 = 240 kg M16 = 500 kg (DIN 580)

Bitte beachten Sie, dass die meisten Ringschrauben eine maximale Last haben von: **M12: 340 kg / M16: 700 kg** auch muss die Ringschraube bis zum Anschlag eingedreht sein!

*Please note that most of the lifting screws have a maximum load of: **M12: 340 kg / M16: 700 kg** It is also important that the lifting screw is driven into the socket!*

Oberflächenabnutzung

Durch schnelle, auf die Turmoberfläche schlagende Späne, sowie durch Hochdruckkühlung, die direkt auf den Turm spritzt, kann die Oberfläche des Mineralgussturmes beschädigt werden!

Surface wear

The surface of the tombstone can be seriously damaged by chips hitting the tombstone quickly as well as by high pressure cooling water splashing directly onto the tombstone!

Massnahmen:

Dort wo lange Späne oder auch kurze abrasive Späne auf den Turm schlagen, Abdeckbleche benutzen!
(Abdeckbleche siehe Seite 244)

Measure:

*Use cover sheets wherever long or short abrasive chips hit the tombstone!
(Cover sheets page 244)*

Achtung Grenzfälle

Folgende Anwendungen können nur bedingt eingesetzt werden, da eine einzelne Schraube auf Zug ohne Gegenlast die eingegossene Buchse belastet!

Attention, limited application

The following applications only have limited use as a single screw without a counterweight puts tremendous tension on the integral socket!

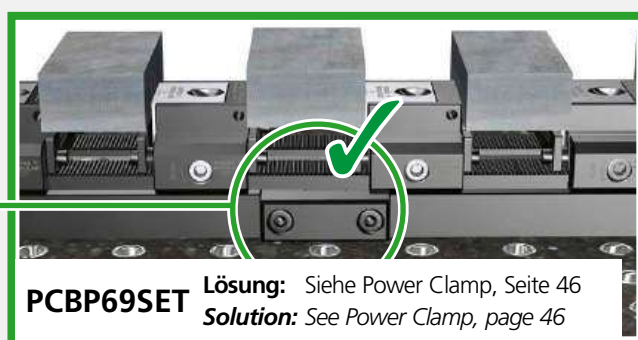
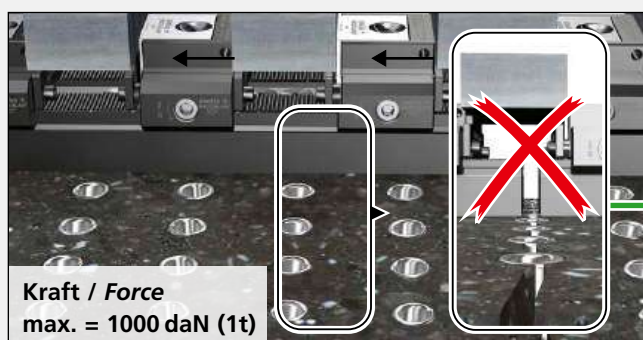
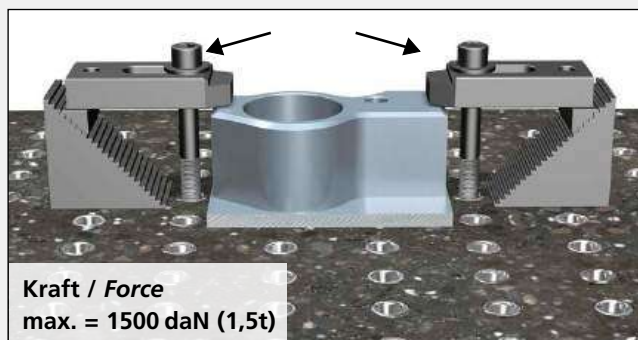
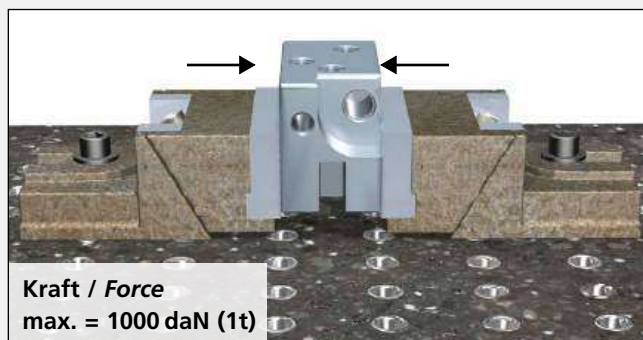


STOP

nicht empfohlen
not recommended

Max. Anzugsmomente beachten.

Note max. starting torques.



PCBP69SET

Lösung: Siehe Power Clamp, Seite 46
Solution: See Power Clamp, page 46

Bruchstelle

Bruchstelle des Mineralgussturmes mit Aceton reinigen, danach mit Metallplatte und Schraubzwinge einschalen. Bei grossen Reparaturen sollte die Platte zusätzlich mit Hartwachs (Bild 6) eingerieben, poliert und nachträglich mit Silikon abgedichtet werden. (Siehe Bilder 1-4)

Point of rupture

Clean the section of fracture with Acetone, then press metal plates with screw clamps onto the point of damage. If the damage is a major one the metal plates must be waxed first (picture No. 6) and sealed with Silicon if necessary (pls. note pictures 1 to 4)

Mineralgussreparaturset (Bild 5)

MREP-SET 0300 ~ 300 gr = ~ 2 dl

Das Reparaturset setzt sich aus dem Harz, Härter und Füller zusammen. Das Mischverhältnis ist: auf 27 gr Härter kommt 100 gr Harz und 150 gr Füller.

Repair kit for epoxy mineral castings (picture 5)

MREP-SET 0300 ~ 300 gr = ~ 2 dl

The repair kit consists of the resin, the hardener, and the filler. The mixture ratio is: 27 gr of hardener, 100 gr of resin and 150 gr of filler.

Das Verhältnis ist genau abgewogen. Wichtig ganze angelieferte Menge gebrauchen.

These components are exactly portioned in the kit and should be used up entirely.

Harz und Härter zusammengiessen und intensiv 2 Min. rühren. Das Durchmischen der Masse ist entscheidend für das optimale Abbinden des Mineralgusses. **Danach Füller dazugeben und das gleiche nochmals 2 Min.** lang untereinander mischen bis eine gipsähnliche Masse entsteht.

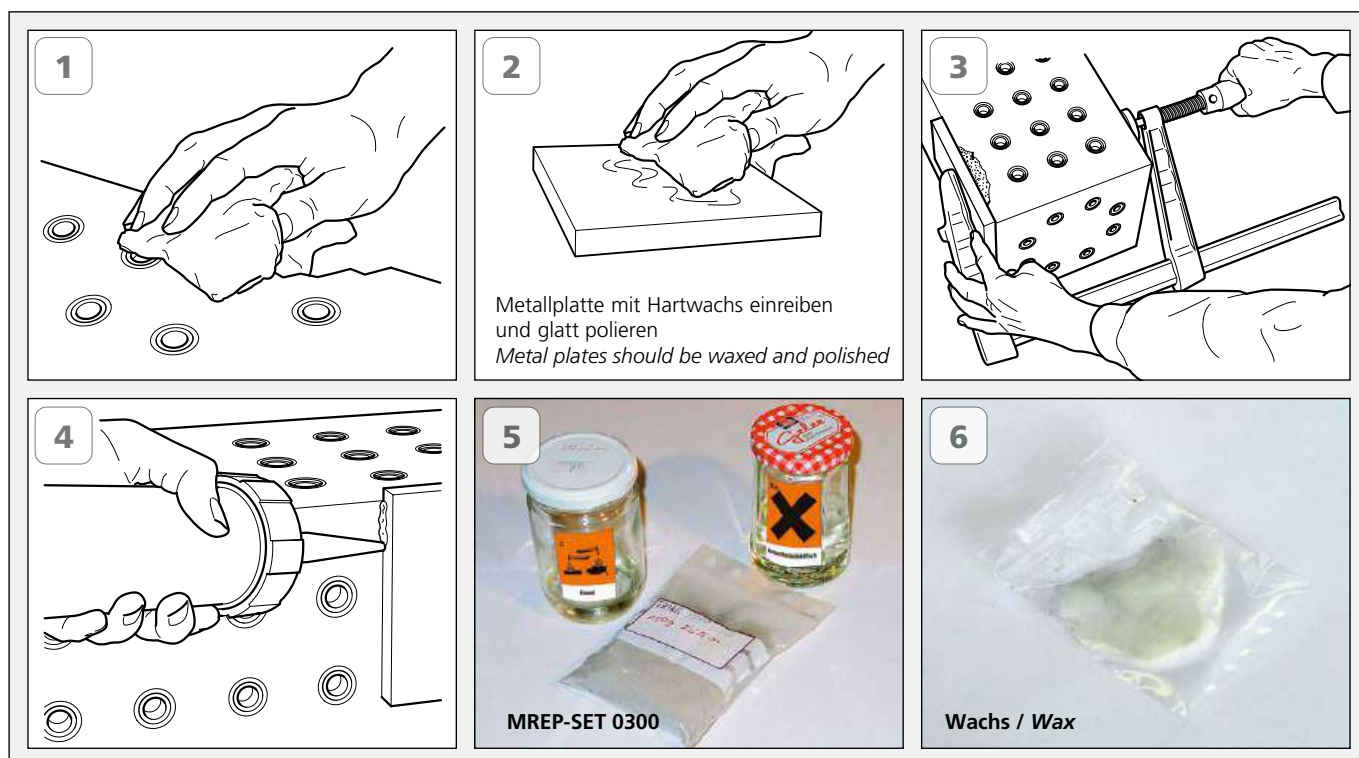
The resin and the hardener should be poured together and mixed for 2 min. This mixing process is essential for a good bonding with the mineral casting. **Then the filler should be added while mixing the mass another 2 min.** It will reach a consistency like plaster.

Die flüssige Masse wird nun in die Bruchstelle eingegossen.

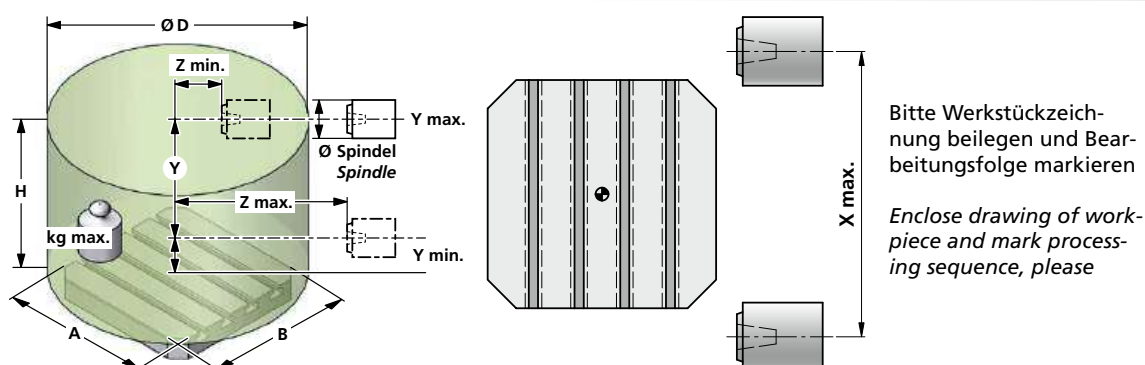
This mortar must be poured into the point of rupture.

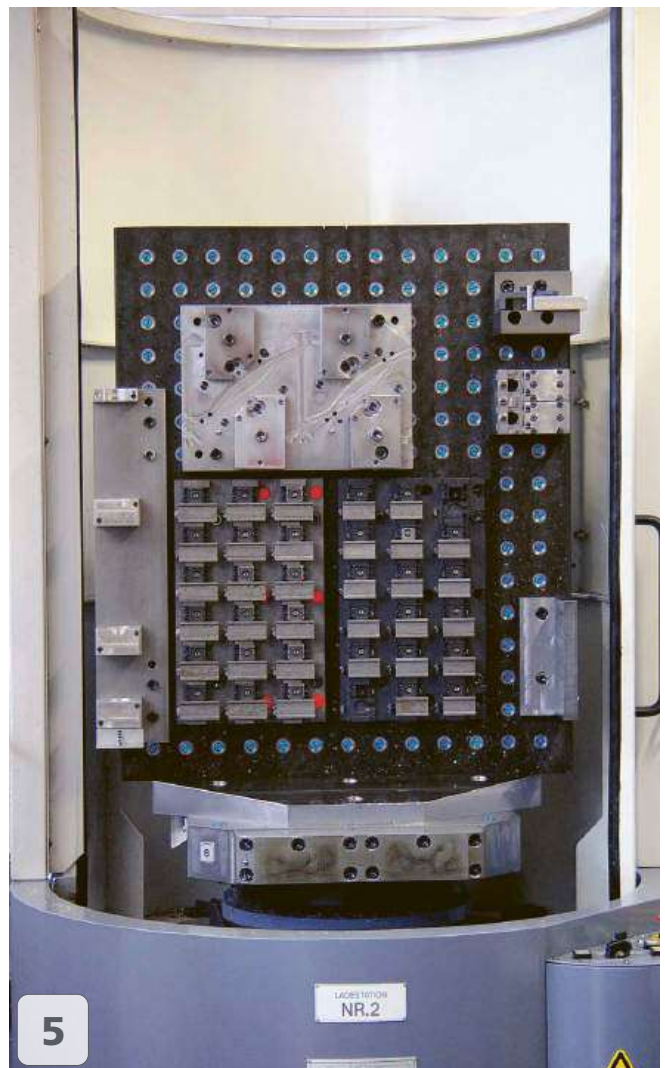
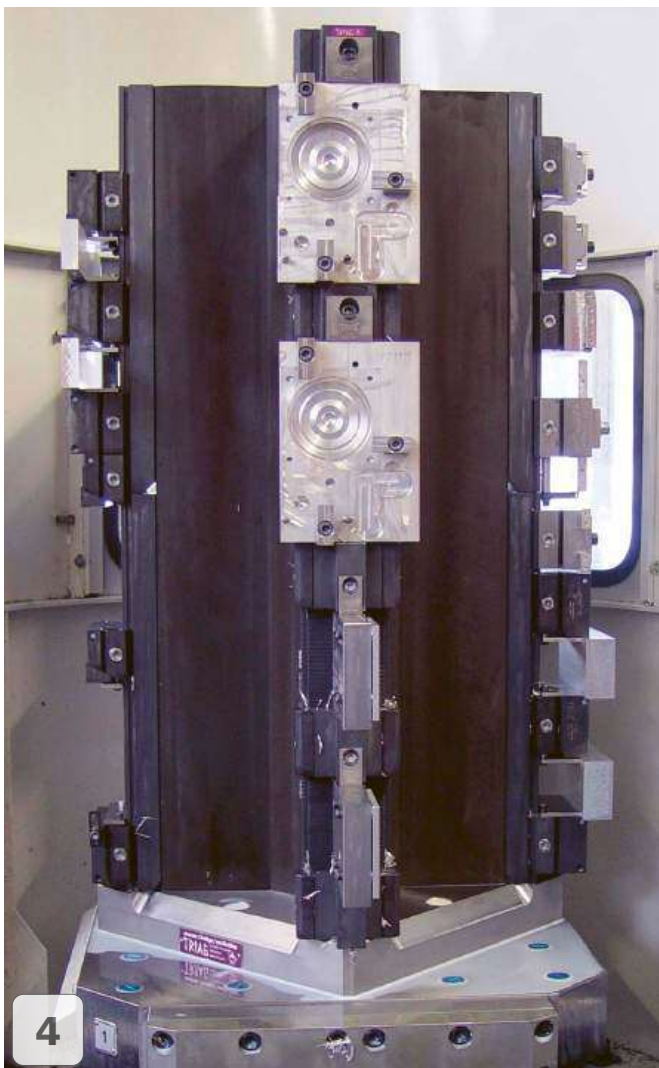
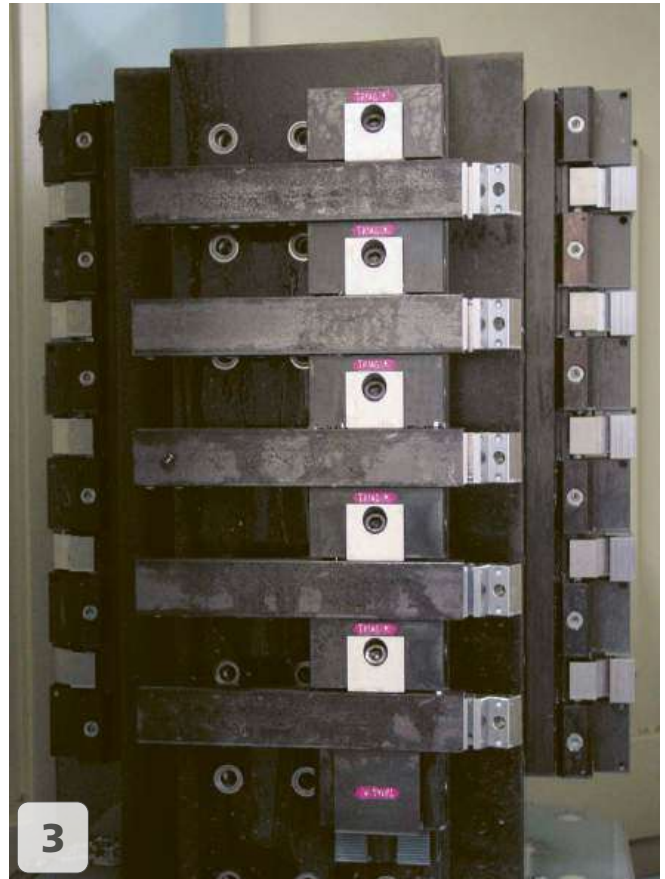
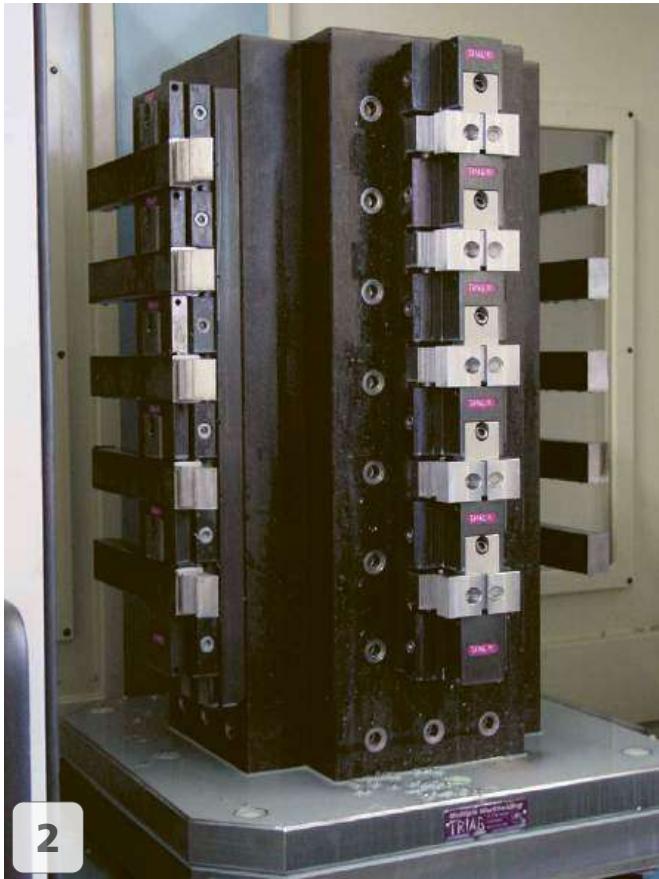
Das Aushärten der Reparaturmasse beträgt 24 Std. Die Unebenheit der frisch eingegossenen Fläche, wird mit einem Schleifstein plangeschliffen.

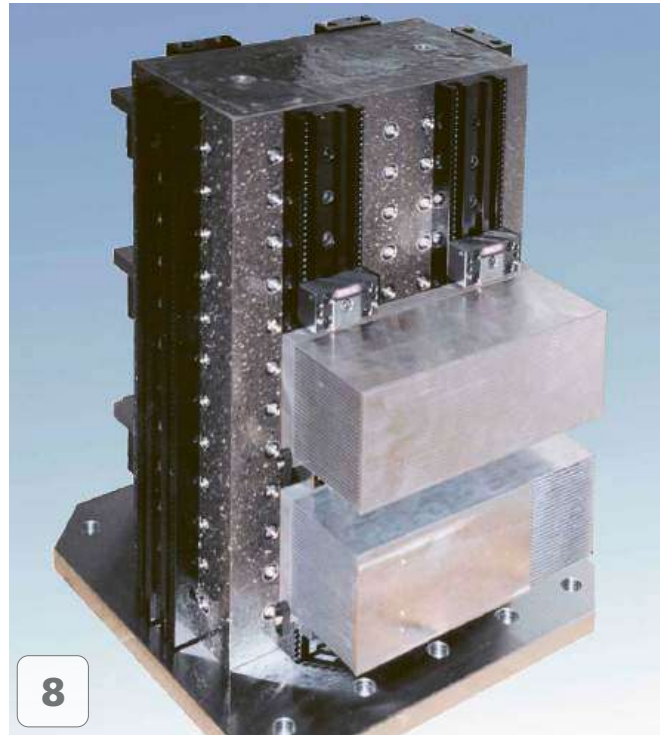
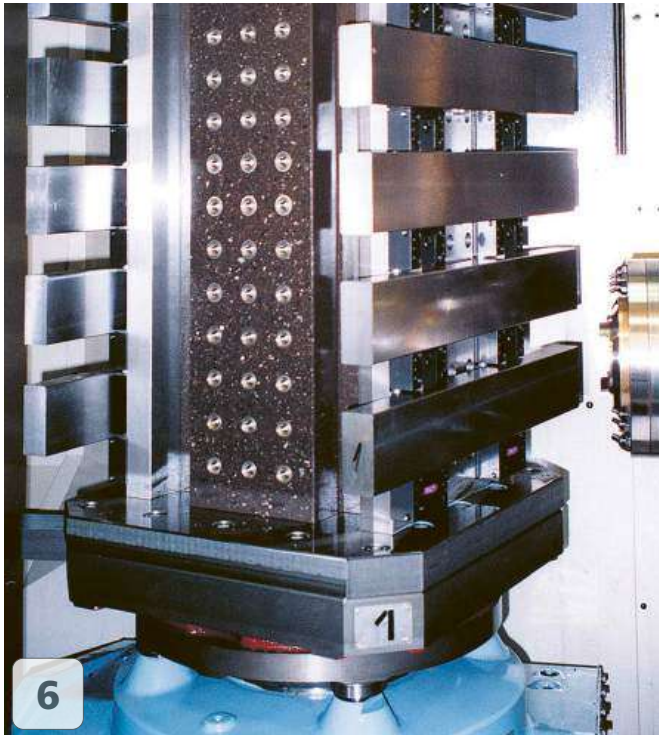
The hardening process takes 24 hours. Protruding material can be levelled with a grindstone.



Kunde <i>Customer</i>			
Maschine <i>Machine</i>		Werkstoff, Halbzeug, Rohteil-Nr., Modell- oder Gesenk-Nr. <i>Raw material, blank or casting-Nr.</i>	
X max.	X Achse Hub <i>X axis stroke</i>		mm
Y min.	Kleinster Abstand von der Palettenoberseite zur Spindelachse <i>Smallest distance from pallet surface to spindle center</i>		mm
Y max.	Grösster Abstand von der Palettenoberseite zur Spindelachse <i>Greatest distance from pallet surface to spindle center</i>		mm
Z min.	Kleinster Abstand von der Palettenachse zur Spindelnase <i>Smallest distance from pallet center to spindle gauge line</i>		mm
Z max.	Grösster Abstand von der Palettenachse zur Spindelnase <i>Greatest distance from pallet center to spindle gauge line</i>		mm
Ø Spindel <i>Spindle</i>	Spindeldurchmesser <i>Spindle diameter</i>		mm
kg max.	Maximale Tischbelastung <i>Maximum loading capacity</i>		kg
ØD max.	Maximaler Störkreis des Werkstücks <i>Maximum workpiece diameter</i>		mm
H max.	Maximale Beladehöhe des Werkstücks <i>Maximum workpiece height</i>		mm
A x B	Palettenabmessung <i>Size of pallet</i>		mm
	Anzahl Werkstücke pro Los <i>Number of workpieces per lot</i>		Stück <i>Pieces</i>







Stahl-Mineralguss Lösungen / Steel epoxy mineral tombstones solutions

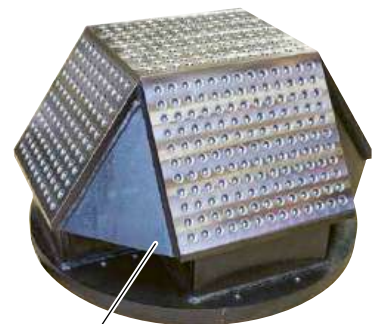
SMK24-24-42 OPP200

~ 120kg



Pyramidenstumpf
Truncated pyramid

~ 474kg



SMK30-17-42 OPP200

~ 142kg



Turm-Material <i>Tombstone material</i>	
M	Mineralguss mit Stahldübel <i>Epoxy mineral with steel anchor</i>
SM	Stahl Mineralguss <i>Steel epoxy mineral tombstones</i>
G	Grauguss <i>Cast iron</i>

Grösste Schlüsselweite <i>Major width</i>	
12	120 mm
20	200 mm
24	240 mm
25	250 mm
30	300 mm
32	320 mm
35	350 mm
40	400 mm
42	420 mm
50	500 mm
60	600 mm
63	630 mm
70	700 mm

Höhe <i>Height</i>	
50	500 mm
55	550 mm
56	567 mm
60	600 mm
62	620 mm
65	650 mm
66	660 mm
70	700 mm
75	750 mm
80	800 mm
85	850 mm
90	900 mm
95	950 mm

M

K

35

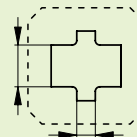
18

95

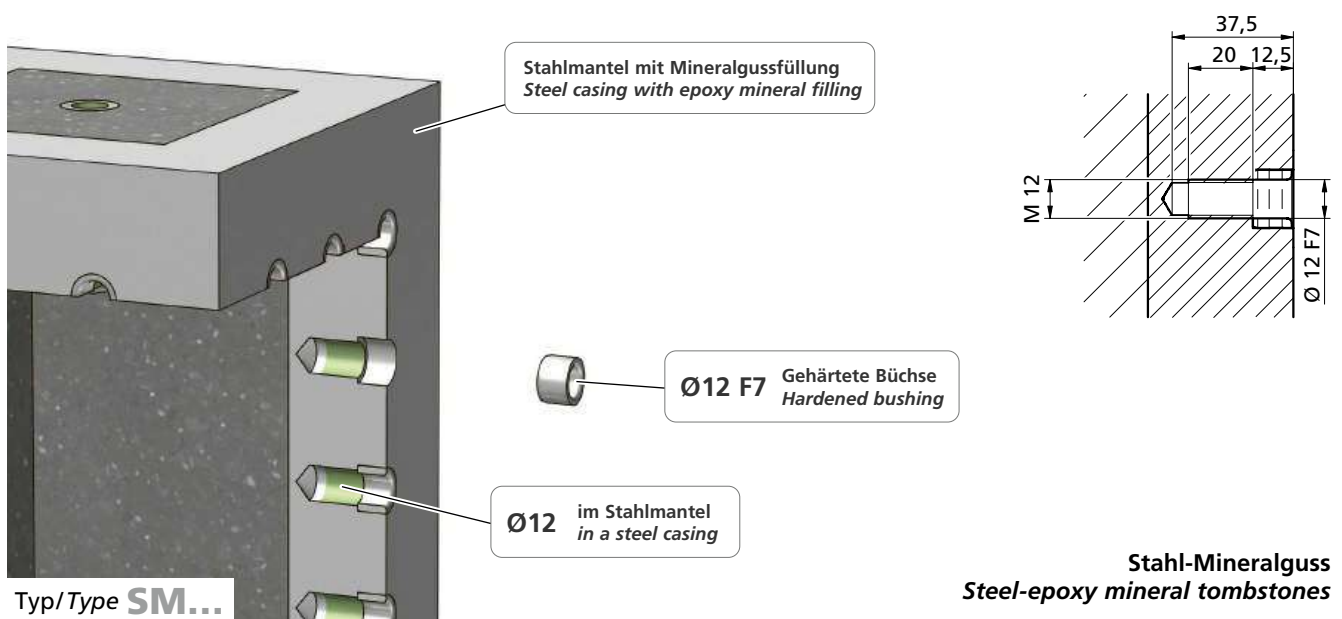
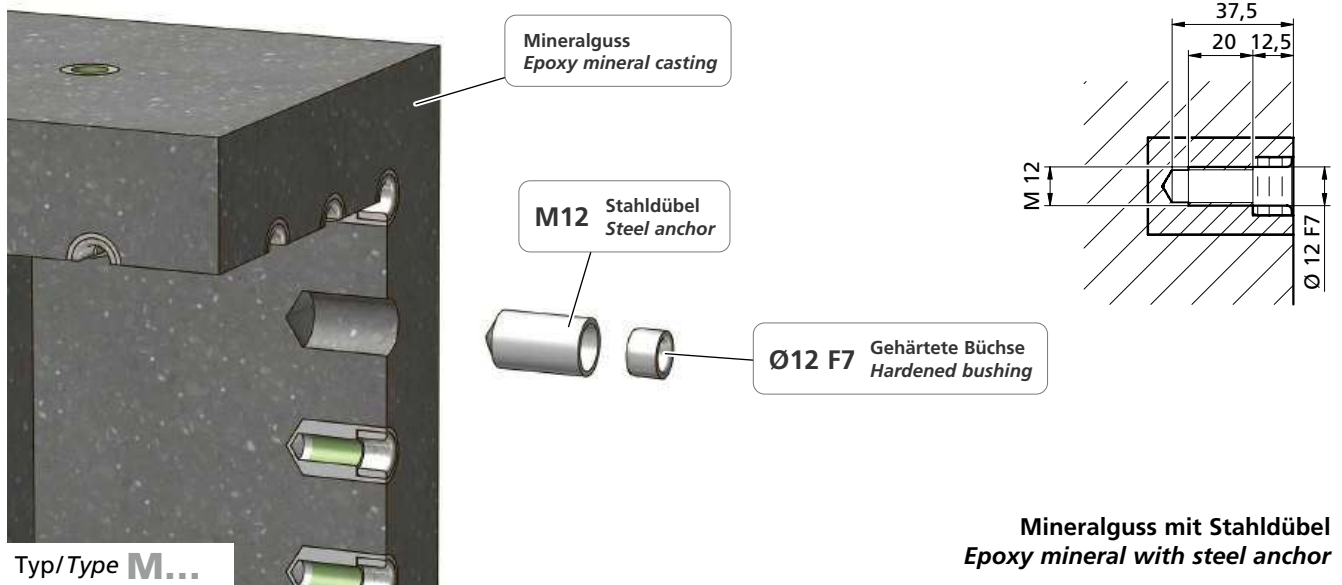
R50

Modultyp <i>Type of module</i>	
K	Kreuz <i>Cross</i>
Q	Quadrat <i>Square</i>
R	Rechteck <i>Rectangular</i>
S	Sechseck <i>Hexagonal</i>
A	Achteck <i>Octagonal</i>
X	Spezialform <i>Special shape</i>

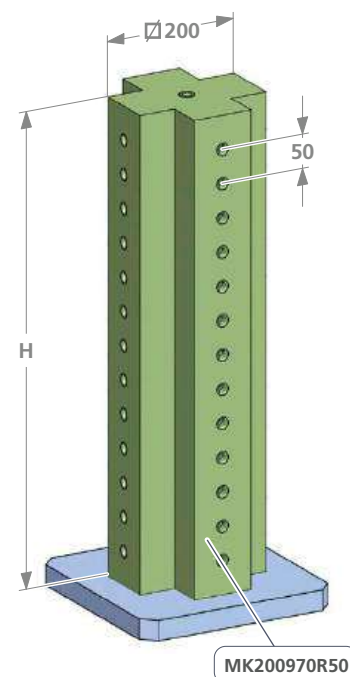
Aufspannbreite <i>Usable width</i>	
08	80 mm
09	90 mm
86	86 mm
10	100 mm
12	120 mm
15	150 mm
16	160 mm
18	180 mm
1808	180 / 80 mm
19	184 mm
20	200 mm
23	231 mm
24	240 mm
25	250 mm
30	300 mm
35	350 mm
40	400 mm
42	420 mm



Raster <i>Grid</i>	
R40	40 mm
R50	50 mm
R80	80 mm
R100	100 mm
OPP	200 mm



Art. Nr.	kg	Raster / Grid	H
MK200950R50	~73	36 x M12/12F7	500
MK200955R50	~40	40 x M12/12F7	550
MK200960R50	~44	44 x M12/12F7	600
MK200965R50	~47	48 x M12/12F7	650
MK200970R50	~51	52 x M12/12F7	700
MK300950R50	~58	36 x M12/12F7	500
MK300955R50	~64	40 x M12/12F7	550
MK300960R50	~70	44 x M12/12F7	600
MK300965R50	~75	48 x M12/12F7	650
MK300970R50	~81	52 x M12/12F7	700
MK300975R50	~87	56 x M12/12F7	750



powerCLAMP
p. 42

PCB4050700

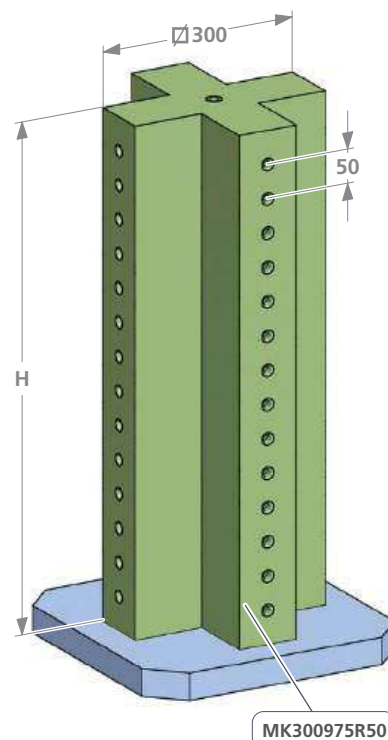
MK200970R50

p. 74

PS1PF48L34-105 / B115P

MK300975R50

PCB4050750



MK300975R50

PS1R43N49-60 / B61

p. 64



PAND48-34PRG-A1

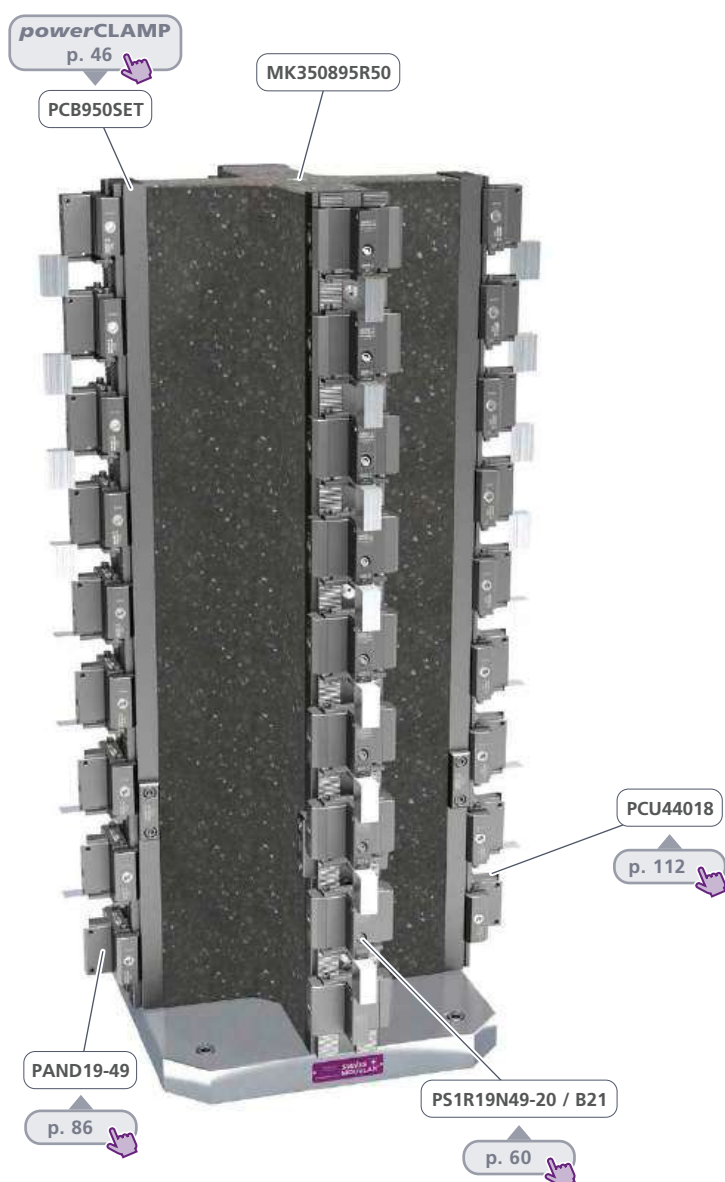
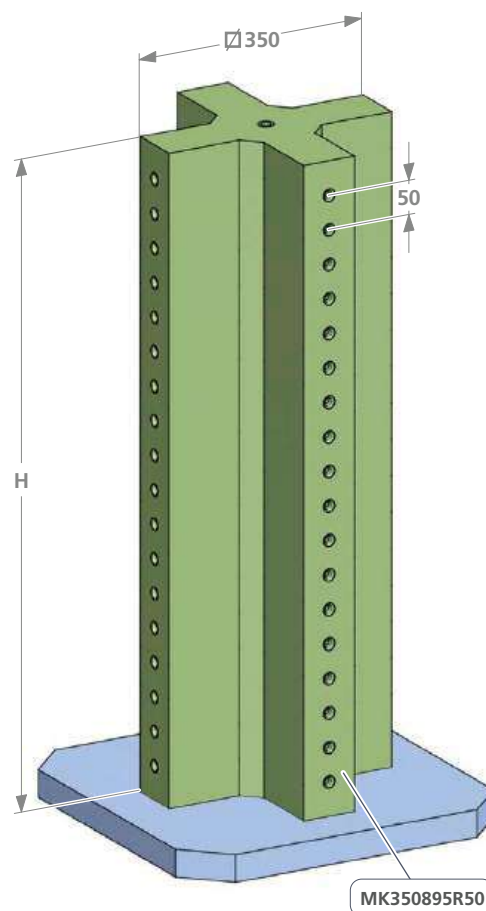
p. 90



PAND43-49

p. 88

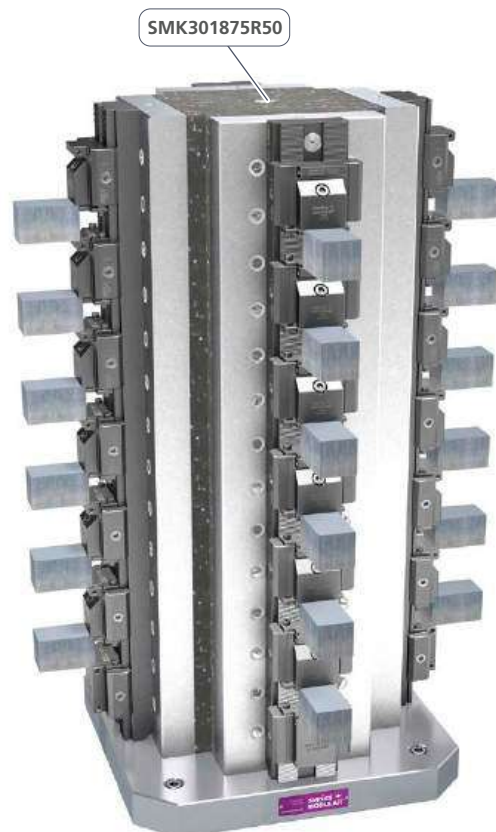
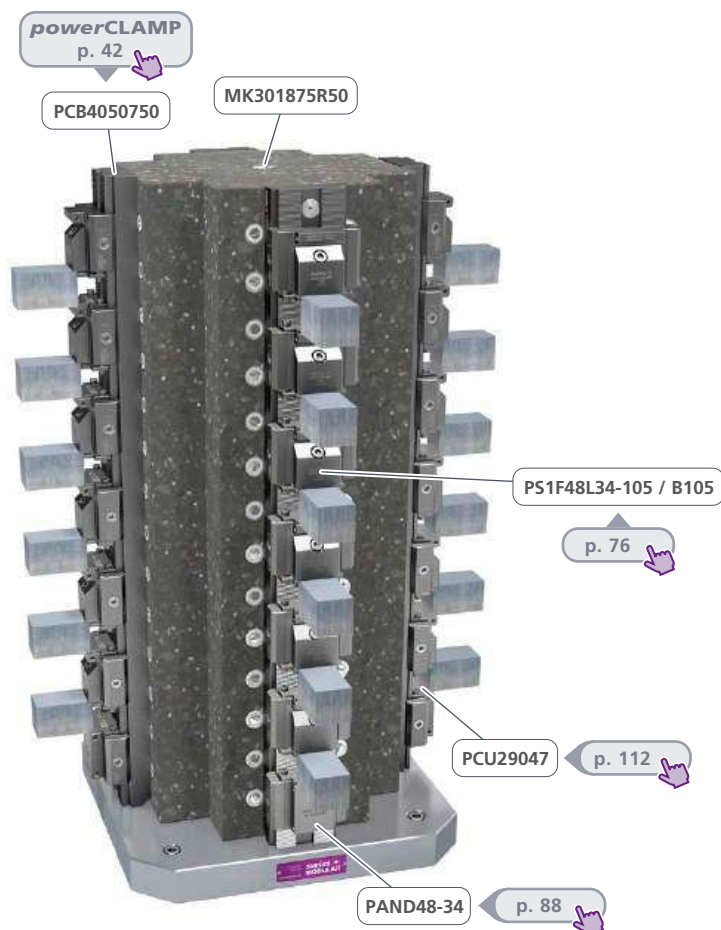
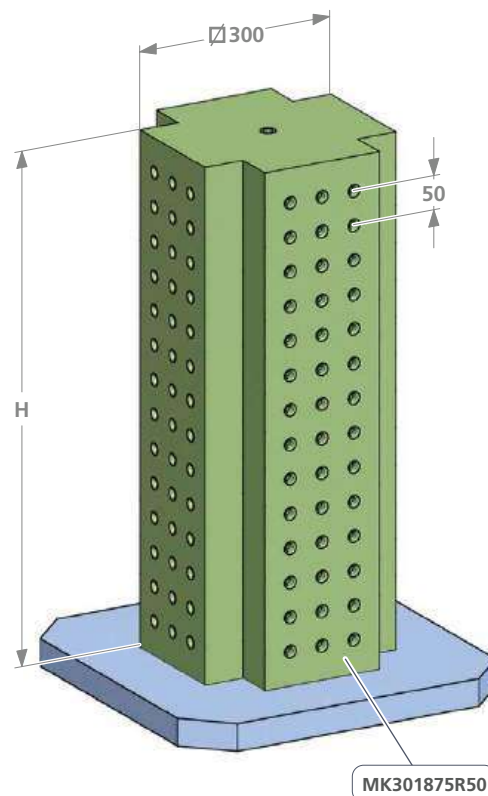
Art. Nr.	kg	Raster / Grid	H
MK350865R50	~83	48 x M12/12F7	650
MK350870R50	~89	52 x M12/12F7	700
MK350875R50	~96	56 x M12/12F7	750
MK350880R50	~102	60 x M12/12F7	800
MK350885R50	~108	64 x M12/12F7	850
MK350890R50	~115	68 x M12/12F7	900
MK350895R50	~121	72 x M12/12F7	950



Art. Nr.	kg	Raster / Grid	H
MK301845R50	~73	96 x M12/12F7	450
MK301850R50	~81	108 x M12/12F7	500
MK301855R50	~88	120 x M12/12F7	550
MK301860R50	~95	132 x M12/12F7	600
MK301865R50	~102	144 x M12/12F7	650
MK301870R50	~109	156 x M12/12F7	700
MK301875R50	~116	168 x M12/12F7	750

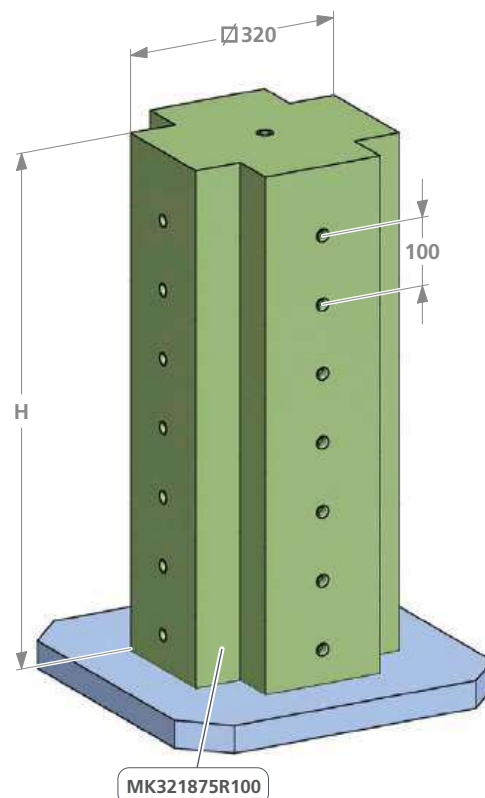
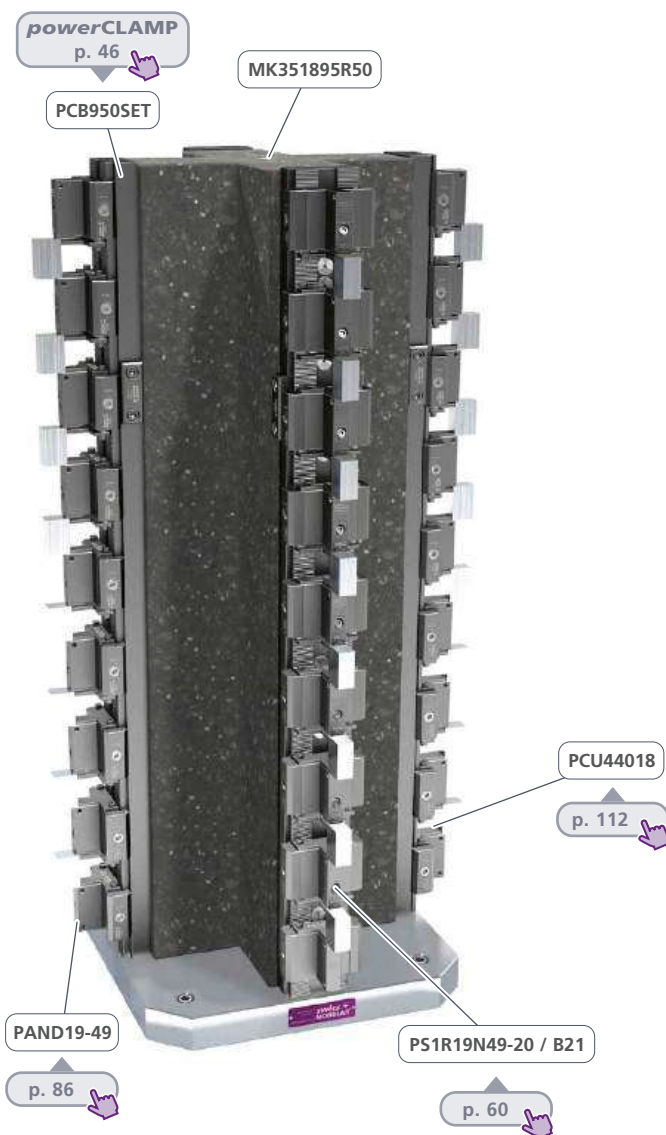
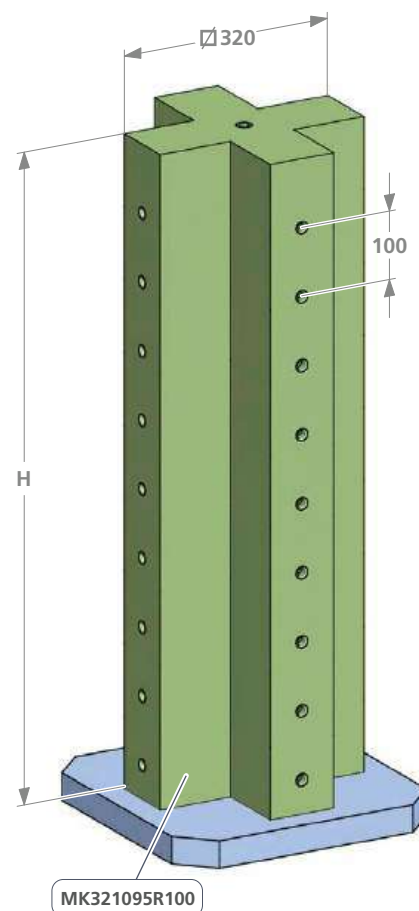


SMK301845R50	~113	96 x M12/12F7	450
SMK301850R50	~124	108 x M12/12F7	500
SMK301855R50	~135	120 x M12/12F7	550
SMK301860R50	~146	132 x M12/12F7	600
SMK301865R50	~157	144 x M12/12F7	650
SMK301870R50	~168	156 x M12/12F7	700
SMK301875R50	~179	168 x M12/12F7	750



Art. Nr.	kg	Raster / Grid	H
MK321075R100	~97	20 x M12/12F7	750
MK321080R100	~103	24 x M12/12F7	800
MK321085R100	~110	28 x M12/12F7	850
MK321090R100	~116	32 x M12/12F7	900
MK321095R100	~123	36 x M12/12F7	950
MK321875R100	~149	20 x M12/12F7	750
MK321880R100	~159	24 x M12/12F7	800
MK321885R100	~169	28 x M12/12F7	850
MK321890R100	~178	32 x M12/12F7	900
MK321895R100	~188	36 x M12/12F7	950

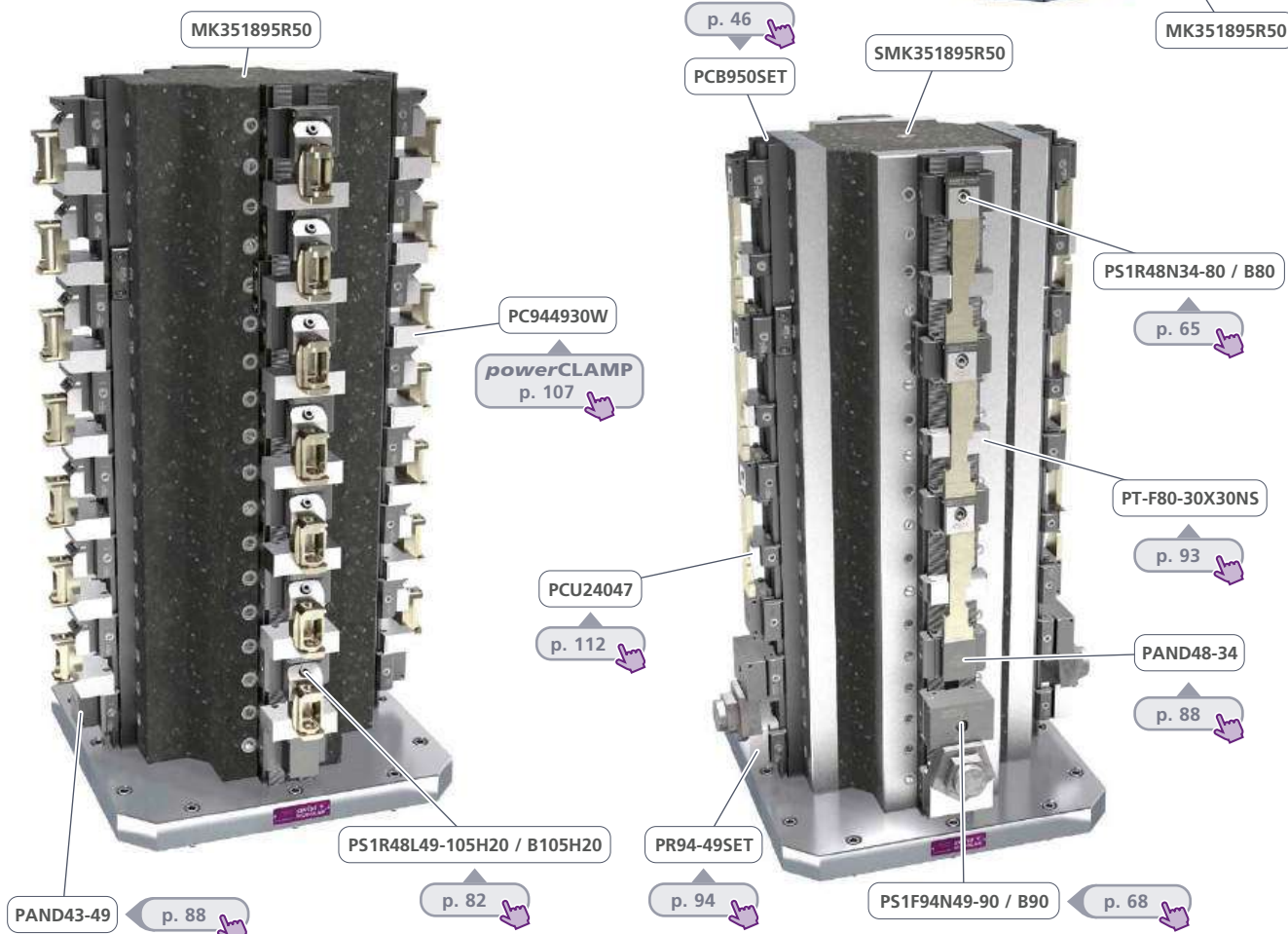
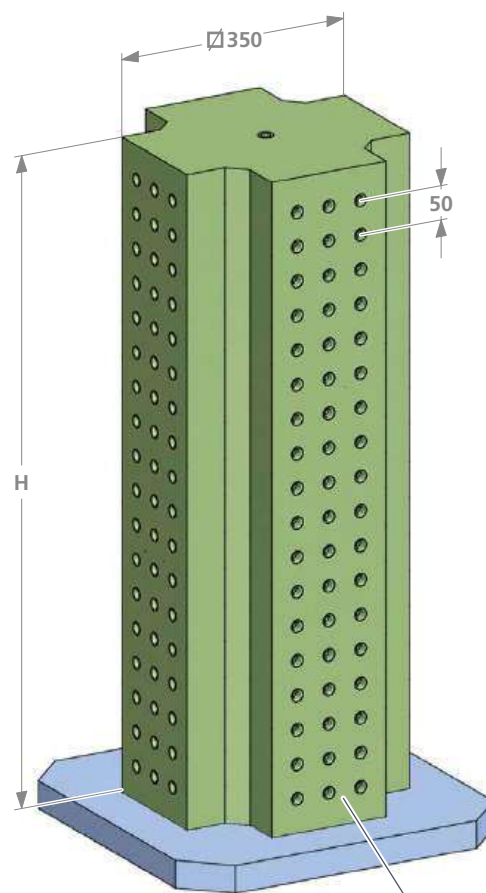
Auf Anfrage erhältlich
Available on request



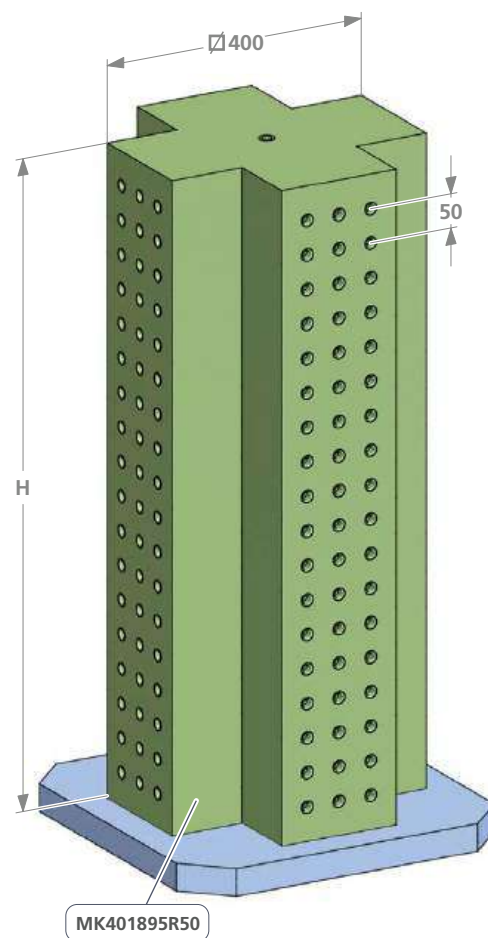
Art. Nr.	kg	Raster / Grid	H
MK351865R50	~123	144 x M12/12F7	650
MK351870R50	~133	156 x M12/12F7	700
MK351875R50	~142	168 x M12/12F7	750
MK351880R50	~151	180 x M12/12F7	800
MK351885R50	~159	192 x M12/12F7	850
MK351890R50	~168	204 x M12/12F7	900
MK351895R50	~176	216 x M12/12F7	950



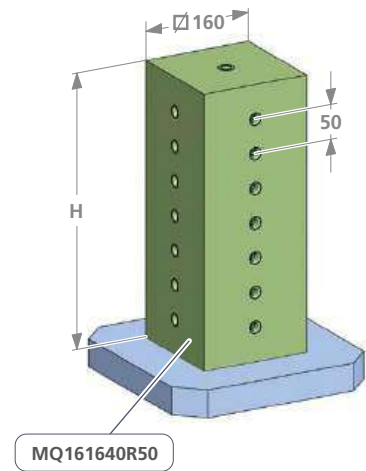
SMK351865R50	~180	144 x M12/12F7	650
SMK351870R50	~193	156 x M12/12F7	700
SMK351875R50	~205	168 x M12/12F7	750
SMK351880R50	~218	180 x M12/12F7	800
SMK351885R50	~231	192 x M12/12F7	850
SMK351890R50	~243	204 x M12/12F7	900
SMK351895R50	~256	216 x M12/12F7	950



Art. Nr.	kg	Raster / Grid	H
MK401865R50	~151	144 x M12/12F7	650
MK401870R50	~162	156 x M12/12F7	700
MK401875R50	~172	168 x M12/12F7	750
MK401880R50	~183	180 x M12/12F7	800
MK401885R50	~193	192 x M12/12F7	850
MK401890R50	~204	204 x M12/12F7	900
MK401895R50	~214	216 x M12/12F7	950



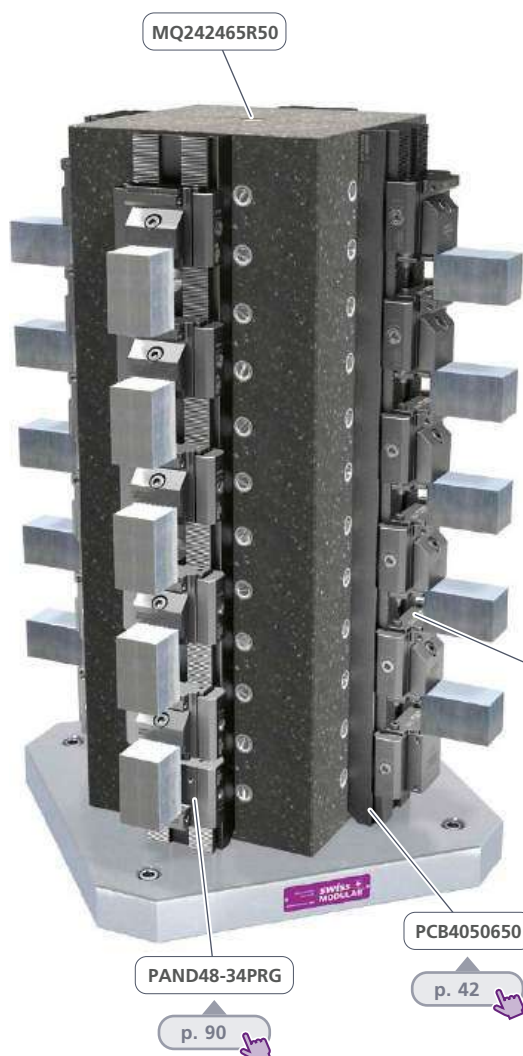
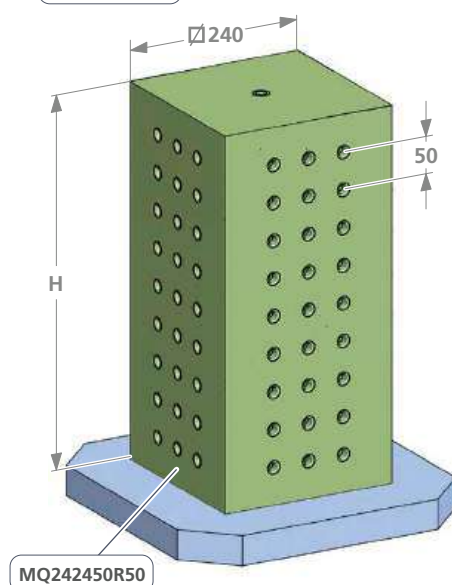
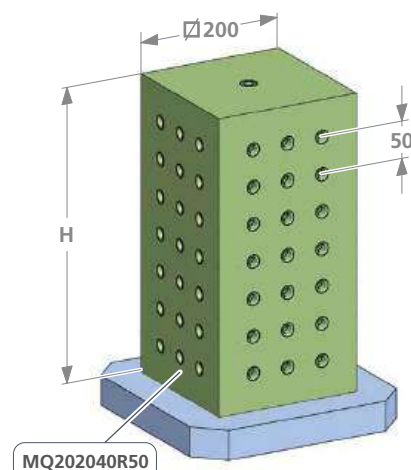
Art. Nr.	kg	Raster / Grid	H
MQ161630R50	~19	20 x M12/12F7	300
MQ161635R50	~22	24 x M12/12F7	350
MQ161640R50	~25	28 x M12/12F7	400
MQ161645R50	~28	32 x M12/12F7	450
MQ161650R50	~31	36 x M12/12F7	500



Maschinenschonend und leicht,
fast in allen Formen herstellbar.

Reduces machine wear due to low
specific weight - can be produced in
all sorts of shapes.

Art. Nr.	kg	Raster / Grid	H
MQ202040R50	~42	84 x M12/12F7	400
MQ202045R50	~53	96 x M12/12F7	450
MQ202050R50	~59	108 x M12/12F7	500
MQ202055R50	~64	120 x M12/12F7	550
MQ202060R50	~70	132 x M12/12F7	600
MQ202065R50	~76	144 x M12/12F7	650
MQ202070R50	~81	156 x M12/12F7	700
MQ242450R50	~81	108 x M12/12F7	500
MQ242455R50	~89	120 x M12/12F7	550
MQ242460R50	~97	132 x M12/12F7	600
MQ242465R50	~103	144 x M12/12F7	650



powerCLAMP
p. 74

PS1PF48L34-105/B115P

PCU29047

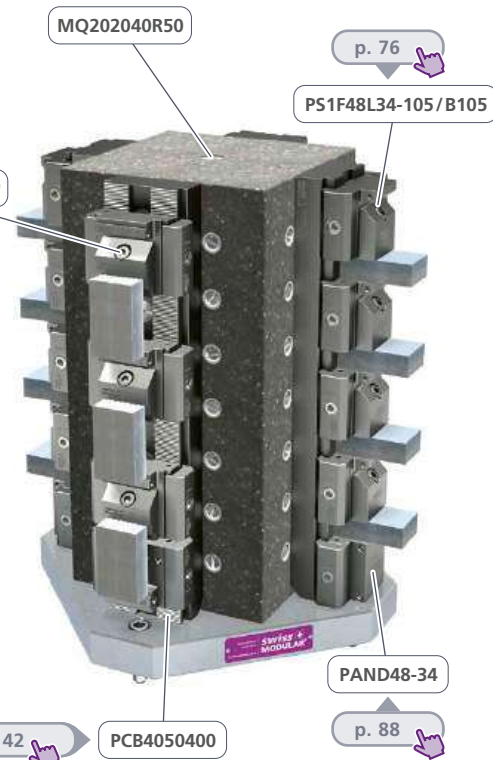
p. 112

PCB4050650

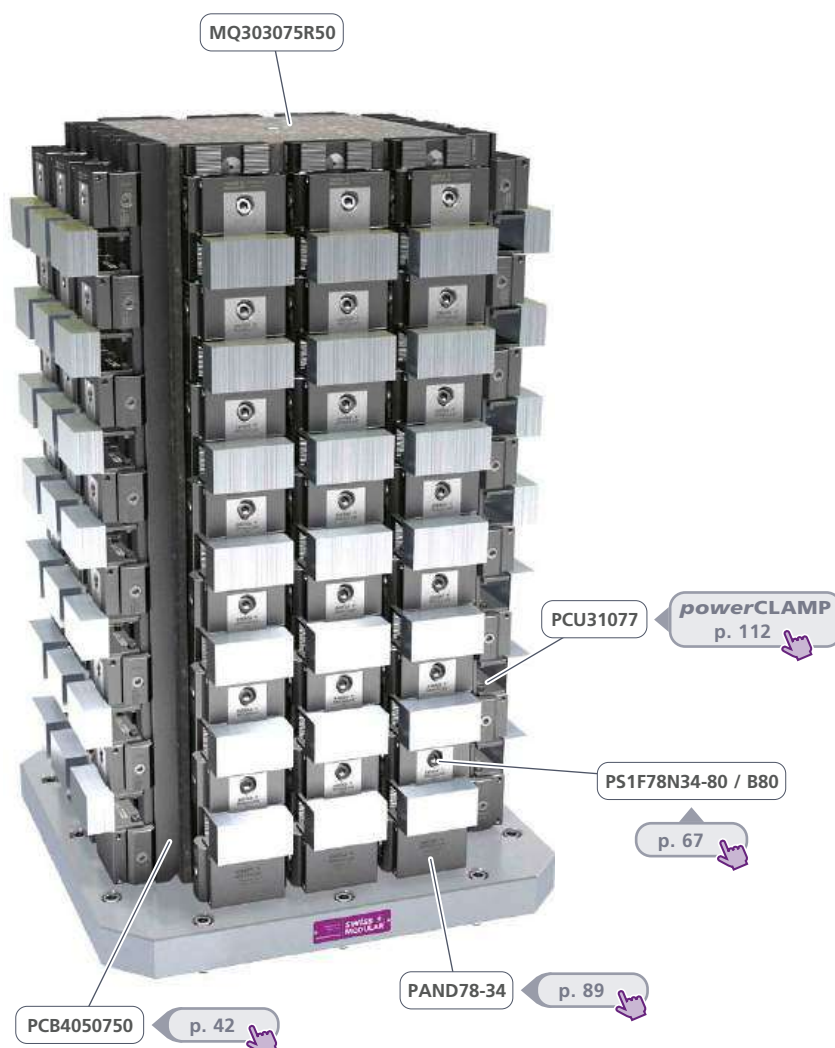
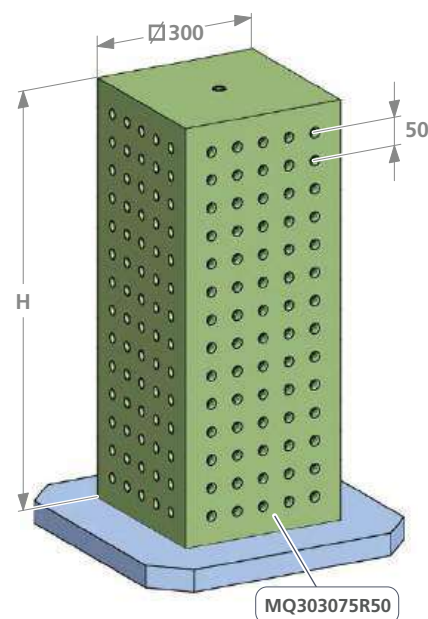
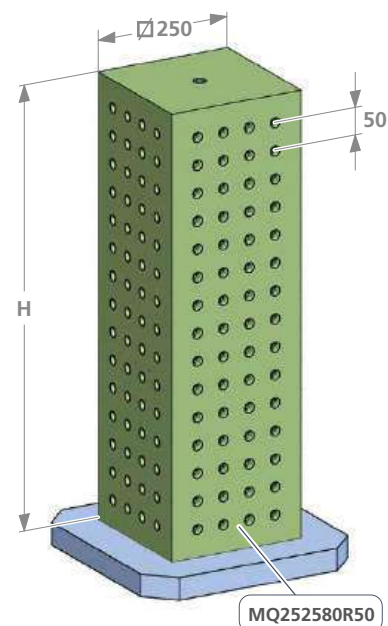
p. 42

PAND48-34PRG

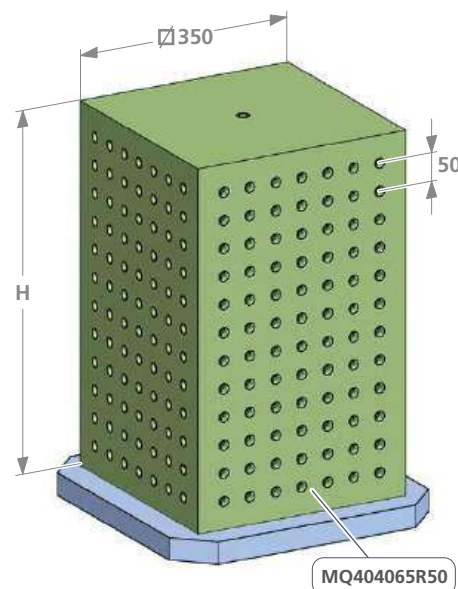
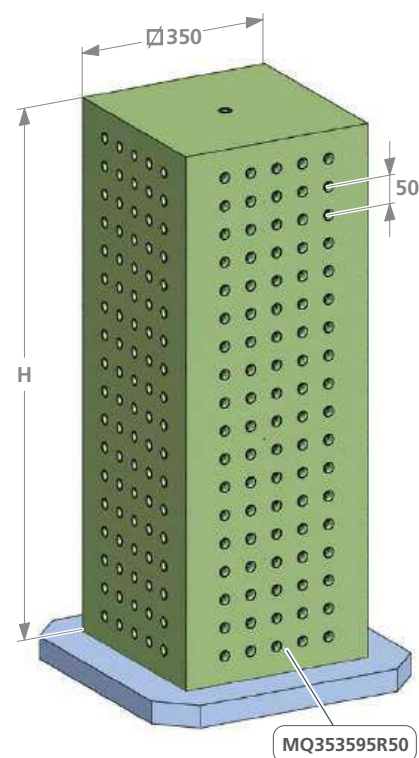
p. 90



Art. Nr.	kg	Raster / Grid	H
MQ252560R50	~101	176 x M12/12F7	600
MQ252565R50	~109	192 x M12/12F7	650
MQ252570R50	~117	208 x M12/12F7	700
MQ252575R50	~126	224 x M12/12F7	750
MQ252580R50	~134	240 x M12/12F7	800
MQ303050R50	~102	180 x M12/12F7	500
MQ303055R50	~111	200 x M12/12F7	550
MQ303060R50	~120	220 x M12/12F7	600
MQ303065R50	~129	240 x M12/12F7	650
MQ303070R50	~138	260 x M12/12F7	700
MQ303075R50	~148	280 x M12/12F7	750

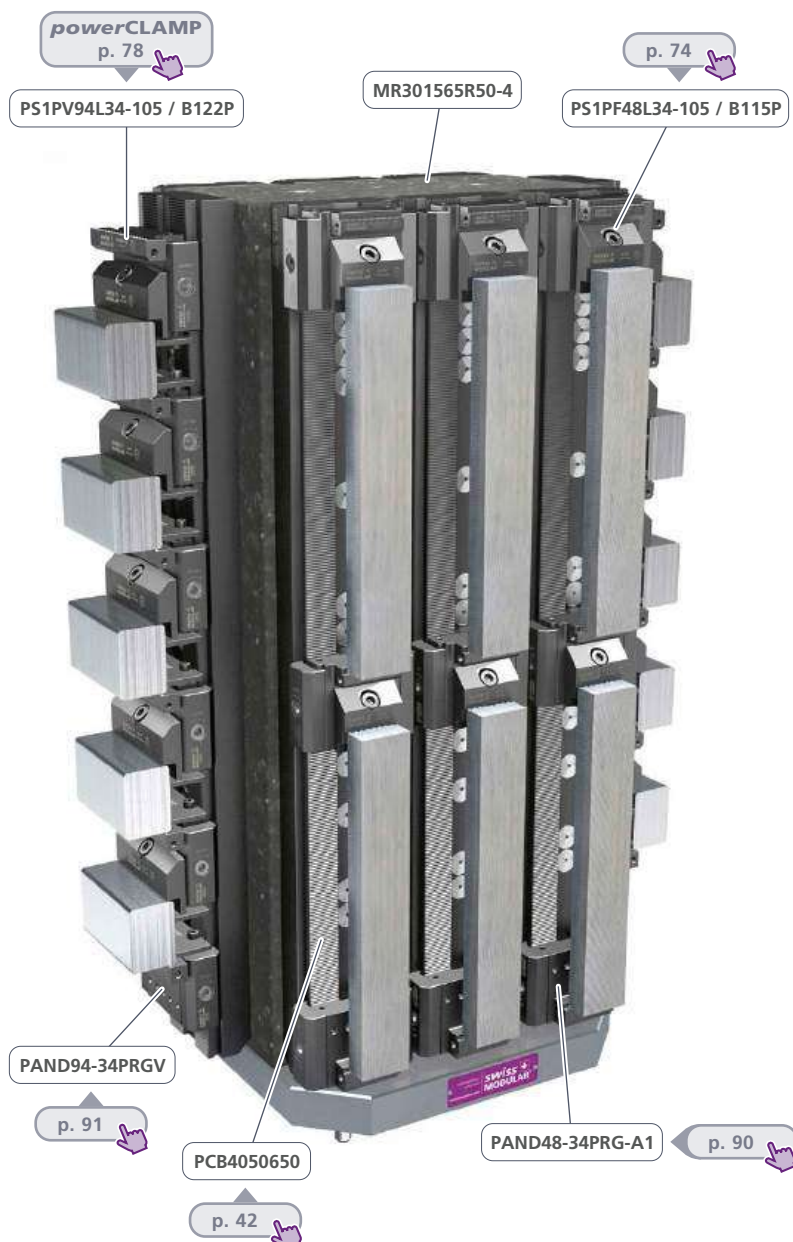
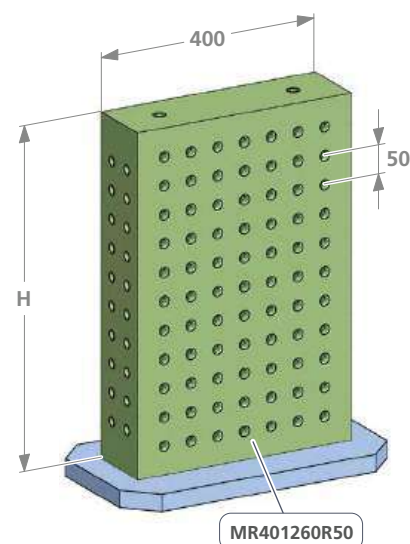
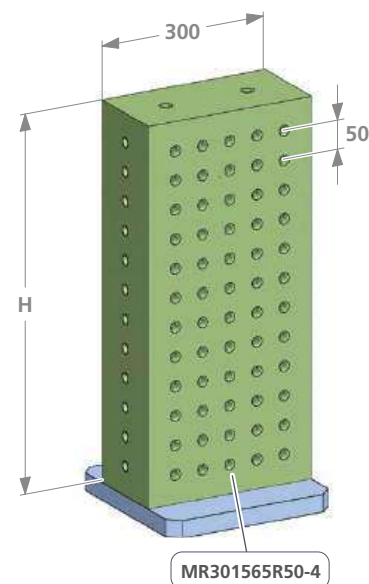


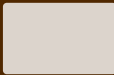
Art. Nr.	kg	Raster / Grid	H
MQ353565R50	~161	240 x M12/12F7	650
MQ353570R50	~172	260 x M12/12F7	700
MQ353575R50	~183	280 x M12/12F7	750
MQ353580R50	~194	300 x M12/12F7	800
MQ353585R50	~205	320 x M12/12F7	850
MQ353590R50	~216	340 x M12/12F7	900
MQ353595R50	~227	360 x M12/12F7	950
MQ404065R50	~199	336 x M12/12F7	650
MQ404070R50	~212	364 x M12/12F7	700
MQ404075R50	~226	392 x M12/12F7	750
MQ404080R50	~239	420 x M12/12F7	800
MQ404085R50	~252	448 x M12/12F7	850
MQ404090R50	~265	476 x M12/12F7	900
MQ404095R50	~279	504 x M12/12F7	950



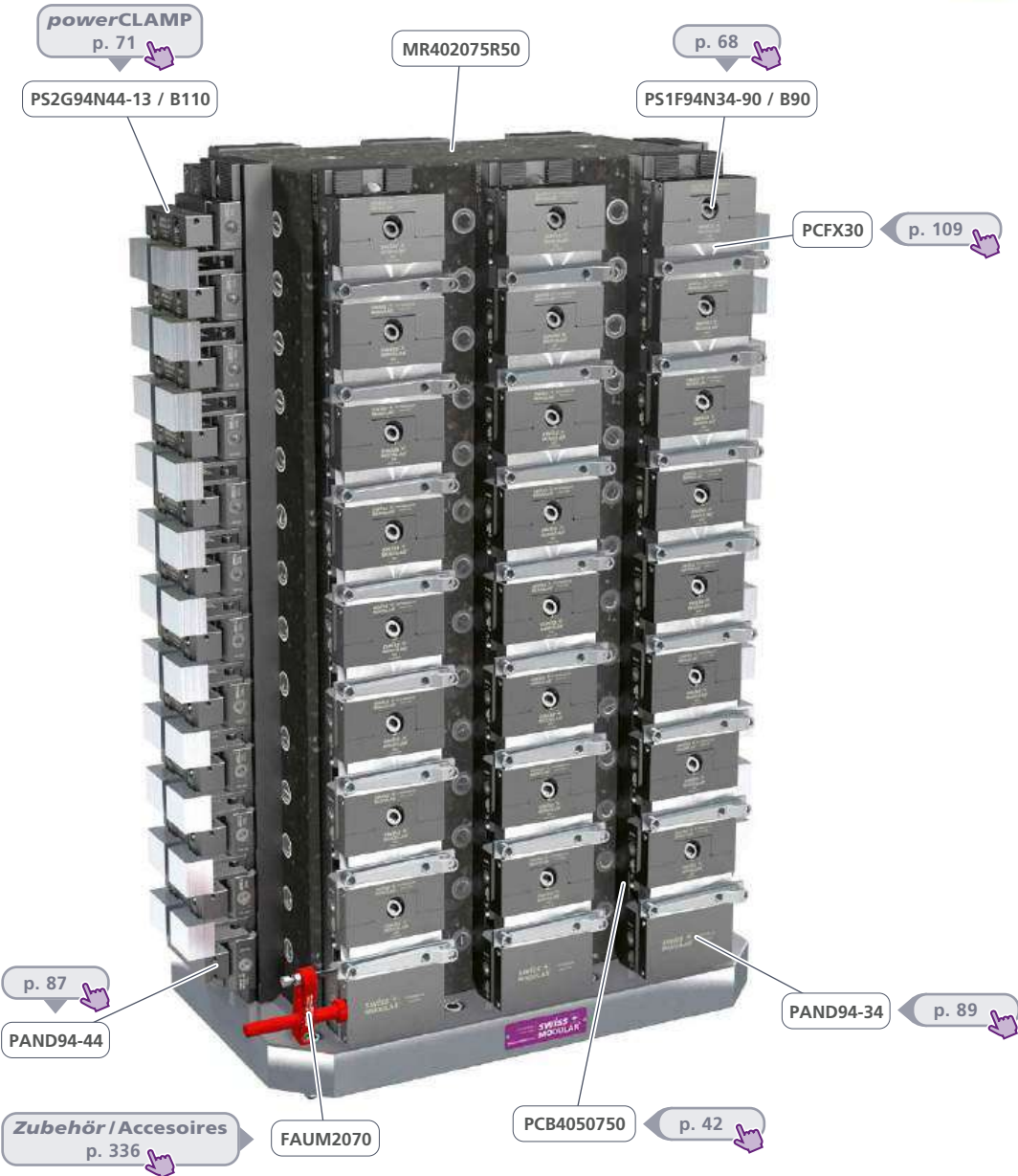
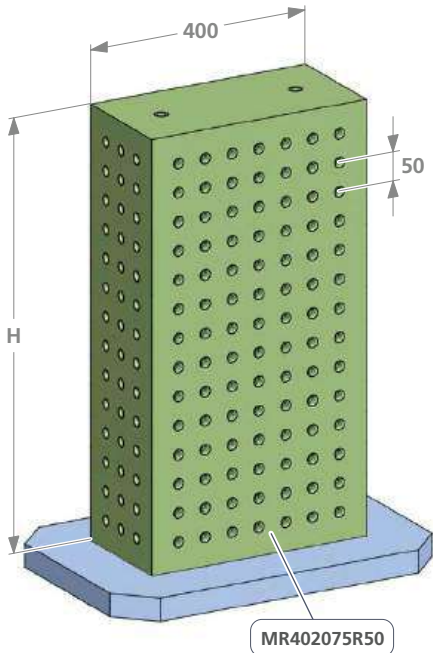


Art. Nr.	kg	Raster / Grid	H
MR301550R50-4	~61	63 x M12/12F7	500
MR301555R50-4	~67	70 x M12/12F7	550
MR301560R50-4	~73	77 x M12/12F7	600
MR301565R50-4	~79	84 x M12/12F7	650
MR401245R50	~61	140 x M12/12F7	450
MR401250R50	~68	158 x M12/12F7	500
MR401255R50	~74	176 x M12/12F7	550
MR401260R50	~81	194 x M12/12F7	600



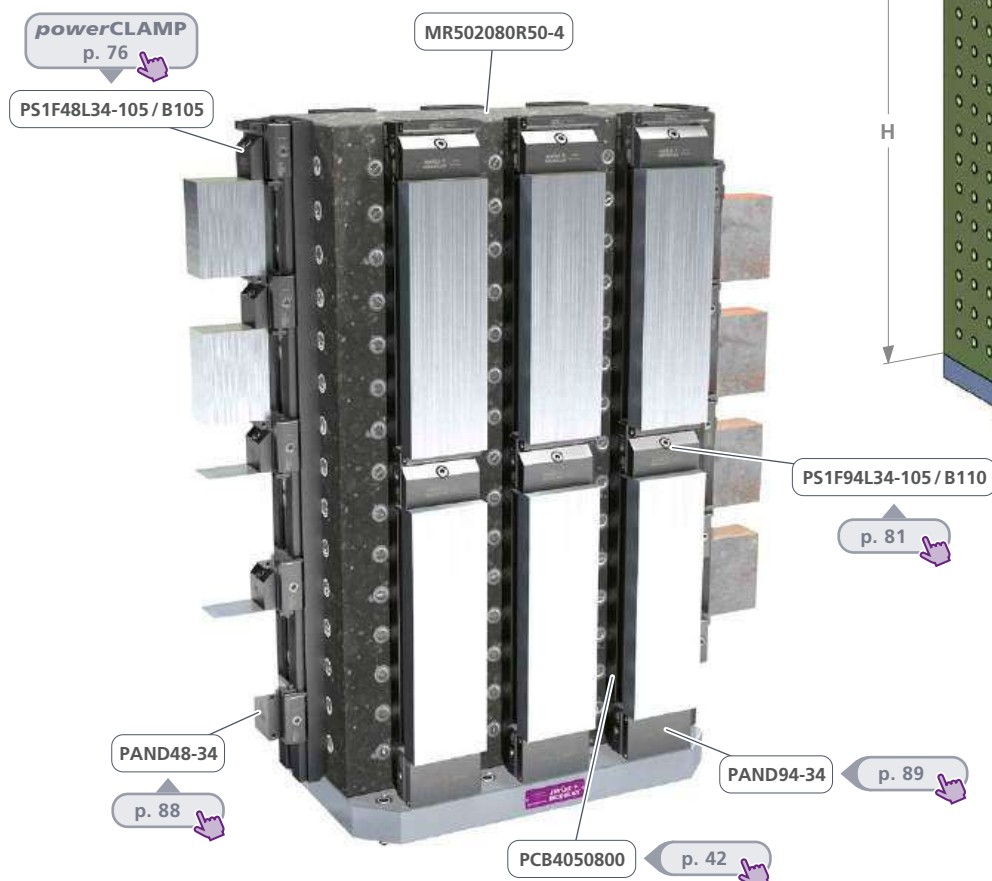
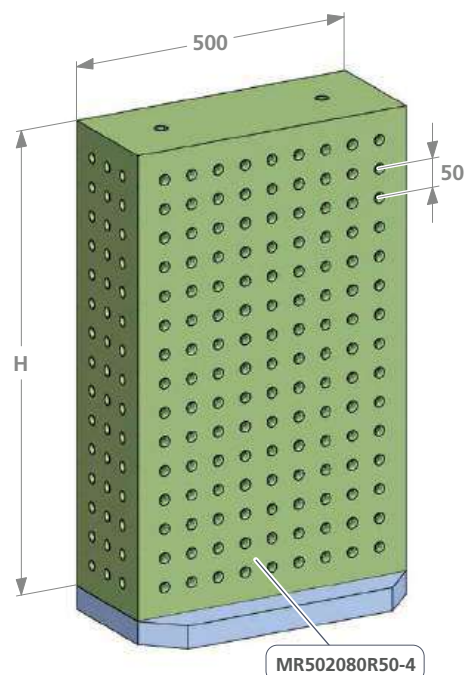
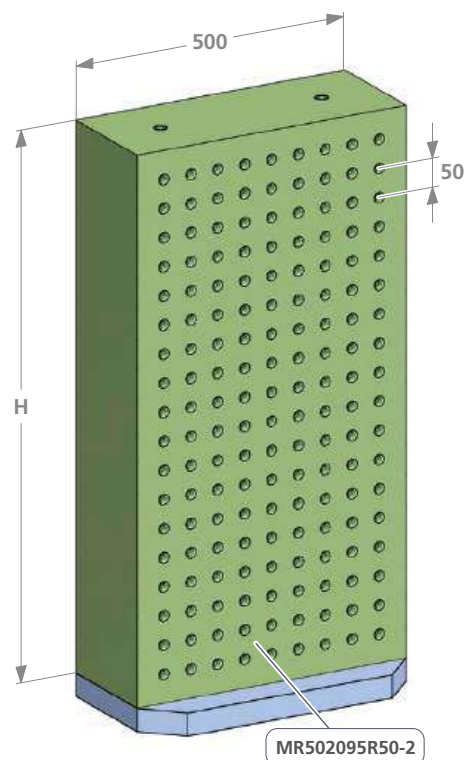


Art. Nr.	kg	Raster / Grid	H
MR402050R50	~107	180 x M12/12F7	500
MR402055R50	~118	200 x M12/12F7	550
MR402060R50	~129	220 x M12/12F7	600
MR402065R50	~139	240 x M12/12F7	650
MR402070R50	~150	260 x M12/12F7	700
MR402075R50	~161	280 x M12/12F7	750



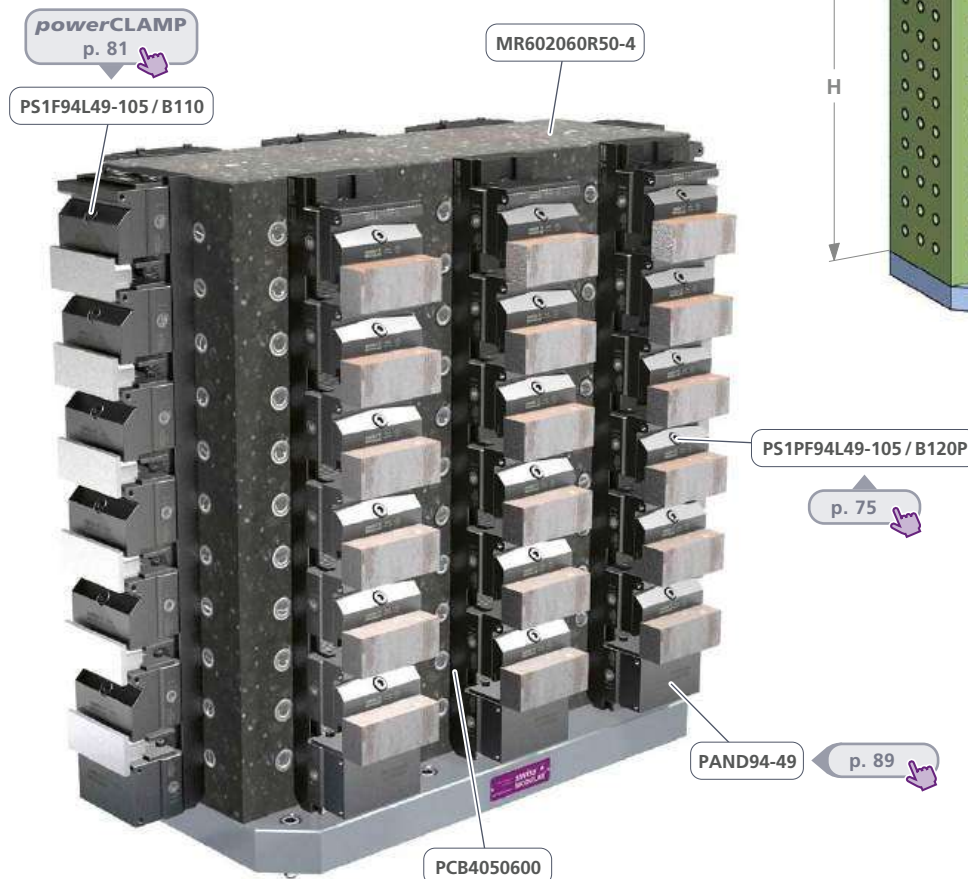
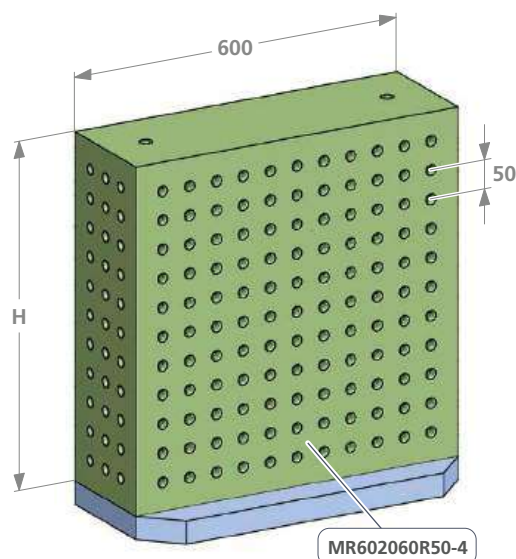
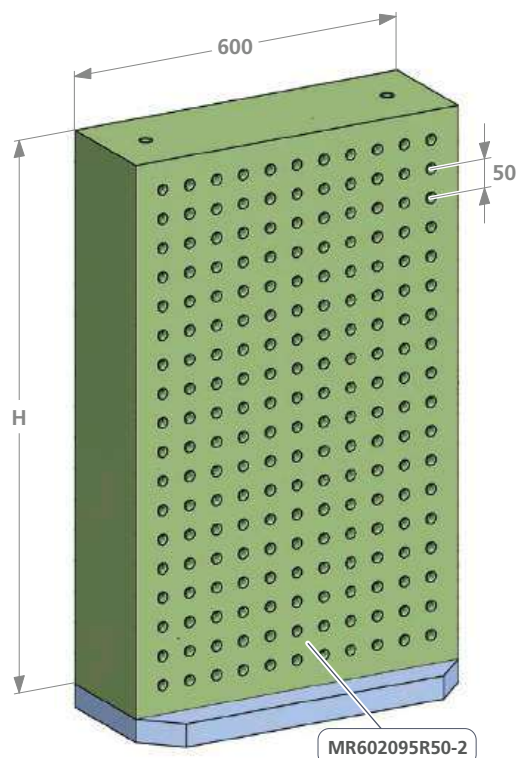


Art. Nr.	kg	Raster / Grid	H
MR502060R50-2	~156	198 x M12/12F7	600
MR502065R50-2	~169	216 x M12/12F7	650
MR502070R50-2	~182	234 x M12/12F7	700
MR502075R50-2	~195	252 x M12/12F7	750
MR502080R50-2	~208	270 x M12/12F7	800
MR502085R50-2	~221	288 x M12/12F7	850
MR502090R50-2	~234	306 x M12/12F7	900
MR502095R50-2	~247	324 x M12/12F7	950
MR502060R50-4	~160	264 x M12/12F7	600
MR502065R50-4	~173	288 x M12/12F7	650
MR502070R50-4	~186	312 x M12/12F7	700
MR502075R50-4	~200	336 x M12/12F7	750
MR502080R50-4	~213	360 x M12/12F7	800
MR502085R50-4	~226	384 x M12/12F7	850
MR502090R50-4	~240	408 x M12/12F7	900
MR502095R50-4	~253	432 x M12/12F7	950



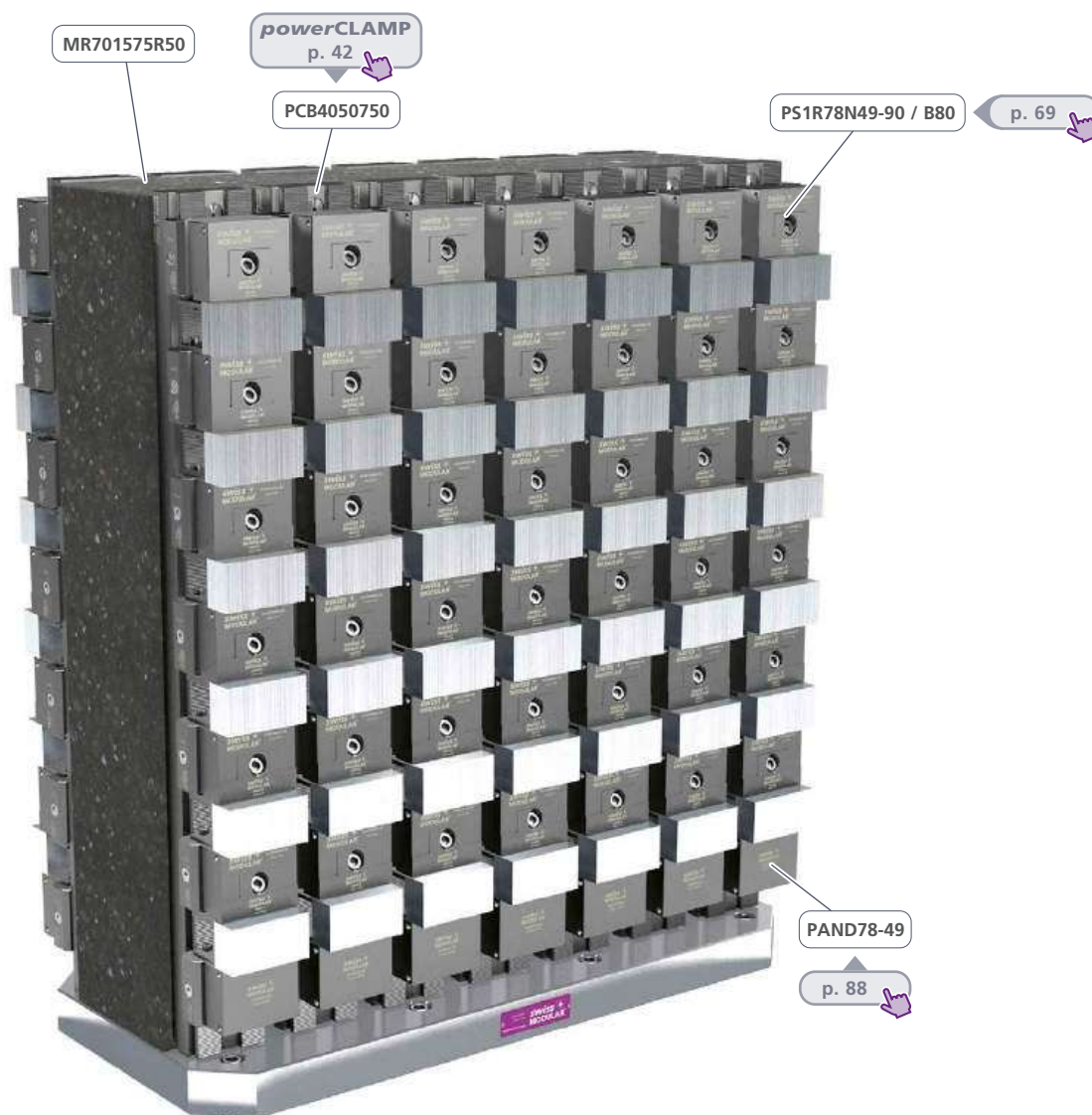
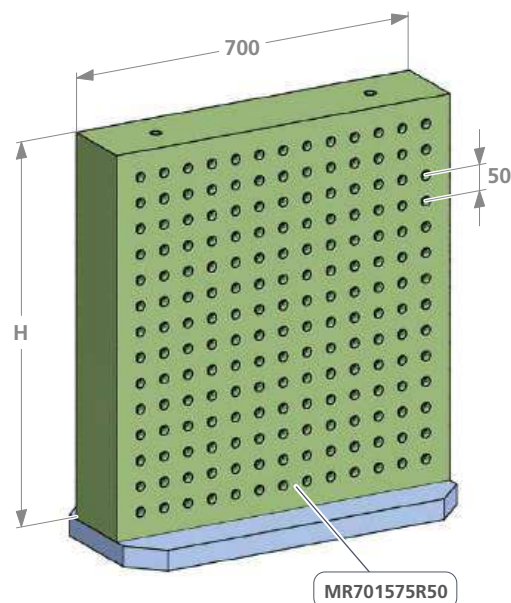


Art. Nr.	kg	Raster / Grid	H
MR602060R50-2	~188	242 x M12/12F7	600
MR602065R50-2	~203	264 x M12/12F7	650
MR602070R50-2	~219	286 x M12/12F7	700
MR602075R50-2	~234	308 x M12/12F7	750
MR602080R50-2	~250	330 x M12/12F7	800
MR602085R50-2	~265	652 x M12/12F7	850
MR602090R50-2	~281	374 x M12/12F7	900
MR602095R50-2	~279	396 x M12/12F7	950
MR602060R50-4	~192	308 x M12/12F7	600
MR602065R50-4	~207	336 x M12/12F7	650
MR602070R50-4	~223	364 x M12/12F7	700
MR602075R50-4	~239	392 x M12/12F7	750
MR602080R50-4	~255	420 x M12/12F7	800
MR602085R50-4	~271	448 x M12/12F7	850
MR602090R50-4	~286	476 x M12/12F7	900
MR602095R50-4	~302	504 x M12/12F7	950





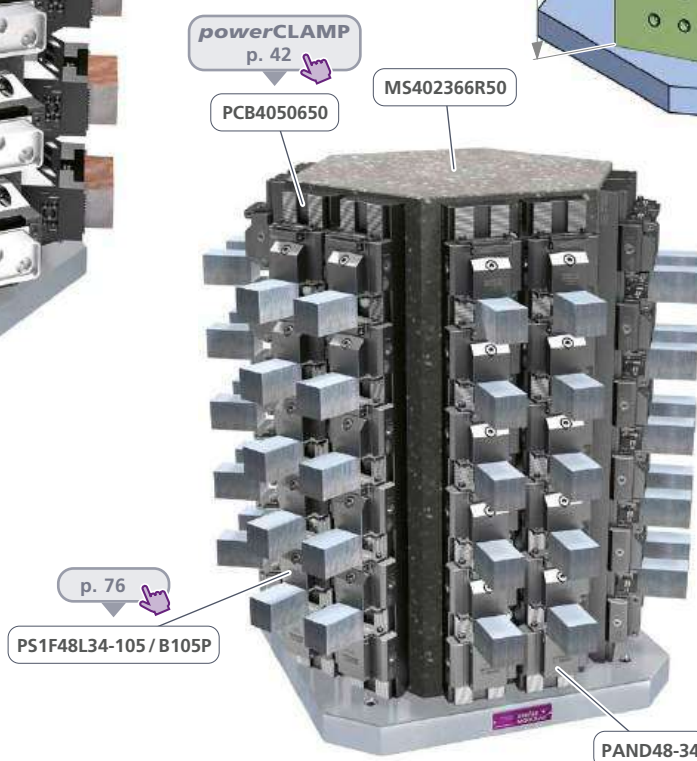
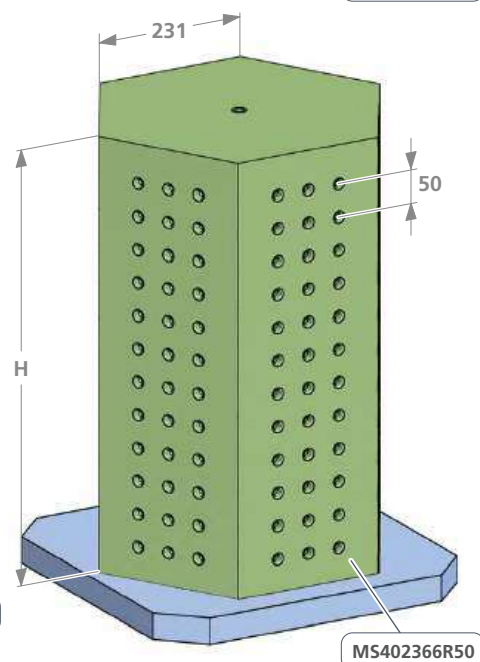
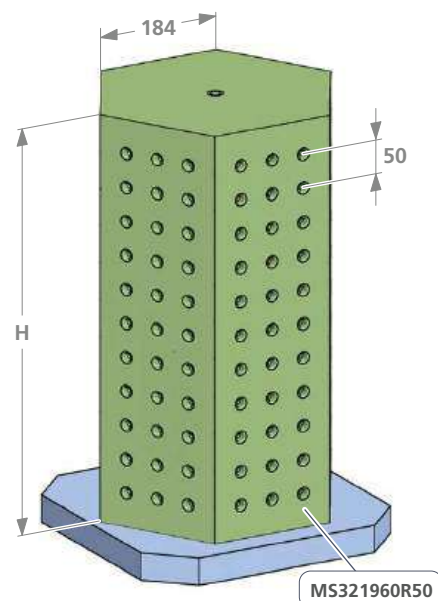
Art. Nr.	kg	Raster / Grid	H
MR701550R50	~140	234 x M12/12F7	500
MR701555R50	~154	260 x M12/12F7	550
MR701560R50	~168	286 x M12/12F7	600
MR701560R50	~182	312 x M12/12F7	650
MR701570R50	~196	338 x M12/12F7	700
MR701575R50	~210	364 x M12/12F7	750



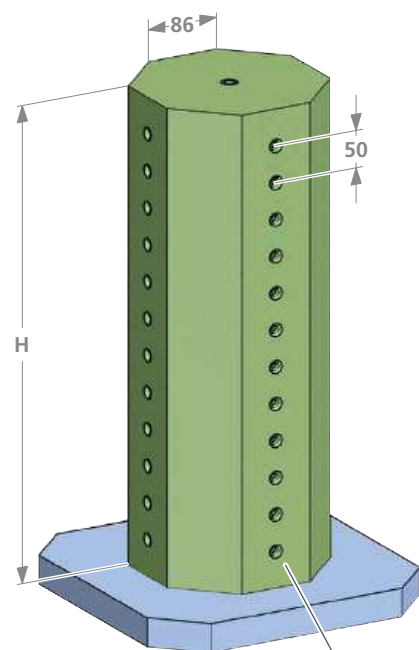
Art. Nr.	kg	Raster / Grid	H
MS321960R50	~111	198 x M12/12F7	600
MS321965R50	~119	216 x M12/12F7	650
MS321970R50	~127	234 x M12/12F7	700
MS321975R50	~135	252 x M12/12F7	750
MS321980R50	~144	270 x M12/12F7	800
MS402366R40	~163	270 x M12/12F7	660
MS402395R40	~223	396 x M12/12F7	950
MS402366R50	~171	216 x M12/12F7	660
MS402395R50	~236	324 x M12/12F7	950



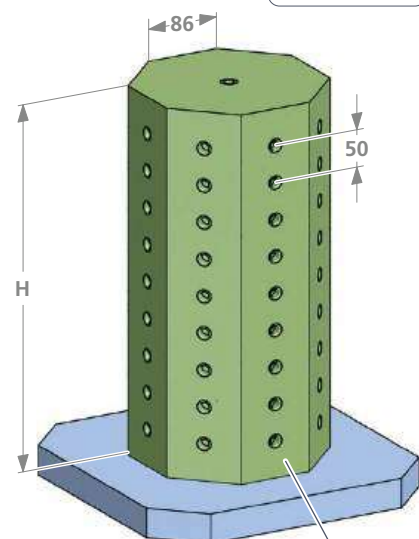
Auf Anfrage erhältlich
Available on request



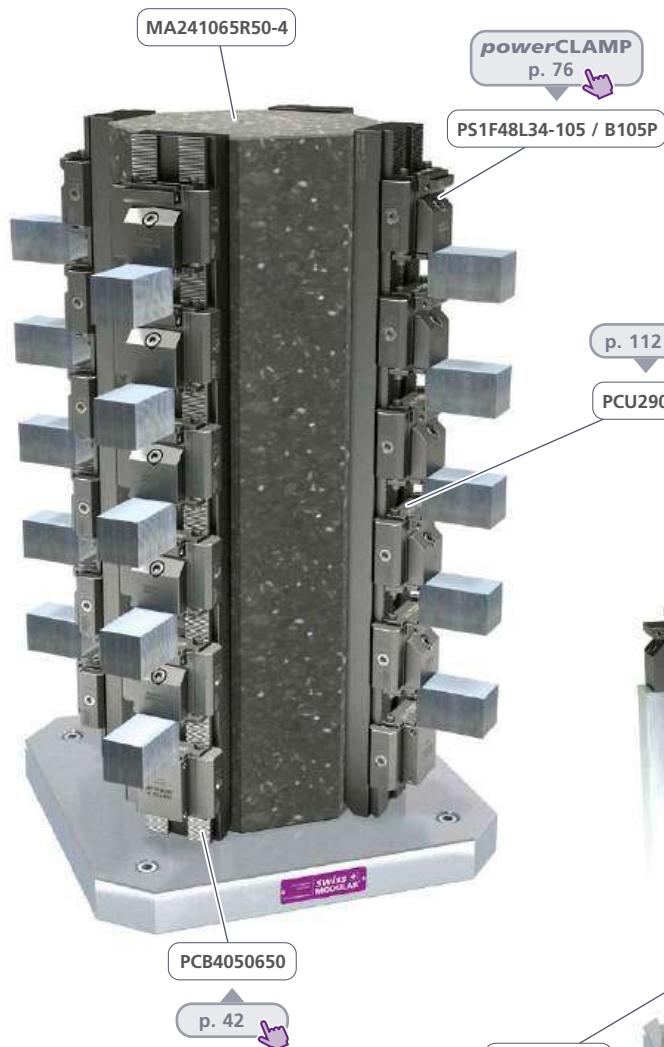
Art. Nr.	kg	Raster / Grid	H
MA241050R50-4	~60	36 x M12/12F7	500
MA241055R50-4	~66	40 x M12/12F7	550
MA241060R50-4	~72	44 x M12/12F7	600
MA241065R50-4	~78	48 x M12/12F7	650
MA241050R50-8	~62	72 x M12/12F7	500
MA241055R50-8	~69	80 x M12/12F7	550
MA241060R50-8	~75	88 x M12/12F7	600
MA241065R50-8	~81	96 x M12/12F7	650



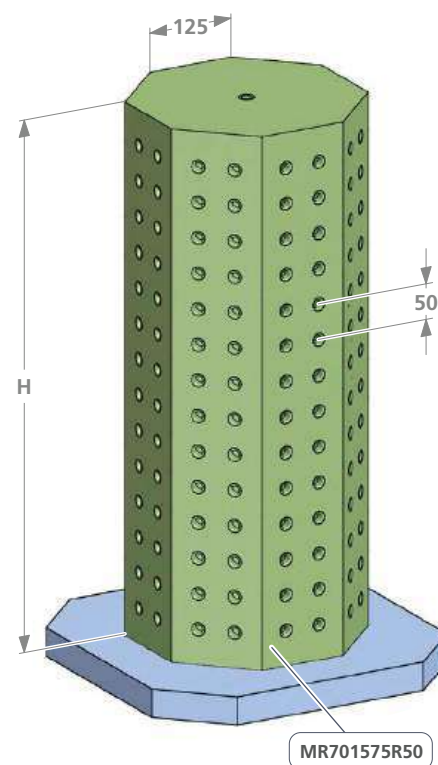
MA241065R50-4



MA241050R50-8



Art. Nr.	kg	Raster / Grid	H
MA301265R50-8-2	~103	192 x M12/12F7	650
MA301270R50-8-2	~111	208 x M12/12F7	700
MA301275R50-8-2	~117	224 x M12/12F7	750

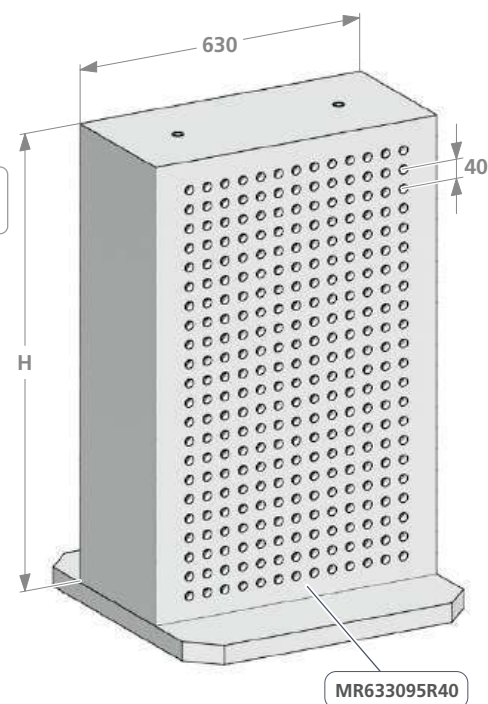


microCLAMP
p. 180



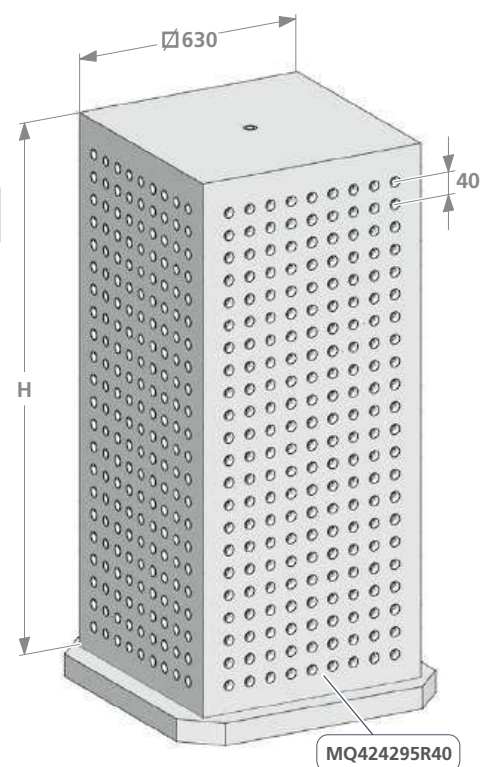
Art. Nr.	kg	Raster / Grid	H
MR633075R40	~314	468 x M12/12F7	750
MR633080R40	~333	494 x M12/12F7	800
MR633090R40	~374	546 x M12/12F7	900
MR633095R40	~393	572 x M12/12F7	950

Auf Anfrage erhältlich
Available on request



Art. Nr.	kg	Raster / Grid	H
MQ424275R40	~329	612 x M12/12F7	750
MQ424280R40	~349	648 x M12/12F7	800
MQ424285R40	~373	684 x M12/12F7	850
MQ424290R40	~393	720 x M12/12F7	900
MQ424295R40	~413	756 x M12/12F7	950

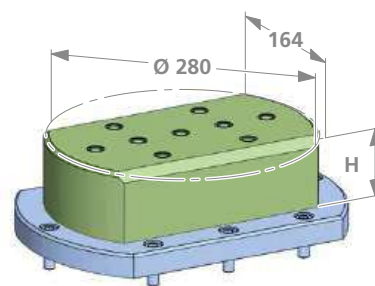
Auf Anfrage erhältlich
Available on request



Mineralgusserhöhung für 5-Achsenmaschinen Epoxy mineral riser for 5-axis machines

tripoxyMINERAL

Art. Nr.	kg	H	Raster / Grid R50
MUB2817-H85	~8,7	85	9 x M12/12F7
MUB2817-H100	~10,3	100	
MUB2817-H125	~12,9	125	



Mineralgusserhöhungen um eine optimale Bearbeitungshöhe und Zugänglichkeit mit der Spindel zu erreichen.

Epoxy mineral risers for an optimal machining height and accessibility with the spindle.

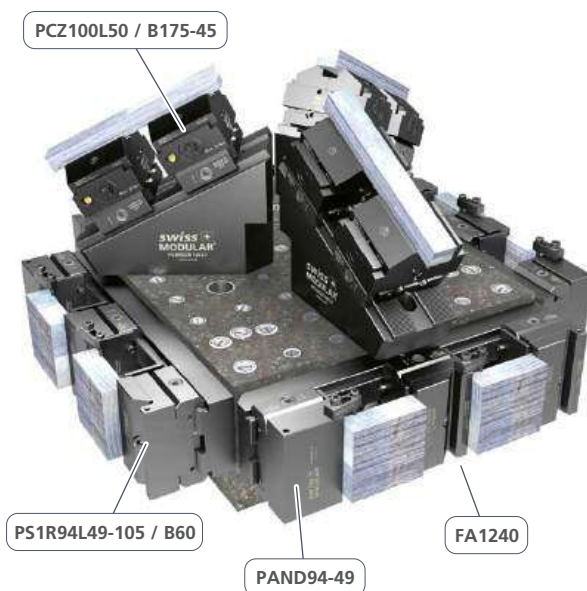
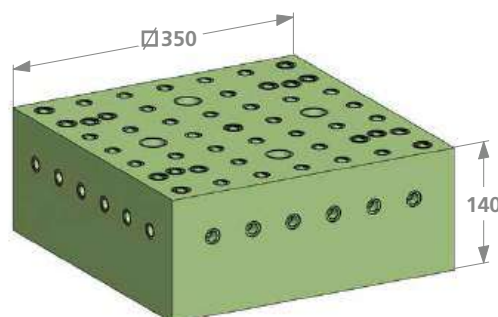


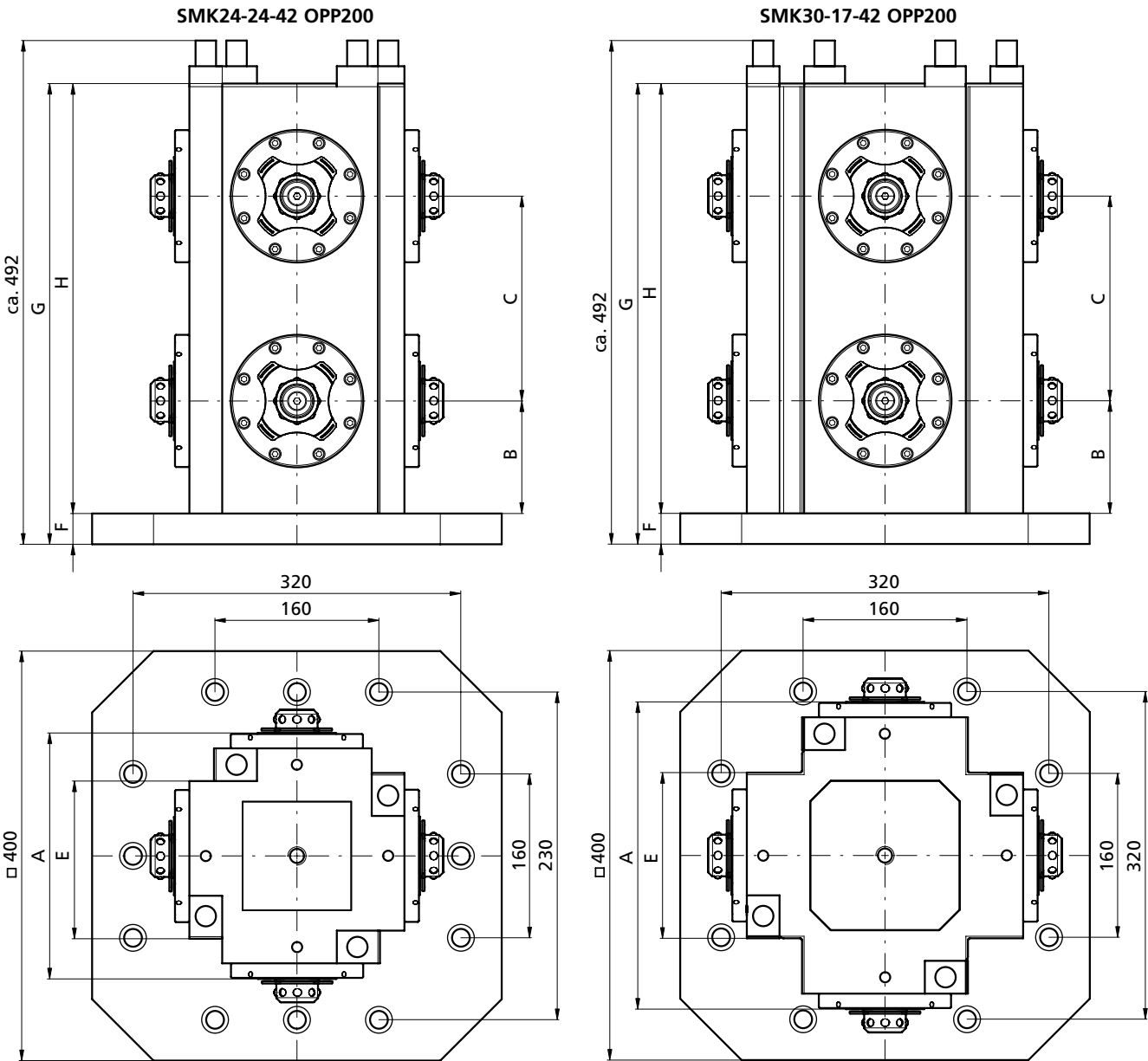
Art. Nr.	kg	Raster / Grid R50
MUB3535H140	~44,1	73 x M12/12F7



Diese Mineralgusserhöhung mit schrägen Basisschienen (PCB50207W27) und einer seitlichen Anordnung weiterer Spannstellen, bietet Ihnen eine Vielzahl an Spannmöglichkeiten.

This epoxy mineral riser with inclined base rails (PCB50207W27) and a lateral arrangement of further clamping points offers you a wide range of clamping possibilities.





Stahl-Mineralguss

Steel-epoxy mineral tombstones

kg

SMK24-24-42OPP200	~120
SMK30-17-42OPP200	~142

andere Höhen auf Anfrage

other heights on request

Seite / Page 250

Bestellbeispiel

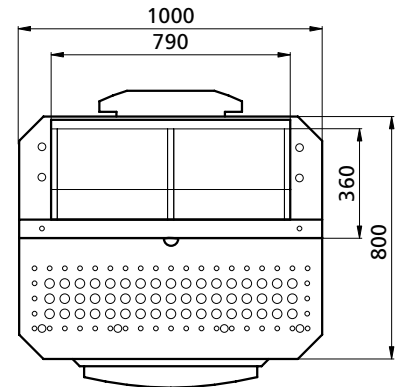
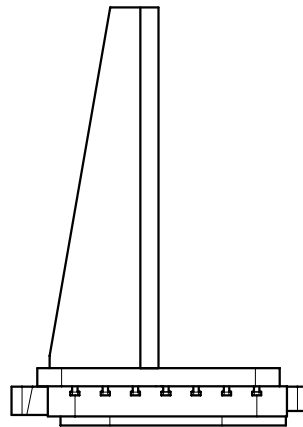
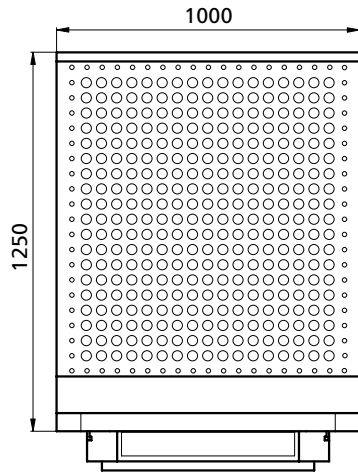
Ordering example: SMK242442OPP-200

	A	B	C	E	F	G	H	Raster / Grid
SMK24-24-42OPP200	240	110	200	166	(30)	(450)	420	OPP-200
SMK30-17-42OPP200	300	110	200	166	(30)	(450)	420	OPP-200

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Stahl-Mineralgusstürme Steel-epoxy mineral tombstones

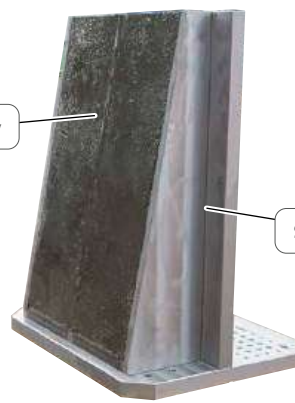
tripoxyMINERAL



Gesamtgewicht
Total weight ~1300kg



Epoxy

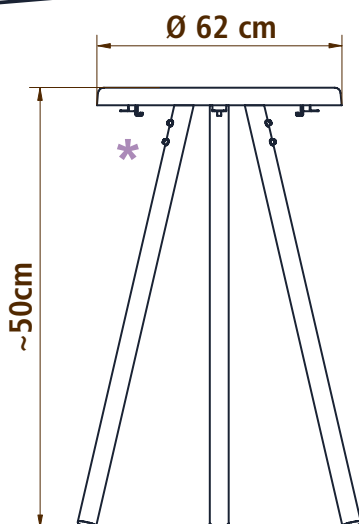


Stahl / Steel



SPECIALS

Beine aus rostfreiem Stahl oder Holz
Legs made of stainless steel or wood



* Inkl. 3x Flaschenöffner / Kleiderhaken
Incl. 3x bottle opener / coat hook



Ihr Logo hier
Your logo here



Salontisch Salon table

Jeder Tisch ist ein Unikat
- Hergestellt aus Schweizer Stein-Granulat

Each table is unique
- Made from Swiss stone granulate

Art. Nr.

MST-TRI-600

Grundplatten für Mineralgusstürme

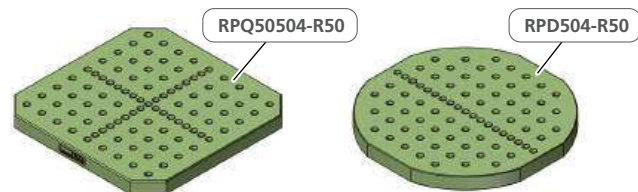
Base plate for epoxy mineral tombstone

	A	B	C	kg
GPL30040	300	300	40	~27
GPL40040	400	400	40	~47
GPL50040	500	500	40	~74
GPL45040	450	450	40	~61
GPL50040040	500	400	40	~58
GPL63040	630	630	40	~120
GPL80040	800	800	40	~195

Rasterplatten für 5AX-Master

Grid plate for 5AX-Master

	A	B	C	Raster / Grid	kg
RPQ50504-R50	500	500	40	M12/12F7	~74
RPD504-R50	Ø 500		40	M12/12F7	~64



Andere Größen auf Anfrage

Other dimensions available on request

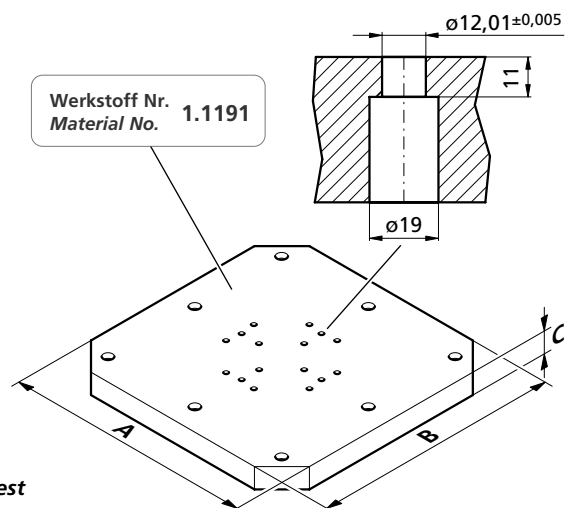
Im Lieferumfang: Schrauben zur Befestigung des Turms, ohne Positionierzapfen und Schrauben maschinenseitig.

The package: Screws for fixing the tombstone, without screws and counter piece to the machine side.

Bohrungen der Grundplatte / Drill holes in the baseplate:

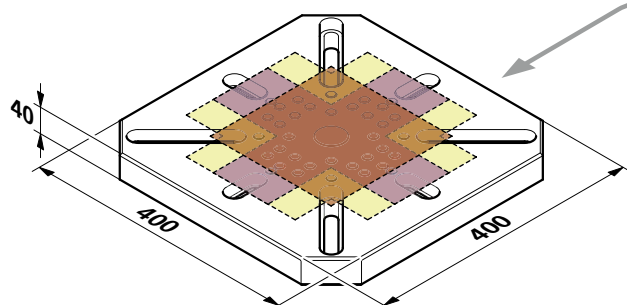
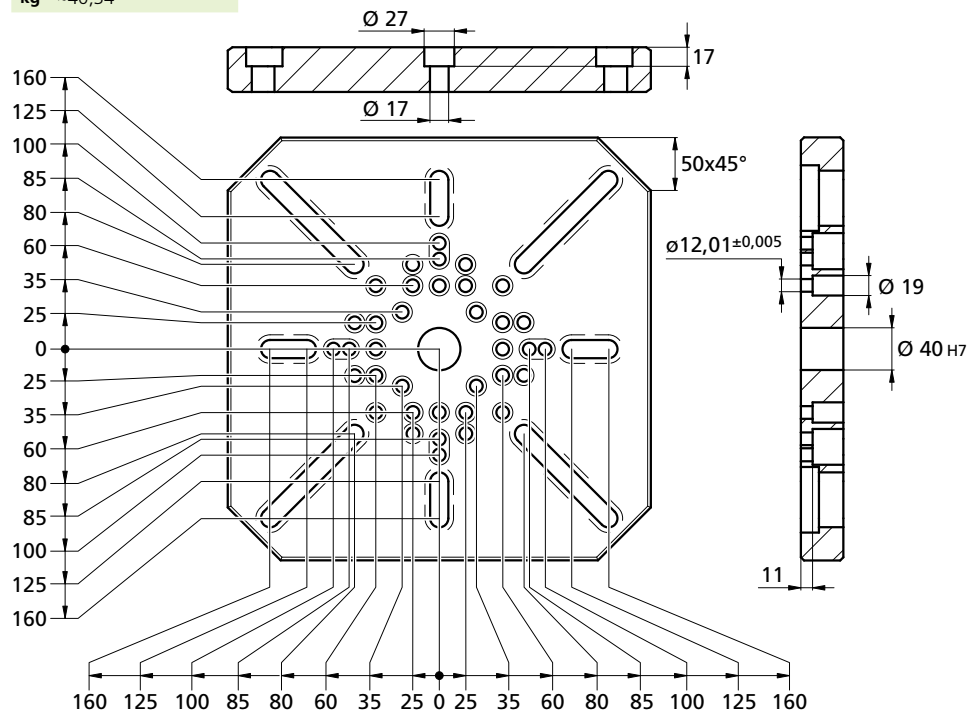
Kundenspezifisch an die Maschine angepasst

Made up to customer's specifications



GPL40040-UV

kg ~40,34



27 verschiedene Mineralgusstürme
passend zu dieser Grundplatte.

27 different Epoxy mineral tombstone
are suitable for this base plate.



MK3009 ... R50



MK3018 ... R50



MQ2020 ... R50

Abdeckbleche zum Schutz der Oberfläche der Mineralgusstürme Cover plates for surface protection of epoxy mineral tombstones

Art. Nr.

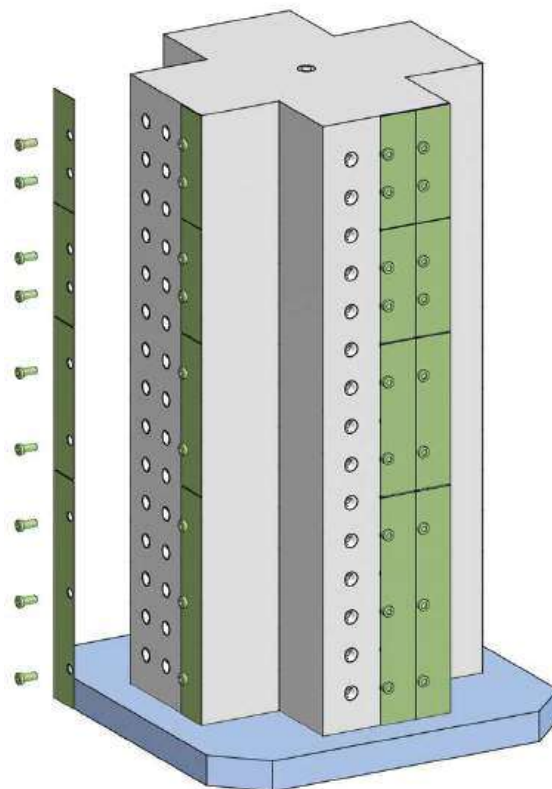
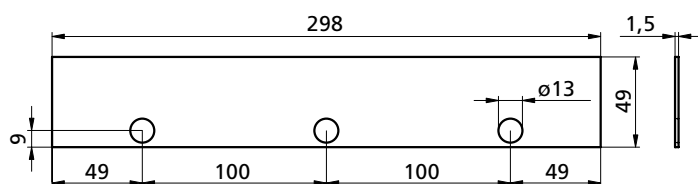
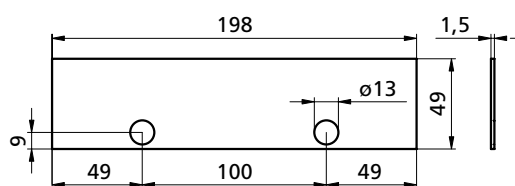
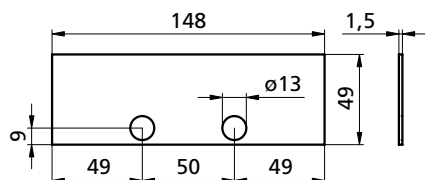
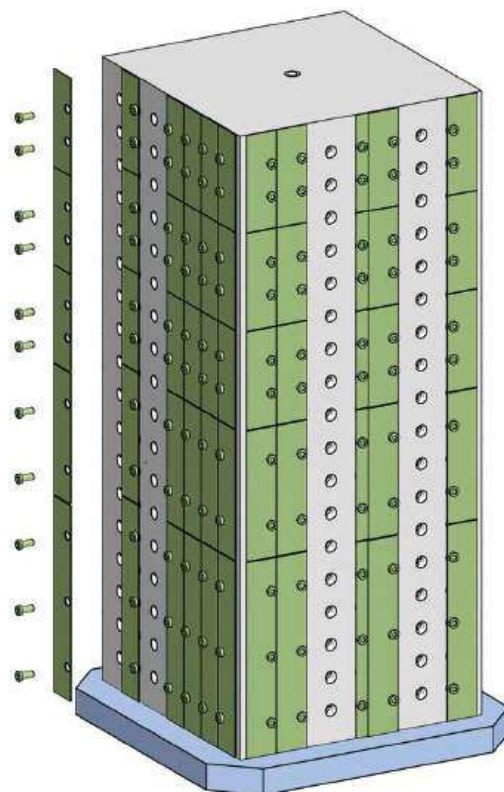
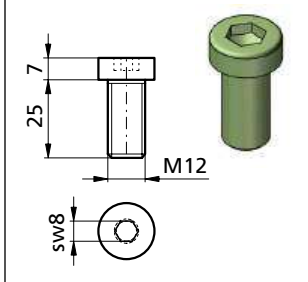
MABD501550

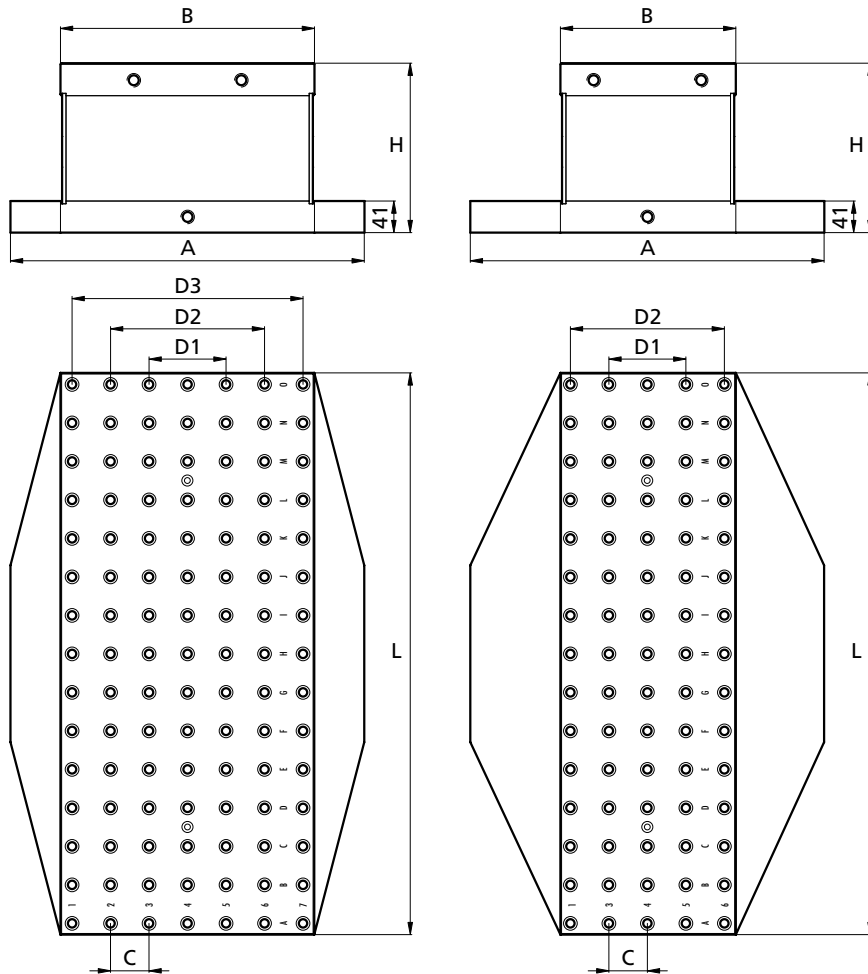
MABD502050

MABD502550

MABD503050

M12X25DIN7984





**Entwickelt für die Luftfahrt.
Gewappnet für höchste
Anforderungen.**

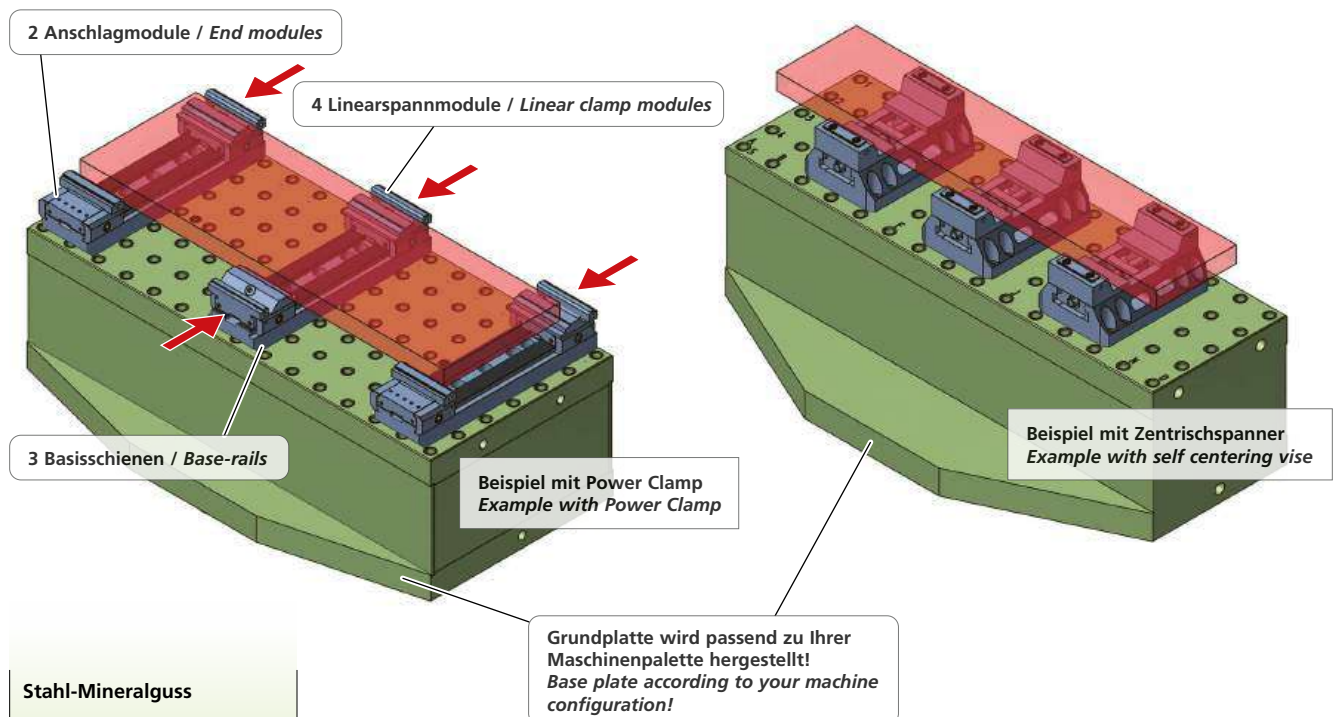
Sehr hohe Vibrationsdämpfung dank Kern aus Mineralguss. Hohe Festigkeit dank Ummantelung aus Stahl. Begünstigt die Gewichtsreduktion wodurch die Maschine geschont wird.

Mit integrierten Vakuum Kanälen erhältlich.

**Developed for aviation.
Prepared for the highest
requirements**

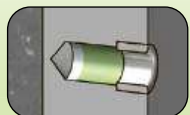
Very high vibration damping thanks to epoxy mineral core. High strength thanks to the coat made of steel. Supports weight reduction which protects the machine.

Risers can be made with integrated vacuum channels.



Stahl-Mineralguss

Steel-epoxy mineral
tombstones



kg

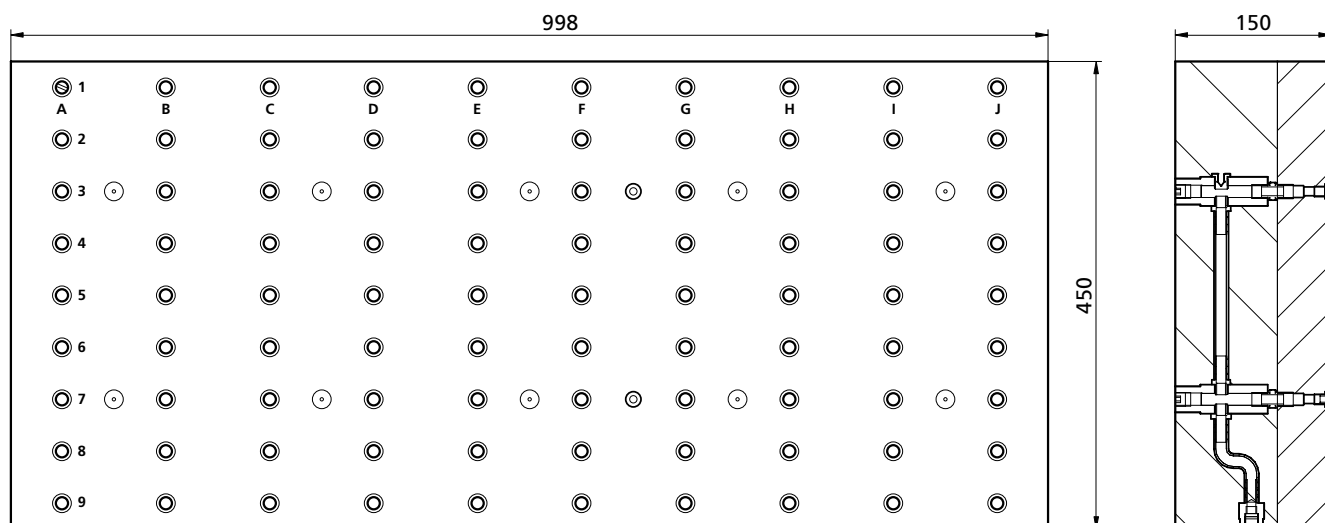
Bestellbeispiel

Ordering example: **SMUB2373H220**

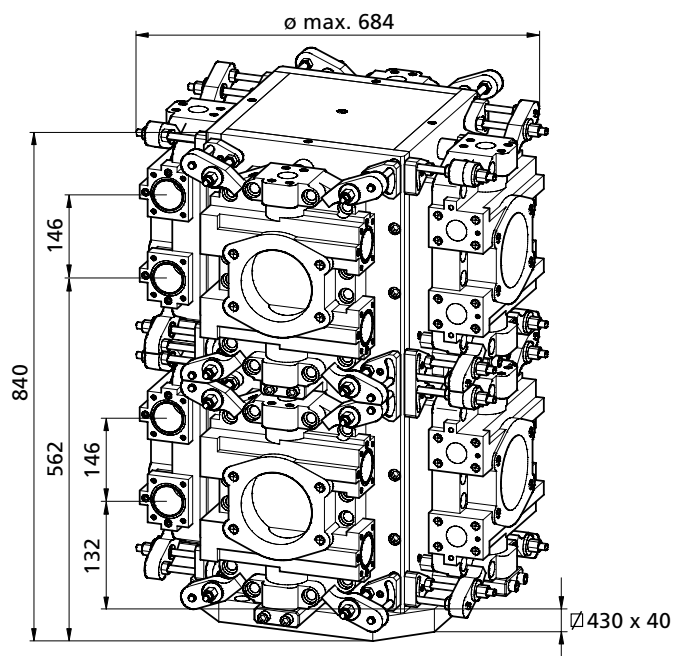
		A	B	C	D1	D2	D3	H	L	Raster / Grid
SMUB2373H220	~168,0	460	230	50	100	200		220	730	75 x M12/12F7
SMUB3373H220	~214,4	460	330	50	100	200	300	220	730	105 x M12/12F7

Stahl Mineralgusserhöhungen mit integriertem Vakuum Anschluss Steel-epoxy riser with integrated vacuum

tripoxyMINERAL



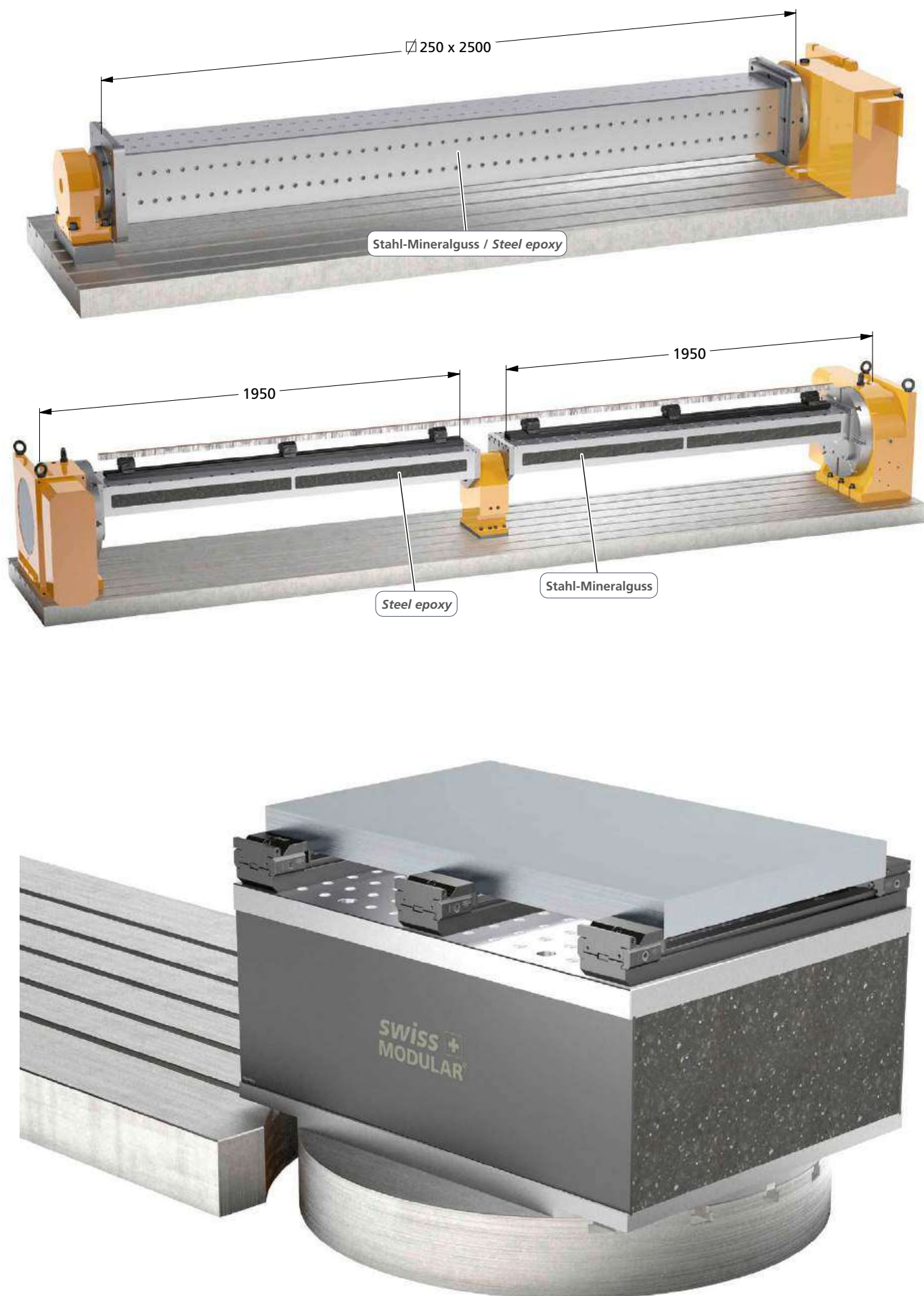
Stahl-Mineralguss
Steel-epoxy mineral tombstones



Gesamtgewicht
Total weight
~600 kg

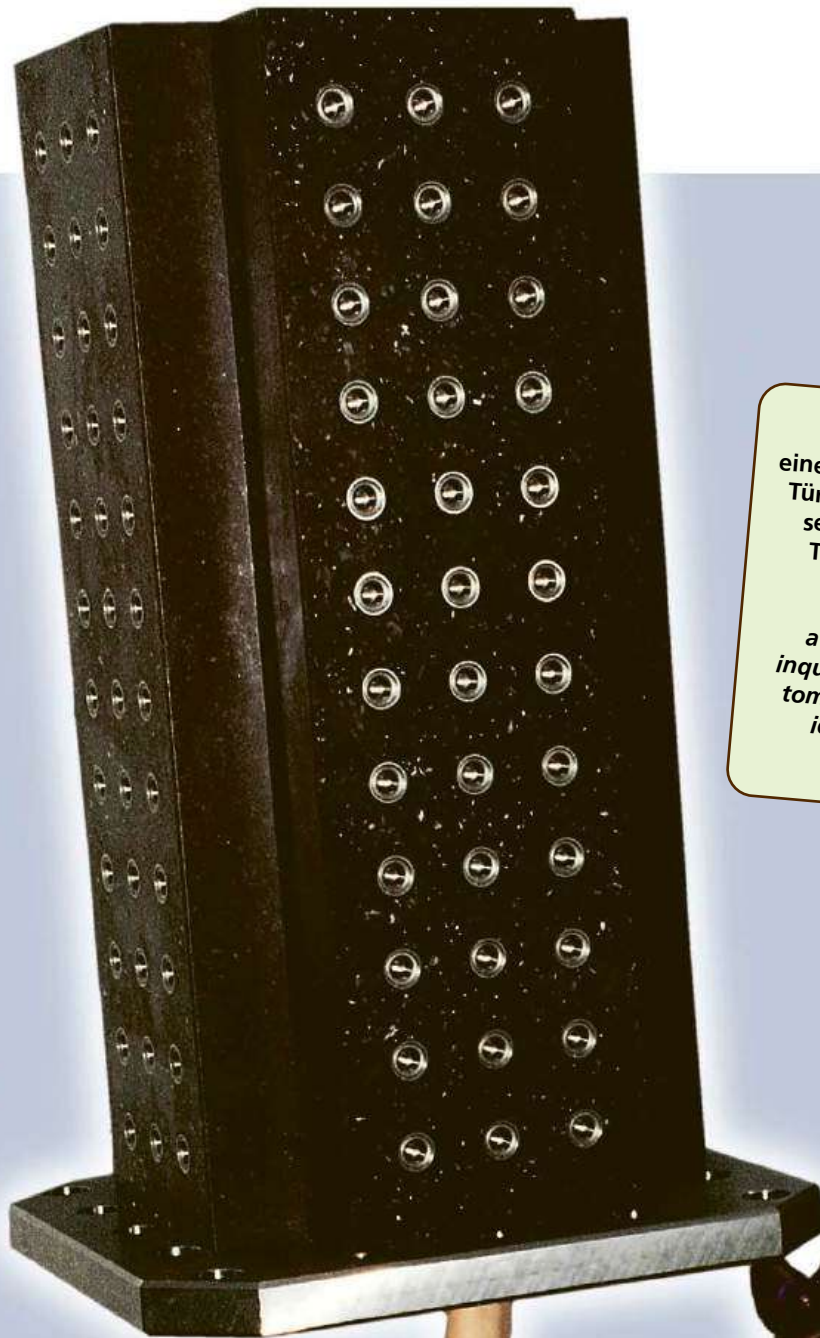
~38 kg





Mineralgusstürme seit
Epoxy tombstones since

1998



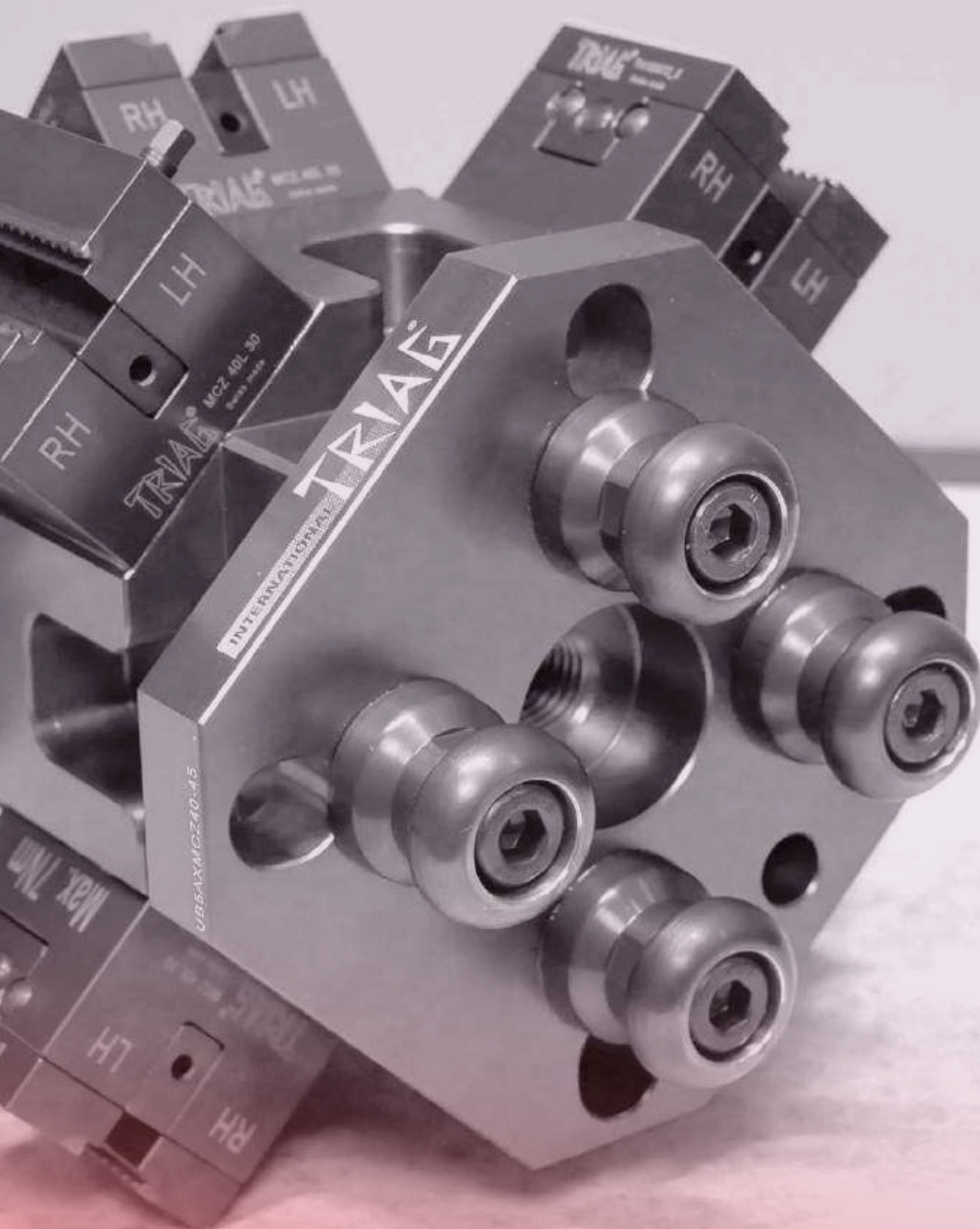
Beat Baumgartner erhält von einem Kunden eine Anfrage für leichte Türme, die aber nicht aus Aluminium sein dürfen. Er hat die Idee, einen Turm aus Mineralguss zu bauen.

Beat Baumgartner receives a request from a customer who inquires about light, non-aluminium tombstones. He comes up with the idea to build a mineral epoxy tombstone.





oppSYSTEM & **5axes**





Einleitung | *Introduction* 281 - 283

Anwendungsbeispiele | *Examples of application* 284 - 285

Mechanisches Nullpunktsystem mit diversen Spannlösungen
Mechanical zero point system with different workholding solutions 286

0-Punkt Schnellwechselsystem | *Mechanical zero point system* 287



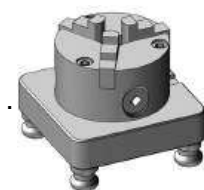
4-Achs Lösungen für mechanische 0-Punkt Schnellwechselsysteme
4-axis solution for mechanical 0-point quick change systems 288



0-Punkt Erhöhung & Ausrichtplatte
Zero point riser & Alignment plate 289



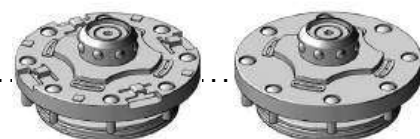
Dreibackenfutter | *Three-jaw chuck* 290



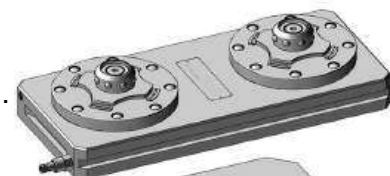
Klemmbüchse | *Clamping-case* 291



Zentriereinheit | *Chuck unit* 292



Palettenträger | *Receiver chuck with chucks* 293



MTS Palettier-System | *MTS palleting system* 297 - 300

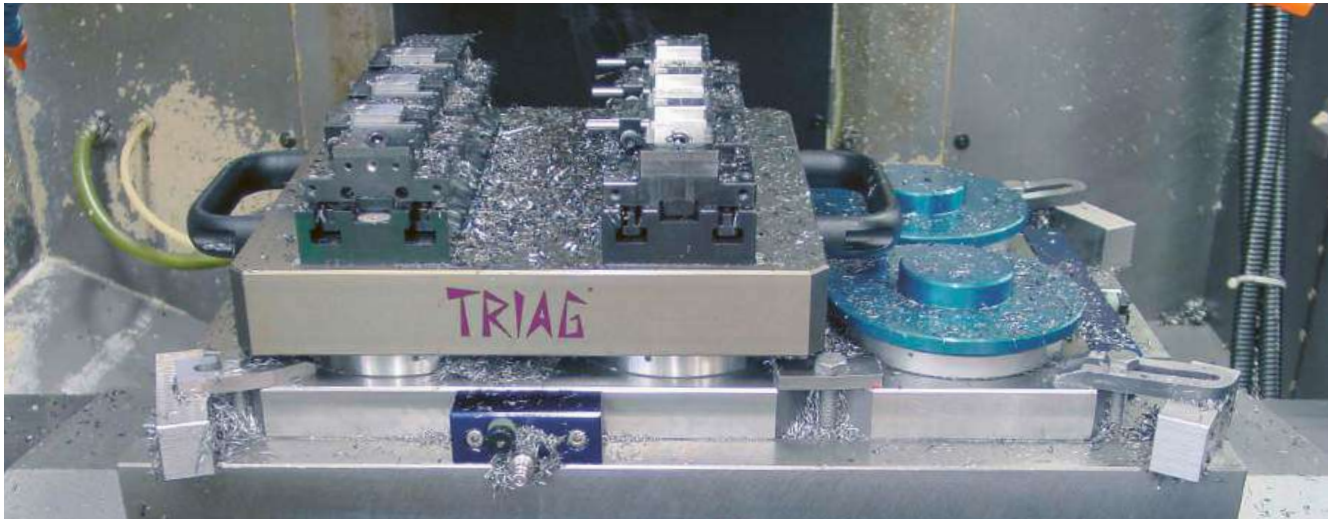


Zubehör | *Accessoires* 301



Nullpunkt-Palettiersystem

Zero-point palleting system



In den letzten Jahren wurden die Werkzeugmaschinen viel leistungsfähiger. Damit wurden die Bearbeitungszeiten wesentlich kürzer. Aufgrund der vom Auftraggeber verlangten Lieferzeiten „just in time“ sind aber die Losgrößen geringer geworden, was zu vermehrten Einrichtzeiten führt.

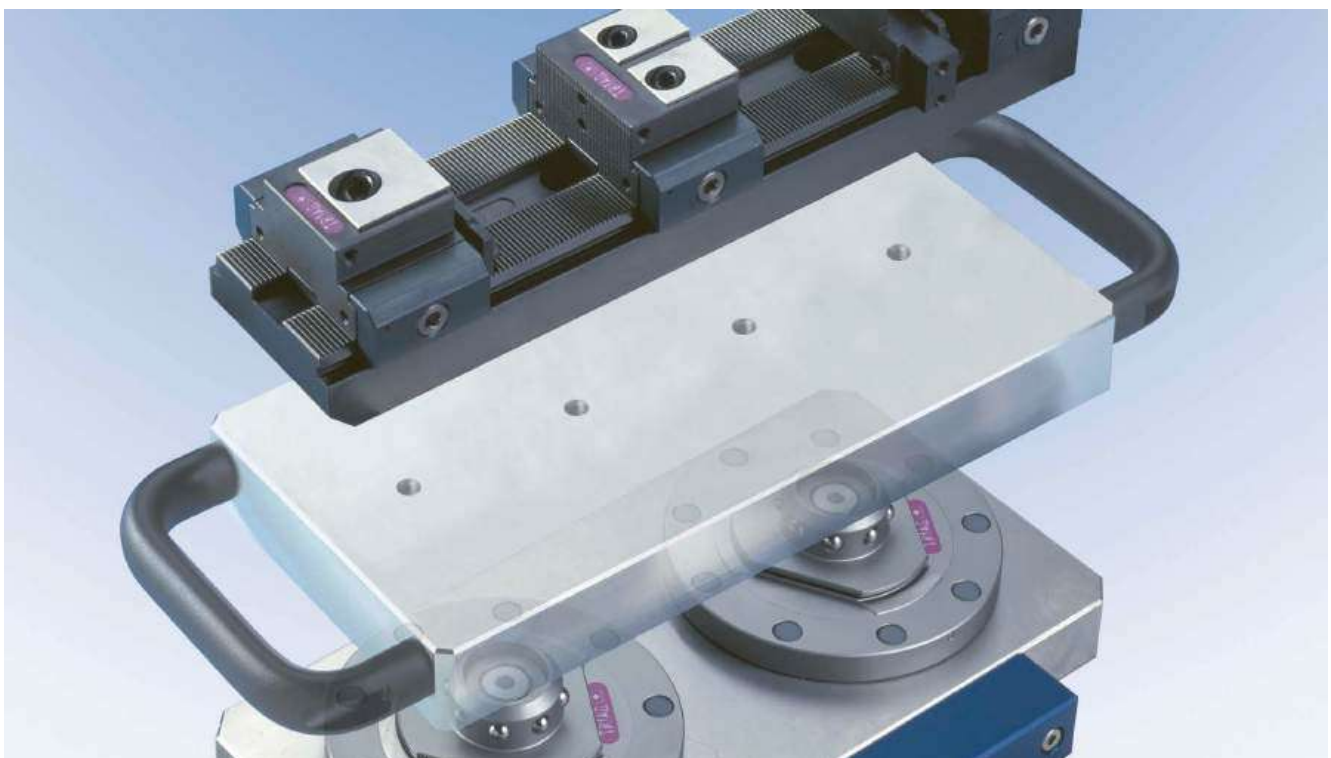
The productivity of modern machining centers has been drastically increased over the past years. Hence the time per workpiece is falling. On the contrary the batch sizes are getting smaller due to the increasing trend to „just in time“ production.

Auch die technisch hochentwickelten Maschinen sind jedoch immer noch mit einem T- Nuten Tisch ausgerüstet. Die Befestigung und das Ausrichten des zu bearbeitenden Werkstückes auf dem T-Nutentisch kann nur während der (teuren) Maschinen-Stillstandszeit erledigt werden. Diese Unproduktivität kumuliert sich, wenn die Werkstückbearbeitung mehrere Maschinenprozesse und somit mehrmaliges Befestigen und Ausrichten erfordert.

This means that the machine must be set up more frequently. Is the machine not equipped with a pallet changer, the set up and the changing of workpieces may only be accomplished during the stand still of the machine. This idling of the machine results in the loss of costly productive machine time. As it is, the aim of any machining facility to keep the spindle turning, the unproductive time must be minimized. As any machinist knows, the set up and alignment of workpieces on a T-slot table is very awkward and time consuming.

Die Lösung, die wir Ihnen für dieses Problem bieten, ist unser neuartiges, modulares Palettiersystem, das oppSystem.

The TRIAG opp (Zero-Point-Palleting) System represents an ideal interface between machining table and workholding device.



Das System besteht aus dem auf dem Maschinentisch der Werkzeugmaschine montierten Palettenträger und mindestens zwei Paletten oder mit Zentrier- und Klemmbüchsen ausgestatteten Werkstückträgern. Die sehr präzise gefertigte Schnittstelle zwischen dem Palettenträger und der Palette ermöglicht ein sekundenschnelles Ein- und Auswechseln der Paletten, auf welcher ausserhalb der Werkzeugmaschine das zu bearbeitende Werkstück montiert und positioniert wird. Es wird eine sehr hohe Ausnutzung der theoretisch zur Verfügung stehenden Maschinenlaufzeit erreicht. Dies erhöht die Produktivität der Maschine und damit die Wirtschaftlichkeit des ganzen Betriebes.

Im Gegensatz zu vielen anderen Palettiersystemen auf dem Markt ist die Dimension des oppSystems in Form von Stichmassen genormt und richtet sich damit nach den individuellen Werkstückdimensionen. Die patentierte Konstruktion erlaubt überdies auch die unbemannte Be- und Entladung mit Hilfe eines Beschickungsgerätes.

Mit dem oppSystem sind 750'000 Spannungen ohne Referenzverlust möglich, bei einer Repetiergenauigkeit von $\pm 0,002$ mm. Das Lösen erfolgt pneumatisch mit ca. 6 bar, womit keine Mehrkosten für Hydraulikaggregate entstehen. Eine allfällig entstehende Wärmeausdehnung wird über die federnde Zentrierung kompensiert. Alle wichtigen Bauteile sind wartungsarm, leicht zu überprüfen und im Bedarfsfall einfach auszutauschen.

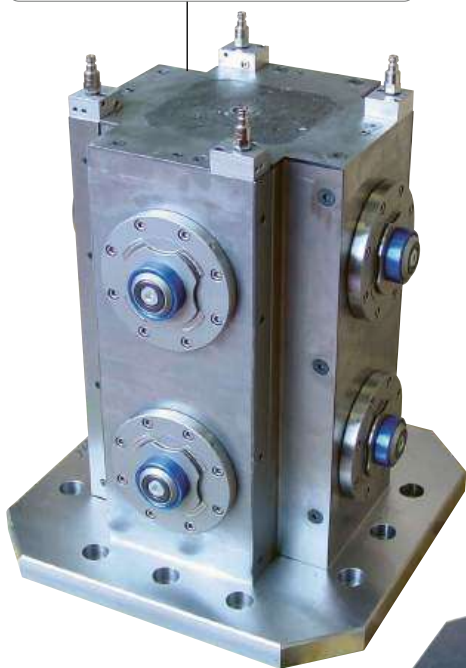
On the machine table the receiver chuck is installed. This chuck may consist of one, two, four, six or more receiver units. Onto these air operated receiver chucks a pallet, a fixture or a vice is mounted within a matter of seconds. On the bottom surface of the workholding devices centering rings are inserted. These centering rings are ground to a very high accuracy permitting the locking down of the workholding device with a repeatability of ± 0.002 mm on all three axes. The chucks are locked by spring force and unlocked by compressed air of 6 bar. This means that no hose connection is necessary during machining. Hydraulic pumps or hydraulic amplifiers are superfluous.

The patented oppSystem allows for 750'000 locking and unlocking cycles without loss of positioning accuracy. If necessary, the changing of the pallet may be accomplished by a robot or a handling system. Thermal expansion is compensated for by the spring loaded centering units.

Due to the unique oppSystem it is possible to bring the loading and unloading of the actual workpiece out of the machine which guarantees a maximum of productive machine time. Maintenance is simple as all components are easily accessible and replaceable. There are standard receiver chucks and pallets available with two or four receiver units. For other solutions or dedicated fixture you should contact TRIAG or your nearest dealer.

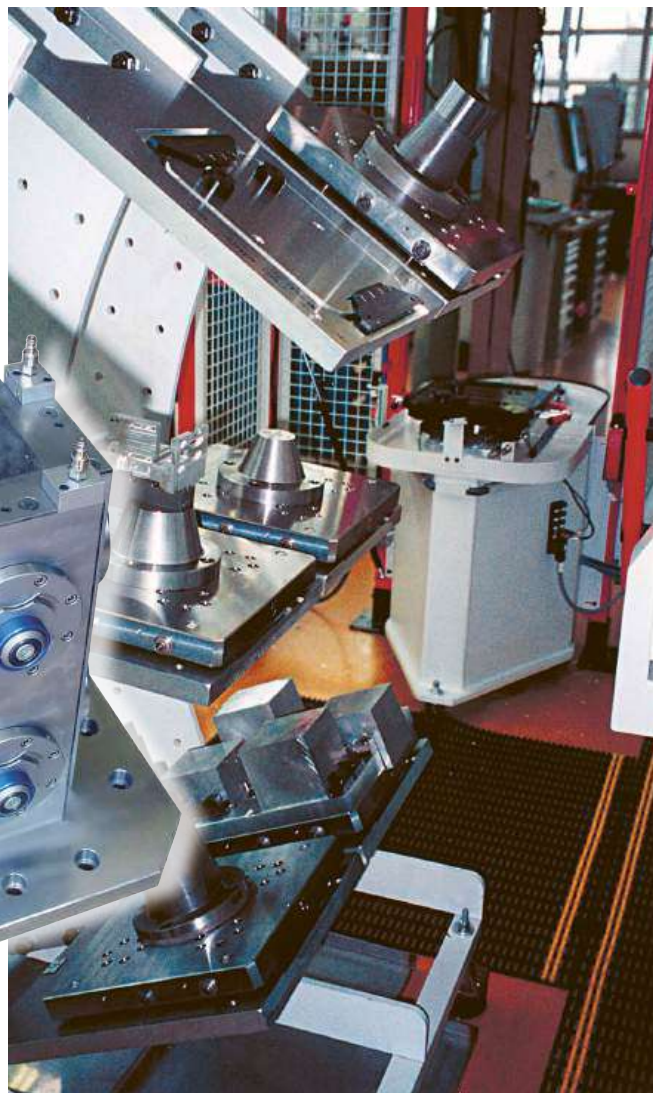
SMK30-17-42 OPP200

~ 142 kg



SMK24-24-42 OPP200

~ 120 kg



Nullpunkt-System OPP & Erowa MTS

In Verbindung mit dem Spannsystem powerCLAMP bilden die Nullpunkt-Paletten oppSysteme sehr kompakte, hochgenaue und schnell wechselbare Spannvorrichtungseinheiten.

Zentrischspanner mit OPP-Anschluss

Das neue mechanische 0-Punktsystem (**OPBM4Q100R50**) findet seine Einsatzmöglichkeiten in allen Bereichen.

Von der einfachen Schnellwechselpalette zur Einzelteilmontage bis hin zur Mehrfachspannung in modernen Fräszentren.

Dank der hohen Wiederholgenauigkeit lassen sich Grossserien problemlos und in höchster Genauigkeit fertigen.

Zero-point system OPP & Erowa MTS

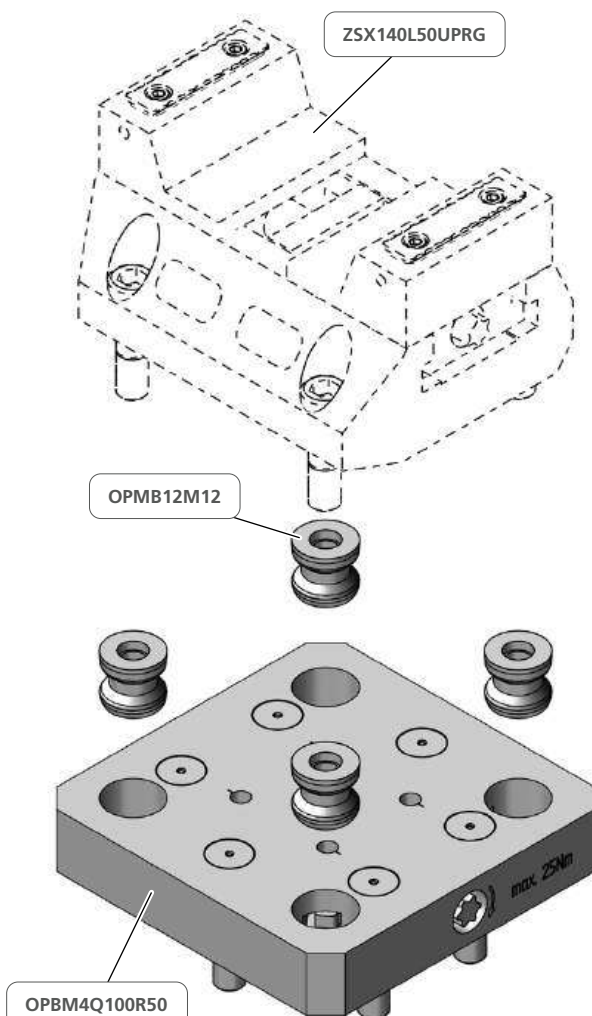
Together the modular system with zero point pallets, give a great performance! Fast changing and accurate!

Self centering vise with integrated zero point adaptation OPP

Because of its compact build body this self centering vise gives a perfect performance to automated 5 axis machines!

The index zero point system is built into the body of the vise, a sub pallet as you normally mount the vises!

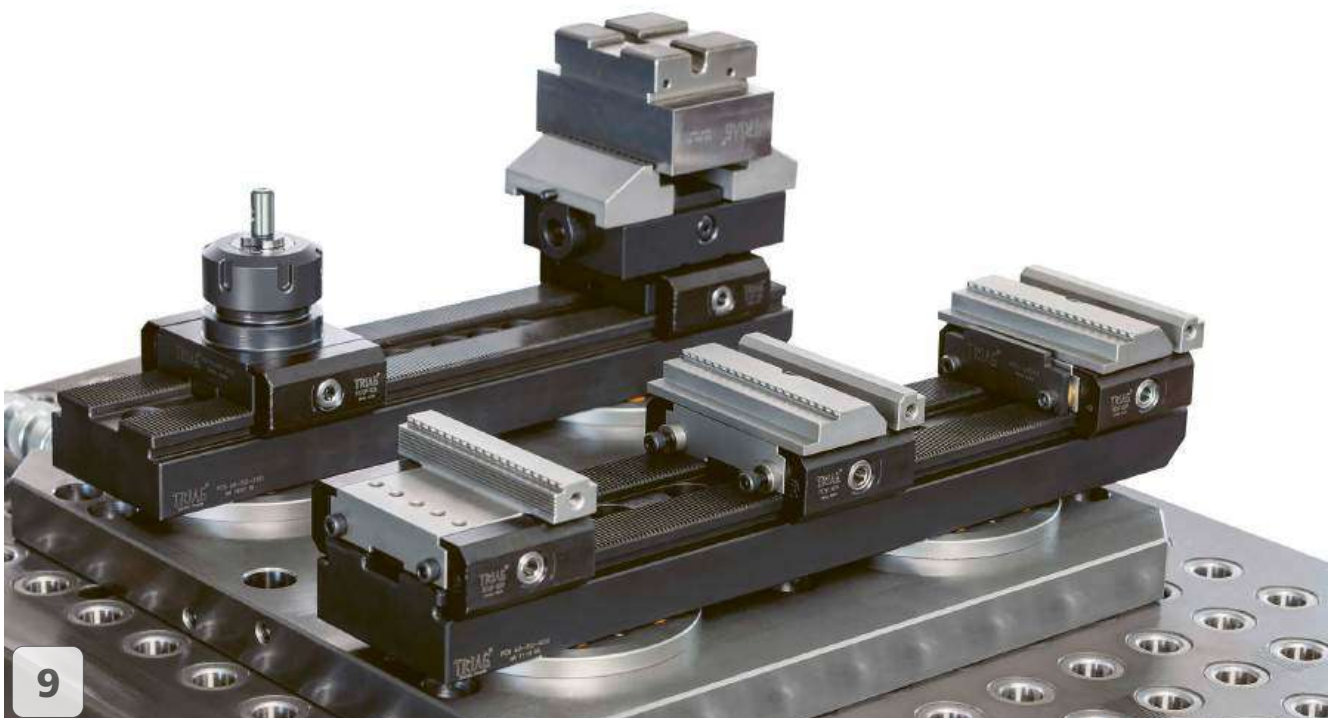
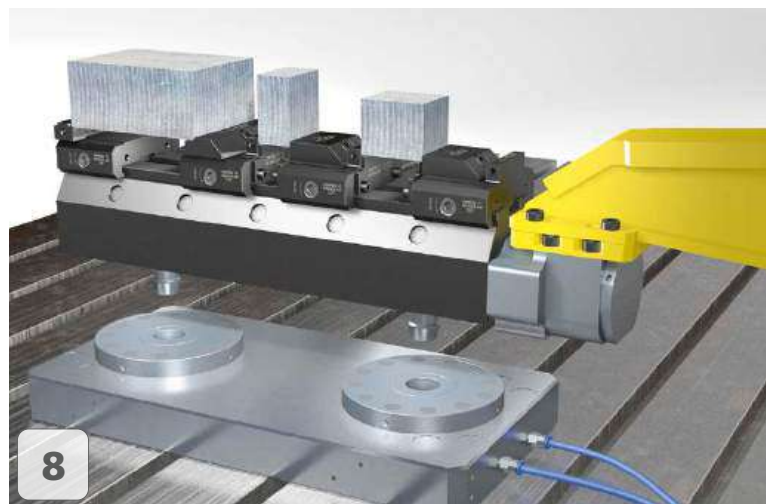
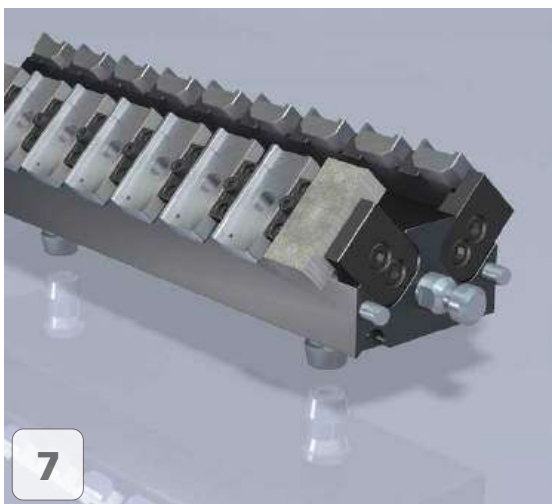
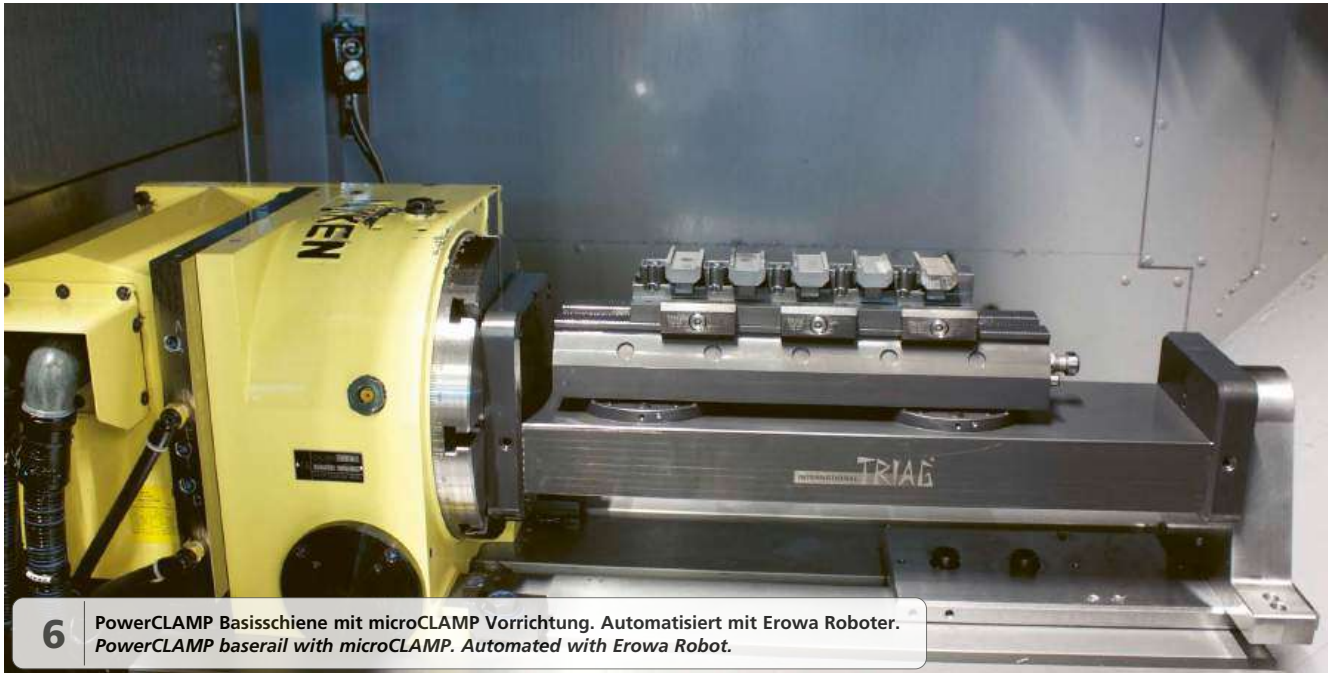
The OPP system is a very accurate system reliable and durable! We guarantee 150'000 changes within $\pm 0,002\text{mm}$





HORIZONTAL





Mechanisches Nullpunktsystem mit diversen Spannlösungen

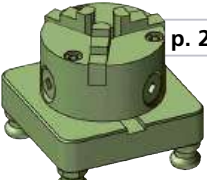
Mechanical zero point system with different workholding solutions

Da die Anforderungen an „just in time“ Produktion in den letzten Jahren stetig gewachsen sind, ist ein modulares Nullpunkt Schnellwechselsystem der richtige Weg um lange Standzeiten der Werkzeugmaschine zu verhindern.

Since the requirements for „just in time“ production have grown steadily in the recent years, a modular zero-point quick-change system is the right way to prevent long down time of a machine tool.

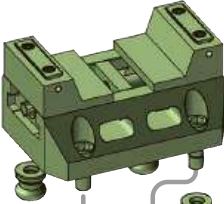
- ✓ **Sehr tiefe Bauhöhe (28 mm)**
- ✓ **Wiederholgenauigkeit 0.01 mm**
- ✓ **6000 dAN Haltekraft**
- ✓ **Abhebefunktion ein- und ausschaltbar (3-4 mm)**

- ✓ **Very low height (28mm)**
- ✓ **Repeat accuracy of 0.01mm**
- ✓ **6000daN holding force**
- ✓ **Lift-off function can be switched on and off (3-4 mm)**



p. 290

1 Erhältlich in 3 versch. Größen
Available in 3 sizes
Ø 80 / 100 / 125



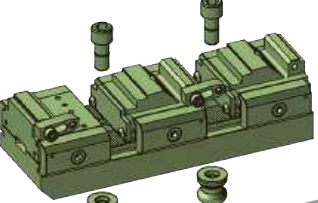
triCENTRO p. 141

140x120x83
Erhältlich in 4 versch. Größen
Available in 4 sizes
140x120x83 / 160x120x83
180x120x83 / 200x120x83



triCENTRO p. 119

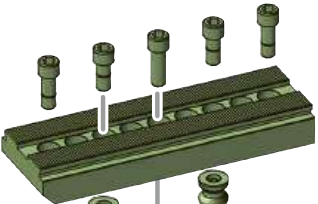
3 Ø176, H=129



4 250x80x35



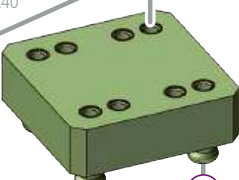
5 220x80x35



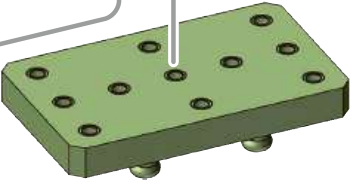
6 250x80x35



7 148x148x4



8 150x150x44



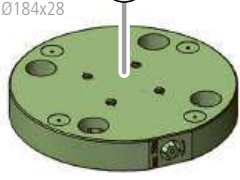
9 250x150x28
R100/M12/12F7



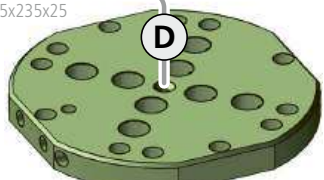
A 150x150x28



B 172x172x28



C Ø184x28



D 235x235x25

0-Punkt Basis / 0-point base kg

A	OPBM4Q100R50	~3,8
B	OPBM4Q100R200	~7,6
C	OPBM4Q100D184	~7,6
D	ZF211785	~7,6

3-Backenfutter / 3-jaw chuck kg

	OPM3X80L75	~5,8
1	OPM3X100L82	~7,3
	OPM3X125L88	~9,5

**Zentrischspanner
Self centering vise**

2	ZSX140L50UPRG-OPM	62-118	~7,1
	ZSX160L50UPRG-OPM	62-138	~7,7
	ZSX180L50UPRG-OPM	62-158	~8,1
	ZSX200L50UPRG-OPM	62-178	~8,8

spaceGRIP I kg

3	UB5AXMCZ4045SET8-OPBM	~6,2
---	-----------------------	------

PowerCLAMP Set kg

4	PCSET18250-OPM	
	1x PCSET18-250A / 03	~5,9
	2x PCSET18-L1 / B48-20	~2,65

Basisschiene diagonal / Baserail diagonal kg

5	PCSET18220W2-OPM	~8,2
---	------------------	------

PC Schiene / PC Rail 250 mm kg

6	PCB2550250-OPM	~4,8
---	----------------	------

Abdeckung / Cover kg

7	OPMAD	~0,8
---	-------	------

Erhöhung / Raiser block kg

8	OPUB150H44	~8,5
---	------------	------

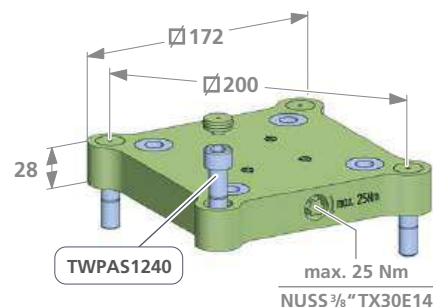
Rasterplatte / Grid plate kg

9	OPM25-15R50H28	~7,7
---	----------------	------

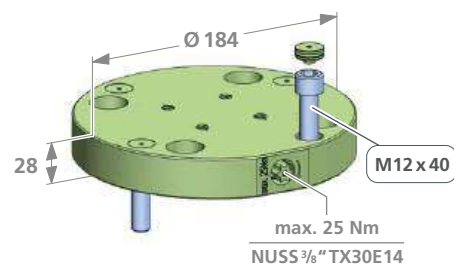
Aluminiumplatte / Aluminium plate kg

10	OPM25-15RH40	~4,3
----	--------------	------

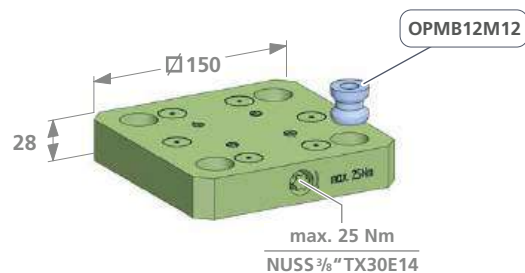
Art. Nr.	kg
OPBM4Q100R200	~4,3



Art. Nr.	kg
OPBM4Q100D184	~4,7

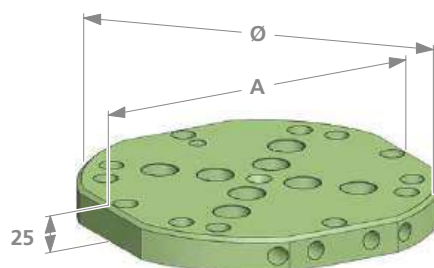


Art. Nr.	kg
OPBM4Q100R50	~3,8



Positionier-Flansch Positioning-flange

Art. Nr.	A	Ø	kg
ZF211785	235	250	~7,6
ZF222333	172	180	~3,7



Die Verbindung zwischen Maschinentisch
und dem opp-Schnellwechselsystem
The connection between the machine table
and the opp-quick-change system

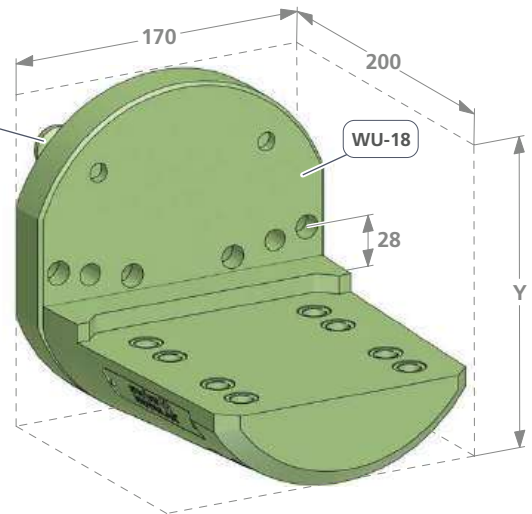
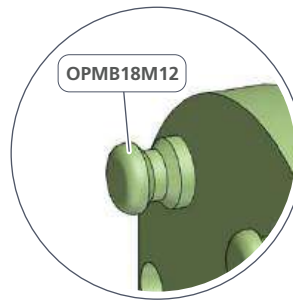
4-Achs Lösung für mechanische 0-Punkt Schnellwechselsysteme

4-axis solution for mechanical 0-point quick change systems

oppSystem

Winkel für die 4-Achse
Angle for the 4-axis

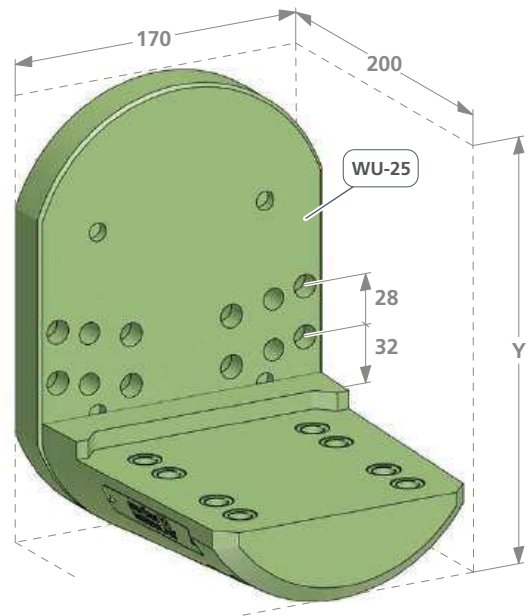
Art. Nr.	Y	kg
WU-18	180	~14,1
WU-25	244	~16



Flansch / Flange
Optional erhältlich
Optional accessory



OPBM4Q100R50



ZSX140L50UPRG

Bei diesen Winkeln kann die Brücke für die Aufnahme der Spannmittel inklusive Werkstücke in der Höhe angepasst werden.

With these angles, the bridge can be adjusted in height to accommodate the clamping devices including workpieces.

0-Punkt Erhöhung & Ausrichtplatte Zero point riser & Alignment plate

oppSystem

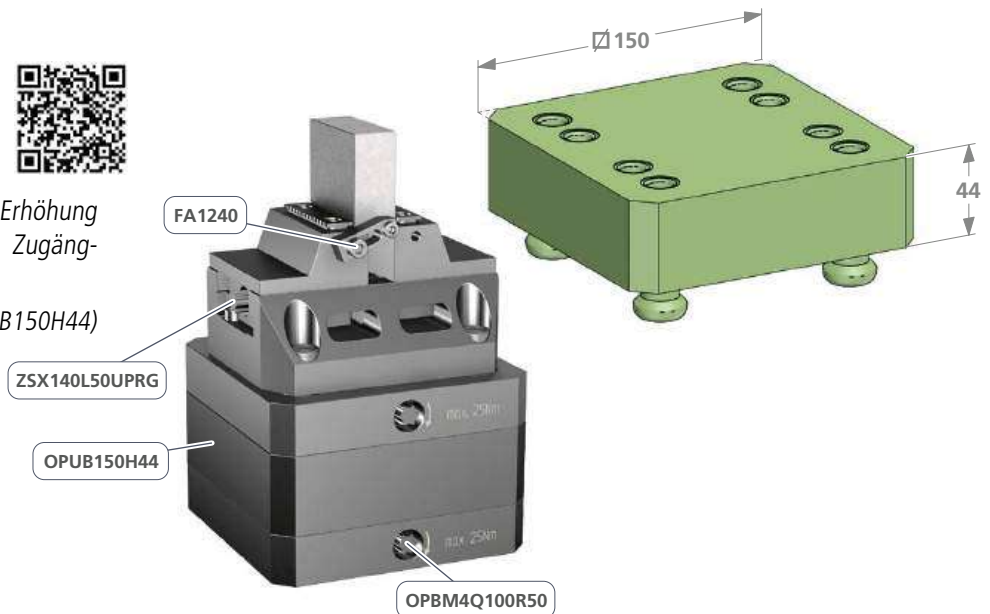
0-Punkt Erhöhung Zero point riser

Art. Nr.	kg
OPUB150H44	~8,5



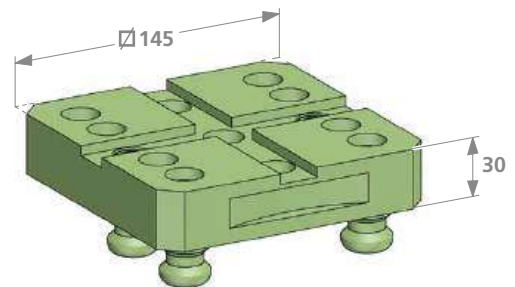
Optimal kombinierbar mit der Erhöhung (OPUB150H44) für eine bessere Zugänglichkeit zum Werkstück.

Ideally combined with the riser (OPUB150H44) for better access to work piece.



Ausrichtplatte Alignment plate

Art. Nr.	kg
OPMAW	~3,54



Diese Platte dient zum Ausrichten auf dem T-Nutentisch.

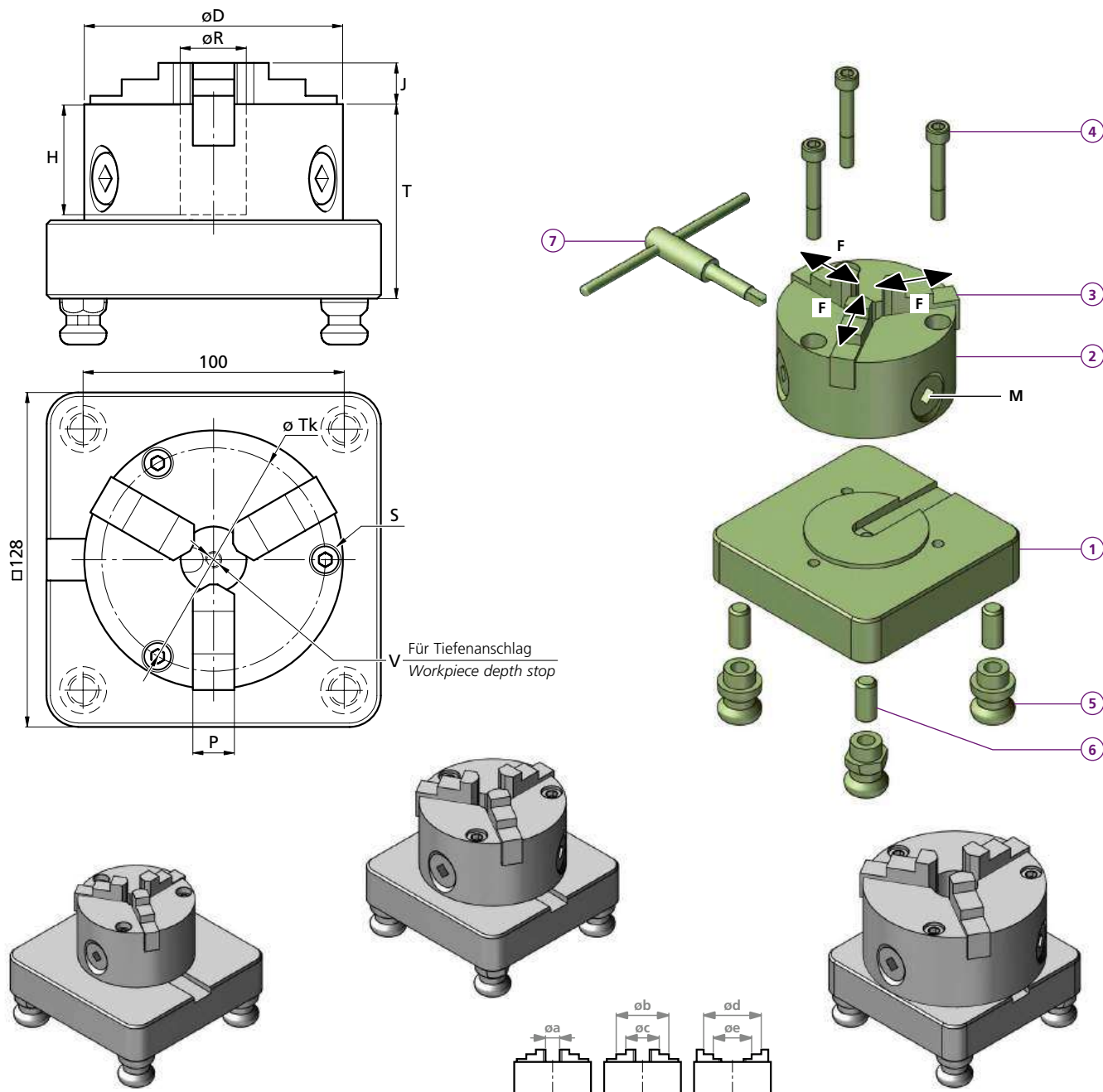
This plate is used to align on the T-slot table.

Nullpunkt Zentrier- und Klemmbolzen Zero point pull studs			Nullpunkt Schwertbolzen Diamond pull studs		Klemmbolzen mit Untermass Pull studs with minus tolerance		Schutzbolzen Protection bolts	
	kg ~0,09		kg ~0,1	kg ~0,1		kg ~0,1	kg ~0,08	kg ~0,07
	OPMB18M12L		OPMB18M12	OPMB18M12S		OPMB18M12U	OPMBL	OPMBL-25
Zentrierbolzen für / Centring pin for PC(M)T & MUB p. 53 - 270 			kg ~0,06	kg ~0,06		kg ~0,06		
			OPMB12M12	OPMB12M12S		OPMB12M12U		

Dreibackenfutter Three-jaw chuck

OPM3X80L75
OPM3X100L82
OPM3X125L88

oppSystem

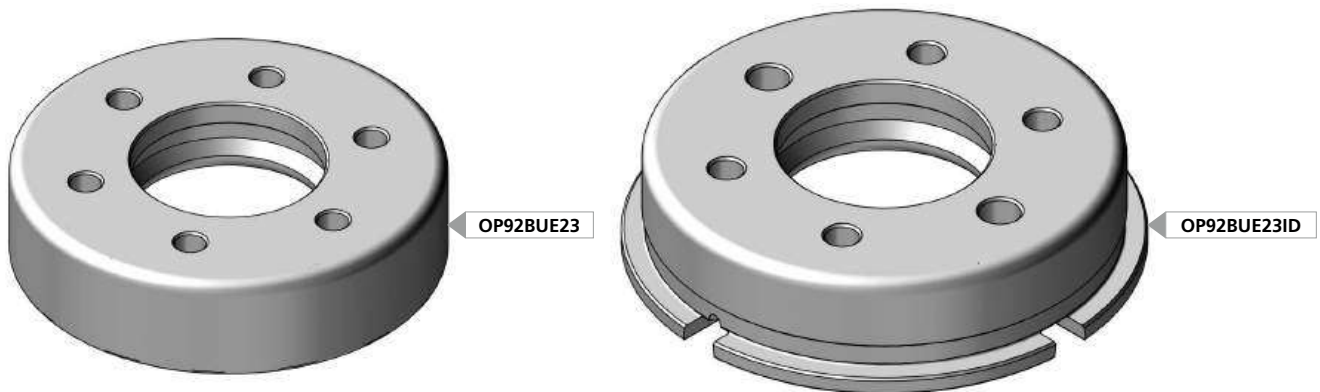


	D	J	T	R	H	P	V	a mm	b mm	c mm	d mm	e mm	M (max.)	F (max.)	ø Tk	S
OPM3X80L75	80	13	75	15	42,5	10	M6	3...27	48...73	23...48	52...76	27...51	28 Nm	1300 daN	67	M6
OPM3X100L82	100	17	82	20	49,5	14	M8	3...39	58...94	24...60	64...100	30...66	38 Nm	1600 daN	83	M8
OPM3X125L88	125	19	88	32	55	16	M8	3...49	70...116	30...75	83...125	38...84	55 Nm	2600 daN	108	M8

OPM3X80L75	OPM3X100L82	OPM3X125L88	
1x TB161207	1x TB161208	1x TB161209	Ø 80
1x 243809.0083220	1x 243809.0103220	1x 243809.0123220	Ø 100
2x 3 Stk. / pcs	2x 3 Stk. / pcs	2x 3 Stk. / pcs	Ø 125
3x TN100346	3x TN100360	3x TN100361	243849.0083200
1x OPMB18M12	1x OPMB18M12	1x OPMB18M12	243850.0083200
2x OPMB18M12U	2x OPMB18M12U	2x OPMB18M12U	243850.0103200
1x OPMB18M12S	1x OPMB18M12S	1x OPMB18M12S	243850.0123200
4x TN100067	4x TN100067	4x TN100067	243849.0123200
1x 243864.0080000	1x 243864.0100000	1x 243864.0120000	3x
kg ~ 5,8	kg ~ 7,3	kg ~ 9,5	Ø 3 - 49
			Ø 38 - 125
			3x *Weich Soft 16MnCr5

Bestellbeispiel / Ordering example: OPM3X80L75

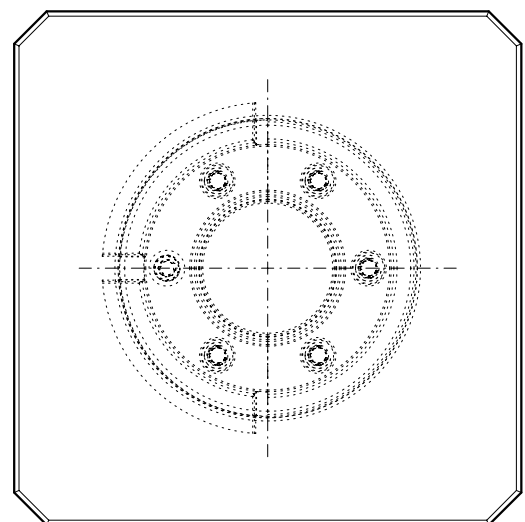
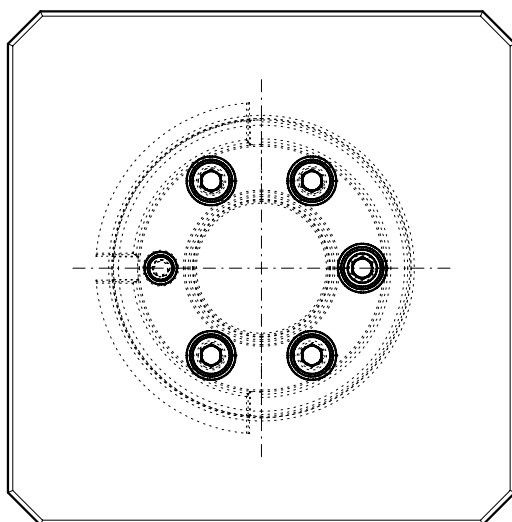
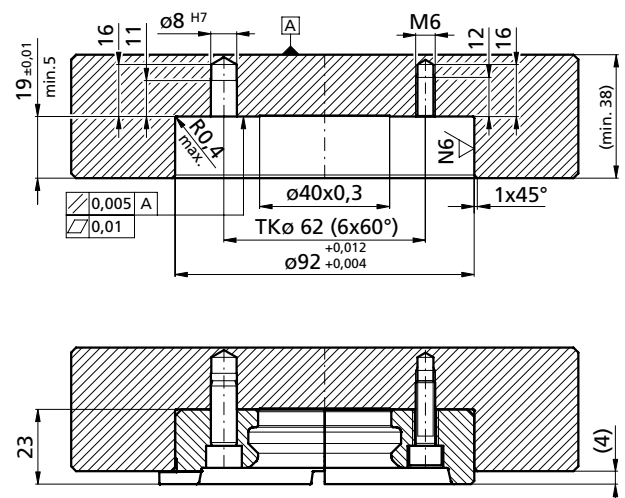
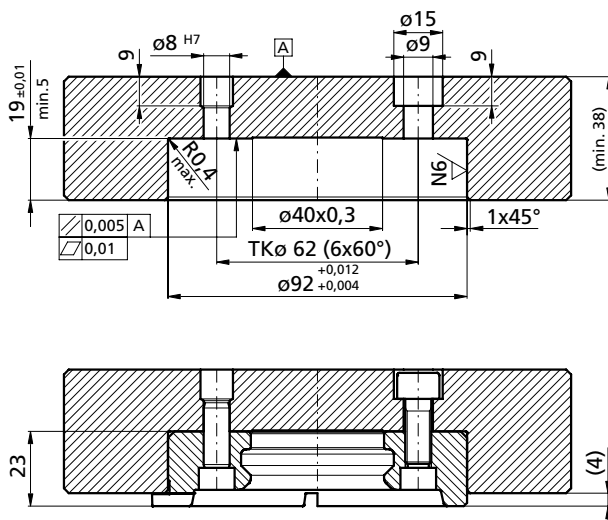
Separat bestellen / Order separately



	kg
OP92BUE23	~0,75
OP92BUE23ID	~0,78

Bestellbeispiel / Ordering example: **OP92BUE23**

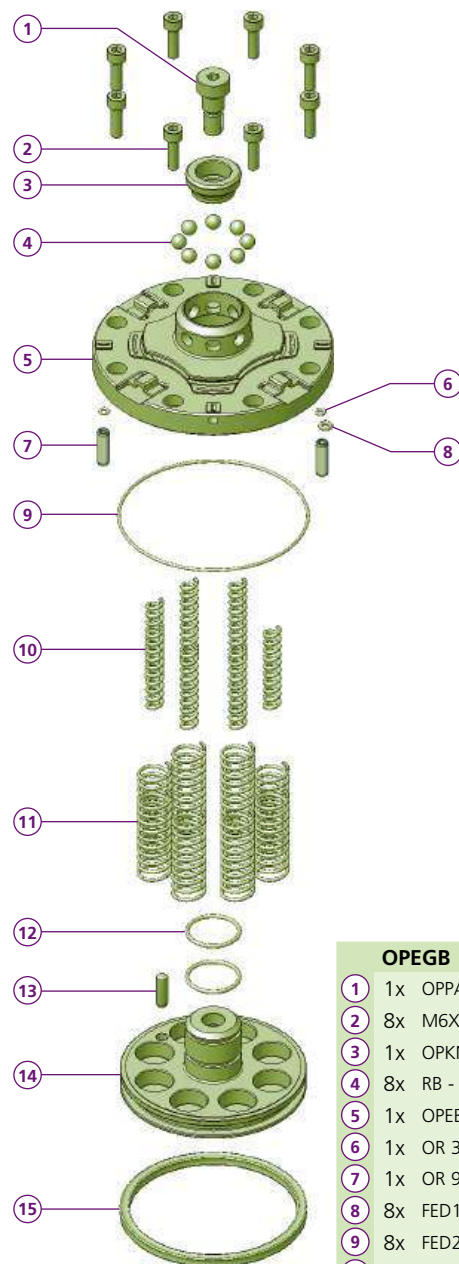
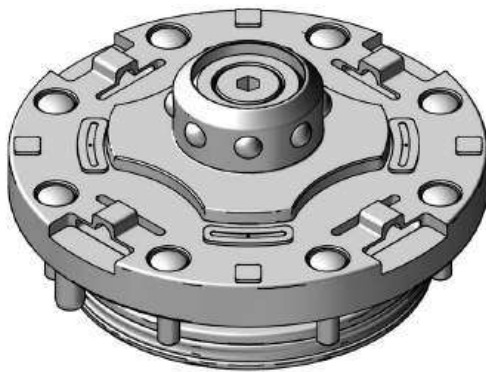
Einbauanleitung / Assembling instructions



Zentriereinheit Chuck unit

Zentrierkörper Chuck body

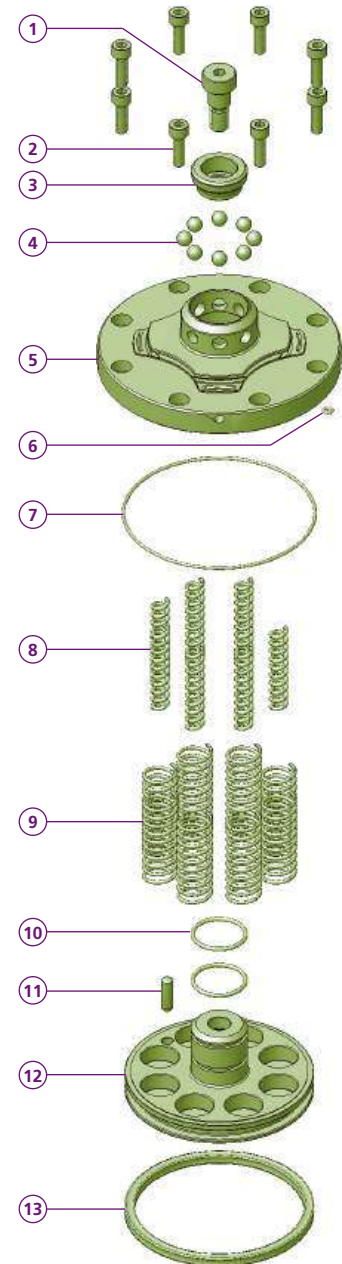
oppSystem



OPEGBID (Index)

- 1 1x OPPAS M10x12
- 2 8x M6X20 ST
- 3 1x OPKN 30x13,5
- 4 8x RB - 8/G20W
- 5 1x OPEBID
- 6 1x OR 3x1,5
- 7 2x **CCBO0801**
- 8 1x OR 5x1,5
- 9 1x OR 90x1,5
- 10 8x FED1044
- 11 8x FED2051
- 12 2x OR 26x2
- 13 1x 6m6x20 DIN 6325
- 14 1x OPKLB100
- 15 1x OPDR885

kg ~2,28

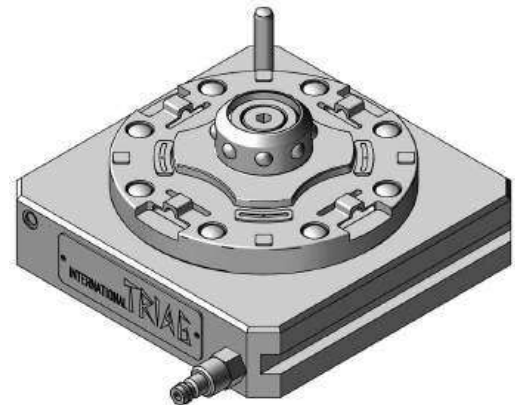


OPEGB

- 1 1x OPPAS M10x12
- 2 8x M6X20 ST
- 3 1x OPKN 30x13,5
- 4 8x RB - 8/G20W
- 5 1x OPEB
- 6 1x OR 3x1,5
- 7 1x OR 90x1,5
- 8 8x FED1044
- 9 8x FED2051
- 10 2x OR 26x2
- 11 1x 6m6x20 DIN 6325
- 12 1x OPKLB100
- 13 1x OPDR885

kg ~2,26

Bestellbeispiel
Ordering example: **OPEGBID**

oppSystem

	kg
OPB1ID (Index)	~7,6

1er Palette
Pallet with 1 clamping case

OPA1ID160

OPA1ID160

OPA1ID160R50

OPA182H63-RS

Bestellbeispiel / Ordering example: **OPA1ID160**

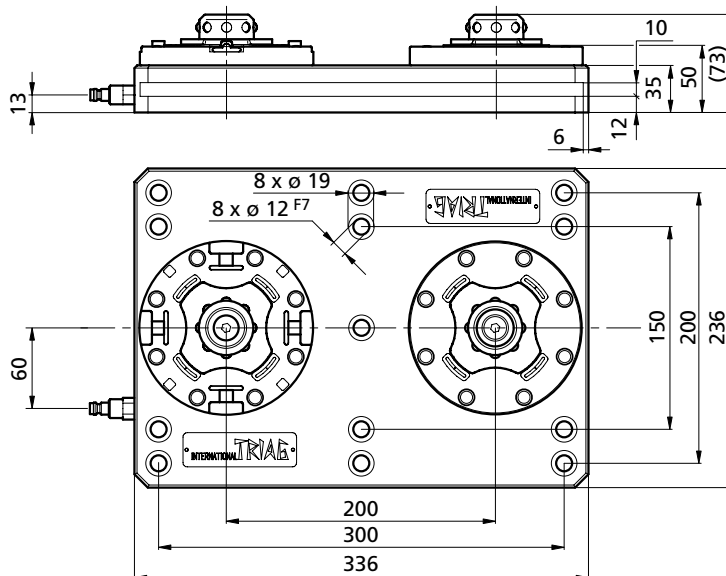
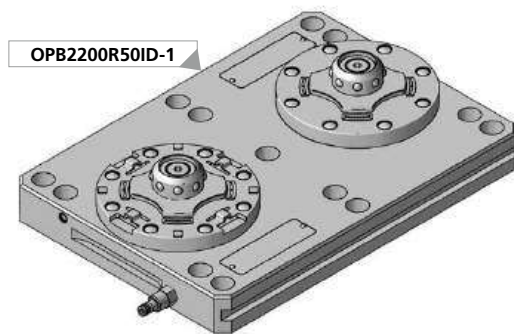
	H	P	kg
OPA1ID160	60,2	56,2	~4,20
OPA1ID200	60,2	56,2	~6,30
OPA1ID160R50	60	56	~4,10
OPA1ID200R50	60	56	~6,20
OPA182H63-RS	= weicher Stahl / soft steel		~11,03

	H	P	kg
OPA1ID160	60,2	56,2	~4,20
OPA1ID200	60,2	56,2	~6,30
OPA1ID160R50	60	56	~4,10
OPA1ID200R50	60	56	~6,20
OPA182H63-RS	= weicher Stahl / <i>soft steel</i>		~11,03

	kg
OPA1IDPCBD178	~8,0

2er Palettenträger Receiver chuck with 2 chucks

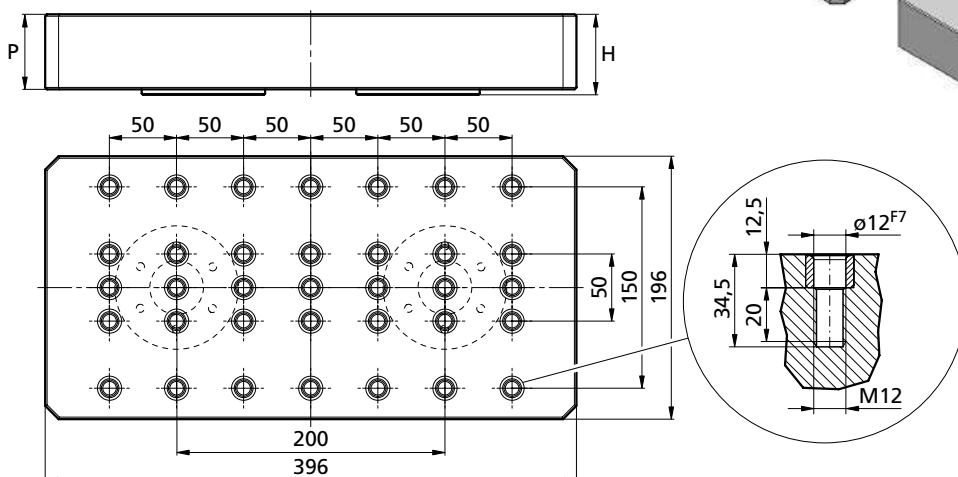
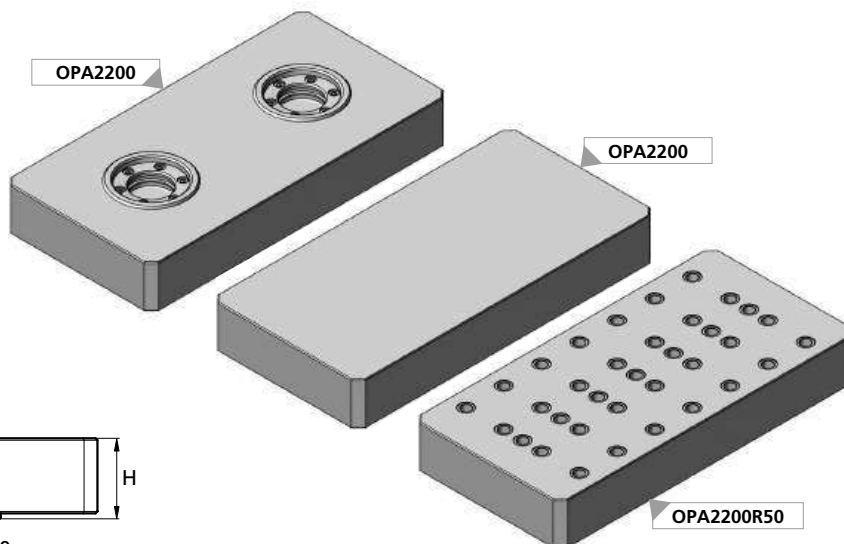
oppSystem



	kg
OPB2200R50	~27,60
OPB2200R50ID-1 (Index)	~30,00
OPB2200R50ID-2 (Index)	~30,00

Bestellbeispiel / Ordering example: **OPB2200R50**

2er Palette Pallet with 2 clamping case

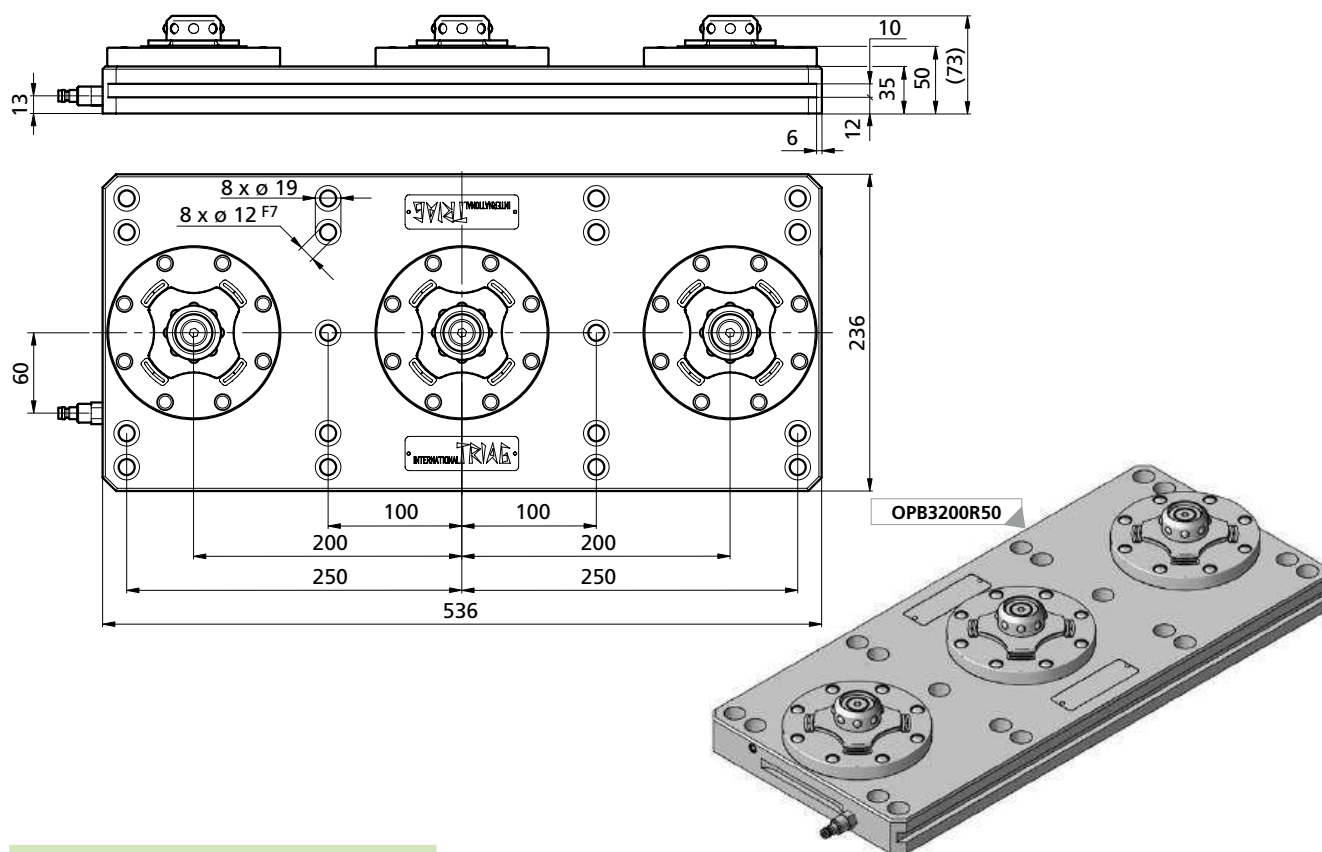


	H	P	kg
OPA2200	60,2	56,2	~12,18
OPA2200R50	60	56	~12,50

Bestellbeispiel / Ordering example: **OPA2200R50**

3er Palettenträger Receiver chuck with 3 chucks

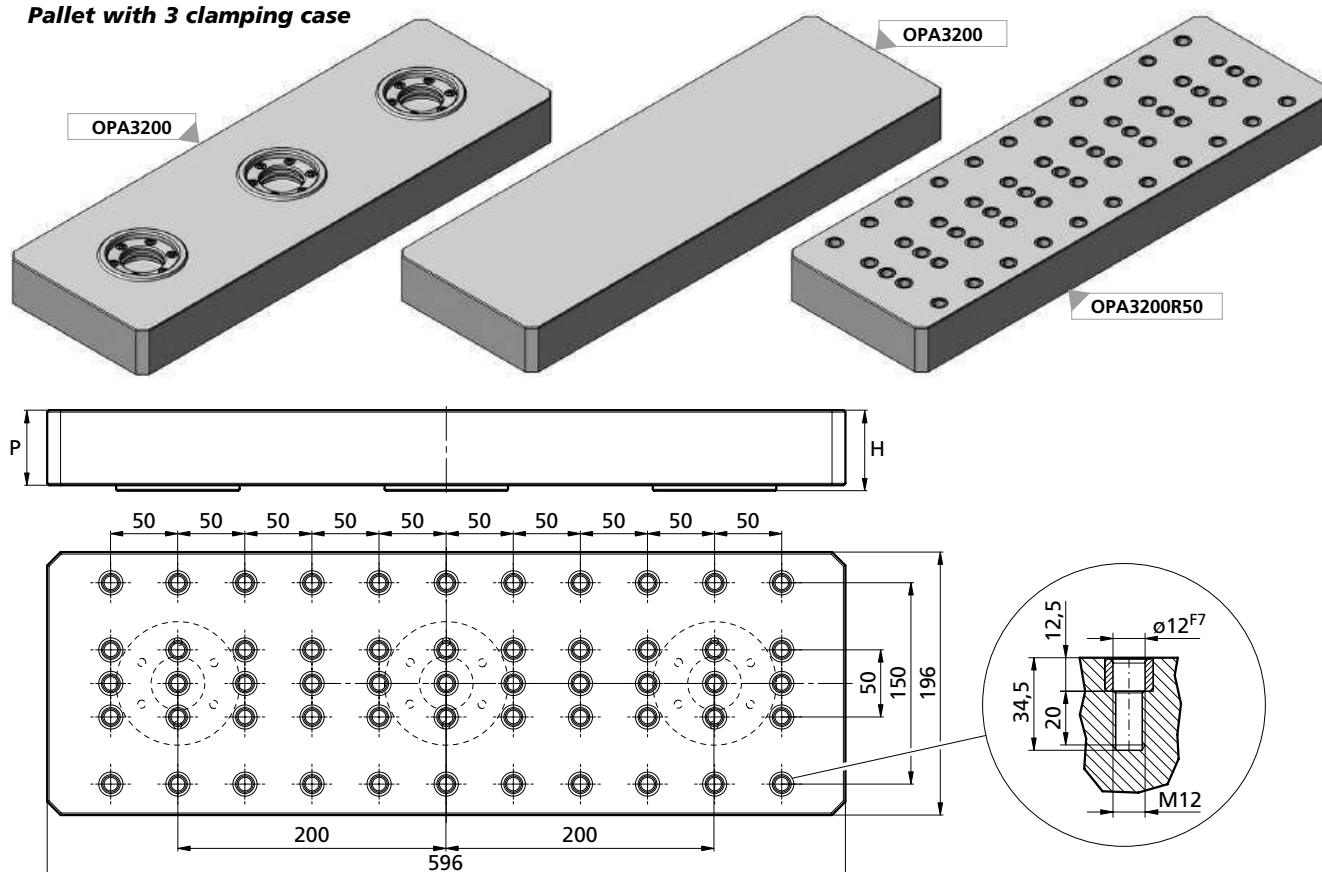
oppSystem



	kg
OPB3200R50	~36,10
OPB3200ID-1 (Index)	~36,00

Bestellbeispiel / Ordering example: **OPB3200R50**

3er Palette Pallet with 3 clamping case

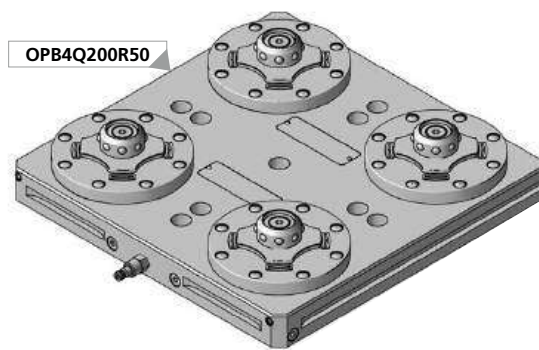


	H	P	kg
OPA3200	60,2	56,2	~18,90
OPA3200R50	60	56	~18,80

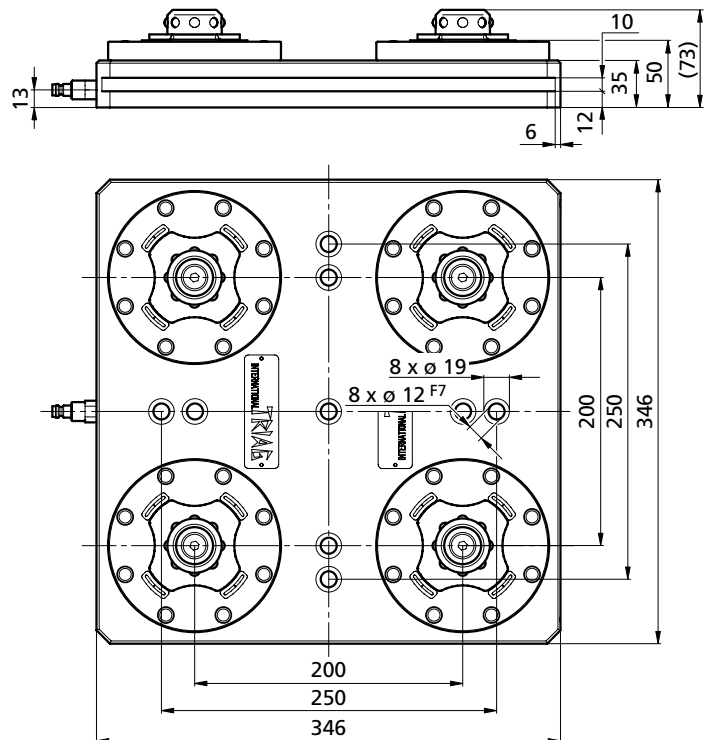
Bestellbeispiel / Ordering example: **OPA3200**

4er Palettenträger Receiver chuck with 4 chucks

oppSystem



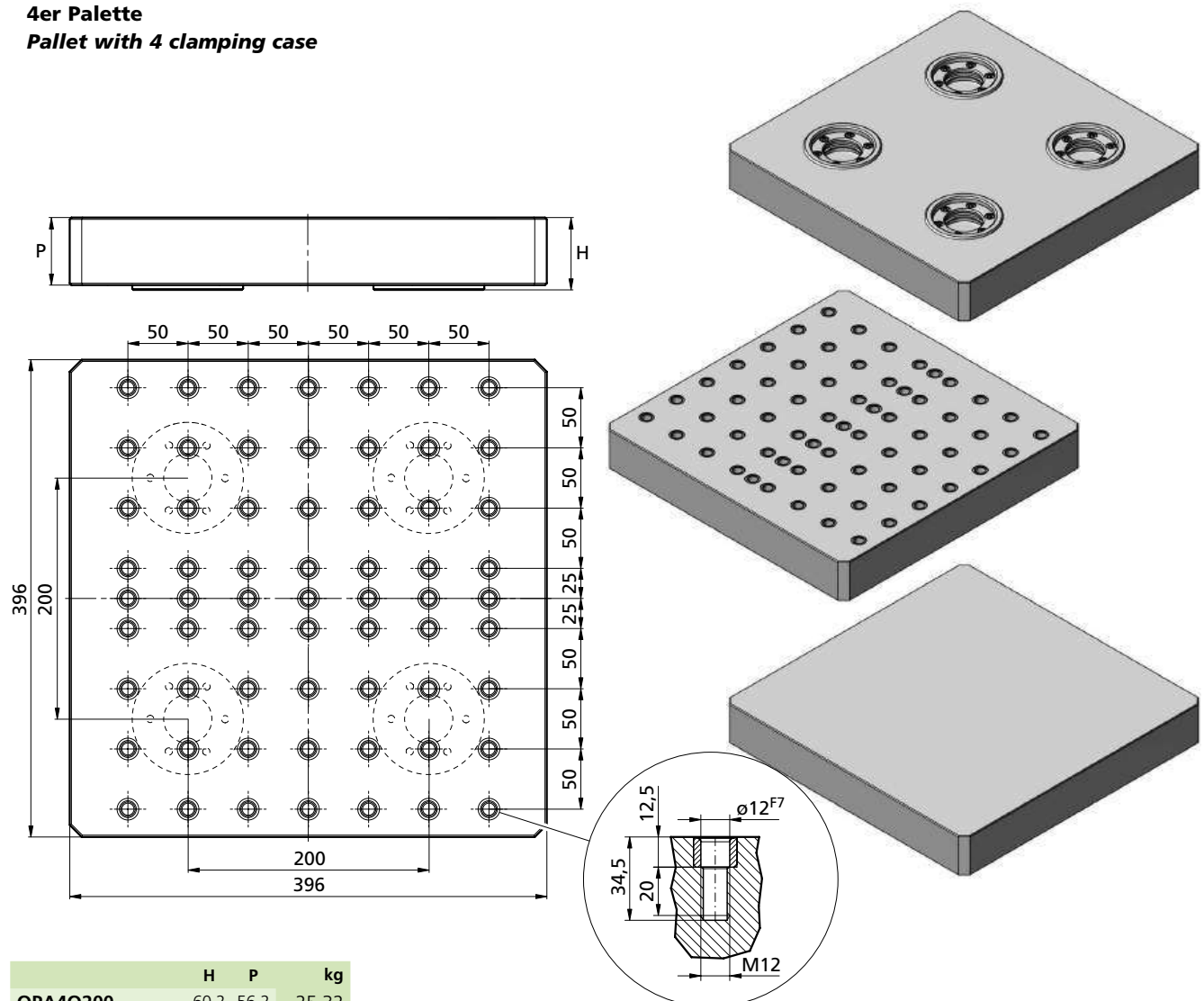
OPB4Q200R50



	kg
OPB4Q200R50	~35,80
OPB4Q200R50ID-4	~35,70

Bestellbeispiel / Ordering example: **OPB4Q200R50**

4er Palette Pallet with 4 clamping case



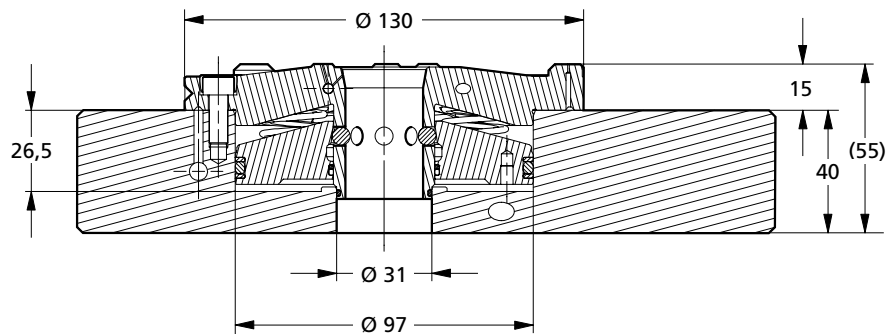
	H	P	kg
OPA4Q200	60,2	56,2	~25,32
OPA4Q200R50	60	56	~25,23

Bestellbeispiel / Ordering example: **OPA4Q200**

EROWA MTS Einbauspannfutter / Integral chucks

Einbauvariante (gültig für MTS IntegralChuck Single und Multi). Toleranzen entsprechend der Einbauanleitung beachten!

Integration variant (applicable to MTS IntegralChucks Single and Multi). Observe tolerances according to integration instructions!



Manuelle Bedienung
Manual operation



Geeignet zur Anwendung unter Flüssigkeit
Suited for submerged operation



Geeignet für automatische Anwendung
Suited for automatic operation



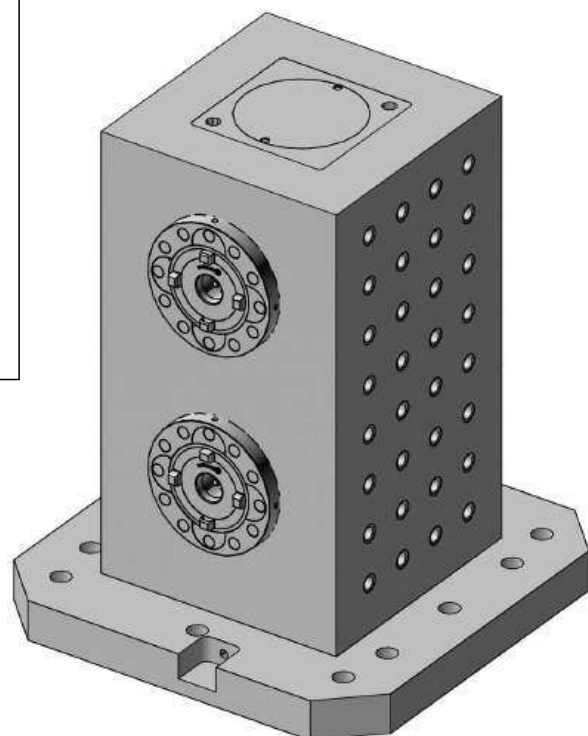
Mit Druckluftpistole bedienen
Operate with compressed air jet



Für spanabhebende Bearbeitung
For chip-removing processes



Zum Senkerodieren
For EDM sinking



1 Präzise

Spelfreie Kurzkegel-Zentrierung.
 Repetiergenauigkeit: < 0,005 mm.
 Leichtes Einfahren der Paletten.

2 Spannmechanismus

Zuverlässiger Spannmechanismus durch selbsthemmenden Kugerverschluss.

3 Öffnen

MTS Spannfutter werden pneumatisch betätigt.

4 Sauberkeit

Flüssigkeit kann ablaufen, keine Schmutzecken.

1 Precise

Play-free round-cone centering.
 Repeatability: <0.005 mm.
 Easy insertion of the pallets.

2 Clamping mechanism

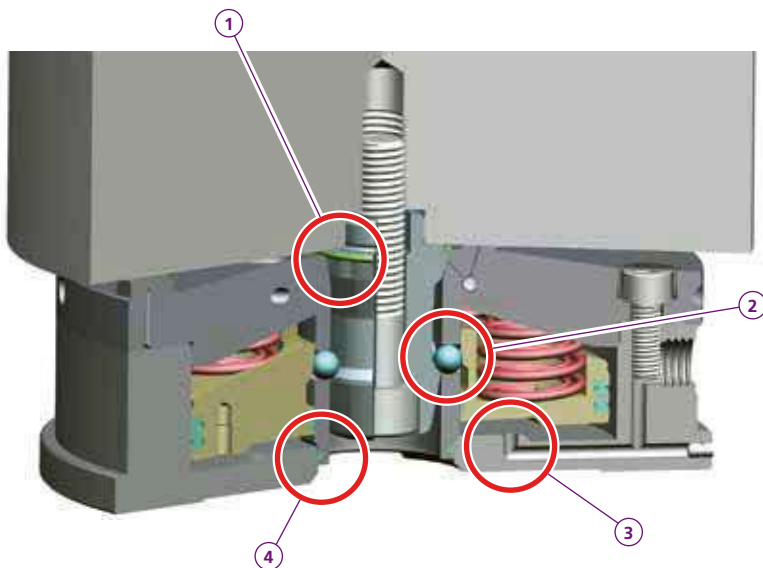
Reliable clamping mechanism through self-locking ball lock.

3 Open

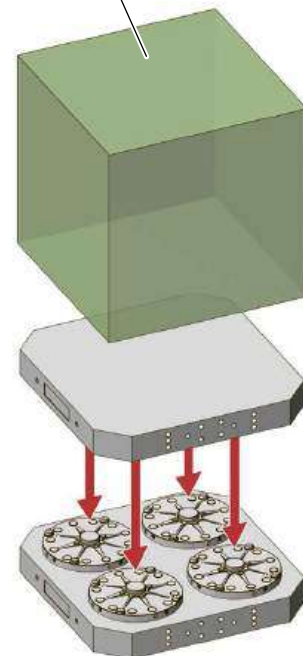
MTS are operated pneumatically.

4 Cleanliness

Liquids can drain off. No dirt traps.



L x B x H: Maschinenabhängig
L x W x H: Depending on the machine



MTS Spannfutter

Das pneumatische MTS Spannfutter benötigt trotz der hohen Spannkraft von 12'000 N dank interner Kraftverstärkung nur 7 bar Öffnungsdruck.

MTS Chuck

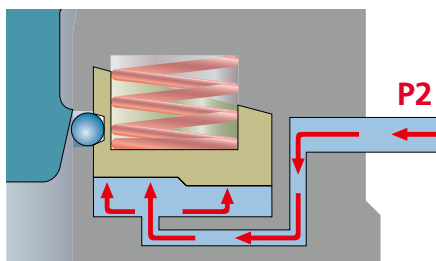
A mere 7 bar of opening pressure results in 12,000 N clamping power thanks to internal power boosting.

MTS Spannfutter, automatisierbar

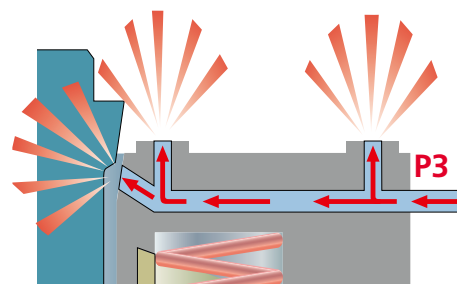
Automatische Reinigung der Auflageflächen und des Zentrierzapfens beim Werkstückwechsel.

MTS chuck, automatable

Automatic cleaning of contact surfaces and of the centering spigot cone while the workpiece is changed.



P2 Anschluss (P2)
 Öffnen
Prise (P2)
 Ouverture



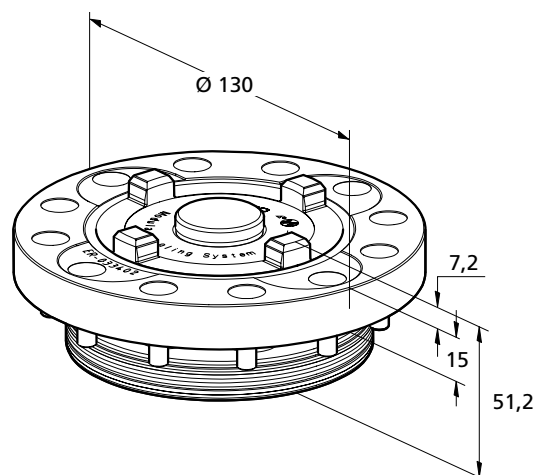
Anschluss (P3)
 Reinigen
Prise (P3)
 Cleaning

MTS IntegralChuck S-P (single + multiple /manually)

ER-033402



- Ausführung** Für den direkten Einbau in Maschinentische, Platten, Spanntürme, Winkel oder Teilapparate.
- Anschlüsse** Zum Öffnen: Pneumatisch.
- Anwendung** Zur Aufnahme von Einzel- oder Mehrfachpaletten.
- Version** For direct integration in machine tables, plates, tombstones, squares or dividing heads.
- Connections** To open: pneumatic or hydraulic.
- Application** To accommodate single or multiple pallets.

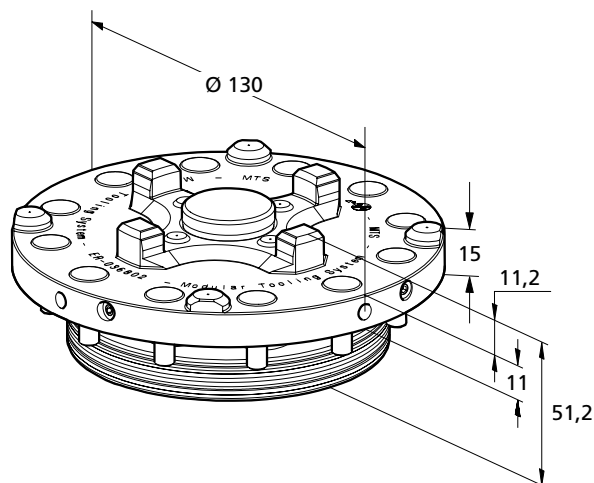


MTS IntegralChuck S-P/A (single + multiple /auto)

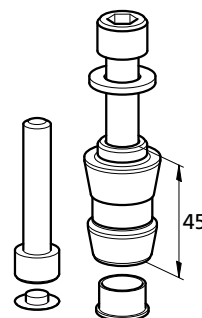
ER-036802



- Ausführung** Für den direkten Einbau in Maschinentische, Platten, Spanntürme, Winkel oder Teilapparate.
- Anschlüsse** Zum Öffnen: Pneumatisch.
Zum Reinigen: Pneumatisch.
- Anwendung** Zur Aufnahme von Einzel- oder Mehrfachpaletten.
- Version** For direct integration in machine tables, plates, tombstones, squares or dividing heads.
- Connections** To open: pneumatic.
To clean: pneumatic.
- Application** To accommodate single or multiple pallets.



Spannzapfen / Spigot		
ER-033800	manuell / 0-Punkt Zapfen manually zero point locating	
ER-039201	auto / Ausgleichszapfen auto / alignment spigot	
ER-039200	auto / Zapfen mit Spiel auto / spigot with clearance	
ER-038000	auto / 0-Punkt Zapfen auto / Zero point spigot	



Um Ihnen die schnelle Orientierung über die Anwendungsbereiche der EROWA Produkte zu erleichtern, verwenden wir die folgenden Zeichen:

To make it easier for you to find your way about the fields of application for EROWA products, we use the following symbols:

S = Single
M = Multi
A = Automatisierbar / Able to automate
P = Pneumatisch betätigt / Pneumatically operated



Manuelle Bedienung
Manual operation



Geeignet zur Anwendung unter Flüssigkeit
Suited for submerged operation



Geeignet für die automatische Anwendung
Suited for automatic operation



Für spanabhebende Bearbeitung
For chip-removing processes



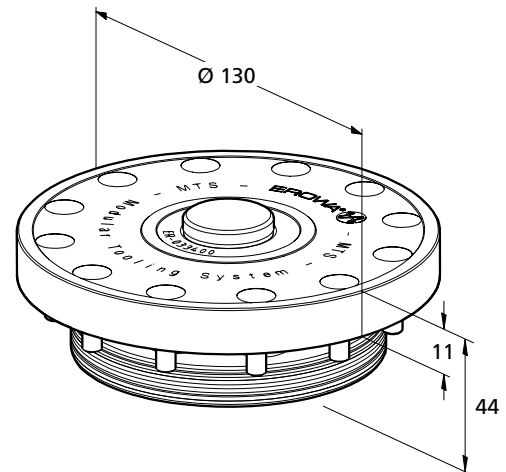
Zum Senkerodieren
For EDM sinking

MTS IntegralChuck M-P (multiple / manually)

ER-033400



- Ausführung** Für den direkten Einbau in Maschinentische, Platten, Spanntürme, Winkel oder Teilapparate.
- Anschlüsse** Zum Öffnen: Pneumatisch.
- Anwendung** Zur Aufnahme von Einzel- oder Mehrfachpaletten.
- Version** For direct integration in machine tables, plates, tombstones, squares or dividing heads.
- Connections** To open: pneumatic or hydraulic.
- Application** To accommodate single or multiple pallets.

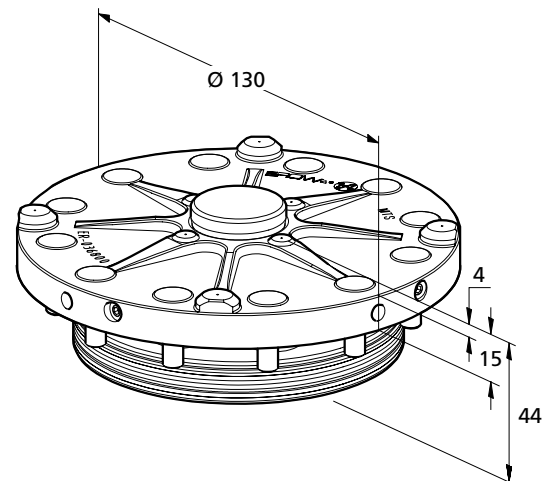


MTS IntegralChuck M-P/A (multiple /auto)

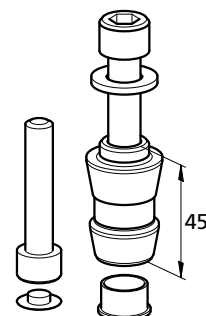
ER-036800



- Ausführung** Für den direkten Einbau in Maschinentische, Platten, Spanntürme, Winkel oder Teilapparate.
- Anschlüsse** Zum Öffnen: Pneumatisch.
Zum Reinigen: Pneumatisch.
- Anwendung** Zur Aufnahme von Einzel- oder Mehrfachpaletten.
- Version** For direct integration in machine tables, plates, tombstones, squares or dividing heads.
- Connections** To open: pneumatic.
To clean: pneumatic.
- Application** To accommodate single or multiple pallets.



Spannzapfen / Spigot		
ER-033800	manuell / 0-Punkt Zapfen manually zero point locating	
ER-039201	auto / Ausgleichszapfen auto / alignment spigot	
ER-039200	auto / Zapfen mit Spiel auto / spigot with clearance	
ER-038000	auto / 0-Punkt Zapfen auto / Zero point spigot	



Um Ihnen die schnelle Orientierung über die Anwendungsbereiche der EROWA Produkte zu erleichtern, verwenden wir die folgenden Zeichen:

To make it easier for you to find your way about the fields of application for EROWA products, we use the following symbols:

S = Single
M = Multi
A = Automatisierbar / Able to automate
P = Pneumatisch betätigt / Pneumatically operated



Manuelle Bedienung
Manual operation



Geeignet zur Anwendung unter Flüssigkeit
Suited for submerged operation



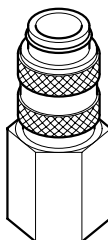
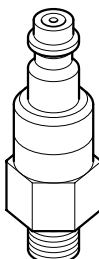
Geeignet für die automatische Anwendung
Suited for automatic operation

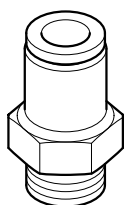


Für spanabhebende Bearbeitung
For chip-removing processes



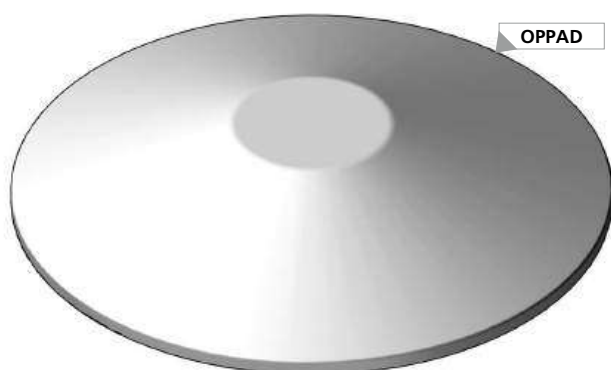
Zum Senkerodieren
For EDM sinking

OPSKU	G1/4" Innengewinde <i>Internal thread</i>	OPST-NI	G1/8" Aussengewinde <i>Male thread</i>	OPRV	G1/8" Aussengewinde <i>Male thread</i>
					
Schnellkupplung <i>Quick fitting coupling</i>		Stecknippel verschmutzungsgeschützt <i>Plug nipple protected against staining</i>		Rückschlagventil <i>Nonreturn valve</i>	
OPANS-8	G1/4" Aussengewinde <i>Male thread</i>				

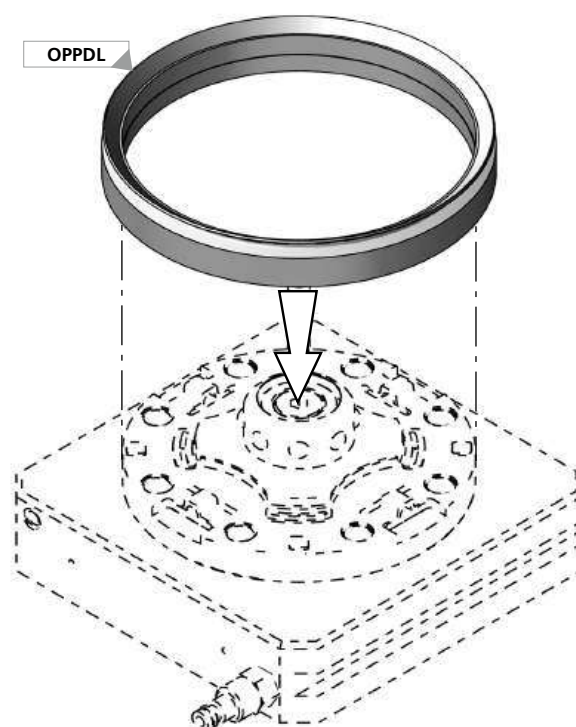


Für 8 mm Schlauch / *For hose*

Abdeckung
Cover

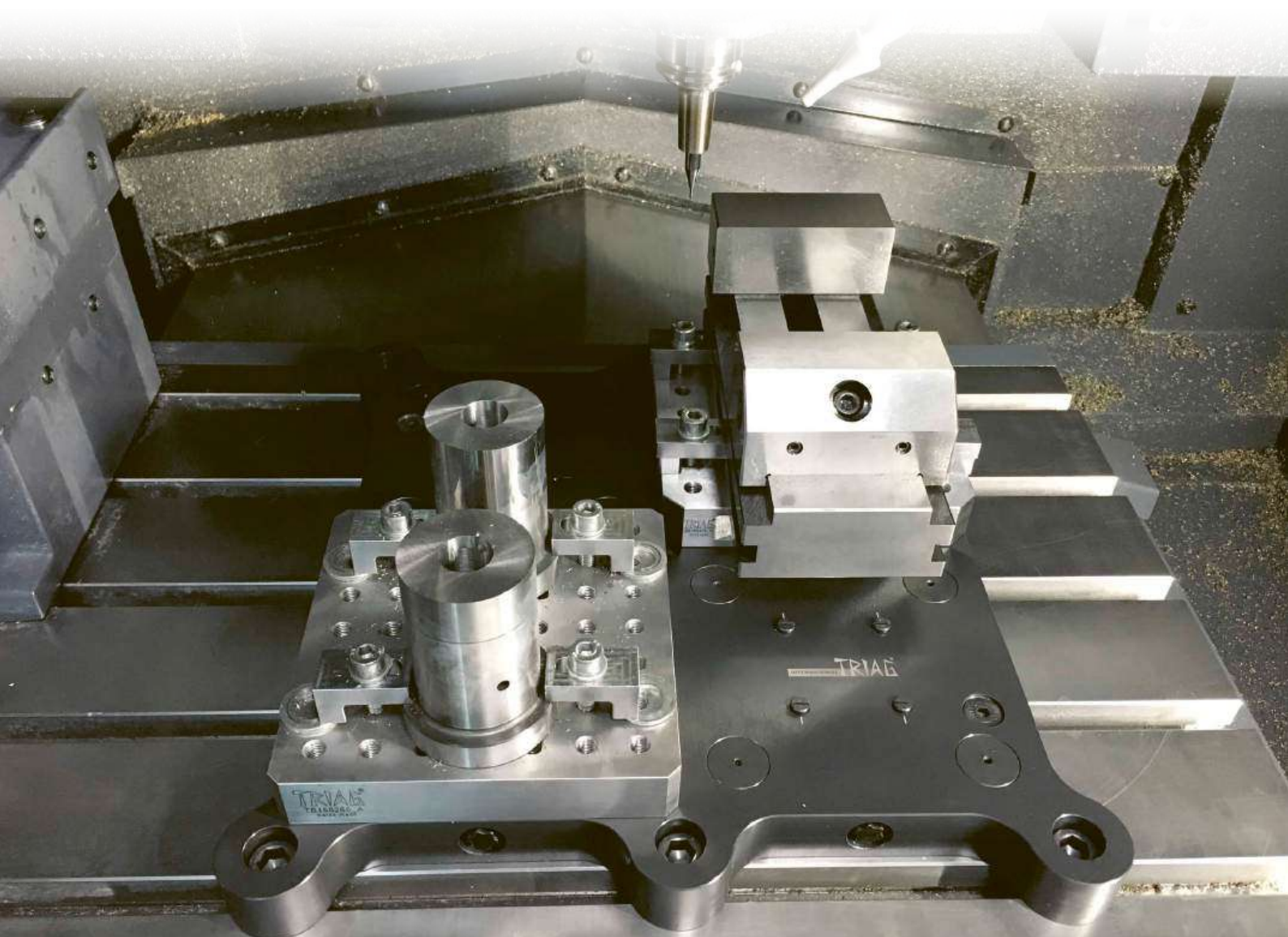


Dichtlippe
Leakproof cover



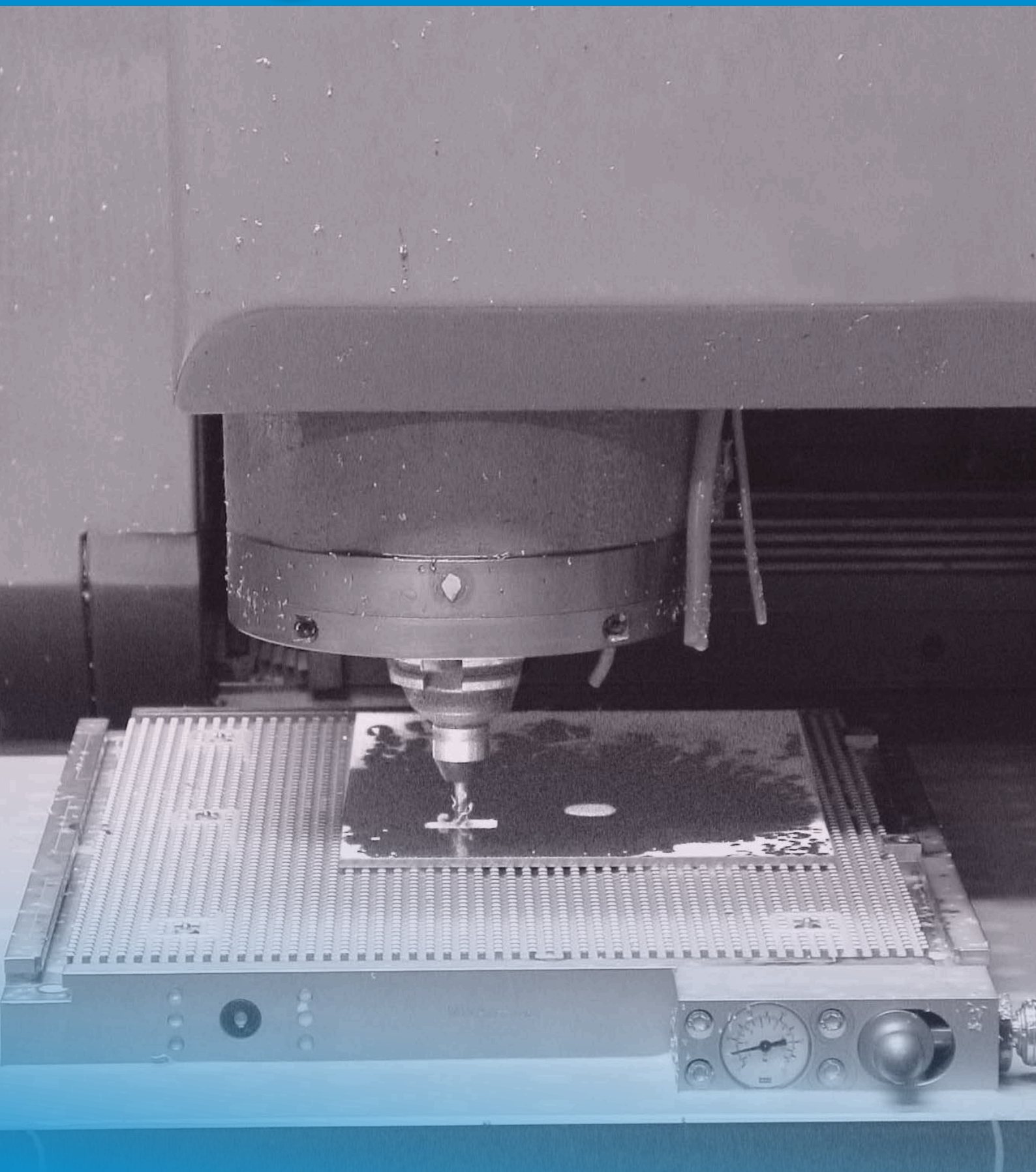
	kg
OPPDL	~0,525
OPPDL	~0,075

Bestellbeispiel / *Ordering example* : 1x **OPPDL**





trivaCLAMP





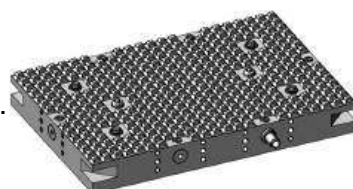
Einleitung | *Introduction* 305 - 307



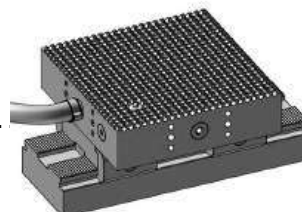
Bedienungsanleitung | *Operating manual* 308 - 309

Anwendungsbeispiele | *Examples of application* 310 - 312

Modulare Vakuumplatten | *Modular vacuum plates* 314 - 317



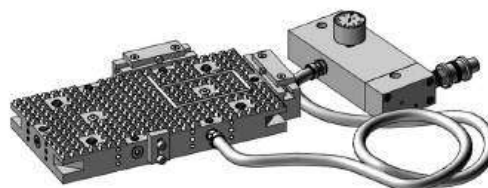
Vakuum-Modul für powerCLAMP | *Vacuum module for powerCLAMP* 318 - 319



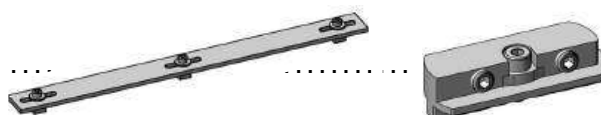
Kombinationsvarianten (Vakuumplatten)
Possible combination of vacuum plates 320



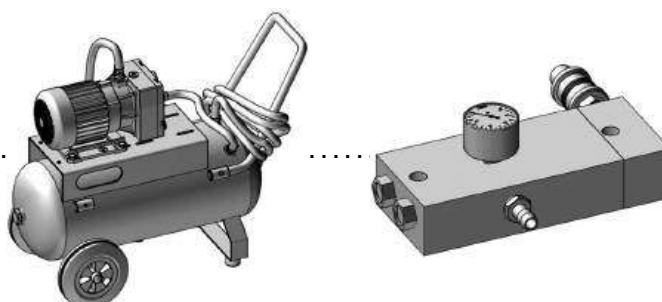
Startersets nach Ihrer Wahl | *Starter kit (Your choice)* 321



Zubehör | *Accessories* 322 - 324



Vakuum erzeugen | *Generate vacuum* 325 - 327



Vakuumspannen

Die mechanische Spannung hat bekanntlich auch Nachteile. Hohe Kräfte auf das Werkstück können zu Druckmarken und Verformungen führen. Vor allem bei grösseren Werkstücken besteht zudem die Gefahr, dass das Werkstück vibriert.

Workholding by vacuum

Mechanical clamping, as described before, has disadvantages. High specific forces on the workpiece can cause pressure marks and distortions. And, particularly on large parts, there is a risk that the workpiece will vibrate.



Bei der Spannung mit Vakuum wird der Druck nicht mechanisch auf das Werkstück sondern durch die umgebende Atmosphäre ausgeübt. Dadurch werden die Werkstücke schonend und gleichmässig über die ganze Auflagefläche fixiert, so dass kaum Vibrationen entstehen.

Der Beschickungs- und Arbeitsraum bleibt zudem frei von Bränden und Spannmittel.

In vacuum clamping the clamping force is not applied to the work piece mechanically, but is provided by the surrounding atmosphere. This means that the work piece is gently and evenly pulled down over the whole supporting surface, so that vibration is minimized. As there are no obstructing brackets, clamps or workholding modules in the working and loading area, there are fewer chances for collisions with the tool.

- Diese Spannmethode ist vor allem für grossflächige, dünnwandige, auch nichtmagnetische Werkstücke geeignet.

- This clamping method is particularly suitable for large surface, thin-walled and also non magnetic work pieces.

Triva Clamp besteht aus folgenden Funktionsteilen:

Triva Clamp consists of the following functional devices:

- **Vakuumpplatten** mit passenden Anschlagleisten für den Einsatz mit seitlich einwirkenden Kräften.
- **Dichtschnur aus Silikongummi**, die immer entlang der Peripherie des Werkstücks eingelegt wird. Die Haltekraft wächst proportional zur Aufspannfläche, die durch die Dichtschnur begrenzt wird.
- **Rotations-Vakuumpumpe** mit Schaltventil und Druckwächter optional.
- **Injektorpumpe** mit Schaltventil.

- **Vacuum plates** with suitable stop gauges for application with lateral workholding forces.
- **Silicone-rubber sealing cord** inlaid along the periphery of the work piece. The clamping force increases proportionally to the surface area defined by the sealing cord.
- **Rotary vacuum pump** with control unit and pressure sensor.
- **Injector pump** with control unit.

Die Ansaugbohrungen werden mit Hilfe von **Triva Clamp-Ventilen** versiegelt. Wenn die Ventile geschlossen sind, sind keine Löcher in der Platte vorhanden, so dass kaum Kühlflüssigkeit eindringen kann. Das **Triva Clamp-Ventil** wird bei der Auflage des Werkstückes automatisch aktiviert. Ständiges manuelles Öffnen und Verschliessen der Bohrungen entfällt somit.

*The suction holes are sealed by the **Triva Clamp valves**. With these valves closed there are no holes in the plate so that hardly any coolant can enter. The **Triva Clamp valve** is automatically activated by placing the work piece on the vacuum plate. Hence constant opening and closing of the suction holes is omitted.*

Theoretische Haltekraft:

Unter Einbezug eines Sicherheitsfaktors für atmosphärische Druckschwankungen und Leckagen im Vakuumkreislauf rechnen wir mit einem zur Verfügung stehenden Druck von 0,85 bar Vakuum oder 8,5 N/cm² (wobei der Druck von der Höhe über Meer abhängig ist).

Diesen Druck bezeichnen wir als theoretisch 100%. Bei 300 cm² Spannfläche ergibt sich also eine theoretische Spann-/Haltekraft von 8,5 N/cm² x 300 cm² = 2550N.

Diese theoretische Haltekraft basiert auf einem vollständigen Hohlraum unter dem Werkstück. Dies ist in der Praxis jedoch nicht möglich, weil das Werkstück abgestützt werden muss.

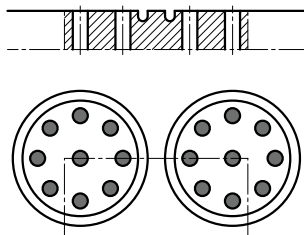
Effektive Haltekraft:

Das heisst, je grösser der Hohlraum unter dem Werkstück und je geringer die Auflagefläche für das Werkstück, desto grösser sind die Haltekräfte.

Die effektive Haltekraft ist folglich abhängig vom Wirkungsgrad des Vakuumspannsystems.

Vakuumspannsysteme im Vergleich:

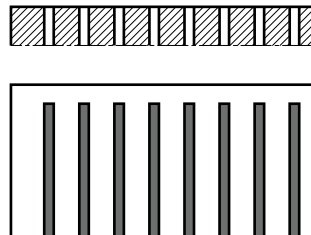
Lochplatte Plate with suction holes



Pro Element Ø 40 mm
9 Bohrungen Ø 4 mm.
Each section of Ø 40 mm
having 9 bores of Ø 4 mm.

Wirkungsgrad: 9%
Degree of efficiency: 9%

Schlitzplatte Plate with slots



Steg 8 mm, Schlitz 2 mm
Slots 2 mm, bar 8 mm

Wirkungsgrad: 25%
Degree of efficiency: 25%

Theoretical holding force:

Including a safety factor for atmospheric pressure variations and leaks within the vacuum circuit, we calculate an available pressure of 0,85 bar (12,1psi) vacuum equalling 8,5 N/cm² (whereas pressure is dependent on altitude).

This amount of pressure is referred to as theoretically attainable 100%. For 300 cm² /46,5 sq inch the pressure thus is 8,5 N/cm² x 300 cm² = 2550N (12,1psi x 46,5sq in = 562lbs).

This theoretically calculated holding force is based upon a hollow space underneath the entire work piece. This is not possible because the work piece must be supported. Therefore we have to subtract the area supporting the workpiece.

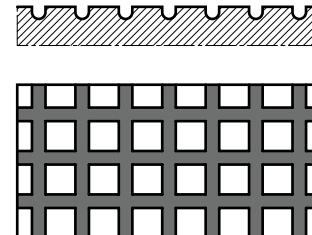
Effective holding force:

In other words: the larger the work piece supporting area, thus reducing the hollow space representing the holding area, the lesser the holding force.

Consequently, the effective holding force depends entirely upon the rate of efficiency of the vacuum system.

Comparison of various vacuum systems:

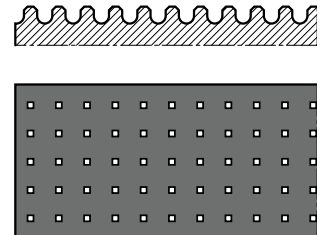
Nutenplatte Plate with U-shaped grooves



Raster 10x10 mm, Nute 3 mm
Grid 10x10 mm, grooves 3 mm

Wirkungsgrad: 51%
Degree of efficiency: 51%

Triva Clamp Waffelmuster Triva Clamp waffle pattern



Raster 6,5 mm, Nute 5 mm
Grid 6,5 mm, grooves 5 mm

Wirkungsgrad: 92%
Degree of efficiency: 92%

Besonderheiten von Triva Clamp:

Durch die besondere Formgebung der Werkstückauflage (Waffelmuster) erreicht Triva Clamp einen kaum zu übertreffenden **Wirkungsgrad von theoretisch 92% = 2346 N bei einem maximal erreichbaren Wert von 2550 N (bezogen auf 300 cm² Spannfläche).**

Special features Triva Clamp:

The unique shape of the Triva Clamp workpiece supporting area (waffle pattern) guarantees maximum attainable holding force with a rate of **efficiency of theoretically 92%, equalling 2346 N holding force applied to the work piece of 300cm² (46,5sq in) holding surface.**

Toleranzen

Höhe 40 mm ± 0,02 / 400 mm
Ebenheit über alles: ± 0,03 / 400 mm

Tolerances

Height 40 mm ± 0,02 / 400 mm
Flatness all over: ± 0,03 / 400 mm

Alle Vakuumplatten sind aus hochfestem Aluminium hergestellt und für eine lange Lebensdauer **Hartanodisiert** beschichtet. Durch an jeder Seite angebrachte Koppelbohrungen wird es möglich, die Spannfläche nach Bedarf allseitig zu erweitern.

Vacuum plates are made from high tensile aluminum alloy, are **hard anodized** treated for long tool life. Triva plates can be coupled longitudinally and transversely with any holding plate to suit workpieces, limited by machine table size only.

Mechanische Spannung = Druck auf das Werkstück,
daraus resultieren:

- Belastung des Werkstücks
- Druckmarken in weichen Werkstoffen
- Verformung labiler Teile
- Risiko von Vibrationen

Mechanical clamping = pressure applied to workpiece,
result:

- Stress applied to workpiece
- Pressure marks in soft materials
- Deforming of delicate workpieces
- Risk of vibrations

Vakuumspannung = Druck auf Spannplatte

Durch die umgebende Atmosphäre, daraus folgt:

- Schonende, gleichmässige Fixierung jeglicher Werkstoffe über die ganze Auflagefläche
- Keine Vibrationen
- Freier Bestückungs- und freier Arbeitsraum

Vacuum clamping = pressure upon vacuum-plate

By the surrounding atmosphere, resulting in:

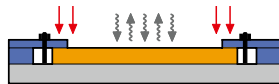
- Equal distribution of holding force over the Entire workpiece holding surface
- Machining with no risk of vibrations
- Free, clear loading and processing area

Spannen von Platten mit Klemm-Briden

Haltekraft nur am Rand. Vibrationen in Werkstückmitte. Folgeoperationen notwendig.

Clamping of plates, using clamps

Edges fixed only - Vibrations in center of workpiece - Subsequent operations required.



Spannen von Platten mit Tiefspannbacken

Haltekraft nur am Rand, Vibrationen in Werkstückmitte. Hoher Spanndruck erzeugt Spannung und Verformung.

Clamping of plates, using clamping jaws

Also high pressure applied to workpiece, holding effect at the edges - Risk of deformation and vibrations.



Kubus spannen im Schraubstock

Belastung des Werkstücks - Risiko von Druckmarken.

Clamping of cubic-shaped items, using vise

Stress applied - Risk of pressure marks in workpiece.

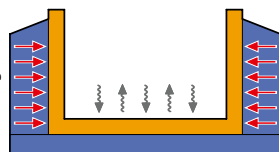


Spannen von U-Profilen im Schraubstock

Risiko von Deformationen und Vibrationen.

Clamping of U-profile, using vise

Risk of deformation and vibrations during processing.

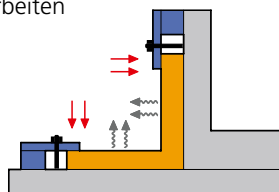


Spannen von Winkelprofil mit Briden

Umständliches Bestücken und Bearbeiten sowie grosse Vibrationen.

Clamping of angled workpiece, using clamps

Bothersome clamps, vibrations, subsequent operation.

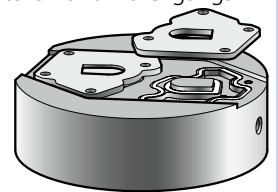


Spannen von unförmigen Werkstücken

Für Werkstücke mit unförmigen Konturen und Durchgangsbohrungen stellen wir Spezialvorrichtungen her.

Holding of bulky workpieces

We build special devices for workpieces with bulky outlines and through bore-holes.

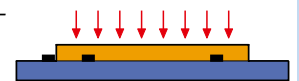


Spannen von Platten auf Vakuum-Platte

Haltekraft gleichmässig über ganze Auflagefläche verteilt. Keine Vibrationen - Freier Arbeitsraum.

Holding of plates, using vacuum-plate

Holding force equally spread all over the workpiece holding area - No vibrations - Free processing area.

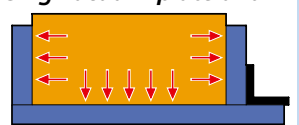


Kubisches Werkstück spannen mit Vakuum-Platte und Steilwänden

Werkstück an 3 (bis 5) Seiten ohne mechanischen Druck gehalten.

Holding of cubic-shaped item, using vacuum-plate and vertical walls

Workpiece held from 3 (up to 5) directions. No stress applied - No stress applied - No pressure marks.

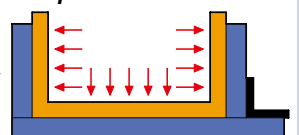


Spannen von U-Profilen mit Vakuum-Platte und Steilwänden

Allseitig gleichmässige, druckfreie Aufspannung. Bearbeitung ohne Risiko von Vibrationen.

Holding of U-profile, using vacuum-plate and 2 vertical walls

Uniform, stressfree holding from 3 directions - No risk of deformations or vibrations during processing.

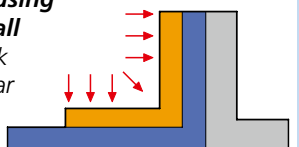


Spannen von Winkelprofil mit Vakuum-Platte und 1 Steilwand

Gleichmässig verteilte Haltekraft. Leichtes Bestücken und freier Arbeitsraum. Keine Vibrationen, keine Nacharbeit notwendig.

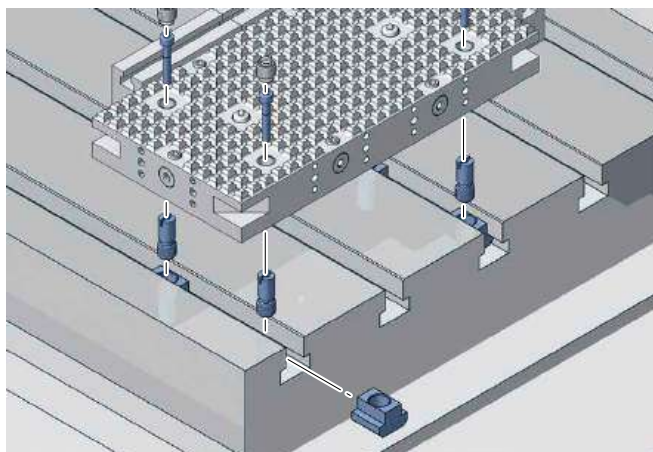
Holding of angled workpiece, using vacuum-plate and 1 vertical wall

Uniform stressfree holding - No risk of vibrations - No clamps, free, clear work area for easier, faster loading and processing.

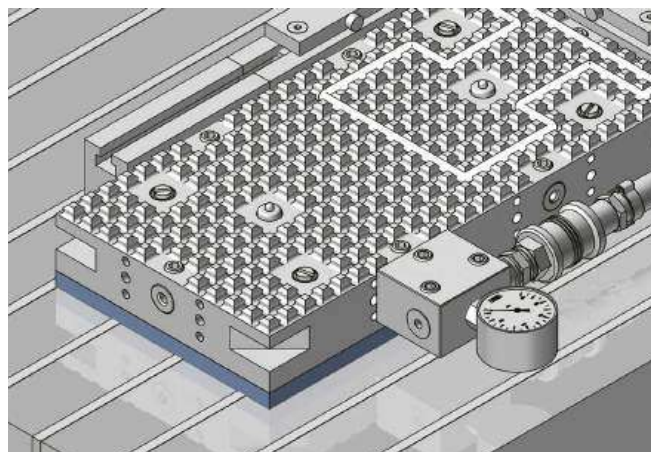


Rote Pfeile → zeigen die Spannrichtung, graue Pfeile ~→ zeigen Vibrationskräfte
Red arrows → show the holding force direction, gray arrows ~→ show vibration forces

Vakuumplatte auf Maschinentisch befestigen / Mounting vacuum plate on machine table

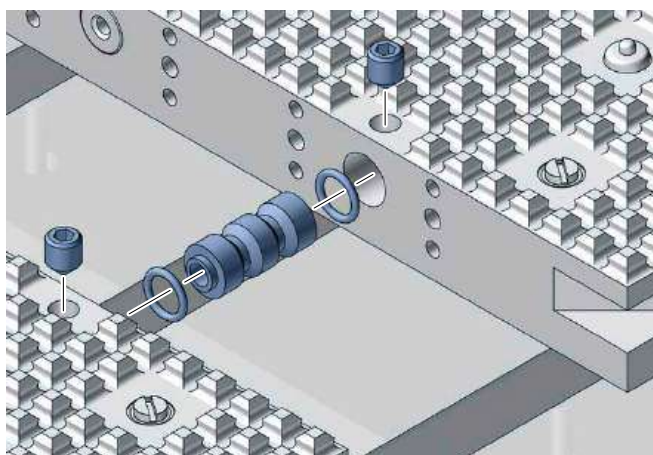


Mechanisch befestigt / Mechanical mounting

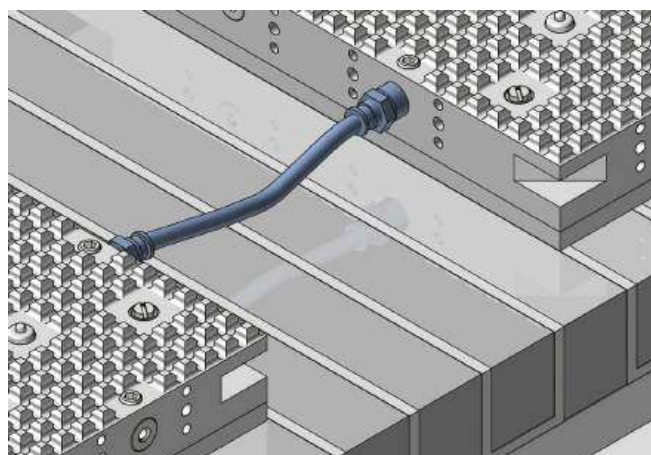


Magnetisch befestigt / Magnetical mounting

Platten koppeln / Connect plates

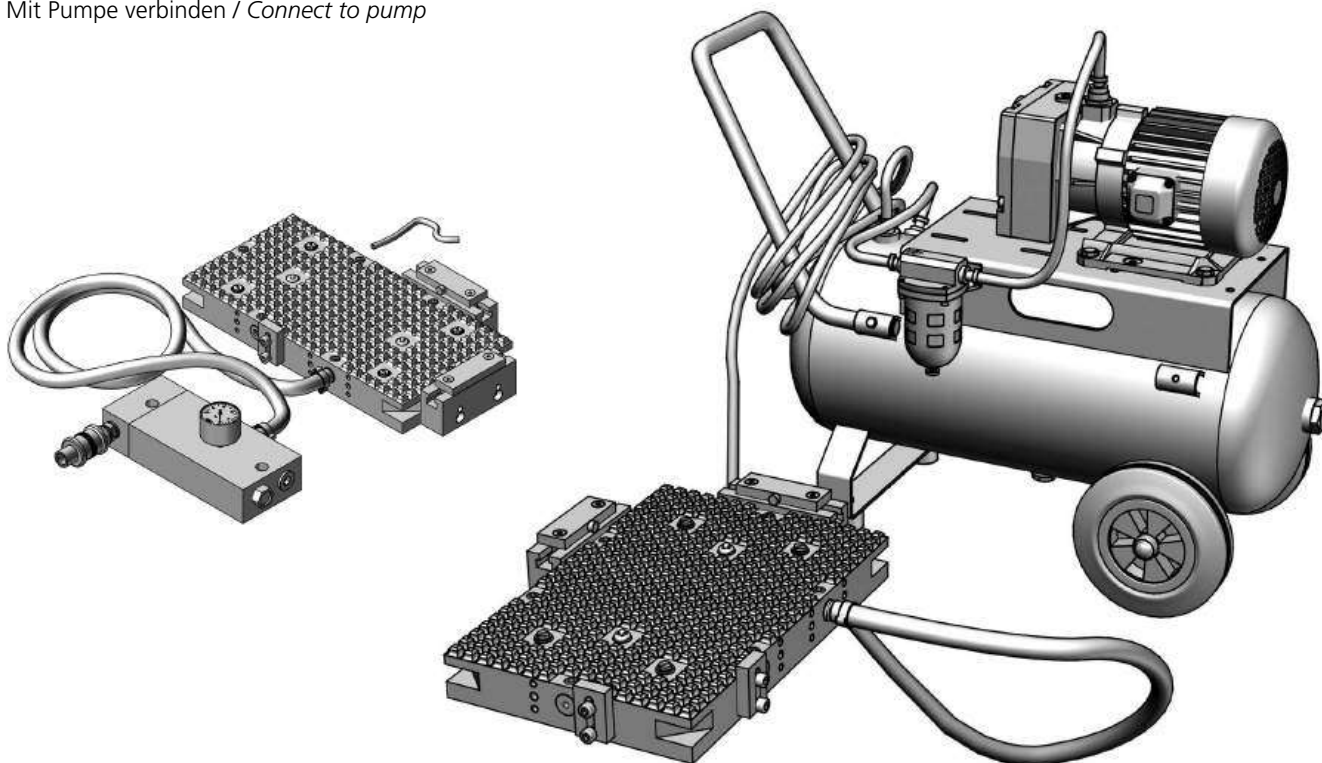


Mit Vakuumverbinder / With vacuum circuit connector

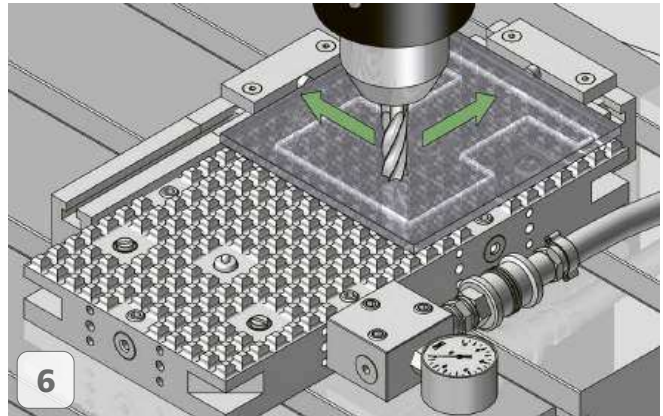
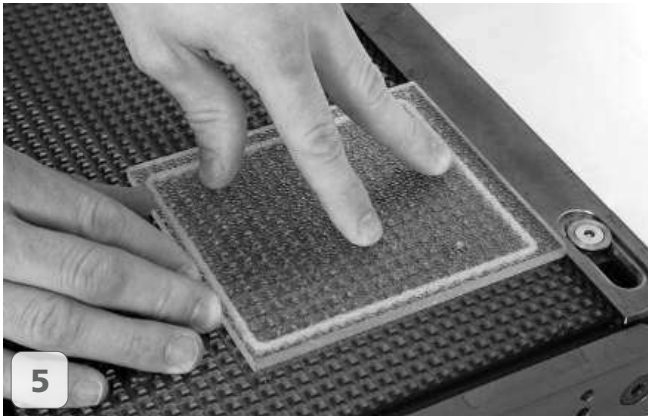
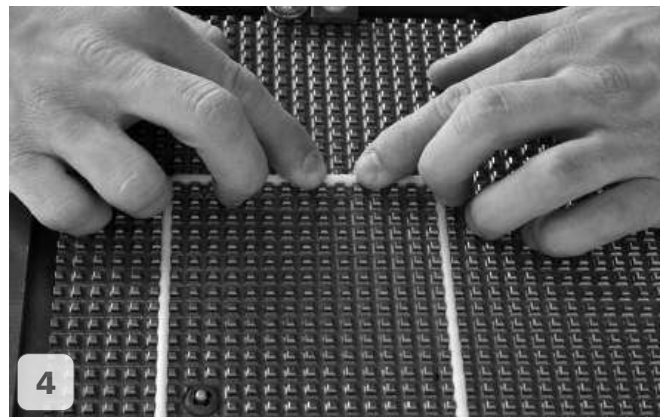
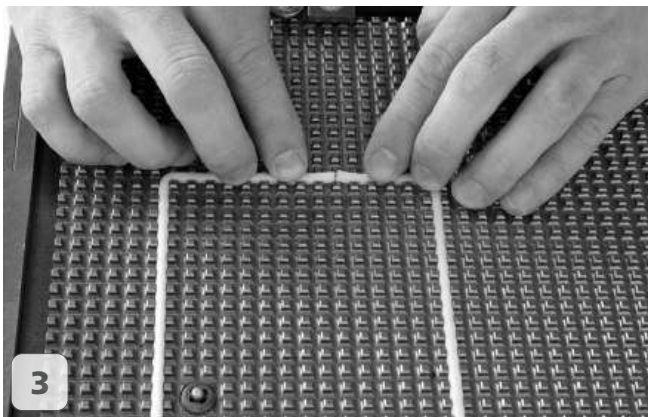
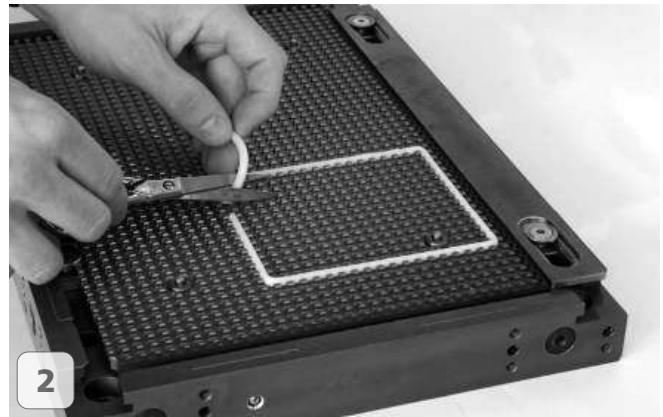
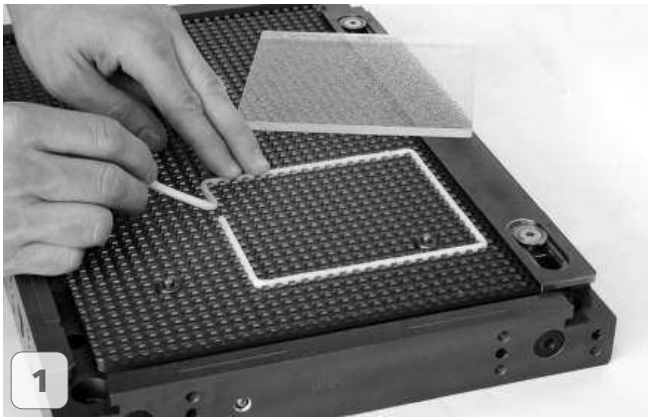


Mit Verbindungsschlauch / With connector-tube

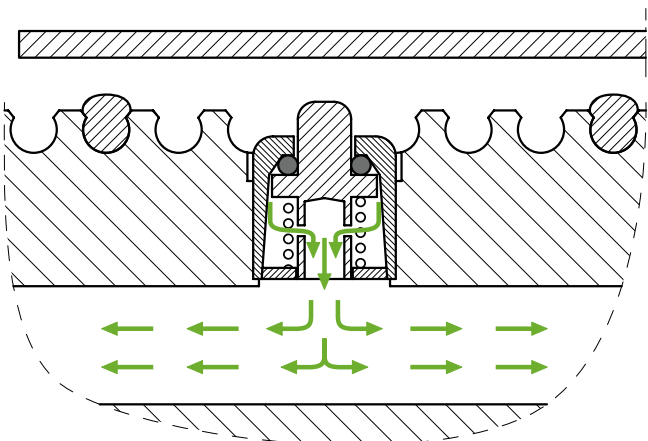
Mit Pumpe verbinden / Connect to pump



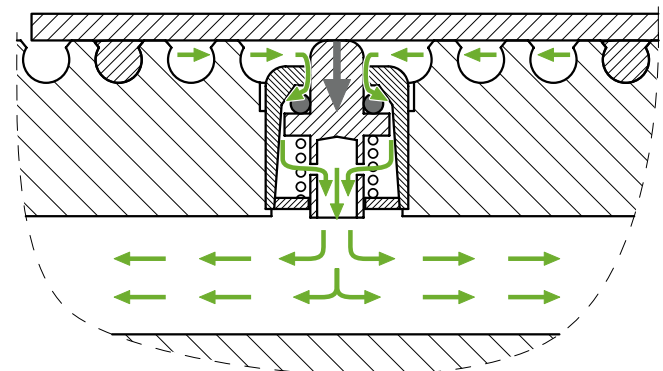
Dichtschnur und Werkstück einlegen / Insert sealing cord and workpiece



Fräsrichtung beachten:
wenn möglich, gegen Festanschläge fräsen.
Pay attention to machining direction:
if possible, toward stop gages milling.

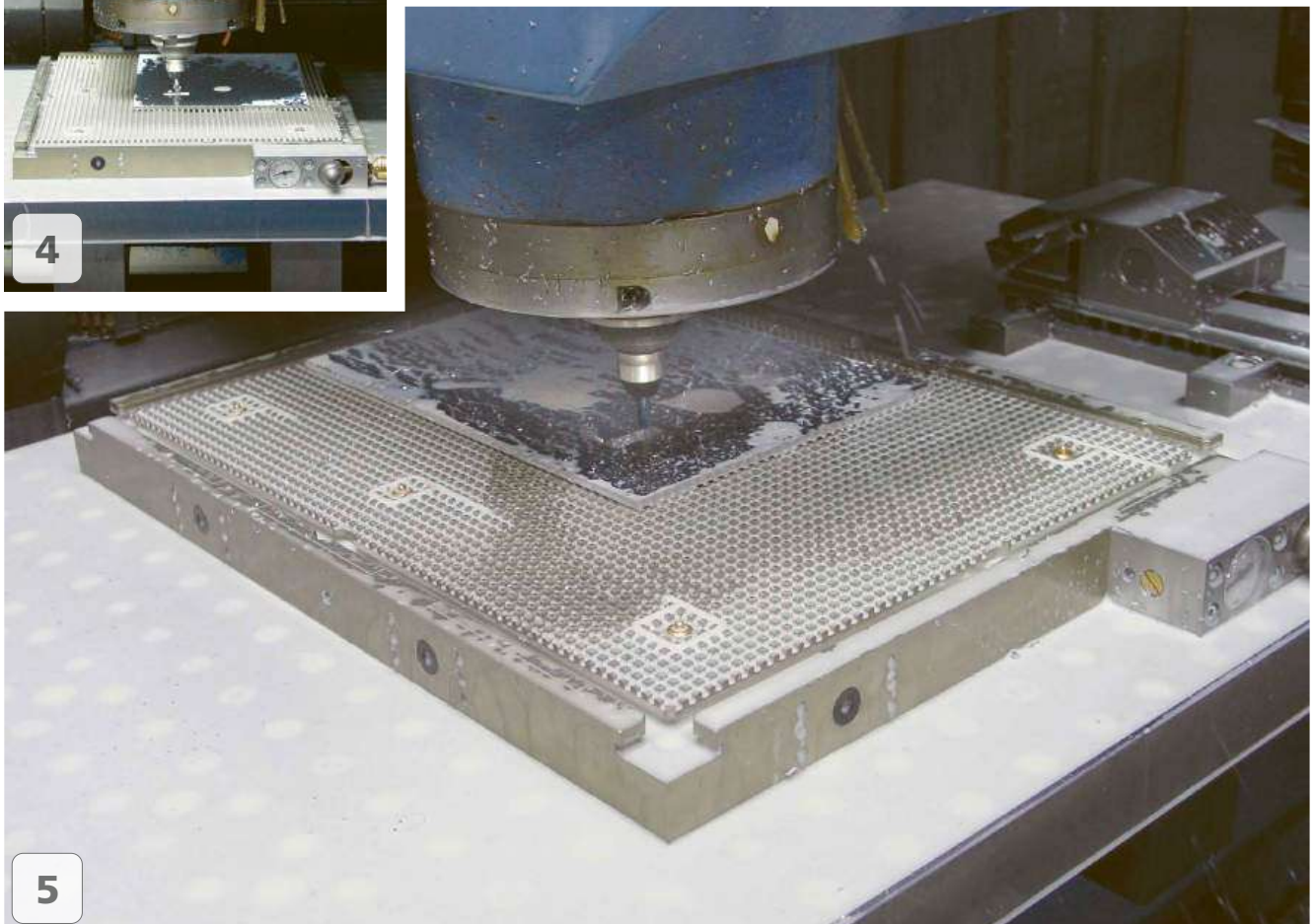
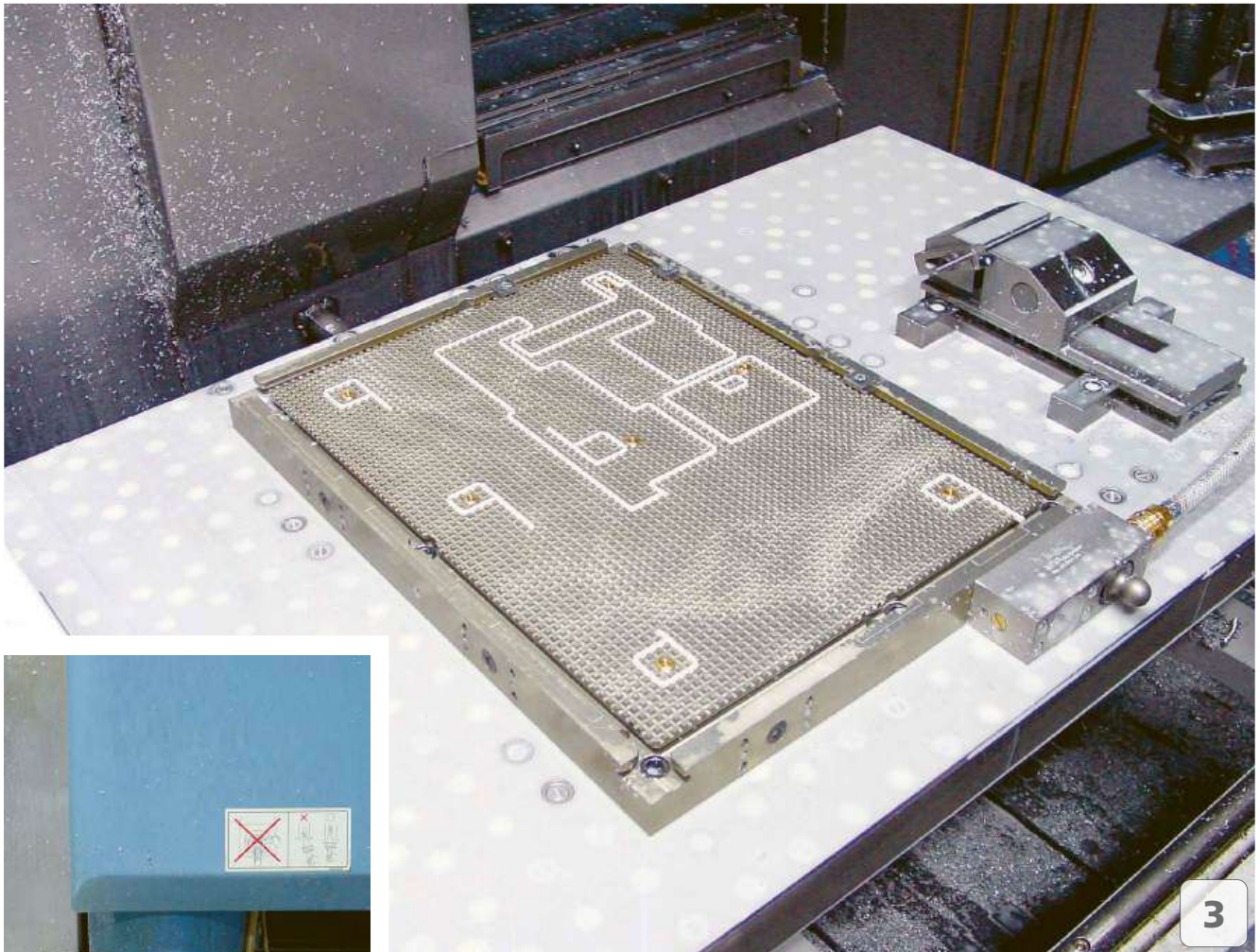


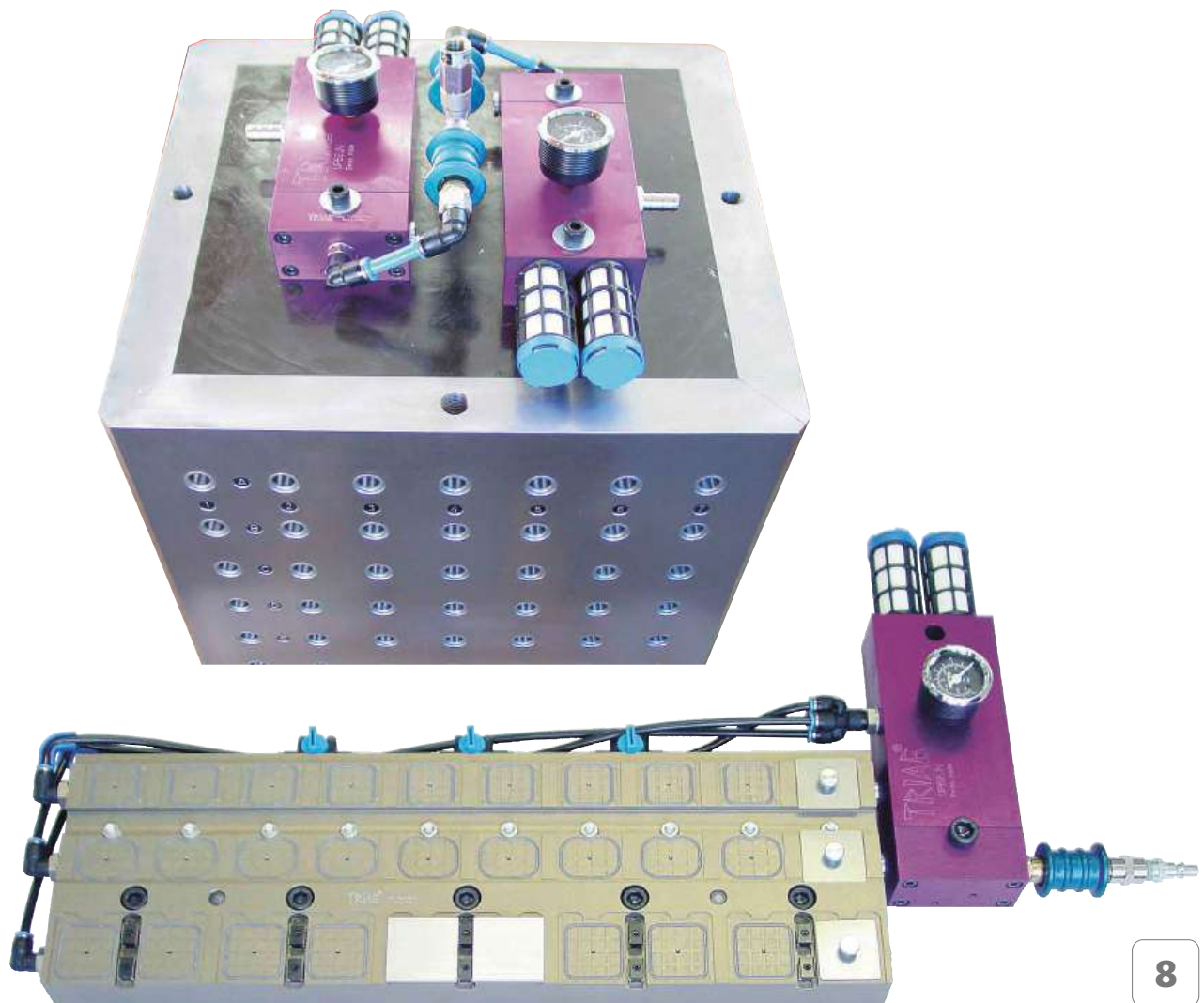
Ventil geschlossen / Valve sealed

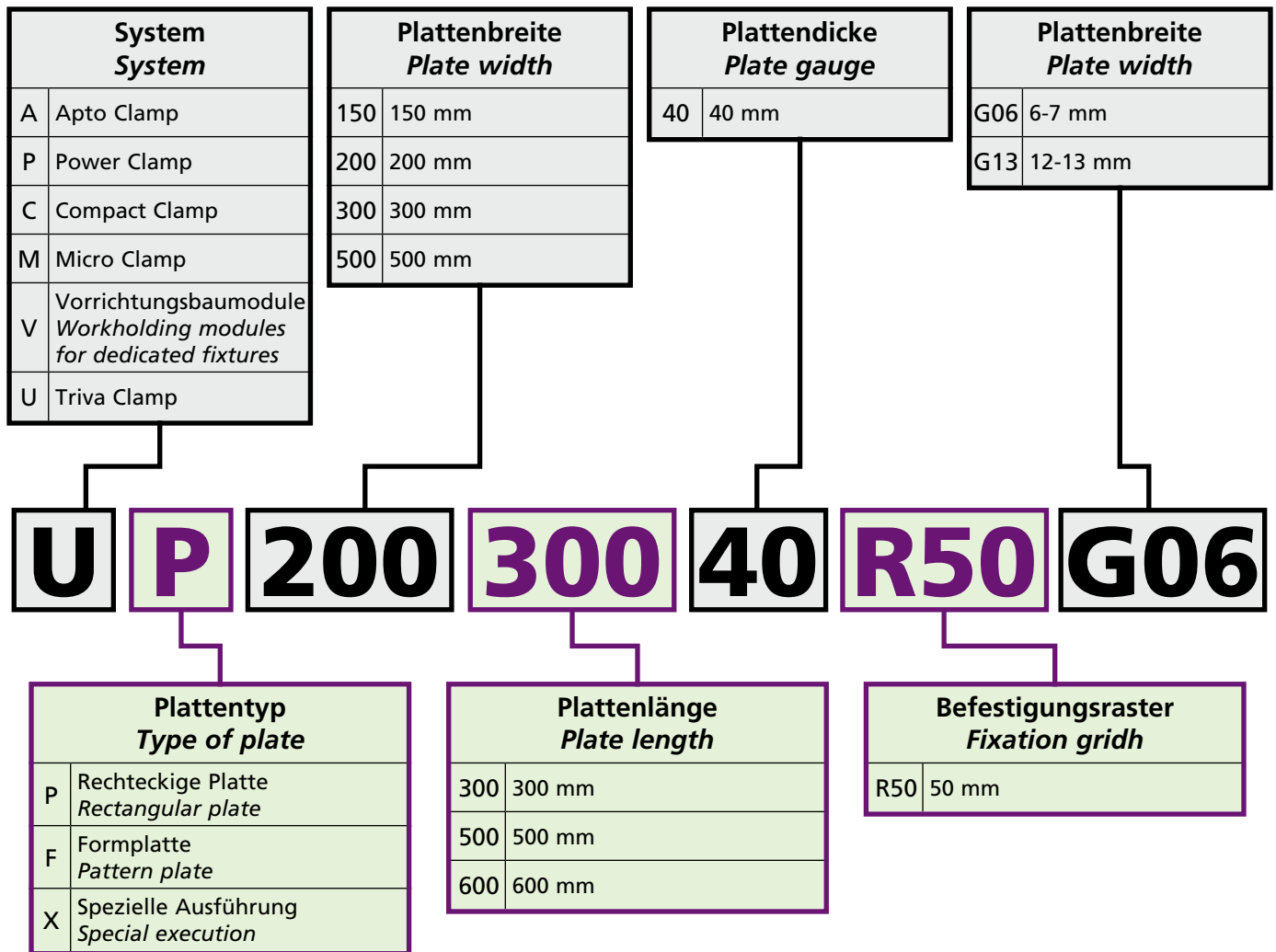


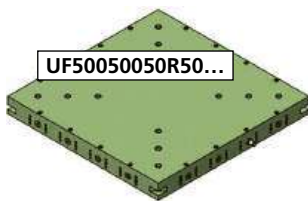
Werkstück eingelegt: Ventil offen
Workpiece inserted: Valve open









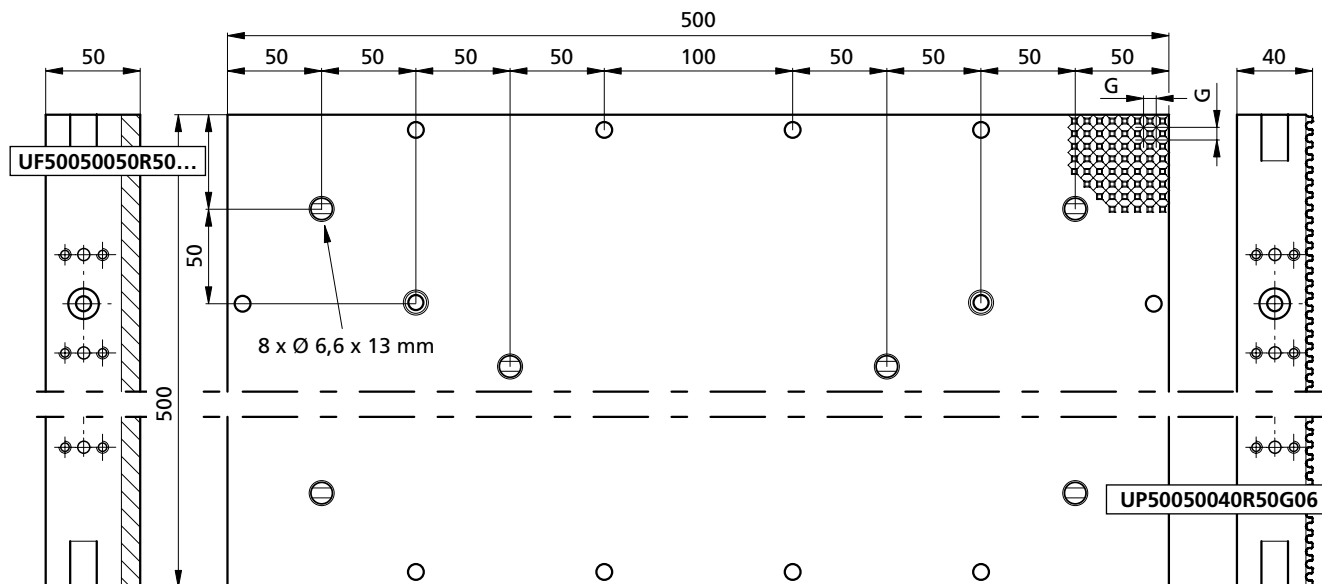


Formplatten

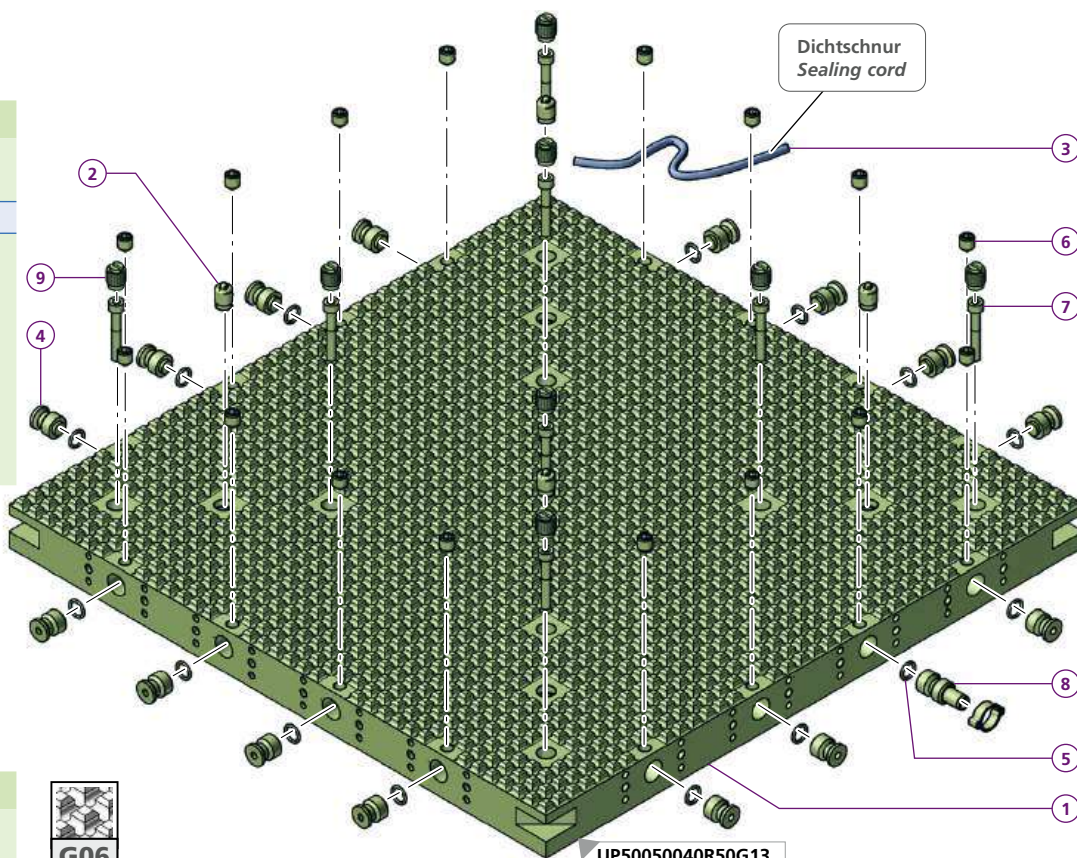
Für spezielle Werkstücke, die für das Spannen auf den Standardplatten ungeeignet sind, haben wir Rohplatten entwickelt, die bis zu 3 mal überfräst werden können. So lassen sich bis zu 3 verschiedene Werkstücke nacheinander bearbeiten.

Die plates

For special work pieces that are unsuitable for clamping on the standard plates, we have developed raw plates that can be milled again up to 3 times. This way, up to 3 different work pieces can be machined one after the other.



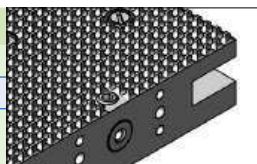
UP50050040R50G13	
1	1x TH160150
2	4x 0700100
3	1x 1110100
4	15x 0920000
5	16x 1111003
6	16x M10X12ISO4027
7	8x M6X45ISO4762
8	1x 0910001
9	8x 0700102
G	= 12,5 mm
kg	~24



UF50050050R50...	
1	1x TH160151
2	4x 0700100
3	1x
4	15x 0920000
5	16x 1111003
6	16x M10X12ISO4027
7	8x M6X45ISO4762
8	1x 0910001
9	8x 0700102
kg	~32,5



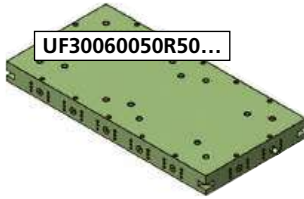
UP50050040R50G06	
1	1x TB160159
3	1x 1120100
G	= 6,5 mm
kg	~26



Profilfräser / Carbide end mills G13 / G06 p. 324

Dichtschnüre je nach Bedarf / Sealing cords as needed

Bestellbeispiel / Ordering example:
UP50050040R50G13 & 1x 1110100

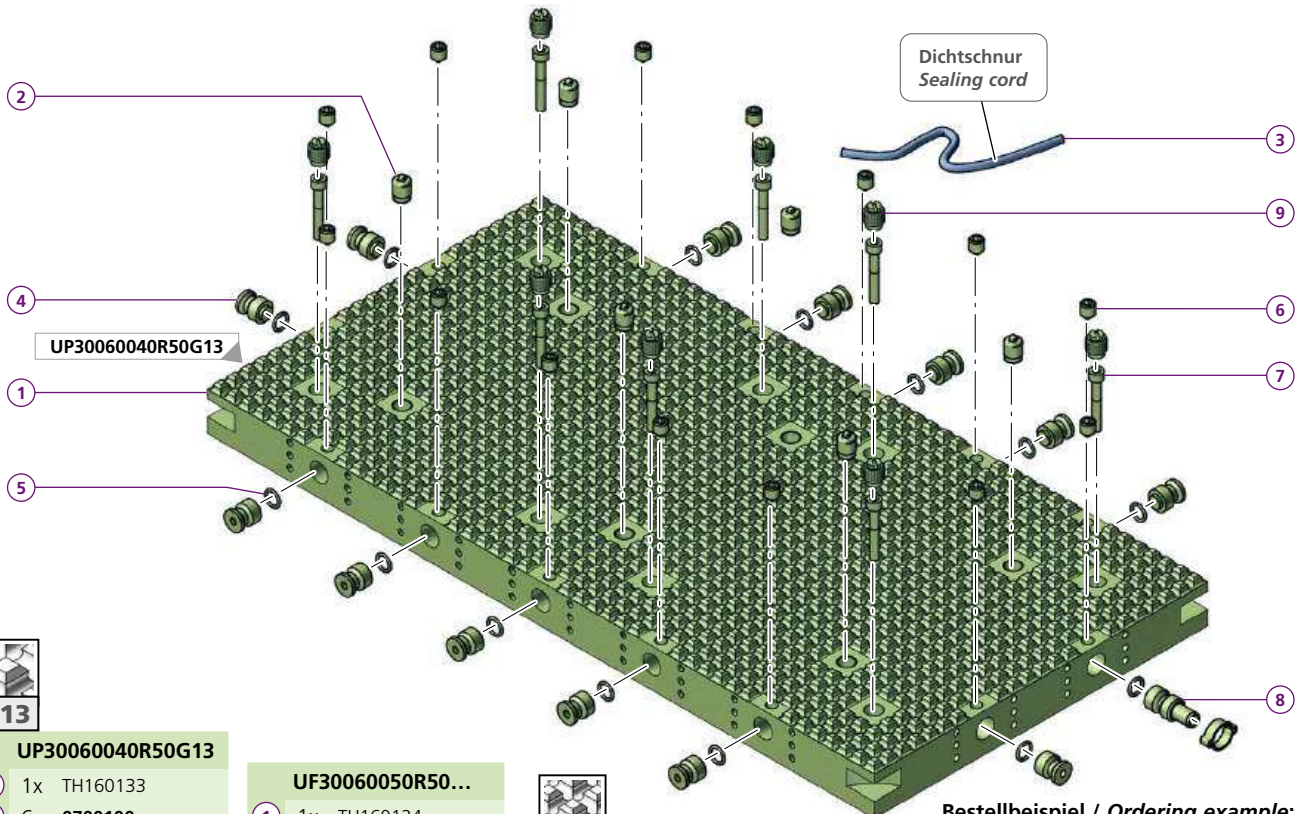
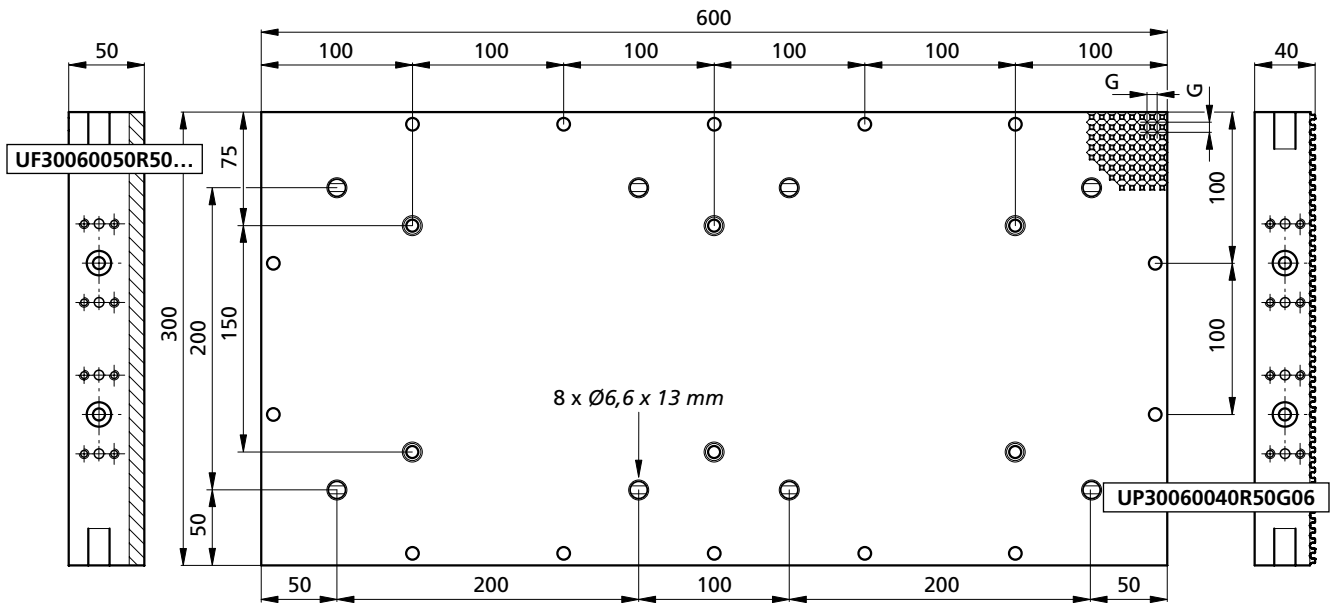


Formplatten

Für spezielle Werkstücke, die für das Spannen auf den Standardplatten ungeeignet sind, haben wir Rohplatten entwickelt, die bis zu 3 mal überfräst werden können. So lassen sich bis zu 3 verschiedene Werkstücke nacheinander bearbeiten.

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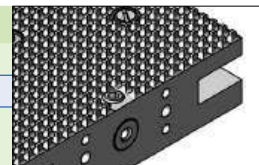


UP30060040R50G13	
1	1x TH160133
2	6x 0700100
3	1x 1110100
4	13x 0920000
5	13x 1111003
6	14x M10X12ISO4027
7	8x M6X45ISO4762
8	1x 0910001
9	8x 0700102
G	= 12,5 mm
kg	~18

UF30060050R50...	
1	1x TH160124
2	6x 0700100
3	1x
4	13x 0920000
5	13x 1111003
6	14x M10X12ISO4027
7	8x M6X45ISO4762
8	1x 0910001
9	8x 0700102
kg	~24,36



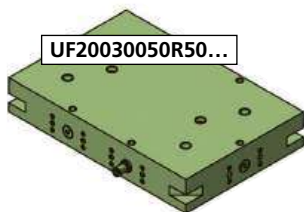
UP30060040R50G06	
1	1x TH120176
3	1x 1120100
G	= 6,5 mm
kg	~18,5



Bestellbeispiel / Ordering example:
UP30060040R50G13 & 1x 1110100

Profilfräser / Carbide end mills G13 / G06 p. 324

Dichtschnüre je nach Bedarf / Sealing cords as needed

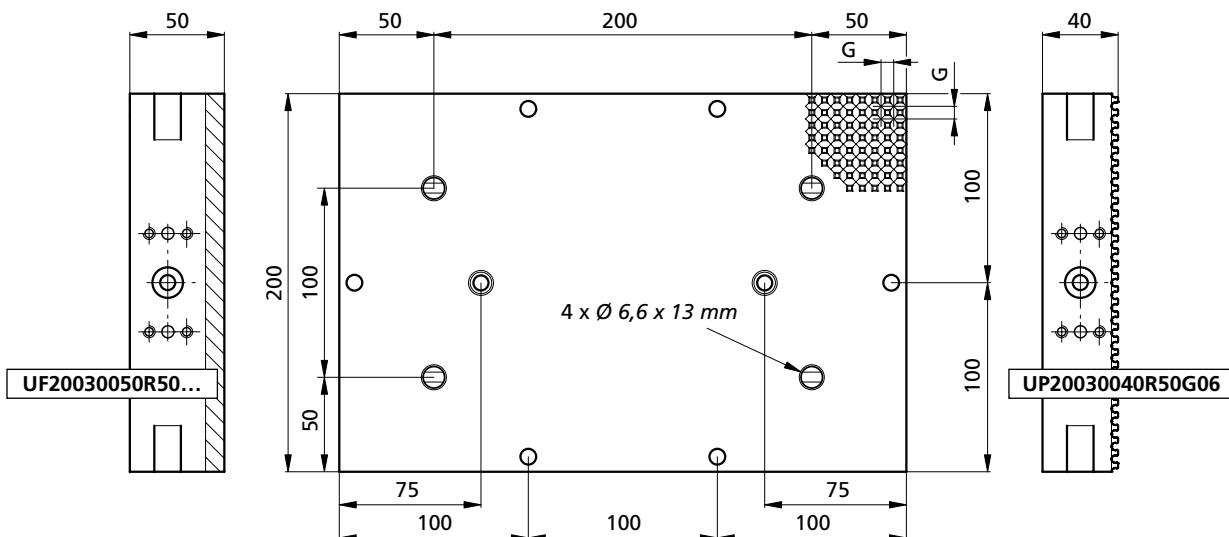


Formplatten

Für spezielle Werkstücke, die für das Spannen auf den Standardplatten ungeeignet sind, haben wir Rohplatten entwickelt, die bis zu 3 mal überfräst werden können. So lassen sich bis zu 3 verschiedene Werkstücke nacheinander bearbeiten.

Die plates

For special work pieces that are unsuitable for clamping on the standard plates, we have developed raw plates that can be milled again up to 3 times. This way, up to 3 different work pieces can be machined one after the other.



G13

UP20030040R50G13

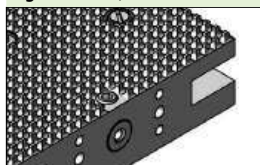
1	1x TH160135
2	2x 0700100
3	1x 1110100
4	5x 0920000
5	6x 1111003
6	6x M10X12ISO4027
7	4x M6X45ISO4762
8	1x 0910001
9	4x 0700102
G	= 12,5 mm
kg	~5,5



G06

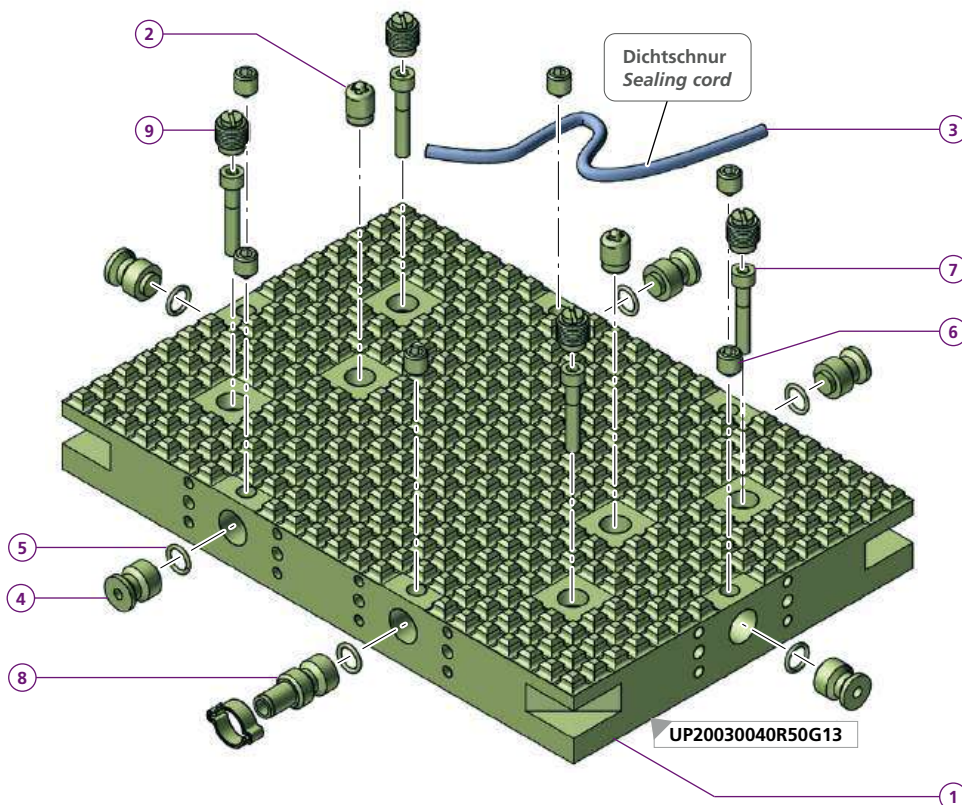
UP20030040R50G06

1	1x TH120175
3	1x 1120100
G	= 6,5 mm
kg	~6,0



UF20030050R50...

1	1x TH160136
2	2x 0700100
3	1x
4	5x 0920000
5	6x 1111003
6	6x M10X12ISO4027
7	4x M6X45ISO4762
8	1x 0910001
9	4x 0700102
kg	~8,09



Bestellbeispiel / Ordering example:
UP20030040R50G13 & 1x 1110100

Profilfräser / Carbide end mills G13 / G06 p. 324

Dichtschnüre je nach Bedarf / Sealing cords as needed

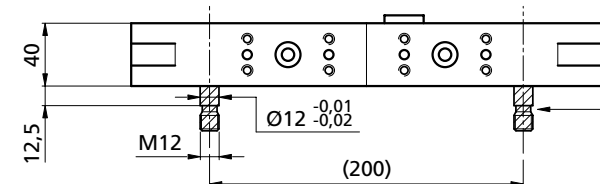


Formplatten

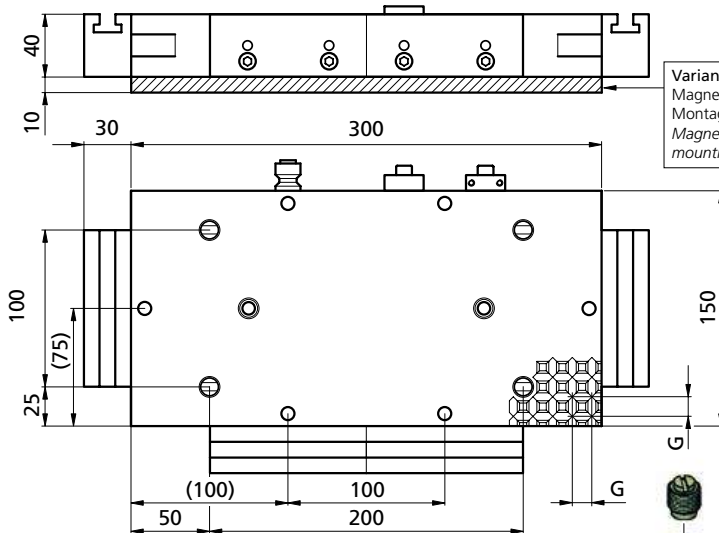
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Die plates

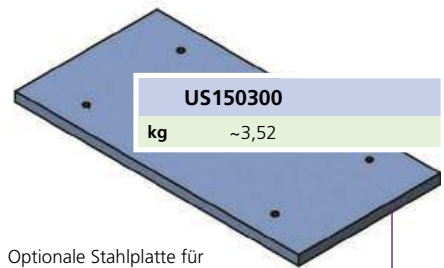
For special work pieces that are unsuitable for clamping on the standard plates, we have developed raw plates that can be milled again up to 3 times. This way, up to 3 different work pieces can be machined one after the other.



Variante / Variant:
Mechanische Befestigung auf Rasterplatte
Mechanical mounting on locking plate
R50 Ø12 M12



Variante / Variant:
Magnetische Befestigung auf Montageplatte
Magnetical fastening on mounting plate



Optionale Stahlplatte für Befestigung auf Magnetunterlage
Optional steel plate for fastening on magnetic basis



G13

UP15030040R50G13

1	1x	TH150942
2	2x	0700100
3	1x	1110100
4	5x	0920000
5	6x	1111003
6	6x	M10X12ISO4027
7	4x	M6X35ISO4762
8	1x	0910001
9	4x	0700102
10	4x	ADAPT6-12
G		= 12,5 mm
kg		~4,6



G06

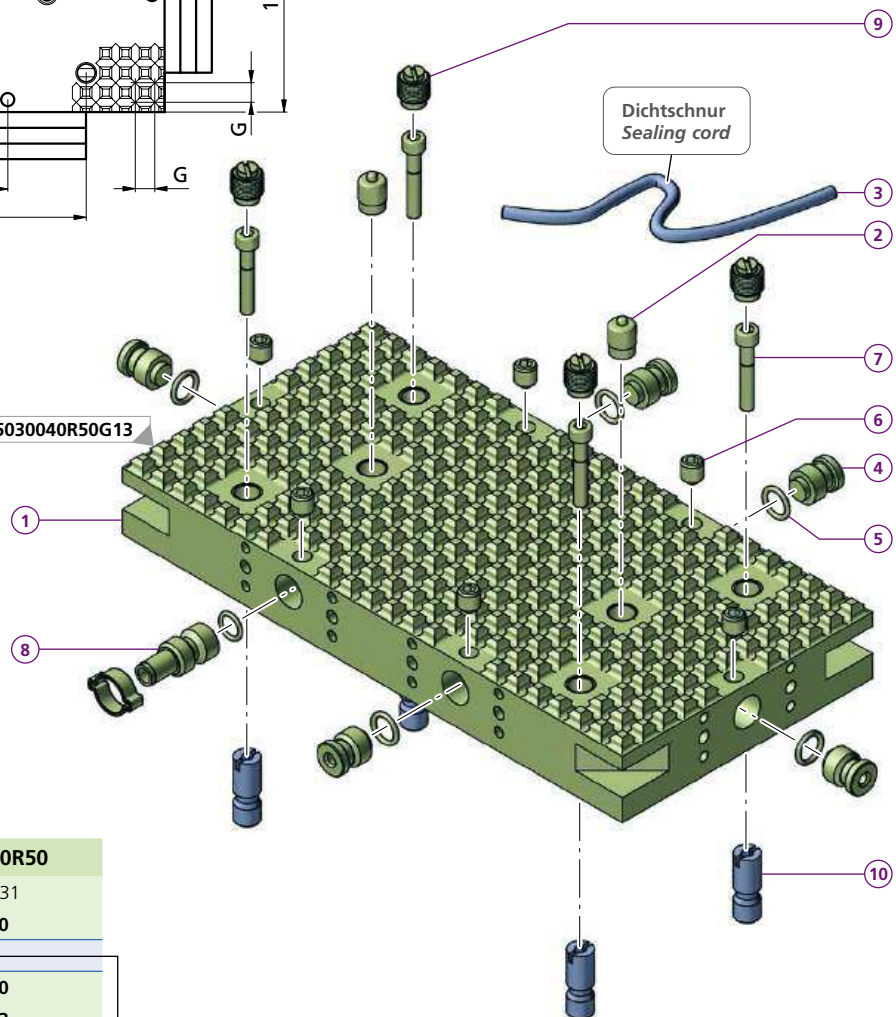
UP15030040R50G06

1	1x	TH160132
3	1x	1120100
G		= 6,5 mm
kg		~4,8

UF15030050R50

1	1x	TH160131
2	2x	0700100
3	1x	
4	5x	0920000
5	6x	1111003
6	6x	M10X12ISO4027
7	4x	M6X35ISO4762
8	1x	0910001
9	4x	0700102
kg		~6

UP15030040R50G13



Bestellbeispiel / Ordering example:

UP15030040R50G13 & 1x ADAPT6-12 & 1x 1110100

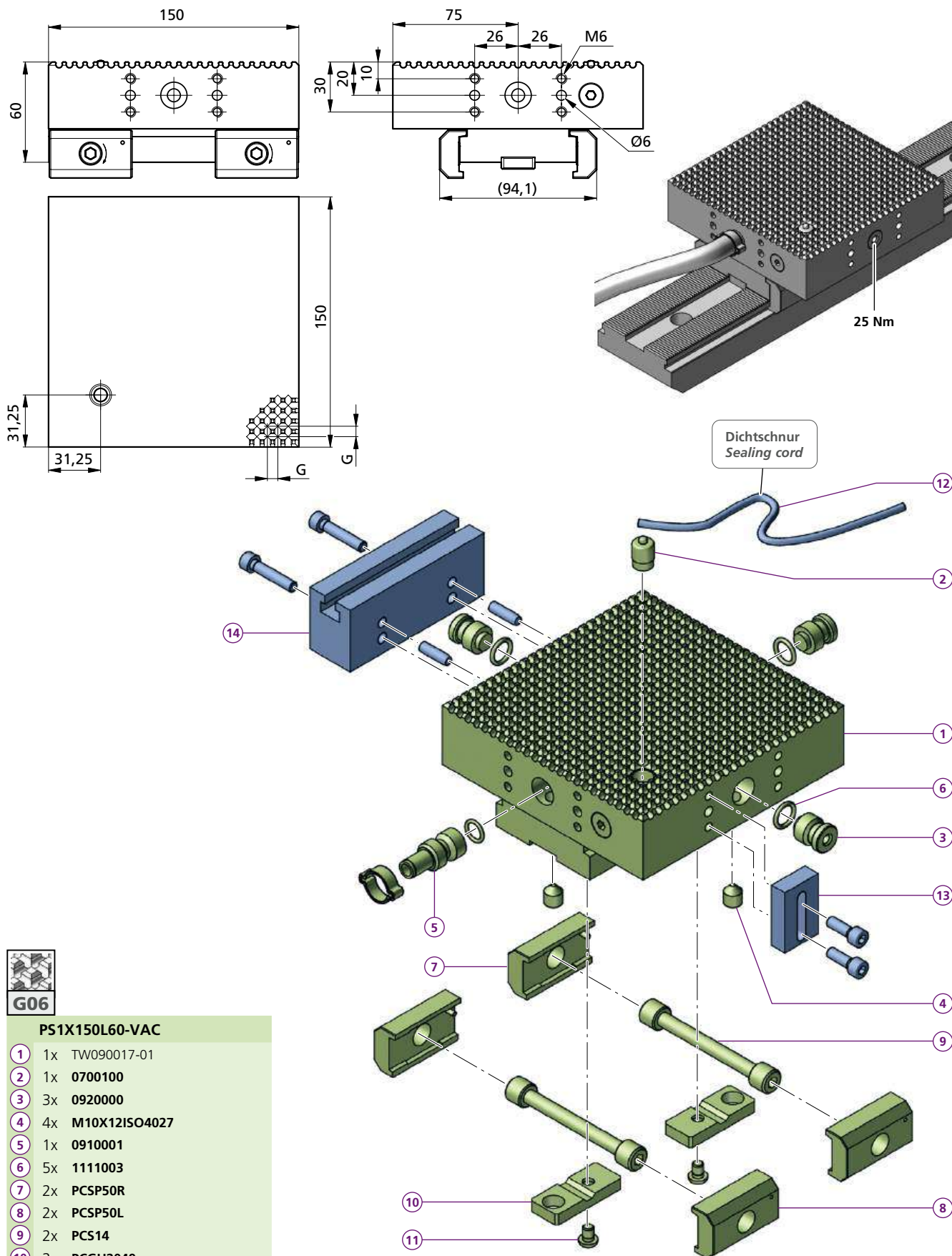
Profilfräser / Carbide end mills G13 / G06 p. 324

Dichtschnüre je nach Bedarf / Sealing cords as needed

Vakuum-Modul für powerCLAMP

Vacuum module for powerCLAMP

PS1X150L60-VAC **trivaCLAMP**



PS1X150L60-VAC

- 1x TW090017-01
- 1x 0700100
- 3x 0920000
- 4x M10X12ISO4027
- 1x 0910001
- 5x 1111003
- 2x PCSP50R
- 2x PCSP50L
- 2x PCS14
- 2x PCGU2049
- 2x M6X8ISO7380

1x 1120100 p. 324

1x UA182540 p. 322

1x UT1003040

G = 6,5 mm

kg ~3,6

Bestellbeispiel / Ordering example:

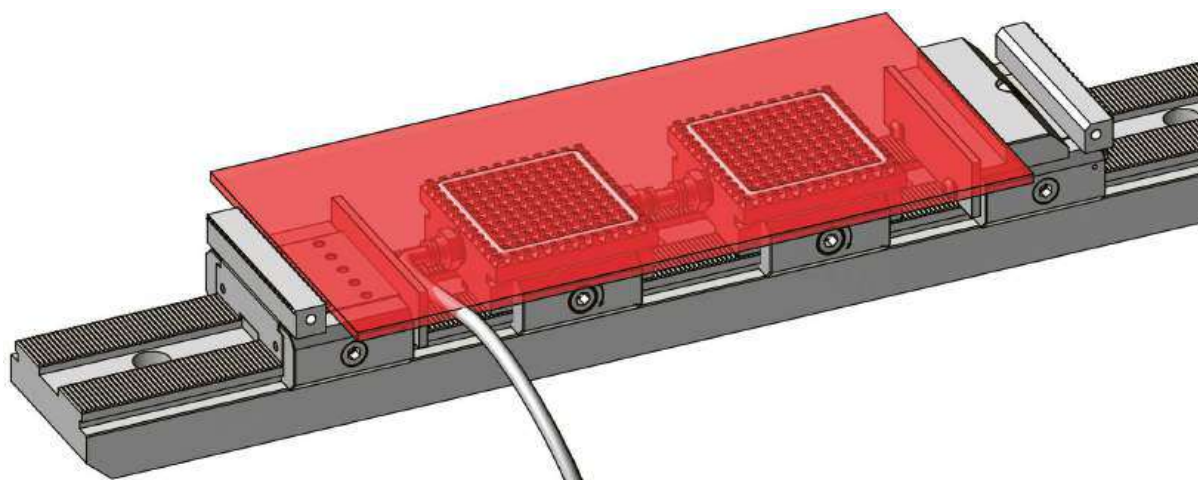
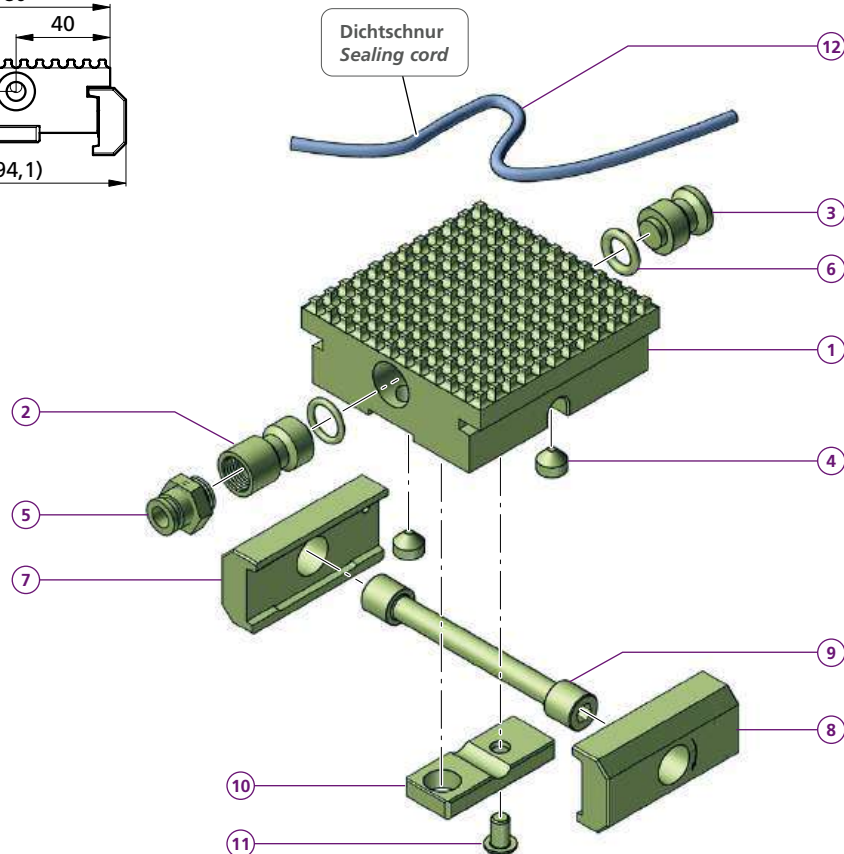
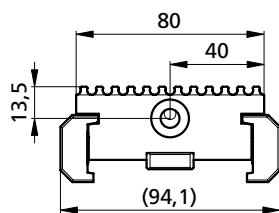
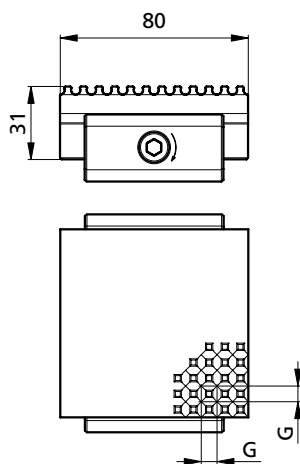
PS1X150L60-VAC & 1x 1120100 & 1x UA182540 & 1x UT1003040

Separat bestellen / Order separately

Vakuum-Modul für powerCLAMP Vacuum module for powerCLAMP

PS1X80L31-VAC

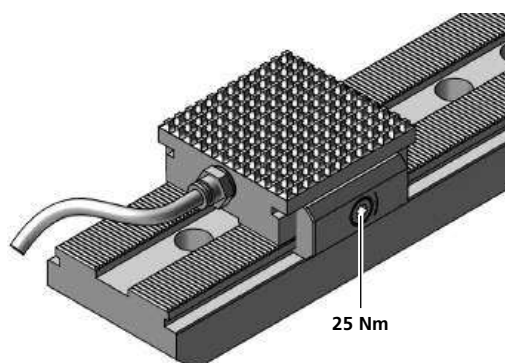
trivaCLAMP



PS1X80L31-VAC

- ① 1x TH140263
- ② 1x UZV16301/4
- ③ 1x 0920000
- ④ 2x M10X8DIN914
- ⑤ 1x QSG1/4-8
- ⑥ 2x 1111003
- ⑦ 1x PCSP60R
- ⑧ 1x PCSP60L
- ⑨ 1x PCS14
- ⑩ 1x PCGU2049
- ⑪ 1x M6X8ISO7380
- ⑫ 1x 1120100

G = 6,5 mm
kg ~0,62



Bestellbeispiel / Ordering example: PS1X80L31-VAC & 1x 1120100

Separat bestellen / Order separately

UP15030040R50 G06 / G13

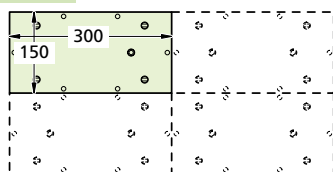
Platte / Plate

1 x = 150 x 300

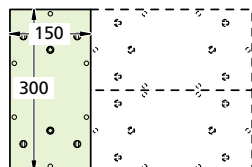
2 x = 150 x 600

2 x = 300 x 300

4 x = 300 x 600



3 x = 300 x 450



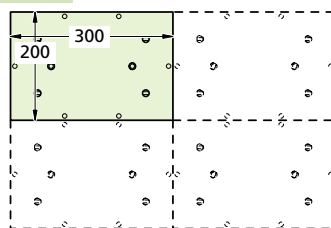
UP20030040R50 G06 / G13

Platte / Plate

1 x = 200 x 300

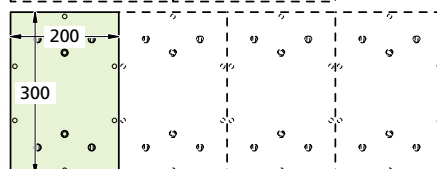
2 x = 200 x 600

4 x = 400 x 600



3 x = 300 x 600

4 x = 300 x 800



UP30060040R50 G06 / G13

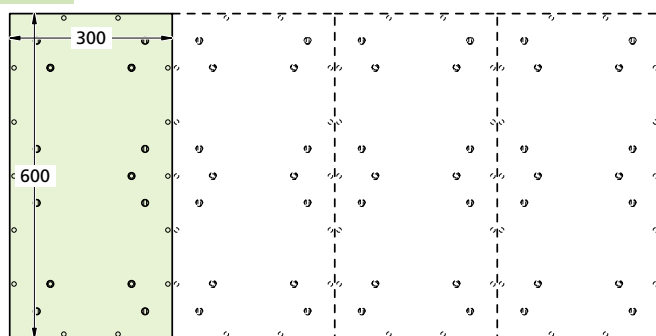
Platte / Plate

1 x = 300 x 600

2 x = 600 x 600

3 x = 600 x 900

4 x = 600 x 1200



UP30060040R50 G06 / G13

Platte / Plate

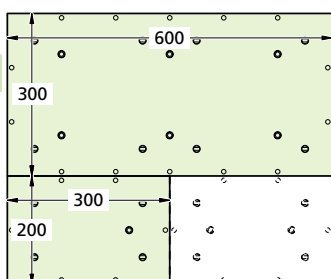
1 x = 300 x 600

UP20030040R50 G06 / G13

Platte / Plate

2 x = 200 x 300

= 500 x 600



UP30060040R50 G06 / G13

Platte / Plate

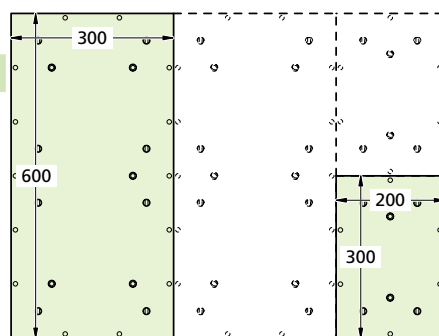
2 x = 300 x 600

UP20030040R50 G06 / G13

Platte / Plate

2 x = 200 x 300

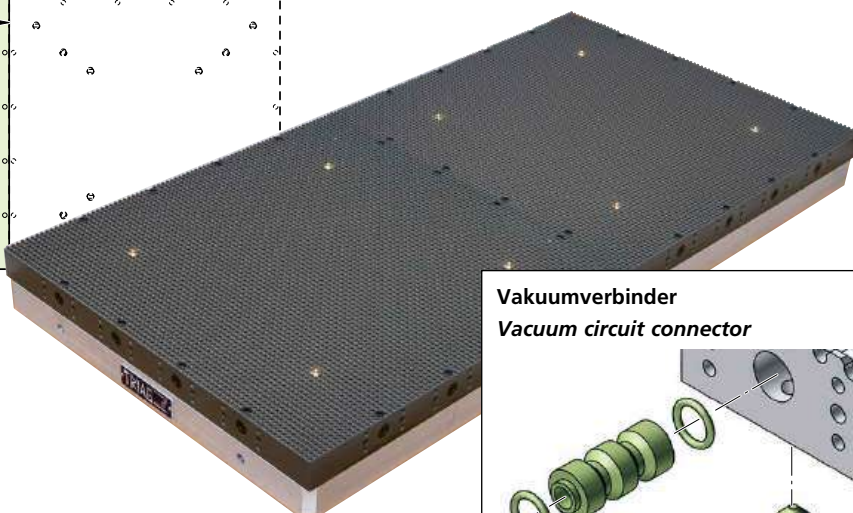
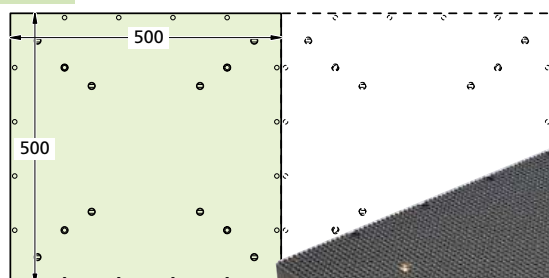
= 600 x 800



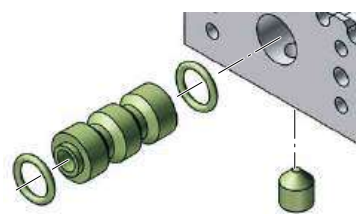
UP50050040R50 G06 / G13

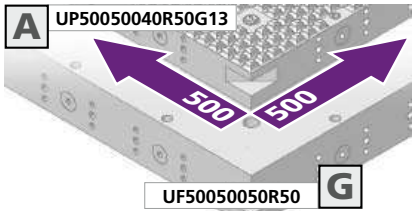
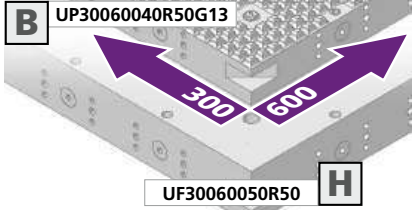
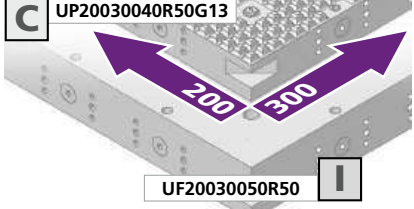
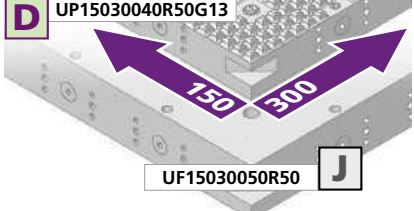
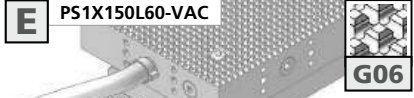
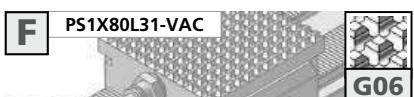
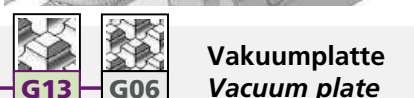
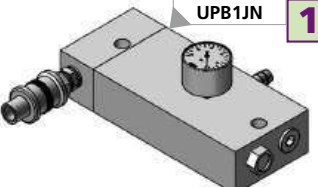
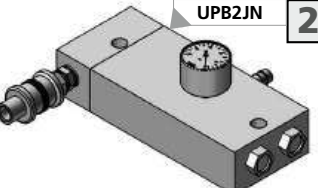
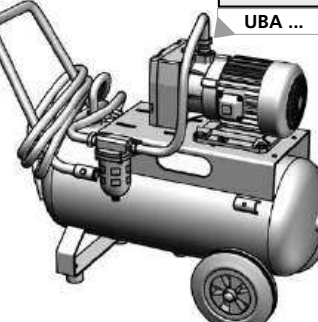
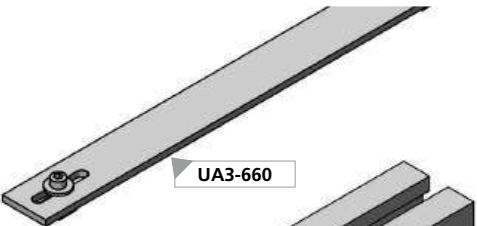
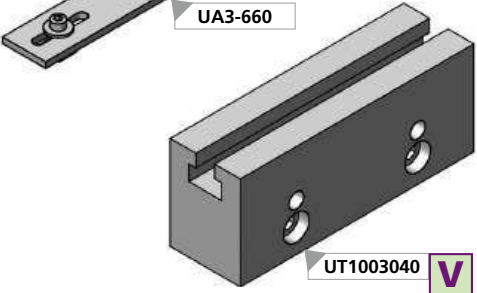
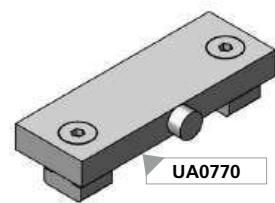
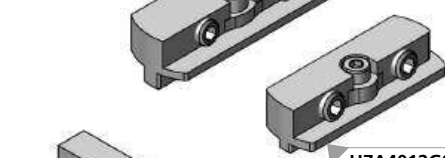
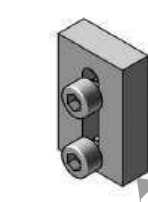
Platte / Plate

2 x = 500 x 1000

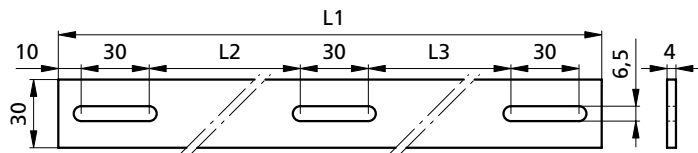


Vakuumverbinder
Vacuum circuit connector



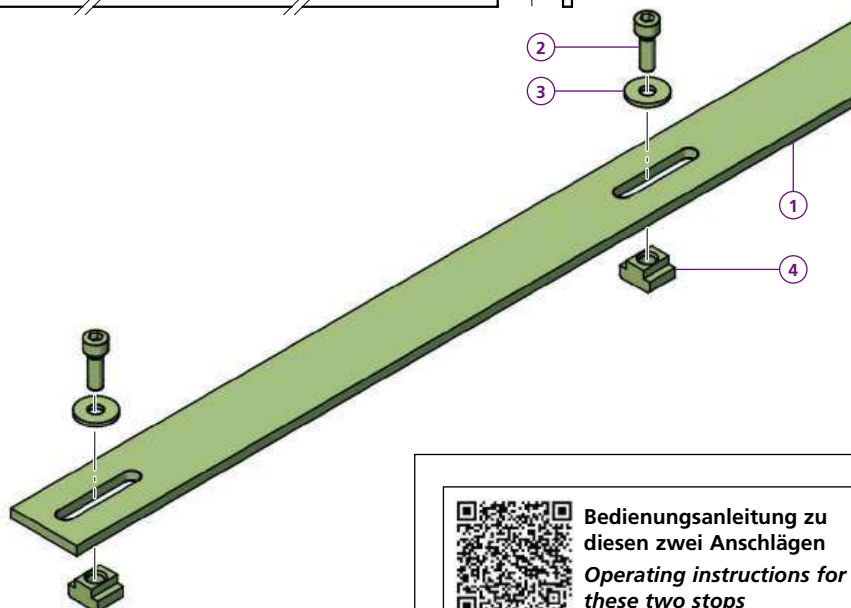
UPSET	D	1	V	G...
 A UP50050040R50G13 500 500 UF50050050R50 G  B UP30060040R50G13 300 600 UF30060050R50 H  C UP20030040R50G13 200 300 UF20030050R50 I  D UP15030040R50G13 150 300 UF15030050R50 J  E PS1X150L60-VAC G06  F PS1X80L31-VAC G06	 G13 G06 Vakuumpalte Vacuum plate	 1 UPB1JN  2 UPB2JN  3-5 UBA ... Vakuum erzeugen Generate vacuum	 UA3-660  UT1003040 V  UA0770  UZA5015G13  UZA4012G06  UA182540 Zubehör Accessories	Zu jedem SET werden zusätzlich 3 m Vakuumschlauch (0941000) und 25 m Dichtschnur mitgeliefert (1120100) Ø 4 oder (1110100) 6 mm inkl. (2 x 10100024). Each SET is supplied with an additional 3 m vacuum hose (0941000) and 25 m sealing cord (1120100) Ø 4 or (1110100) 6 mm incl. (2 x 10100024).
A 500 x 500 (UP50050040R50 G06 / G13) B 300 x 600 (UP30060040R50 G06 / G13) C 200 x 300 (UP20030040R50 G06 / G13) D 150 x 300 (UP15030040R50 G06 / G13) E 150 x 60 (PS1X150L60-VAC) F 80 x 31 (PS1X80L31-VAC) G 500 X 500 (UF50050050R50) H 300 X 600 (UF30060050R50) I 200 X 300 (UF20030050R50) J 150 X 300 (UF15030050R50)	1 UPB1JN 2 UPB2JN 3 UBA106230300 4 UBA106110250 5 UBA318400550	Z 2x UT1003040 1x UA182540 1x UA3-660 Y 2x UT1003040 1x UA182540 1x UA3-560 X 2x UT1003040 1x UA182540 1x UA3-360 W 2x UT1003040 1x UA182540 1x UA2-260 V 2x UT1003040 1x UA182540 2x UA0770 U 4x UZA4012G06 T 4x UZA5015G13	Dichtschnur Sealing cord 25 m: 1120100 Vakuumschlauch Vacuum hose 3 m: 0941000	
Bestellbeispiel / Ordering example: UPSETD1VG13				

Anschlagleisten
Stop rails



UA3-660		UA3-560	
1	1x TH160274	1	1x TH160275
2	3x M6X12ISO4762	2	3x M6X12ISO4762
3	3x 6,4 DIN9021	3	3x 6,4 DIN9021
4	3x SM1135M6X8	4	3x SM1135M6X8
L1	= 660 mm		= 560 mm
L2	= 270 mm		= 225 mm
L3	= 280 mm		= 225 mm
kg	~0,6		~0,5

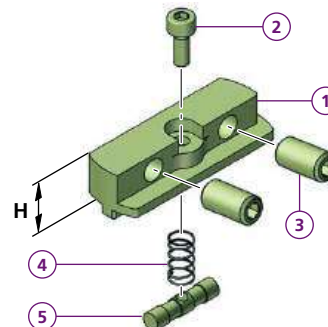
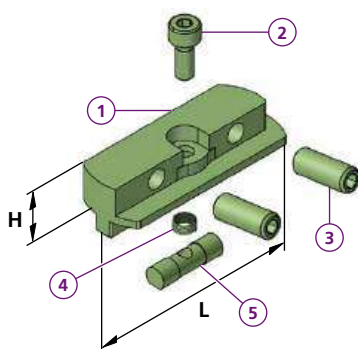
UA3-360		UA2-260	
1	1x TH160277	1	1x TH160278
2	3x M6X12ISO4762	2	2x M6X12ISO4762
3	3x 6,4 DIN9021	2	2x 6,4 DIN9021
4	3x SM1135M6X8	2	2x SM1135M6X8
L1	= 360 mm		= 260 mm
L2	= 120 mm		= 180 mm
L3	= 130 mm		
kg	~0,32		~0,2



Bedienungsanleitung zu diesen zwei Anschlägen
Operating instructions for these two stops

Anschlag
Stop rail

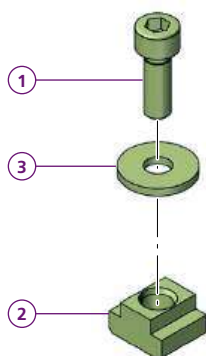
UZA5015G13	
1	1x TB170561
2	1x M4X10ISO4762
3	2x M6x16 DIN913
4	1x TN100036
5	1x TB170562
L	= 50 mm
H	= 9 mm
kg	~0,04



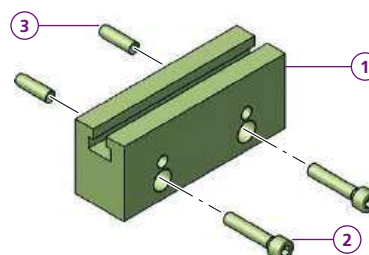
UZA4012G06	
1	1x TB170558
2	1x M3X8ISO4762
3	2x M6X12 DIN913
4	1x TN100036
5	1x TB170559
L	= 40 mm
H	= 8,5 mm
kg	~0,03

T-Nuten Stein
T-nuts

0802000-SET	
1	1x M6X12ISO4762
2	1x SM1135M6X8
3	1x 6,4 DIN9021
kg	~0,03



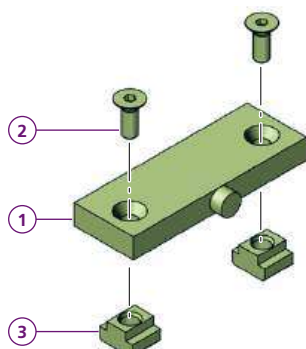
Ansetzbare T-Nuten
Attachable T-slots



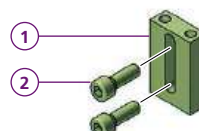
UT1003040	
1	1x TH160227
2	2x M6X25ISO4762
3	2x 6X20-B ISO8734
kg	~0,4

Seiten-/Wendeanschlag
Reversible stop gage

UA0770	
1	1x TH160259
2	2x TN100899
3	2x SM1135M6X8
kg	~0,14



Seitenanschlag
Side lay



UA182540	
1	1x TH160098
2	2x M6X18ISO4762
kg	~0,1

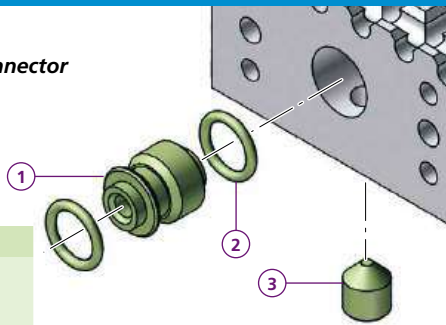
Vakuumverbinder Vacuum circuit connector

Koppelemente Link-up plug

trivaCLAMP

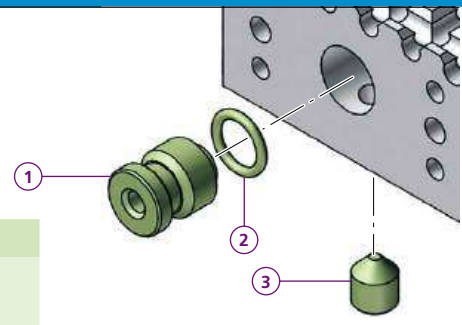
Vakuumverbinder
Vacuum circuit connector

0930000
1x TK110401
2x 1111003
1x M10X12ISO4027
kg ~0,02



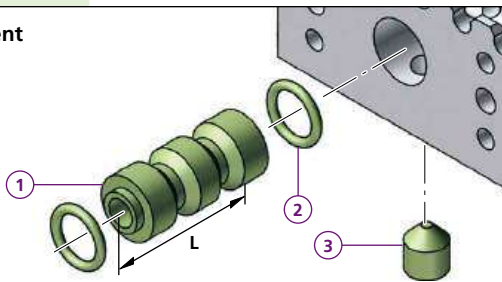
Blindstopfen
Blind plug

0920000
1x TK110402
1x 1111003
1x M10X12ISO4027
kg ~0,03



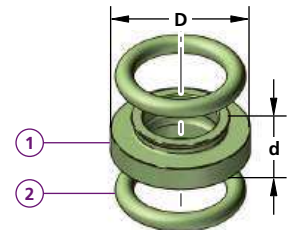
Koppelement
Link-up plug

0910000	0910080
1x TK110403	1x TK140763
2x 1111003	2x 1111003
1x M10X12ISO4027	1x M10X12ISO4027
L = 40 mm	L = 80 mm
kg ~0,03	kg ~0,04



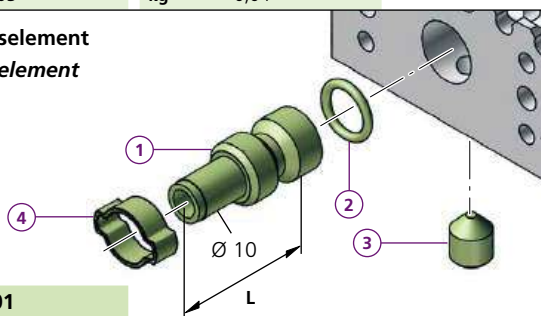
Vakuumverbinder
Vacuum circuit connector

TS150487
1x TS150487
2x TN100682
d = 5,8 mm
D = 15 mm



Anschlüsselement
Adapter element

0910001
1x TK110404
1x 1111003
1x M10X12ISO4027
1x 10100024
L = 40 mm
kg ~0,04



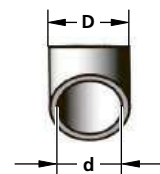
Vakuumschlauch (per Laufmeter)
Vacuum hose (per running meter)

D = 8 mm für Vakuumanbindung von Platte zu Platte
for vacuum supply from plates to accessories

D = 16 mm für Vakuumverbindung von Pumpe zu Platten
for vacuum supply from pump to plate



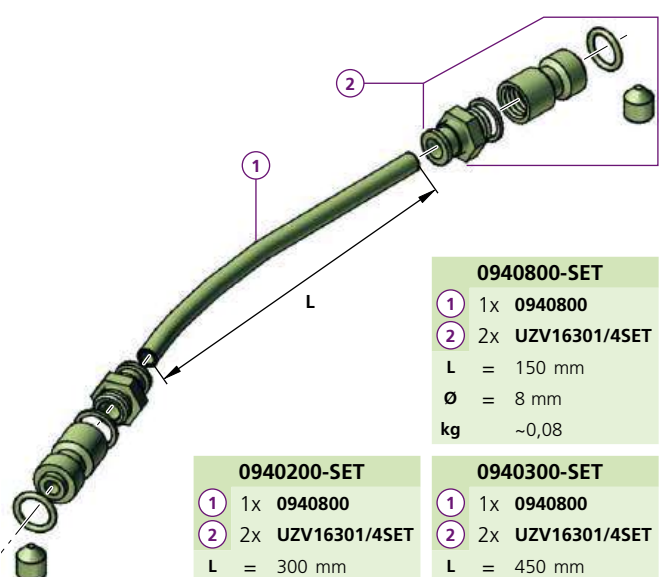
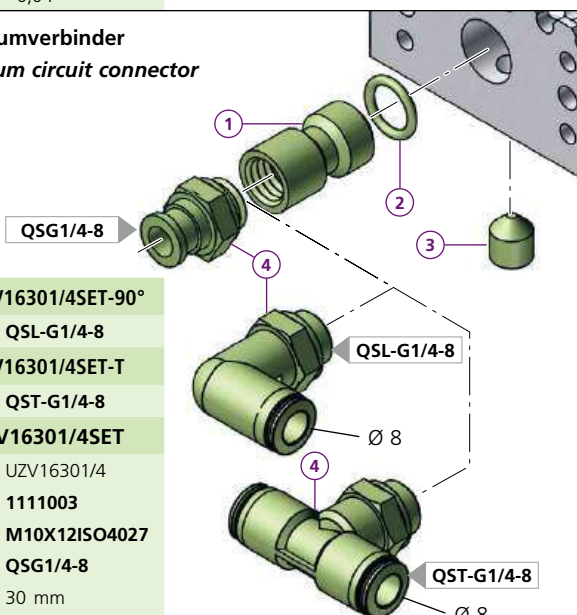
0940800	0941000
D = 8 mm	D = 16 mm
d = 5,5 mm	d = 10 mm



Verbindungsschlauch mit Koppelementen
Connector-tube with link-ups

Vakuumverbinder
Vacuum circuit connector

UZV16301/4SET-90°
1x QSL-G1/4-8
UZV16301/4SET-T
1x QST-G1/4-8
UZV16301/4SET
1x UZV16301/4
1x 1111003
1x M10X12ISO4027
1x QSG1/4-8
L = 30 mm
kg ~0,024



0940800-SET
1x 0940800
2x UZV16301/4SET
L = 150 mm
Ø = 8 mm
kg ~0,08

0940200-SET
1x 0940800
2x UZV16301/4SET
L = 300 mm
Ø = 8 mm
kg ~0,08

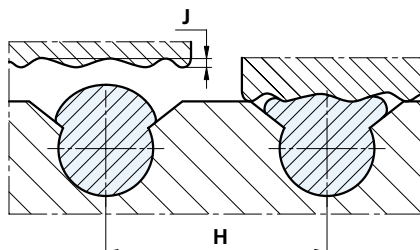
0940300-SET
1x 0940800
2x UZV16301/4SET
L = 450 mm
Ø = 8 mm
kg ~0,09

Dichtschnüre aus Silikon-Gummi

Beständig gegen Öle, Säuren, Emulsionen, Dielektrika, ionisiertes Wasser und Wärme bis 200°C

Silicone-rubber sealing cord

Resistant to oils, acids, coolants, dielectrics, activated water (EDM) and heat up to 200°C

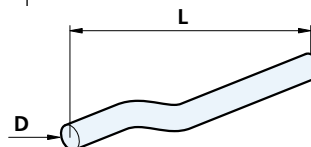


Dichtschnüre aus Gummi

- ölbeständig
- für spezielle Vorrichtungen

Rubber sealing cord

- oil resistance
- to fit special devices



G13



G06

weiss / white

1110100	1120100	1120100M	1130000
L = 25 m	L = 25 m	L = 25 m	L = 5 m
D = 6,5 mm ±0,5	D = 4 mm (4,3-4,6 mm)	D = 4 mm (4,0-4,3 mm)	D = 3 mm
J = max. 0,6 mm	J = max. 0,4 mm	J = max. 0,3 mm	
H = 12-13 mm	H = 6-7 mm	H = 6-7 mm	



G13

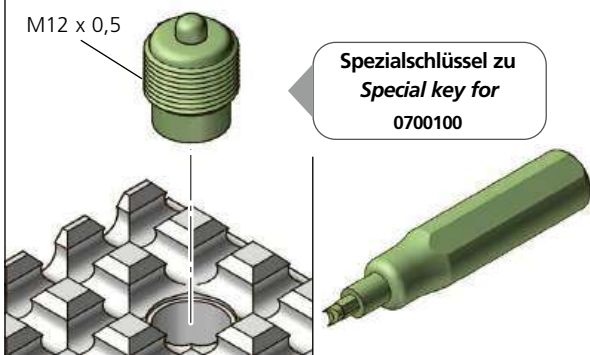
schwarz / black

weiss / white

1110100S	1110100SP	0130001	0130002
L = 25 m	L = 25 m	L = 1 m	L = 1 m
D = 6,0-6,5 mm	D = 6,6-7,0 mm	D = 2,15 mm	D = 1,65 mm
J = max. 0,6 mm	J = max. 0,6 mm		
H = 12-13 mm	H = 12-13 mm		

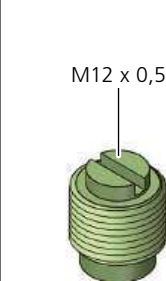
Triva Clamp Ventil / Triva Clamp valve

Montage von oben
Mounting from above



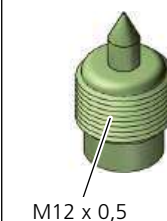
0700100	kg	~0,01	Triva Bit	kg	~0,14
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Ventil-Blindstopfen
Valve blind plug



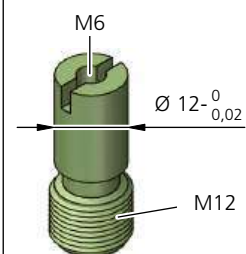
0700102	kg	~0,01
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Montage von unten, für Spezialvorrichtungen
Mounting from bottom side, for special devices



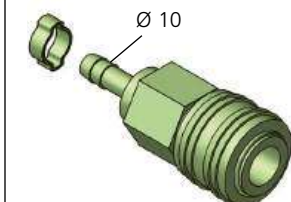
0700200	kg	~0,01
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Reduktionstück für Rasterplatten M12/12^{f7} auf M6
Adapter piece for Gridplates from M12/12^{f7} to M6



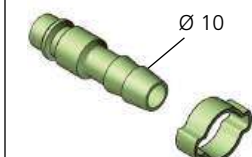
ADAPT6-12	kg	~0,02
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Schnellkupplung mit Bride Quick hose coupling including clip



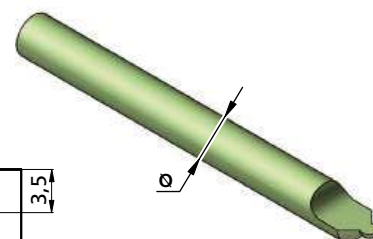
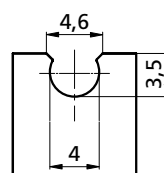
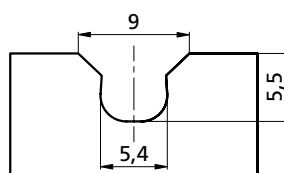
0520000	kg	~0,14
---------	----	-------

Schlauchnippel mit Bride Hose nozzle including clip



0941010	kg	~0,03
---------	----	-------

VHM Profilfräser für Vorrichtungsplatten Carbide end mills for plate for dedicated fixtures



G13

VFP10065L100 (Ø 6,5 mm)

Ø	= 10
L	= 100



G06

VFP08040L90 (Ø 4 mm)

Ø	= 8
L	= 90

**Rotationspumpe auf Speichertank
für Arbeiten mit Kühlwasser**

Aggregat ausgerüstet mit:

- Vakuumpumpe, Enddruck 20 mbar
- Wasserabscheider mit Sintermetallfilter
- Fahrenbarem 40 Liter Behälter als Vakuumspeicher und Wasserreservoir
- 5 Meter Vakuumschlauch
- für 3-Phasenbetrieb wartungsfreie Drehstrommotoren
- für 1-Phasenbetrieb wartungsfreie Motoren mit Anlauf-Kondensatoren.

für Vakuumaufspannflächen:

- zusammenhängend, oder auf mehrere einzelne Platten verteilt

**Rotary pumptank assembly Pump assembly
for machining with flowing coolant**

Assembly equipped with:

- Vacuum pump, pressure limit 20 mbar
- Liquid separator with sintered metall filter
- Pump mounted on a movable 40l (13gal) tank being both, vacuum reservoir and water collector
- 5 m (6.5ft) Vacuum hose
- maintenance-free motors for 3 phase operating
- single phase motors with capacitor starter.

To cover maximum holding surface:

- built by plate or plate-assembly, or display over several single plates mounted to various machine-tools

Technische Daten
Technical data

Saugkraft
Suction capacity

Spannfläche bis / Surface up to 1,8 m²

3-Phasen / Triple phase 400 V ± 10%, 50/60 Hz, 250/300 W	6 / 7,2 m³/h	UBA306400250
1-Phasen / Single phase 230 V ± 10%, 50/60 Hz, 300/360 W	6 / 7,2 m³/h	UBA106230300
1-Phasen / Single phase 110 V ± 10%, 60 Hz, 250/300 W	6 / 7,2 m³/h	UBA106110250

Spannfläche bis / Surface up to 5,0 m²

3-Phasen / Triple phase 400 V ± 10%, 50/60 Hz, 550/660 W	18 / 21 m³/h	UBA318400550
1-Phasen / Single phase 230 V ± 10%, 50/60 Hz, 600/720 W	18 / 21 m³/h	UBA118230600

Separater Tank / Separate tank

UBT40
Vol. 40l

Öl für Vakuumpumpe / Oil for vacuum pump

UB1-OIL
Vol. 1l



Bedienungsanleitung zu diesem
Vakuumpumpen
Operating instructions for this
vacuum pump

➔ Grössere Pumpen auf Anfrage
➔ Larger pumps on demand

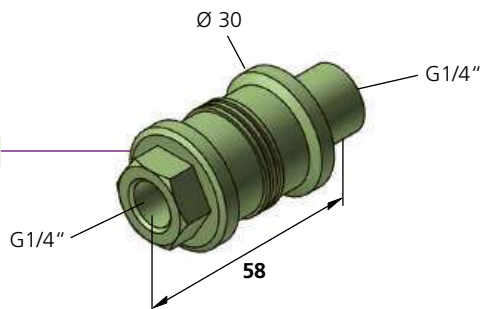
Schaltventil und Druckwächter

Control unit with pressure sensor switch

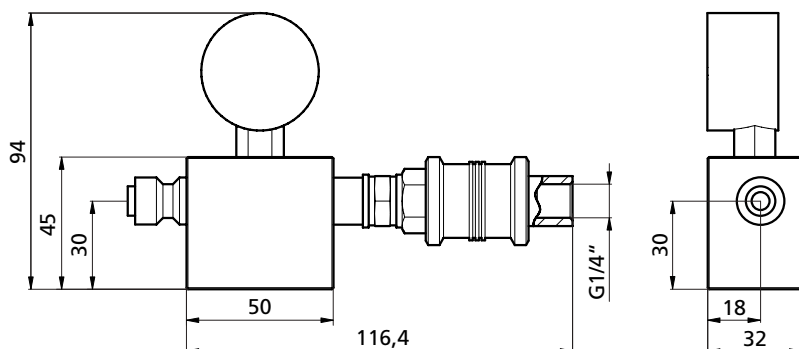
trivaCLAMP

Schaltventil
Control unit

TN100668 kg ~0,096



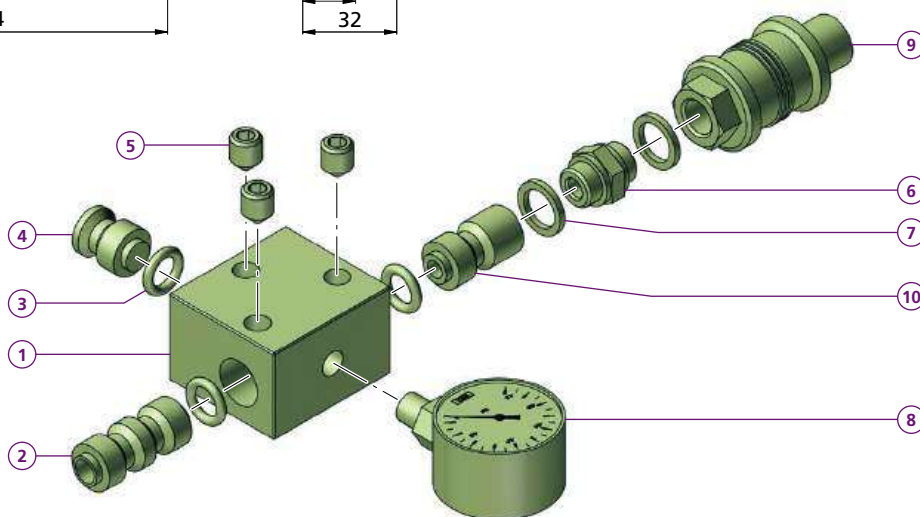
Schaltventil mit Unterdruckanzeige
Control unit valve with vacuum indicator



UBS5045

- 1x UBS5045-1
- 1x 0910000
- 3x TN100822
- 1x 0920000
- 3x TN100086
- 1x TN100671
- 2x TN100642
- 1x TN100925
- 1x TN100668
- 1x TH120180

kg ~0,74



Druckwächter / Pressure sensor switch

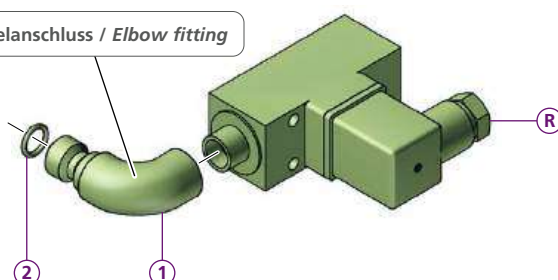
Druck einstellbar; je nach Aufspannung einzustellen.

With adjustable threshold value; to be adjusted according to clamping task.

Anschluss 24-250 V, 50-60 Hz am Ausgang (R) für Elektrokabel zu optischem oder akustischem Warnsignal, oder zum Stillsetzen der Werkzeugmaschine über deren Steuerung, normalerweise mit Funktion M 00 (Programm Stop).

Power supply (24-250 V, 50-60 Hz). Connecting point (R) for wiring to trigger a signal (light or whistle) or to switch the machine tool off via its control system, normally using function M 00 (machine stop), in the event of a drop of vacuum.

Winkelanschluss / Elbow fitting



0500205

- 1x 0940000
- 1x 1111003

➔ Weiteres Zubehör auf Anfrage
➔ Further accessories on demand

Vakuumspannplatte auf Power-Clamp mit Injektorpumpe für Trocken- und Nasseinsatz

Das modulare Triag Power Clamp Spannsystem kann nun mit Vakuumspannplatten bestückt werden. Die Vakuum Platten können mit oder ohne Zwischenräume gekoppelt werden. Die handliche Injektorpumpe wird mit Pressluft betrieben und kann im Trocken- oder Nasseinsatz verwendet werden.

Vacuum clamping plates on Power - Clamp with injector pump for dry and wet use

The modular Triag Power Clamp workholding system can now be equipped with vacuum plates. The vacuum plates can be coupled with or without gaps. The handy injector pump is operated with compressed air and can be used in dry and wet applications.

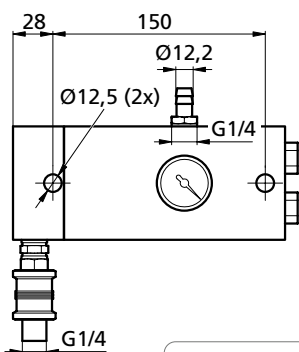
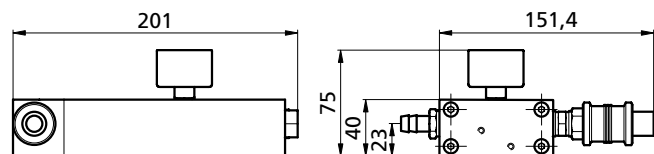
Maximaler zulässiger Speisedruck: 7 bar
Maximal erreichbares Vakuum: 0,92 bar

Maximum allowable supply pressure: 7 bar
Maximum attainable vacuum: 0,92 bar

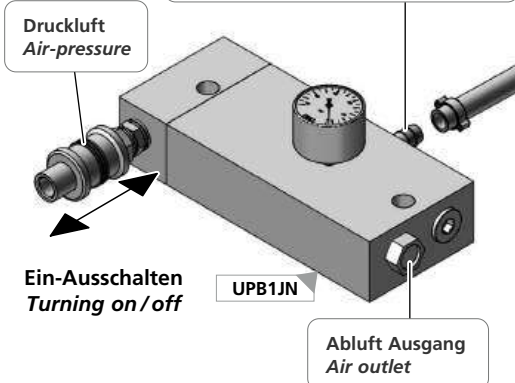
Der Normalliter (NI) entspricht dem Volumen, das eine bestimmte Menge (Masse) Gas bei atmosphärischem Druck einnehmen würde. Die Durchflussmenge wird berechnet aus Volumen pro Zeit (NI/s) unter Normalbedingungen (atmosphärischer Druck, 20°C).

The normal litres (NI) is the volume that would take a certain amount (mass) of gas at atmospheric pressure. The flow rate is calculated as volume per time (NI/s) under normal conditions (atmospheric pressure, 20° C).

Typ	Speisedruck	Luftverbrauch	Saugleistung bei 50% Vakuum	Saugleistung bei 90% Vakuum
Type	Feed pressure	Air consumption	Vacuum suction power at 50%	Vacuum suction power at 90%
	bar	NI/s	NI/s	NI/s
UPB1JN	5	2,0	0,6	0,02
	6	2,3	0,5	0,03
UPB2JN	5	4,0	1,2	0,04
	6	4,6	1,0	0,06



Vakuumananschluss (zur Spannplatte)
Vacuum adapter (to clamping plate)

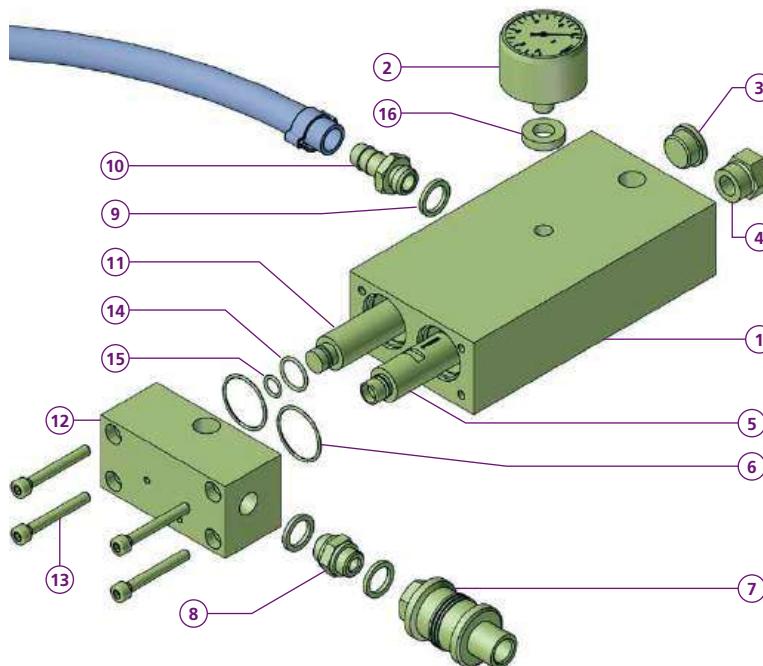


Druckluft
Air-pressure

Ein-Ausschalten
Turning on/off

UPB1JN

Abluft Ausgang
Air outlet



UPB1JN

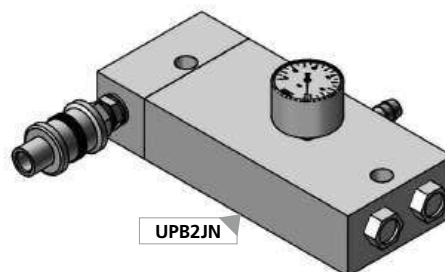
- 1 1x TW090057
- 2 1x TN100667
- 3 1x TN100660
- 4 1x TW100199
- 5 1x TN100665
- 6 2x TN100057
- 7 1x **TN100668**
- 8 1x TN100671
- 9 3x TN100642
- 10 1x TN100664
- 11 1x TW090057
- 12 1x TW90057-02
- 13 4x TN100666
- 14 1x TN100691
- 15 1x TN100163
- 16 1x TN100942

kg ~1,61

UPB2JN

- 1 1x TW090057
- 2 1x TN100667
- 4 2x TW100199
- 5 2x TN100665
- 6 2x TN100057
- 7 1x **TN100668**
- 8 1x TN100671
- 9 3x TN100642
- 10 1x TN100664
- 12 1x TW90057-02
- 13 4x TN100666
- 14 1x TN100691
- 15 1x TN100163
- 16 1x TN100942

kg ~1,67



UPB2JN

Bestellbeispiel / Ordering example: **UPB1JN**

Separat bestellen / Order separately

Vakuumpumpe mit integriertem Unterdruckausgleich Vacuum pump with integrated vacuum equalisation

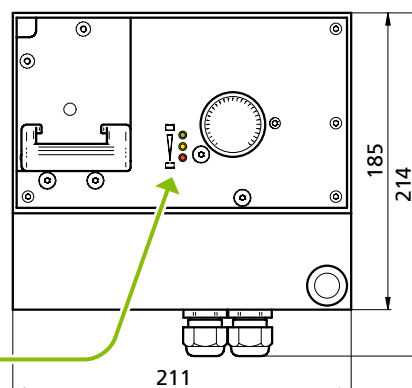
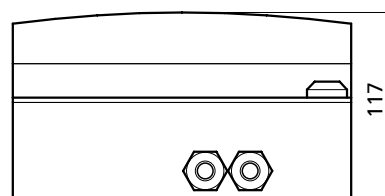
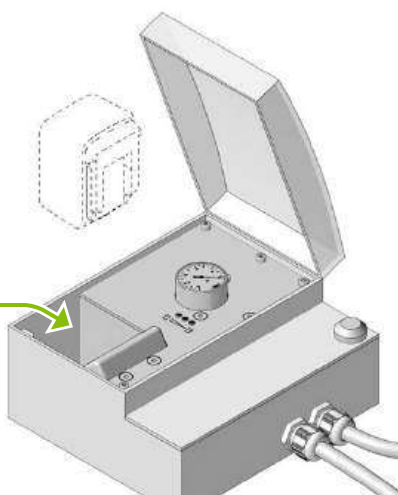
trivaCLAMP

UX1AUT



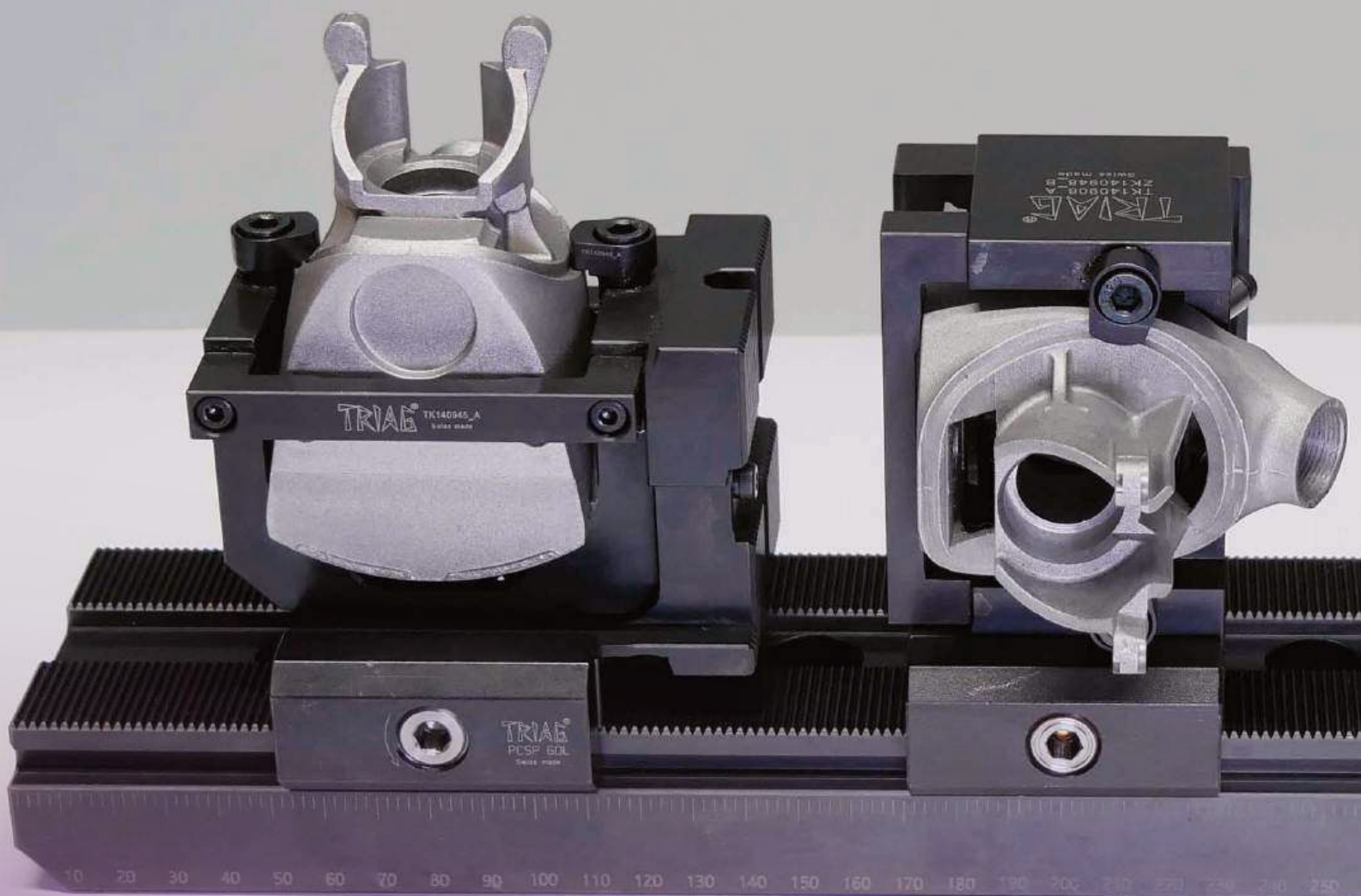
Platz für Lithium-Ionen-Akkumulator
12V / 4Ah (Makita)
Space for lithium-ion battery 12 V / 4
Ah (Makita)

Ladezustands-Anzeige regelmässige
Sichtprüfung erforderlich!
State of charge indicator Regular
visual inspection required!





customCLAMP



Fordern Sie uns heraus! *Challenge us!*



Wir sind Ihr Spezialist für Sondervorrichtungen.
Nehmen Sie mit uns Kontakt auf.

*We are your specialist for custom made fixtures.
Feel free to contact us.*

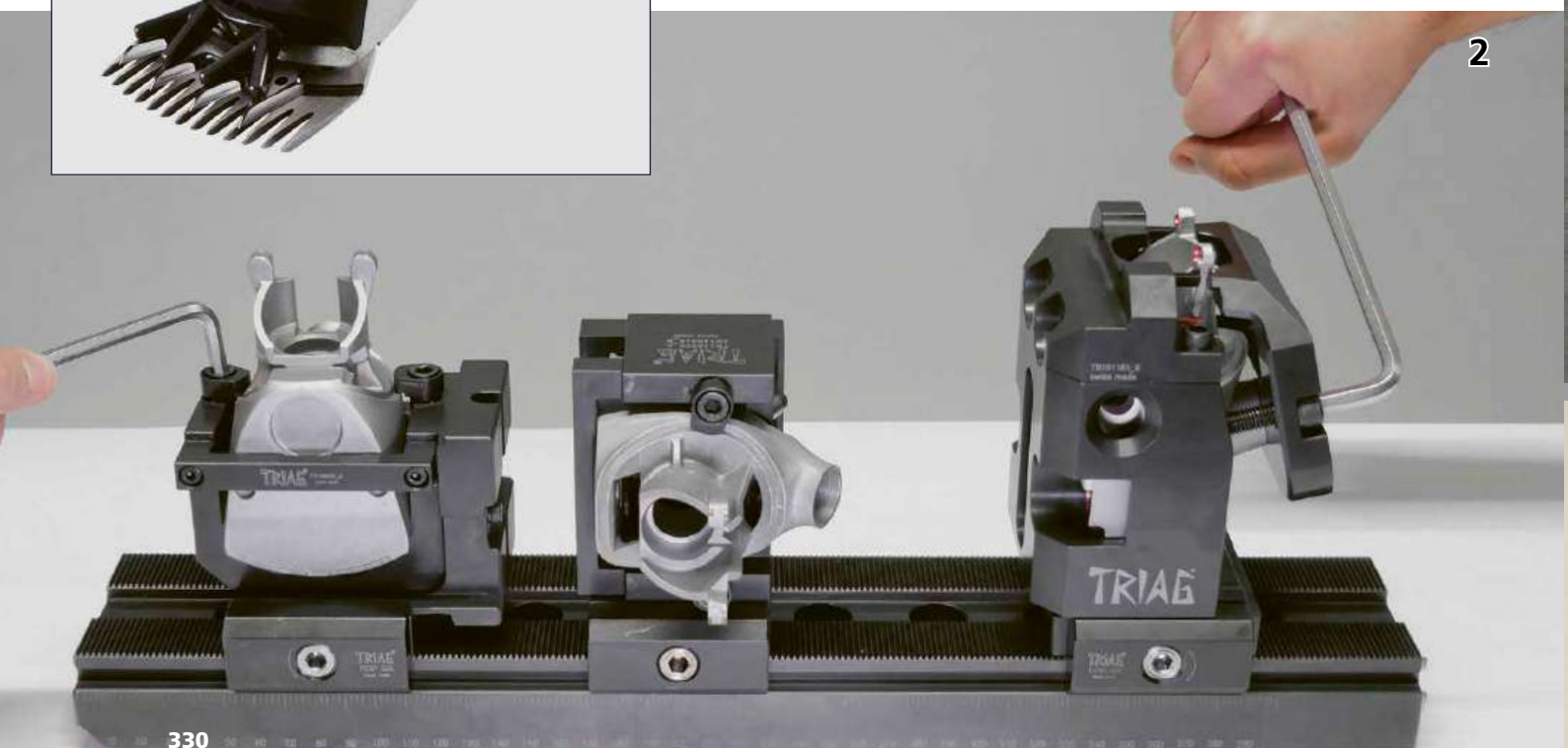


Komplexe Teile einfach gespannt *Complex parts simply clamped*



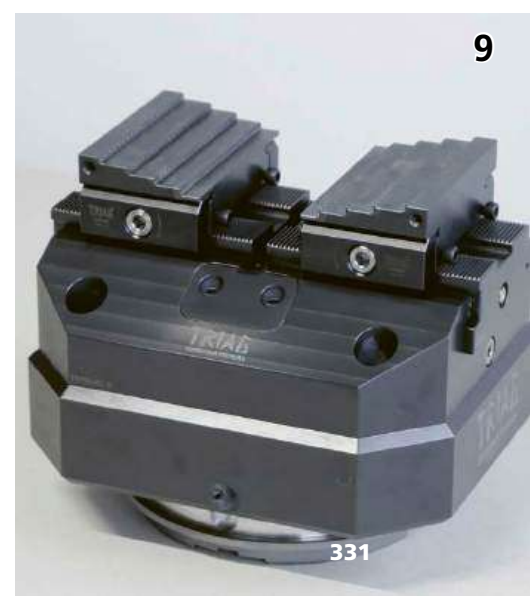
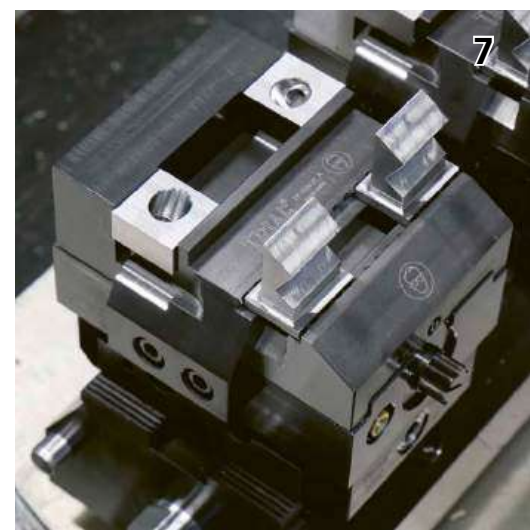
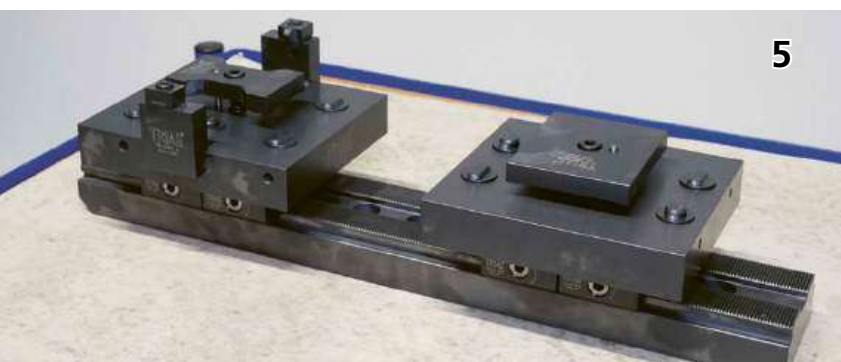
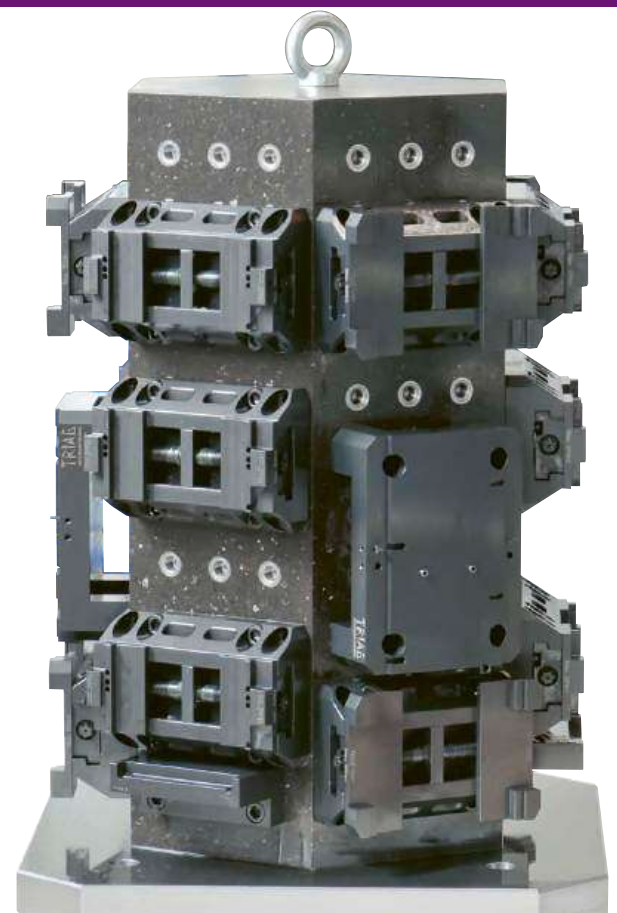
Drei Sonderspannmodule mit powerCLAMP
Schnittstelle für komplex geformte Aluminium
Druckguss Teile.

*Three customized clamping modules with
powerCLAMP interface for complex shaped
die cast aluminium pieces.*



Anwendungsbeispiele Examples of application

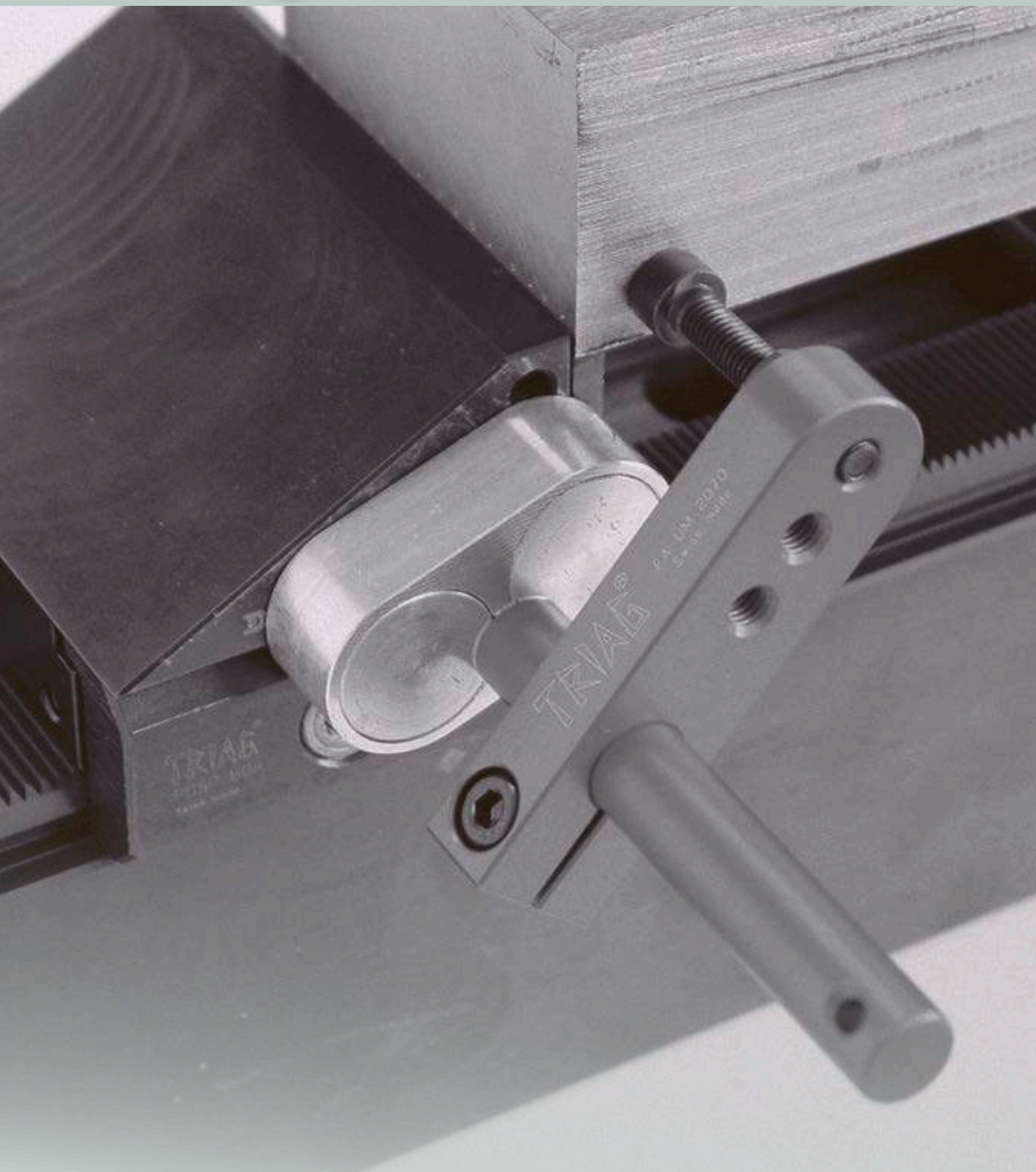
customCLAMP







Zubehör Accessories



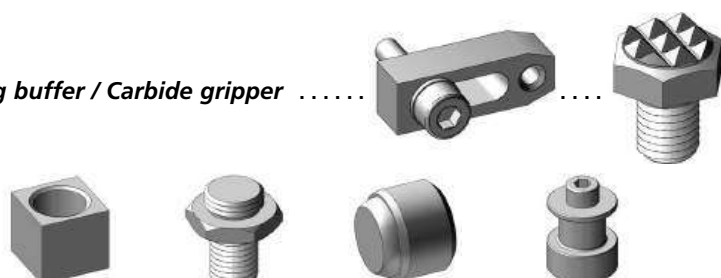
Einstellmassstab | Measuring device 335



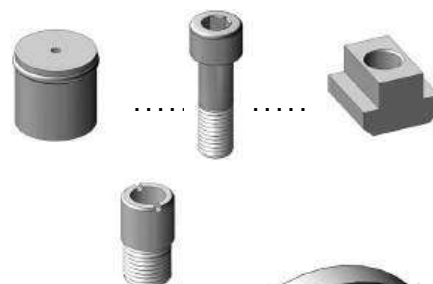
Magnetanschlag | Magnetic milling buffer 336



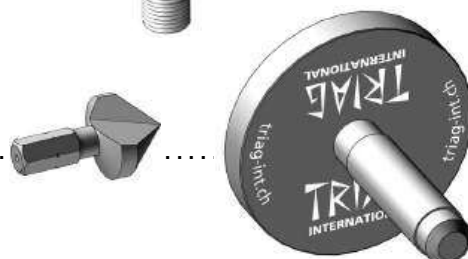
Fräsanschlag / Hartmetalldruckstück | Milling buffer / Carbide gripper 337



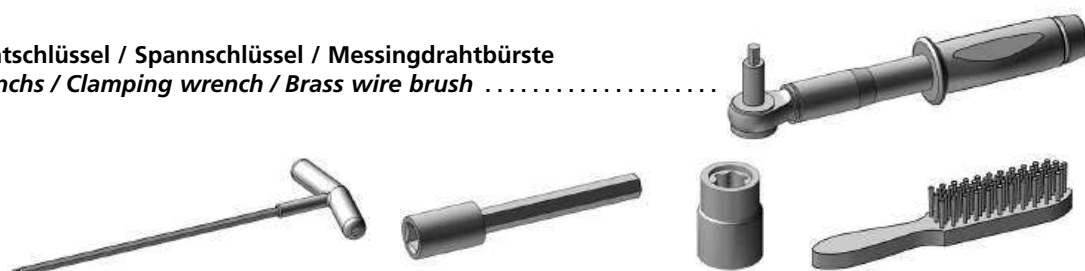
Stopfen / Spannschrauben / Passschrauben / T-Nuten Steine
Plug / Clamping screw / Fitting screw / T-slot nuts 338



Triag Bitburr / Magnethalter / Pneumatikschrauber Set
Magnetic holder / Pneumatic screwdrivers set 339



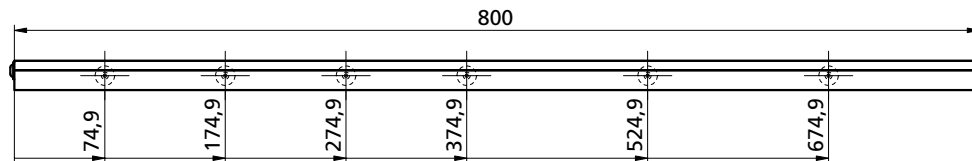
Drehmomentschlüssel / Spannschlüssel / Messingdrahtbürste
Torque wrenches / Clamping wrench / Brass wire brush 340



Masstab mit Magnetleiste
Scale with magnet profile

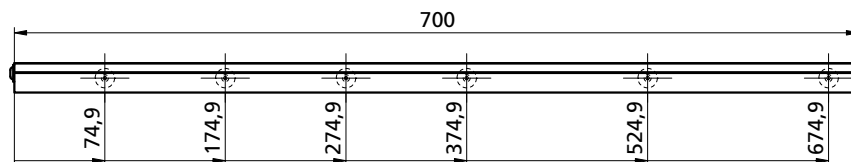
PCMAS800ML

- ① 1x PCMAS800ML
 - ② 2x MG1645
 - ③ 2x M3X10ISO4762
 - ④ 1x M6X12BN5128
- kg ~1,0



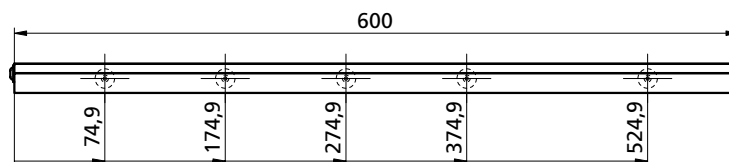
PCMAS700ML

- ① 1x PCMAS700ML
 - ② 2x MG1645
 - ③ 2x M3X10ISO4762
 - ④ 1x M6X12BN5128
- kg ~0,88



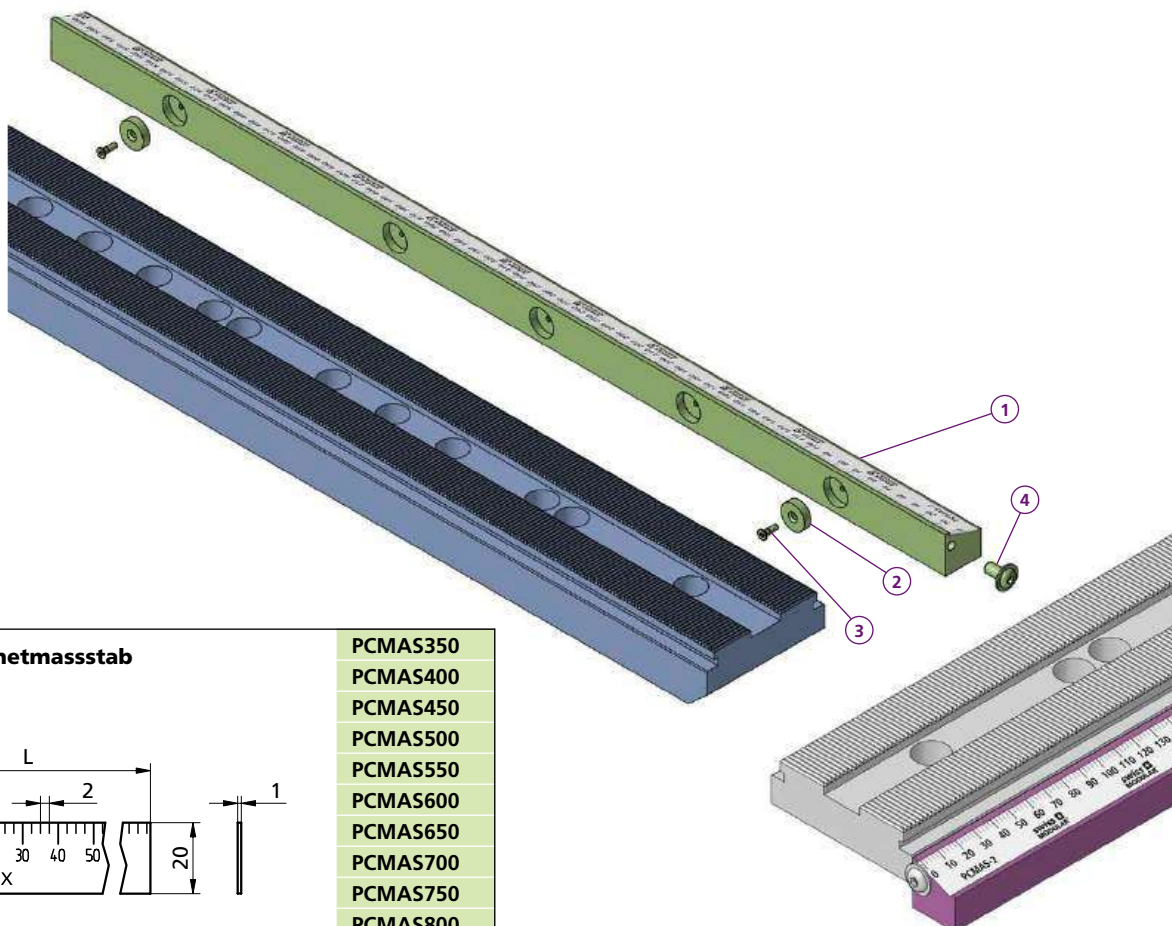
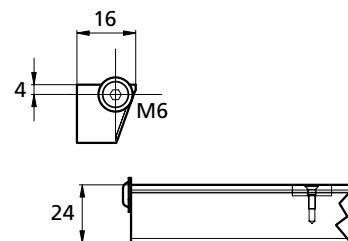
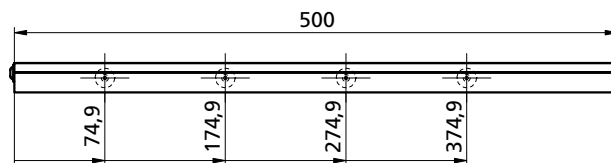
PCMAS600ML

- ① 1x PCMAS600ML
 - ② 2x MG1645
 - ③ 2x M3X10ISO4762
 - ④ 1x M6X12BN5128
- kg ~0,75

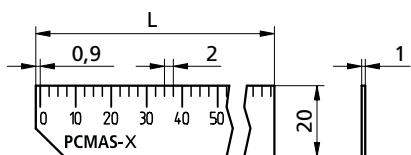


PCMAS500ML

- ① 1x PCMAS500ML
 - ② 2x MG1645
 - ③ 2x M3X10ISO4762
 - ④ 1x M6X12BN5128
- kg ~0,63



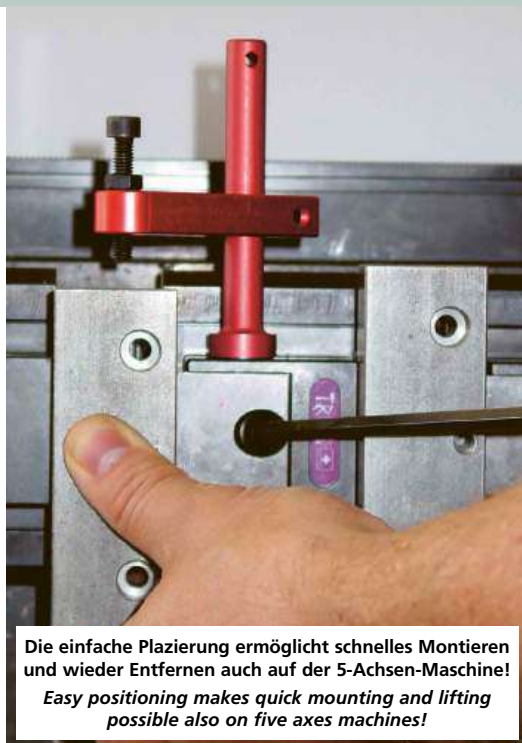
Alu - Magnetmassstab
Alu scale



- PCMAS350
- PCMAS400
- PCMAS450
- PCMAS500
- PCMAS550
- PCMAS600
- PCMAS650
- PCMAS700
- PCMAS750
- PCMAS800

Bestellbeispiel / Ordering example : **PCMAS800ML**

Separat bestellen / Order separately



Die 3 Sicherheitsstufen:

Durch seine **rote Farbe** ist der Anschlag besser sichtbar, was das Risiko vermindert, dass er in der Maschine vergessen wird.

Die **Bohrung** dient zum Befestigen einer Schnur am Handgelenk oder ausserhalb der Maschine.

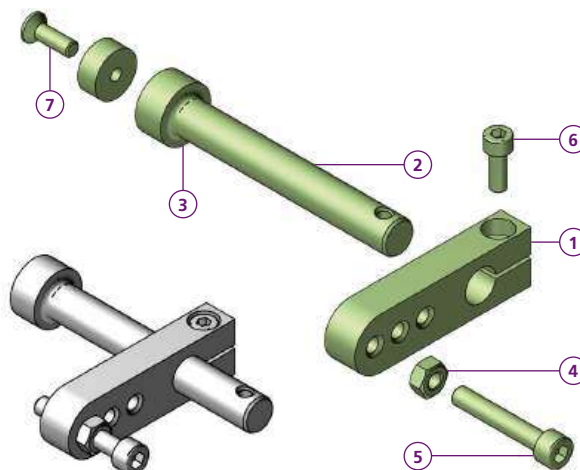
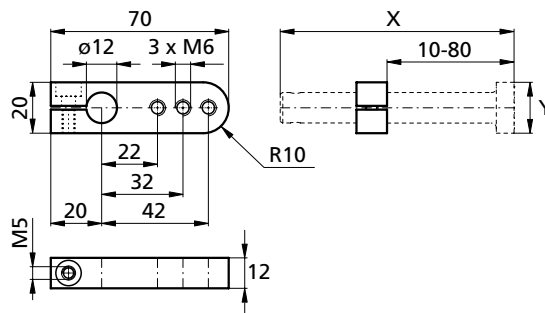
Dank dem **Magnet** ist der Anschlag auf allen magnetischen Materialien auf minimalem Platz einsetzbar, bei Kollision wird er weggedrückt. Es entstehen so keine teuren Werkzeugbrüche oder Maschinendefekte.

The 3 safety levels:

Because of its **red color**, the buffer is better visible. So the risk of forgetting the device in the machine is diminished.

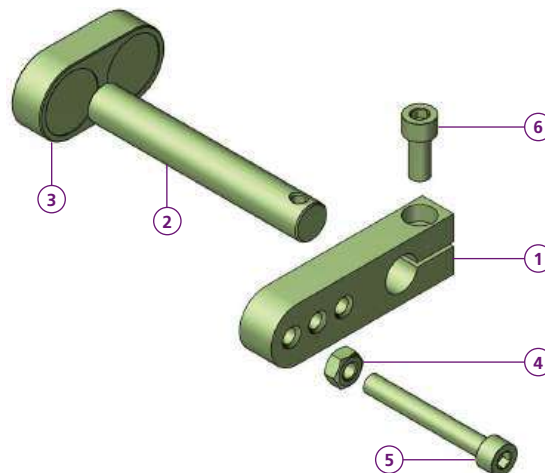
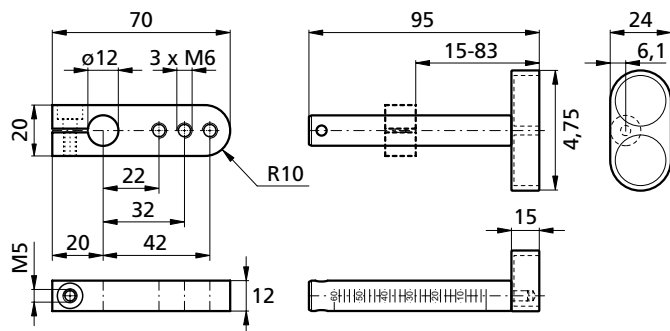
The **drilling** serves to fasten a cord around the wrist or outside the machine.

Its **magnet** makes the buffer applicable on all magnetic materials on minimum space, in case of collision it gets pressed away, so there won't be any expensive breaking of tools or machines.

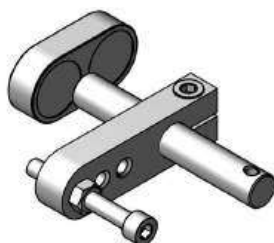


Haltekraft / Holding force	
45N = 4,5daN (~4,5 kg)	
FAUM2070	
1	1x FA2070
2	1x FAD2092
3	2x MG1645
4	2x M6ISO4032
5	1x M6X35ISO4762
6	1x M5X14ISO4762
7	1x M3X8ISO10642
X	= 92
Y	= ø 20
kg	~0,084

Haltekraft / Holding force	
80N = 8daN (~8 kg)	
FAUM2070S	
1	1x FA2070
2	1x FAD2092S
3	1x MG2570
4	1x M6ISO4032
5	1x M6X35ISO4762
6	1x M5X14ISO4762
7	1x M5X16ISO10642
X	= 95
Y	= ø 25
kg	~0,1

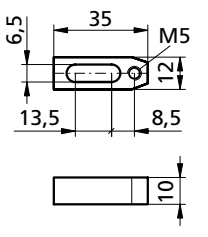
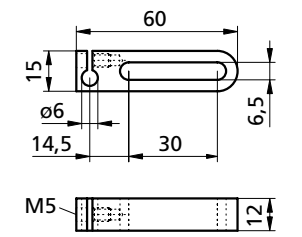
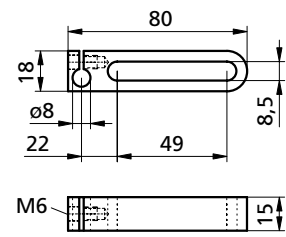
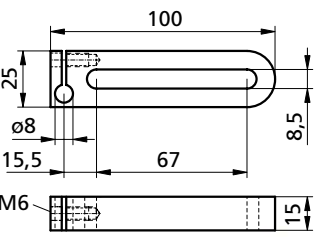


Haltekraft / Holding force	
120N = 12daN (~12 kg)	
FAUM2070US	
1	1x FA2070
2	1x FAD1280
3	1x FUSSUS
4	1x M6ISO4032
5	1x M6X35ISO4762
6	1x M5X14ISO4762
kg	~0,146

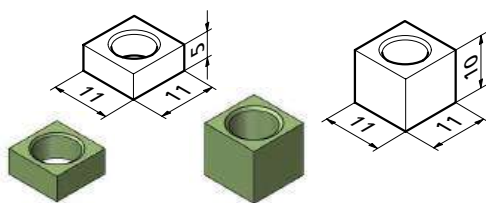


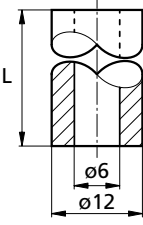
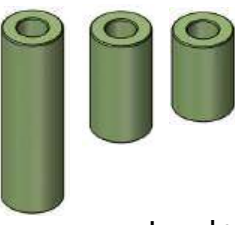
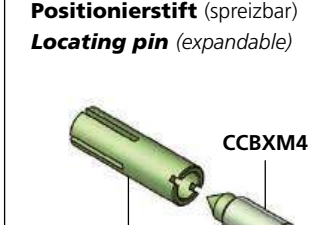
Bestellbeispiel Ordering example : **FAUM2070US**

Fräsanschlag / Milling buffer

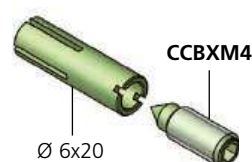
 FA1240 1x M6X18ISO4762 1x M5X12ISO4762 kg ~0,024	 FA1260 1x M6X20ISO4762 1x M5X12ISO4762 kg ~0,07	 FA1280 1x M8X25ISO4762 1x M6X12ISO4762 kg ~0,014	 FA12100 1x M8X25ISO4762 1x M6X16ISO4762 kg ~0,022
---	--	--	--

Distanzbüchse zu Fräsanschlag
Spacers for workpiece stop

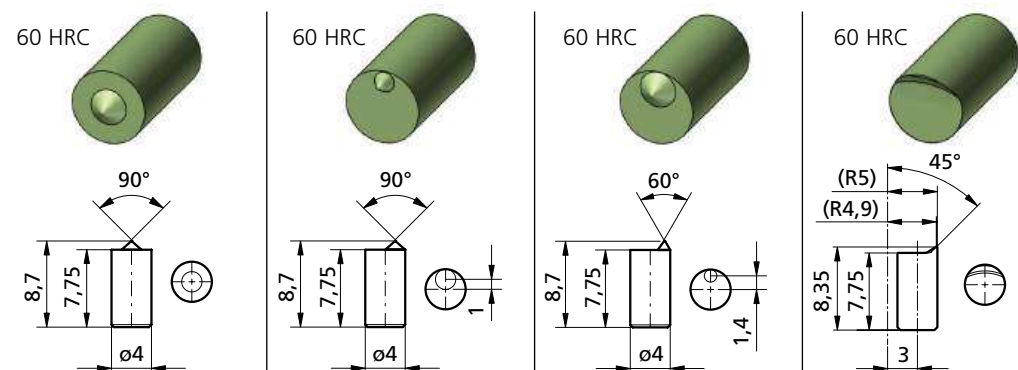


 FAD12018 kg ~0,012	 FAD12023 kg ~0,016	 FAD12040 kg ~0,026
--	---	--

Positionierstift (spreizbar)
Locating pin (expandable)

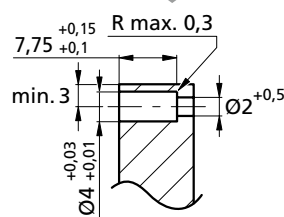


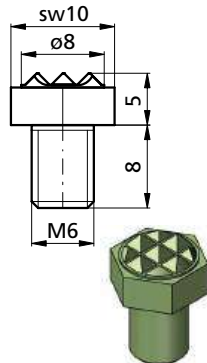
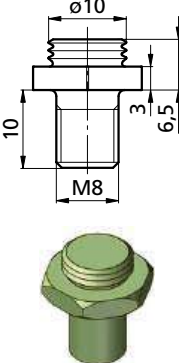
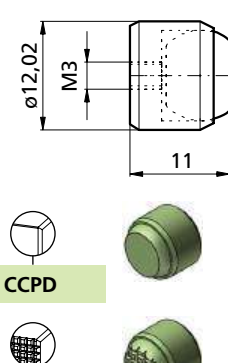
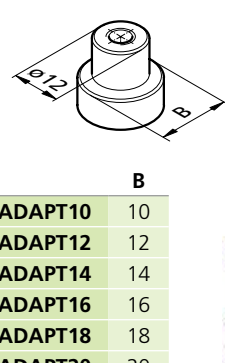
Druckstift / Gripping pins

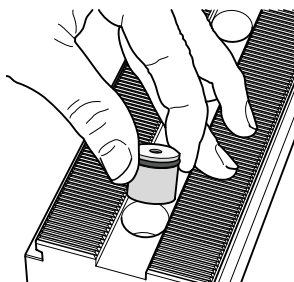
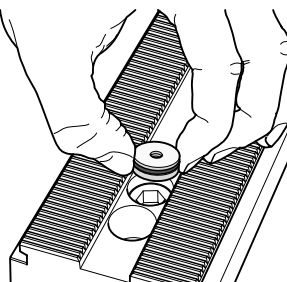
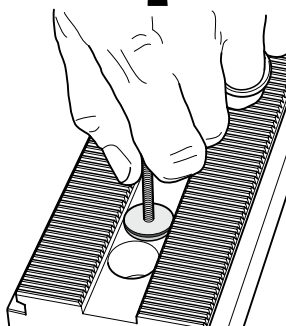
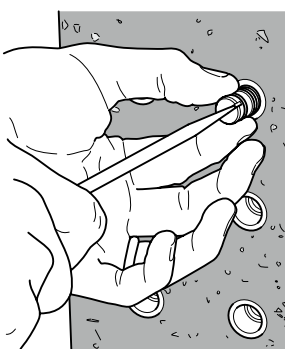


Einbauanleitung
Installation guide

Bohrung vorbereiten
Preparation of drill-hole
Einkleben mit / Glue with
Loctite 641

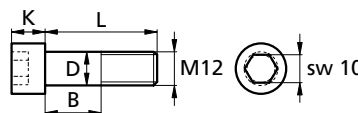


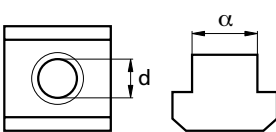
DSE0402-90°	DSE0402-90°	DSE0402-60°	DSE0402-BS																
Hartmetalldruckstück Carbide gripper  CCHMR	Prägespannschraube Stamping roll screw  PRG1003M8	Kugeldruckstück Gripper  CCPDR	Ausrichtzapfen für T-Nuten Alignment-pins for t-slots <table><thead><tr><th></th><th>B</th></tr></thead><tbody><tr><td>TWADAPT10</td><td>10</td></tr><tr><td>TWADAPT12</td><td>12</td></tr><tr><td>TWADAPT14</td><td>14</td></tr><tr><td>TWADAPT16</td><td>16</td></tr><tr><td>TWADAPT18</td><td>18</td></tr><tr><td>TWADAPT20</td><td>20</td></tr><tr><td>TWADAPT22</td><td>22</td></tr></tbody></table>		B	TWADAPT10	10	TWADAPT12	12	TWADAPT14	14	TWADAPT16	16	TWADAPT18	18	TWADAPT20	20	TWADAPT22	22
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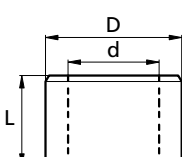
Stopfen Plug (Ø19 L18)		(Ø19 L6)		Auszieher Extractor		Stopfen Plug Ø 12/16 M 12/16	
							
							
PCPF16L18		PCPF16L6		PCAZM3		CCPF12ALU / CCPF16ALU	

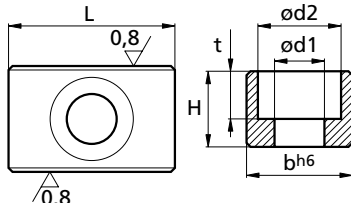
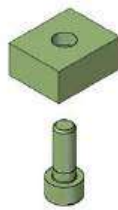
Spannschrauben (Nitriert) Clamping screw (Nitrided) für/for kg			
M8x20ISO4762NQ	B60	~0,012	
M10x25ISO4762NQ	B80	~0,024	

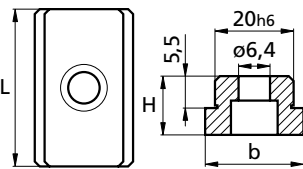
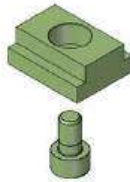
Reduktionshülsen für Rasterplatte		Reduction sleeve for grid plate	
			
RD18M1612M12	RD16M1612M12	RD16M12	

Passschrauben / Fitting screw M 5 / M 6 / M 12 / M 16																																																																									
																																																																									
	<table><tr><td></td><td>D</td><td>G</td><td>L</td><td>B</td><td>K</td><td>sw</td><td>Nm</td><td>kg</td></tr><tr><td>MS50</td><td>5 f7</td><td>M5</td><td>17</td><td>9</td><td>5</td><td>4</td><td>4,5</td><td>~0,004</td></tr><tr><td>MS60</td><td>6 f7</td><td>M6</td><td>17</td><td>9</td><td>6</td><td>5</td><td>8</td><td>~0,006</td></tr><tr><td>TWPAS1227</td><td>12 g7</td><td>M12</td><td>27</td><td>14</td><td>12</td><td>10</td><td>60</td><td>~0,038</td></tr><tr><td>TWPAS1232</td><td>12 g7</td><td>M12</td><td>32</td><td>19</td><td>12</td><td>10</td><td>60</td><td>~0,042</td></tr><tr><td>TWPAS1240</td><td>12 g7</td><td>M12</td><td>40</td><td>20</td><td>12</td><td>10</td><td>60</td><td>~0,048</td></tr><tr><td>TWPAS1250</td><td>12 g7</td><td>M12</td><td>50</td><td>30</td><td>12</td><td>10</td><td>60</td><td>~0,058</td></tr><tr><td>TWPAS16055</td><td>16 f7</td><td>M16</td><td>55</td><td>30</td><td>15,8</td><td>14</td><td>150</td><td>~0,120</td></tr></table>		D	G	L	B	K	sw	Nm	kg	MS50	5 f7	M5	17	9	5	4	4,5	~0,004	MS60	6 f7	M6	17	9	6	5	8	~0,006	TWPAS1227	12 g7	M12	27	14	12	10	60	~0,038	TWPAS1232	12 g7	M12	32	19	12	10	60	~0,042	TWPAS1240	12 g7	M12	40	20	12	10	60	~0,048	TWPAS1250	12 g7	M12	50	30	12	10	60	~0,058	TWPAS16055	16 f7	M16	55	30	15,8	14	150	~0,120
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T-Nuten Steine / T-slot nuts																																																																						
<table><tr><td>d</td><td>α</td><td>kg</td></tr><tr><td>SM1135 M06X08</td><td>~0,012</td><td></td></tr><tr><td>SM1135 M06X10</td><td>~0,012</td><td></td></tr><tr><td>SM1135 M08X10</td><td>~0,012</td><td></td></tr><tr><td>SM1135 M08X12</td><td>~0,022</td><td></td></tr><tr><td>SM1135 M08X14</td><td>~0,04</td><td></td></tr><tr><td>SM1135 M10X12</td><td>~0,02</td><td></td></tr><tr><td>SM1135 M10X14</td><td>~0,038</td><td></td></tr><tr><td>SM1135 M12X14</td><td>~0,045</td><td></td></tr><tr><td>SM1135 M12X16</td><td>~0,045</td><td></td></tr><tr><td>SM1135 M12X18</td><td>~0,078</td><td></td></tr><tr><td>SM1135 M12X20</td><td>~0,13</td><td></td></tr><tr><td>SM1135 M12X22</td><td>~0,188</td><td></td></tr><tr><td>SM1135 M14X16</td><td>~0,188</td><td></td></tr><tr><td>SM1135 M14X18</td><td>~0,188</td><td></td></tr><tr><td>SM1135 M16X18</td><td>~0,068</td><td></td></tr><tr><td>SM1135 M16X20</td><td>~0,11</td><td></td></tr><tr><td>SM1135 M18X20</td><td>~0,11</td><td></td></tr><tr><td>SM1135 M18X22</td><td>~0,15</td><td></td></tr><tr><td>SM1135 M18X22</td><td>~0,15</td><td></td></tr><tr><td>SM1135 M20X22</td><td>~0,15</td><td></td></tr><tr><td>SM1135 M20X24</td><td>~0,23</td><td></td></tr><tr><td>SM1135 M24X28</td><td>~0,31</td><td></td></tr></table>		d	α	kg	SM1135 M06X08	~0,012		SM1135 M06X10	~0,012		SM1135 M08X10	~0,012		SM1135 M08X12	~0,022		SM1135 M08X14	~0,04		SM1135 M10X12	~0,02		SM1135 M10X14	~0,038		SM1135 M12X14	~0,045		SM1135 M12X16	~0,045		SM1135 M12X18	~0,078		SM1135 M12X20	~0,13		SM1135 M12X22	~0,188		SM1135 M14X16	~0,188		SM1135 M14X18	~0,188		SM1135 M16X18	~0,068		SM1135 M16X20	~0,11		SM1135 M18X20	~0,11		SM1135 M18X22	~0,15		SM1135 M18X22	~0,15		SM1135 M20X22	~0,15		SM1135 M20X24	~0,23		SM1135 M24X28	~0,31	
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Bohrbüchsen Position case																					
																					
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	L	D	d																		
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CCBUE1218512	12	18,5	12,0																		
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CCBUE162616	16	26,0	16,0																		
																					

Nutensteine, flach Low slot tenons Einsatzgehärtet, brüniert, geschliffen Case-hardened, blackened, ground																																																							
																																																							
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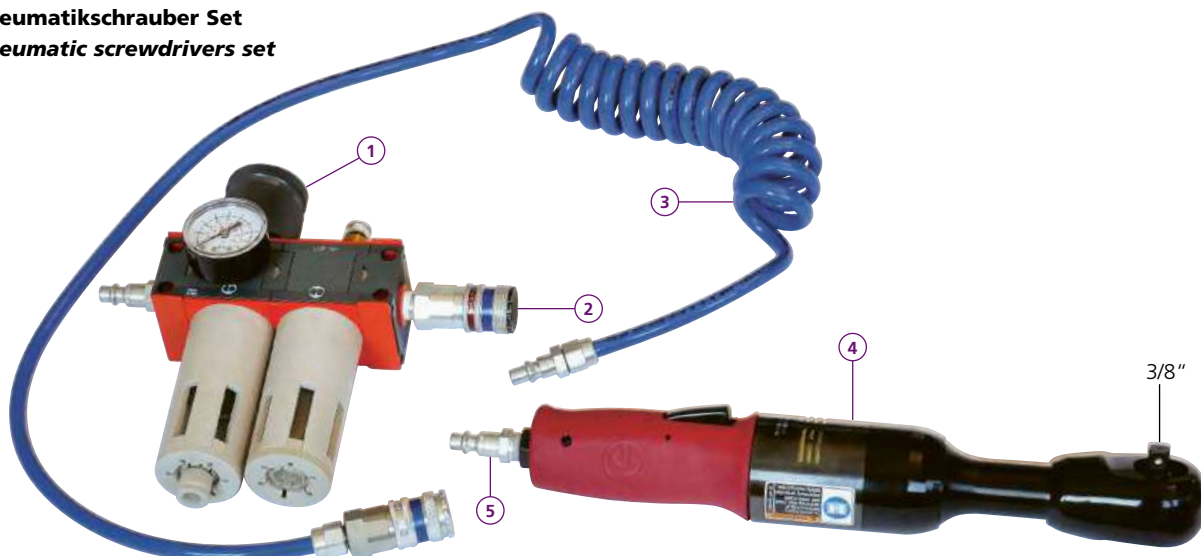
Pneumatikschrauber Set

Pneumatic screwdrivers set

Triag Bitburr / Triag Bit

Zubehör / Accessories

Pneumatikschrauber Set Pneumatic screwdrivers set



RP9431SET

- ① 1x P1H-200-M3QG
 - ② 1x 103002152 (SERIE 300) 1/4"
 - ③ 1x 199589977 (5 x 8 mm, 300, 2 m)
 - ④ 1x RP9431
 - ⑤ 2x 103105152 1/4"
- kg ~1,5

Drehmomenttabelle / Torque table	Druck / Compression (bar)	Nm
	6	50
Schlauchdurchmesser 8 mm	5,5	45
Luftverbrauch 2,5 L Sek	5	40
	4,5	35
Hose diameters 8 mm	4	30
Air consumption 2,5 L sec	3,5	25
	3	20

mit Feder gehalten, nicht magnetisch
spring locked, not magnetic



mit Feder gehalten, nicht magnetisch
spring locked, not magnetic

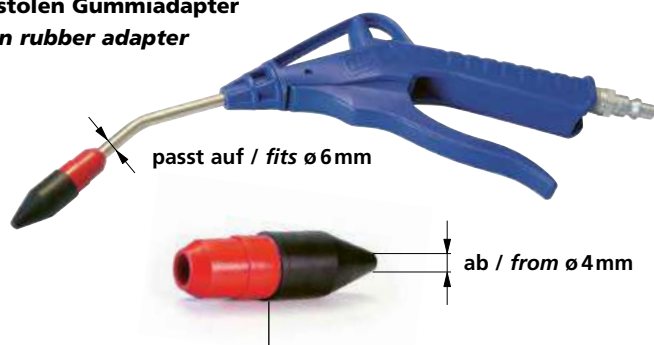


siehe Video
see video

Triag Bit

Triag Bitburr

Luftpistolen Gummiadapter Air gun rubber adapter



ARA14

Magnethalter Magnetic holder



Smiley

Einsatz für Triva Bit Insert for Triva Bit



BitT

Einsätze zu Bitburr Inserts for Bitburr



TC10



BitF63 Ø 6,3-90°



BIT-KH



BitF104 Ø 10,4-90°

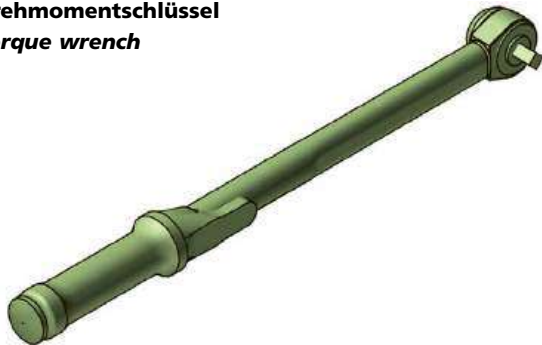
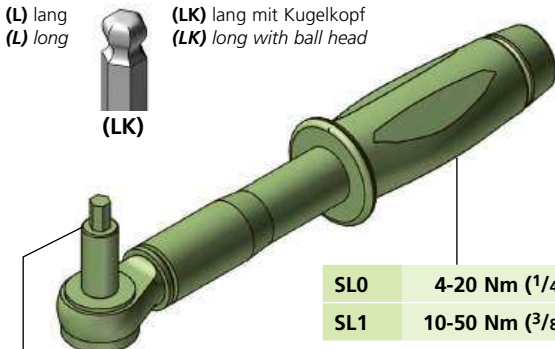
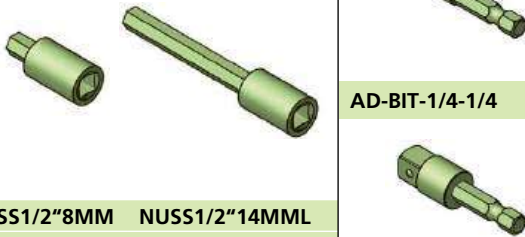
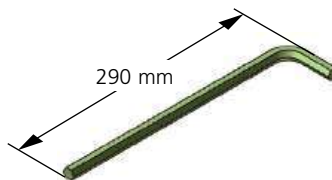
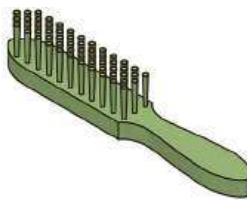


BIT-BF



BitF165 Ø 16,5-90°

Bestellbeispiel / Ordering example: **RP9431SET**

Drehmomentschlüssel <i>Torque wrench</i>		Sechskantstifteinsatz <i>Hexagonal socket wrench</i>	
			
SL3 20-200 Nm (1½")		SL0 4-20 Nm (¼") SL1 10-50 Nm (⅜")	
Steckschlüsseinsatz <i>Socket wrench insert</i>		Sechskantstifteinsatz <i>Hexagonal socket wrench</i>	
			
Torx		Sechskanteinsatz Hexagon insert	
NUSS3/8"TX30E14 für / for MCZ, ZSX, ZSM, ZSB, PCZ		NUSS1/4"4MM 4 mm NUS3/8"6MM 6 mm	
NUSS1/4"4.5MM 4,5 mm		NUSS1/4"5MM 5 mm NUS3/8"6MML 6 mm	
NUSS1/4"5.5MM 5,5 mm		NUSS1/4"6MM 6 mm NUS3/8"6MMLK 6 mm	
		NUSS1/4"8MM 8 mm NUS3/8"8MM 8 mm	
		NUSS3/8"5MM 5 mm NUS3/8"8MML 8 mm	
		NUSS3/8"5MML 5 mm NUS3/8"8MMLK 8 mm	
		NUSS3/8"5MMLK 5 mm NUS3/8"10MM 10 mm	
		NUSS3/8"10MML 10 mm	
		NUSS3/8"10MMLK 10 mm	
Spannschlüssel <i>Clamping wrench</i>		Sechskantstifteinsatz <i>Hexagonal socket wrench</i>	
			
02613160 4 mm		AD-BIT-1/4-1/4	
02613164 5 mm		AD-BIT-1/4-3/8	
02613168 6 mm			
02613172 8 mm			
02613176 10 mm			
Langer Spannschlüssel <i>Long clamping wrench</i>		Sechskantstifteinsatz <i>Hexagonal socket wrench</i>	
			
290 mm		NUSS1/2"8MM 8 mm NUS1/2"14MML 14 mm	
		NUSS1/2"10MM 10 mm	
		NUSS1/2"14MM 14 mm	
Messingdrahtbürste <i>Brass wire brush</i>		Mess-Gelenkstativ <i>Articulated indicator holders</i>	
			
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Produktion einer Werkstück Familie
Producing a complete workpiece family



part 1 / OP 10

part 1 / OP 20

part 2 / OP 20

part 2 / OP 10

part 3 / OP 20

part 3 / OP 10

Zykluszeit / Cycle time

28 Min !



powerCLAMP & Saxes

Das schnellstverstellbare Mehrfachspannsystem! Die Positionierung der Spannmodule erfolgt mittels einer Verzahnung auf der Schiene. Befestigung mit nur einer Schraube!

powerCLAMP & Saxes

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triCENTRO

Kleine bis grosse, sowie modulare Zentrischspanner in verschiedenen Ausführungen.

triCENTRO

Small to big modular self centering vises in different variations.



microCLAMP

Kleinste Module für den Vorrichtungsbau. Sie haben eine grosse Spannkraft (bis 28'000N), der benötigte Abstand zwischen den Werkstücken ist im Optimalfall nur 15 mm.

microCLAMP

Smallest modules for dedicated fixtures. Having a high clamping force (up to 28'000N) the distance between workpieces is only 15 mm in optimum set up.



aptoCLAMP & Saxes

Die hohe Spannkraft dieses Systems ermöglicht den Einsatz für schwere Zerspanung.

aptoCLAMP & Saxes

The high clamping force of the aptoCLAMP enables heavy cuts.



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Spanntürme aus Mineralguss. Die Vibrationsdämpfung ist zehnmal besser als bei Grauguss. Das spezifische Gewicht ist hingegen kleiner als bei Aluminium. Erhältlich in vielen verschiedenen Formen.

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Tombstones made of composite concrete. Vibration damping effect is ten times better than with cast iron. Specific weight on the other hand is less than aluminum. Available in many different shapes.



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Unser Nullpunkt-Palettiersystem ermöglicht ein genaues Positionieren von Mehrfachspannsystemen, Schraubstöcken und Vorrichtungen auf Maschinentischen oder Spanntürmen.

oppSystem & Saxes

Our zero-point palleting system allows exact positioning of multiple workholding systems, vices and dedicated fixtures on machining tables or tombstones.



trivaCLAMP

Vakuumspannsystem: Bestens geeignet für plattenförmige Werkstücke (auch nicht magnetische). Es können sowohl Druckstellen als auch Deformationen an labilen Teilen vermieden werden.

trivaCLAMP

Workholding by vacuum: Suited for plateshaped workpieces (also for non magnetical). Pressure marks as well as deformations on soft parts can be avoided.



triGEL

Unser Gefrierspannsystem. Sehr gut geeignet für unförmige Teile. Es erlaubt mehrseitiges Bearbeiten ohne Neuspannen. Das Haftvermögen ist sehr gross, wobei die Gefrier- und Auftauzeiten sehr gering sind.

triGEL

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