HOME OF CLAMPING



CATALOGUE 2026

2026
STANDARD CLAMPING ELEMENTS

WE GENERATE EXCITEMENT.

Since the foundation of the company in 1890 until today the goal has remained the same: the highest quality in products and services. Nevertheless, the circumstances, tasks and challenges have changed, of course. By focussing on our core areas of expertise, we have long set new standards for innovative clamping technology - driven by our own development, the greatest possible flexibility and passion for individual solutions.

All this is only possible with committed and contented employees. Respectful interaction with others, personal development and measures for the wellbeing of each individual are therefore values that matter to us.



Company Management:
Wolfgang Balle, Johannes Maier (CEO), Jügen Förster

OUR COMPANY HISTORY

1890 Company founded as a lock manufacturer by Andreas Maier.

1920 Product range extended to include spanners.

1928 Production line assembly of FELLBACH LOCKS.

1951 Introduces clamping elements and diversifies into workpiece and tool clamping technology.

1965 Toggle clamps extend the AMF product range, AMF catalogues are now printed in ten languages.

1975 Further specialisation into hydraulic clamping technology.

1982 Clamping and fixture systems round off AMF's clamping expertise.

1996 AMF team organisation in all sectors of the business, Quality management with certification to ISO 9001.

2001 AMF Service Guarantee for all products.

2004 Introduction of the ZPS zero-point clamping system.

2007 The magnetic clamping technology extends the AMF product range.

2009 Development and marketing of AMF Vacuum clamping technology.

2012 LOW-COST AUTOMATION gripping, clamping, marking and cleaning.

2014 AMF presents the most extensive product range of automation solution in zero-point clamping technology.

2017 Wireless sensoring systems extend the expertise into Industry 4.0 and blends seamlessly into the AMF product range.

PLEDGES THAT COUNT IN EVERYDAY LIFE

For this reason, we have a few principles that we follow by conviction and which always apply.

INDIVIDUAL DEVELOPMENT

Even if the product you need does not even exist yet, we will find the right solution with you: from special designs to new developments, everything is possible.

WARRANTY

If, despite our high quality standard, there is a complaint, this is dealt with quickly and unbureaucratically, even beyond the warranty period.

HIGHEST QUALITY STANDARDS

Careful manufacturing based on tradition since 1890, and naturally with a modern quality management system according to ISO 9001 for many years.

SHORT DELIVERY TIME

With over 5,000 articles in our warehouse, you can expect your order to be dispatched on the same day.

COMPETENT SERVICE FROM EXPERTS

Your local retail partner or the specialists in our team will find the right solution for every task.

MADE IN GERMANY

Our entire product range is developed and manufactured exclusively by our employees in Germany.

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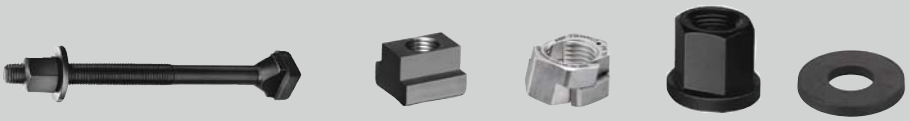
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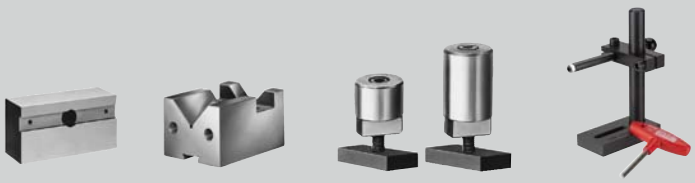
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POWER CLAMP
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NEW SIZE!



SWIVELLING ATTACHMENT SMOOTH WITH +/- 3° ANGLE FUNCTION
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NEW!



NEW!

SWING CLAMP, MECHANICAL
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SWING CLAMP, MECHANICAL, MODULAR
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ALUMINIUM SCREW JACK WITH CHIP GUARD PLATE AND ALUMINIUM BASE OR MAGNETIC BASE
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SIDE CLAMP WITH CLAMPING POINT
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NOT ONLY INCREDIBLE IN TERMS OF USE - OUR MODULAR SCREW JACK ALSO BOASTS AN IMPRESSIVE PRODUCT DESIGN.

Andreas Maier GmbH & Co. KG (AMF) has won an international design award. In the capital goods/tools category, our flexible, modular screw jack was able to convince the jury.

Focus Open 2020
Gold

TAKE A LOOK AT OUR PRIZE WINNER!
MORE FROM PAGE 54 ...



Subject to technical alterations.

THE POWER CLAMP THAT KEEPS ITS PROMISES

- **Uses:** All clamping tasks in cutting and non-cutting finishing operations. There are no limits to the possible uses in tool-making, injection moulding, presses and die-cutters as well as in model- and mould-making.
- **Characteristics:**
  - Clamping force up to 22 kN or 60 kN
  - Low installation height
  - Fast and simple clamping possible
  - Continuously adjustable

When using clamps in non-cutting and cutting metal finishing processes, as well as in mould making, clamping force and precision that meet the highest demands are required. With the sliding power clamp made of alloyed tempered steel, we offer an exceptionally robust and versatile mechanical clamping element, which can achieve extremely high clamping force of up to 60 kN.

The power clamp, which is usable both horizontally and vertically, can be fastened to regular T-slot tables using T-nuts or, alternatively, to grid pallets using threaded mounting.



Subject to technical alterations.

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No. 7600

Power clamp

Continuously adjustable clamping element made of alloyed tempered steel in forged, black galvanised design. Complete with mounting kit 7600BFS.
Thrust piece in smooth and ribbed variant, optionally available.

GERMAN DESIGN AWARD SPECIAL 2017



Order no.	Size	max. load static [kN]	M	Slot	H	E	L	Weight [g]
562184	22	22	M10	12	5 - 38	19 - 54	65	700
556406	22	22	M12	14	5 - 38	19 - 54	65	700
556186	30	30	M12	14	6 - 68	20 - 110	135	2013
556187	30	30	M16	18	6 - 68	24 - 113	135	2045
556189	32	32	M12	14	6 - 50	20 - 82	95	1462
556190	40	40	M16	18	6 - 55	25 - 94	110	2262
556188	43	43	M16	18	6 - 80	29 - 134	155	3158
563656	44	44	M18	20	7 - 88	36 - 165	176	5880
554198	49	49	M20	22	7 - 88	36 - 165	176	5928
564654	60	60	M24	28	8 - 102	63 - 180	203	8950
NEW! 572092	60	60	M30	36	8 - 102	45 - 163	203	9512

Application:

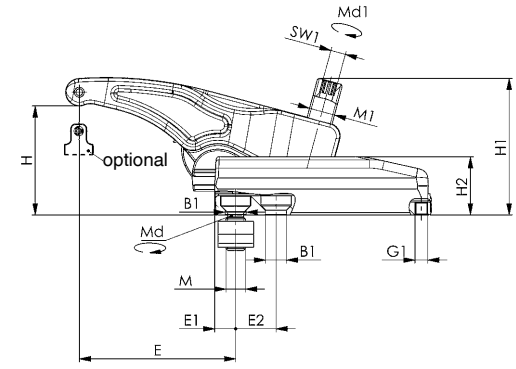
1. Position carrier element on the tool table and secure with the specified tightening torque Md.
2. Move the clamp arm to the desired position.
3. Moving the adjusting screw clamps the workpiece.

Advantage:

- Low installation height
- High clamping force of 22 - 60 kN
- Height and length continuously adjustable
- The very robust design enables quick and easy clamping
- Elements easy to install
- For use in T-slots 12 - 36 mm and/or grid plates M10, M12, M16, M18, M20, M24, M30
- 2 thrust piece variants

Note:

- The max. load may differ, depending on the manner of clamping and condition of the threads (lubrication).
- To reduce the wear on the adjusting screw, we recommend the use of AMF screw compound no. 6339. It has a synergistic combination of highly effective solid lubricants, is heat-resistant, and cannot be washed out.
- Use only the corresponding AMF mounting kit 7600BFS.
- If the clamping element without T-slot nut DIN 508 is used, the tensile strength of the support plate must be at least 900 N/mm²!
- Sizes 30 M16 / 44 M18 / 60 M24 and 60 M30 are not suitable for use with no. 7600Z.



Dimensions:

Order no.	Size	Max. load, dynamic swelling [kN]	B	B1	B2	E1	E2	G1	H1	H2	M1	SW1	Md 1 [Nm]	Md [Nm]
562184	22	17	45	13	13	11	-	M6	58	30	M12	6	50	35
556406	22	17	45	13	13	11	-	M6	58	30	M12	6	50	40
556186	30	23	54	13	18	13	25	M8	85	36	M16	8	100	70
556187	30	23	54	17	18	16	28	M8	85	36	M16	8	100	150
556189	32	24	54	13	18	12	20	M8	78	36	M16	8	100	70
556190	40	31	59	17	20	15	26	M8	92	42	M20	10	150	150
556188	43	32	59	17	20	16	32	M8	105	42	M20	10	150	150
563656	44	34	75	21	25	20	36	M10	125	52	M24	12	180	160
554198	49	38	75	21	25	20	36	M10	125	52	M24	12	220	200
564654	60	45	90	24,5	30	23	45	M10	143	57	M24	12	300	280
NEW! 572092	60	45	90	30,5	-	26	-	M10	143	57	M24	12	300	280

CAD

Subject to technical alterations.

No. 7600Z

Spacer element

Made of alloyed tempered steel in forged, black galvanised design. Complete with mounting kit.

GERMAN DESIGN AWARD SPECIAL 2017



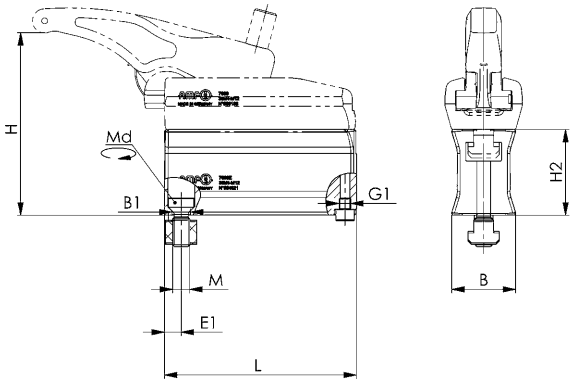
Order no.	Size	M	Slot	H	H2	L	Weight [g]
562185	22	M10	12	40 - 73	35	65	480
556407	22	M12	14	40 - 73	35	65	480
554821	30	M12	14	66 - 128	60	135	2300
554822	32	M12	14	66 - 110	60	95	1570
554823	40	M16	18	76 - 120	70	110	2290
554824	43	M16	18	75 - 150	70	155	3344
554825	49	M20	22	87 - 168	80	175	5286

Advantage:

- Additional clamping heights can be achieved by installing multiple spacer elements
- Continuous transition between the clamping heights
- For use in T-slots 12 - 28 mm and/or grid plates M10, M12, M16, M20

Note:

- Use only the corresponding AMF mounting kit 7600BFS.
- If the clamping element without T-slot nut DIN 508 is used, the tensile strength of the support plate must be at least 900 N/mm²!



Recommendations



No. 6339, page 119

Dimensions:

Order no.	Size	B	B1	E1	G1	Md [Nm]
562185	22	36,0	13	12	M6	35
556407	22	36,0	13	12	M6	40
554821	30	44,5	13	12	M8	70
554822	32	44,5	13	12	M8	70
554823	40	47,5	17	16	M8	150
554824	43	47,5	17	16	M8	150
554825	49	58,0	21	19	M10	200

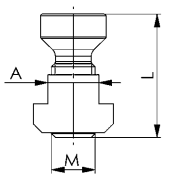
CAD

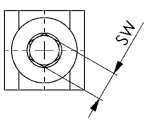
No. 7600BFS

Mounting kit

comprising flat-head screw strength class 12.9 and T-nuts DIN 508.







Order no.	Size	A	L	M	SW	Weight [g]
562186	22	12	29,0	M10	6	61
556576	22	14	31,5	M12	6	61
556152	30 / 32	14	34,0	M12	8	70
556153	30 / 32	16	38,0	M12	8	98
556154	30 / 32	18	38,0	M12	8	125
556155	30	18	41,0	M16	8	143
556156	30	20	45,0	M16	8	208
556157	30	22	49,0	M16	8	270
556158	30	24	49,0	M16	8	348
556159	40 / 43	18	43,0	M16	10	145
556160	40 / 43	20	47,0	M16	10	195
556161	40 / 43	22	51,0	M16	10	264
556162	40 / 43	24	51,0	M16	10	350
563658	44	20	49,0	M18	12	235
554298	49	22	52,0	M20	12	300
554299	49	24	55,0	M20	12	390
554300	49	28	62,0	M20	12	505
564665	60	28	64,0	M24	12	550
564681	60	36	77,0	M24	12	985
572093	60	36	77,0	M30	12	1061

NEW!

CAD

Subject to technical alterations.

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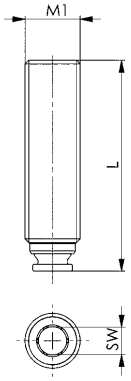
No. 7600S

Ball pressure screw

Tempered steel, burnished.



Order no.	Size	M1	L	SW	Weight [g]
556408	22	M12	43	6	30
553353	30	M16	62	8	80
554214	32	M16	55	8	70
554215	40	M20	65	10	128
553441	43	M20	80	10	165
554216	44 / 49	M24	93	12	275
564669	60	M24	105	12	320



CAD

No. 7600SE

Ball pressure screw with hexagon head for power clamp

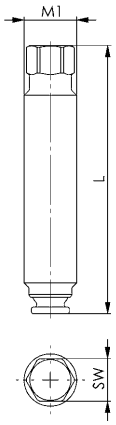
Tempered steel, burnished.



Order no.	Size	M1	L	SW	Weight [g]
571088	22	M12	50	10	37
571089	30	M16	82	13	115
571090	32	M16	66	13	88
571091	40	M20	79	16	163
571092	43	M20	79	16	202
571093	44/49	M24	112	21	353
571094	60	M24	125	21	399

Advantage:

The hexagon head of the ball pressure screw is resistant to dirt during machining processes. Process reliable clamping with a specified torque.



Recommendations



No. 7600, page 7



No. 7630, page 12

Subject to technical alterations.

No. 7600D

Pressure pad

Complete with dowel pin.
Stainless steel.

EDELSTAHL Rostfrei INOX STAINLESS STEEL



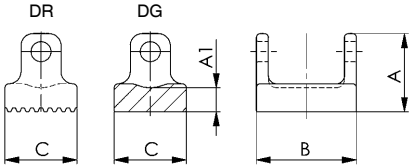
DG



DR

Order no.	Size	Form	A	A1	B	C	Weight [g]
556409	22	DG	14	4,5	19	12	11
556410	22	DR	14	4,5	19	12	10
553351	30 / 32	DG	19,5	6,0	25	18	28
553352	30 / 32	DR	19,5	6,0	25	18	27
553442	40 / 43	DG	24,0	6,5	30	20	47
553443	40 / 43	DR	24,0	6,5	30	20	48
554301	44 / 49	DG	28	7,0	36	25	75
554302	44 / 49	DR	28	7,0	36	25	78
564667	60	DG	29	8,0	43	28	115
564668	60	DR	29	8,0	43	28	110

DG = smooth contact surface, DR = wavy contact surface



CAD

Recommendations



ISO 2936C



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No. 7600DGK

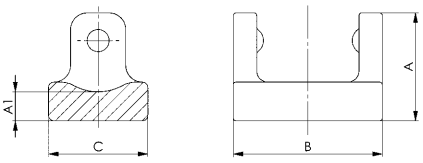
Thrust piece plastic (plain)



Order no.	Size	A	A1	B	C	Weight [g]
563695	22	12,5	3,0	20	11,4	2
563697	30 / 32	19,5	5,25	27	18,0	6
563698	40 / 43	24,0	5,75	30	24	9
563699	44 / 49	28,0	6,25	38	25	15

Advantage:

Suitable for processing sensitive workpieces/surfaces (e.g. aluminium).



Recommendations



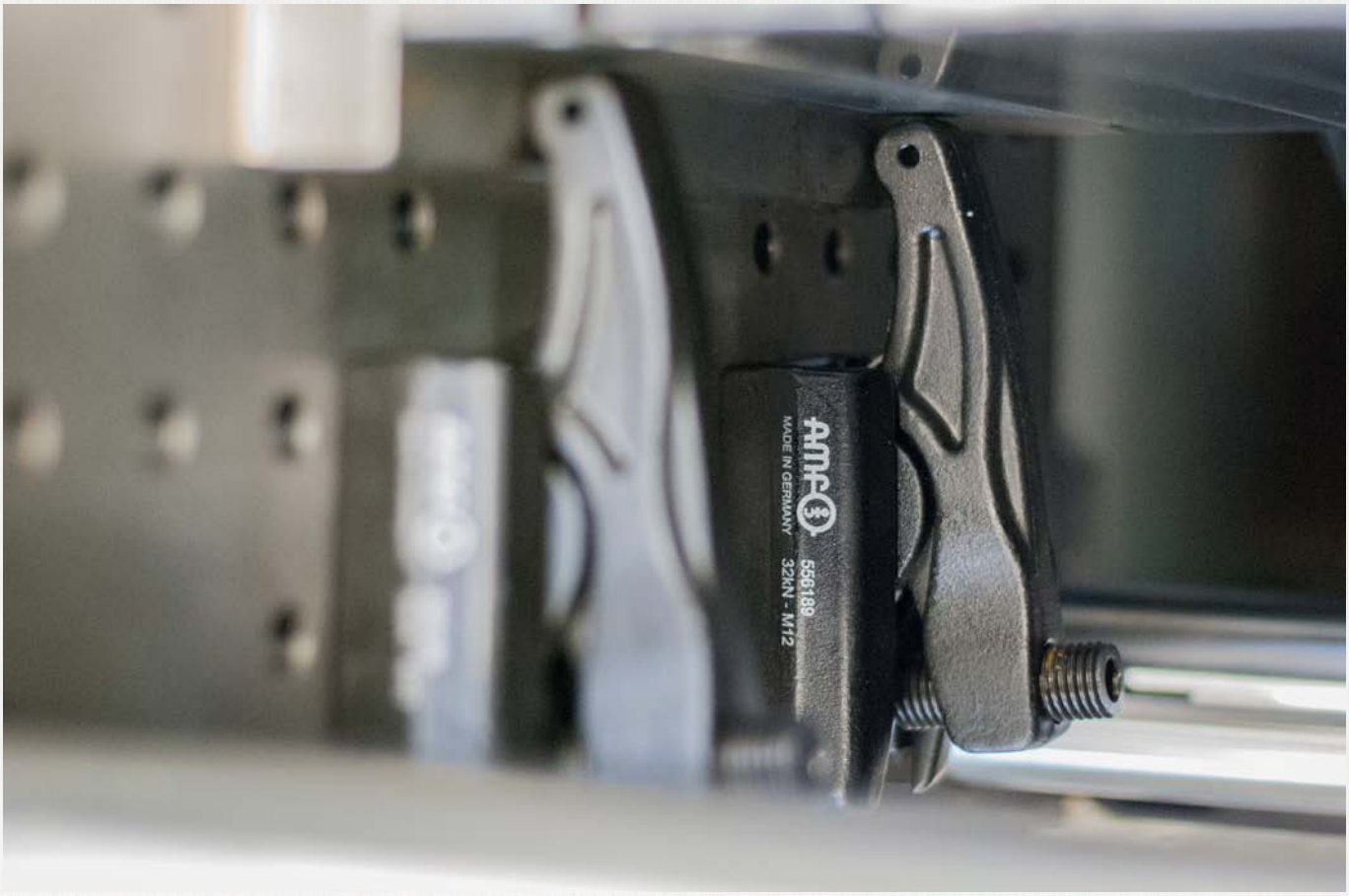
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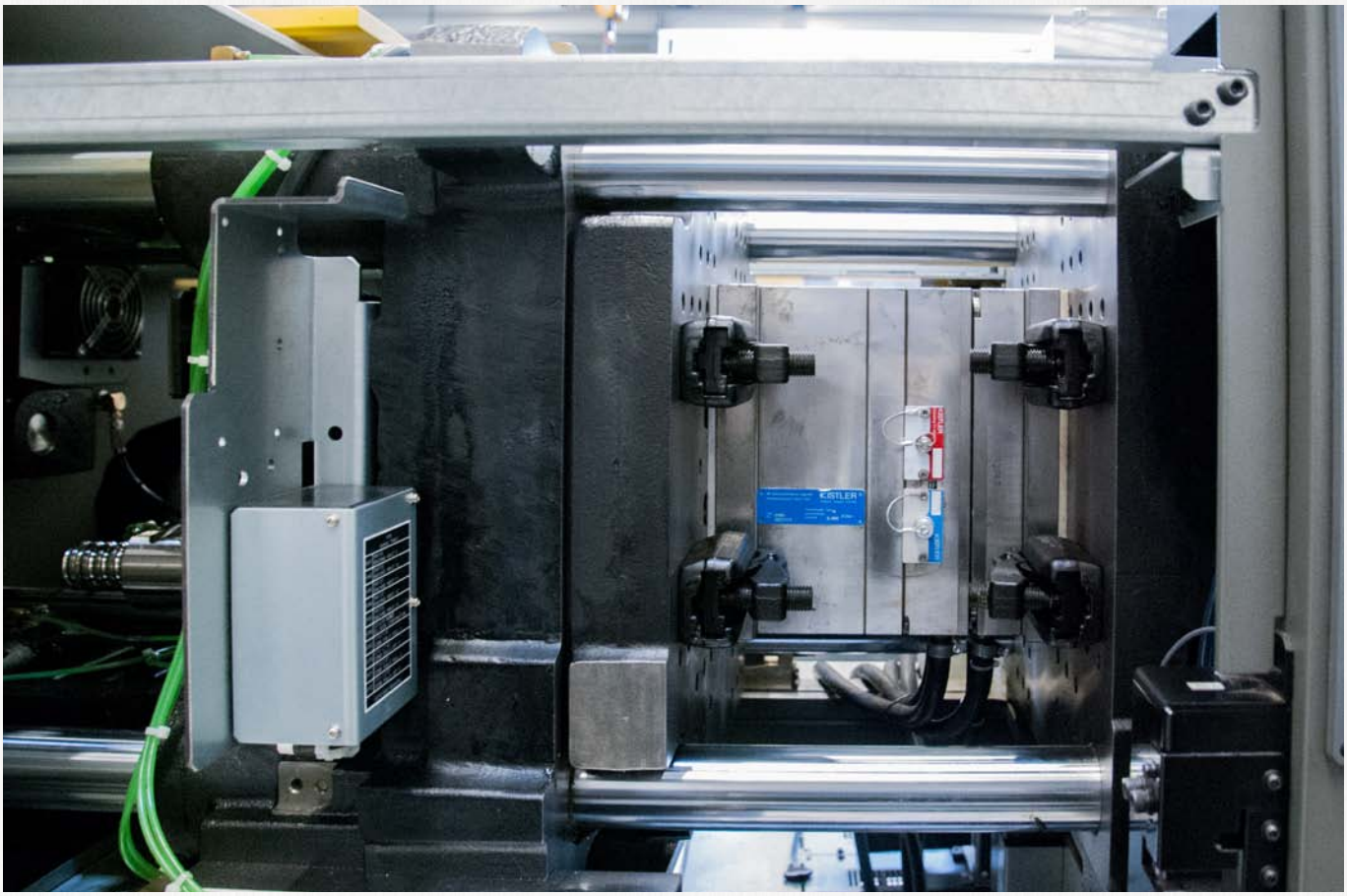


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Subject to technical alterations.

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Subject to technical alterations.

No. 7630

Power clamp 3-step

Made of alloyed tempered steel, forged and black galvanized.
Complete with 3-step support element, clamping unit and mounting kit 7630BFS.
Thrust piece in smooth and ribbed variant, optionally available.



Order no.	Size	max. load static [kN]	M	H	E	L	Weight [g]
559877	**22**	22	M12	9 - 74	30 - 58	65	1120
559879	**30**	30	M12	13 - 129	37 - 106	130	4600
559881	**43**	43	M16	16 - 147	48 - 144	150	6844
559882	**49**	49	M20	16 - 169	68 - 172	170	10870

Application:

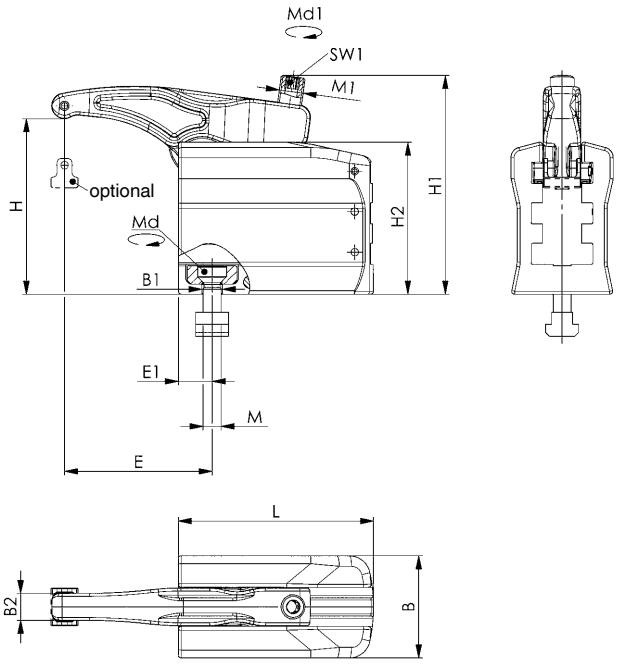
1. Position carrier element on the tool table and secure with the specified tightening torque Md.
2. Move the clamp arm to the desired position.
3. Moving the adjusting screw clamps the workpiece.

Advantage:

- Captive feature by means of threaded stud at all levels
- 3-fold continuously adjustable adjustment range
- High clamping forces of 22 kN - 49 kN
- Height and length continuously adjustable
- The very robust design enables quick and easy clamping
- Elements easy to install
- For use in T-slots 14 - 28 mm or grid plates M12, M16, M20
- 2 thrust piece variants

Note:

- The max. load may differ, depending on the manner of clamping and condition of the threads (lubrication).
- To reduce the wear on the adjusting screw, we recommend the use of AMF screw compound no. 6339. It possesses a synergistic combination of highly-effective solid lubricants, is heat-resistant, and does not wash out.
- Use only the corresponding AMF mounting kit No. 7630BFS.
- If the clamping element without T-slot nut DIN 508 is used, the tensile strength of the support plate must be at least 900 N/mm²!
- **Not suitable for use on injection moulding and die-casting machines and presses.**



Dimensions:

Order no.	Size	B	B1	B2	E1	H1	H2	M1	SW1	Md [Nm]	Md 1 [Nm]
559877	**22**	52	13,5	13,0	14,5	98	67	M12	6	40	55
559879	**30**	68	13,5	18,0	22,5	146	101	M16	8	70	100
559881	**43**	75	17,5	20,0	25,0	175	116	M20	10	150	200
559882	**49**	85	22,0	25,0	29,0	207	138	M24	12	200	220

CAD

Subject to technical alterations.

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No. 7630T

Carrier element 3-step

Made of alloyed tempered steel, forged and black galvanized.
Complete with pressure plate and mounting kit 7630BFS.

Order no.	Size	M	Slot	H	H2	L	Weight [g]
559925	22	M12	14	9 - 74	67	65	795
559926	30	M12	14	13 - 129	101	130	3440
559930	43	M16	18	16 - 147	116	150	5010
559931	49	M20	22	16 - 169	138	170	7710



Application:

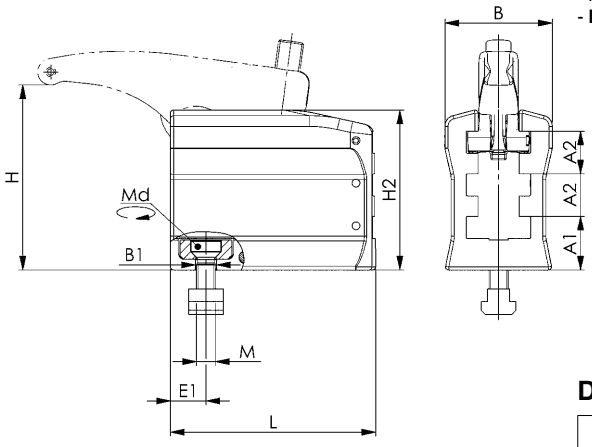
1. Position carrier element on the tool table and secure with the specified tightening torque Md.
2. Move the clamp arm to the desired position.
3. Moving the adjusting screw clamps the workpiece.

Advantage:

- Captive feature by means of threaded stud at all levels
- 3-fold continuously adjustable adjustment range
- High clamping forces of 22 kN - 49 kN
- Height and length continuously adjustable
- The very robust design enables quick and easy clamping
- Elements easy to install
- For use in T-slots 14 - 28 mm or grid plates M12, M16, M20
- 2 thrust piece variants

Note:

- The max. load may differ, depending on the manner of clamping and condition of the threads (lubrication).
- To reduce the wear on the adjusting screw, we recommend the use of AMF screw compound no. 6339. It possesses a synergistic combination of highly-effective solid lubricants, is heat-resistant, and does not wash out.
- Use only the corresponding AMF mounting kit No. 7630BFS.
- If the clamping element without T-slot nut DIN 508 is used, the tensile strength of the support plate must be at least 900 N/mm²!
- **Not suitable for use on injection moulding and die-casting machines and presses.**



Dimensions:

Order no.	Size	A1	A2	B	B1	E1	Md [Nm]
559925	22	25,0	16,5	52	13,5	14,5	40
559926	30	34,0	27,0	68	13,5	22,5	70
559930	43	43,0	29,0	75	17,5	25,0	150
559931	49	51,5	34,0	85	22,0	29,0	200

CAD

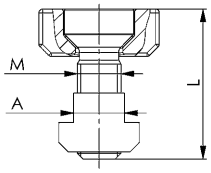
No. 7630BFS

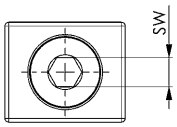
Fastening kit for carrier element 3-step

Comprising fastening bolt of strength class 12.9, T-nut DIN 508 and pressure plate.

Order no.	Size	A	L	M	SW	Weight [g]
559909	22	14	35,5	12	6	95
559912	30	14	41,0	12	8	139
559914	43	18	52,0	16	10	258
559915	49	22	66	20	12	511







CAD

Subject to technical alterations.

No. 7640

Compact clamp

Continuously adjustable clamping element made of tempered steel. Black, galvanised in tempered investment casting. Complete with fastening kit 7640BFS and captive, smooth compression piece.

Order no.	Size	max. load static [kN]	G	Slot	H	E	L	Weight [g]
567996	12	12	M12	14	0 - 100	38,5 - 59,5	141,5 - 163,0	2271
567997	16	16	M12	14	0 - 90	22,8 - 40,2	126,0 - 143,5	2166

Application:

Mount compact clamp on the machine table with fastening kit 7640BFS, then position and fasten to the machine table with the specified torque. Clamp workpiece (observe torque).

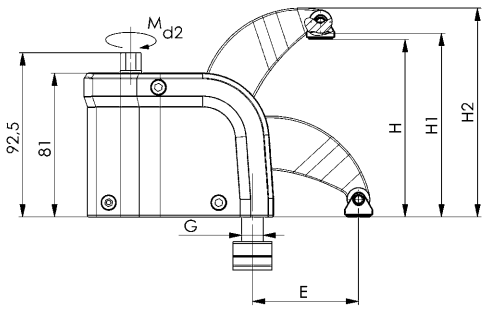
Advantage:

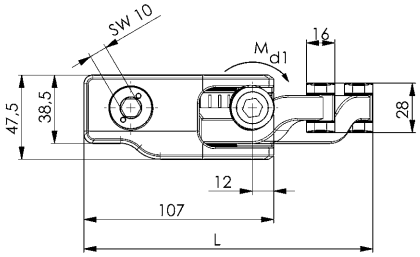
- Continuous clamping
- clamping forces 12kN / 16kN
- compact design
- height scale permits fast presetting of the clamping height
- thrust piece captive-mounted
- repels dirt and chips
- Curved clamping arm ensures reliable vertical clamping of the fastening bolt with defined torque
- The compact clamp can be connected to the spacer element 7640Z without screws through a new type of quick-action clip

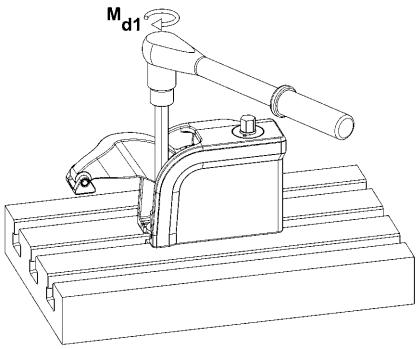
Note:

- Use only the corresponding AMF mounting kit 7640BFS.
- When using the clamping element without T-slot nut DIN508, the tensile strength of the support plate must be at least 900 N/mm^2!
- Do not clean with compressed air.

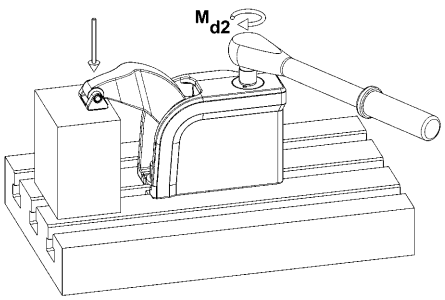








1



2

Recommendations



No. 7640Z, page 15



No. 7640D, page 20



No. 7640BFS, page 20

Dimensions:

Order no.	Size	Max. load, dynamic swelling [kN]	H1	H2	Md 1 [Nm]	Md 2 [Nm]
567996	12	9	3,5 - 103,5	56,5 - 118	40	100
567997	16	12	3,5 - 93,5	52,0 - 107	40	100

Subject to technical alterations.

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No. 7640Z

Spacer element with quick-action clip

Made of alloyed tempered steel. Black, galvanised in tempered investment casting. Complete with mounting kit 7640BFS.



Order no.	Size	Height [mm]	Md 1 [Nm]	Weight [g]
567998	12/16	80	80	1406

Application:

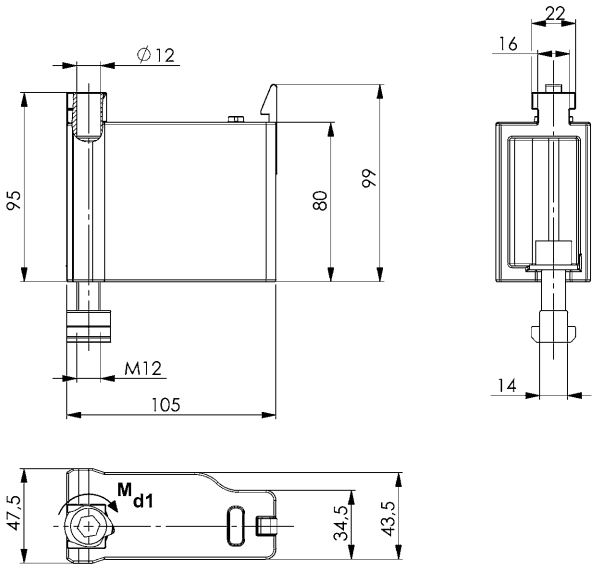
Mount the spacer element on the machine table with the fastening kit 7640BFS. Then connect the compact clamp with the quick-action clip. Fasten the clamping unit to the machine table with the specified torque. Now the workpiece can be clamped.

Advantage:

- new type of quick-action clip permits screw-free connection of the spacer elements to each other and to the compact clamp.
- Continuous transition between the clamping heights.
- Reliable clamping of the fastening bolt with defined torque guaranteed.

Note:

- Use only the corresponding AMF mounting kit 7640BFS.
- When using the clamping element without T-slot nut DIN508, the tensile strength of the support plate must be at least 900 N/mm².
- Recommendation: build a maximum of 2 spacer elements onto each other.



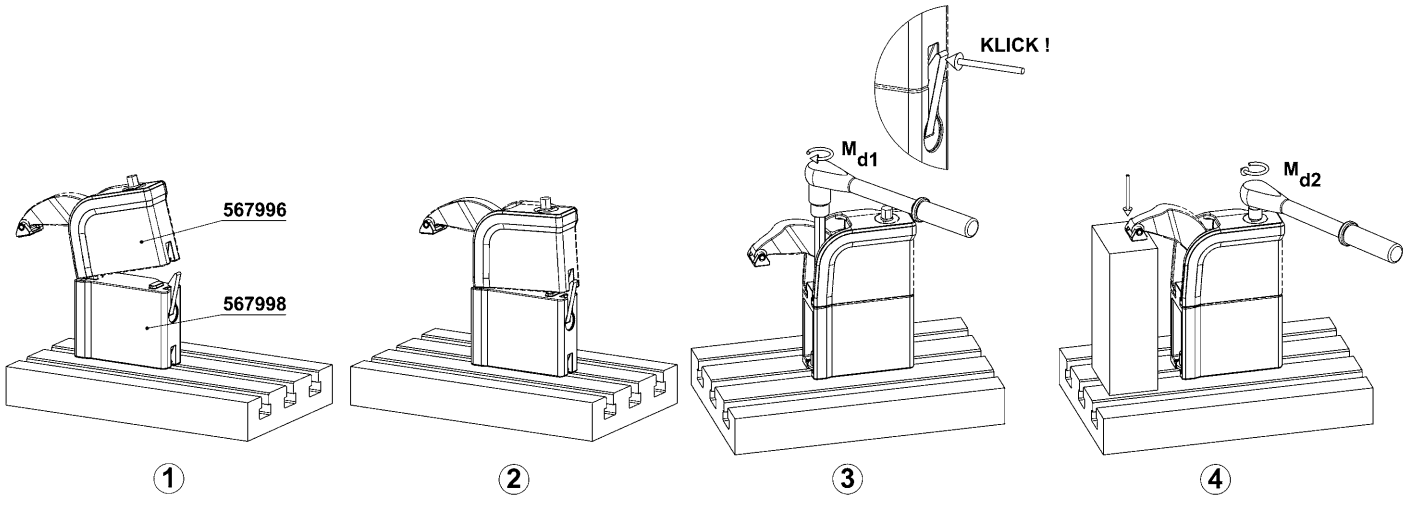
Recommendations



No. 7640, page 14



No. 7640BFS, page 20



Subject to technical alterations.

No. 7650

Swing clamp, mechanical

Burnished tempered steel, complete with fastening bolts of strength 10.9 and washers.

Order no.	Size	max. load static [kN]	G [mm]	H [mm]	L [mm]	E [mm]	Weight [g]
572511	**15**	15	M6	47 - 52	57,5	6,0	426,5
572512	**18**	18	M8	57 - 62,5	73,0	8,8	797,3
572513	**20**	20	M10	67 - 72	86,0	10,0	1329,9
572514	**25**	25	M12	87 - 92	102	16,5	2455

NEW!



Application:

The swing clamp can be positioned vertically or horizontally and fastened onto the device plate with two fastening bolts of strength 10.9. The clamp arm is clamped with the actuation bolt of strength 12.9.

Advantage:

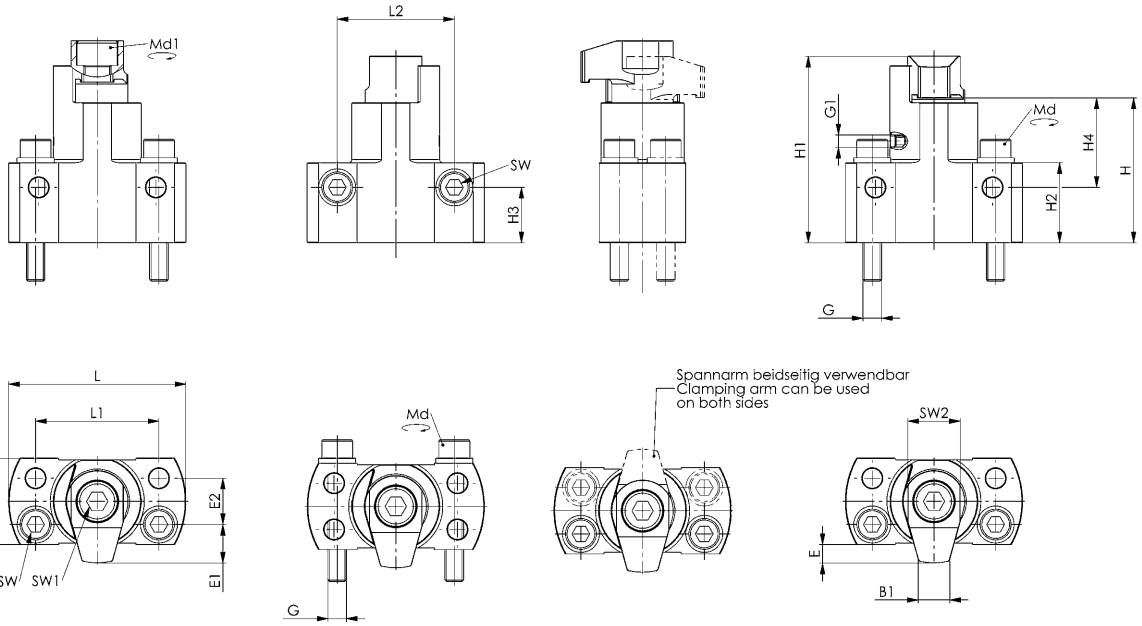
- Compact design
- Swivels right and left in a clamp
- Swivel angle 180°
- Safety-relevant stroke limitation of the clamp arm through integrated securing
- High tensioning force ensures secure fixing even under high loads

Note:

- The maximum load may differ depending on the condition of the attaching threads of the screws (lubrication).
- When using the clamping element on device plates, the tensile strength of the device plate must be at least 900 N/mm^2.
- To reduce wear to the fastening and actuation bolt, we recommend using AMF screw compound No. 6339. It possesses a synergistic combination of highly-effective solid lubricants and is heat-resistant.

On request:

Other sizes.



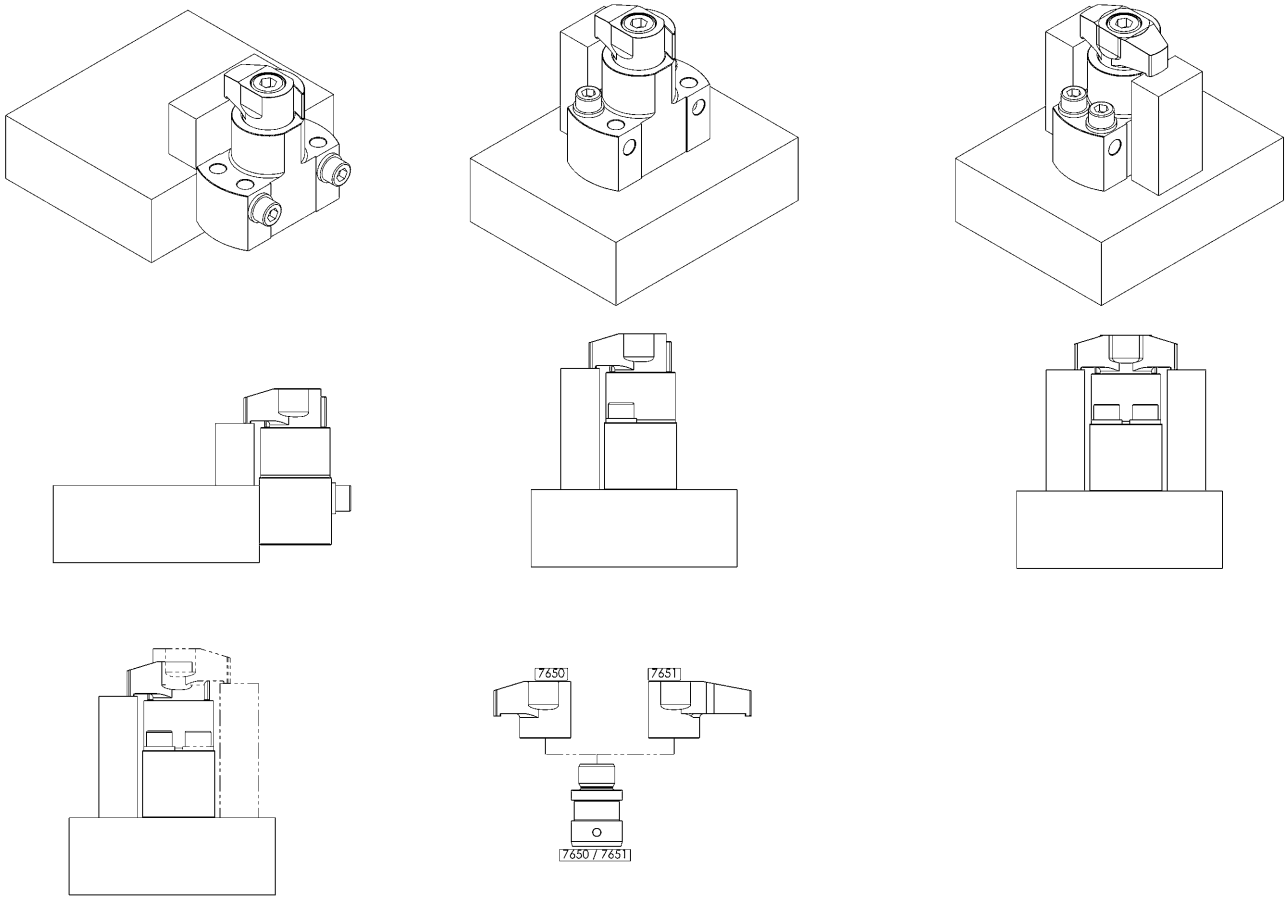
Dimensions:

Order no.	Size	B [mm]	B1 [mm]	E1 [mm]	E2 [mm]	G1 [mm]	H1 [mm]	H2 [mm]	H3 [mm]	H4 [mm]	L1 [mm]	L2 [mm]	Md [Nm]	Md 1 [Nm]	SW [mm]	SW 1 [mm]
572511	**15**	28	10	12,5	15	M4	60,7 - 66,8	26,0	18	29 - 34	40	38	14	30	5	6
572512	**18**	34	12	17,5	17	M5	72,5 - 78,0	31,5	21	36 - 41,5	53	48	36	50	6	8
572513	**20**	40	15	20,5	19	M5	85,5 - 90,5	37,5	24	43 - 48	62	55	67	60	8	10
572514	**25**	48	18	29,5	22	M6	112 - 117	48,0	32	55 - 60	74	65	120	110	10	14

Subject to technical alterations.

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Application examples:



No. 7651

Swing clamp, mechanical, modular

Body: painted tempered steel.
Base element: burnished tempered steel.

NEW!



Order no.	Size	max. load static [kN]	G [mm]	H [mm]	L [mm]	E [mm]	Weight [g]
572515	10	10	M12	63,5 - 68,5	50	5	696
572516	13	13	M12	72 - 77	50	7	836
572517	14	14	M12	81,5 - 86,5	50	10	1083
572518	15	15	M16	100 - 105	50	20	1716

Application:

The swing clamp can be positioned vertically or horizontally and fastened onto device plates and T-slot tables. The clamp arm is clamped with the actuation bolt of strength 12.9.

Advantage:

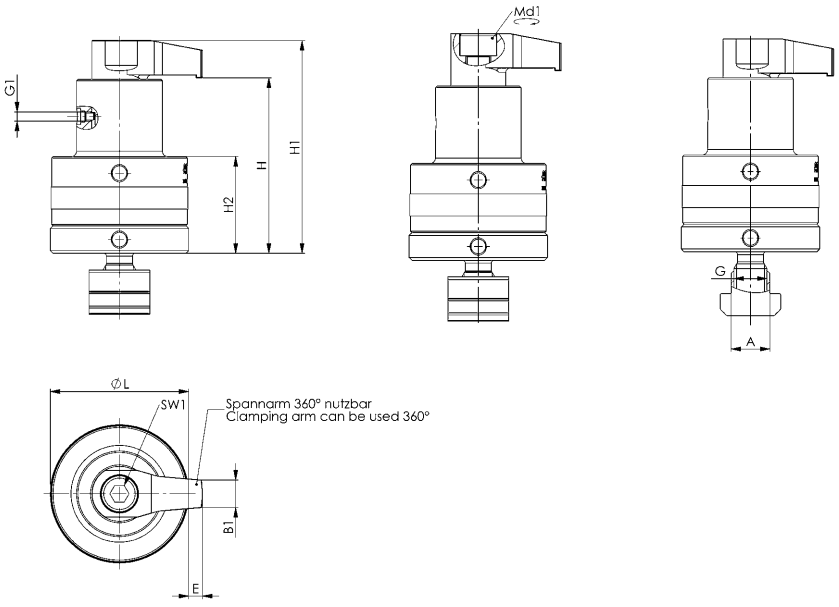
- Compact, modular design
- Use of the AMF spacer elements 6400Z, with a maximum installation height of 50 mm
- Use of the AMF base elements 6400FB M12 and M16
- Swivel angle 360°
- Safety-relevant stroke limitation of the clamp arm through integrated securing
- High clamping force ensures secure fixing even under high loads

Note:

- The maximum load may differ depending on the condition of the attaching threads of the screws (lubrication).
- When using the clamping element on device plates, the tensile strength of the device plate must be at least 900 N/mm^2.
- To reduce wear to the fastening and actuation bolt, we recommend using AMF screw compound No. 6339. It possesses a synergistic combination of highly-effective solid lubricants and is heat-resistant. The swing clamp can be positioned vertically or horizontally and fastened onto the device plate with two fastening bolts of strength 10.9.

On request:

Other sizes.



Dimensions:

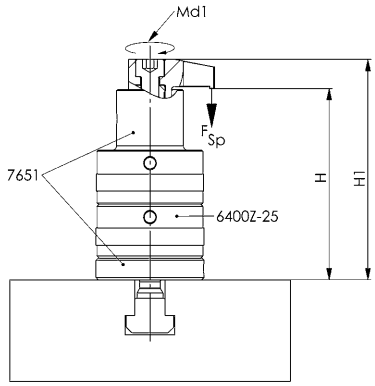
Order no.	Size	A [mm]	B1 [mm]	G1 [mm]	H1 [mm]	H2 [mm]	Md 1 [Nm]	SW 1 [mm]
572515	10	14	9	M4	77 - 82	35	25	6
572516	13	14	11	M5	87,5 - 92,5	35	30	8
572517	14	14	13	M5	100 - 105	35	40	10
572518	15	18	17	M6	125 - 130	35	50	14

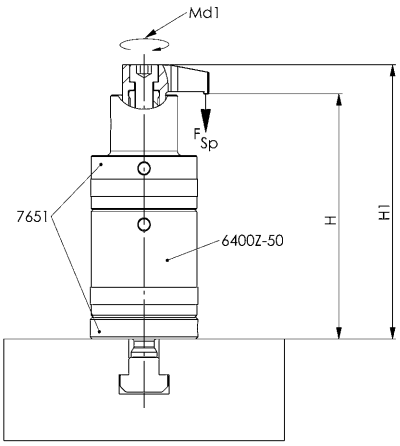
Subject to technical alterations.

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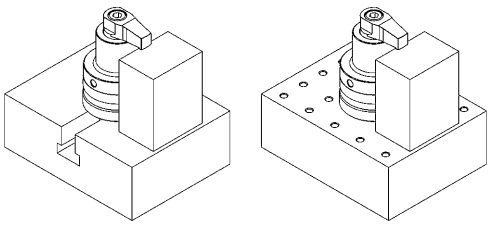
Installation recommendations and dimensions when using AMF intermediate elements 6400Z-25 and 6400Z-50:

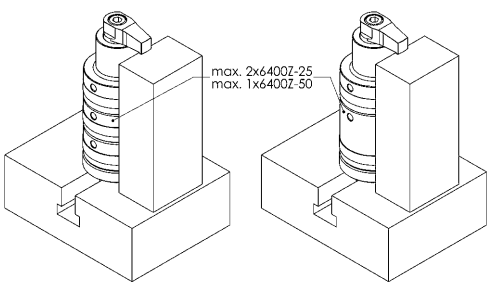
Size	6400Z	Number	H [mm]	H1 [mm]	Md 1 [Nm]	FSp [kN]
10	6400Z-25	1	88,5 - 93,5	102 - 107	20	9
		2	113,5 - 118,5	127 - 132		
	6400Z-50	1	113,5 - 118,5	127 - 132		
13	6400Z-25	1	97 - 102	112,5 - 117,5	25	11
		2	122 - 124	137,5 - 142,5		
	6400Z-50	1	122 - 127	137,5 - 142,5		
14	6400Z-25	1	106,5 - 111,5	125 - 130	27	10
		2	131,5 - 136,5	150 - 155		
	6400Z-50	1	131,5 - 135,6	150 - 155		
15	6400Z-25	1	125 - 130	150 - 155	35	9
		2	150 - 155	175 - 180		
	6400Z-50	1	150 - 155	175 - 180		





Application examples:





Subject to technical alterations.

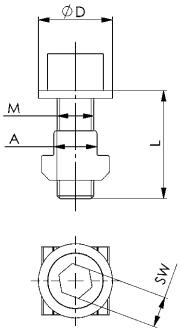
No. 7640BFS

Mounting kit

Consisting of cylinder screw ISO4762, T-nut 508, disc ISO7090.



Order no.	Size	A	dia. D	L	M	SW	Weight [g]
568000	**12/16**	14	24	30	M12	10	90



No. 7640D

Thrust piece set

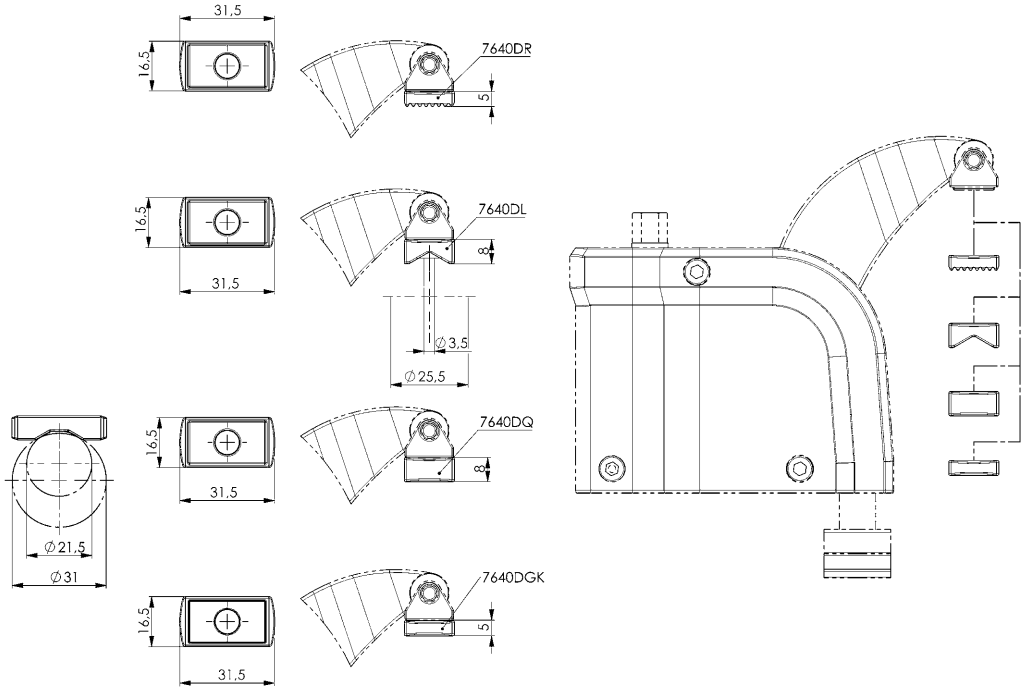
Top parts with magnetic insert.
Design: fluted, crosswise prism, lengthwise prism and plastic.

Order no.	Size	Weight [g]
567999	12/16	60

Advantage:

Depending on the workpiece surface, top parts can be attached easily and quickly to the existing thrust piece using the installed magnet.





Subject to technical alterations.

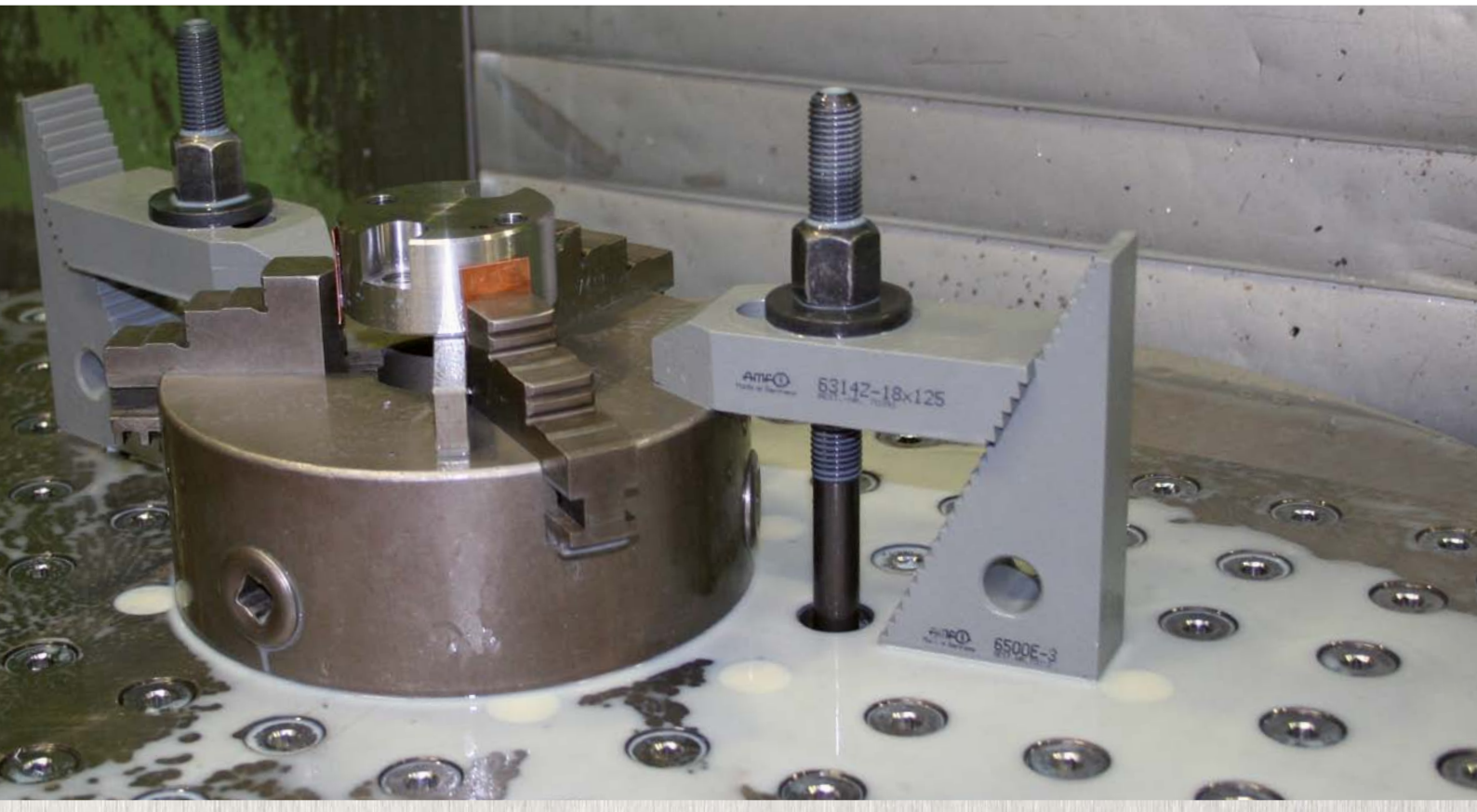
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CLAMPING WITH SINGLE CLAMPS OR WITH COMPACT CLAMPING UNITS

- **Material:** Tempering steel to DIN regulations.
- **Machining:** Plane-parallel base- and clamping faces ensure safe force transmission.
- **Tempering:** According to DIN regulations.
- **Finishing:** All clamps are abrasionproof quality varnished, or of equal quality finish.

Where high clamping forces or flexible adaption to shapes and sizes of workpieces are demanded, we offer our single clamps or clamping combinations by using our adjustable clamps.
All AMF-clamps shown in this catalogue be combined with different support blocks and are therefore adaptable to different shaped and sized workpieces.

The Advantages of these adjustable clamps are theire unsiversal application abilities for single parts up to medium series production with changing clamping dimensions. They allow simple and fast horizontal and vertical application, are interchangeable and price worthy. Their compact design ensures high clamping forces even at large clamping dimensions.



No. 6312V

„Crocodile“ clamp

Continuously adjustable, tempered, galvanized, with undetachable compression piece and back support.



Order no.	B1	for clamping screw	Slot	Clamping force max.* [kN]	H1	L	Weight [g]
79756	13	M10, M12	10, 12, 14	30	0-55	115	661
79798	17	M12, M16	12, 14, 16, 18	40	0-70	150	1494
79855	21	M16, M20	16, 18, 20, 22	60	0-80	187	2252
79913	25	M20, M24	20, 22, 24, 28	75	0-100	235	3635
376475	25	M20, M24	20, 22, 24, 28	75	0-100	285	4335

* Specified clamping forces in optimal clamping position (smallest distance from the clamping screw to the clamping point). Clamping forces can vary depending clamping, strength class of the clamping screw and condition of the thread (lubrication).

Application:

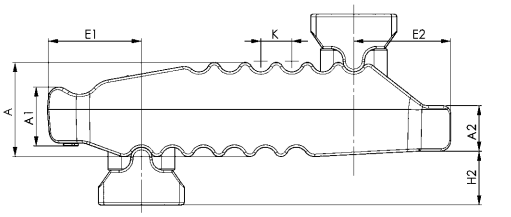
The crocodile clamping claw is used for all clamping tasks using T-slots and threaded holes. Thrust piece and counter-bearing are connected permanently to the clamping jaw, and thus the crocodile is quickly ready to use. The clamping jaw features two ridges and can be turned around easily depending on the application. In this way, it is possible to cover all fields of application involving cutting and non-cutting processes (e.g. injection moulding and pressure forming).

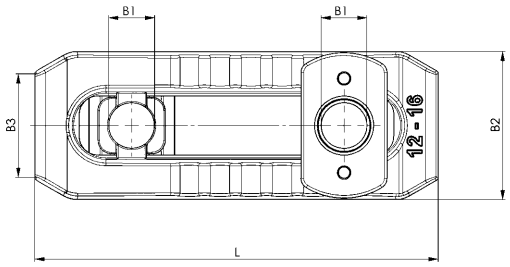
Advantage:

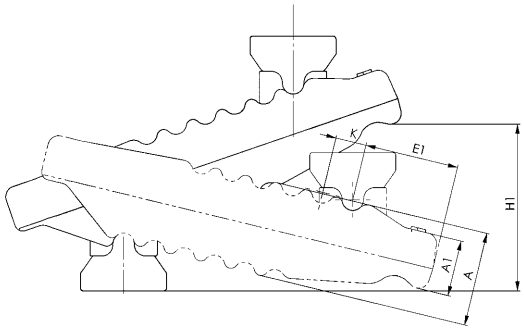
- Variable and fast adjustment option at a distance from the workpiece
- Use in all areas involving cutting and non-cutting processes
- Especially well-suited for use on injection moulding machines and presses
- No additional supports needed to achieve the required clamping height
- Thrust piece and counter-bearing are connected permanently to the clamping jaw
- The crocodile can be extended easily for every clamping height.

Note:

For clamping, either clamping studs DIN 787, studs DIN 6379 and cylinder screws ISO 4762 can be used. Greater clamping heights can be achieved using the support extension No. 6312S.
A washer disc DIN 6340 must always be used between the hexagonal nut and compression piece!







Dimensions:

Order no.	A	A1	A2	B2	B3	E1	E2	H2	K
79756	27	17	12	44	30	25	30	18	11
79798	36	21	17	55	41	35	36	20	12
79855	42	27	20	62	30	44	44	30	14
79913	51	34	24	70	30	60	47	31	17
376475	56	35	24	73	30	62	51	35	17

Recommendations



No. 6312S, page 26



No. 787, page 96



No. 6379I, page 102

CAD

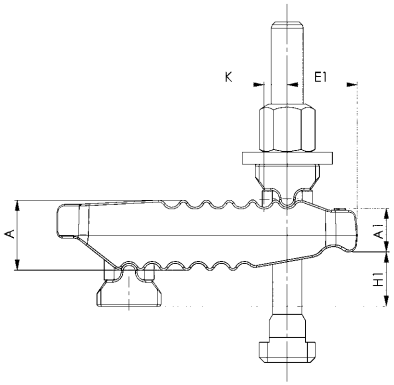
Subject to technical alterations.

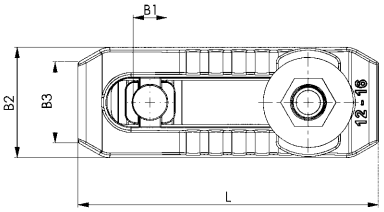
No. 6312VT

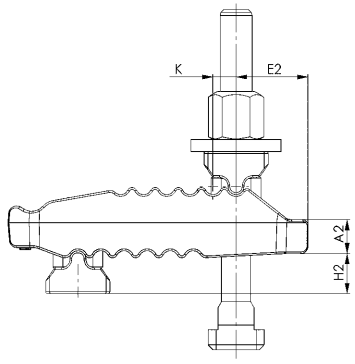
„Crocodile“ clamp, complete with DIN 787

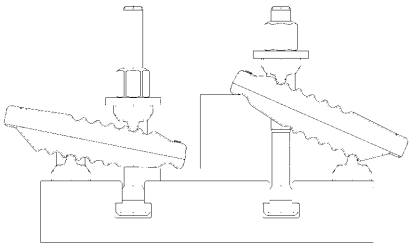
with clamping bolt DIN 787, washer DIN 6340 and nut DIN 6330B. Infinitely adjustable, tempered, galvanised with captive compression piece and counter bearing.











Order no.	B1	Slot	Clamping bolt DIN 787	Clamping force max.* [kN]	H1	Weight [g]
79780	13	10	M10x10x100	25	0-40	613
79806	13	12	M12x12x125	30	0-55	686
79822	13	14	M12x14x125	30	0-55	705
79848	17	12	M12x12x160	35	0-70	1591
79863	17	14	M12x14x160	35	0-70	1610
79889	17	16	M16x16x160	40	0-70	1798
79905	17	18	M16x18x160	40	0-70	1818
79921	21	16	M16x16x200	55	0-80	2715
79210	21	18	M16x18x200	55	0-80	3018
79228	21	20	M20x20x200	60	0-80	3018
374926	21	22	M20x22x200	60	0-80	3060
374942	25	20	M20x20x250	70	0-100	4368
374967	25	22	M20x22x250	70	0-100	4410
374983	25	24	M24x24x250	75	0-100	4895
375006	25	28	M24x28x250	75	0-100	4966

* Specified clamping forces in optimal clamping position (smallest distance from the clamping screw to the clamping point). Clamping forces can vary depending clamping, strength class of the clamping screw and condition of the thread (lubrication).

Application:

The crocodile clamping claw is used for all clamping tasks using T-slots and threaded holes. Thrust piece and counter-bearing are connected permanently to the clamping jaw, and thus the crocodile is quickly ready to use. The clamping jaw features two ridges and can be turned around easily depending on the application. In this way, it is possible to cover all fields of application involving cutting and non-cutting processes (e.g. injection moulding and pressure forming).

Advantage:

- Variable and fast adjustment option at a distance from the workpiece
- Use in all areas involving cutting and non-cutting processes
- Especially well-suited for use on injection moulding machines and presses
- No additional supports needed to achieve the required clamping height
- Thrust piece and counter-bearing are connected permanently to the clamping jaw
- The crocodile can be extended easily for every clamping height.

Note:

For missing dimensions, see No. 6312V.

Dimensions:

Order no.	A	A1	A2	B2 x L	B3	E1	E2	H2	K
79780	27	17	12	44x115	30	25	30	18	11
79806	27	17	12	44x115	30	25	30	18	11
79822	27	17	12	44x115	30	25	30	18	11
79848	36	21	17	55x150	41	35	36	20	12
79863	36	21	17	55x150	41	35	36	20	12
79889	36	21	17	55x150	41	35	36	20	12
79905	36	21	17	55x150	41	35	36	20	12
79921	42	27	20	62x187	30	44	44	30	14
79210	42	27	20	62x187	30	44	44	30	14
79228	42	27	20	62x187	30	44	44	30	14
374926	42	27	20	62x187	30	44	44	30	14
374942	51	34	24	70x235	30	60	47	31	17
374967	51	34	24	70x235	30	60	47	31	17
374983	51	34	24	70x235	30	60	47	31	17
375006	51	34	24	70x235	30	60	47	31	17

Recommendations



No. 6312S, page 26



No. 787, page 96



No. 6379I, page 102

CAD

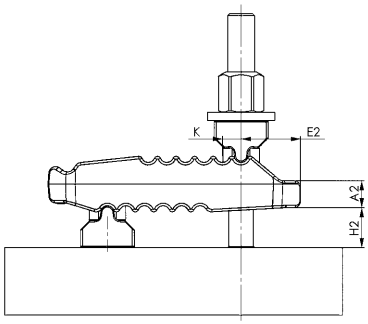
Subject to technical alterations.

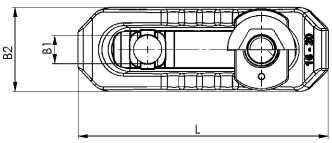
No. 6312VS

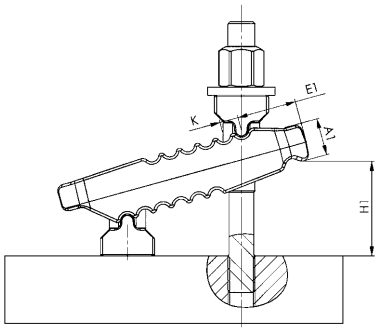
„Crocodile“ clamp, complete with DIN 6379

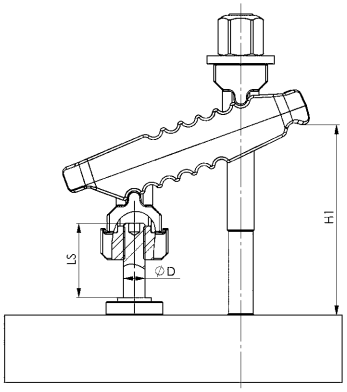
with stud bolt DIN 6379, washer DIN 6340 and nut DIN 6330B. Infinitely adjustable, tempered, galvanised with captive compression piece and counter bearing.











Order no.	B1	Clamping bolt DIN 6379	Support extension 6312V	Clamping force max.* [kN]	H1	Weight [g]
375766	13	M12x100	-	30	0-30	639
375782	13	M12x125	-	30	0-55	659
375808	17	M12x125	-	40	0-50	1535
375824	17	M12x160	-	40	0-70	1558
375840	17	M16x125	-	40	0-40	1660
375865	17	M16x160	-	40	0-70	1718
375881	21	M20x160	-	60	0-40	2754
375907	21	M20x200	-	60	0-80	2834
375923	25	M20x200	-	75	0-70	4072
375949	25	M20x250	-	75	0-100	4172
375964	25	M24x200	-	75	0-50	4374
375980	25	M24x250	-	75	0-100	4524
375816	21	M20x250	M16x55	60	30-141	3428
375832	21	M20x315	M16x90	60	40-190	3704
375857	25	M20x315	M20x69	75	50-175	5438
375873	25	M20x400	M20x109	75	50-220	5873
375899	25	M24x315	M20x69	75	45-180	5850
375915	25	M24x400	M20x109	75	45-215	6350

* Specified clamping forces in optimal clamping position (smallest distance from the clamping screw to the clamping point). Clamping forces can vary depending clamping, strength class of the clamping screw and condition of the thread (lubrication).

Application:

The crocodile clamping claw is used for all clamping tasks using T-slots and threaded holes. Thrust piece and counter-bearing are connected permanently to the clamping jaw, and thus the crocodile is quickly ready to use. The clamping jaw features two ridges and can be turned around easily depending on the application. In this way, it is possible to cover all fields of application involving cutting and non-cutting processes (e.g. injection moulding and pressure forming).

Advantage:

- Variable and fast adjustment option at a distance from the workpiece
- Use in all areas involving cutting and non-cutting processes
- Especially well-suited for use on injection moulding machines and presses
- No additional supports needed to achieve the required clamping height
- Thrust piece and counter-bearing are connected permanently to the clamping jaw
- The crocodile can be extended easily for every clamping height.

Note:

For missing dimensions, see no. 6312V.

Dimensions:

Order no.	A	A1	A2	B2 x L	B3	E1	E2	H2	K
375766	27	17	12	44x115	30	25	30	18	11
375782	27	17	12	44x115	30	25	30	18	11
375808	36	21	17	55x150	41	35	36	20	12
375824	36	21	17	55x150	41	35	36	20	12
375840	36	21	17	55x150	41	35	36	20	12
375865	36	21	17	55x150	41	35	36	20	12
375881	42	27	20	62x187	30	44	44	30	14
375907	42	27	20	62x187	30	44	44	30	14
375923	51	34	24	70x235	30	60	47	31	17
375949	51	34	24	70x235	30	60	47	31	17
375964	51	34	24	70x235	30	60	47	31	17
375980	51	34	24	70x235	30	60	47	31	17
375816	42	27	20	62x187	30	44	44	63-91	63
375832	42	27	20	62x187	30	44	44	63-123	63
375857	51	34	24	70x235	30	60	47	72-108	72
375873	51	34	24	70x235	30	60	47	72-147	72
375899	51	34	24	70x235	30	60	47	72-108	72
375915	51	34	24	70x235	30	60	47	72-147	72

Recommendations



No. 6312S, page 26



No. 6379I, page 102

CAD

Subject to technical alterations.

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No. 6312VI

„Crocodile“ clamp, complete with no. 6379I

with stud no. 6379I, hexagon screwdriver ISO 2936C, washer DIN 6340 and nut DIN 6330B. Continuously adjustable, tempered, galvanised with captive thrust piece and counter bearing.



Order no.	B1	Clamping bolt No. 6379I	Clamping force max.* [kN]	H1	SW [mm]	Weight [g]
375956	13	M12x100	30	0-30	4	639
375972	13	M12x125	30	0-55	4	659
375998	17	M12x125	40	0-50	4	1535
376004	17	M12x160	40	0-70	4	1558
376012	17	M16x125	40	0-40	4	1660
376020	17	M16x160	40	0-70	4	1718
376038	21	M16x160	60	0-40	4	2587
376046	21	M16x200	60	0-80	4	2625
376053	21	M20x160	60	0-40	5	2745
376061	21	M20x200	60	0-80	5	2834
376079	25	M20x200	75	0-70	5	4072
376087	25	M20x250	75	0-100	5	4172
376103	25	M24x200	75	0-50	5	4374
376095	25	M24x250	75	0-100	5	4524

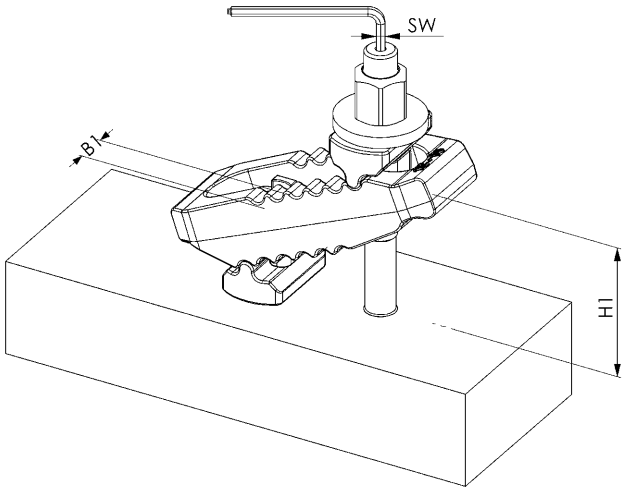
* Specified clamping forces in optimal clamping position (smallest distance from the clamping screw to the clamping point). Clamping forces can vary depending clamping, strength class of the clamping screw and condition of the thread (lubrication).

Advantage:

For better handling when setting up the clamping element, the threaded pin can be mounted and removed using an Allen key.

Note:

Use the Allen key only to set up the clamping element, not for clamping!
For missing dimension, see no. 6312V.



CAD

Recommendations



No. 6312S, page 26

Subject to technical alterations.

No. 6312S

Support extension

Steel, galvanised and tempered, support screw, hardened, strength class 8.8. Comprising body, support screw and fastening bolts.

Order no.	B1	D x LS	A	B	C	D1	E	G	H	K	Weight [g]
79772	13	M10x39	10	30	30	30	44	M5	18 - 40	8	197
79814	17	M12x49	16	35	42	36	54	M5	25 - 53	10	433
79830	17	M12x94	16	35	42	36	54	M5	26 - 96	10	473
79871	21	M16x55	20	40	50	42	60	M5	33 - 61	13	608
79897	21	M16x90	20	40	50	42	60	M5	33 - 93	13	640
79749	25	M20x69	25	50	46	50	70	M6	41 - 77	16	910
79764	25	M20x109	25	50	46	50	70	M6	41 - 116	16	1000

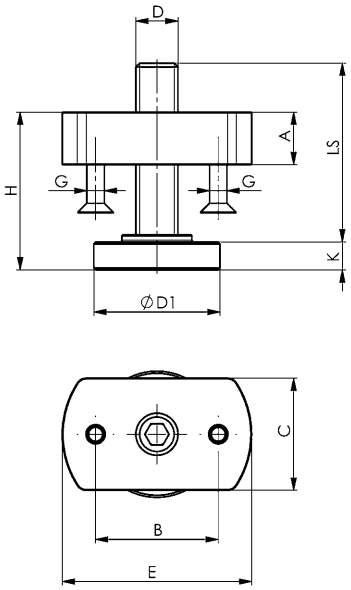


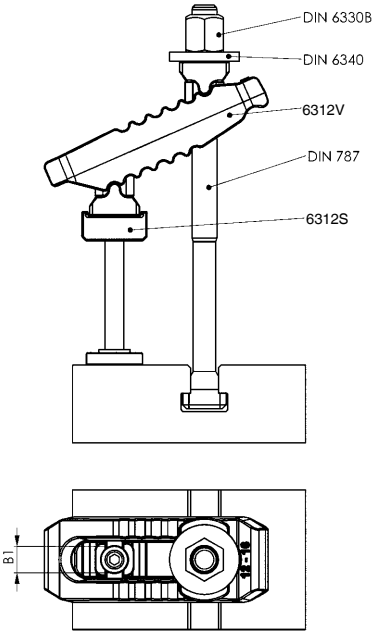
Application:

To increase the clamping height, the support extension is screwed to the counter-bearing of the crocodile.

Advantage:

Continuous adjustment of clamping heights.





CAD

The right size for your application is always available, for example, order no. 6312V, without clamping bolt

Requirements: Table slot 18 / required clamping height: 125 mm / required clamping force: 35 kN

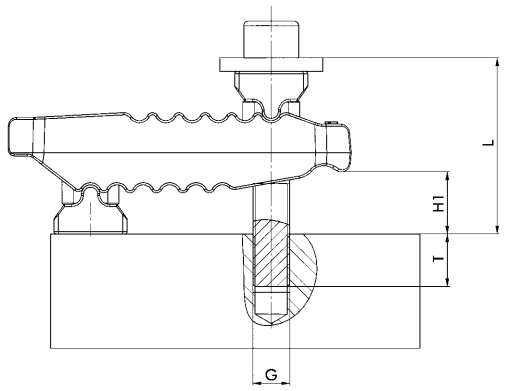
1) Select clamp no. 6312V
Groove 18 ▶ clamping force 40 kN ▶ B1 = 17 ▶ crocodile order no. 79798

2) For a clamping height of 125 mm, support extension no. 6312S is used
B1 = 17 ▶ groove 18 ▶ clamping height 125 mm (clamping range 26-166 mm) ▶ DxLS = M12x94 ▶ Support extension order no. 79830

3) Size of the T-slot bolts DIN787, complete with washer and hexagon nut
M16x18x250 ▶ order no. 81042

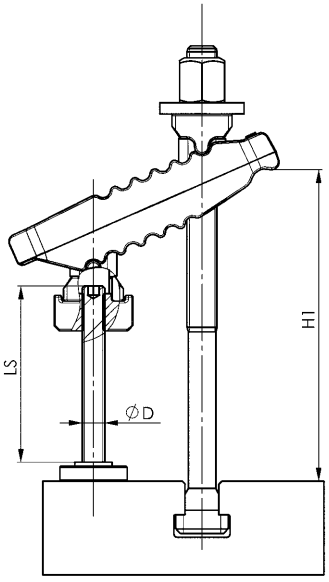
Subject to technical alterations.

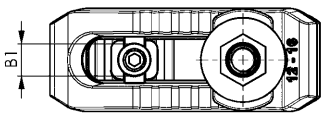
Installation recommendations and dimensions when using the clamping bolt ISO 4762 (without support extension 6312S)



B1	Dimensions ISO 4762 G x L	Clamping height H1	Thread depth T
13	M10x80	4-25	15-31
13	M10x90	17-40	15-31
13	M10x100	31-55	15-31
13	M12x80	0-20	18-33
13	M12x90	10-34	18-36
13	M12x100	22-50	18-36
17	M12x90	0-22	18-34
17	M12x110	24-50	18-36
17	M12x120	38-66	18-36
17	M16x100	0-26	24-43
17	M16x110	12-40	24-44
17	M16x120	26-55	24-44
21	M16x120	2-29	24-44
21	M16x130	15-43	24-44
21	M16x150	43-72	24-44
21	M20x140	18-48	30-52
21	M20x150	31-63	30-52
21	M20x160	45-78	30-52
25	M20x160	23-54	30-52
25	M20x180	51-83	30-52
25	M20x195	72-100	34-52
25	M24x140	0-15	36-48
25	M24x160	10-42	36-60
25	M24x180	37-71	36-60

Installation recommendations and dimensions when using the clamping bolt DIN 787 (with support extension 6312S)





B1	D x LS	Dimensions DIN 787	Clamping range H1
13	M10x39	M10x10x100	18-31
13	M10x39	M12x12x160	18-95
13	M10x39	M12x14x160	18-95
17	M12x49	M12x12x200	26-123
17	M12x49	M12x14x200	26-123
17	M12x49	M16x16x200	26-123
17	M12x49	M16x18x200	26-123
17	M12x94	M12x12x200	26-120
17	M12x94	M12x14x200	26-120
17	M12x94	M16x16x250	26-166
17	M12x94	M16x18x250	26-166
21	M16x55	M16x16x250	33-141
21	M16x55	M16x18x250	33-141
21	M16x55	M20x20x250	33-141
21	M16x55	M20x22x250	33-141
21	M16x90	M16x16x250	33-150
21	M16x90	M16x18x250	33-150
21	M16x90	M20x20x315	33-173
21	M16x90	M20x22x315	33-173
25	M20x69	M20x20x315	41-177
25	M20x69	M20x22x315	41-177
25	M20x69	M24x24x315	41-177
25	M20x69	M24x28x315	41-177
25	M20x109	M20x20x315	41-197
25	M20x109	M20x22x315	41-193
25	M20x109	M24x24x315	41-180
25	M20x109	M24x28x315	41-180

Subject to technical alterations.

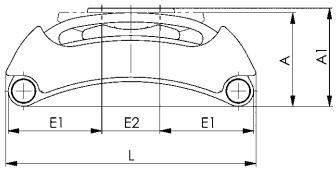
No. 6310

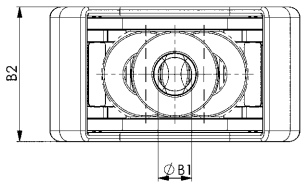
Clamp with plastic cap

and U-piece undetachable, (without clamping stud), burnished tempered steel.

CAD







Order no.	Size	for clamping screw	H1 *	B1	B2	L	A	A1	E1	Weight [g]
376863	10	M10	0-15	11	44	80	30,5	32,0	30	257
376889	14	M12 M14	0-33	14	57	125	47,0	49,5	37	708
376905	18	M16 M18	0-45	18	67	160	58,5	62,0	49	1235
376921	22	M20 M22	0-65	22	72	200	71,5	75,0	58	1880
376947	26	M22 M24	0-85	26	82	250	89,5	94,0	74	2799

*depending on depth of slot to DIN 650 and position of fixture nut.

Application:

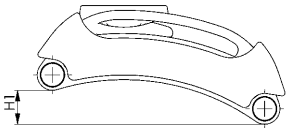
The clamp is used for all clamping tasks in which clamping is effected via T-grooves, grooves and threaded bores.

Advantage:

Weight-saving thanks to lightweight design. Variable and fast adjustment option at a distance from the workpiece. No additional clamping supports are needed to reach the required clamping height. The U-piece is undetachable from the clamp.

Note:

For clamping, either clamping screws DIN 787, stud bolts DIN 6379 and cheese head screws ISO 4762 can be used.
A washer DIN 6340 must always be used between the hexagonal nut and U-piece!



Recommendations



DIN 6340, page 113



DIN 787, page 94



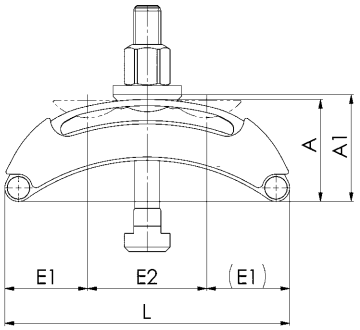
DIN 6330B, page 107

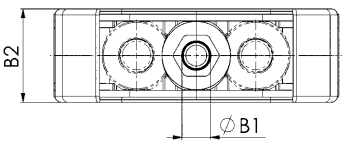
No. 6310

Clamp with plastic cap, complete

with DIN 787, DIN 6340, DIN 6330B and undetachable U-piece, burnished tempered steel.







Order no.	Slot	with clamping stud	H1 *	B1	B2	L	A	A1	E1	E2	Weight [g]
376555	10	M10x10x80	0-15	11	44	80	30,5	32,0	30	19	349
376871	12	M12x12x100	0-33	14	57	125	47,0	49,5	37	51	886
376897	14	M12x14x125	0-33	14	57	125	47,0	49,5	37	51	905
376913	16	M16x16x160	0-45	18	67	160	58,5	62,0	49	63	1648
376939	18	M16x18x160	0-45	18	67	160	58,5	62,0	49	63	1668

*depending on depth of slot to DIN 650 and position of fixture nut.

Application:

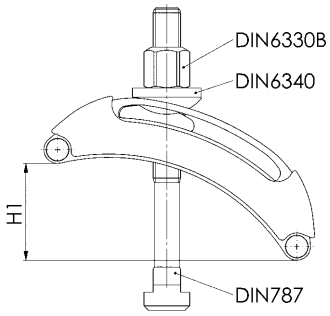
The clamp is used for all clamping tasks in which clamping is effected via T-grooves, grooves and threaded bores.

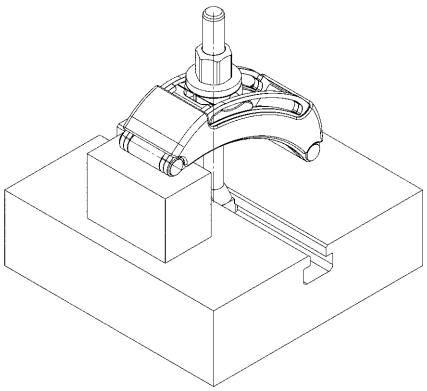
Advantage:

Weight-saving thanks to lightweight design. Variable and fast adjustment option at a distance from the workpiece. No additional clamping supports are needed to reach the required clamping height. The U-piece is undetachable from the clamp.

Note:

A washer DIN 6340 must always be used between the hexagonal nut and U-piece!





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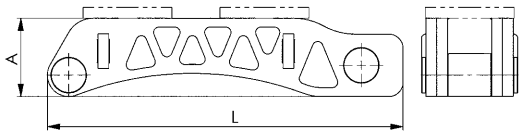
No. 6311

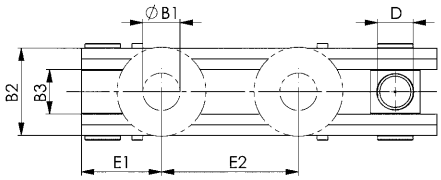
Clamp, „light design“

Tempered steel, burnished.

CAD







Order no.	Size	for clamping screw	B1	B2	B3	D	L	A	E1	E2	Weight [g]
376962	22	M20 M22	22	49	25	M20	200	44	45	77	1289
377002	26	M24	26	54	30	M24	250	44	46	116	1630
377044	33	M30	33	72	40	M30	315	71	59	152	4522
377069	43	M36 M42	43	102	54	M30	400	80	74	209	9709

*depending on depth of slot to DIN 650 and position of fixture nut.

Application:

The clamp is used for all clamping tasks in which clamping is effected via T-grooves, grooves and threaded bores.

Advantage:

Through the weight-saving design, the clamping iron is up to 50% lighter, but still offers 100% clamping force and can thus also be used even for rotating clamping tasks. Variable and fast adjustment option at a distance from the workpiece.

Note:

For clamping, either clamping screws DIN 787, stud bolts DIN 6379 and cheese head screws ISO 4762 can be used.

Up to 50 % lighter – 100 % clamping force

No. 6311

Clamp „light design“, with adjustable support screw, complete

with DIN 787, DIN 6340, DIN 6330B.
Tempered steel, burnished.

CAD



Order no.	Slot	with clamping stud	H1 *	D x LS	B1	B2	B3	L	A	E1	E2	Weight [g]
376731	20	M20x20x160	8-58	M20x69	22	49	25	200	44	45	77	2434
376756	20	M20x20x200	8-98	M20x109	22	49	25	200	44	45	77	2531
376772	24	M24x28x200	10-81	M24x87	26	54	30	250	44	46	116	3779
376798	24	M24x28x250	10-130	M24x137	26	54	30	250	44	59	116	3884
376814	36	M30x36x315	7-214	M30x180	33	72	40	315	71	59	152	9044
376830	48	M36x42x400	7-153	M30x180	43	102	54	400	80	74	209	17560

*depending on depth of slot to DIN 650 and position of fixture nut.

Application:

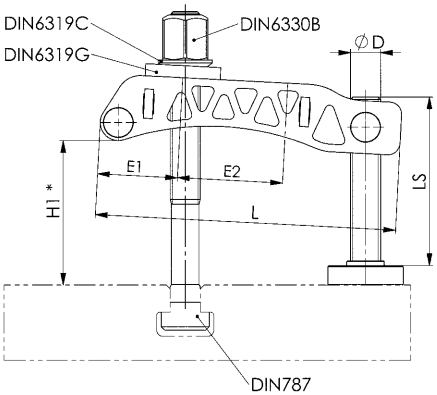
The clamp is used for all clamping tasks in which clamping is effected via T-grooves, grooves and threaded bores.

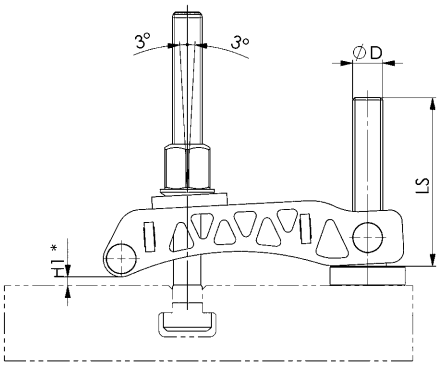
Advantage:

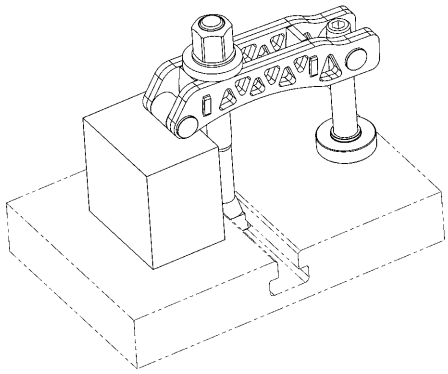
Through the weight-saving design, the clamping iron is up to 50% lighter, but still offers 100% clamping force and can thus also be used even for rotating clamping tasks. Variable and fast adjustment option at a distance from the workpiece.

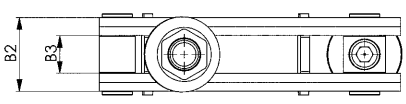
Note:

For clamping, either clamping screws DIN 787, stud bolts DIN 6379 and cheese head screws ISO 4762 can be used.









Subject to technical alterations.

DIN 6314

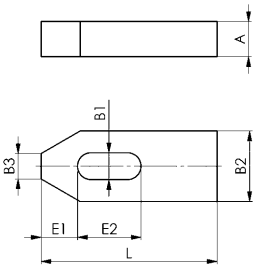
Clamp, flat

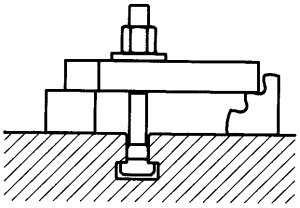
Tempering steel, varnished.



Order no.	B1	L	for clamping screw metric	for clamping screw inch	A	B2	B3	E1	E2	Weight [g]
70003	6,6	50	M6	1/4	10	20	8	10	20	63
70011	9	60	M8	5/16	12	25	10	13	22	113
70029	11	80	M10	3/8	15	30	12	15	30	226
70037	14	100	M12 M14	1/2	20	40	14	21	40	490
70045	14	125	M12 M14	1/2	20	40	14	21	50	621
70052	18	125	M16 M18	5/8	25	50	18	26	45	960
70060	18	160	M16 M18	5/8	25	50	18	26	65	1240
70078	22	160	M20 M22	3/4	30	60	22	30	60	1787
70086	22	200	M20 M22	3/4	30	60	22	30	80	2237
70094	26	200	M24	1	30	70	26	35	80	2580
70102	26	250	M24	1	35 *	70	26	35	105	3800
70110	33	250	M30	1 1/4	40	80	34	45	100	4934
70128	33	315	M30	1 1/4	50	80	34	45	130	7788
70136	43 *	400	M36 M42	1 1/2 1 5/8	60	100	43	100	150	15000

* Size not included in DIN, dimensions similar to DIN





Recommendations



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DIN 6331, page 108

CAD





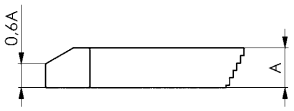
Subject to technical alterations.

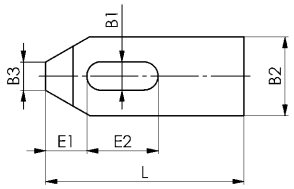
No. 6314Z

Step clamp

Tempering steel, varnished.
Only match step blocks no. 6500E. The longer versions are used for large clamping distances due to large T-slot distance or enlarged work depth, i.e. on graving machines.







Order no.	B1	L	for clamping screw metric	for clamping screw inch	A	B2	B3	E1	E2	Weight [g]
70359	6,6	50	M6	1/4	10	20	8	10	20	55
70227	6,6	80	M6	1/4	10	20	8	10	45	90
70367	9	60	M8	5/16	12	25	10	13	22	100
70243	9	100	M8	5/16	12	25	10	13	60	180
70375	11	80	M10	3/8	15	30	12	15	30	200
70235	11	125	M10	3/8	15	30	12	15	70	350
70383	14	100	M12 M14	1/2	20	40	14	21	40	450
70250	14	160	M12 M14	1/2	20	40	14	21	90	770
70391	18	125	M16 M18	5/8	25	50	18	26	45	900
70334	18	200	M16 M18	5/8	25	50	18	26	110	1500
70409	22	160	M20 M22	3/4	30	60	22	30	60	1700
70417	26	200	M24	1	30	70	26	35	80	2500

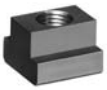
Recommendations



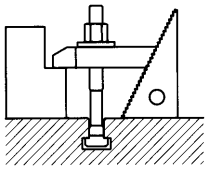
No. 6500E, page 50

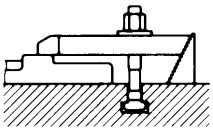


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DIN 508, page 104





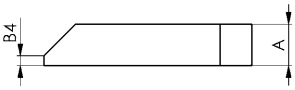
CAD

DIN 6315B

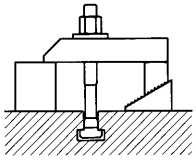
Forked clamp tapered

Tempering steel, varnished.









Order no.	B1	L	for clamping screw metric	for clamping screw inch	A	B2	B3	B4	Weight [g]
70466	6,6	60	M6	1/4	12	19	6	3	60
70474	9	80	M8	5/16	15	25	8	4	140
70482	11	100	M10	3/8	20	31	10	5	300
70490	14	125	M12 M14	1/2	25	38	12	6	570
70508	14	160	M12 M14	1/2	25	38	12	6	730
70516	14	200	M12 M14	1/2	25	38	12	6	910
70524	18	160	M16 M18	5/8	30	48	15	8	1080
70532	18	200	M16 M18	5/8	30	48	15	8	1360
70540	18	250	M16 M18	5/8	40	48	15	10	2250
70557	22	200	M20 M22	3/4	40	52	15	10	1800
70565	22	250	M20 M22	3/4	40	62	20	10	3000
70573	22	315	M20 M22	3/4	40	62	20	10	3850
70425	22 *	500	M20 M22	3/4	50	62	20	10	7500
70581	26	200	M24	1	40	66	20	10	2400
70599	26	250	M24	1	40	66	20	10	3000
70607	26	315	M24	1	40	66	20	10	3850
37390	26 *	400	M24	1	50	66	20	10	5962
70433	26 *	500	M24	1	50	66	20	10	7600
3079	26 *	600	M24	1	50	66	20	10	9042
30064	26 *	800	M24	1	50	66	20	10	12122
70615	33	250	M30	1 1/4	50	74	20	12	3700
70623	33	315	M30	1 1/4	50	74	20	12	4750
70631	33	400	M30	1 1/4	50	74	20	12	6100
70441	33 *	600	M30	1 1/4	50	74	20	12	9200
70458	33 *	1000	M30	1 1/4	60	94	30	12	28000
70649	40 *	400	M36	1 1/2	60	100	30	12	11000
70656	40 *	600	M36	1 1/2	60	100	30	12	16500
70672	43 *	600	M36 M42	1 1/2 1 5/8	80	123	40	12	29600

* Size not included in DIN, dimensions similar to DIN

Recommendations



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CAD

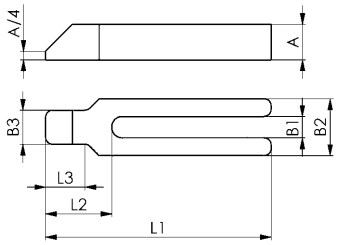
Subject to technical alterations.

No. 6315GN

Forked clamp with shoe

Tempering steel, varnished.





Order no.	B1	L1	for clamping screw metric	for clamping screw inch	A	B2	B3	L2	L3	Weight [g]
70862	9	100	M8	5/16	15	30	16	32	18	240
70870	11	125	M10	3/8	20	30	20	38	24	380
70888	14	160	M12 M14	1/2	25	40	24	47	30	800
70896	14	200	M12 M14	1/2	25	40	24	47	30	950
70904	18	200	M16 M18	5/8	30	50	28	57	36	1500
70912	18	250	M16 M18	5/8	30	50	28	57	36	1850
70920	22	250	M20 M22	3/4	40	60	35	68	45	2900
70938	22	315	M20 M22	3/4	40	60	35	68	45	3600
70946	26	250	M24	1	40	70	43	83	56	3400
70953	26	315	M24	1	40	70	43	83	56	4300
70961	33	315	M30	1 1/4	50	80	50	88	56	6000
70979	33	400	M30	1 1/4	50	80	50	88	56	7300

Recommendations



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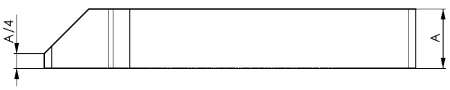
CAD

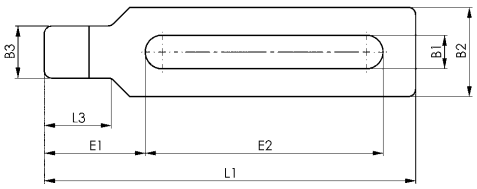
No. 6315GNG

Clamp with nose, closed

Infinitely adjustable, tempered and painted, with closed slot for use with rotating workpieces







Order no.	B1	L	for clamping screw metric	for clamping screw inch	A	B2	B3	E1	E2	L3	Weight [g]
376145	22	250	M20 M22	3/4	40	60	35	68	160	45	3025
376160	22	315	M20 M22	3/4	40	60	35	68	220	45	3810
376186	22	400	M20 M22	3/4	50	60	35	68	300	45	5995
376202	22	500	M20 M22	3/4	50	60	35	68	400	45	7440
376228	26	250	M24	1	40	70	43	83	140	56	3639
376244	26	315	M24	1	40	70	43	83	200	56	4560
376269	26	400	M24	1	50	70	43	83	270	56	7243
376285	26	500	M24	1	50	70	43	83	370	56	8937
376301	33	315	M30	1 1/4	50	80	50	88	200	56	6367
376327	33	400	M30	1 1/4	50	80	50	88	283	56	7798
376343	33	500	M30	1 1/4	50	80	50	88	383	56	9607

Recommendations



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CAD

Subject to technical alterations.

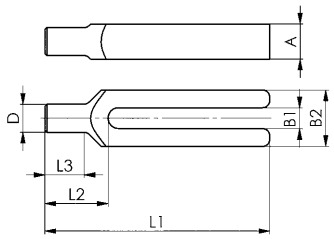
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DIN 6315C

Forked clamp with pin end

Tempering steel, varnished.





Order no.	B1	L1	for clamping screw metric	for clamping screw inch	A	B2	D	L2	L3	Weight [g]
70706	9	100	M8	5/16	15	30	12	30	18	220
70714	11	125	M10	3/8	20	30	16	36	24	350
70722	14	160	M12 M14	1/2	25	40	20	45	30	750
70730	14	200	M12 M14	1/2	25	40	20	45	30	950
70748	18	200	M16 M18	5/8	30	50	24	55	36	1400
70755	18	250	M16 M18	5/8	30	50	24	55	36	1750
70763	22	250	M20 M22	3/4	40	60	30	65	45	2700
70771	22	315	M20 M22	3/4	40	60	30	65	45	3400
70789	26	250	M24	1	40	70	38	80	56	3200
70797	26	315	M24	1	40	70	38	80	56	4100
70805	33	315	M30	1 1/4	50	80	45	85	56	5700
70813	33	400	M30	1 1/4	50	80	45	85	56	7000

Recommendations



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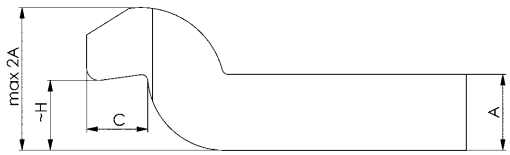
CAD

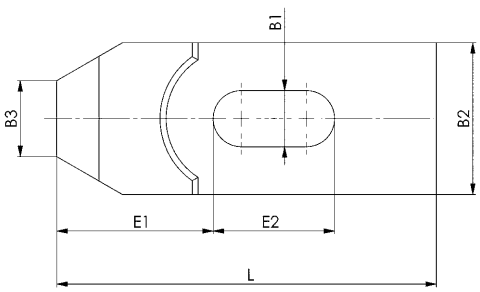
DIN 6316

Clamp, cranked

Tempering steel, varnished.







Order no.	B1	L	for clamping screw metric	for clamping screw inch	A	B2	B3	C	E1	E2	H	Weight [g]
71027	6,6	60	M6	1/4	10	20	10	8	20	20	9	81
71035	9	80	M8	5/16	12	25	12	9	25	25	11	166
71043	11 *	100	M10	3/8	15	30	15	12	32	32	14	299
71050	14	125	M12 M14	1/2	20	40	20	16	40	40	18	678
71068	18 *	125	M16 M18	5/8	25	50	25	20	49	40	23	1049
71076	18	160	M16 M18	5/8	25	50	25	20	49	50	23	1366
71084	22 *	160	M20 M22	3/4	30	60	30	24	55	55	27	1911
71092	22	200	M20 M22	3/4	30	60	30	24	55	70	27	2417
71100	26 *	200	M24	1	35	70	35	25	72	60	32	3315
71118	26 *	250	M24	1	35	70	35	25	72	80	32	4132
71126	33 *	250	M30	1 1/4	40	80	40	40	91	80	45	5225
71134	33	315	M30	1 1/4	50	80	40	40	91	100	45	8459
71159	43 *	400	M36 M42	1 1/2 1 5/8	60	100	50	50	105	120	55	17078

* Size not included in DIN, dimensions similar to DIN

Recommendations



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CAD

Subject to technical alterations.

No. 6317

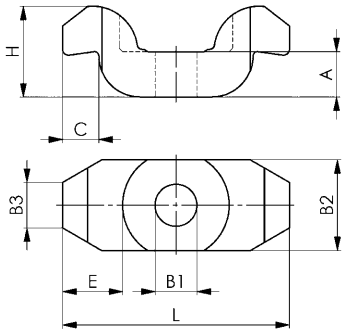
Double goose-neck clamp

Tempering steel, varnished.

Order no.	B1	L	for clamping screw	A	B2	B3	C	E	H	Weight [g]
71340	18	100	M12-M18	20	40	20	16	26	40	620
71357	25	140	M20-M24	30	60	30	24	38	60	2040

For use with washers DIN 6340 or DIN 6319G.





Recommendations



CAD

No. 6317K

Clamp, double (short)

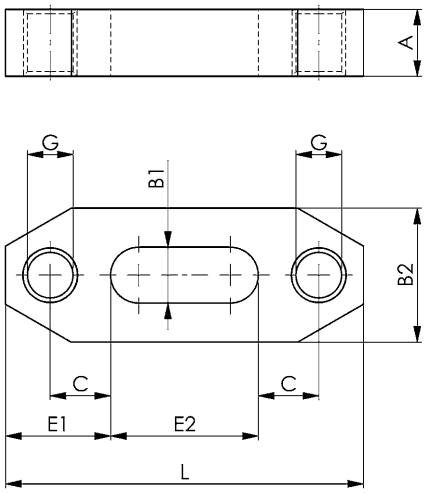
tempered.

Order no.	Size	A [mm]	B1 [mm]	B2 [mm]	C [mm]	E1 [mm]	E2 [mm]	G [mm]	L [mm]	Weight [g]
78956	12	15	12,5	30	13,5	23,5	33	M12	80	200
78972	16	25	17,0	40	16,0	29,0	42	M16	100	525



Note:

For pressure screws that fit, see accessories.



Subject to technical alterations.

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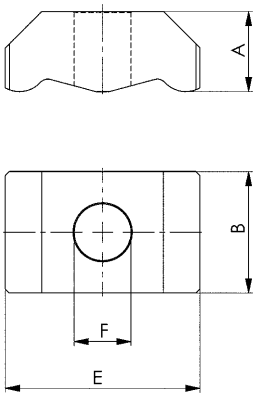
No. 6365-**-009

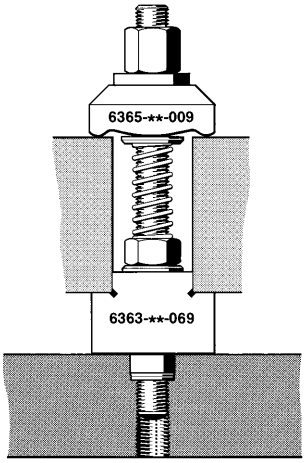
Clamp, double

tempered.

Order no.	Size	A	B	E	F	Weight [g]
78626	12	20	30	48	14	192
78667	16	25	40	62	18	385







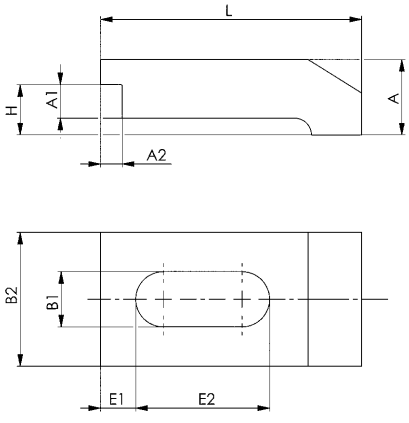
No. 6325

Clamps for machine vices

Tempered steel, milled, quenched in blue oxide finish. Packaged in pairs.

Order no.	H	B1	L	for clamping screw metric	for clamping screw inch	A	A1	A2	B2	E1	E2	Weight [g]
74682	15	16,5	78	M12, 14, 16	1/2, 5/8	22,5	10	6,5	40	10,5	40	660
74690	20	16,5	78	M12, 14, 16	1/2, 5/8	27,5	10	6,5	40	10,5	40	705





Recommendations



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CAD

Subject to technical alterations.

No. 6314V

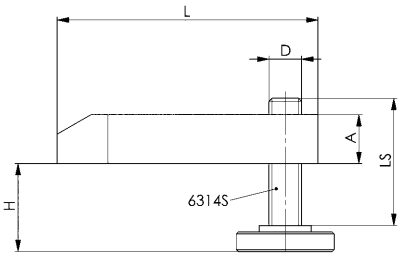
Tapered clamp with adjusting support screw

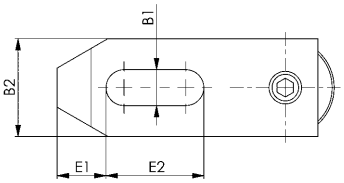
(without clamping stud)
Painted tempered steel.



Order no.	for clamping screw	H*	sim. DIN6314 B1 x L	D x LS	A	B2	E1	E2	Weight [g]
70177	M10	8-37	11x80	M10x39	15	30	15	30	200
70193	M12 M14	10-47	14x100	M12x49	20	40	21	40	560
70821	M12 M14	10-92	14x100	M12x94	20	40	21	40	635
70219	M16 M18	13-52	18x125	M16x55	25	50	26	45	1110
70839	M16 M18	13-87	18x125	M16x90	25	50	26	45	1230
70201	M20 M22	16-65	22x160	M20x69	30	60	30	60	2050
70847	M20 M22	16-105	22x160	M20x109	30	60	30	60	2230
70151	M24	20-83	26x200	M24x87	30	70	35	80	3200
70854	M24	20-133	26x200	M24x137	30	70	35	80	3470
373928	M24	20-80	26x250	M24x87	35	70	35	105	4340
373936	M24	20-130	26x250	M24x137	35	70	35	105	4520
374405	M30	24-150	33x315	M30x180	50	80	45	130	11215
374439	M36 M42	24-150	43x400	M30x180	80	100	80	170	24350

*depending on depth of slot to DIN 650 and position of fixture nut.
Clamps without T-bolts are same item for sizes 12 and 14, 16 and 18, 20 and 22, each.





CAD

No. 6314V

Tapered clamp with adjusting support screw, complete

with DIN 787, DIN 6340, DIN 6330B. Painted tempered steel.



Order no.	Slot	with clamping stud	H*	sim. DIN6314 B1 x L	D x LS	A	B2	E1	E2	Weight [g]
70268	10	M10x10x80	8-32	11x80	M10x39	15	30	15	30	340
70276	12	M12x12x100	10-40	14x100	M12x49	20	40	21	40	700
72801	12	M12x12x160	24-92	14x100	M12x94	20	40	21	40	830
70284	14	M12x14x100	10-38	14x100	M12x49	20	40	21	40	720
72827	14	M12x14x160	23-92	14x100	M12x94	20	40	21	40	845
70292	16	M16x16x125	13-48	18x125	M16x55	25	50	26	45	1400
72942	16	M16x16x160	15-83	18x125	M16x90	25	50	26	45	1610
70300	18	M16x18x125	13-46	18x125	M16x55	25	50	26	45	1400
73056	18	M16x18x160	13-81	18x125	M16x90	25	50	26	45	1630
70326	20	M20x20x160	16-65	22x160	M20x69	30	60	30	60	2600
73064	20	M20x20x200	21-105	22x160	M20x109	30	60	30	60	2930
70318	22	M20x22x160	16-65	22x160	M20x69	30	60	30	60	2770
73072	22	M20x22x200	19-105	22x160	M20x109	30	60	30	60	2980
373944	28	M24x28x200	20-80	26x250	M24x87	35	70	35	105	5486
373951	28	M24x28x250	30-130	26x250	M24x137	35	70	35	105	5716
381988	36	M30x36x315	24-150	33x315	M30x180	50	80	45	130	11995
382002	42	M36x42x400	24-150	43x400	M30x180	80	100	80	170	25683

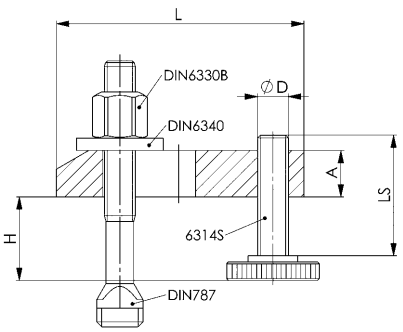
*depending on depth of slot to DIN 650 and position of fixture nut.
Clamps without T-bolts are same item for sizes 12 and 14, 16 and 18, 20 and 22, each.

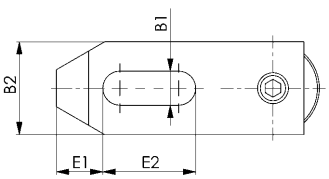
Recommendations



No. 6621, page 42

CAD





Subject to technical alterations.

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No. 6316V

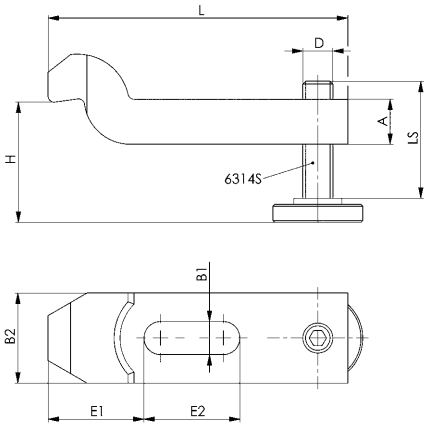
Cranked clamp with adjusting support screw

(without clamping stud)
Painted tempered steel.

Order no.	for clamping screw	H*	sim. DIN6316 B1 x L	D x LS	A	B2	E1	E2	Weight [g]
71183	M10	22-51	11x100	M10x39	15	30	32	32	344
71209	M12 M14	28-65	14x125	M12x49	20	40	40	40	761
71225	M16 M18	36-75	18x160	M16x55	25	50	49	50	1516
71217	M20 M22	43-92	22x200	M20x69	30	60	55	70	2669
71266	M24	52-115	26x200	M24x87	35	70	72	60	3810

*depending on depth of slot to DIN 650 and position of fixture nut.





CAD

No. 6316V

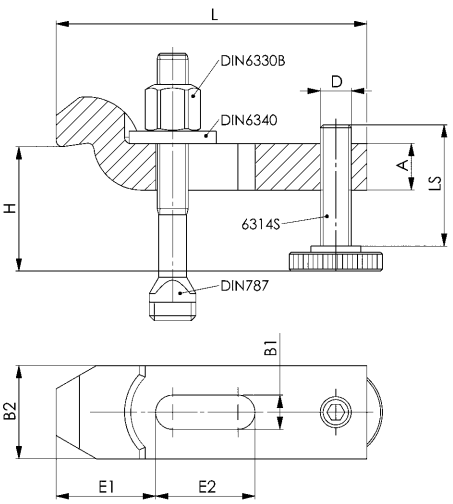
Cranked clamp with adjusting support screw, complete

with DIN 787, DIN 6340, DIN 6330B.
Painted tempered steel.

Order no.	Slot	with clamping stud	H*	sim. DIN6316 B1 x L	D x LS	A	B2	E1	E2	Weight [g]
71274	10	M10x10x80	22-46	11x100	M10x39	15	30	32	32	440
71282	12	M12x12x100	28-58	14x125	M12x49	20	40	40	40	906
71290	14	M12x14x100	28-56	14x125	M12x49	20	40	40	40	926
71308	16	M16x16x125	36-71	18x160	M16x55	25	50	49	50	1859
71316	18	M16x18x125	36-69	18x160	M16x55	25	50	49	50	1875
71332	20	M20x20x160	43-92	22x200	M20x69	30	60	55	70	3322
71324	22	M20x22x160	43-92	22x200	M20x69	30	60	55	70	3352

*depending on depth of slot to DIN 650 and position of fixture nut.
Clamps without T-bolts are same item for sizes 12 and 14, 16 and 18, 20 and 22, each.





CAD

Subject to technical alterations.

No. 6314AV

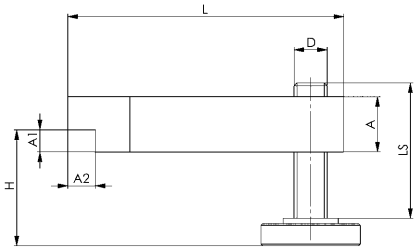
Stepped clamp with adjusting support screw

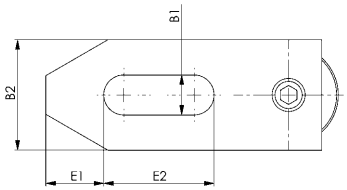
(without clamping stud)
Painted tempered steel.

Order no.	for clamping screw	H*	sim. DIN6314 B1 x L	D x LS	A	A1xA2	B2	E1	E2	Weight [g]
74567	M12, M14	10-55	14x100	M12x49	20	8 x10,0	40	21	40	580
74575	M16, M18	13-62	18x125	M16x55	25	10x12,5	50	26	45	1140
74583	M20, M22	16-77	22x160	M20x69	30	12x15,0	60	30	60	2100

*depending on depth of slot to DIN 650 and position of fixture nut.
To clamp thin parts, turn the clamp over.







CAD

No. 6314AV

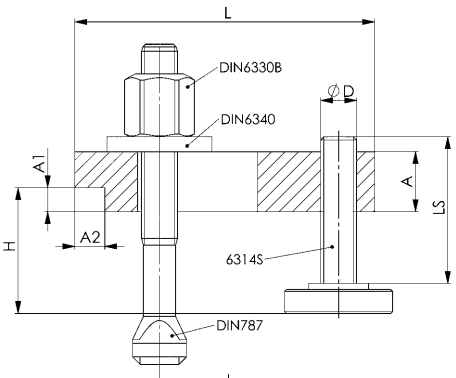
Stepped clamp with adjusting support screw, complete

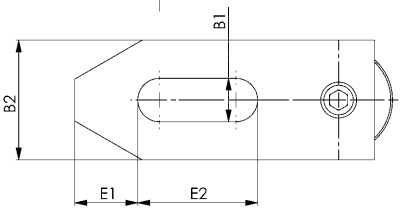
with DIN 787, DIN 6340, DIN 6330B.
Painted tempered steel.

Order no.	Slot	with clamping stud	H*	sim. DIN6314 B1 x L	D x LS	A	A1xA2	B2	E1	E2	Weight [g]
74591	12	M12x12x100	10-48	14x100	M12x49	20	8 x10,0	40	21	40	745
74625	14	M12x14x100	10-46	14x100	M12x49	20	8 x10,0	40	21	40	764
74633	16	M16x16x125	13-58	18x125	M16x55	25	10x12,5	50	26	45	1510
74641	18	M16x18x125	13-56	18x125	M16x55	25	10x12,5	50	26	45	1530
74658	20	M20x20x160	16-77	22x160	M20x69	30	12x15,0	60	30	60	2800
74666	22	M20x22x160	16-77	22x160	M20x69	30	12x15,0	60	30	60	2840

*depending on depth of slot to DIN 650 and position of fixture nut.
To clamp thin parts, turn the clamp over.
Clamps without T-bolts are same item for sizes 12 and 14, 16 and 18, 20 and 22, each.







CAD

Subject to technical alterations.

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No. 6315V

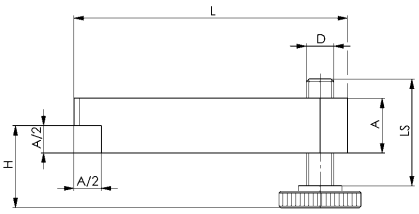
Stepped clamp with adjusting support screw

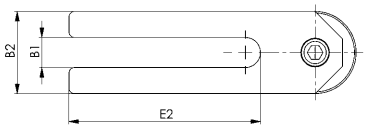
(without clamping stud)
Painted tempered steel.

Order no.	for clamping screw	H*	sim. DIN 6315B B1 x L	D x LS	A	B2	E2	Weight [g]
71167	M10	8-47	11x100	M10x39	20	30	70	330
71175	M12 M14	10-59	14x125	M12x49	25	40	90	700
71191	M16 M18	13-67	18x160	M16x55	30	50	110	1300
71258	M20 M22	16-85	22x200	M20x69	40	60	135	2600

*depending on depth of slot to DIN 650 and position of fixture nut.
To clamp thin parts, turn the clamp over.







Recommendations



No. 6342, page 119

CAD

No. 6315V

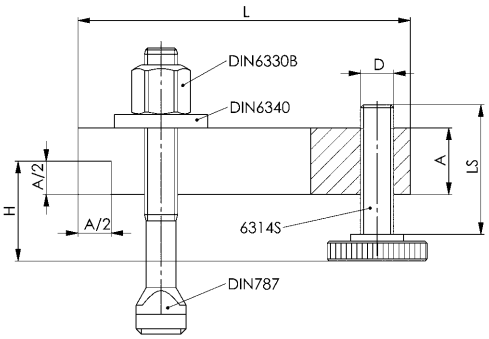
Stepped clamp with adjusting support screw, complete

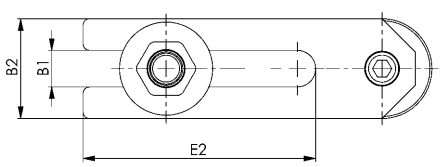
with DIN 787, DIN 6340, DIN 6330B.
Painted tempered steel.

Order no.	Slot	with clamping stud	H*	sim. DIN 6315B B1 x L	D x LS	A	B2	E2	Weight [g]
73189	10	M10x10x 80	8-37	11x100	M10x39	20	30	70	403
73197	12	M12x12x100	10-48	14x125	M12x49	25	40	90	920
73205	14	M12x14x100	10-45	14x125	M12x49	25	40	90	940
73247	16	M16x16x125	13-58	18x160	M16x55	30	50	110	1860
73254	18	M16x18x125	13-56	18x160	M16x55	30	50	110	1880
73262	20	M20x20x160	16-77	22x200	M20x69	40	60	135	3610
73288	22	M20x22x160	16-75	22x200	M20x69	40	60	135	3650

*depending on depth of slot to DIN 650 and position of fixture nut.
To clamp thin parts, turn the clamp over.
Clamps without T-bolts are same item for sizes 12 and 14, 16 and 18, 20 and 22, each.







CAD

Subject to technical alterations.

No. 6313K

Clamp, short, with U-piece

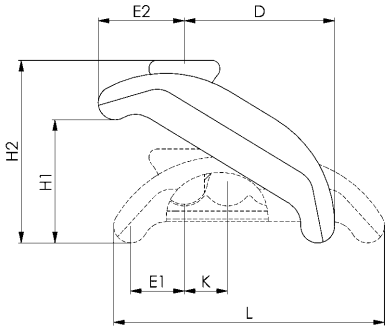
(without clamping bolt)
continuously adjustable, tempered and galvanized.

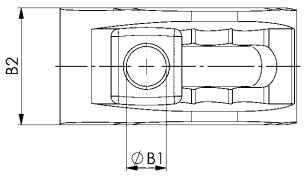


Order no.	Size	for clamping screw	H1	B1	B2 x L	D	E1	E2	H2	K	Weight [g]
73932	13	M12	0-35	13	38x 88	48	23	28	30-55	14	260
73940	18	M16	0-55	18	56x130	74	29	38	42-84	18	809
73957	22	M20	0-65	22	66x144	80	32	46	50-100	20	1253
73965	26	M24	0-75	25	76x174	100	39	52	54-111	24	1718
73973	32	M30	0-80	31	90x200	110	44	61	62-125	28	2785

Note:

Suitable fastening elements: DIN 787 clamping bolts, DIN 6340 washers and DIN 6330B hexagon nuts.





CAD

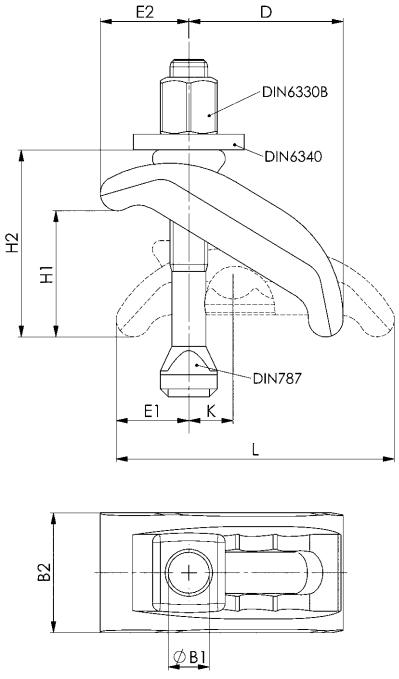
No. 6313K

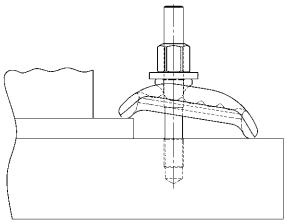
Clamp, short, with U-piece, complete

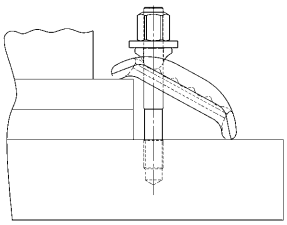
with DIN 787, DIN 6340, DIN 6330B.
continuously adjustable, tempered and galvanised.



Order no.	Slot	with clamping stud	H1	B1	B2 x L	D	E1	E2	H2	K	Weight [g]
77149	12	M12x12x100	0-35	13	38x88	52	23	27	30-55	14	395
77156	14	M12x14x100	0-35	13	38x88	52	23	27	30-55	14	415
77180	16	M16x16x160	0-55	18	56x130	79	29	37	42-84	18	1130
77198	18	M16x18x160	0-55	18	56x130	79	29	37	42-84	18	1550
77206	20	M20x20x200	0-65	22	66x144	84	32	42	50-100	20	1880







CAD

Subject to technical alterations.

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No. 6321

Clamp, continuously adjustable

with U-piece. Steel, forged and tempered, galvanised.



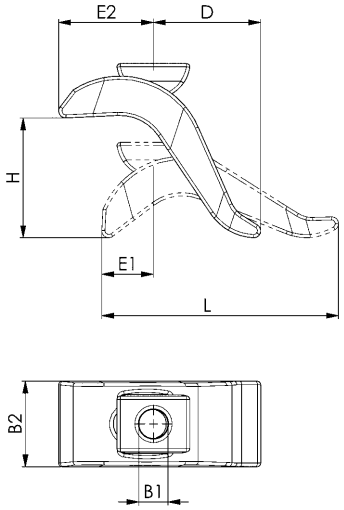
Order no.	Size	for clamping screw	H	B1	B2 x L	D	E1	E2	Weight [g]
71522	17	M12, M14, M16	0-75	17	50x140	60	30	55	900
71530	21	M20	0-85	21	60x175	80	40	70	1600

Application:

Stepless clamp for fast coverage of several ranges of work height without additional supports. Low space requirement on machine table. Heavy-duty design and specially suitable for clamping of press- and punching tools.

Note:

Suitable fastening elements: DIN 787 clamping bolts, DIN 6340 washers and DIN 6330B hexagon nuts.



CAD

No. 6321

Clamp, continuously adjustable, complete

with DIN 787, DIN 6340, DIN 6330B and U-piece. Steel, forged and tempered, galvanised.



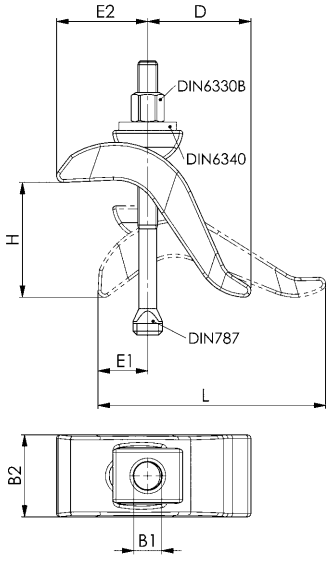
Order no.	Slot	with clamping stud	H	B1	B2 x L	D	E1	E2	Weight [g]
74906	12	M12x12x125	0-50	17	50x140	60	30	55	1070
74914	14	M12x14x125	0-50	17	50x140	60	30	55	1080
74922	16	M16x16x160	0-75	17	50x140	60	30	55	1270
74930	18	M16x18x160	0-75	17	50x140	60	30	55	1280
74971	20	M20x20x200	0-85	21	60x175	80	40	70	2300
74963	22	M20x22x200	0-85	21	60x175	80	40	70	2370

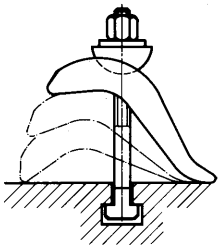
Application:

Stepless clamp for fast coverage of several ranges of work height without additional supports. Low space requirement on machine table. Heavy-duty design and specially suitable for clamping of press- and punching tools.

Note:

With the clamping jaw size 17 a maximum clamping height of 75 mm can be achieved with screws for T-slots DIN 787, length 160 mm.





CAD

Recommendations



No. 6312V, page 22



No. 6312VT, page 23

Subject to technical alterations.

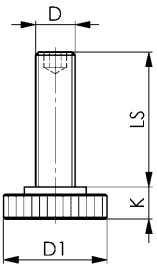
No. 6314S

Support screw

Hardened, strength class 8.8 Suitable for all lockable clamps.

Order no.	D x LS	D1	K	Weight [g]
73437	M10x39	30	8	52
73445	M12x49	36	10	96
74039	M12x94	36	10	145
73452	M16x55	42	13	180
74047	M16x90	42	13	230
73460	M20x69	50	16	320
74054	M20x109	50	16	400
73478	M24x87	60	20	590
74062	M24x137	60	20	820
374413	M30x180	80	24	1704





CAD

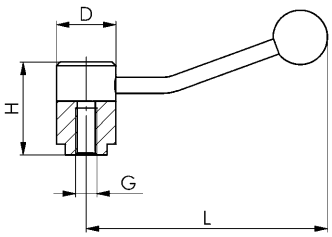
No. 6621

Detent clamp lever

Steel, blued. Suitable for adjustable clamps no. 6313K, 6314V, 6315V, 6316V and 6321.

Order no.	G	D	H	L	Weight [g]
74609	M12	33	48	135	360
74617	M16	40	64	158	620





CAD

Subject to technical alterations.

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No. 7000

Step clamp

Special cast iron, screw and bushing 8.8.



Order no.	Size	Slot	Clamping force max.* [kN]	Md [Nm]	B	C	H	L	S	Weight [g]
74716	**12-1**	12	11,4	50	34	14	15- 45	112	0,75	600
74724	**12-2**	12	11,4	50	34	15	30- 75	112	1,25	800
74732	**12-3**	12	11,4	50	34	16	60-135	112	2,50	1200
74740	**12-4**	12	11,4	50	34	18	120-195	112	2,50	1700
74757	**12-5**	12	11,4	50	34	19	180-255	112	2,50	2200
74765	**14-0**	14	15,5	80	34	14	0- 45	140	0,75	700
74773	**14-1**	14	15,3	80	34	14	15- 45	112	0,75	600
74781	**14-2**	14	15,3	80	34	15	30- 75	112	1,25	800
74799	**14-3**	14	15,3	80	34	16	60-135	112	2,50	1200
74807	**14-4**	14	15,3	80	34	18	120-195	112	2,50	1700
74815	**14-5**	14	15,3	100	34	19	180-255	112	2,50	2200
74831	**16-1**	16	16,3	100	50	20	25- 70	125	1,25	1700
74849	**16-2**	16	16,3	100	50	21	50-120	125	2,50	2500
74856	**16-3**	16	16,3	100	50	21	100-220	125	3,75	3540
74997	**18-1**	18	19,0	130	50	20	25- 70	125	1,25	1670
75002	**18-2**	18	19,0	130	50	21	50-120	125	2,50	2500
75010	**18-3**	18	19,0	130	50	21	100-220	125	3,75	3580
75028	**18-4**	18	19,0	130	50	24	200-320	125	3,75	4750

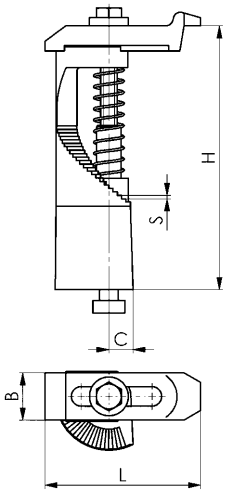
* Specified clamping forces in optimal clamping position (smallest distance of the clamping screw to the clamping position).

Application:

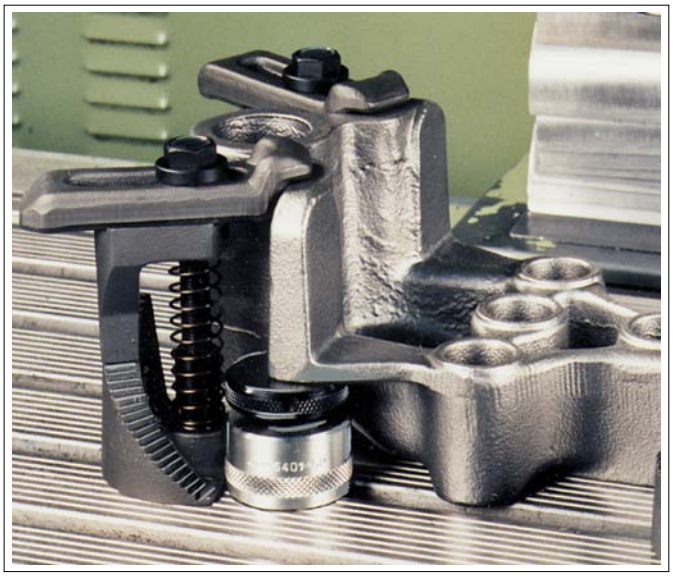
- thanks to the compact design the helical clamp requires little space on the machine table

Advantage:

- quickly ready
- The spiral serration allows fast adapting to any workpiece height up to approx. 320 mm



CAD



Recommendations



No. 6312V, page 22



No. 6312VT, page 23

Subject to technical alterations.

No. 6314AT

Clamping unit to clamp outside of the tool table

Tempered steel. Infinitely adjustable.



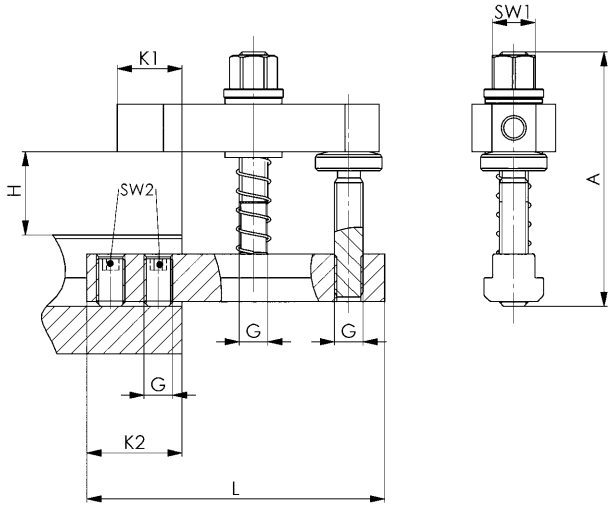
Order no.	Clamping force [kN]	Tightening torque [Nm]	Slot	G	H	Weight [g]
73999	15	70	18	M12	20-35	840
73981	25	170	22	M16	30-45	2126
79194	50	320	28	M20	40-53	5000

Application:

Used for clamping outside of the tool table. For use when clamping large workpieces or tools that do not allow any space for clamping elements on the tool or machine table.

Note:

For the installation dimensions of the clamp, see No. 7110GX-**-1.
Do not use on presses!



Dimensions:

Order no.	A	L	K1	K2	SW1	SW2
73999	105	125	27	40	18	6
73981	168	165	35	55	24	8
79194	206	255	33	85	30	10



CAD

Subject to technical alterations.

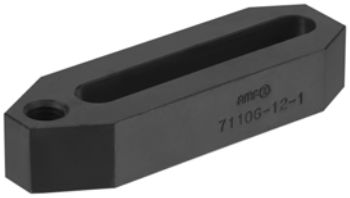
ANDREAS MAIER GmbH & Co. KG · Phone: +49 711 5766-0 · Web: www.amf.de

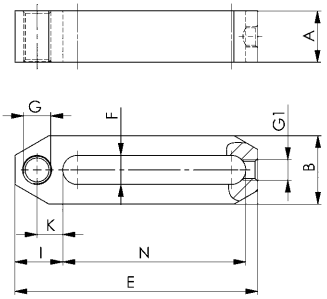
No. 7110GX-**-1

Clamp, straight

tempered.

Order no.	Size	A x B	E	F	G	G1	I	K	N	Weight [g]
73528	12	20x35	110	12,5	M12	M10	21,5	11,5	82	340
73536	16	30x40	142	17,0	M16	M12	28,0	15,0	107	770
73544	20	40x50	200	21,0	M20	M16	38,0	21,0	150	1800





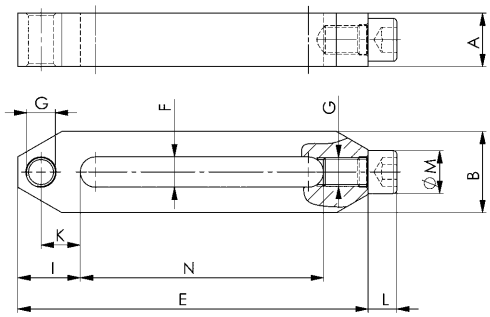
No. 7110GLX-**-1

Clamp, straight (long)

with screw-in pin end tempered.

Order no.	Size	A x B	E	F	G	I	K	L	M	N	Weight [g]
73551	12	20x35,0	156	12,5	M12	30	20	12	18	106	600
73577	16	30x45,5	196	17,0	M16	35	22	16	24	136	1400
73585	20	40x60,0	298	21,0	M20	47	30	20	30	221	3900





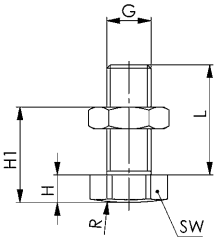
No. 7110DX-**xM**

Set screw

ball-shaped, strength class 10.9.

Order no.	Size	G	H	H1	L	R	SW	Weight [g]
73593	12	M12	7,5	16-28	30	60	19	50
73601	16	M16	10,0	20-38	40	75	24	100





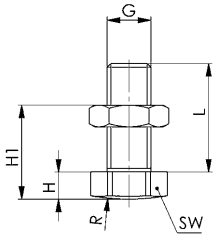
No. 7110DMX-**xM**

Set screw, brass

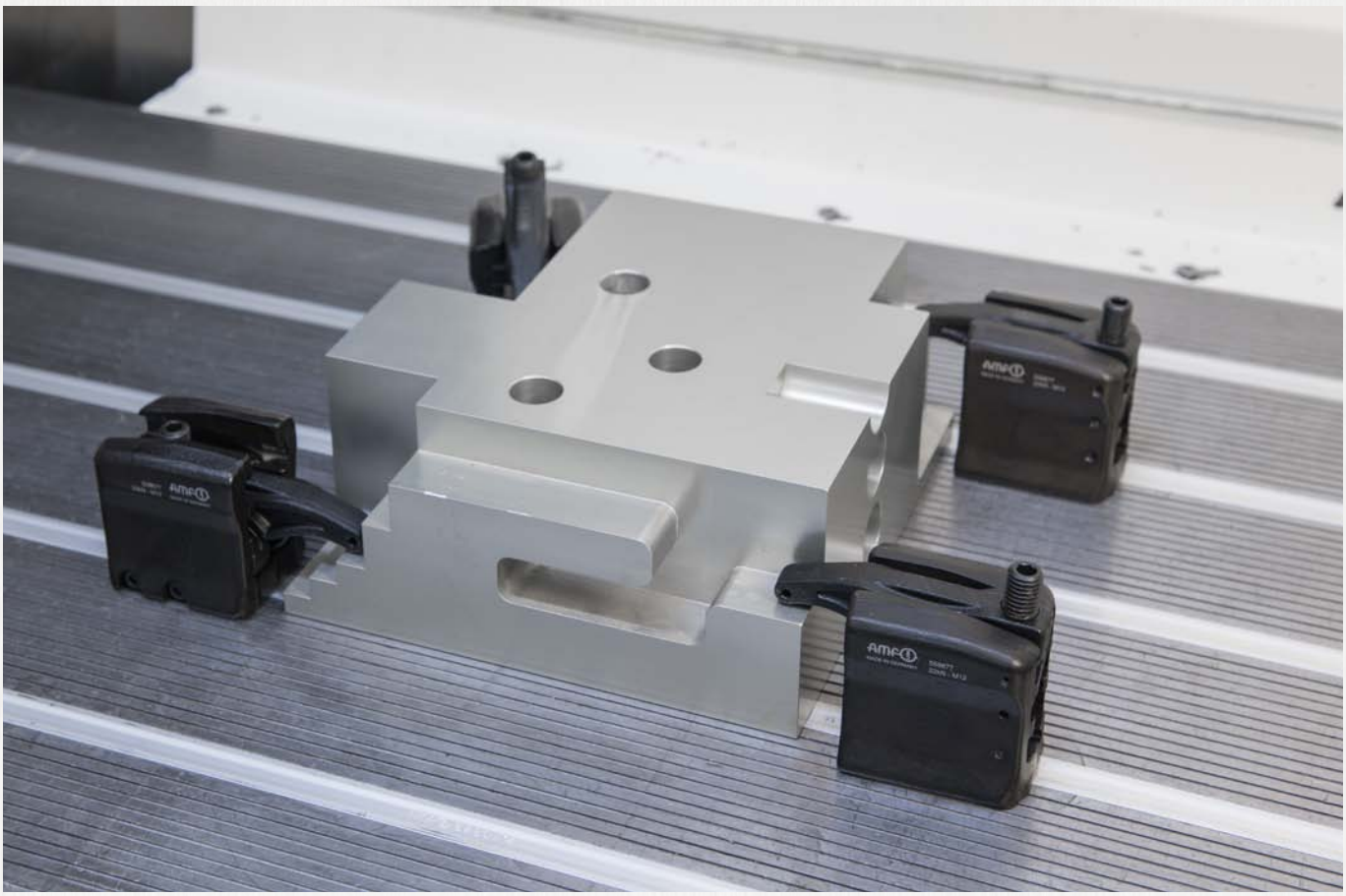
ball-shaped, with steel nut.

Order no.	Size	G	H	H1	L	R	SW	Weight [g]
73635	12	M12	7,5	16-28	30	60	19	50
73643	16	M16	10,0	20-38	40	75	24	100





Subject to technical alterations.





Subject to technical alterations.

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No. 7110DHX-**xM**

Set screw with ball

Adjustable, ribbed, with nut ISO 4035.
Flat-faced ball: ball bearing steel, hardened, ribbed
body: tempered steel, tempered



Order no.	Size	G	H	dia. K	L	SW1	SW2	max. load static [kN]	Max. tightening torque [Nm]	Weight [g]
374447	**M8**	M8	11,6	5,8	25	13	13	8	25	20
73650	**M12**	M12	15,7	8,6	35	17	17	15	82	55
73668	**M16**	M16	20,7	10,5	40	24	24	25	206	128
73692	**M20**	M20	27,3	20,0	50	30	30	90	407	274

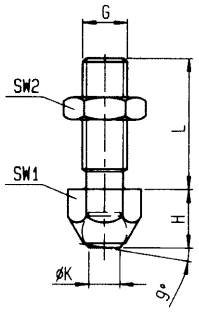
No. 7110DIX-**xM**

Set screw with ball

Adjustable, plain, with nut ISO 4035.
Ball bearing: ball bearing steel, hardened, smooth
body: tempered steel, tempered



Order no.	Size	G	H	dia. K	L	SW1	SW2	max. load static [kN]	Max. tightening torque [Nm]	Weight [g]
374454	**M8**	M8	11,6	5,8	25	13	13	8	25	20
73684	**M12**	M12	15,7	8,6	35	17	17	15	82	55
73718	**M16**	M16	20,7	10,5	40	24	24	25	206	128
73726	**M20**	M20	27,3	20,0	50	30	30	90	407	275



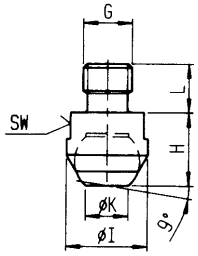
No. 7110DKX-**xM**

Set screw with ball, plain

Ball bearing: ball bearing steel, hardened, smooth
body: tempered steel, tempered



Order no.	Size	G	H	dia. I	dia. K	L	SW	max. load static [kN]	Max. tightening torque [Nm]	Weight [g]
374462	**M8**	M8	13	13	7,2	8	11	10	25	13
568020	**M10**	M10	18	20	10,5	10	17	25	46	40
73734	**M12**	M12	18	20	10,5	12	17	25	82	43
73742	**M16**	M16	27	30	20,0	16	27	90	206	150
73759	**M20**	M20	35	50	34,5	20	41	165	407	486



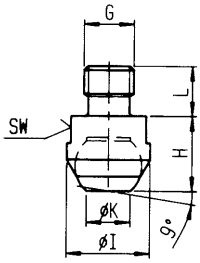
No. 7110DFX-**xM**

Set screw with flat-faced ball, ribbed

Flat-faced ball: ball bearing steel, hardened, ribbed
body: tempered steel, tempered



Order no.	Size	G	H	dia. I	dia. K	L	SW	max. load static [kN]	Max. tightening torque [Nm]	Weight [g]
75432	**M8**	M8	13	13	7,2	8	11	10	25	13
568021	**M10**	M10	18	20	10,5	10	17	25	46	40
73767	**M12**	M12	18	20	10,5	12	17	25	82	43
73775	**M16**	M16	27	30	20,0	16	27	90	206	150
73783	**M20**	M20	35	50	34,5	20	41	165	407	486



Subject to technical alterations.

THE MOST IMPORTANT FACTS ABOUT SUPPORT BLOCKS

> **Material:** High quality tempering steel resp. castings.

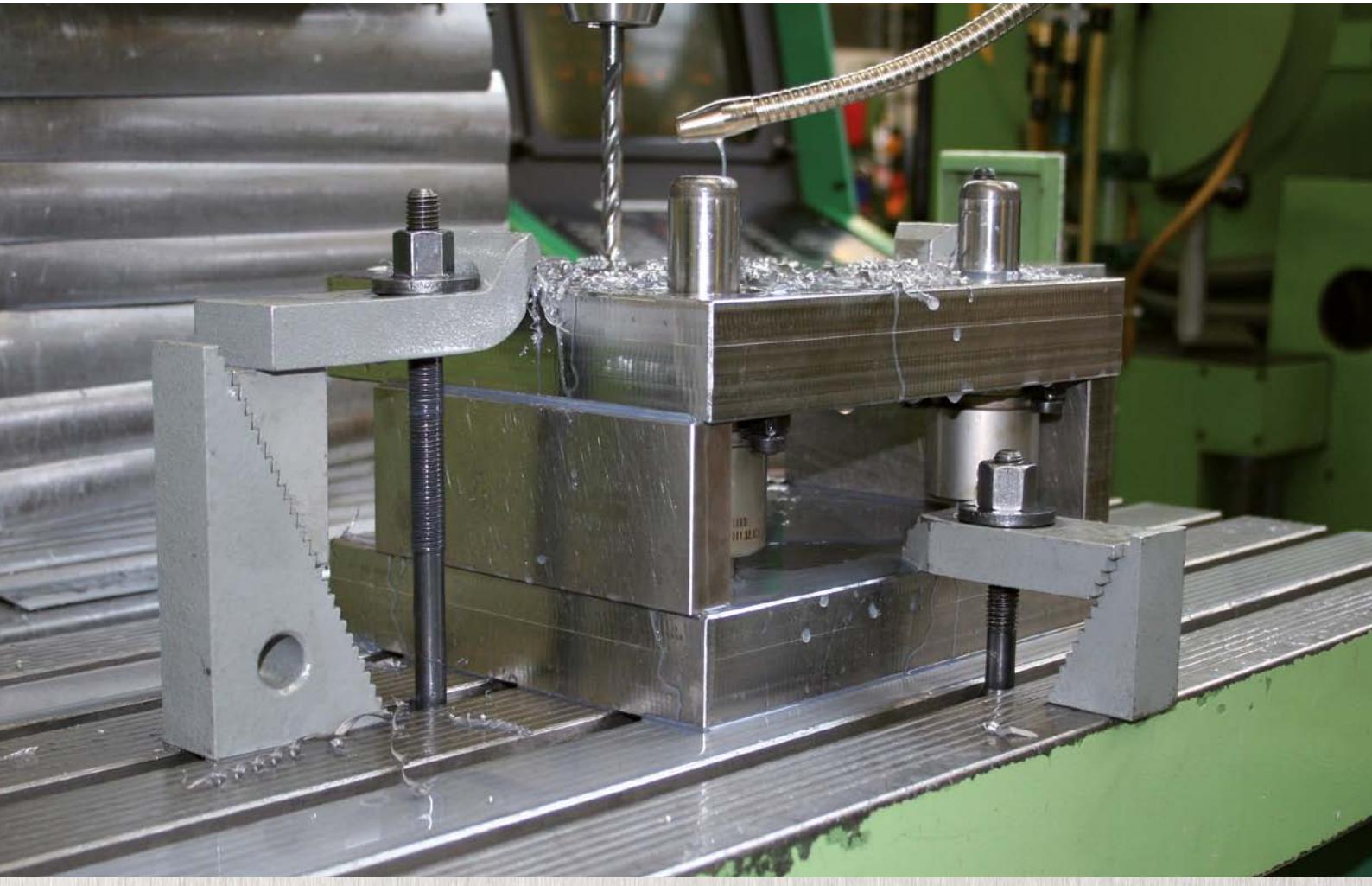
> **Machining:** All support blocks shown, have machined base- and contact faces. The serrated elements are precisely milled or broached. Leveled work support and safe force transmission are therefore provided.

> **Execusion:** To DIN regulations.

> **Finishing:** All support blocks are abrasionproof quality varnished.

The following pages contain suitable support blocks, finely graduated or infinitely adjustable, for any application. Support heights from 12.5 to 340 mm are achievable with all support blocks.
For clamping heights over 340 mm, we recommend our screw jacks on pages 66 to 67.

> Conventional workpiece clamping for drilling and pinning a fixture.



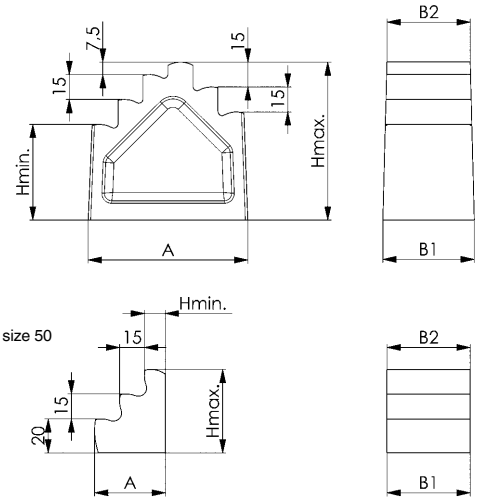
DIN 6318

Step blocks

with step increments of 7.5 mm each. Machine casting, varnished, base and step faces milled.

Order no.	Size	H min. [mm]	H max. [mm]	A	B1	B2	Weight [g]
71365	**50**	12,5	50	42,5	50	50	500
71373	**95**	57,5	95	95,0	55	50	1600
71381	**140**	102,5	140	100,0	60	50	2000
71399	**185**	147,5	185	105,0	65	50	2900
71407	**230**	192,5	230	110,0	70	50	3600
71415	**275**	237,5	275	115,0	75	50	4300
71423	**320**	282,5	320	120,0	80	50	5200





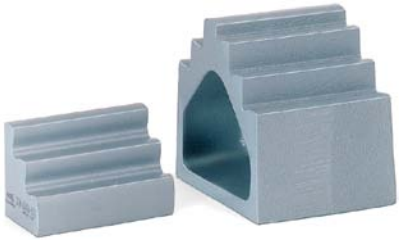
CAD

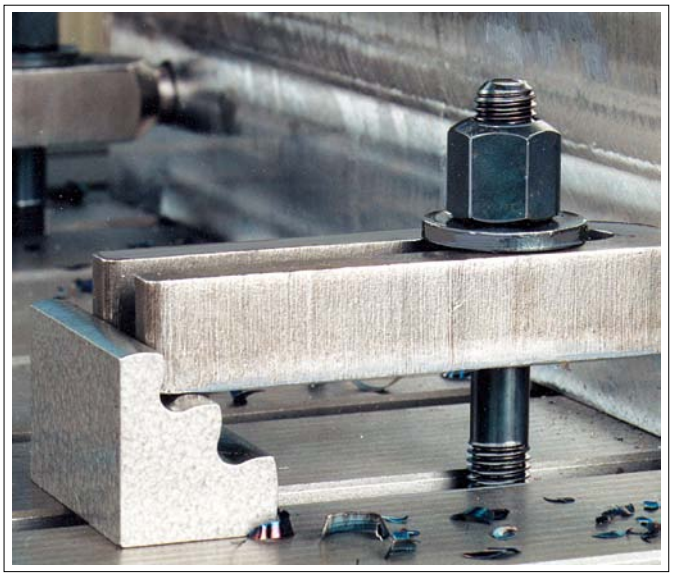
No. 6318B

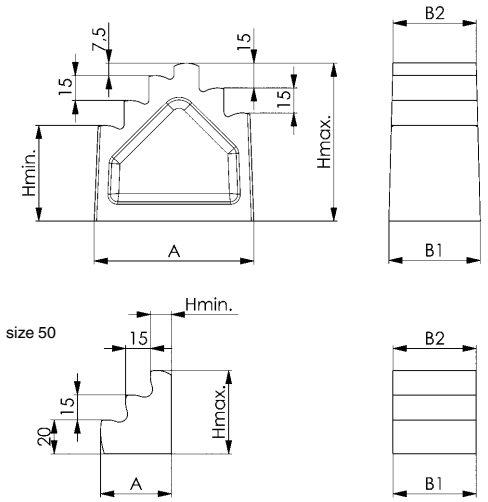
Step blocks, wide

with step increments of 7.5 mm each. Machine casting, varnished, base and step faces milled.

Order no.	Size	H min. [mm]	H max. [mm]	A	B1	B2	Weight [g]
71480	**50**	12,5	50	42,5	80	80	800
71498	**95**	57,5	95	95,0	85	80	2300
71506	**140**	102,5	140	100,0	90	80	3450







CAD

Subject to technical alterations.

No. 6500E

Universal step blocks

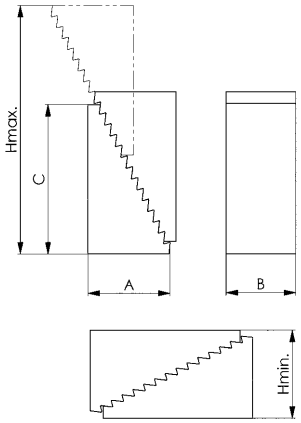
Step increments: vertical 4.65 mm, horizontal 2.3 mm.
Tempering steel, varnished.

Order no.	Size	H min. [mm]	H max. [mm]	A	B	C	Weight [g]
73296	1	23	51	19,0	30	33	90
73304	2	39	107	35,5	30	66	300
73312	3	71	208	68,0	30	131	1050

Application:

For use in pairs with all clamps and single use with clamp no. 6314Z.





Recommendations



No. 6314Z, page 31



No. 6501, page 51

CAD

No. 6500H

Universal step block set

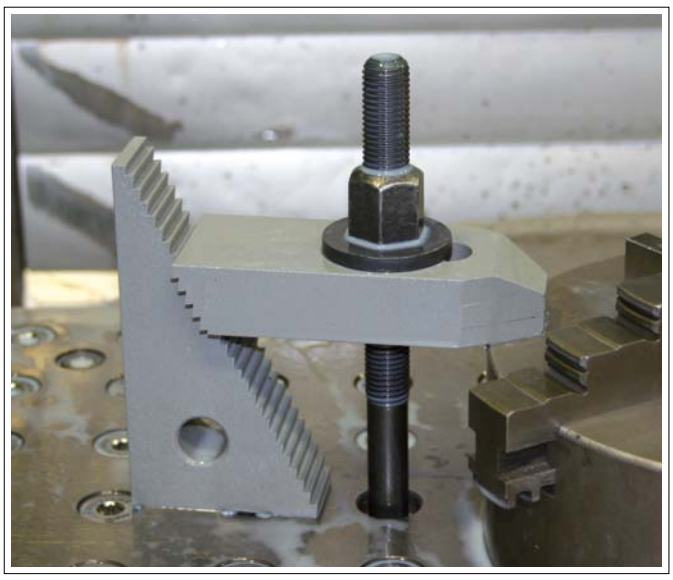
in solid wooden case with lid.
Tempering steel, varnished.

Order no.	Contents	H min. [mm]	H max. [mm]	Case L x B x H	Weight [Kg]
73346	8x6500E-1, 8x6500E-2, 4x6500E-3	23	208	280x155x40	8,4

Application:

For use in pairs with all clamps and single use with clamp no. 6314Z.





Subject to technical alterations.

No. 6501

Step block

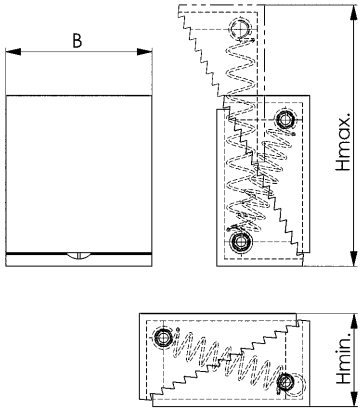
contact face 60 mm wide. With link spring.
Step increments: vertical 4.65 mm, horizontal 2.3 mm.
Tempering steel, varnished.

Order no.	Size	H min. [mm]	H max. [mm]	B	Weight [g]
73353	2	37	107	60	1000

Note:

The two parts of this AMF-support blocks are linked with a spring for easy handling.





CAD

No. 6501M

Support block with magnet

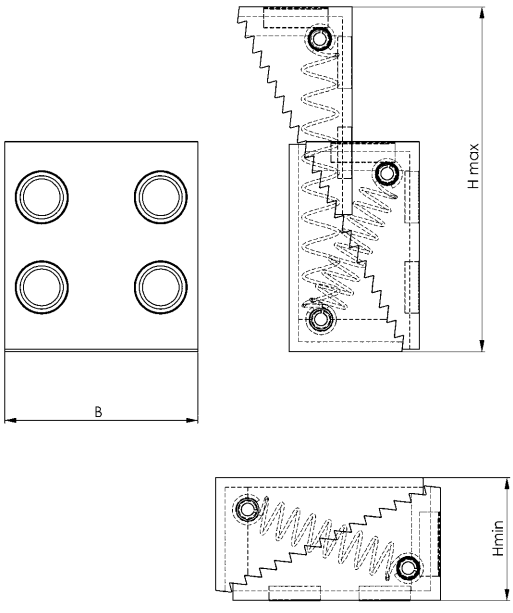
Mounting surface 60 mm wide, with connecting spring.
Step increments: vertical 4.65 mm, horizontal 2.3 mm.
Tempered steel, burnished.

Order no.	Size	H min. [mm]	H max. [mm]	B	Weight [g]
373969	2	37	107	60	980

Note:

The two parts of this AMF support block are connected by a spring for ease of handling.
Holding force 4 magnets = 380 N
Holding force 2 magnets = 280 N







Version with connecting springs no. 6501 and 6501M

CAD

Subject to technical alterations.

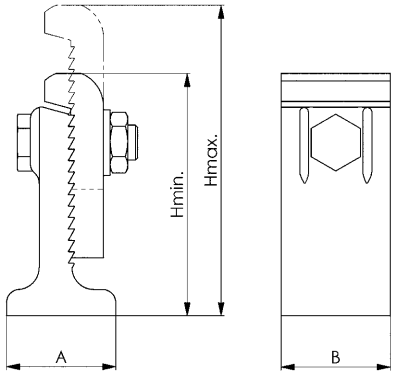
No. 6510

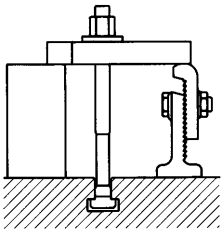
Serrated heel block

(serrated jacks). Step increments: 5.2 mm. Malleable casting, varnished. Base mill finished.

Order no.	Size	H min. [mm]	H max. [mm]	A	B	F max. [kN]	Weight [g]
73379	2	111	147	50	50	40	1225
73387	3	155	223	60	60	60	2607
73395	4	220	340	80	80	90	6028







CAD

DIN 6326

Support blocks for continuous adjustment, combination

with spiral gearing. Tempering steel, varnished.

Order no.	Combination	H min. [mm]	H max. [mm]	Lower part	H1	Upper part	H2	Weight [g]
71969	AK	25	45	A	42	K	24	1050
71977	AG	45	65	A	42	G	44	1350
71985	BK	65	85	B	82	K	24	2500
71993	BG	85	105	B	82	G	44	2800
72009	CK	105	125	C	122	K	24	4000
72017	CG	125	145	C	122	G	44	4300
72025	AKG	25	65	A	42	K / G	24 / 44	1550
72033	BKG	65	105	B	82	K / G	24 / 44	3000
72041	CKG	105	145	C	122	K / G	24 / 44	4500



CAD

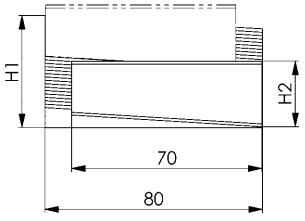
DIN 6326

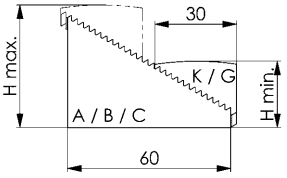
Support blocks for continuous adjustment, single

with spiral gearing. Tempering steel, varnished.

Order no.	Single parts	H1	H2	Weight [g]
72090	A	42	-	850
72108	B	82	-	2300
72116	C	122	-	3800
72124	K	-	24	200
72132	G	-	44	500







CAD

Subject to technical alterations.

THE MOST IMPORTANT FACTS ABOUT SETTING ELEMENTS

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



APPLICATIONS AND COMBINATIONS:

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



Subject to technical alterations.

SIMPLY CLEVERLY COMBINE – THE MODULAR SCREW JACK FROM AMF

With the modular screw jack from AMF your production becomes even more flexible and economical.

When cleverly combined, you can achieve a maximum height of 1620 mm. The screw jack can be used on T-slots and grid plates. The individual elements are plugged together, connected by means of a threaded ring ensuring process reliability and guarantee you maximum flexibility during the installation.

THE BENEFITS:

> The maximum height of 1620 mm is continuously adjustable and a height overlap is attainable.

> The connecting points are protected against soiling.

> Improved handling by means of individual elements.

> Set-up time saving thanks to flexibility of parts.

> Storage optimisation.



SUPPORT ELEMENT WITH FINE THREAD

> Used as an extra support point to prevent sagging and vibration of the workpiece.

> Mounted directly under a clamping point, distortion of the workpiece is prevented.




SCREW JACK ELEMENT
SPACER ELEMENTS
BASE ELEMENTS
THREAD ADAPTER
M16
M20
M24
M16
M20
M24

No. 6425-706

Screw jack, modular

Tempered steel, burnished.
Comprising:
- Screw jack element with base element 6425FB
- Spacer element 100 mm
- Spacer element 200 mm
- Thread adapter M16, M20, M24
- T-nuts groove 18, 22, 28
- Insertion tool

CAD

Order no.	TR	H min. [mm]	H max. [mm]	F max. [kN]	Weight [g]
562000	40 x 7	306	706	60	21481

Focus Open 2020
Gold

Application:

Can be used on T-slots and grid plates by means of adapters, which are screwed in the base element. The individual elements are plugged together and connected by means of a threaded ring ensuring process reliability. The threaded ring must not be retightened under load. The insertion tool makes it possible to use the head and base elements as well as thread adapter.

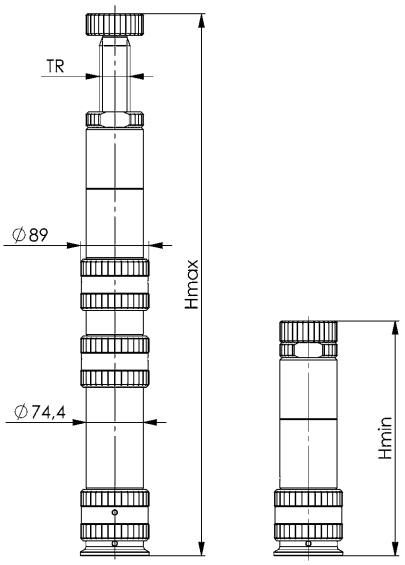
Advantage:

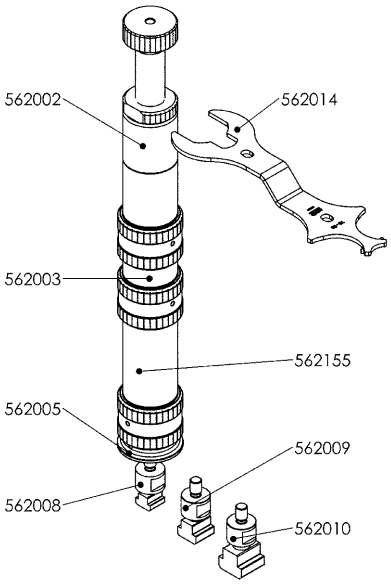
- The maximum height of 1626 mm is continuously adjustable and a height overlap is attainable (with base element 6425FG or 6425FY).
- The connecting points are protected against soiling.
- Improved handling by means of individual elements.
- Set-up time saving thanks to flexibility of parts.
- Storage optimisation.

Note:

- The modular design makes it possible to use different head and intermediate elements. Thus, a maximum height (with base element 6425FG or 6425FY) of 1626 mm with a permissible support force of 60 kN is possible. In addition, there is a risk of buckling.
- Do not adjust under load.







Recommendations



No. 6425FY,
page 59



No. 6425FG,
page 59



No. 6425WW,
page 62

Subject to technical alterations.

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No. 6425S-406

Screw jack element with acme thread and base element 6425FB

with locknut for locking, centring hole diameter 12 mm. Spindle with acme thread made completely of tempered steel, spindle head burnished.
Body and base element, tempered steel, burnished.

Focus Open 2020
Gold



Order no.	TR	H min. [mm]	H max. [mm]	F max. [kN]	Weight [g]
562002	40 x 7	306	406	60	9436

Application:

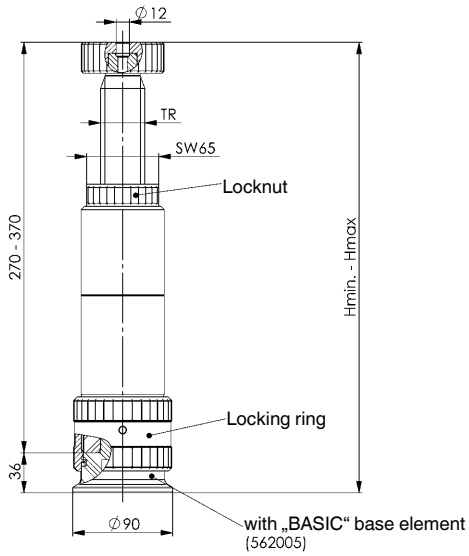
Can be used on T-slots and grid plates by means of adapters, which are screwed in the base element. The individual elements are plugged together and connected by means of a threaded ring ensuring process reliability. The insertion tool makes it possible to use the locknut and base element as well as the thread adapter.

Advantage:

- Can be used modularly.

Note:

- The use as a head element in the screw jack modular makes a maximum height of 1626 mm with a permissible support force of 60 kN possible. In addition, there is a risk of buckling.
- Do not adjust under load.



Recommendations



No. 6425Z, page 57



No. 6425MW, page 62

CAD

No. 6425Z

Spacer element

Tempered steel, burnished.



Order no.	Size	H	H1	Weight [g]
562003	100	100	150 - 166,5	3132
562155	200	200	250 - 266,5	6228
562004	300	300	350 - 366,5	7493

Application:

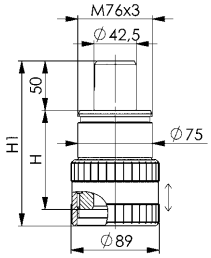
- As extension of the modular screw jack to achieve the maximum permitted support height of 1626 mm (with base element 6425FG or 6425FY).

Advantage:

- The maximum height of 1626 mm is continuously adjustable and a height overlap is attainable.
- The connecting points are protected against soiling.
- Improved handling by means of individual elements.
- Set-up time saving thanks to flexibility of parts.
- Storage optimisation.

Note:

- The use as an intermediate element in the screw jack modular makes a maximum height of 1626 mm with a permissible support force of 60 kN possible. In addition, there is a risk of buckling.
- Do not adjust under load.



Recommendations



No. 6425FB, page 58



No. 6425S-406, page 57

CAD

Subject to technical alterations.

No. 6425FB

Base element

Tempered steel, burnished.

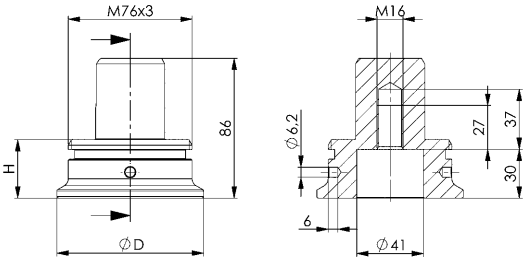
CAD

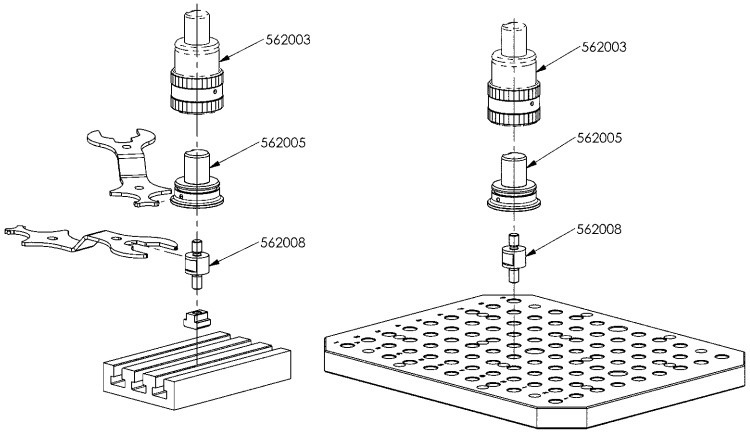
Order no.	D	H	Weight [g]
562005	90	36	1497

Application:

Can be used on T-slots and grid plates by means of adapters, which are screwed in the base element. The individual elements are plugged together and connected by means of a threaded ring ensuring process reliability. The insertion tool makes it possible to use the base element as well as thread adapter.







Recommendations



No. 6425GA, page 58



No. 6425MW, page 62

No. 6425GA

Thread adapter

Tempered steel, burnished.

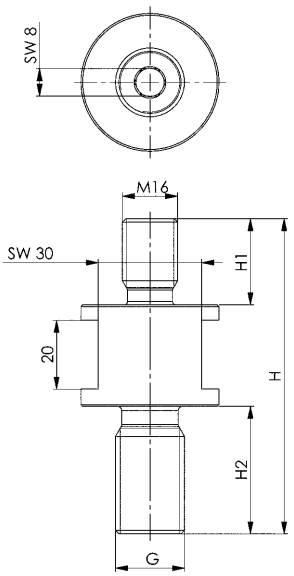
CAD

Order no.	G	H	H1	H2	Weight [g]
562008	M16	83,5	25	29	339
562009	M20	91,5	25	37	381
562010	M24	101,5	25	47	452

Application:

The thread adapters are screwed in the base element 6425FB and can thus be used on T-slots and grid plates. The insertion tool makes it easy to use the thread adapter.





Subject to technical alterations.

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No. 6425FG

Base element

Tempered steel, burnished.

CAD

Order no.	D	H	Weight [g]
562006	90	56	5717

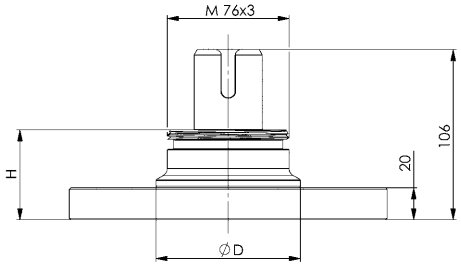


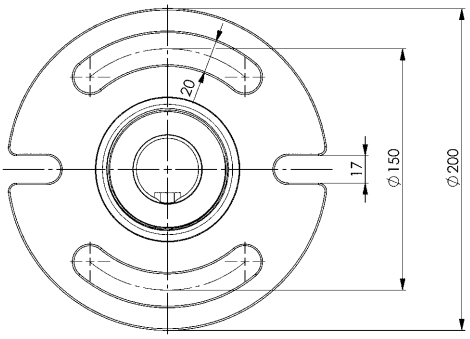
Application:

Can be used on T-slots and grid plates. The individual elements are plugged together and connected by means of a threaded ring ensuring process reliability. The insertion tool makes it possible to use the base element as well as thread adapter.

Advantage:

- Enables variable positioning on the machine table.
- The threaded interface allows the base element to be replaced easily on the modular screw jack.





No. 6425FY

Base element

Tempered steel, burnished.

CAD

Order no.	D	H	Weight [g]
562007	90	56	5652

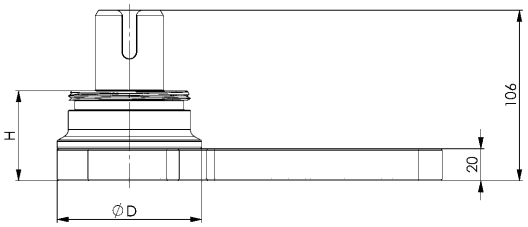


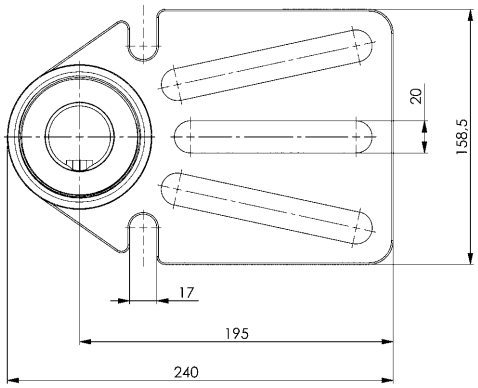
Application:

Can be used on T-slots and grid plates. The individual elements are plugged together and connected by means of a threaded ring ensuring process reliability. The insertion tool makes it possible to use the base element as well as thread adapter.

Advantage:

- Enables variable positioning on the machine table.
- The threaded interface allows the base element to be replaced easily on the modular screw jack.





Subject to technical alterations.

No. 6425A-230

Height adjustment jack with fine thread and base element 6425FB

Body and base element, tempered steel, burnished.
Spindle and bearing smooth, tempered steel, plasma-nitrided and burnished.

CAD

Order no.	H min. [mm]	H max. * [mm]	F max. [kN]	Weight [g]
562001	210	230	35	6671

* maximum attainable height with an spacer element 6425Z-100 is 330 mm

Focus Open 2020
Gold



Application:

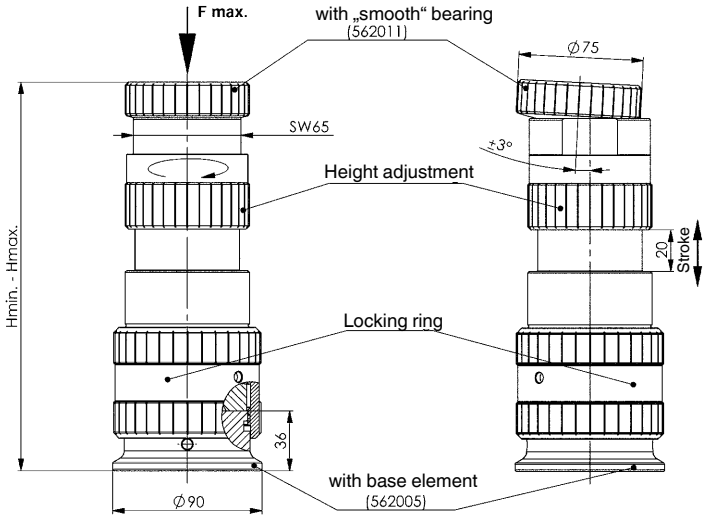
Can be used on T-slots and grid plates by means of adapters, which are screwed into the base element. The bearings can be adjusted with an angle of +/- 3 °.

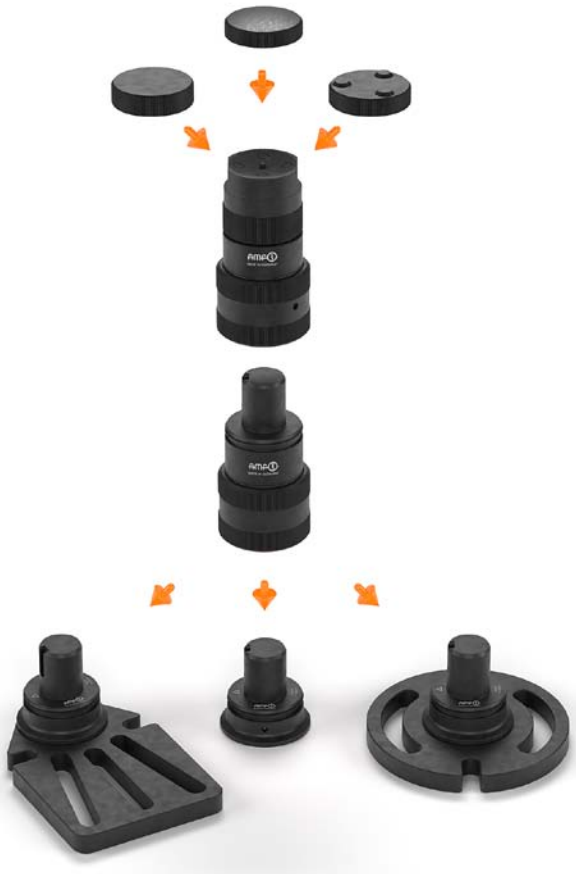
Advantage:

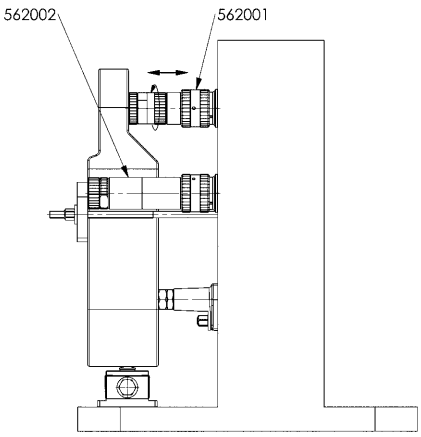
- The height adjustment jack can be adjusted up to a support height of max. 330 mm under load.
- Used as an extra support point to prevent sagging and vibration of the workpiece.
- Mounted directly under a clamping point, distortion of the workpiece is prevented.
- Compensation of large workpiece tolerances (castings and forgings).
- For use in horizontal and vertical clamping.

Note:

- **maximum height 330 mm** with the bearing with +/- 3° angle function 6425AB, 6425AG, 6425AP
- maximum height 1626 mm with the fixed bearing without angle function 6425AGF
- The bearings are retained by magnets
- Bearings (smooth, spherical, point) can be replaced







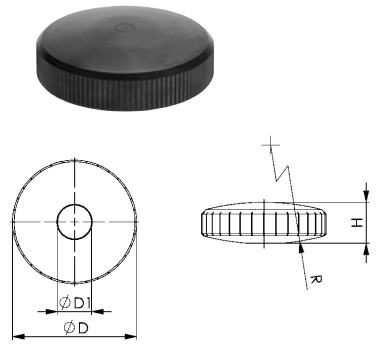
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No. 6425AB

Bearing, spherical

Tempered steel, plasma-nitrided and burnished.



Order no.	dia. D [mm]	dia. D1 [mm]	H [mm]	R [mm]	Weight [g]
562012	75	20,5	24,7	140	655

Application:

- Interchangeable bearing for the support element 6425A-230.

Advantage:

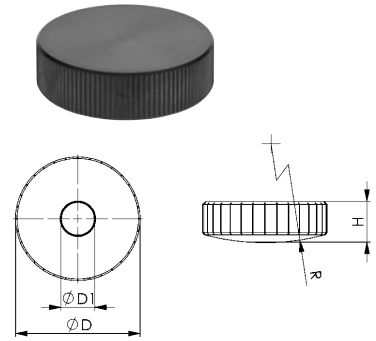
- Compensation of large workpiece tolerances (castings and forgings).
- For use in horizontal and vertical clamping, since secured by magnet and cylinder pin.
- The bearings can be adjusted with an angle of + / - 3°.

No. 6425AG

Bearing, smooth

Tempered steel, plasma-nitrided and burnished.

CAD



Order no.	dia. D [mm]	dia. D1 [mm]	H [mm]	R [mm]	Weight [g]
562011	75	20,5	24,7	140	739

Application:

- Interchangeable bearing for the support element 6425A-230.

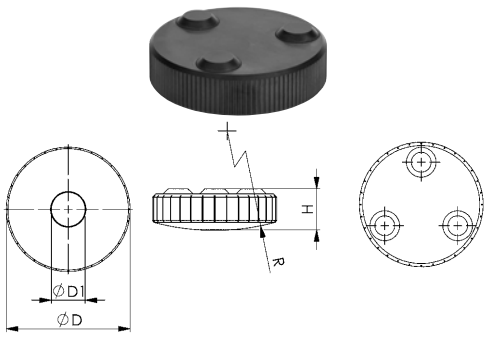
Advantage:

- Compensation of large workpiece tolerances (castings and forgings).
- For use in horizontal and vertical clamping, since secured by magnet and cylinder pin.
- The bearings can be adjusted with an angle of + / - 3°.

No. 6425AP

Bearing, point

Tempered steel, plasma-nitrided and burnished.



Order no.	dia. D [mm]	dia. D1 [mm]	H [mm]	R [mm]	Weight [g]
562013	75	20,5	24,7	140	651

Application:

- Interchangeable bearing for the support element 6425A-230.

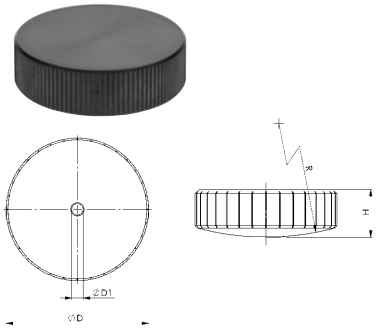
Advantage:

- Compensation of large workpiece tolerances (castings and forgings).
- For use in horizontal and vertical clamping, since secured by magnet and cylinder pin.
- The bearings can be adjusted with an angle of + / - 3°.

No. 6425AGF

Bearing, smooth, fixed

Tempered steel, plasma-nitrided and burnished.



Order no.	dia. D [mm]	dia. D1 [mm]	H [mm]	R [mm]	Weight [g]
569434	75	6	25	140	750

Application:

- Interchangeable bearing for the support element 6425A-230

Advantage:

- Smooth, fixed support without angle function enables alignment with the support element and various spacer elements up to a total height of 1626 mm
- For use in horizontal and vertical clamping, since secured by magnet and cylinder pin.

Subject to technical alterations.

No. 6425WW

Tool cart

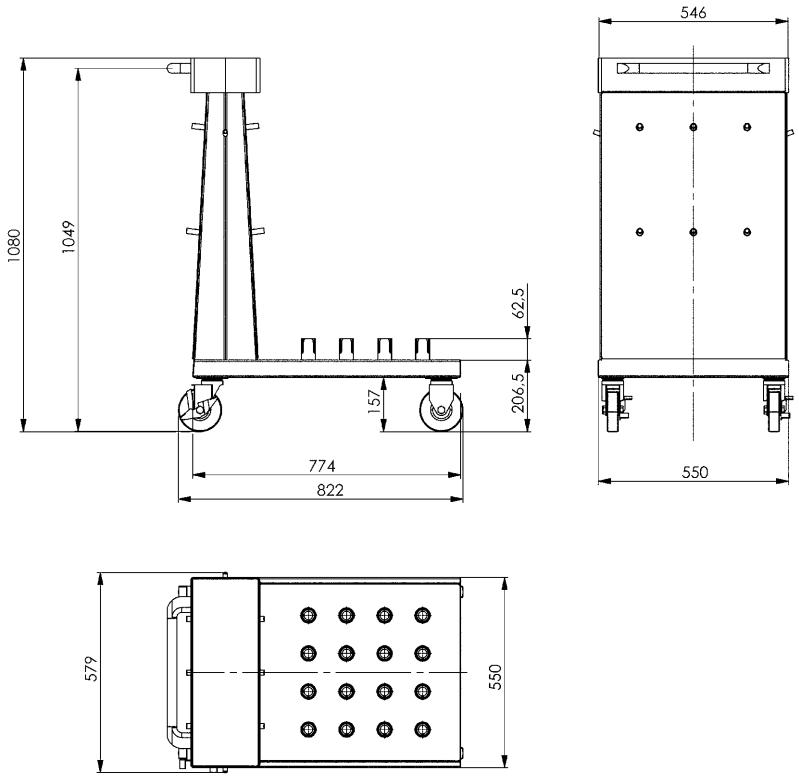
without screw jack elements
Steel housing powder-coated.
All surfaces protected with rubber mats.
2 rollers + 2 castors with locking brake

Order no.	Height x length [mm]	Weight [g]
562015	1080 x 822	63240

Advantage:

- mobile = quickly ready when needed at the workplace
- Tidy = convenient, space-saving and always readily available
- Individual equipment configurations possible through construction of many mounting points





No. 6425MW

Insertion tool

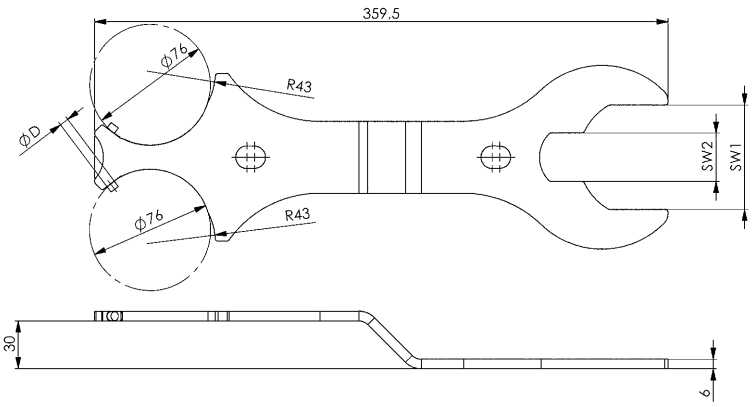
Special steel, hardened and blued in black oxide finish.

Order no.	Size	D	SW1	SW2	Weight [g]
562014	76	6	65	30	960

Application:

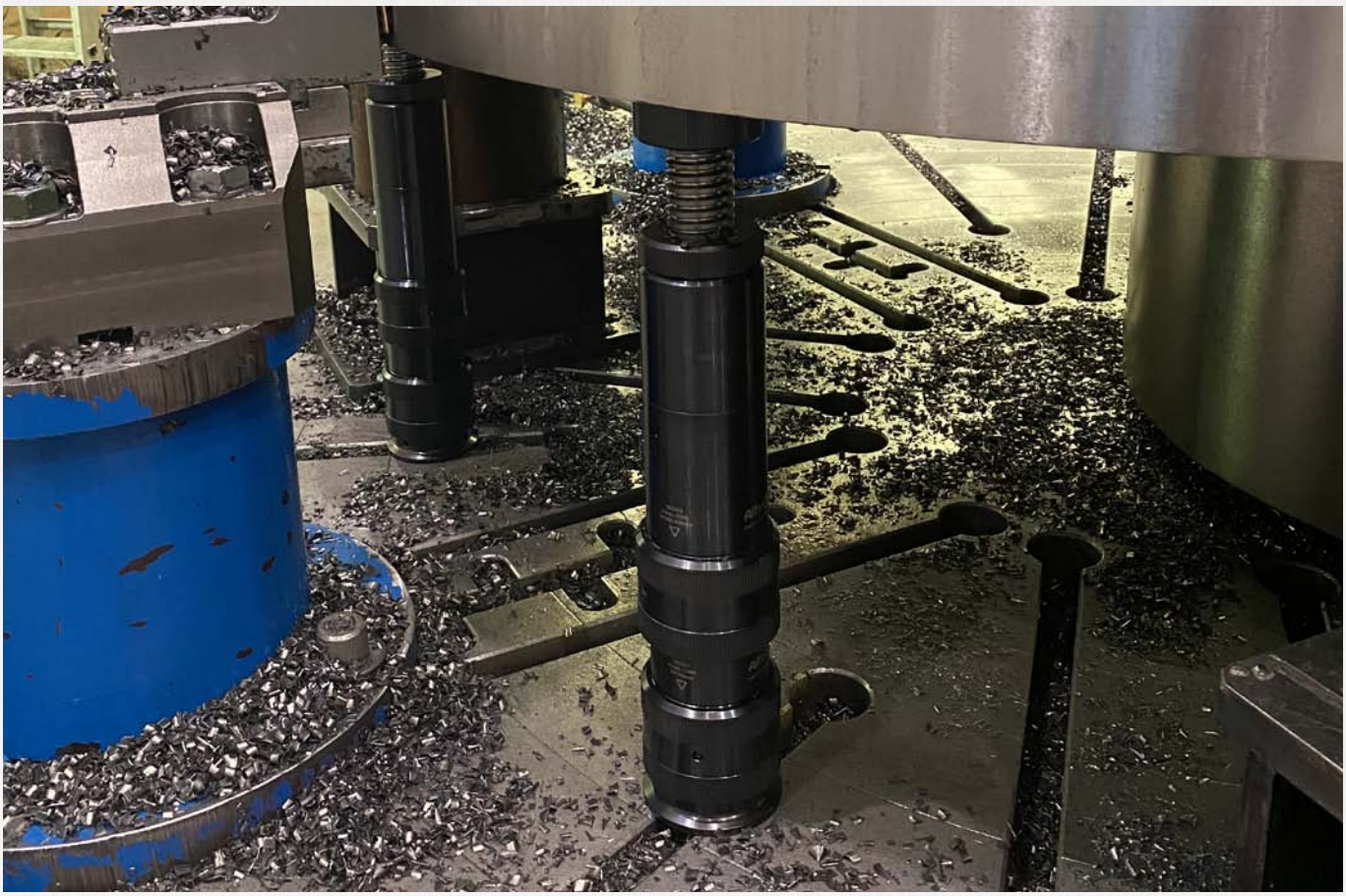
The insertion tool makes it possible to use the head and base elements of the screw jack modular as well as thread adapter.





Subject to technical alterations.

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Subject to technical alterations.

No. 6400-285

Screw jack set

Tempered steel
Consisting of 1 item each
- Screw jack 6400 size 52
- Screw jack 6400 size 70
- Screw jack 6400 size 100
- Base element 6400FB
- Spacer element 6400Z-25
- Spacer element 6400Z-50
- Spacer element 6400Z-100
- Spherical attachment 6440G-M10
- Hook spanner DIN1810B

Order no.	Size	H min. [mm]	H max. [mm]	Weight [g]
569431	M10 x 12	42	285	4678
569432	M12 x 14	42	285	4691
569433	M16 x 18	42	285	4748

Application:

The modular design allows the use of various screw jack intermediate and base elements, which are screwed together using the thread.
The individual elements are fixed in place process safe using a hook spanner. A maximum height of 285 mm can be achieved with this set.

Advantage:

- Maximum height of 422 mm achievable with additional intermediate elements
- Improved handling by means of individual elements
- Set-up time saving thanks to flexibility of parts
- storage optimisation

Note:

Maximum achievable height of 422 mm with a permissible support force of 100 kN, above this there is a risk of buckling. Do not adjust under load.



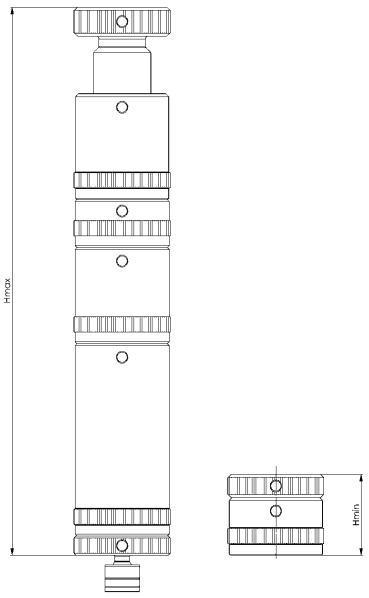
Recommendations

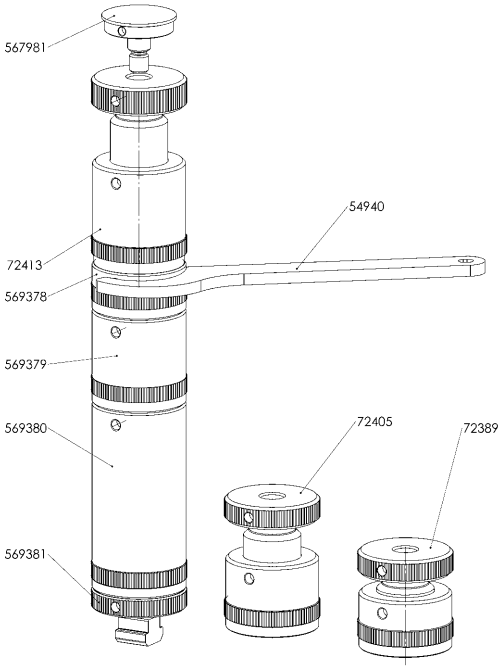


No. 6400Z, page 66



No. 6400FY, page 68





Subject to technical alterations.

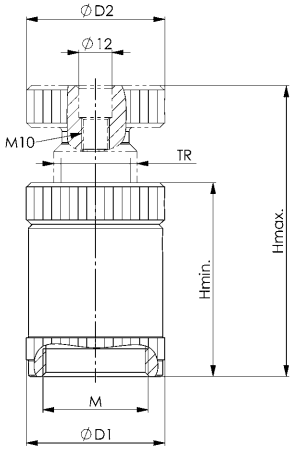
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No. 6400

Screw jack with flat support

Centring hole Ø12 mm / M10.
Spindle: self-locking acme thread, with final stop. Tempered steel, burnished.
Body: tempered steel, painted.





CAD

Order no.	Size	H min. [mm]	H max. [mm]	TR	D1	D2	M	F max. [kN]	Weight [g]
72397	**50**	38	50	20 x 4	31	31	-	25	190
72389	**52**	42	52	30 x 4	50	50	M38 x 2	100	550
72405	**70**	50	70	30 x 4	50	50	M38 x 2	100	620
72413	**100**	70	100	30 x 4	50	50	M38 x 2	100	900
72421	**140**	100	140	40 x 7	70	70	-	120	2760
72439	**210**	140	210	50 x 8	80	70	-	170	4600
72496	**200**	140	200	65 x10	100	80	-	350	6900
72447	**300**	190	300	65 x10	100	80	-	350	9000

Application:

The sizes 52-100 are suitable for clamps with a slot width of approx. 14-22 mm. The screw jack no. 6430S represents a useful addition for large clamping heights. The sizes 140-300 are suitable for clamps with a slot width of approx. 20-40 mm. For these, the screw jacks no. 6435S represent a useful addition for large clamping heights. When using clamps DIN 6315B, 6315C and 6315GN from 26 mm slot width, we recommend, fixing cap no. 6443. The sizes 200-300 are intended for supporting large workpieces.

Advantage:

- Modular design of sizes 52, 70, 100 with spacer elements 6400Z possible
- Improved rust protection, burnished spindle

Note:

Size 50 without centring hole Ø 12 / M10 mm. Size 200, 210 and 300 without thread M10.
Suitable attachments for screw jack sizes 52-280 are nos. 6440, 6441, 6442, 6443 and 6445. The suitable support for sizes 52-100 is no. 6442 or 6442G.
Do not adjust screw jack under load!

Recommendations



No. 6440, page 80



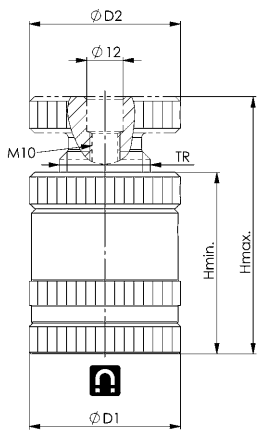
No. 6441, page 80

No. 6400M

Screw jack with flat support and magnetic base

Centring hole Ø12 mm / M10. Spindle: self-locking acme thread, with final stop. Tempered steel, burnished.
Body: tempered steel, painted.





CAD

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

Advantage:

Improved rust protection, burnished spindle

Note:

AMF screw jacks with magnetic base are designed for horizontal and vertical application. The permanent magnet allows permanent and exact positioning of the workpiece in a vertical position. The screw jacks are suitable for clamps of approx. 14-22 mm. When using clamps DIN 6415B, 6315C and 6315GN from 26 mm slot width, we recommend, by way of precaution, fixing cap no. 6443.
Suitable attachments: No. 6440, 6441, 6442, 6443 and 6445.
Suitable support for dismantled magnetic base: No. 6442G.
Do not adjust screw jack under load!

Recommendations



No. 6440, page 80



No. 6443, page 81

Subject to technical alterations.

No. 6400Z

Spacer element

Painted tempered steel.

Order no.	Size	D1 [mm]	H [mm]	H1 [mm]	Weight [g]
569378	**25**	50	25	35	217
569379	**50**	50	50	60	593
569380	**100**	50	100	110	1320



Application:

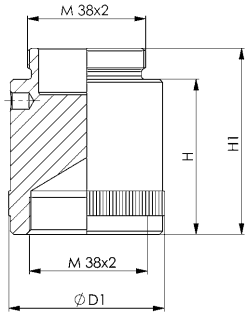
The spacer elements enable a modular height extension for the AMF 6400 screw jack in sizes 52/70/100. The individual elements are screwed together.
The combination of different base elements and the assembly of three screw jacks of different heights enables variable use.
The various elements can be fixed in place process safe using a hook spanner.

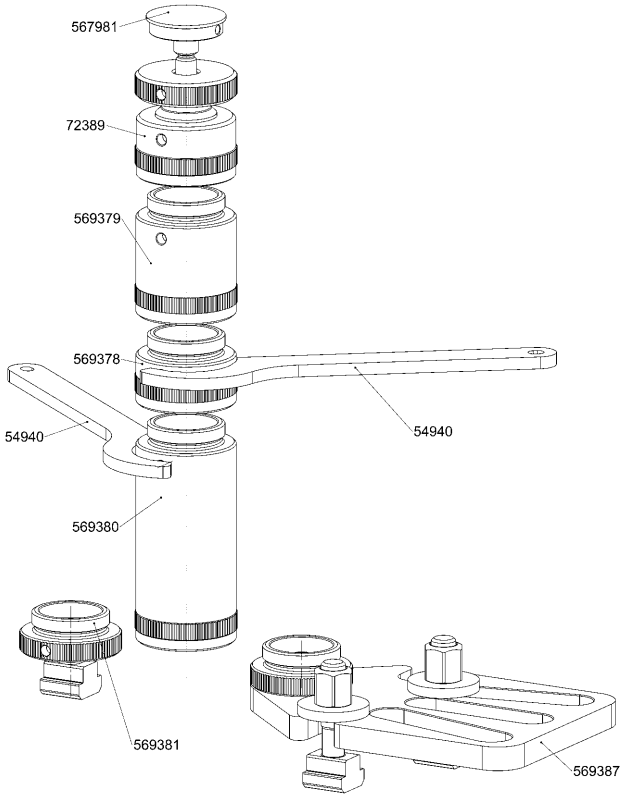
Advantage:

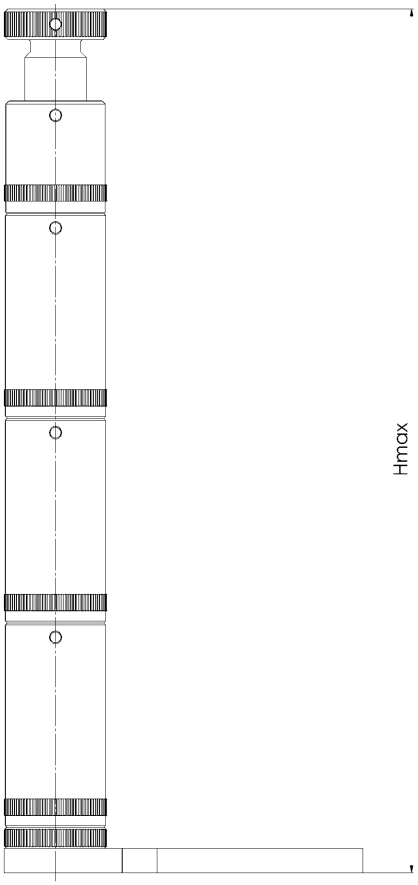
- Maximum height of 422 mm is achieved continuously adjustable and with a height overlap
- Improved handling by means of individual elements
- Set-up time saving thanks to flexibility of parts
- storage optimisation

Note:

Maximum achievable height of 422 mm with a permissible support force of 100 kN, above this there is a risk of buckling.
Do not adjust under load.
When using the magnetic base 6401M, a maximum height of 160 mm can be implemented when the modular screw jack is used horizontally.







Recommendations



No. 6400, page 65



No. 6400FY, page 68



DIN 1810B

Subject to technical alterations.

No. 6400FB

Base element

Tempered steel, burnished.

Order no.	Size	A [mm]	G [mm]	H [mm]	Weight [g]
569381	**M10 x 12**	12	M10	10	212
569382	**M12 x 14**	14	M12	10	230
569386	**M16 x 18**	18	M16	10	287

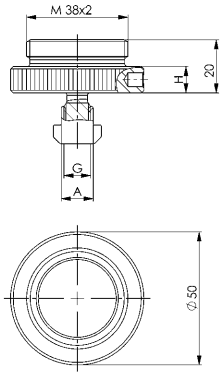


Application:

The base elements can be used on T-slots and grid plates.
Screw jack elements in sizes 52/70/100 can be screwed directly onto the base elements or spacer elements.

Advantage:

By using the 6400FB base elements, the 6400 modular screw jack can be bolted process safe horizontally and vertically. For this purpose, the base element can be fastened in T-slots using the nut for T-slots supplied. It is also possible to screw directly onto breadboard plates or fixture plates.



Recommendations



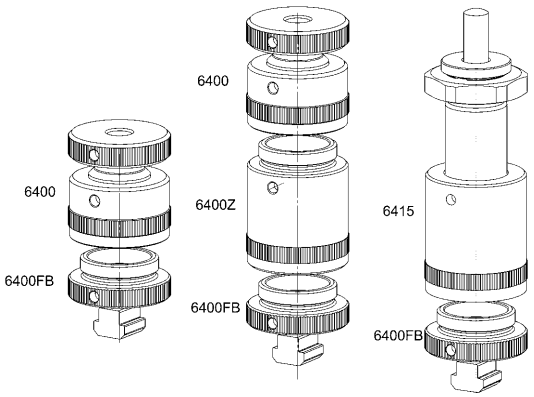
No. 6400,
page 65



No. 6400Z,
page 66



DIN 1810B



Subject to technical alterations.

No. 6400FY

Base element slot

Tempered steel, burnished.

Order no.	H [mm]	Weight [g]
569387	22	1280

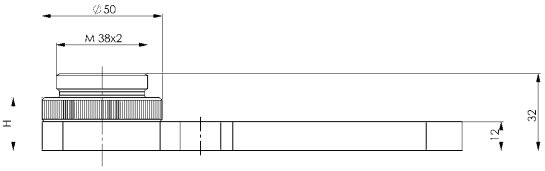
Application:

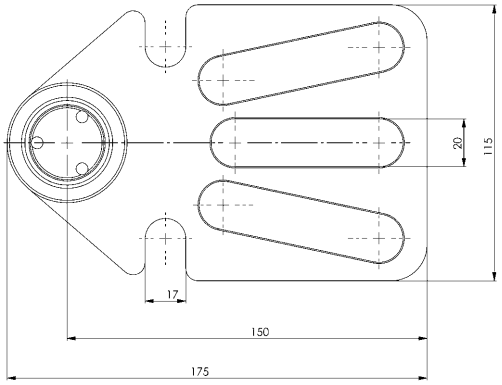
The base elements can be used on T-slots and grid plates.
Screw jack elements in sizes 52/70/100 can be mounted directly onto the base elements or spacer elements.

Advantage:

- Enables variable positioning on the machine table.
- The threaded interface allows the base element to be replaced easily on the modular screw jack.







Recommendations



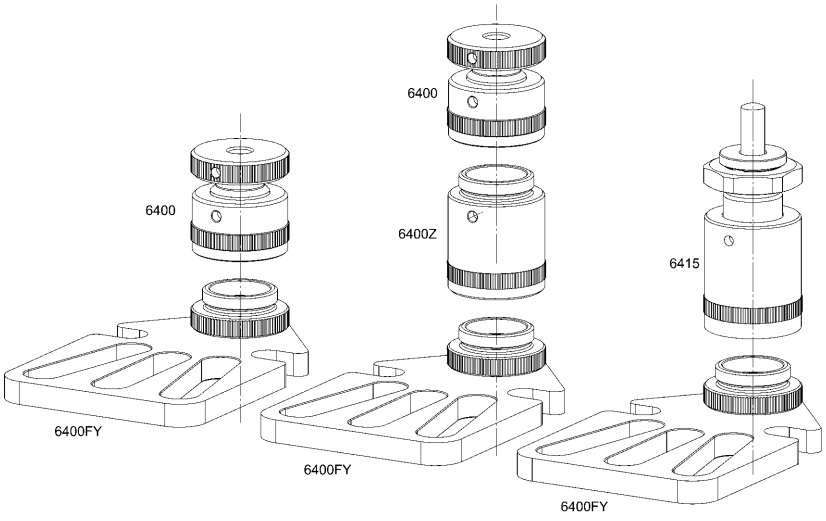
No. 6400, page 65



No. 6400Z, page 66



DIN 1810B



Subject to technical alterations.

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No. 6401

Aluminium screw jack

Centring hole Ø12 mm / M10. Spindle: tempered steel burnished, self-locking trapezoidal thread, with final stop. Base: aluminium 400 N/ mm2 tensile strength.

Order no.	Size	H min. [mm]	H max. [mm]	TR	D1	D2	M	F max. [kN]	Weight [g]
75770	**52**	42	52	30x4	50	50	M38 x 2	30 *	370
75788	**70**	50	70	30x4	50	50	M38 x 2	30 *	430
75796	**100**	70	100	30x4	50	50	M38 x 2	30 *	600



Application:

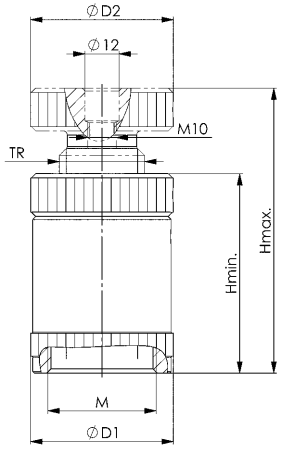
Protects the tables from precision machines (steel chips do no penetrate into the machine table, but into the aluminium base). Suitable for all machine tool tables as well as for guide and measuring plates with precision machined surfaces.

Advantage:

Modular design with aluminium spacer elements 6401Z possible.

Note:

F max.* until max. 350 mm total height ensured. In addition, there is a risk of buckling.
Suitable attachments: no. 6440, 6440G, 6441, 6442, 6442G/M10, 6443/14 and 6445
Suitable support: no. 6401MF, 6401AF, 6400FB, 6400FY
Do not adjust screw jack under load!



CAD

Recommendations



No. 6401Z, page 71

No. 6401M

Aluminium screw jack with magnetic base

Centring hole Ø12 mm / M10. Spindle: tempered steel burnished, self-locking trapezoidal thread, with final stop. Base: aluminium 400 N/ mm2 tensile strength.

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



Application:

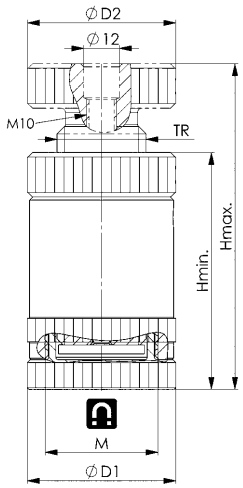
AMF screw jacks with magnetic base are designed for horizontal and vertical application. The permanent magnet allows permanent and exact positioning of the workpiece in a vertical position.

Advantage:

Modular design with aluminium spacer elements 6401Z possible.

Note:

F max.* until max. 350 mm total height ensured. In addition, there is a risk of buckling.
Suitable attachments: no. 6440, 6440G, 6441, 6442, 6442G/M10, 6443/14 and 6445
Suitable support: no. 6401MF, 6401AF, 6400FB, 6400FY
Do not adjust screw jack under load!



CAD

Subject to technical alterations.

No. 6406A-88

Aluminium screw jack with chip guard plate and aluminium base

Screw jack thread protected penetration of chips by the scraper.
Centring hole Ø12 mm / M10.
Spindle: tempered steel burnished, self-locking trapezoidal thread, with final stop.
Base: aluminium 400 N/mm² tensile strength.

Order no.	Size	H min. [mm]	H max. [mm]	TR	D1	D2	F max. [kN]	Weight [g]
72850	88	75	88	30x4	50	50	30	630

Application:

AMF screw jacks with aluminium base are designed for vertical applications.

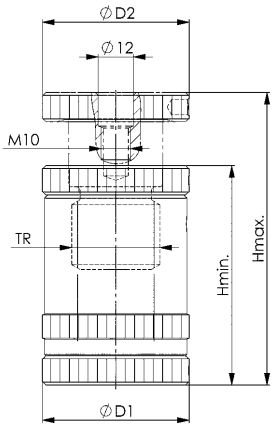
Advantage:

The screw jack thread is protected from the penetration of chips by the scraper. Modular design with aluminium spacer elements 6401Z possible.

Note:

F max. until max. 350 mm total height ensured. In addition, there is a risk of buckling.
Suitable attachments: no. 6440, 6440G, 6441, 6442, 6442G/M10, 6443/14 and 6445
Suitable support: no. 6400FB, 6400FY
Do not adjust screw jack under load!





Recommendations



No. 6401Z, page 71



No. 6440G, page 80

No. 6406M-88

Aluminium screw jack with chip guard plate and magnetic base

Screw jack thread protected penetration of chips by the scraper.
Centring hole Ø12 mm / M10.
Spindle: tempered steel burnished, self-locking trapezoidal thread, with final stop.
Base: aluminium 400 N/mm² tensile strength.

Order no.	Size	H min. [mm]	H max. [mm]	TR	D1	D2	F max. [kN]	Weight [g]
72868	88	75	88	30x4	50	50	30	720

Application:

AMF screw jacks with magnetic base are designed for horizontal and vertical application. The permanent magnet allows permanent and exact positioning of the workpiece in a vertical position.

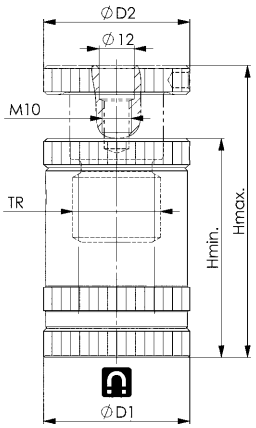
Advantage:

The screw jack thread is protected from the penetration of chips by the scraper. Modular design with aluminium spacer elements 6401Z possible.

Note:

F max. until max. 350 mm total height ensured. In addition, there is a risk of buckling.
Suitable attachments: no. 6440, 6440G, 6441, 6442, 6442G/M10, 6443/14 and 6445
Suitable support: no. 6400FB, 6400FY
Do not adjust screw jack under load!





Recommendations



No. 6401Z, page 71



No. 6440G, page 80

Subject to technical alterations.

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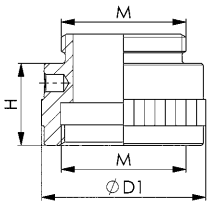
No. 6401Z

Aluminium spacer element

for the height extension of aluminium screw jacks.

Order no.	Size	H	D1	M	F max. [kN]	Weight [g]
72876	12	12,5	50	M38 x 2	30	38
72884	25	25,0	50	M38 x 2	30	76
72926	50	50,0	50	M38 x 2	30	165





CAD

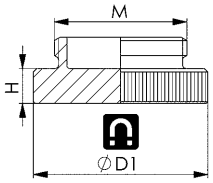
No. 6401MF

Magnetic base for screw jacks

Housing: Steel, black zinc-plated

Order no.	H	D1	M	Weight [g]
558436	10	50	M38 x 2	125





CAD

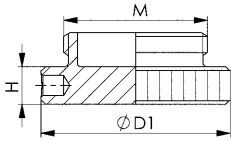
No. 6401AF

Aluminium base for screw jacks

Case: Aluminium

Order no.	H	D1	M	F max. [kN]	Weight [g]
557186	10	50	M38 x 2	30	60





CAD

Recommendations



No. 6401Z, page 71

Subject to technical alterations.

Aluminium screw jack with swarf protection

No. 6406-125

Aluminium screw jack with swarf protection

Screw jack thread protected penetration of chips by the scraper. Centring hole Ø12 mm / M10. Spindle: tempered steel burnished, self-locking trapezoidal thread, with final stop.
Consisting of:
- Screw jack with chip guard
- Spacer element 12.5 mm
- Spacer element 25 mm
- Aluminium and magnetic base.

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

Application:

AMF screw jacks with magnetic base are designed for horizontal and vertical application. The permanent magnet allows permanent and exact positioning of the workpiece in a vertical position.

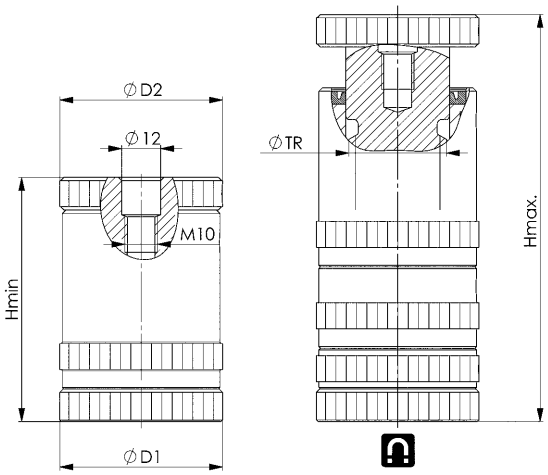
Advantage:

The screw jack thread is protected from the penetration of chips by the scraper. Modular design with aluminium spacer elements 6401Z possible.

Note:

F max. until max. 350 mm total height ensured. In addition, there is a risk of buckling.
Suitable attachments: no. 6440, 6440G, 6441, 6442, 6442G/M10, 6443/14 and 6445
Suitable support: no. 6400FB, 6400FY
Do not adjust screw jack under load!





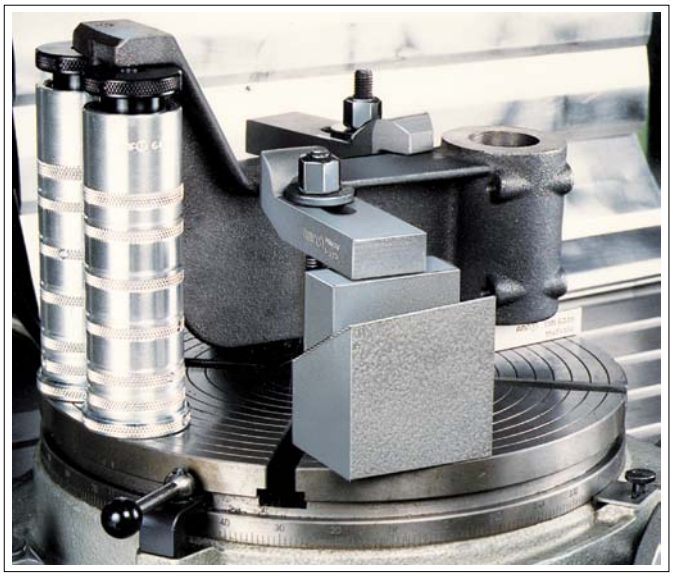
Recommendations



No. 6401Z, page 71



No. 6440G, page 80



CAD

Subject to technical alterations.



No. 6415

Height setting screw jack

with a cylinder pin ISO8734-12x50. Centring hole Ø12 mm. Spindle: Metric fine thread M30x1.5 with final stop. Sliding insert runs on pressed plain bearing bushing. Tempered steel, burnished.



Order no.	Size	H min. [mm]	H max. [mm]	D1	D2	H1 min.	H1 max.	F max. [kN]	Weight [g]
86504	**75**	55	75	50	34	82	102	30	680
86512	**115**	75	115	50	34	102	142	30	950

Application:

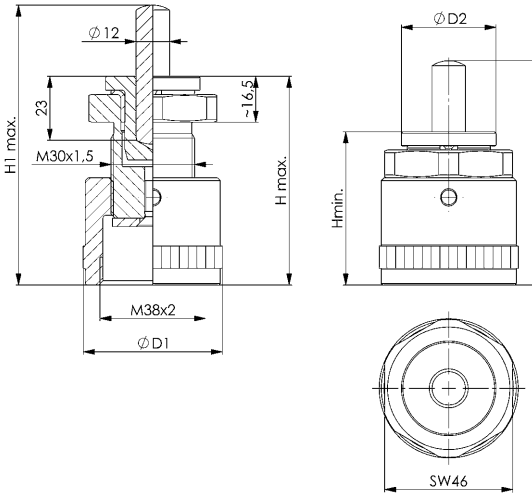
The height guide bench vice can also be used without cylinder pin or with the attachments No. 6440 and No. 6441. The combination with all AMF screw jacks is possible with centring plate.

Advantage:

Sensitive adjustment. A bearing insert prevents the workpiece from being turned while the jack is adjusted.

Note:

Suitable attachments: No. 6440, 6441 and 6442.
Suitable support: No. 6442G.



Recommendations



No. 6440, page 80



No. 6441, page 80



No. 6442, page 81

CAD

No. 6416

Height setting screw jack with magnetic base

with a cylinder pin ISO8737-12x50. Centring hole Ø12 mm. Spindle: Metric fine thread M30x1.5 with final stop. Sliding insert runs on pressed plain bearing bushing. Tempered steel, burnished.



Order no.	Size	H min. [mm]	H max. [mm]	D1	D2	H1 min.	H1 max.	F max. [kN]	Weight [g]
86520	**85**	65	85	50	34	92	112	30	800
86538	**125**	85	125	50	34	112	152	30	1000

Application:

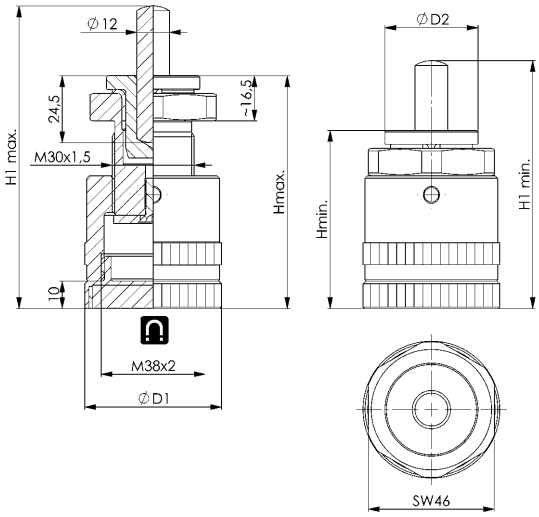
The height guide bench vice can also be used without cylinder pin or with the attachments No. 6440 and No. 6441. The combination with all AMF screw jacks is possible with centring plate.

Advantage:

Sensitive adjustment. A bearing insert prevents the workpiece from being turned while the jack is adjusted.

Note:

Suitable attachments: No. 6440, 6441 and 6442.
Suitable support for dismantled magnetic base: No. 6442G.



Recommendations



No. 6315GN, page 32



No. 6315GNG, page 32

CAD

Subject to technical alterations.

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No. 6420

Height setting screw jack with pivotable ball

Steel tempered, burnished. Ball made of hardened steel.



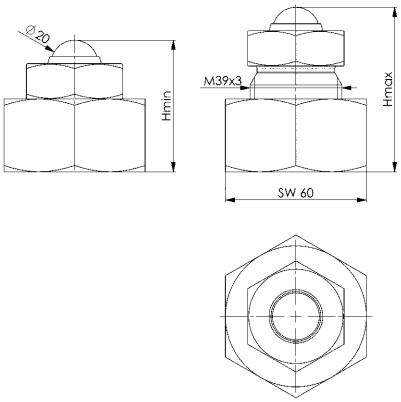
Order no.	Size	H min. [mm]	H max. [mm]	F max. [kN]	Weight [g]
72546	70	56	70	30	950

Application:

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

Advantage:

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



Recommendations



No. 6400, page 65



No. 6415, page 74

CAD

Subject to technical alterations.

No. 6460

Wedge block „Herkules“ height wedge

Ø12 mm centring hole. Ductile iron and steel, tempered, quenched in black oxide finish. Wedge surface finely machined. A spherical attachment 6440 or 6440G accompanies each wedge block.



Order no.	Size	H min. [mm]	H max. [mm]	B1 [mm]	B1 [mm]	H1 [mm]	H1 [mm]	L [mm]	SW [mm]	H/U* [mm]	F max. [kN]	Weight [g]
72777	**63**	50	68	63	40	80	7	63	13	0,9	40	1700
72785	**125**	100	125	115	60	135	20	125	24	1,2	100	8600
72793	**190**	170	190	145	80	200	20	175	36	2,0	250	23750

*H/U= height adjustment per single turn.

Application:

The fine-machined wedge surfaces permits a smooth, precise adjustment to less than 1/10 mm. The double wedge effect produces a large stroke and precise vertical movement with no lateral shift. The height wedge proves its worth with heavy castings or forgings on large tool machines. The AMF „Herkules“ whipstock has an additional centring hole in the floor of the base area.

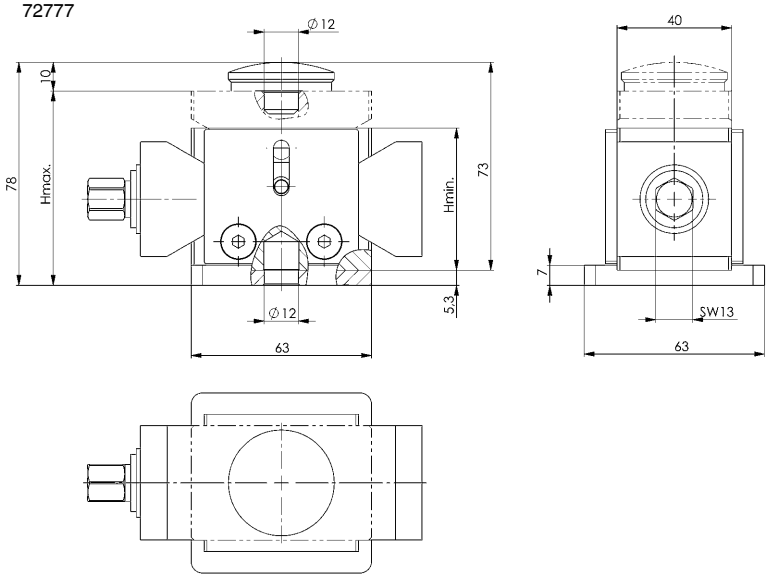
Advantage:

For the sizes 125 and 190, the attachment 6440G can be screwed in so it cannot be lost.

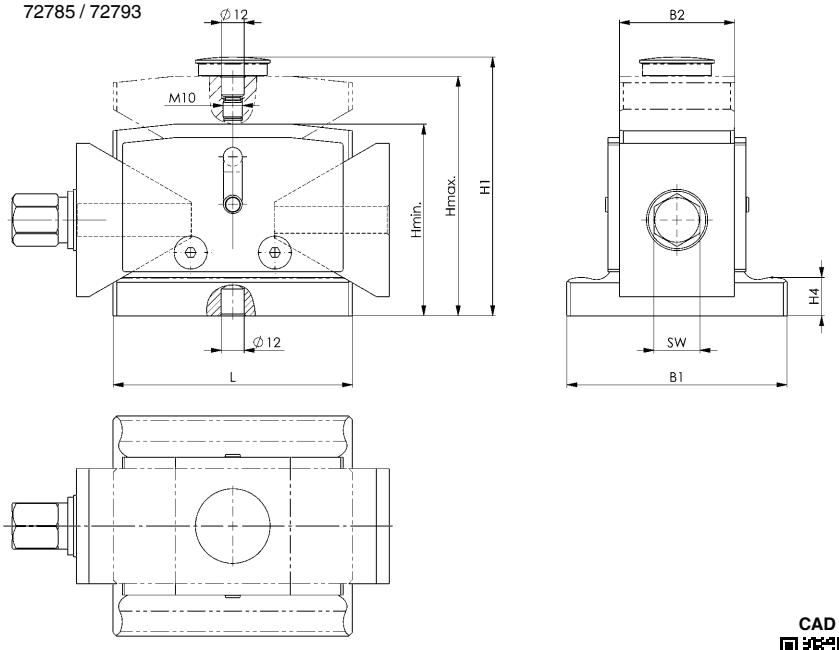
Note:

Suitable attachments for wedge block No. 6460 are No. 6440, 6440G, 6441 and 6442.
All sizes with lateral clamping rim for fastening on the machine table.
For size 63, the base plate is removable for reaching Hmin.

72777



72785 / 72793



Recommendations



No. 6440, page 80



No. 6440G, page 80



No. 6444, page 81

CAD

Subject to technical alterations.

No. 6465

Precision wedge block

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



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

*H/U= height adjustment per single turn.

Application:

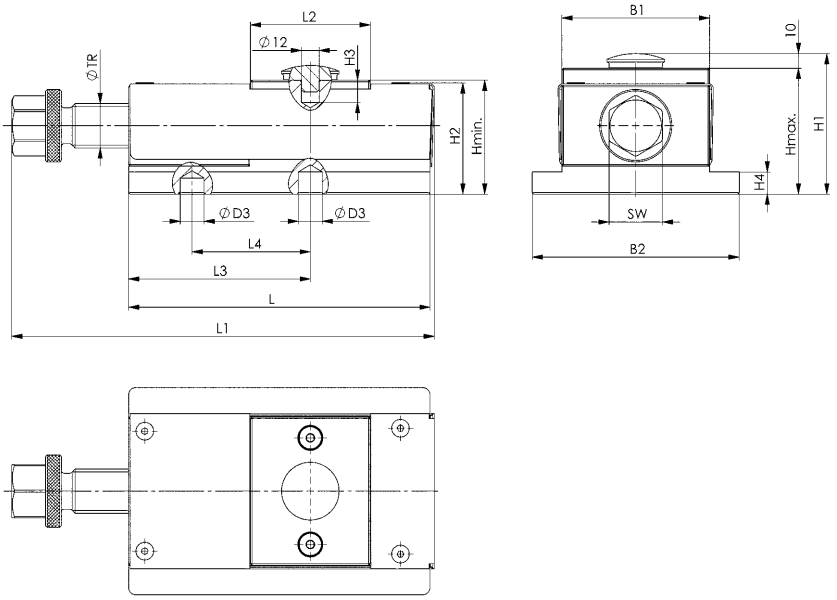
- The fine-machined wedge surfaces permits a smooth, precise adjustment to less than 1/10 mm.
- Operation can be via an open-ended spanner - hence ensuring enhanced safety and ease of handling due to the large adjusting forces.
- The double wedge effect produces a precise vertical movement with no lateral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

Advantage:

Precision whipstock can be adjusted under load.

Note:

- Suitable caps for the precision whipstock are nos. 6440, 6441 and 6442
- Height adjustment is 0.71 mm / revolution



Recommendations



No. 6440, page 80



No. 6445, page 81



No. 6443, page 81

Dimensions:

Order no.	B1	B2	TR	H1	H2	H3	H4	L	L1	L2	L3	L4	D3
375592	60	80	20	60-65	47,5	10	13	128	150-179	60	71	-	12
375618	100	140	30	87-95	74,0	15	15	204	242-287	81	123	80	16

CAD

Subject to technical alterations.

No. 6430S

Atlas screw jack with counter nut

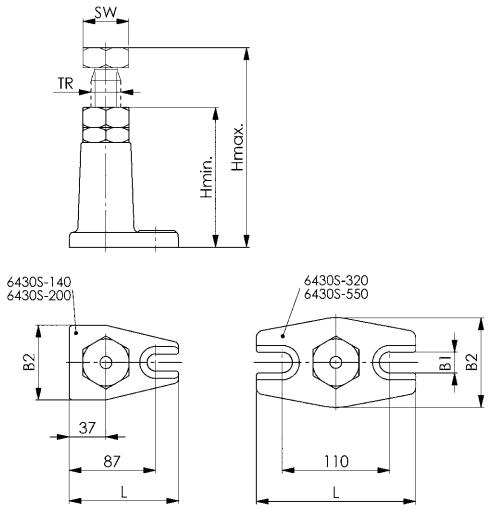
Centring hole dia. 12 mm. Spindle complete: tempering steel with trapezoidal thread. Spindle head blued. Housing: cast iron, varnished.



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

Note:

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



Recommendations



No. 6442, page 81



No. 6443, page 81



No. 6445, page 81

CAD

No. 6435S

Heavy screw jack

with nickel lock bolt. Centring hole D12 / M10. Spindle: Tempered steel, self-locking acme thread, with final stop. Spindle head burnished. Body: tempered steel, painted.



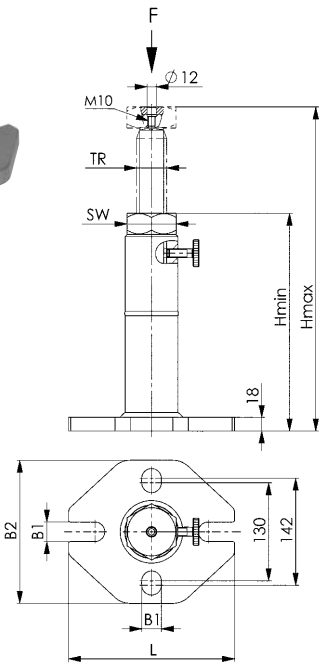
Order no.	Size	H min. [mm]	H max. [mm]	TR	B1	B2	L	SW	F max. [kN]	Weight [Kg]
72637	**300**	200	300	40x7	26	190	220	65	80	8
72645	**460**	290	470	40x7	26	190	220	65	60	10
72652	**750**	430	750	40x7	26	190	220	65	50	13
72660	**1250**	710	1250	40x7	26	190	220	65	40	18

Advantage:

- Thread M10 on the spindle top for fixing attachment elements.
- Greater clamping heights can be achieved by installing with no. 6442G and no. 6415.
- Base plate with closed slots for fastening onto the machine table. Accordingly, it can also be used for rotating clamping tasks.

Note:

When using clamps DIN 6315B, 6315C and No. 6315GN from 26 mm slot width, we recommend the fixing cap No. 6443. Suitable attachments for screw jack No. 6435S are No. 6440, 6441, 6442, 6443, 6445 and 6442G.
Do not adjust screw jack under load!



Recommendations



No. 6440, page 80



No. 6441, page 80



No. 6445, page 81

Subject to technical alterations.

CAD

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No. 6438S

Screw jack, quick-action

continuously adjustable with nickel lock bolt.
Centring hole D12 / M10. Spindle: Tempered steel, self-locking acme thread with final stop.
Spindle head burnished. Body: tempered steel, painted.

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



Application:

This screw jack allows fast adjustment and continuous adjustment within the entire height range.
Suitable attachments: No. 6440, 6441, 6443, 6445 and 6442G.

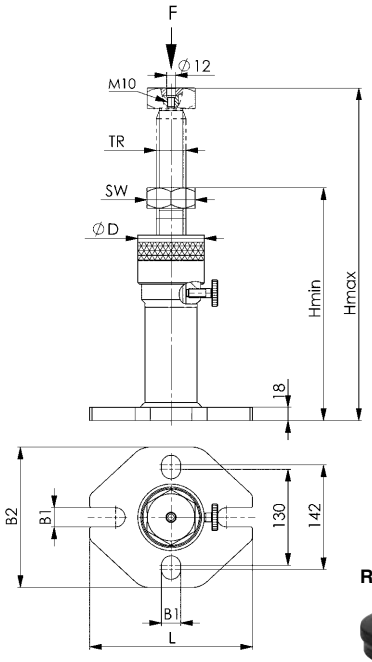
Advantage:

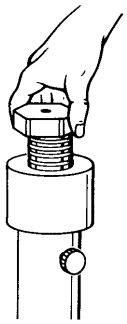
- Thread M10 on the spindle top for fixing attachment elements.
- Greater clamping heights can be achieved by installing with No. 6442G and No. 6415.
- Base plate with closed slots for fastening on the machine table.

Note:

- Hold spindle, max. 6 kg
- Undo lock bolt
- Turn actuating ring to undo the spindle
- Adjust height
- Turn actuating ring to fasten the spindle
- Secure spindle with lock bolt

Do not subject the screw jack to excessive load!





Recommendations



No. 6440, page 80



No. 6441, page 80

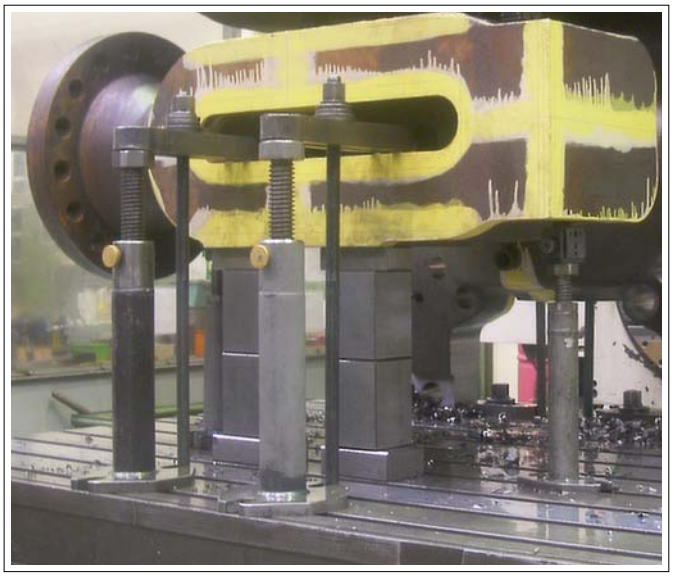


No. 6442, page 81

CAD







Subject to technical alterations.

No. 6440

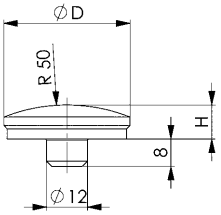
Ball-pad

Steel tempered, burnished.

Order no.	H	D	Weight [g]
72710	10	39	75



CAD



No. 6440G

Spherical attachment with thread

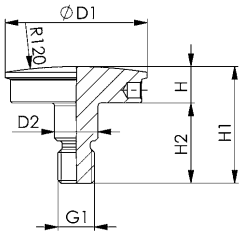
Tempered steel, burnished quenched.

Order no.	H	D1	D2	G1	H1	H2	Weight [g]
567981	10	39	11,9	M10	32	22	95



Application:

The centring plate can be screwed to the screw jacks 6435S, 6438S or onto the wedge block 6460 size 125/190.



No. 6440GS

Swivelling attachment smooth with +/- 3° angle function

Tempered steel, burnished quenched.

Order no.	Size	H	D	Weight [g]
570303	M10	27,5	50	389

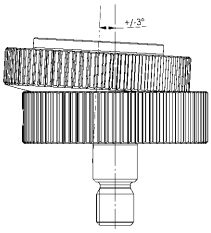


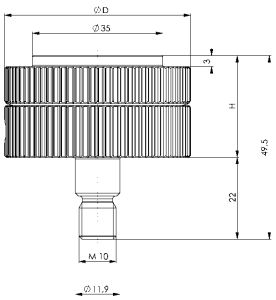
Application:

The swivel attachment can be fastened to the spindle heads of the AMF 6400, 6435S or 6438S screw jacks using a thread.

Features:

The support has a +- 3° angle function and allows the compensation of large workpiece tolerances.





Recommendations



No. 6400, page 65



No. 6435S, page 78

No. 6441

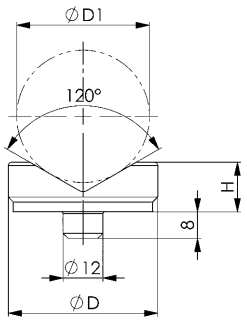
Vee-pad

Steel tempered, burnished.

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



CAD



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No. 6442

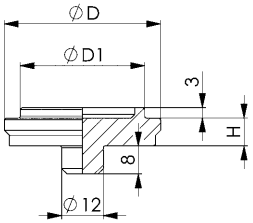
Centering-pad

Steel tempered, burnished.

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



CAD



No. 6443

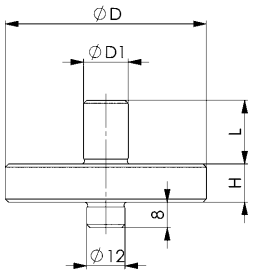
Locating-pad

for forked clamps. Steel tempered, burnished.

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



CAD



No. 6444

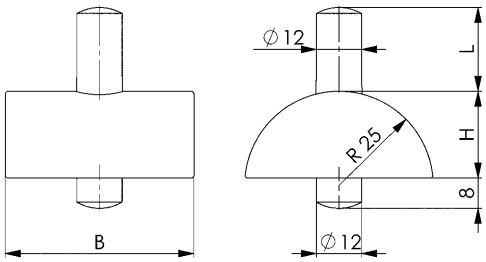
Locating-pad

with cylindrical face. Steel tempered and burnished.

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



CAD



No. 6445

Support with pivotable ball

Steel tempered, burnished. Ball made of hardened steel.

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



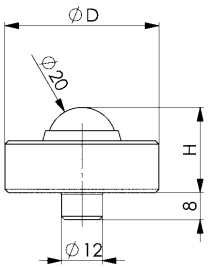
Application:

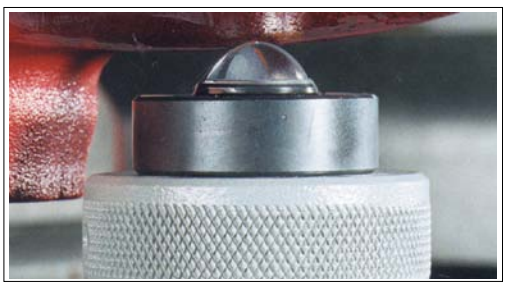
This rugged element was designed for the supporting and alignment of workpieces made of cast iron and forging-grade steels. Designed for use with AMF-screw jacks.

Advantage:

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

CAD





Subject to technical alterations.

No. 6442G

Centring plate with thread

Steel tempered, burnished.



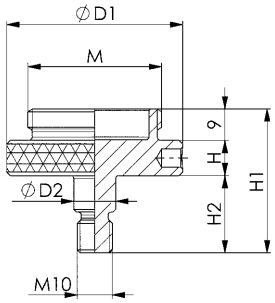
Order no.	Size	D1	D2	H	H1	H2	M	Weight [g]
562125	**M10**	50	11,9	10	41	22	M38x2	200

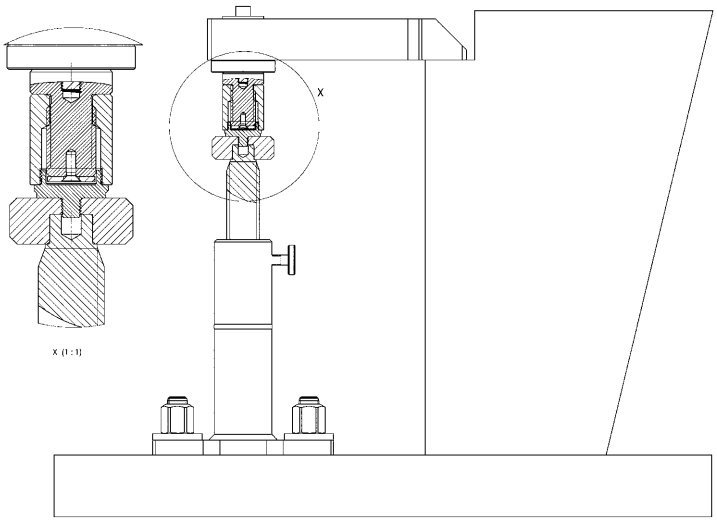
Application:

Centring plate can be screwed onto screw jacks. The screw jacks can be screwed onto the centring plate.
- Height guide bench 6415
- Screw jack with flat bearing 6400-52 /-70/-100
- Aluminium-screw jack 6401

Note:

The maximum possible support force of the screw jack combination must be adjusted to the support force (Fmax.) of the screw jack used.





CAD

Subject to technical alterations.

No. 6418

Support element, mechanical

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



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

Application:

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

Advantage:

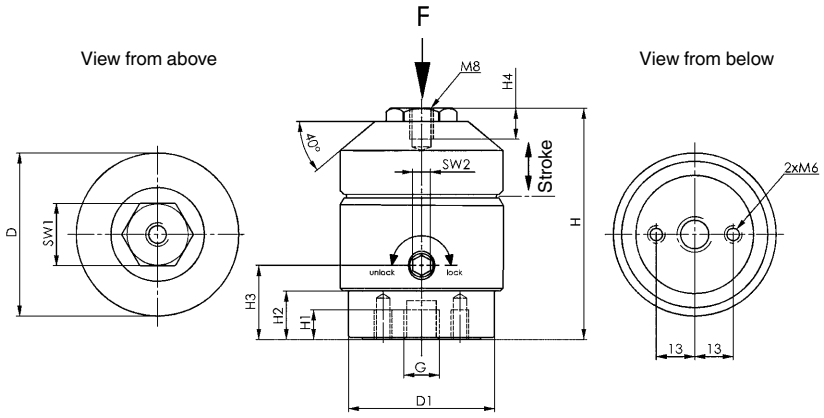
- Used as an extra support to prevent sagging and vibration of the workpiece.
- Mounted directly under a clamping point, it prevents distortion of the workpiece.
- Compensation of large workpiece tolerances (castings).

Note:

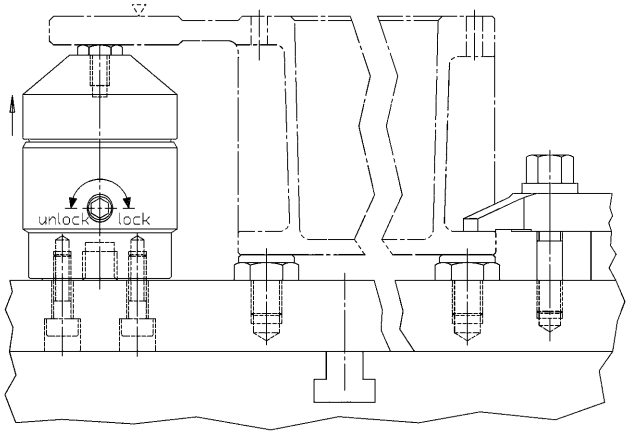
- M8 thread on supporting bolt can be mounted with pressure screws (Nos. 7110DHX, 7110DIX, 7110DKX, 7110DFX).
- Customer-specific extensions can also be mounted.
- For reliable function the M12 threaded hole must always be closed.

Dimensions:

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



Application example:



CAD

Subject to technical alterations.

No. 6417

Mandrel

blued, with brass thrust piece.

Order no.	Size	Slot	H ±0,1	H1 min.	H1 max.	H2 min.	H2 max.	dia. D1	dia. D2	dia. D3	G1	G2	SW	Weight [g]
74179	**80**	14	80	116	148	8	40	40	50	32	M12	M16	27	1270
568987	**80L**	14	80	148	180	40	72	40	50	32	M12	M16	27	1310



Application:

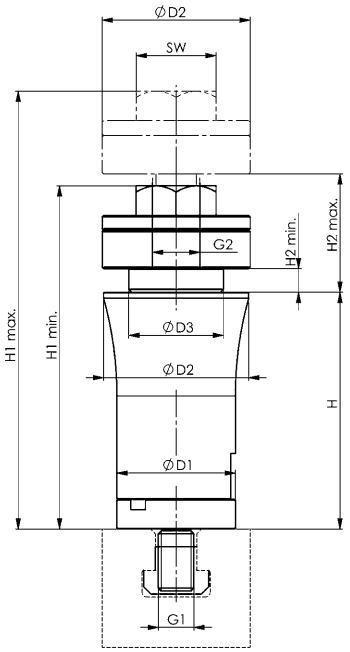
- The mandrels are fastened to the machine table by means of T-nuts.
- The mandrel is fixed on the slotted table by operating the SW 27 mm pre-tensioning nut.
- Clamping is by means of the SW 27 mm screw of tempered steel.
- Damage to the workpiece is prevented by a brass clamping ring.

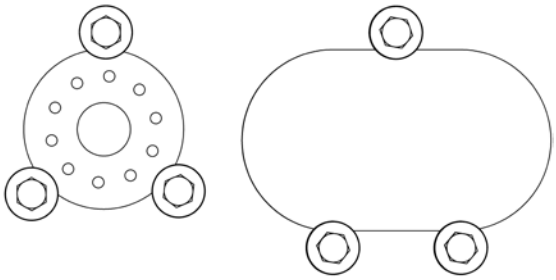
Advantage:

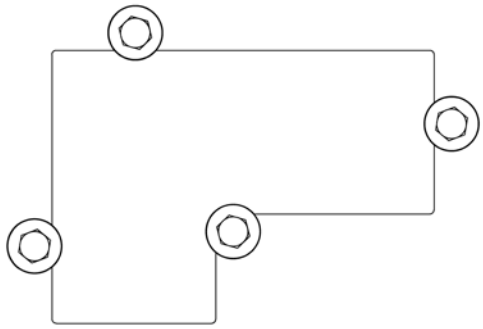
- Reduced tooling time and tool elements cuts tooling costs
- Optimal use of the machine table
- Tension on flat workpieces increased to make holes, threads and grooves

Note:

- Suitable for workpiece thicknesses from 8 to 40 mm
- Support height 80 mm
- Spacer elements of 25 mm and 50 mm are also available to increase the support height







Recommendations



No. 6417Z, page 85

CAD





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No. 6417Z

Spacer element

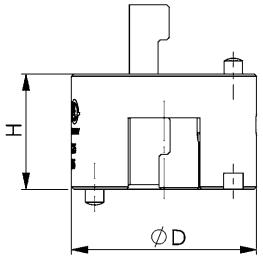
blued.

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

Application:

Used to increase the support height.





CAD

Subject to technical alterations.

No. 6419

Floating clamp

combined support and clamping,
incl. fastening for T-slots.



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

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

Application:

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

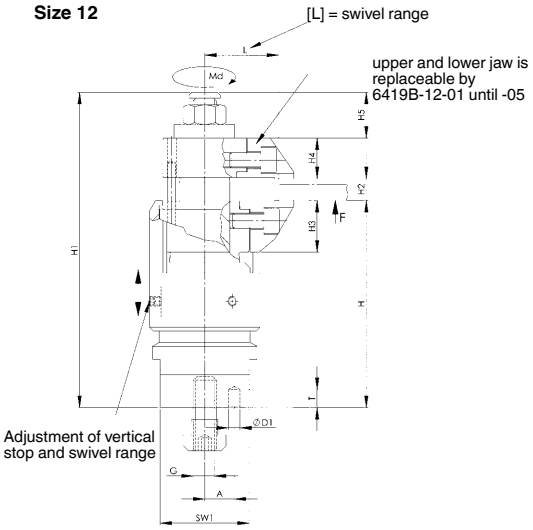
Advantage:

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

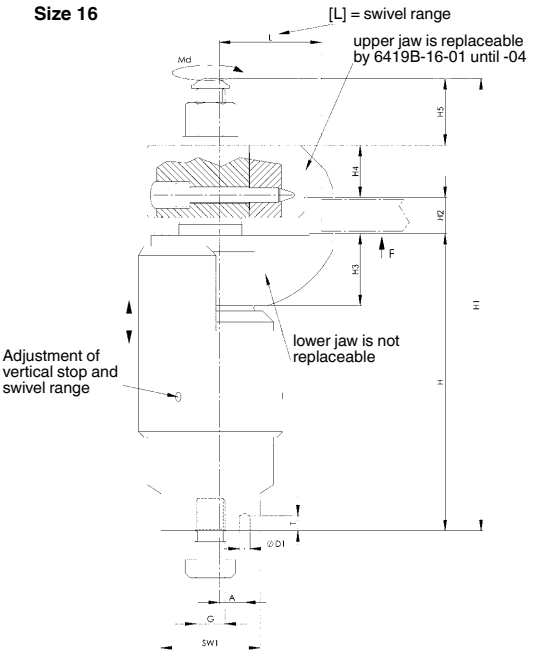
Note:

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

Size 12



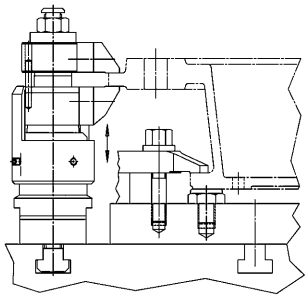
Size 16

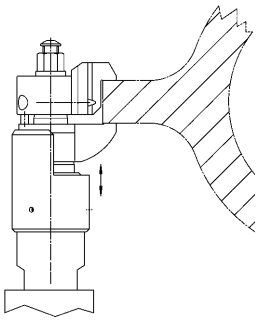


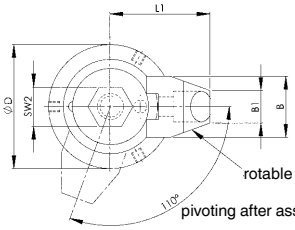
Dimensions:

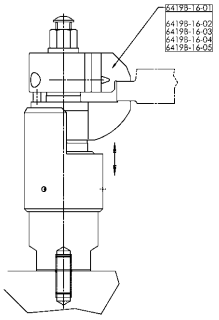
Order no.	Size	A	B	B1	D	ØD1 +0.3	H1	H3	H4	H5	L	SW2	SW1	L1	T
75754	**12**	14	28	15	57	6	163	26,8	21	32	39	18	46	46	8
75622	**16**	20	54	20	80	6	261	40,0	29	45	54	24	55	68	8

Application examples:









CAD

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No. 6419B-12-01

Clamping jaw

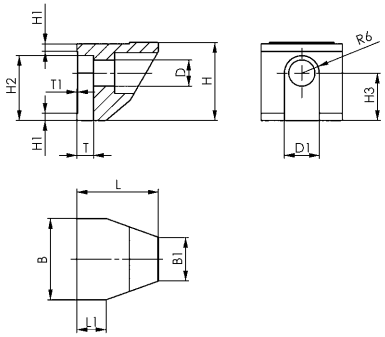
Case-hardened steel, nitrided and burnished.
Lower standard clamping jaw.

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

Note:

Fastening with ISO 4762-M8 cylinder bolts.





CAD

No. 6419B-12-02

Clamping jaw

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

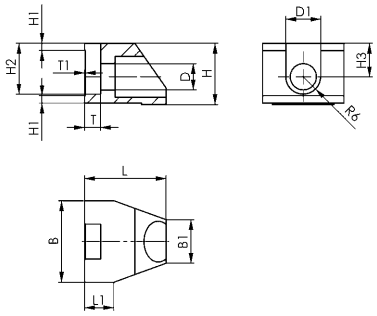
Order no.	Size	B	B1	D	D1 +0,02	H -0,1	H1	H2 -0,1	H3 ±0,1	L	L1	T +0,2	T1	Weight [g]
71605	12	28	15	9	12	21	2,5	17,5	11,5	29,5	11,5	5,5	0,2	71

Clamping range = workpiece thickness 0-12 mm.

Note:

Fastening with ISO 4762-M8 cylinder bolts.





CAD

No. 6419B-12-03

Clamping jaw

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

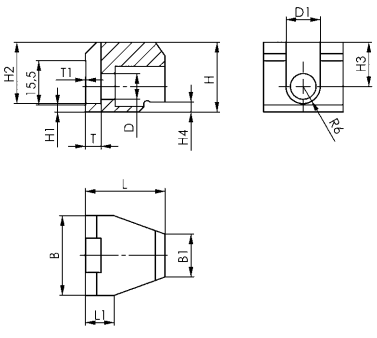
Order no.	Size	B	B1	D	D1 +0,02	H -0,1	H1	H2 -0,1	H3 ±0,1	H4	L	L1	T +0,2	T1	Weight [g]
74229	12	28	15	9	12	24,5	2,5	21,5	15,5	3,5	29,5	11,5	5,5	0,2	94

Clamping range = workpiece thickness 4-16 mm.

Note:

Fastening with ISO 4762-M8 cylinder bolts.





CAD

Subject to technical alterations.

No. 6419B-12-04

Clamping jaw

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

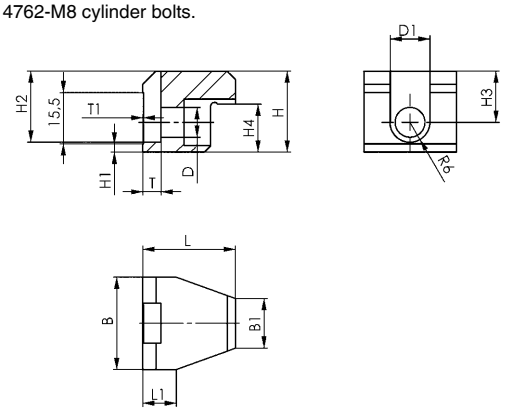
Order no.	Size	B	B1	D	D1 +0,02	H -0,1	H1	H2 -0,1	H3 ±0,1	H4	L	L1	T +0,2	T1	Weight [g]
74245	**12**	28	15	9	12	24,5	2,5	21,5	15,5	14,5	29,5	11,5	5,5	0,2	90

Clamping range = workpiece thickness 15-27 mm.

Note:

Fastening with ISO 4762-M8 cylinder bolts.





CAD

No. 6419B-12-05

Clamping jaw

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

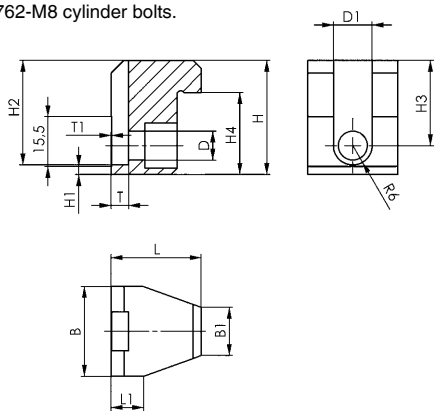
Order no.	Size	B	B1	D	D1 +0,02	H -0,1	H1	H2 -0,1	H3 ±0,1	H4	L	L1	T +0,2	T1	Weight [g]
75051	**12**	28	15	9	12	35,5	2,5	32,5	26,5	25,5	29,5	11,5	5,5	0,2	132

Clamping range = workpiece thickness 26-38 mm.

Note:

Fastening with ISO 4762-M8 cylinder bolts.





CAD

No. 6419B-16-01

Clamping jaw

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

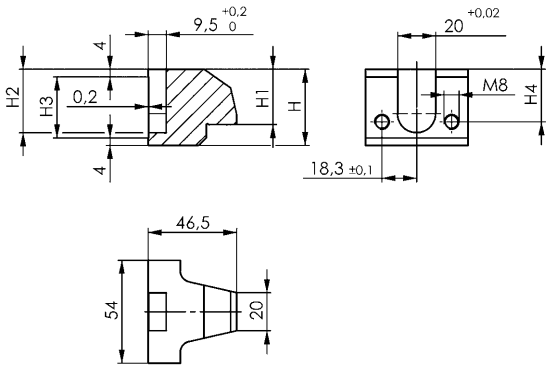
Order no.	Size	H	H1	H2	H3	H4	Weight [g]
75382	**16**	40	29	33,3	32	27,6	400

Clamping range = workpiece thickness 10-25 mm.

Note:

Fastening with ISO 4762-M8x50 cylinder bolts.





CAD

Subject to technical alterations.

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No. 6419B-16-02

Clamping jaw

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

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

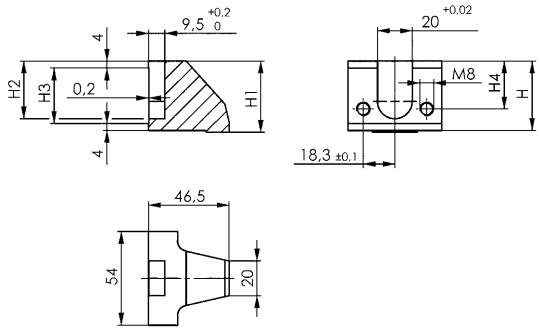
Clamping range = workpiece thickness 0-14 mm.



CAD

Note:

Fastening with ISO 4762-M8x50 cylinder bolts.



No. 6419B-16-03

Clamping jaw

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

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

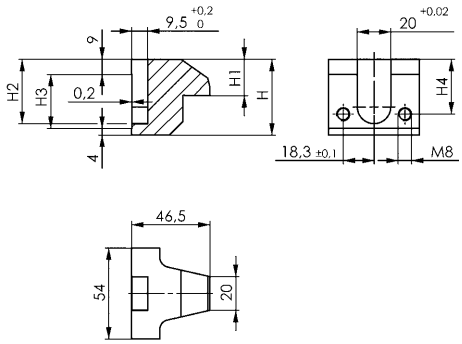
Clamping range = workpiece thickness 23-38 mm.



CAD

Note:

Fastening with ISO 4762-M8x50 cylinder bolts.



No. 6419B-16-04

Clamping jaw

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

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

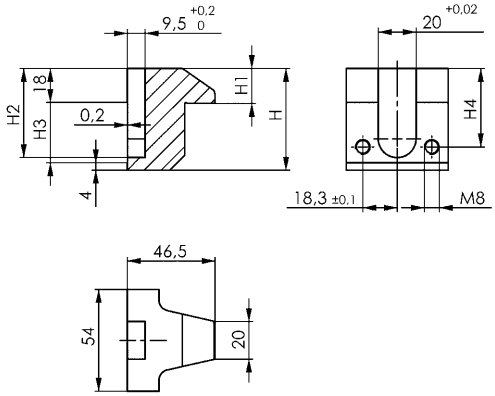
Clamping range = workpiece thickness 35-50 mm.



CAD

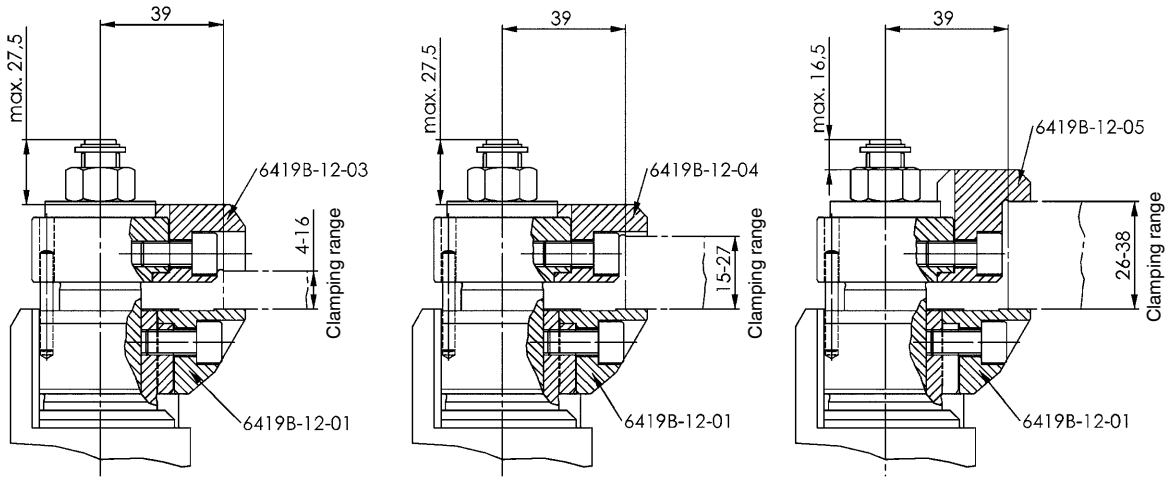
Note:

Fastening with ISO 4762-M8x50 cylinder bolts.

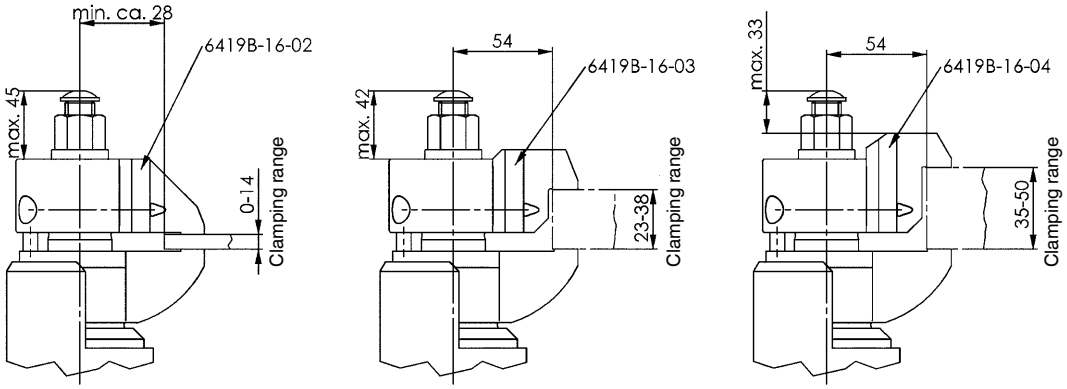


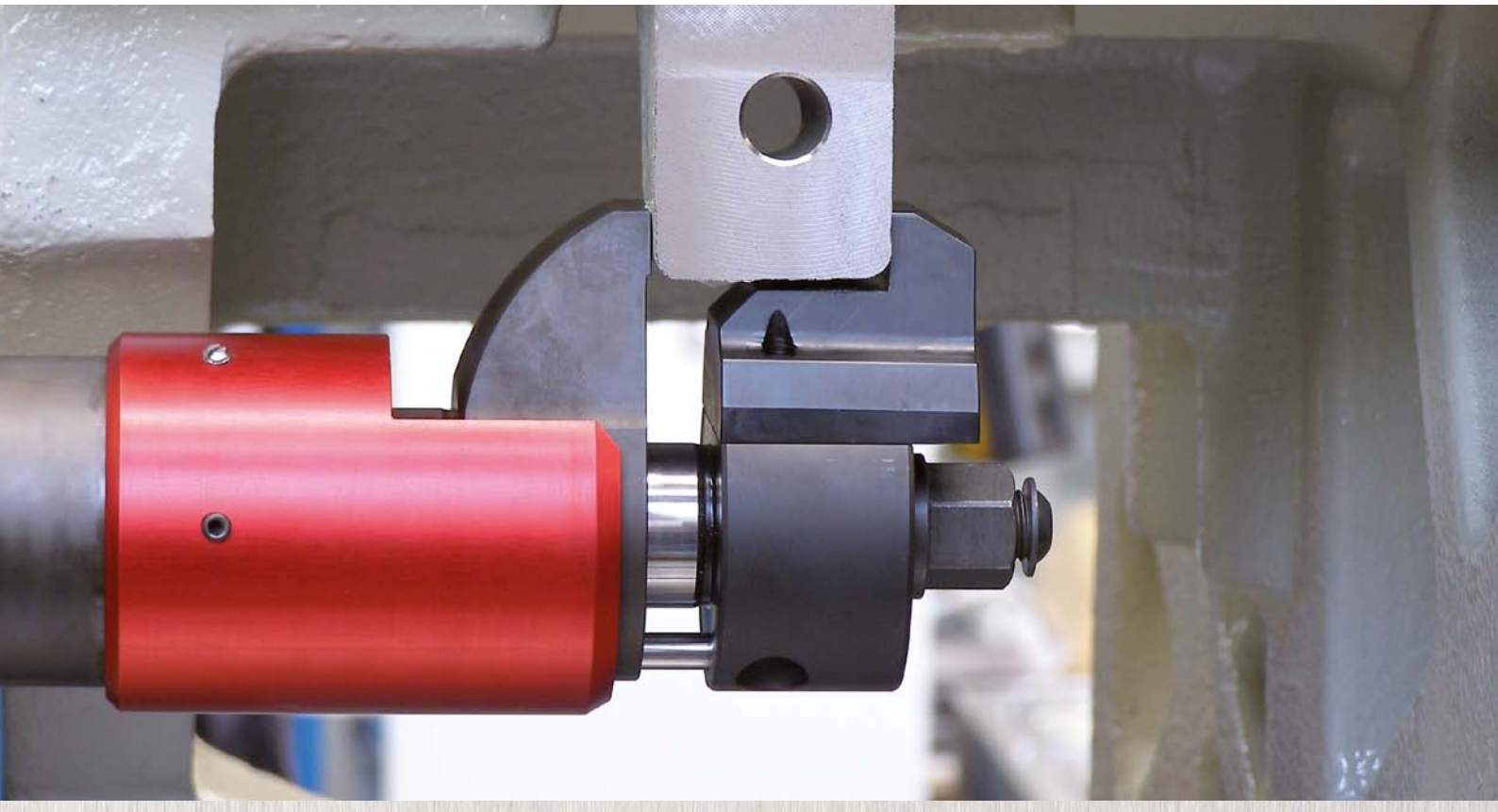
Subject to technical alterations.

Application examples clamping jaw 6419B-12



Application examples clamping jaw 6419B-16





CLAMPING BOLTS, NUTS AND WASHERS - QUALITY OF AMF

> **Material:** Tempering steel to DIN regulations within tensile strength classes 8.8, 10.9 and 12.9.

> **Machining:** All bolts and studs have rolled threads and guarantee high clamping forces and long life.

> **Tempering:** Tensile strength classes according to DIN regulations.

Bolts, T-nuts and nuts are manufactured to DIN 267 and ISO 898. By galvanizing tempered and hardened components there is a certain risk of the material getting brittle. In the event of components being subsequently galvanized we refuse all possible claims regarding breakages and damages.

There are strong reasons for demanding operators to only use AMF-clamping bolts of highest quality:

> Strict checks guarantee a consistent quality level.

> High quality clamping bolts and nuts last longer, reduce tool management and idle periods resulting in more economy in the long run.

Please notice!

The torque which can be achieved by hand can be higher than required by DIN standard for screws sizes up to 12 mm dia. Result: Only under worst conditions will the screw first of all twist and eventually break when overstressed. A small but decisive contribution to safety at the workplace.





AMF-T-SLOT BOLTS DIN 787 and No. 787
are manufactured within tensile strength classes 8.8, 10.9 and 12.9.

AMF-STUDS DIN 6379 and No. 6379
are manufactured within tensile strength classes 8.8, 10.9 and 12.9.

AMF-HEXAGON NUTS DIN 6330B, DIN 6331 and No. 6334
are manufactured within tensile strength class 10.

The individual characteristics in tensile strength classes 8.8, 10.9 and 12.9 are defined as follows:

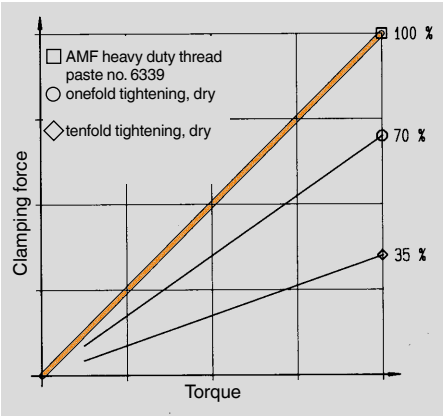
8. = minimum tensile strength = 800 N/mm²
.8 = minimum yield point (80% of min. tensile strength) = 640 N/mm²
10. = minimum tensile strength = 1000 N/mm²
.9 = minimum yield point (90% of min. tensile strength) = 900 N/mm²
12. = minimum tensile strength = 1200 N/mm²
.9 = minimum yield point (90% of min. tensile strength) = 1080 N/mm²

STRENGTH OF HEXAGON NUTS:

The individual characteristic in tensile strength class 10. defined is:
10. = minimum test strength = 1000 N/mm²
This test strength is equal to the minimum tensil strength of a screw which can be charged to its minimum breaking load, when matched with the respective nut.

A normal screw / nut combination for load transmission would be a nut of tensil strength class “8” for 8.8 screws. For manufacturing of this nut, a minor quality material than for 8.8 screws neccessary could be used, since lower tensions occur in the nut, compared with screw. But since nuts require a high wear resistance in addition to sufficient strength, we manufacture them of the same material as our 8.8-screws. This results with tensile strength class “10” for nuts.

Clamping forces depending on lubrication.



Test results revealed clearly:
Frequent use of non-greased bolt/nut connections in fixtures will reduce clamping forces consider-ably at still constant torques, with additional wear involved!

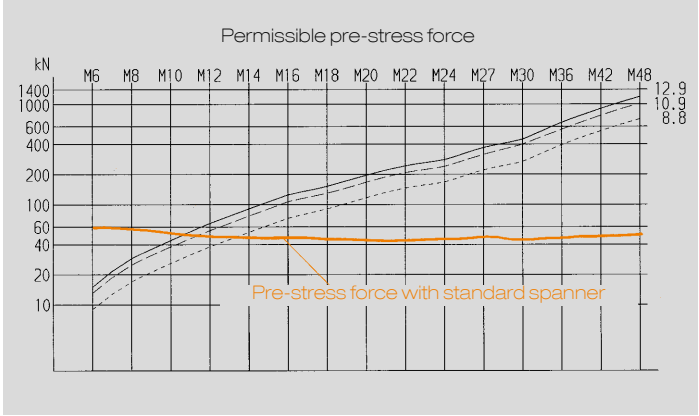
We therefore recommend the AMF-Heavy-duty thread paste no. 6339. It has a synergetic acting combination of highly active white solid lubrications and is resistant to heat and wash-off. It provides optimal sliding characteristics for increased clamping force and improved thread life.

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	Tensile strength classes			
	8.8	10.9	12.9	10
DIN 787 / No. 787 	X	X	X	-
DIN 6379 / No. 6379 	X	X	X	-
DIN 6330B DIN 6331 No. 6334 	-	-	-	X
Nominal tensile strength [N/mm²]	800	1000	1200	1000*
Minimum yield point [N/mm²]	640	900	1080	-

CHART OF PERMISSIBLE AND POSSIBLE PRE-STRESS FORCES:



* Strength figures of the right bolts

EXPLANATION OF TABLE CHARACTERISTICS:

> **PERMISSIBLE BOLT LOAD** is the maximum tension load, the screw can be stressed with talcing into account all active forces. The yield point is only utilized to 80% for safety.

> **PERMISSIBLE PRE-STRESS FORCE** is the load, the screw can be pre-stressed at most, when tightening the matching nut. Figures of table are valid for a friction of μ = 0,14 in thrust faces and thread, corresponding to the friction of greased medium faces.

> **REQUIRED LENGTH FOR LEVER OF SPANNER:** These length figures were calculated with the mean value of hand forces achieved in test series by different workmen.

STRENGTH FIGURES AND TORQUES FOR BOLTS AND NUTS:

Thread		Tensile	M6	M8	M10	M12	M14	M16	M18	M20	M22	M24	M27	M30	M36	M42	M48
Pitch of thread	mm		1	1.25	1.50	1.75	2	2	2.50	2.50	2.50	3	3	3.50	4	4.50	5
Nuts:																	
Hardness DIN6330/6331/6334	HRC	10	26 - 36													20 - 30	
Test force (AS x Sp) DIN EN ISO 898-2	kN	10	20.9	38.1	60.3	88.5	120.8	164.9	203.5	259.7	321.2	374.2	486.5	594.7	866	-	-
Nuts for T-slots DIN508/DIN508L:																	
Size			M6x8	M8x10	M10x12	M12x14	-	M16x18	-	M20x22	-	M24x28	-	M30x36	M36x42	M42x48	M48x54
Hardness	HRC		22 - 30														
Test force to DIN 508	kN		16	29	46	67	-	128	-	196	-	282	-	448	653	653	653
Bolts:																	
Hardness	HRC	8.8	22 - 32						23 - 34								
		10.9	32 - 39														
		12.9	39 -44														

PERMITTED SCREW LOADS AND TIGHTENING TORQUES:

Minimum breaking force (AS x Rm)	kN	8.8	16	29	46	67	92	125	159	203	252	293	381	466	678	930	1222
		10.9	21	38	60	88	120	163	200	255	315	367	477	583	850	1165	1531
		12.9	24	45	71	103	140	192	234	299	370	431	560	684	997	1367	1797
Permissible bolt load max. 80% of yield point	kN	8.8	10	19	30	43	59	80	101	129	160	186	242	296	431	591	777
		10.9	14	27	43	63	86	118	144	184	228	265	345	421	614	843	1107
		12.9	17	32	51	74	101	138	169	215	266	310	404	493	719	986	1296
Test force (AS x Sp) to DIN EN ISO 898, part 1	kN	8.8	12	21	34	49	67	91	115	147	182	212	275	337	490	672	882
		10.9	17	30	48	70	96	130	159	203	252	293	381	466	678	930	1222
		12.9	20	35	56	82	112	152	186	238	294	342	445	544	792	1087	1428
Permissible pre-stress force max. 90% of yield point and friction μ = 0,14	kN	8.8	9	17	26	38	53	73	91	117	146	168	221	269	394	542	714
		10.9	13	25	38	55	77	107	130	167	208	240	315	384	561	773	1018
		12.9	15	29	44	65	91	125	152	196	243	281	369	449	657	904	1191
Necessary tightening torque for permissible pre-tensioning force and a friction of μ=0.14	Nm	8.8	10	25	46	82	130	206	284	407	542	698	1021	1355	2372	3802	5730
		10.9	14	36	67	120	191	302	405	580	772	994	1455	1930	3378	5415	8162
		12.9	17	43	79	141	223	354	474	679	903	1163	1703	2258	3953	6337	9571
Required length for lever to achieve permissible pre-stress force	mm	8.8	30	67	120	205	310	479	645	900	1130	1395	-	-	-	-	-
		10.9	42	97	175	300	545	700	920	1285	1600	1980	-	-	-	-	-
		12.9	51	116	207	352	530	823	1075	1500	1880	2300	-	-	-	-	-
Combination wrench test torque in accordance with ISO 1711-1	Nm	-	58	107	175	230	330	451	594	760	884	1165	1579	2067	3140	4021	5394

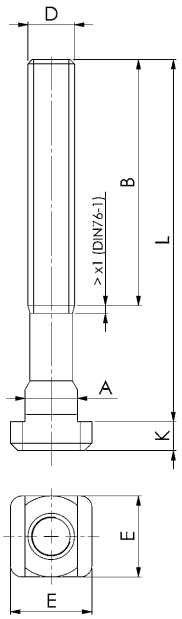
A_S = nominal cross section in mm² / S_p = min. clamping force in N/mm² / R_m = minimum tensile strength in N/mm² / μ = friction

DIN 787

Bolts for T-slots

forged, T-slot guide cleared, rolled thread, stamped with AMF logo and strength class. M6 to M12 tempered to strength class 10.9, M14 to M42 tempered to strength class 8.8.





Order no.	D x Slot x L	Strength class	A	B	E	K	Packaging Unit	Weight [g]
84004	M6x6x25	10.9	5,7	15	10	4	25	9
84012	M6x6x40	10.9	5,7	28	10	4	25	12
84038	M8x8x32	10.9	7,7	22	13	6	25	20
80374	M8x8x50	10.9	7,7	35	13	6	25	25
80382	M8x8x80	10.9	7,7	50	13	6	25	30
84046	M10x10x40	10.9	9,7	30	15	6	25	30
80390	M10x10x63	10.9	9,7	45	15	6	25	50
81323	M10x10x80 *	10.9	9,7	50	15	6	25	60
80408	M10x10x100	10.9	9,7	60	15	6	25	70
80416	M12x12x50 *	10.9	11,7	33	18	7	25	60
85605	M12x12x63 *	10.9	11,7	40	18	7	25	65
80424	M12x12x80	10.9	11,7	55	18	7	25	75
81406	M12x12x100 *	10.9	11,7	65	18	7	25	90
80432	M12x12x125	10.9	11,7	75	18	7	25	110
81497	M12x12x160 *	10.9	11,7	100	18	7	-	135
80440	M12x12x200	10.9	11,7	120	18	7	-	160
80457	M12x14x50	10.9	13,7	35	22	8	25	70
85613	M12x14x63 *	10.9	13,7	45	22	8	25	80
80465	M12x14x80	10.9	13,7	55	22	8	25	100
81851	M12x14x100 *	10.9	13,7	65	22	8	25	110
80473	M12x14x125	10.9	13,7	75	22	8	25	120
82966	M12x14x160 *	10.9	13,7	100	22	8	-	150
80481	M12x14x200	10.9	13,7	120	22	8	-	180
80499	M14x16x63 *	8.8	15,7	45	25	9	25	115
84426	M14x16x80 *	8.8	15,7	55	25	9	25	130
80507	M14x16x100 *	8.8	15,7	65	25	9	25	150
84434	M14x16x125 *	8.8	15,7	75	25	9	25	180
80515	M14x16x160 *	8.8	15,7	100	25	9	25	220
80523	M14x16x250 *	8.8	15,7	150	25	9	-	300
80531	M16x16x63 *	8.8	15,7	45	25	9	25	140
85621	M16x16x80 *	8.8	15,7	55	25	9	10	160
80549	M16x16x100 *	8.8	15,7	65	25	9	10	180
84384	M16x16x125 *	8.8	15,7	85	25	9	10	225
80556	M16x16x160 *	8.8	15,7	100	25	9	10	270
85647	M16x16x200 *	8.8	15,7	125	25	9	-	315
80564	M16x16x250 *	8.8	15,7	150	25	9	-	380
80572	M16x18x63	8.8	17,7	45	28	10	25	160
85639	M16x18x80 *	8.8	17,7	55	28	10	10	185
80580	M16x18x100	8.8	17,7	65	28	10	10	203
84400	M16x18x125 *	8.8	17,7	85	28	10	10	230
80598	M16x18x160	8.8	17,7	100	28	10	10	280
85654	M16x18x200 *	8.8	17,7	125	28	10	-	330
80606	M16x18x250	8.8	17,7	150	28	10	-	430
84103	M20x20x80 *	8.8	19,7	55	32	12	-	290
84053	M20x20x100 *	8.8	19,7	65	32	12	-	340
84111	M20x20x125 *	8.8	19,7	85	32	12	-	390
85662	M20x20x160 *	8.8	19,7	110	32	12	-	470
84129	M20x20x200 *	8.8	19,7	125	32	12	-	550
84079	M20x20x250 *	8.8	19,7	150	32	12	-	670
84137	M20x20x315 *	8.8	19,7	190	32	12	-	800
80614	M20x22x80	8.8	21,7	55	35	14	-	330
85829	M20x22x100 *	8.8	21,7	65	35	14	-	370
80622	M20x22x125	8.8	21,7	85	35	14	-	428
85670	M20x22x160 *	8.8	21,7	110	35	14	-	500
80630	M20x22x200	8.8	21,7	125	35	14	-	570
85845	M20x22x250 *	8.8	21,7	150	35	14	-	680
80648	M20x22x315	8.8	21,7	190	35	14	-	820
80770	M24x24x100 *	8.8	23,7	70	40	16	-	540
85688	M24x24x125 *	8.8	23,7	85	40	16	-	600
80788	M24x24x160 *	8.8	23,7	110	40	16	-	770
85704	M24x24x200 *	8.8	23,7	125	40	16	-	900
80796	M24x24x250 *	8.8	23,7	150	40	16	-	960
84061	M24x24x315 *	8.8	23,7	190	40	16	-	1270
80804	M24x24x400 *	8.8	23,7	240	40	16	-	1410
80655	M24x28x100	8.8	27,7	70	44	18	-	650
85696	M24x28x125 *	8.8	27,7	85	44	18	-	720
80663	M24x28x160	8.8	27,7	110	44	18	-	800
85712	M24x28x200 *	8.8	27,7	125	44	18	-	950
80671	M24x28x250	8.8	27,7	150	44	18	-	1120

Recommendations



DIN 6331, page 108



DIN 6340, page 113

Subject to technical alterations.

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DIN 787

Bolts for T-slots

forged, T-slot guide cleared, rolled thread, stamped with AMF logo and strength class. M6 to M12 tempered to strength class 10.9, M14 to M42 tempered to strength class 8.8.

Order no.	D x Slot x L	Strength class	A	B	E	K	Packaging Unit	Weight [g]
84087	**M24x28x315 ***	8.8	27,7	190	44	18	-	1350
80689	**M24x28x400 ***	8.8	27,7	240	44	18	-	1490
87643	**M27x32x160 ***	8.8	31,6	100	50	20	-	1168
87783	**M27x32x200 ***	8.8	31,6	135	50	20	-	1345
80697	**M30x36x125**	8.8	35,6	80	54	22	-	1250
85720	**M30x36x160 ***	8.8	35,6	110	54	22	-	1440
80705	**M30x36x200**	8.8	35,6	135	54	22	-	1630
85738	**M30x36x250 ***	8.8	35,6	150	54	22	-	1920
80713	**M30x36x315**	8.8	35,6	200	54	22	-	2100
80721	**M30x36x500**	8.8	35,6	300	54	22	-	3300
80739	**M36x42x160**	8.8	41,6	100	65	26	-	2200
80747	**M36x42x250**	8.8	41,6	175	65	26	-	2820
80754	**M36x42x400**	8.8	41,6	250	65	26	-	3930
84152	**M42x48x250**	8.8	47,6	175	75	30	-	4300
84160	**M42x48x400**	8.8	47,6	250	75	30	-	5800

* Size not included in DIN, dimensions similar to DIN

Advantage:

Benefits of thread rolling:
- no interrupted fibre orientation
- reduced notch sensitivity
- very good roughness values on the thread flanks and in the base radius

CAD

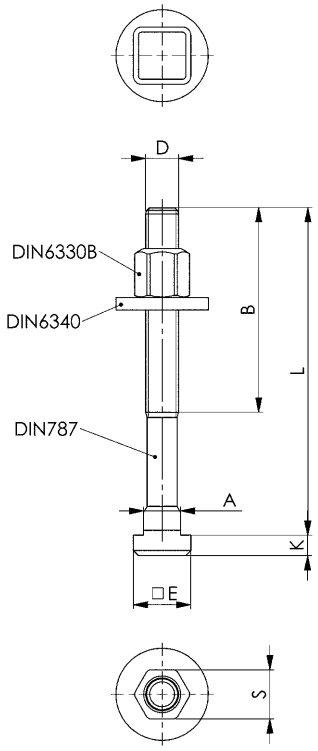
Subject to technical alterations.

No. 787

Bolts for T-slots, complete

with DIN 787 screws for T-slots, hexagon nut DIN 6330B and washer DIN 6340.
Forged, T-slot guide cleared, rolled thread, stamped with AMF logo and strength class. M6 to M12 tempered to strength class 10.9, M14 to M42 tempered to strength class 8.8.





Order no.	D x Slot x L	Strength class	A	B	E	K	S	Weight [g]
84202	M6x6x25	10.9	5,7	15	10	4	10	19
84210	M6x6x40	10.9	5,7	28	10	4	10	22
84236	M8x8x32	10.9	7,7	22	13	6	13	40
80812	M8x8x50	10.9	7,7	35	13	6	13	45
80820	M8x8x80	10.9	7,7	50	13	6	13	55
84244	M10x10x40	10.9	9,7	30	15	6	16	65
80838	M10x10x63	10.9	9,7	45	15	6	16	80
81356	M10x10x80	10.9	9,7	50	15	6	16	90
80846	M10x10x100	10.9	9,7	60	15	6	16	110
80853	M12x12x50	10.9	11,7	35	18	7	18	120
85746	M12x12x63	10.9	11,7	40	18	7	18	128
80861	M12x12x80	10.9	11,7	55	18	7	18	130
81448	M12x12x100	10.9	11,7	65	18	7	18	145
80879	M12x12x125	10.9	11,7	75	18	7	18	170
81505	M12x12x160	10.9	11,7	100	18	7	18	195
80887	M12x12x200	10.9	11,7	120	18	7	18	220
80895	M12x14x50	10.9	13,7	35	22	8	18	130
85753	M12x14x63	10.9	13,7	45	22	8	18	145
80903	M12x14x80	10.9	13,7	55	22	8	18	155
82974	M12x14x100	10.9	13,7	65	22	8	18	165
80911	M12x14x125	10.9	13,7	75	22	8	18	180
84376	M12x14x160	10.9	13,7	100	22	8	18	210
80929	M12x14x200	10.9	13,7	120	22	8	18	240
80937	M14x16x63	8.8	15,7	45	25	9	21	200
84442	M14x16x80	8.8	15,7	55	25	9	21	220
80945	M14x16x100	8.8	15,7	65	25	9	21	230
84459	M14x16x125	8.8	15,7	75	25	9	21	280
80952	M14x16x160	8.8	15,7	100	25	9	21	310
80960	M14x16x250	8.8	15,7	120	25	9	21	390
80978	M16x16x63	8.8	15,7	45	25	9	24	250
85761	M16x16x80	8.8	15,7	55	25	9	24	275
80986	M16x16x100	8.8	15,7	65	25	9	24	290
84392	M16x16x125	8.8	15,7	85	25	9	24	300
80994	M16x16x160	8.8	15,7	100	25	9	24	380
85779	M16x16x200	8.8	15,7	125	25	9	24	435
81000	M16x16x250	8.8	15,7	150	25	9	24	530
81018	M16x18x63	8.8	17,7	45	28	10	24	260
85787	M16x18x80	8.8	17,7	55	28	10	24	305
81026	M16x18x100	8.8	17,7	65	28	10	24	315
84418	M16x18x125	8.8	17,7	85	28	10	24	360
81034	M16x18x160	8.8	17,7	100	28	10	24	400
85795	M16x18x200	8.8	17,7	125	28	10	24	448
81042	M16x18x250	8.8	17,7	150	28	10	24	560
84301	M20x20x80	8.8	19,7	55	32	12	30	520
81547	M20x20x100	8.8	19,7	65	32	12	30	570
84319	M20x20x125	8.8	19,7	85	32	12	30	600
85803	M20x20x160	8.8	19,7	110	32	12	30	680
84327	M20x20x200	8.8	19,7	125	32	12	30	750
81562	M20x20x250	8.8	19,7	150	32	12	30	800
84335	M20x20x315	8.8	19,7	190	32	12	30	940
81059	M20x22x80	8.8	21,7	55	35	14	30	530
85837	M20x22x100	8.8	21,7	65	35	14	30	610
81067	M20x22x125	8.8	21,7	85	35	14	30	670
85811	M20x22x160	8.8	21,7	110	35	14	30	710
81075	M20x22x200	8.8	21,7	125	35	14	30	750
85852	M20x22x250	8.8	21,7	150	35	14	30	850
81083	M20x22x315	8.8	21,7	190	35	14	30	980
81216	M24x24x100	8.8	23,7	70	40	16	36	910
85860	M24x24x125	8.8	23,7	85	40	16	36	970
81224	M24x24x160	8.8	23,7	110	40	16	36	1040
85878	M24x24x200	8.8	23,7	125	40	16	36	1265
81232	M24x24x250	8.8	23,7	150	40	16	36	1410
81588	M24x24x315	8.8	23,7	190	40	16	36	1640
81240	M24x24x400	8.8	23,7	240	40	16	36	1780
81091	M24x28x100	8.8	27,7	70	44	18	36	980
85886	M24x28x125	8.8	27,7	85	44	18	36	1010
81109	M24x28x160	8.8	27,7	110	44	18	36	1150
85894	M24x28x200	8.8	27,7	125	44	18	36	1240
81117	M24x28x250	8.8	27,7	150	44	18	36	1500

Subject to technical alterations.

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No. 787

Bolts for T-slots, complete

with DIN 787 screws for T-slots, hexagon nut DIN 6330B and washer DIN 6340.
Forged, T-slot guide cleared, rolled thread, stamped with AMF logo and strength class. M6 to M12 tempered to strength class 10.9, M14 to M42 tempered to strength class 8.8.

Order no.	D x Slot x L	Strength class	A	B	E	K	S	Weight [g]
81604	**M24x28x315**	8.8	27,7	190	44	18	36	1730
81125	**M24x28x400**	8.8	27,7	240	44	18	36	1860
81133	**M30x36x125**	8.8	35,6	80	54	22	46	1860
85902	**M30x36x160**	8.8	35,6	110	54	22	46	1950
81141	**M30x36x200**	8.8	35,6	135	54	22	46	2230
85910	**M30x36x250**	8.8	35,6	150	54	22	46	2555
81158	**M30x36x315**	8.8	35,6	200	54	22	46	2950
81166	**M30x36x500**	8.8	35,6	300	54	22	46	3950
81174	**M36x42x160**	8.8	41,6	100	65	26	55	3220
81182	**M36x42x250**	8.8	41,6	175	65	26	55	3840
81190	**M36x42x400**	8.8	41,6	250	65	26	55	4950
84186	**M42x48x250**	8.8	47,6	175	75	30	65	6900
84194	**M42x48x400**	8.8	47,6	250	75	30	65	8400

Advantage:

Benefits of thread rolling:
- no interrupted fibre orientation
- reduced notch sensitivity
- very good roughness values on the thread flanks and in the base radius

Note:

AMF quality starts with controlled raw material!
Our fully-automated forging plant produces clamping screws. Once cleared, the thread is rolled.



CAD

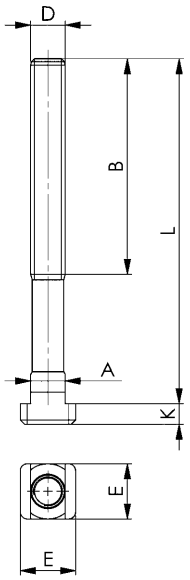
Subject to technical alterations.

No. 787

Screws for T-slot, strength class 12.9

Forged, T-slot guid-faces broached, rolled. Thread, tempered. Strenght class punched into head.





Order no.	D x Slot x L	A	B	E	K	Packaging Unit	Weight [g]
83956	M10x10x40	9,7	30	15	6	25	30
83972	M10x10x50	9,7	35	15	6	25	40
83998	M10x10x80	9,7	50	15	6	25	60
83923	M10x10x100	9,7	60	15	6	25	70
86140	M12x12x50	11,7	35	18	7	25	60
86231	M12x12x63	11,7	40	18	7	25	65
86157	M12x12x80	11,7	55	18	7	25	75
86256	M12x12x100	11,7	65	18	7	25	90
86165	M12x12x125	11,7	75	18	7	25	110
87304	M12x12x160	11,7	100	18	7	-	135
86173	M12x12x200	11,7	120	18	7	-	160
86181	M12x14x50	13,7	35	22	8	25	70
86611	M12x14x63	13,7	45	22	8	25	80
86199	M12x14x80	13,7	55	22	8	25	100
86678	M12x14x100	13,7	65	22	8	25	110
86207	M12x14x125	13,7	75	22	8	25	120
87320	M12x14x160	13,7	100	22	8	-	150
86215	M12x14x200	13,7	120	22	8	-	180
86264	M16x16x63	15,7	45	25	9	25	140
87346	M16x16x80	15,7	55	25	9	10	160
86272	M16x16x100	15,7	65	25	9	10	180
87361	M16x16x125	15,7	85	25	9	10	225
86280	M16x16x160	15,7	100	25	9	10	270
86298	M16x16x250	15,7	150	25	9	-	380
86306	M16x18x63	17,7	45	28	10	25	160
86629	M16x18x80	17,7	55	28	10	10	185
86314	M16x18x100	17,7	65	28	10	10	203
86645	M16x18x125	17,7	85	28	10	10	230
86322	M16x18x160	17,7	100	28	10	10	280
87403	M16x18x200	17,7	125	28	10	-	330
86330	M16x18x250	17,7	150	28	10	-	430
86421	M20x20x80	19,7	55	32	12	-	290
86439	M20x20x125	19,7	85	32	12	-	390
87429	M20x20x160	19,7	110	32	12	-	470
86447	M20x20x200	19,7	125	32	12	-	550
87437	M20x20x250	19,7	150	32	12	-	670
86454	M20x20x315	19,7	190	32	12	-	800
86348	M20x22x80	21,7	55	35	14	-	330
86355	M20x22x125	21,7	85	35	14	-	428
87445	M20x22x160	21,7	110	35	14	-	500
86363	M20x22x200	21,7	125	35	14	-	570
87510	M20x22x250	21,7	150	35	14	-	680
86371	M20x22x315	21,7	190	35	14	-	820
86462	M24x24x100	23,7	70	40	16	-	540
86470	M24x24x160	23,7	110	40	16	-	770
87577	M24x24x200	23,7	125	40	16	-	900
86488	M24x24x250	23,7	150	40	16	-	960
86496	M24x24x400	23,7	240	40	16	-	1410
86389	M24x28x100	27,7	70	44	18	-	650
86397	M24x28x160	27,7	110	44	18	-	800
87585	M24x28x200	27,7	125	44	18	-	950
86405	M24x28x250	27,7	150	44	18	-	1120
86413	M24x28x400	27,7	240	44	18	-	1490
81281	M30x36x160	35,6	110	54	22	-	1950
81364	M30x36x200	35,6	135	54	22	-	2230
81463	M30x36x250	35,6	150	54	22	-	2555

Advantage:

- higher strength class compared to DIN 787

Benefits of thread rolling:
- no interrupted fibre orientation
- reduced notch sensitivity
- very good roughness values on the thread flanks and in the base radius

Recommendations



DIN 6330B, page 107



DIN 6340, page 113

CAD

Subject to technical alterations.

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No. 797

Rhombus-head screws for T-slots

forged, T-slots milled, rolled thread, heat-treated.



Order no.	D x Slot x L	Strength class	A	B	E	K	Weight [g]
87296	M12x14x 50	8.8	13,7	35	22	8	70
87312	M12x14x 80	8.8	13,7	55	22	8	100
87338	M12x14x125	8.8	13,7	75	22	8	120
87353	M16x18x 63	8.8	17,7	45	28	10	160
87379	M16x18x100	8.8	17,7	65	28	10	220
87395	M16x18x160	8.8	17,7	100	28	10	280
86793	M20x22x 80	8.8	21,7	55	35	14	330
86801	M20x22x125	8.8	21,7	85	35	14	430
86819	M20x22x200	8.8	21,7	120	35	14	570
86959	M24x28x125	8.8	27,7	85	44	18	770
87114	M24x28x250	8.8	27,7	150	44	18	1120

Application:

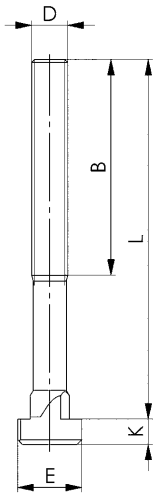
- additional setup of a clamping point for a previously clamped fixture
- subsequent setup of a clamping point for previously occupied machine table T-slot
- Insertion of the rhombus-head screw from above into the T-slot and turning up to the stop in the T-slot
- This is also possible with the combination of rhombus-head screw no. 510 and stud DIN 6379

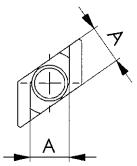
Advantage:

Benefits of thread rolling:
- no interrupted fibre orientation
- reduced notch sensitivity
- very good roughness values on the thread flanks and in the base radius

Note:

Owing to the reduced contact surface in the T-slot, the max. permissible screw load capacity corresponds to the values for strength class 8.8.
Matching nuts DIN 6330B and washers DIN 6340.





Recommendations



DIN 6331, page 108



DIN 6340, page 113



CAD

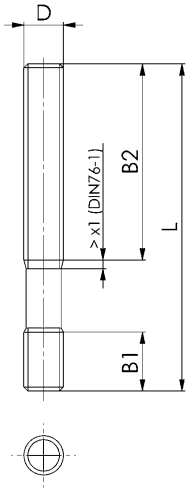
Subject to technical alterations.

DIN 6379

Studs for nuts and T-slots

Rolled thread. M 6-M12 tempered to strength class 10.9,
M14-M42 tempered to strength class 8.8.





Order no.	D x L	Strength class	B1	B2	Packaging Unit	Weight [g]
84772	M 6x 32 *	10.9	9	16	50	8
86546	M 6x 40 *	10.9	9	20	50	9
84780	M 6x 50	10.9	9	30	50	11
85522	M 6x 63 *	10.9	9	40	50	14
84798	M 6x 80	10.9	9	50	50	18
81257	M 8x 40	10.9	11	20	100	10
84806	M 8x 63	10.9	11	40	50	20
81273	M 8x 80 *	10.9	11	50	50	25
84814	M 8x100	10.9	11	63	50	30
84756	M 8x125 *	10.9	11	75	50	36
84822	M 8x160 *	10.9	11	100	50	45
81299	M10x 50	10.9	13	25	50	25
84830	M10x 80	10.9	13	50	50	40
86041	M10x100 *	10.9	13	75	50	50
81315	M10x125	10.9	13	75	25	62
85928	M10x160 *	10.9	13	100	50	80
84848	M10x200	10.9	13	125	-	100
84855	M12x 50	10.9	15	25	25	37
81331	M12x 63 *	10.9	15	32	25	45
84863	M12x 80	10.9	15	50	50	55
81349	M12x100 *	10.9	15	63	50	70
84871	M12x125	10.9	15	75	25	90
85480	M12x160 *	10.9	15	100	25	113
84889	M12x200 *	10.9	15	125	-	140
81372	M14x 63 *	8.8	17	32	25	80
84467	M14x80 *	8.8	17	50	25	85
81380	M14x100 *	8.8	17	63	25	90
84475	M14x125 *	8.8	17	75	25	120
81398	M14x160 *	8.8	17	100	25	150
86553	M14x200 *	8.8	17	125	-	195
84897	M14x250 *	8.8	17	160	-	240
84905	M16x 63	8.8	19	32	25	85
81414	M16x 80 *	8.8	19	50	25	105
84913	M16x100	8.8	19	63	25	130
81422	M16x125 *	8.8	19	75	25	160
84921	M16x160	8.8	19	100	25	218
85498	M16x200 *	8.8	19	125	-	280
84939	M16x250	8.8	19	160	-	325
85548	M16x315 *	8.8	19	190	-	425
85472	M16x500 *	8.8	19	315	-	650
84947	M18x 80 *	8.8	23	50	25	130
84954	M18x125 *	8.8	23	75	25	200
86561	M18x160 *	8.8	23	100	-	255
81471	M18x200 *	8.8	23	125	-	320
81489	M18x250 *	8.8	23	150	-	400
84962	M18x315 *	8.8	23	180	-	500
84970	M20x 80	8.8	27	32	-	185
84988	M20x125	8.8	27	70	-	255
85506	M20x160 *	8.8	27	100	-	330
81513	M20x200	8.8	27	125	-	410
81521	M20x250 *	8.8	27	160	-	510
84996	M20x315	8.8	27	190	-	640
85977	M20x400 *	8.8	27	250	-	815
85001	M20x500 *	8.8	27	315	-	1020
85019	M22x100 *	8.8	31	45	-	270
81539	M22x160 *	8.8	31	100	-	430
86579	M22x200 *	8.8	31	125	-	500
86595	M22x315 *	8.8	31	190	-	790
85027	M22x400 *	8.8	31	250	-	1070
85035	M24x100	8.8	35	45	-	290
85563	M24x125 *	8.8	35	70	-	380
81570	M24x160	8.8	35	100	-	470
85514	M24x200 *	8.8	35	125	-	580
81596	M24x250	8.8	35	160	-	730
86009	M24x315 *	8.8	35	190	-	920
85043	M24x400	8.8	35	250	-	1160
86025	M24x500 *	8.8	35	315	-	1460
85050	M24x630 *	8.8	35	315	-	1860
81695	M27x125 *	8.8	39	56	-	485

Recommendations



DIN 6331,
page 108



DIN 6340,
page 113



DIN 508,
page 104

Subject to technical alterations.

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DIN 6379

Studs for nuts and T-slots

Rolled thread. M 6-M12 tempered to strength class 10.9, M14-M42 tempered to strength class 8.8.

Order no.	D x L	Strength class	B1	B2	Packaging Unit	Weight [g]
81703	M27x200 *	8.8	39	125	-	770
81711	M27x315 *	8.8	39	190	-	1110
86587	M27x400 *	8.8	39	250	-	1535
85068	M30x125	8.8	43	56	-	590
81612	M30x200 *	8.8	43	125	-	950
81620	M30x315	8.8	43	190	-	1490
81638	M30x500	8.8	43	315	-	2360
81646	M30x700 *	8.8	43	400	-	3300
81661	M30x1000 *	8.8	43	400	-	4700
85076	M36x160	8.8	51	80	-	1100
81653	M36x200 *	8.8	51	125	-	1340
85084	M36x250	8.8	51	160	-	1710
85555	M36x315 *	8.8	51	190	-	2150
85092	M36x400	8.8	51	250	-	2700
81679	M36x500 *	8.8	51	315	-	3450
85589	M42x315 *	8.8	59	190	-	2950

* Size not included in DIN, dimensions similar to DIN

Advantage:

Benefits of thread rolling:
- no interrupted fibre orientation
- reduced notch sensitivity
- very good roughness values on the thread flanks and in the base radius



CAD

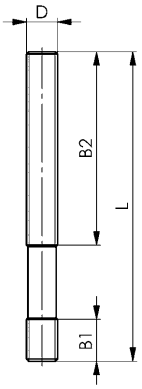
Subject to technical alterations.

No. 6379

Studs for nuts and T-slots, strength class 12.9

Steel, tempered, rolled thread.





Order no.	D x L	B1	B2	Packaging Unit	Weight [g]
82123	M12x 80	15	50	50	55
89193	M12x100	15	63	25	70
89250	M12x125	15	75	25	90
89276	M12x160	15	100	25	113
82180	M16x 80	19	50	25	105
82263	M16x100	19	63	25	130
85571	M16x125	19	75	25	160
87734	M16x160	19	100	25	218
87759	M16x200	19	125	-	280
87791	M16x250	19	160	-	325
87668	M20x125	27	70	-	255
87684	M20x160	27	100	-	330
87700	M20x200	27	125	-	410
87742	M20x250	27	160	-	510
87833	M20x315	27	190	-	640
87692	M20x500	27	315	-	1020
88286	M24x160	35	100	-	470
88930	M24x200	35	125	50	580
89094	M24x250	35	160	-	730
89136	M24x315	35	200	-	920
89151	M24x400	35	250	-	1160
89177	M24x500	35	315	-	1460

Advantage:

- higher strength class compared to IN 6379

Benefits of thread rolling:
- no interrupted fibre orientation
- reduced notch sensitivity
- very good roughness values on the thread flanks and in the base radius

Recommendations



DIN 6331, page 108



DIN 6340, page 113



DIN 508, page 104

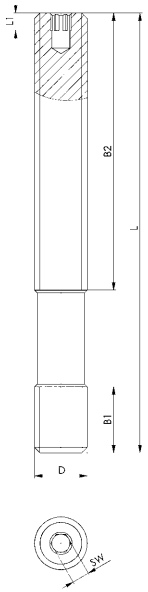
CAD

No. 6379I

Studs with hexagon socket, strength class 12.9

Steel, tempered, rolled thread.





Order no.	D x L	Strength class	B1	B2	L1	SW	Weight [g]
381954	M12x100	12.9	15	63	4	4	70
381913	M12x125	12.9	15	75	4	4	90
381970	M12x160	12.9	15	100	4	4	113
381996	M16x125	12.9	19	75	4	4	160
381939	M16x160	12.9	19	100	4	4	218
382010	M16x200	12.9	19	125	4	4	280
382028	M20x160	12.9	27	100	5	5	330
382036	M20x200	12.9	27	125	5	5	410
382044	M20x250	12.9	27	160	5	5	510
382051	M24x200	12.9	35	125	5	5	580
382069	M24x250	12.9	35	160	5	5	730

Application:

- For use in all areas of cutting and non-cutting production
- particularly suitable for use on injection moulding machines and presses

Advantage:

- fast loosening or tightening by additional hexagon socket
- variable and fast adjustment options at a distance from the workpiece
- higher strength class compared to IN 6379

Benefits of thread rolling:
- no interrupted fibre orientation
- reduced notch sensitivity
- very good roughness values on the thread flanks and in the base radius

Note:

The nuts DIN 6330B, strength class 10 and washers DIN 6340 must be used in combination with this threaded pin.

Recommendations

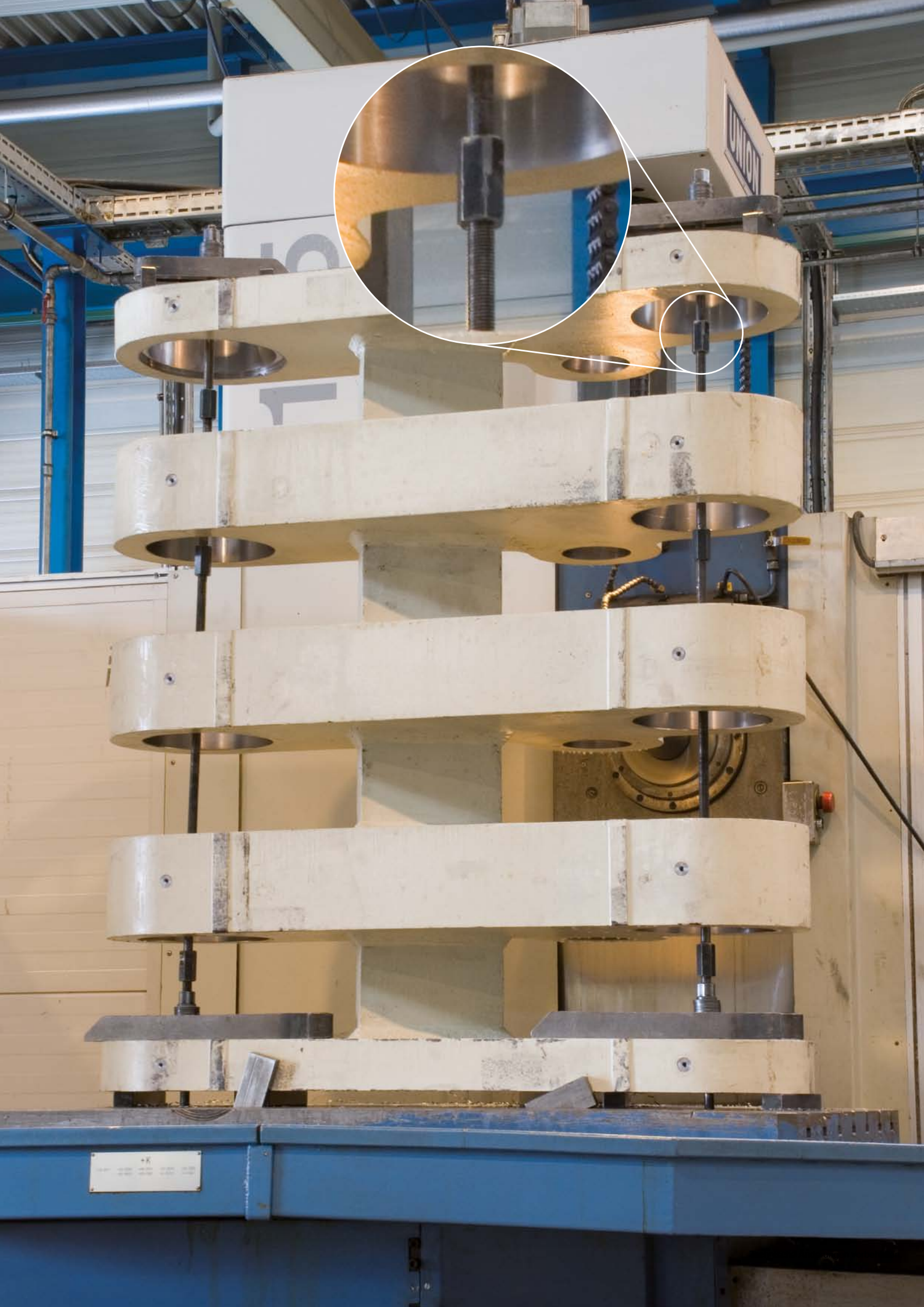


ISO 2936C

CAD

Subject to technical alterations.

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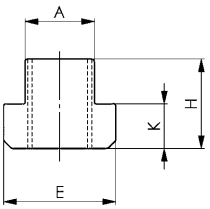


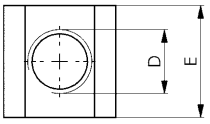
DIN 508

Nuts for T-slots (T-nuts)

tempered, grade 10.







Order no.	D x Slot	Test force [kN]	A	E	H	K	Packaging Unit	Weight [g]
80002	M 5x 6	11,4	5,7	10	8	4	50	4
80010	M 6x 8	16,0	7,7	13	10	6	100	9
80028	M 8x10	29,0	9,7	15	12	6	100	12
140301	M 8x12*	29,0	11,7	18	14	7	50	22
140327	M 8x14*	29,0	13,7	22	16	8	50	41
153460	M 8x16*	29,0	15,7	25	18	9	25	50
153478	M 8x18*	29,0	17,7	28	20	10	25	91
80036	M10x12	46,0	11,7	18	14	7	50	22
80234	M10x14*	46,0	13,7	22	16	8	50	37
80366	M10x16*	46,0	15,7	25	18	9	25	60
81265	M10x18*	46,0	17,7	28	20	10	25	87
80044	M12x14	67,0	13,7	22	16	8	50	35
80168	M12x16*	67,0	15,7	25	18	9	25	50
158907	M12x18*	67,0	17,7	28	20	10	25	82
80051	M14x16*	-	15,7	25	18	9	25	50
80176	M14x18*	-	17,7	28	20	10	25	70
80069	M16x18	128,0	17,7	28	20	10	50	70
80184	M16x20*	128,0	19,7	32	24	12	25	110
155630	M16x22*	128,0	21,7	35	28	14	25	176
159418	M16x24*	128,0	23,7	40	32	16	10	260
159426	M16x28*	128,0	27,7	44	36	18	-	383
80077	M18x20*	-	19,7	32	24	12	25	110
80242	M18x22*	-	21,7	35	28	14	10	163
80085	M20x22	196,0	21,7	35	28	14	25	155
80192	M20x24*	196,0	23,7	40	32	16	10	235
158899	M20x28*	196,0	27,7	44	36	18	-	355
80093	M22x24*	-	23,7	40	32	16	10	220
80358	M22x28*	-	27,7	44	36	18	10	340
80101	M24x28	282,0	27,7	44	36	18	-	322
80200	M24x30*	282,0	29,7	48	38	19	-	440
80218	M24x36*	282,0	35,6	54	44	22	-	700
80119	M27x32*	-	31,6	50	40	20	-	460
80127	M30x36	448,0	35,6	54	44	22	-	590
80226	M30x42*	448,0	41,6	65	52	26	-	1150
80135	M36x42	653,0	41,6	65	52	26	-	1010
80143	M42x48	653,0	47,6	75	60	30	-	1600
80150	M48x54	653,0	53,6	85	70	34	-	2300

* Size not included in DIN, dimensions similar to DIN

Note:

The full load capacity can only be achieved if the screw connection is applied over the entire length „H“ of the thread.
For test force see DIN 508

On request:

Special makes on request.

Recommendations



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DIN 6331, page 108



DIN 6340, page 113

CAD

Subject to technical alterations.

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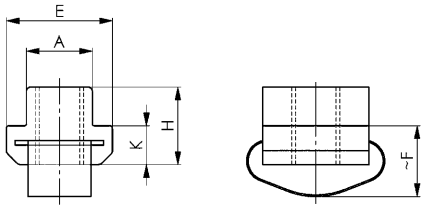
No. 508F

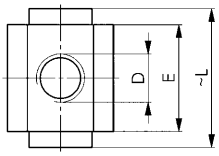
T-nuts with spring

tempered, grade 10.
Spring: Stainless steel.

Order no.	D x Slot	Test force [kN]	A	E	F	H	K	L	Weight [g]
89730	M8x12	29	11,7	18	12,5	14	7	31	24
89748	M10x12	46	11,7	18	12,5	14	7	31	21
89763	M10x14	46	13,7	22	13,5	16	8	33	38
89771	M12x14	67	13,7	22	13,5	16	8	33	34
89839	M16x18	128	17,7	28	17,5	20	10	43	70
89904	M20x22	196	21,7	35	21,5	28	14	56	153







Advantage:

- stable position in the T-slot, especially in vertical position
- easy screwing of the stud, pull rod etc.
- slot cleaning effect

Note:

For test force see DIN 508

Recommendations



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DIN 6331, page 108



DIN 6340, page 113

CAD

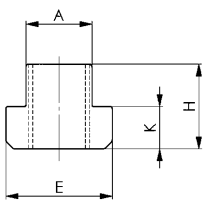
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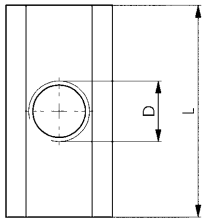
Nuts for T-slots, extended

tempered, grade 10.

Order no.	D x Slot	Test force [kN]	A	E	H	K	L	Packaging Unit	Weight [g]
84640	M5x6	11,4	5,7	10	8	4	20	50	8
84657	M6x8	16,0	7,7	13	10	6	26	50	14
84665	M8x10	29,0	9,7	15	12	6	30	50	30
84673	M10x12	46,0	11,7	18	14	7	36	50	49
84681	M12x14	67,0	13,7	22	16	8	44	25	82
84699	M14x16	-	15,7	25	18	9	50	50	120
84707	M16x18	128,0	17,7	28	20	10	56	20	170
84715	M18x20	-	19,7	32	24	12	64	10	260
84723	M20x22	196,0	21,7	35	28	14	70	-	360
84749	M24x28	282,0	27,7	44	36	18	88	-	730
84764	M30x36	448,0	35,6	54	44	22	108	-	1390







Advantage:

This extended form safegards the T-slots of precission machine tables.

Note:

For test force see DIN 508

Recommendations



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DIN 6340, page 113

CAD

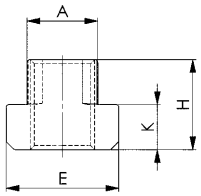
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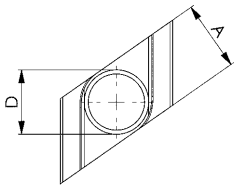
No. 510

Nuts for T-slots „Rhombus“

Tempered.







Order no.	D x Slot	Test force [kN]	A	E	H	K	Packaging Unit	Weight [g]
85993	M 6x8	10	7,7	13	10	6	50	7
87411	M 8x10	19	9,7	15	12	6	50	11
80259	M10x12	30	11,7	18	14	7	50	14
158220	M10x14	30	13,7	22	16	8	50	27
158238	M10x18	30	17,7	28	20	10	25	64
80267	M12x14	43	13,7	22	16	8	50	22
80275	M14x16	59	15,7	25	18	9	25	33
80283	M16x18	80	17,7	28	20	10	25	46
80341	M16x20	80	19,7	32	24	12	25	79
158246	M16x22	80	21,7	35	28	14	25	119
158253	M16x28	80	27,7	44	36	18	-	278
80291	M18x20	101	19,7	32	24	12	25	70
80309	M20x22	129	21,7	35	28	14	25	98
88153	M20x24	129	23,7	40	32	16	-	170
84731	M20x28	129	27,7	44	36	18	-	248
80317	M24x28	186	27,7	44	36	18	-	215
80325	M30x36	296	35,6	54	44	22	-	430
80333	M36x42	431	41,6	65	52	26	-	690

Application:

- additional setup of a clamping point for a fixture already clamped
- subsequent setup of a clamping point for machine table T-slots already occupied
- Insertion of the nut for „Rhombus“ T-slots from above into the T-slot and turning up to the stop in the T-slot
- To be used in conjunction with the studs DIN 6379

Note:

The nuts for „Rhombus“ T-slots are tempered to grade 10. Owing to the reduced contact surface in the T-slot, the load capacity is less than with the comparable sizes of DIN 508. The screw connection must be applied over the entire length of thread „H“.

Recommendations



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DIN 6331, page 108



DIN 6340, page 113

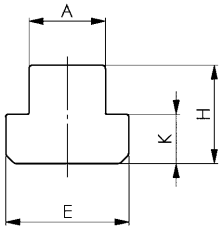
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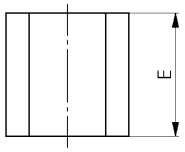
No. 508R

Blanks for T-nuts

Tempered steel 0.35-0.45 % C, unhardened, bare.







Order no.	Slot	A	E	H	K	Packaging Unit	Weight [g]
84509	6	5,7	10	8	4	25	4
84517	8	7,7	13	10	6	25	10
84525	10	9,7	15	12	6	50	16
84533	12	11,7	18	14	7	50	27
84541	14	13,7	22	16	8	50	50
84558	16	15,7	25	18	9	25	70
84566	18	17,7	28	20	10	25	95
84574	20	19,7	32	24	12	25	150
84582	22	21,7	35	28	14	25	210
84590	24	23,7	40	32	16	10	300
84608	28	27,7	44	36	18	-	430
84483	32	31,7	50	40	20	-	630
84632	36	35,6	54	44	22	-	800
84491	42	41,6	65	52	26	-	1400

Note:

Heat treatment for achieving grade 10 according to 22-32 HRC. Harden: 880°C for 45 minutes, quench in oil at 75°C. Temper: 550°C for 2 hours. This blank can be used to economically produce „Nuts for T-slots“ with customised thread.

Recommendations



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DIN 6340, page 113

CAD

Subject to technical alterations.

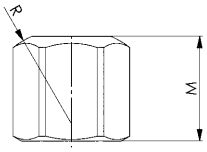
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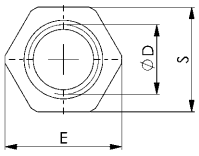
DIN 6330B

Hexagon nuts (1.5 d high)

Steel, tempered, strength class 10.
Can be used for conical socket DIN 6319D or DIN 6319G.
Can be used with the flat end for washers DIN 6340.







Order no.	Size D	E	M	R	S	Packaging Unit	Weight [g]
82362	M6	11,05	9	9	10	100	5
82370	M8	14,38	12	12	13	100	9
82354	M10	17,77	15	15	16	50	14
82388	M10 *	18,90	15	15	17 *	50	20
82347	M12	20,03	18	17	18	50	20
82396	M12 *	21,10	18	17	19 *	50	28
82321	M14 *	23,36	21	20	21	50	34
82404	M14 *	24,49	21	20	22 *	50	45
82412	M16	26,75	24	22	24	50	58
82420	M18 *	30,14	27	24	27	25	83
82438	M20	33,53	30	27	30	25	110
82339	M22 *	37,72	33	30	34	10	185
82446	M22 *	35,72	33	30	32 *	10	130
82453	M24	39,98	36	32	36	10	195
82461	M27 *	45,63	40	36	41	-	280
82479	M30	51,28	45	41	46	-	405
82487	M36	61,31	54	50	55	-	715
82495	M42	72,61	63	58	65	-	1170
82503	M48	83,91	72	67	75	-	1800

* Size not included in DIN, dimensions similar to DIN

Recommendations



DIN 6379, page 100



DIN 787, page 94



DIN 6340, page 113

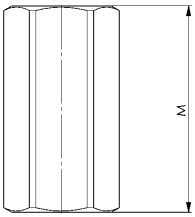
CAD

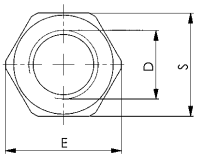
No. 6334

Elongation nuts (3.0 d high)

Steel, tempered, strength class 10.







Order no.	Size D	E	M	S	Packaging Unit	Weight [g]
82651	M6	11,05	18	10	100	8
82669	M8	14,38	24	13	50	19
82271	M10	17,77	30	16	25	30
82677	M10	18,90	30	17	25	42
82289	M12	20,03	36	18	25	48
82685	M12	21,10	36	19	25	64
82297	M14	23,36	42	21	25	73
82693	M14	24,49	42	22	25	95
82701	M16	26,75	48	24	25	120
82719	M18	30,14	54	27	20	170
82727	M20	33,53	60	30	10	240
82305	M22	37,72	66	34	10	390
82735	M22	35,72	66	32	10	280
82743	M24	39,98	72	36	-	400
82750	M27	45,63	81	41	-	600
82768	M30	51,28	90	46	-	850
82776	M36	61,31	108	55	-	1470
82784	M42	72,61	126	65	-	2340
82792	M48	83,91	144	75	-	3600

Application:

The extension nut no. 6334 is used to connect T-slot bolts DIN 787 with studs DIN 6379. Through-drive of thread is not possible. For function and safety both screws should match half the length of nut on either side. Minimum depth is 1,2 x D

CAD

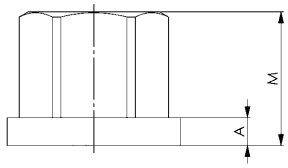
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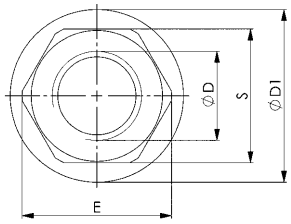
DIN 6331

Hexagonal nuts with collar (1.5 d high)

Steel, turned, tempered, strength class 10.







Order no.	Size D	A	D1	E	M	S	Packaging Unit	Weight [g]
82529	M6	3,0	14	11,05	9	10	50	6
82537	M8	3,5	18	14,38	12	13	50	12
82222	M10	4,0	22	17,77	15	16	50	21
82545	M10 *	4,0	22	18,90	15	17 *	50	25
82230	M12	4,0	25	20,03	18	18	25	30
82552	M12 *	4,0	25	21,10	18	19 *	25	36
82248	M14 *	4,5	28	23,36	21	21	25	43
82560	M14 *	4,5	28	24,49	21	22 *	25	51
82578	M16	5,0	31	26,75	24	24	25	70
82586	M18 *	5,0	34	30,14	27	27	25	95
82594	M20	6,0	37	33,53	30	30	25	130
82255	M22 *	6,0	40	37,72	33	34	10	200
82602	M22 *	6,0	40	35,72	33	32 *	10	160
82610	M24	6,0	45	39,98	36	36	10	230
82628	M27	8,0	50	45,63	40	41	-	320
82636	M30	8,0	58	51,28	45	46	-	470
82644	M36	10,0	68	61,31	54	55	-	800
82511	M42	12,0	80	72,61	63	65	-	1340
82800	M48	14,0	92	83,91	72	75	-	2040

* Size not included in DIN, dimensions similar to DIN

Advantage:

- very good roughness values on the clamping surface by means of lathed surface

Recommendations



DIN 6379, page 100



DIN 787, page 94

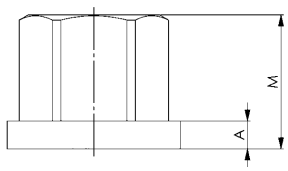
CAD

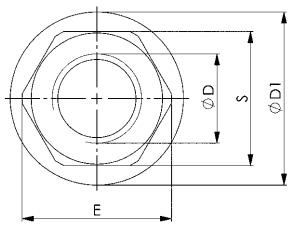
DIN 6331

Hexagonal nuts with collar (1.5 d high)

Steel, forged, tempered, strength class 10.







Order no.	Size D	A	D1	E	M	S	Packaging Unit	Weight [g]
82198	M6	3,0	14	11,05	9	10	50	6
82115	M8	3,5	18	14,38	12	13	50	12
82214	M10	4,0	22	17,77	15	16	50	21
82107	M12	4,0	25	20,03	18	18	25	30
82149	M16	5,0	31	26,75	24	24	25	70
82206	M18 *	5,0	34	30,14	27	27	25	95
82156	M20	6,0	37	33,53	30	30	25	130
82164	M24	6,0	45	39,98	36	36	10	230
82313	M27	8,0	50	45,63	40	41	-	320
82172	M30	8,0	58	51,28	45	46	-	470

* Size not included in DIN, dimensions similar to DIN

Recommendations



DIN 6379, page 100



DIN 787, page 94

CAD

Subject to technical alterations.

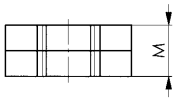
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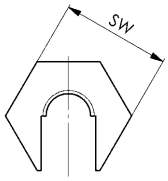
No. 6332S

Quick-action clamping nut without collar

Steel, galvanised, strength class 6.







Order no.	Size	Test force [kN]	SW	M	Weight [g]
88146	M 6	13,5	16	9,0	10
88534	M 8	24,9	19	10,5	15
88559	M10	39,4	22	12,5	23
88567	M12	59,0	27	15,0	44
88575	M16	109,9	34	16,0	68
88583	M20	176,4	41	22,0	85

Application:

Slide quick-action clamping nut directly over screw thread up to clamping point and then lock it. If the quick-action clamping nut base is firmly in contact at the clamping point, then the head can be locked with the base by means of a 1/4 to 1/2 turn.

Advantage:

- time-saving in the case of long and damaged studding
- easy assembly/disassembly at narrow and non-visible places
- no seizing up on the thread by external influences
- no impairment by soiling such as paint residues or rust

Note:

For test force see EN ISO 898-2

CAD



Recommendations



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DIN 787, page 94

DIN 894

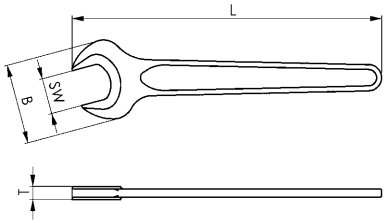
Open-ended spanner, single-ended

Special steel forging, jaws machined, angle of jaws 15°, hardened and phosphated.



Order no.	SW	Thread metric	B	L	T	Packaging unit	Weight [g]
53579	8	5	19	100	4	10	15
53595	10	6	22	105	5	10	22
53611	12	-	26	125	5	10	31
53629	13	8	29	130	5	10	37
53645	17	10*	36	160	6	10	81
53520	18	12	39	160	7	10	89
53652	19	12*	40	175	7	10	98
53660	22	14*	46	195	8	10	139
53678	24	16	50	215	9	10	165
53686	27	18	56	235	10	10	210
53694	30	20	62	260	11	10	290
53702	32	22*	67	275	12	10	333
53710	36	24	74	300	13	10	500

* Size not according to DIN ISO 272.



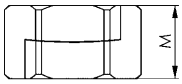
Subject to technical alterations.

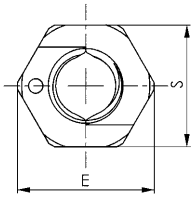
No. 6333S

AMF-TWINNUT nut - without collar

with hard detent.
Bright, strength class 10.







Order no.	Size	E	M	S	Weight [g]
381772	M6	11	6	10	3
381780	M8	14	8	13	6
381798	M10	19	10	17	14
381806	M12	21	12	19	20
381814	M16	27	16	24	39
381822	M20	33	20	30	75
381830	M24	40	24	36	131

Application:

Separable bolt nuts for quick-mounting applications. It can be simply pushed over long or damaged studding. Nut halves are undetachable through the separation block, even in the swivelled out condition.

Advantage:

- Time saved with long and damaged studding
- Overcomes studding that is corroded, damaged at the thread and even bent up to approx. 20°
- Compact design., extremely easy to handle
- Fast installation and disassembly using standard tools
- Retention as solid nuts of the same size with strength class 10.

Note:

After they are pushed together, a 1/4 to 1/2 turn suffices for locking.

On request:

Other materials and special sizes on request.

Recommendations



DIN 6379,
page 100



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page 94

Easy mounting of the TWINNUT collar nut:



Easy removal of the TWINNUT collar nut:



Subject to technical alterations.

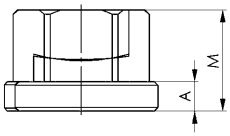
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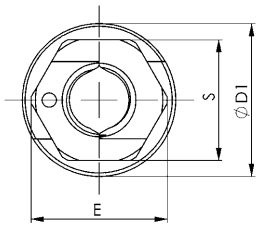
No. 6333SB

AMF-TWINNUT nut - with collar

with hard detent.
Bright, strength class 10.







Order no.	Size	A	D1	E	M	S	Weight [g]
381848	M6	3,0	14	11	9	10	5
381855	M8	3,5	18	14	12	13	12
381863	M10	4,0	22	19	14	17	24
381871	M12	4,0	25	21	16	19	33
381889	M16	5,0	31	27	21	24	62
381897	M20	6,0	37	33	26	30	114
381905	M24	6,0	45	40	30	36	188

Application:

Separable bolt nuts for quick-mounting applications. It can be simply pushed over long or damaged studding. Nut halves are undetachable through the separation block, even in the swivelled out condition.

Advantage:

- Time saved with long and damaged studding
- Overcomes studding that is corroded, damaged at the thread and even bent up to approx. 20°
- Compact design, extremely easy to handle
- Fast installation and disassembly using standard tools
- Retention as solid nuts of the same size with strength class 10.

Note:

After they are pushed together, a 1/4 to 1/2 turn suffices for locking.

On request:

Other materials and special sizes on request.

Recommendations



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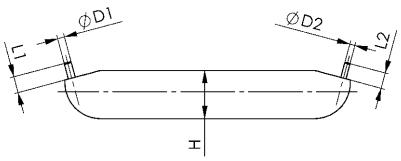
CAD

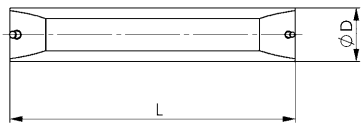
No. 6333

Mounting key

Aluminium.







Order no.	D	D1	D2	H	L	L1	Weight [g]
381921	15	2	1,5	13,3	80	5	36

Application:

- for opening the AMF-TWINNUT nuts
- can be used for all nut sizes

Subject to technical alterations.

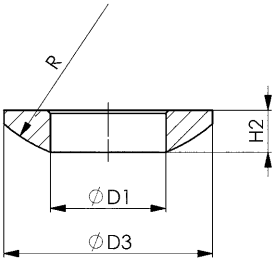
DIN 6319C

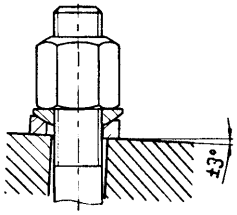
Spherical seat washer

Case hardened.

Order no.	Size	D1	D3	H2	R	Packaging Unit	Weight [g]
81828	M6	6,4	12	2,3	9	100	1,0
81737	M8	8,4	17	3,2	12	100	2,5
81745	M10	10,5	21	4,0	15	100	5,0
81752	M12	13	24	4,6	17	100	7,0
81760	M14	15	28	5,0	22	50	10
81778	M16	17	30	5,3	22	100	12
81786	M20	21	36	6,3	27	50	23
81794	M24	25	44	8,2	32	25	42
81802	M30	31	56	11,2	41	-	87
81810	M36	37	68	14,0	50	-	184
81836	M42	43	78	17,0	58	-	297
81844	M48	50	92	21,0	67	-	525







CAD

Recommendations



DIN 6330B, page 107

DIN 6319D

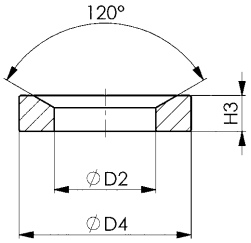
Dished washer

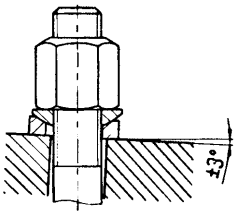
Case hardened. Designed for screw solidity in compliance with 8.8. Limited for use on flat closed ring areas (not allowed for elongated holes, we recommend DIN 6319G for these).

Order no.	Size	max.* [kN]	D2	D4	H3	Packaging Unit	Weight [g]
81950	M6	9	7,1	12	2,8	100	1,5
81869	M8	17	9,6	17	3,5	100	4,0
81877	M10	26	12,0	21	4,2	100	6,5
81885	M12	38	14,2	24	5,0	100	10
81893	M14	53	16,5	28	5,6	50	18
81901	M16	73	19,0	30	6,2	50	19
81919	M20	117	23,2	36	7,5	25	32
81927	M24	168	28,0	44	9,5	25	63
81935	M30	269	35,0	56	12	-	133
81943	M36	394	42,0	68	15	-	236
81968	M42	542	49,0	78	18	-	365
81976	M48	714	56,0	92	22	-	641

* max. transmittable static screw force.







CAD

Recommendations



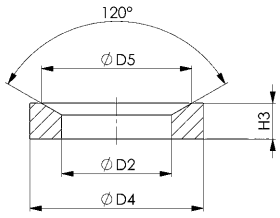
DIN 6330B, page 107

No. 6319D

Conical sockets, tempered

made of C45. Designed for screw solidity in compliance with 12.9. Limited for use on flat closed ring areas (not allowed for elongated holes, we recommend DIN 6319G for these).

Order no.	Size	D2	D4	D5	H3	F max. [kN]	Packaging Unit	Weight [g]
87171	M12	14,2	24	20	5,0	38	100	10
87197	M16	19,0	30	26	6,2	73	50	19
87239	M20	23,2	36	31	7,5	117	25	32
87254	M24	28,0	44	37	9,5	168	25	63



Note:

F max. = max. transferable static screw force.

Subject to technical alterations.

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DIN 6319G

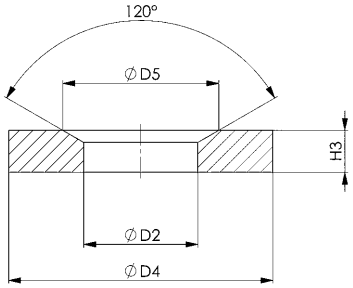
Dished washer

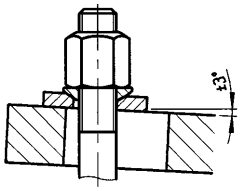
Steel, tempered to 350 + 80 HV30.
Suitable for clamping over slots with clamps.

Order no.	Size	D2	D4	D5	H3	F max. [kN]	Packaging Unit	Weight [g]
82073	M6	7,1	17	11,0	4	9	25	5,5
81984	M8	9,6	24	14,5	5	17	100	13
81992	M10	12,0	30	18,5	5	26	100	19
82008	M12	14,2	36	20,0	6	38	100	32
82016	M14	16,5	40	24,8	6	53	50	48
82024	M16	19,0	44	26,0	7	73	50	56
82032	M20	23,2	50	31,0	8	117	25	94
82040	M24	28,0	60	37,0	10	168	10	169
82057	M30	35,0	68	49,0	12	269	-	230
82065	M36 *	42,0	80	60,0	12	394	-	350
82081	M42 *	49,0	100	70,0	15	-	-	640
82099	M48 *	56,0	108	82,0	17	-	-	830

* Size not included in DIN, dimensions similar to DIN







Note:

F max. = max. transferable static screw force.

Recommendations



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DIN 6319C, page 112

CAD

DIN 6340

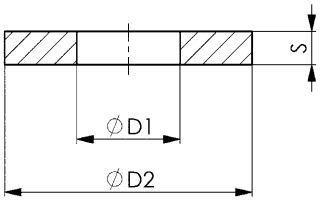
Washers for clamping tools

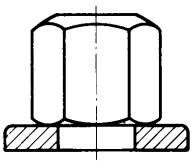
Steel, tempered (350 + 80 HV30)

Order no.	Size	Size inch	D1	D2	S	Packaging Unit	Weight [g]
82818	M6	1/4	6,4	17	3	100	5
82826	M8	5/16	8,4	23	4	100	10
82834	M10	3/8	10,5	28	4	100	16
82842	M12	1/2	13	35	5	100	35
82859	M14 *	-	15	40	5	50	40
82867	M16	5/8	17	45	6	50	60
82875	M18 *	-	19	45	6	50	60
82883	M20	3/4	21	50	6	50	73
82891	M22 *	7/8	23	50	6	25	72
82909	M24	7/8	25	60	8	20	170
82917	M27 *	1 1/16	28	68	10	-	210
82925	M30	1 1/8, 1 3/16	31	68	10	-	230
82933	M36 *	1 1/4, 1 3/8	38	80	10	-	350
82941	M42 *	1 1/2	44	100	15	-	670
82958	M48 *	1 3/4	50	108	17	-	920

* Size not included in DIN, dimensions similar to DIN







Recommendations



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DIN 787, page 94

CAD

Subject to technical alterations.

No. 6530

Boxed set of assorted clamping elements

With deep clamping jaw no. 6490 and screw compound no. 6339. The clamping tool assortment boxes are designed for machine tools with T-slot tables and contain all the elements required for the fast clamping of tools, fixtures and workpieces. They are produced from tempered steel according to DIN or factory standards. Screw parts strength class 8 and/or 10. In a sturdy and high-quality wooden box with removable folding lid.



Order no.	Slot	No. 6500E Pcs.xSize	No. 6314Z Pcs.xSize	DIN 787 Pcs.xLength	DIN 6379 Pcs. xLength	DIN 6330B	DIN 6319G	No. 6334	No. 6490* Pcs.xSize	No. 6485 Pcs.xSize	No. 3113A Pcs.xSize	No. 6339	L x W x H	Weight [Kg]
83584	M10x10	4x1, 4x2, 2x3	4x 11x80	2x40, 4x63, 4x100	4x80	6x	6x	4x	4x12	-	1x 16x16	1x	355x270x47	9,2
83592	M12x12	4x2, 4x3	4x 14x100	2x50, 4x80, 4x125	4x100	6x	6x	4x	4x12	-	1x 18x18	1x	460x330x50	14,3
83600	M12x14	4x2, 4x3	4x 14x100	2x50, 4x80, 4x125	4x100	6x	6x	4x	4x14	1x 14-20	1x 18x18	1x	460x330x50	14,6
83691	M14x16	4x2, 4x3	2x 14x100, 4x 14x160	2x63,4x100,4x160	4x125	6x	6x	4x	4x16	1x 14-20	1x 22x22	1x	510x415x50	18,5
83618	M16x16	4x2, 4x3	4x 18x125	2x63,4x100,4x160	4x125	6x	6x	4x	4x16	1x 14-20	1x 24x24	1x	510x415x50	21,5
83626	M16x18	4x2, 4x3	4x 18x125	2x63,4x100,4x160	4x125	6x	6x	4x	4x18	1x 14-20	1x 24x24	1x	510x415x50	21,5

* The low height clamping jaws no. 6490 are complete sets with T-nuts DIN 508, screws ISO 4762 and two hexagon keys ISO 2936.
Single items available.

No. 6531

Boxed set of assorted clamping elements

With sprung clamp holder no. 6342 and screw compound no. 6339.
The clamping tool assortment boxes are designed for machine tools with T-slot tables and contain all the elements required for the fast clamping of tools, fixtures and workpieces. They are produced from tempered steel according to DIN or factory standards. Screw parts strength class 8 and/or 10. In a sturdy and high-quality wooden box with removable folding lid.



Order no.	Slot	No. 6500E Pcs.xSize	No. 6314Z Pcs.xSize	DIN 787 Pcs.xLength	DIN 6379 Pcs. xLength	DIN 508	DIN 6330B	DIN 6319G	No. 6485 Pcs.xSize	No. 3113A Pcs.xSize	DIN 6342 Pcs.xSize	No. 6334	No. 6339	L x W x H	Weight [Kg]
83808	M10x10	4x1, 4x2, 2x3	4x 11x80	4x63, 4x100	4x80	-	6x	6x	-	1x 16x16	4x1	4x	1x	350x225x47	6,5
83816	M12x12	4x2, 4x3	4x 14x100	4x80, 4x125	4x100	-	4x	6x	-	1x 18x18	4x2	4x	1x	359x333x57	11,0
83824	M12x14	4x2, 4x3	4x 14x100	4x80, 4x125	4x100	-	4x	6x	1x 14-20	1x 18x18	4x2	4x	1x	359x333x57	11,0
83832	M16x16	4x2, 4x3	4x 18x125	4x100, 4x160	4x125	-	4x	6x	1x 14-20	1x 24x24	4x3	4x	1x	390x415x55	16,5
83840	M16x18	4x2, 4x3	4x 18x125	4x100, 4x160	4x125	-	4x	6x	1x 14-20	1x 24x24	4x3	4x	1x	390x415x55	16,5
83642	M20x22	4x2, 4x3	4x 22x160	4x125, 4x200	4x125	-	6x	6x	1x 22-32	1x 30x30	4x4	4x	1x	480x528x60	24,5

Single items available.

Subject to technical alterations.

No. 6520

T-bolt set

In a sturdy and high-quality wooden box with removable folding lid. All parts tempered, strength class 8 or 10.



Order no.	Slot	DIN 787 Pcs.xLength	DIN 6379 Pcs.xLength	DIN 508	DIN 6330B	No. 6334	DIN 6319C+G	DIN 6340	L x W x H	Weight [Kg]
82982	M10x10	2x40, 4x63, 4x100	4x50, 4x80, 4x200	1)	4x	4x	4x	4x	254x188x32	2,0
82990	M12x12	2x50, 4x80, 4x125	4x63, 4x100, 4x200	1)	4x	4x	4x	4x	278x234x36	3,2
83006	M12x14	2x50, 4x80	4x63, 4x100, 4x125, 4x200	4x	4x	4x	4x	4x	278x234x36	3,5
83014	M14x16	2x63, 4x100	4x63, 4x100, 4x160, 4x250	4x	4x	4x	4x	4x	317x239x44	5,4
83030	M16x18	2x63, 4x100	4x80, 4x125, 4x160, 4x250	4x	4x	4x	4x	4x	339x294x48	7,4
83055	M20x22	2x80, 4x125	4x80, 4x125, 4x200, 4x315	4x	4x	4x	4x	4x	358x342x56	13,5
83063	M24x28	2x100, 4x160	4x100, 4x160, 4x250, 4x400	4x	4x	4x	4x	4x	444x409x72	23,6

1) = T-nuts DIN 508 not suitable for this size.
2) = M18x20, included instead DIN 787 are 4 studs DIN 6379x125 mm and 2x80 mm,with DIN 508 T-nuts and DIN 6340 washers each.
Single items available.

No. 6532

Basic sortiment

All parts are produced from tempered steel according to DIN or factory standards, screw parts tempered to strength class 8 or 10. Ideal for tool making, manufacturing and training facilities.



Order no.	Size	Clamping force [kN]	max. clamping height using 2 clamps [mm]	max. clamping height using 4 clamps [mm]	No. 6314Z Pcs.xSize	No. 6500E Pcs.xSize	DIN 787 Pcs.xLength	DIN 6379 Pcs.xLength	DIN 6330B	DIN 6340	No. 6334	Weight [Kg]
83899	M12x14	20	165	70	2x14x100,2x14x160	4x2, 4x3	2x50,4x80,4x125	2x100	6x	6x	2x	10,0
83915	M14x16	28	195	100	2x14x100,2x14x160	4x2, 4x3	2x63,4x100,4x160	2x100, 2x160	6x	6x	2x	11,1
83907	M16x18	40	205	130	2x18x125,2x18x200	4x2, 4x3	2x63,4x80,4x160	2x200, 4x125	6x	6x	4x	15,2

Subject to technical alterations.

No. 6470

Trolley for clamping equipment

without clamping equipment and without holders.
Rugged steel housing, storage compartments designed with rubber mats. 2 rollers + 2 castors with locking brake.



Order no.	Load [Kg]	Height [cm]	Width [cm]	Depth [cm]	Weight [Kg]
74252	400	126	123	80	100

Advantage:

- Mobile = quickly ready when needed at the workplace
- Tidy = convenient, space-saving and always readily available
- Individual equipment configurations possible through variable arrangement of holders

Note:

Holders for clamps (No. 6470H-2) and clamping bolts (No. 6470H-1) can be selected as required.

No. 6470-Mxx

Trolley for clamping equipment with basic set of clamping equipment

incl. clamping equipment tool cart no. 6470.



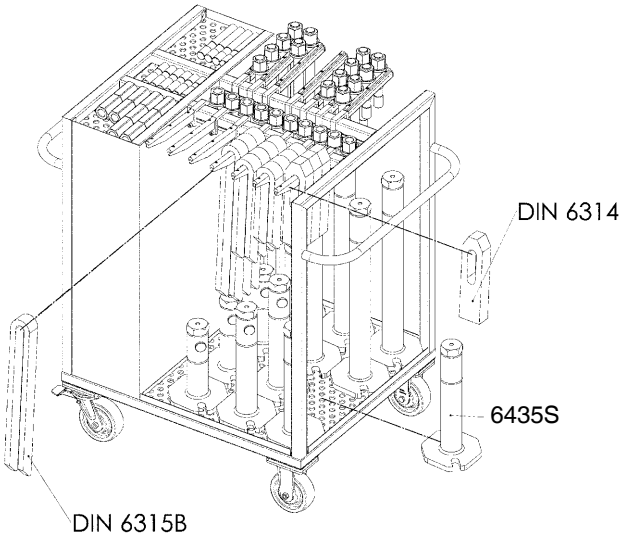
Order no.	Size	Holder no. 6470H-01 [St.]	Holder no. 6470H-02 [St.]	Weight [Kg]
72520	M16	5	4	257,0
73270	M20	5	4	277,0
74674	M24	5	4	304,0
74880	M30	7	4	512,5

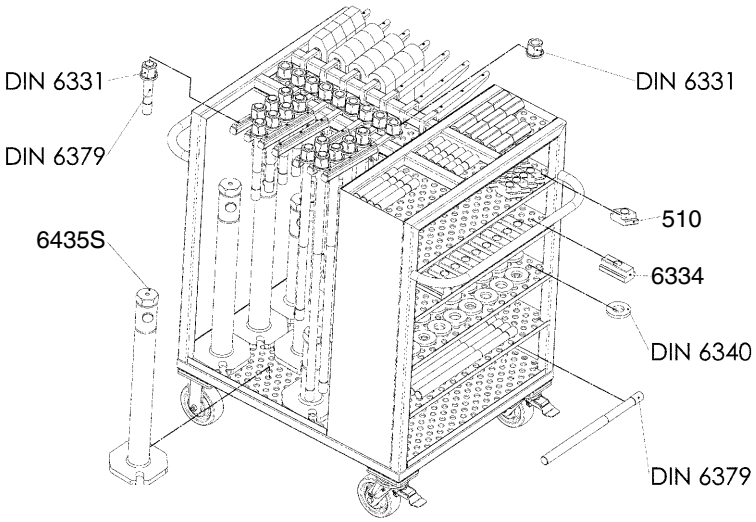
Design:

	Order no. 72520 (Size M16)			Order no. 73270 (Size M20)			Order no. 74674 (Size M24)			Order no. 74880 (Size M30)		
Product	**Order no.**	**Size**	**Pc.**	**Order no.**	**Size**	**Pc.**	**Order no.**	**Size**	**Pc.**	**Order no.**	**Size**	**Pc.**
DIN 6379	81422	M16x125	6	84988	M20x125	6	85563	M24x125	6	85068	M30x125	6
	85498	M16x200	6	81513	M20x200	6	85514	M24x200	6	81612	M30x200	6
	85548	M16x315	6	84996	M20x315	6	86009	M24x315	6	81620	M30x315	6
	85472	M16x500	6	85001	M20x500	6	86025	M24x500	6	81638	M30x500	6
										81646	M30x700	6
										81661	M30x1000	6
DIN 6331	82578	M16	30	82594	M20	30	82610	M24	30	82636	M30	30
DIN 6340	82867	M16	30	82883	M20	30	82909	M24	30	82925	M30	30
DIN 6314	70060	18x160	4	70086	22x200	4	70102	26x250	4	70128	33x315	4
DIN 6315B	70524	18x160	4	70557	22x200	4	70581	26x250	4	70623	33x315	4
	70532	18x200	4	70573	22x315	4	70607	26x315	4	70631	33x400	4
	70540	18x250	4	70425	22x500	4	70433	26x500	4	70441	33x600	4
No. 6334	82701	M16	10	82727	M20	10	82743	M24	10	82768	M30	10
No. 6400	72413	100	4									
	72439	210	4									
No. 6435S	72637	300	4	72637	300	4	72637	300	4	72645	460	4
	72645	460	4	72645	460	4	72645	460	4	72652	750	4
										72660	1250	4
No. 508L	84707	M16x18	10	84723	M20x22	10	84749	M24x28	10	84764	M30x36	10
No. 510	80283	M16x18	10	88153	M20x24	10	80317	M24x28	10	80325	M30x36	10

Subject to technical alterations.

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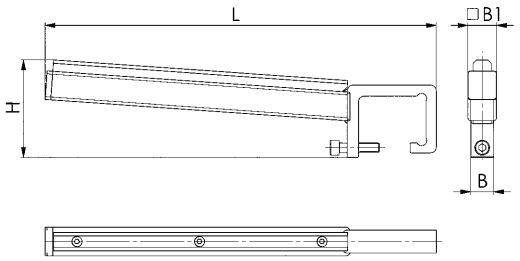


No. 6470H-1

Holder for clamping bolts

Order no.	L [mm]	B [mm]	B1 [mm]	H [mm]	Weight [g]
74187	342	20	25	85	866



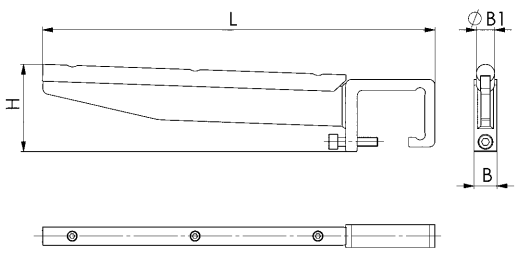


No. 6470H-2

Holder for clamps

Order no.	L [mm]	B [mm]	B1 [mm]	H [mm]	Weight [g]
74203	342	20	16	76	870





Subject to technical alterations.

Set of assorted plastic clamping elements

No. 6535

Set of assorted plastic clamping elements

depending on size consisting of:
4 x support blocks with stepped teeth
2 x clamping jaws with stepped teeth
2 x clamping jaws double
10 x knurled nuts with hexagonal
high-strength plastic PBT, red.
Studs: Aluminium anodised.



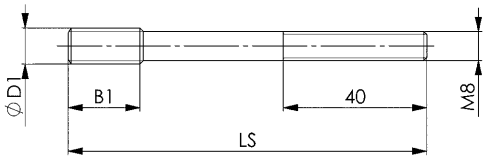
Order no.	Size	D1 x M	B1	St. x LS	L x W x H	Weight [g]
83071	06	M6 x M8	10	4x100, 4x125, 4x150, 4x175, 4x200	440x370x50	1700
83105	08	M8 x M8	40	4x100, 4x125, 4x150, 4x175, 4x200	440x370x50	1740
83089	10	M10 x M8	20	4x100, 4x125, 4x150, 4x175, 4x200	440x370x50	1770

Application:

Most suitable for 3D-coordinate measuring machines, engraving and E.D.M. machine application and any light duty clamping. The possible clamping force (up to 500 N), depending on the actual leverage, can be achieved by manual tightening of knurled nut, while its hexagon section allows release through use of open jaw wrench.

Advantage:

- The weight is only 1/4 compared with aluminium and 1/10 compared with steel elements.
- anticorrosive against hand sweat
- very easy to handle
- no damage to surface plate, supporting table or workpiece
- suitable for multi-combination.



Recommendations



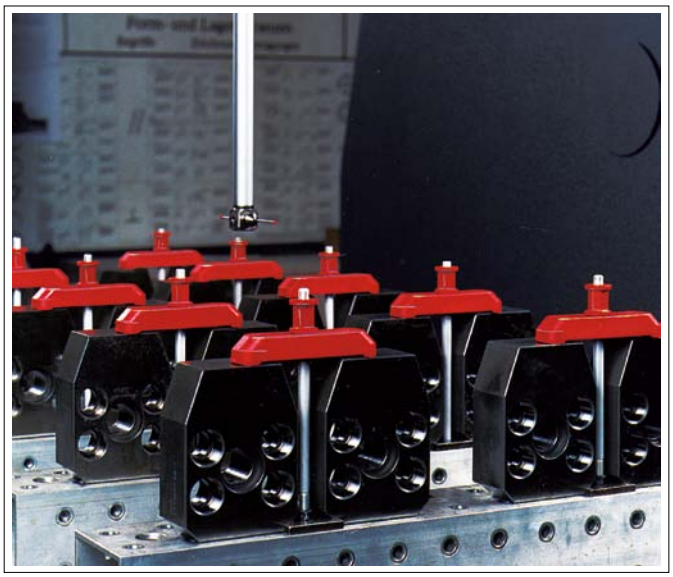
No. 6530, page 114

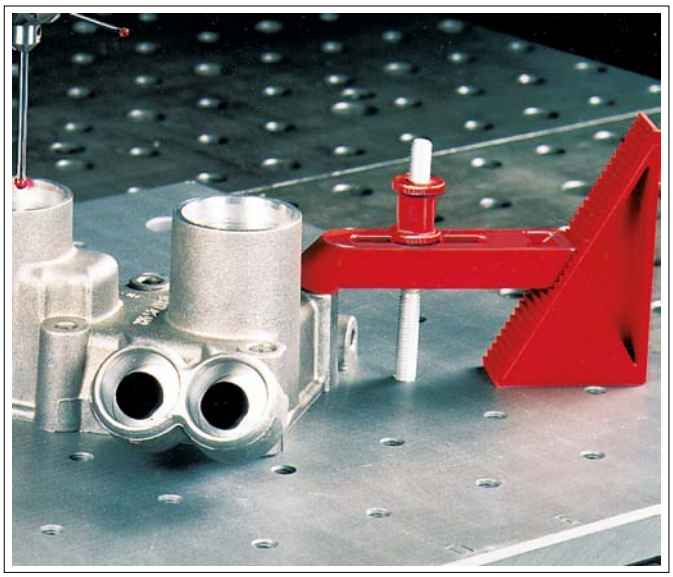


No. 6531, page 114



No. 6520, page 115





Subject to technical alterations.

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No. 6339

Heavy duty thread paste



Order no.	Temperature range	Contents [ml]	Weight [g]
86686	-25 - + 125°C	75	75

Application:

For lubricating screw connections in clamping fixtures. Especially when aggressive coolants are used. Unlubricated (dry) screw connections are subjected to high friction forces (clamping force reduction) and rapid wear when tightened securely often. Thanks to its optimal lubricity, AMF screw compound increases the achievable clamping force and protects the material (longer service life).

Features:

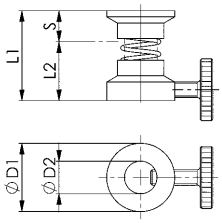
The paste, based on mineral fat, has a synergetic acting combination of highly active white solid lubricants. It is resistant to heat and wash off. (Washouttest according DIN 51807, part 2; loss of lubricant after 1 h/37.8°C = 1.4%).

No. 6342

Spring type clamp support

with brass locking screw





CAD

Order no.	Size	D1	D2	L1	L2	Travel of spring S	for clamping screw	Weight [g]
75952	1	22	10,5	30	22	8	M8-M10	41
75960	2	26	14,5	32	22	10	M12-M14	55
75978	3	32	18,5	38	26	12	M16-M18	89
75986	4	38	22,5	40	28	12	M20-M22	133
75994	5	45	27,5	44	32	12	M24-M27	177

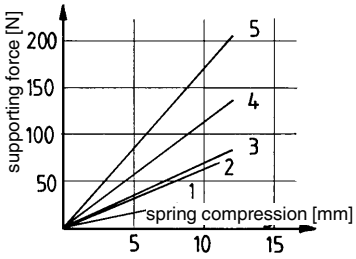
The spring type clamp support holds the clamp while the work piece is removed and loaded, ensuring fast and safe clamping sequence.

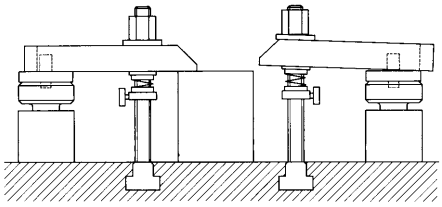
Recommendations



DIN 6379, page 100

DIN 787, page 94





No. 6485

T-slot scraper

Steel, zinc-plated.



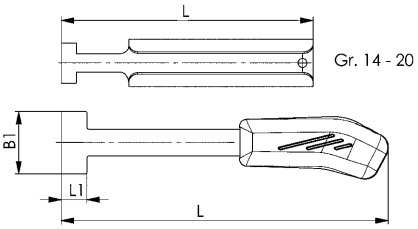


CAD

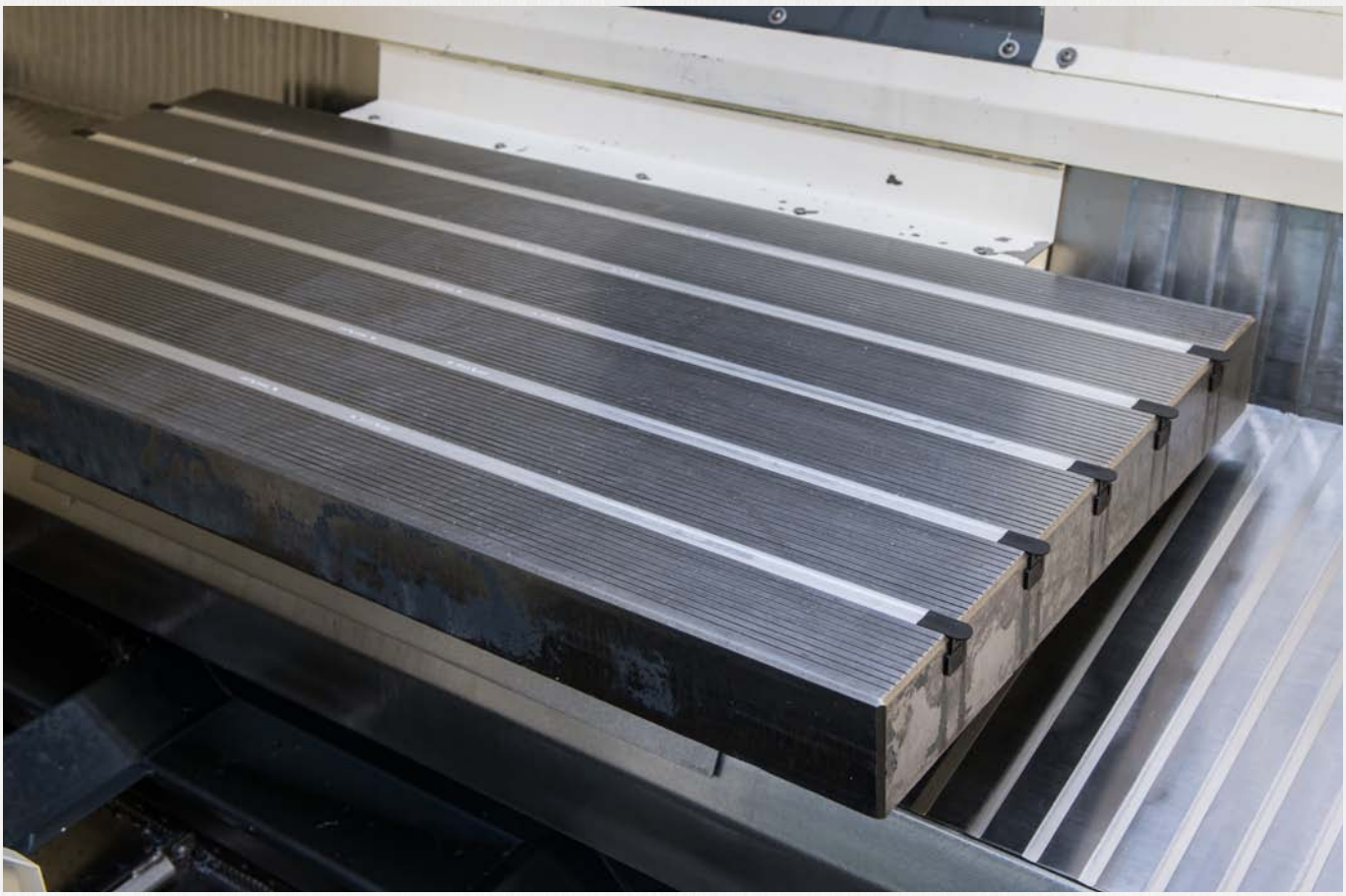
Order no.	Size	Slot	B1	L1	L	Packaging Unit	Weight [g]
72892	14-20	14-20	22,5	8,5	142	100	105
72900	22-32	22-32	35,0	14,5	184	50	170
72918	36-54	35-54	54,0	23,0	260	-	525

Note:

Size 14-20 without 2k hand grip.



Subject to technical alterations.





Subject to technical alterations.

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No. 6486AO

T-slot side cover

Recyclable TPE plastic, RAL2008 orange.
Packaging unit: 10 each/size



Order no.	Slot	A	E	H	K	L	L1	L2	Packaging unit	Weight [g]
565405	14	14	23,0	14,5	15,5	23	30	8	10	5
565401	16	16	26,5	16,5	18,5	26	33	9	10	7
565402	18	18	30,0	18,5	20,0	30	37	10	10	9
565403	22	22	37,0	22,5	24,5	35	42	12	10	14
565404	28	28	46,0	28,5	29,5	44	54	15	10	28

Application:

In addition to our cover strips for T-slots 6486, these **new, lateral covers for T-slots** also protect the machine slot from chips and soiling.
This is especially advantageous for T-slot tables of a 5-axis processing machine.

Advantage:

- 100% recyclable plastic
- Holes and bevels permit unhindered coolant flow
- Grip possibility for pulling out of the T-slot
- The flexible cover compensates for all slot tolerances in accordance with DIN650
- Use in all machine table T-slots
- Labelled with size, fast assignment possible

No. 6486AS

T-slot side cover

Recyclable TPE plastic, RAL9017 black.
Packaging unit: 10 each/size



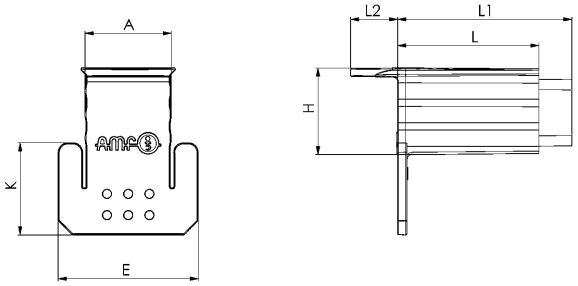
Order no.	Slot	A	E	H	K	L	L1	L2	Packaging unit	Weight [g]
565165	14	14	23,0	14,5	15,5	23	30	8	10	5
565320	16	16	26,5	16,5	18,5	26	33	9	10	7
565321	18	18	30,0	18,5	20,0	30	37	10	10	9
565322	22	22	37,0	22,5	24,5	35	42	12	10	14
565323	28	28	46,0	28,5	29,5	44	54	15	10	28

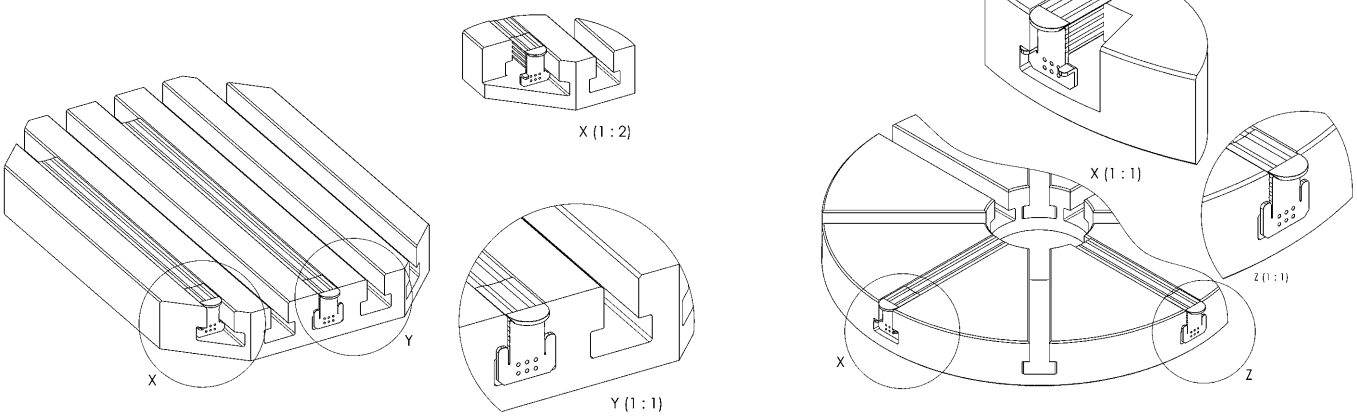
Application:

In addition to our cover strips for T-slots 6486, these **new, lateral covers for T-slots** also protect the machine slot from chips and soiling.
This is especially advantageous for T-slot tables of a 5-axis processing machine.

Advantage:

- 100% recyclable plastic
- Holes and bevels permit unhindered coolant flow
- Grip possibility for pulling out of the T-slot
- The flexible cover compensates for all slot tolerances in accordance with DIN650
- Use in all machine table T-slots
- Labelled with size, fast assignment possible



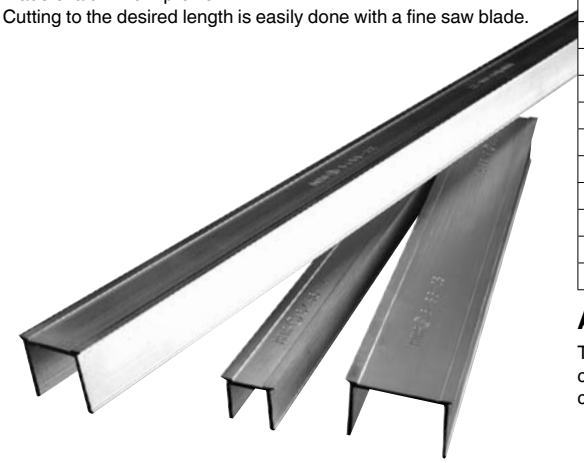


Subject to technical alterations.

No. 6486

T-slot cover

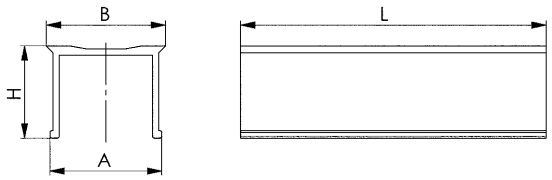
Made of aluminium profile.
Cutting to the desired length is easily done with a fine saw blade.



Order no.	Size	Slot	A	B	H	L	Weight [g]
71449	12x1000	12	12,0	13,0	10,5	1000	88
71456	14x1000	14	14,0	15,5	11,5	1000	100
71464	16x1000	16	16,0	17,5	14,0	1000	120
71472	18x1000	18	18,0	19,5	15,0	1000	135
71928	20x1000	20	20,5	21,5	16,5	1000	150
71936	22x1000	22	22,5	23,5	18,0	1000	165
71787	24x1000	24	24,5	25,5	20,0	1000	170
71944	28x1000	28	28,5	29,5	22,0	1000	200
71951	36x1000	36	36,5	38,0	22,0	1000	220
564437	42x1000	42	42,7	43,4	30,0	1000	367
571087	48x1000	48	48,7	50,0	30,0	1000	395

Advantage:

The thorough subsequent cleaning of the slot on the machine table is no longer required. Always cover free slots by using the original AMF-T-slot cover before starting with machining. The T-slot covers can easily be removed after machining.



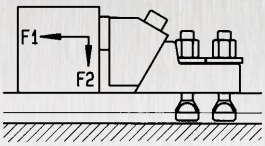
CAD

Subject to technical alterations.

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

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

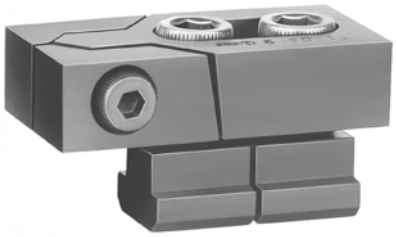


No. 6490

Low height clamping jaws, model „Bulle“

tempered and blued in black oxide finish. Complete with fastening bolts ISO 4762 (10.9), nuts for T-slots DIN 508 and hexagon screwdriver ISO 2936.
Packed in carton in pairs.

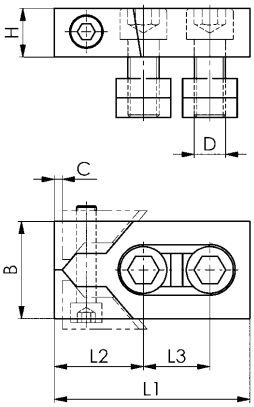
Order no.	Slot	B	C	D	H	L1	L2	L3	F1 [kN]	F2 [kN]	Weight [g]
72959	12	40	3	M10	20	80	39	26	16	0,6	1150
72967	14	40	3	M12	20	80	39	26	22	0,9	1250
72975	16	40	3	M12	20	80	39	26	22	0,9	1330
72983	16	50	4	M14	25	100	46	34	32	1,2	2340
72991	18	50	4	M16	25	100	46	34	36	1,4	2540
73007	20	50	4	M16	25	100	46	34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

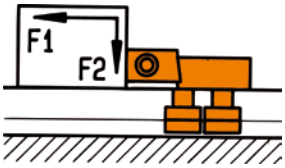


CAD

Note:

The clamping forces F1 and F2 are achieved with optimum design and utilisation of the max. tightening torque of the fastening bolts.





No. 6491

Slot stop

tempered and burnished.

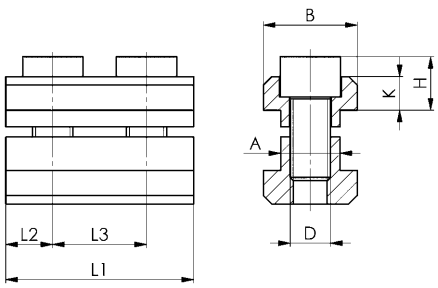
Order no.	Slot	A	B	D	H	K	L1	L2	L3	Weight [g]
73817	12	11,7	18	M8	12	7	36	9,0	18	100
73825	14	13,7	22	M8	12	8	44	11,0	22	140
73833	16	15,7	25	M12	15	9	50	12,5	25	240
73841	18	17,7	28	M12	16	10	56	14,0	28	340
73858	20	19,7	32	M16	19	12	64	16,0	32	520
73866	22	21,7	35	M16	21	14	70	17,5	35	720
73874	24	23,7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



CAD

Application:

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



Recommendations



No. 911LG-H100F

Subject to technical alterations.

No. 6492

Flat clamp, model „Mini-Bulle“

tempered and blued in black oxide finish. Complete with fastening bolts ISO 4762 (8.8), and hexagon screwdriver ISO 2936.
Packed in carton in pairs.

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

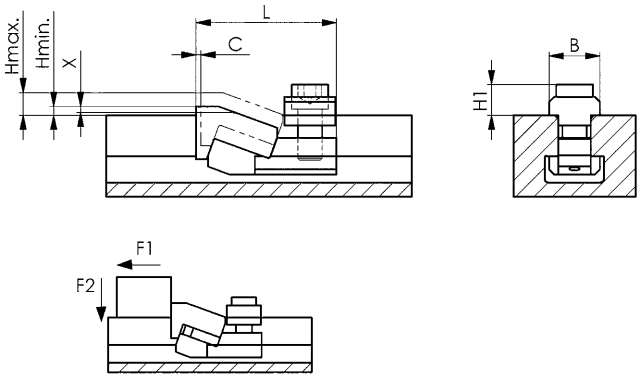


Application:

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

Note:

Hmin./Hmax.: depending on the groove depth according to DIN 650.
The clamping piece can be ground by X mm. This allows lower clamping heights to be achieved.
The clamping forces F1 and F2 are achieved with optimum design and utilisation of the max. tightening torque of the fastening bolts.



CAD

No. 6365

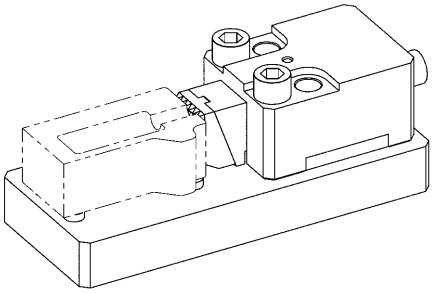
CAD

Pull-Down Clamp

Hardened steel

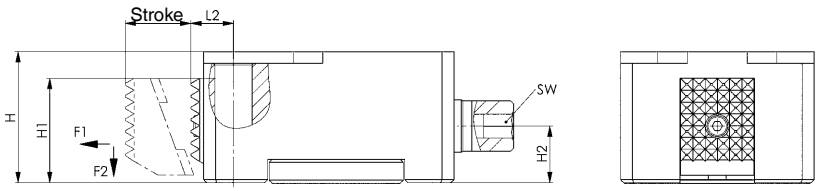
Order no.	Size	B	B1	H	H1	H2	Stroke	F1 [kN]	F2 [kN]	Weight [g]
88492	12	65	25	44	36	19	22	20	2	1515
79392	16	80	30	50	41	21	27	40	4	2604

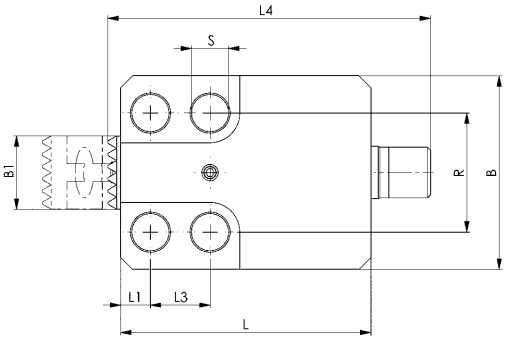




Application:

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





Recommendations



No. 6365G, page 125



No. 6365N, page 125

Dimensions:

Order no.	L	L1	L2	L3	L4	R	dia. S	SW	Md [Nm]
88492	84	10	14	20	108,5	40	12,5	8	50
79392	102	15	18	25	123,0	50	16,5	10	100

Subject to technical alterations.

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No. 6365G

Clamping Jaws, serrated

Hardened steel

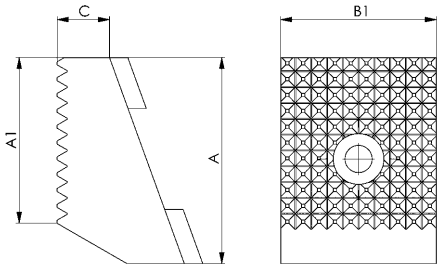
CAD

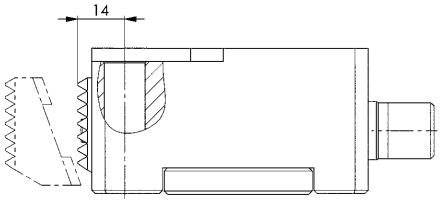


Order no.	Size	A	A1	B1	C	Weight [g]
88500	12	32,5	26	24,6	8,5	69
120360	16	37,5	31	29,8	7,5	99

Note:

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





No. 6365N

Clamping Jaws, with ridge

hardened steel

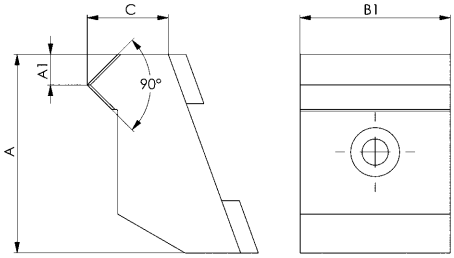
CAD

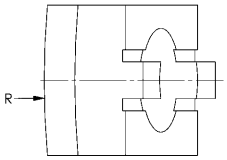


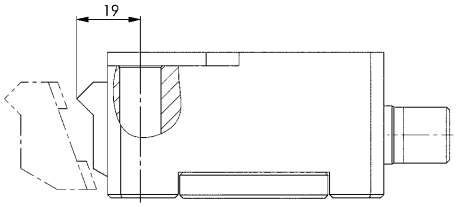
Order no.	Size	A	A1	B1	C	R	Weight [g]
88526	12	32,5	5	24,6	13	200	74
88542	16	37,5	5	29,8	12,5	250	110

Application:

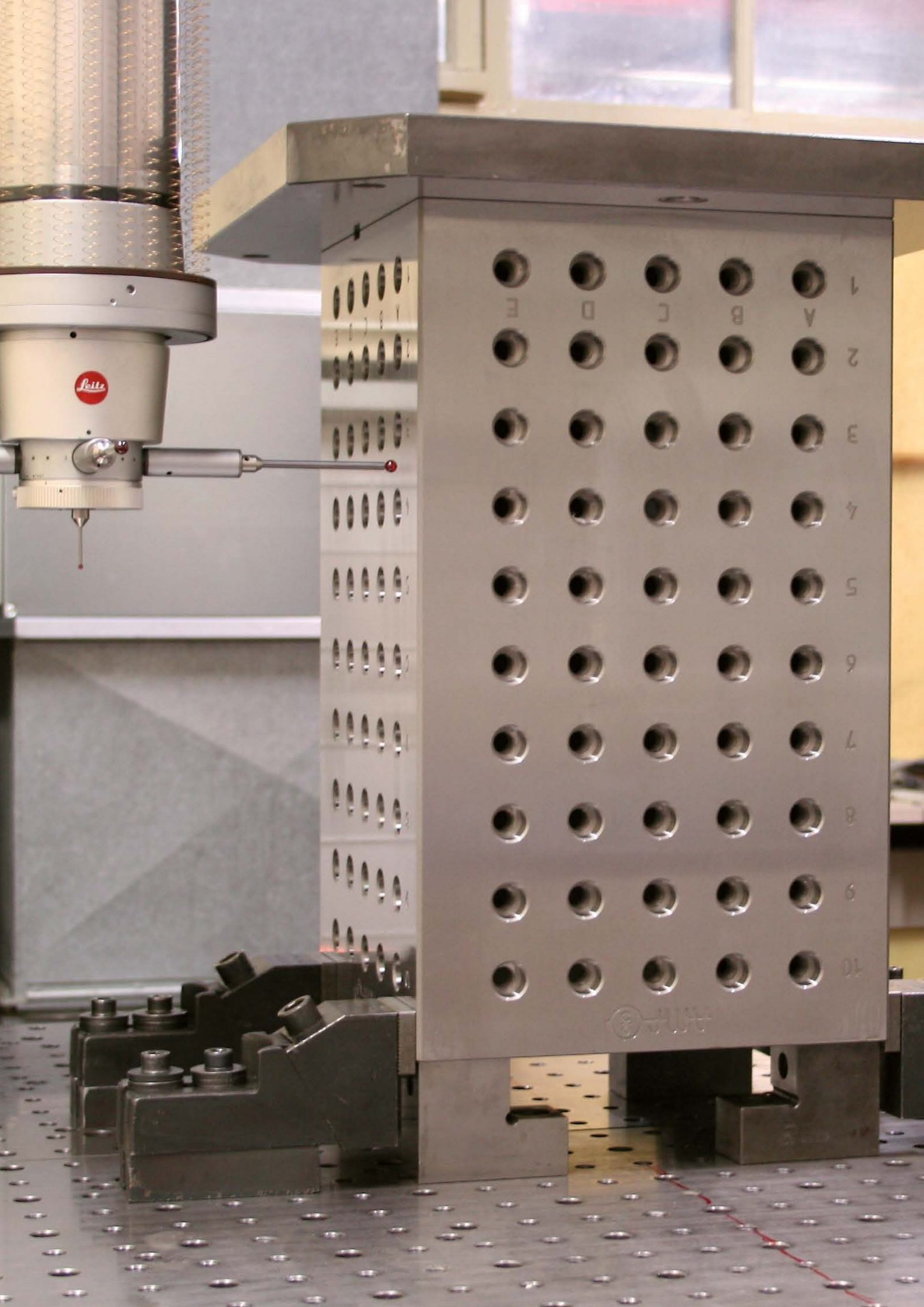
Suitable for pull-down clamp no. 6365. Especially suitable for workpieces with a very uneven or hard surface (castings).







Subject to technical alterations.


Leitz
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B
A
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No. 6494

CAD

Low height clamping jaws, model „Maxi-Bulle“

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

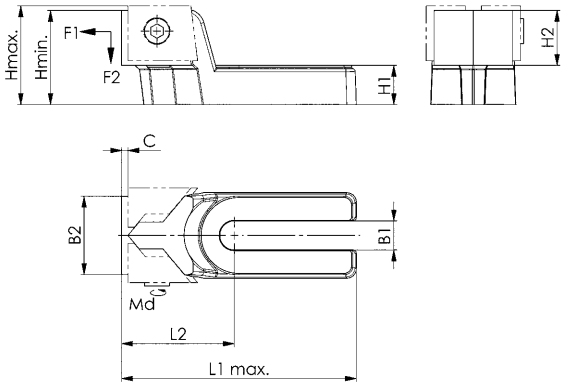


Order no.	Slot	B1	B2	C	H min. [mm]	H max. [mm]	H1	H2	L1 max.	L2	F1* [kN]	F2* [kN]	Weight:/ pair [g]
73130	10 12 14	14	40	3	50	52	20	30	115	60	6 10 15	0,2 0,4 0,6	1590
73148	16 18 20	19	50	4	60	63	25	35	150	72	20 28 36	0,8 1,1 1.4	2940
73155	22 24 28 30 32 36	31	80	5	75	79	30	45	205	102	38 38 40 40 44 44	1,5 1,5 1,6 1,6 1,7 1,7	7900

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

Application:

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





Recommendations



No. 911LG-H100F

Subject to technical alterations.

No. 6497F

CAD

Solid clamping jaws, flat design

with exact prismatic guide.
Body: Tempered steel.
Clamping jaws: Case-hardened steel, case-hardened.
Reversible clamping jaws with smooth side for machined workpieces and serrated side for rough clamping surfaces.



Order no.	Slot	B1	B2	C	E	H min. [mm]	H max. [mm]	H1	H2	L1 max.	L2	L4	SW	F1* [kN]	F2* [kN]	Md [Nm]	Weight [g]
564074	10 12 14	14	40	3	8	3	33,5	20	25,4	128	82	19	13	4 8 15	0,7 1,2 2,2	11 20 40	840
562016	12 14 16 18	19	65	6	12	20	60	30	40	177	113	29	16	8 15 20 28	1,2 2,2 3,0 4,2	20 40 45 60	3020
562017	20 22 24 28 30	26	75	7,5	12	33	73	36	40	224	135	29	18	25 25 32 32 36	4,5 4,5 4,8 4,8 5,4	85 85 95 95 110	4880
562018	32 36 42	38	90	10	12	51	91,5	46	40	256	152	34	21	50	7,5	160	7715

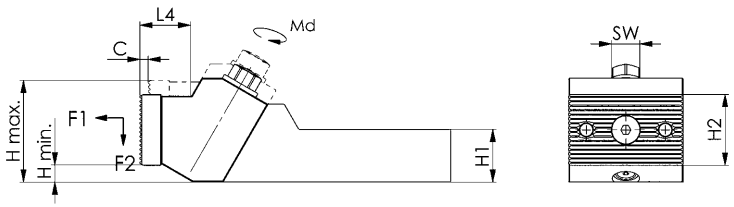
* Clamping forces F1 and F2 depend on the groove width

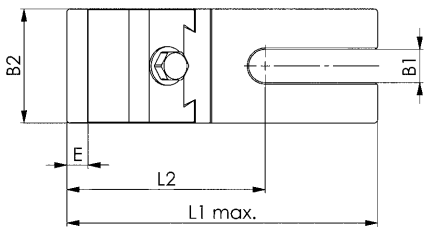
Application:

The large clamping surface makes these solid clamping jaws suitable for laterally clamping workpieces. We recommend using two clamping studs for fastening the solid clamping jaw on the machine table. Screws for T-slots DIN 787 - two screws per clamping jaw - should be ordered separately as a fastening bolt depending on the width of the slot.

Note:

The clamping forces F1 and F2 are achieved with optimum design and utilisation of the maximum tightening torque of the fastening bolts.





Subject to technical alterations.

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No. 6497

CAD

Extra strong clamping jaw

High design with exact prismatic guide.
Main body: malleable iron.
Clamping jaws: case-hardening steel, case-hardened. Reversible clamping jaws with smooth side for machined workpieces and serrated side for rough clamping surfaces.



Order no.	Slot	B1	B2	C	E	H min. [mm]	H max. [mm]	H1	H2	L1	L2	F1* [kN]	F2* [kN]	Md [Nm]	Weight [g]
73213	12 14 16 18	19	65	8	12	46	99	38	40	179	112,5	8 15 20 28	1,2 2,2 3,0 4,2	20 40 45 60	4037
73221	20 22 24 28 30	26	75	11	12	61	118	45	40	230	138,5	25 25 32 32 36	4,5 4,5 4,8 4,8 5,4	85 85 95 95 110	6688
73239	32 36 42	38	90	15	12	89	145	56	40	265	158	50	7,5	160	11031

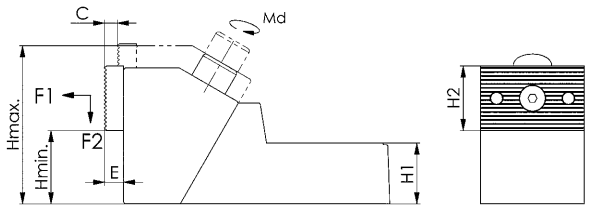
* Clamping forces F1 and F2 depend on the groove width.

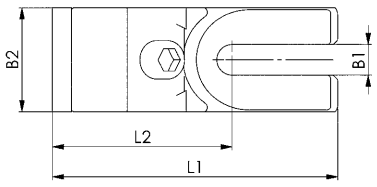
Application:

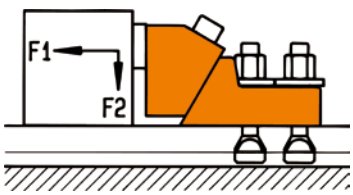
Due to their large clamping faces these clamping jaws are suitable for lateral clamping of high workpieces. For fastening on the machine table we recommend the use of 2 clamping screws! Related to T-slot size in use, 2 T-slot bolts DIN 787 for each clamp should be ordered separately.

Note:

The clamping forces F1 and F2 are achieved with optimum design and utilisation of the maximum tightening torque of the fastening bolts.







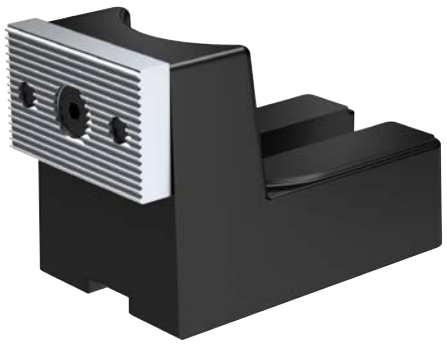
Subject to technical alterations.

No. 6497A

Stop, fixed

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

CAD



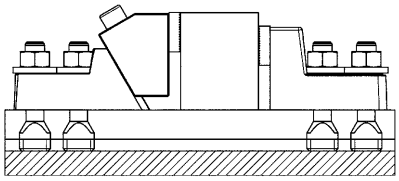
Order no.	Slot	B1	B2	E	G	H	H1	H2	K	L1	L2	Weight [g]
550509	12 14 16 18	19	65	12	M6	85	38	40	20	132	66,0	2857
550510	20 22 24 28 30	26	75	12	M6	100	45	40	20	177	85,5	4673
550511	32 36 42	38	90	12	M6	120	56	40	20	211	95,0	7900

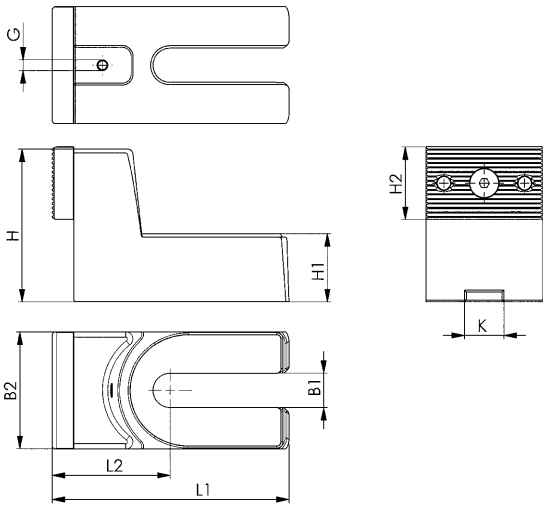
Application:

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

Note:

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





Recommendations



No. 6497B, page 131

Subject to technical alterations.

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No. 6497B

Clamping jaw

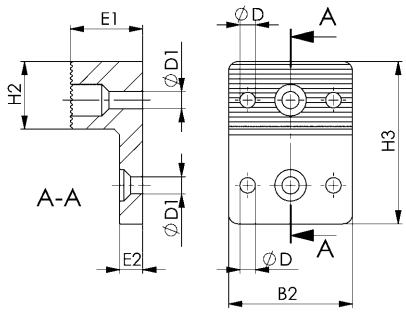
Case-hardened steel, nitrided, with fastening bolt M8

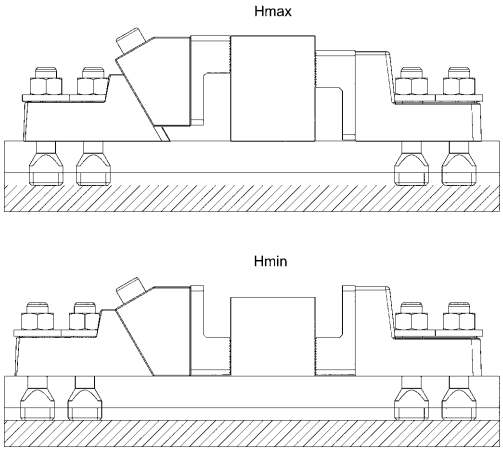
Order no.	Size	B2	D	D1	E1	E2	H2	H3	Weight [g]
550512	**19**	65	8,1	9	38	12	35	85	889
550513	**26**	75	8,1	9	38	12	45	100	1306
550514	**38**	90	8,1	9	38	12	50	120	1829

Application:

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



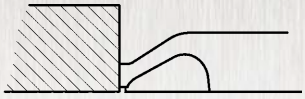




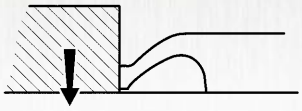
CLAMPING WITH HORIZONTAL PRESSURE:

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

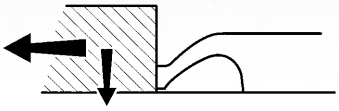
A workpiece is clamped in 3 steps:



Contact:
The flexible clamp elements are positioned against the workpiece.



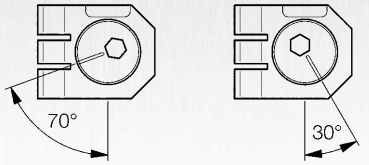
Hold:
The flexible clamp elements push the workpiece down until it comes into contact with the rigid clamping fingers.

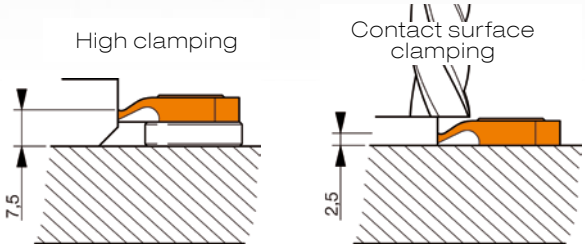


Clamping and positioning:
The rigid clamping finger clamps the workpiece.

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

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





No. 6493SP

Clamping element, horizonal

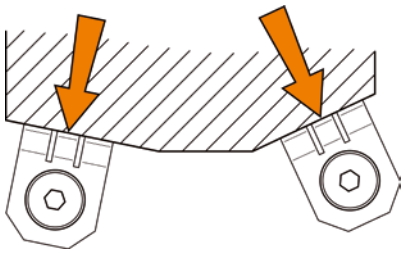
Order no.	Clamping force [N]	Clamping height A [mm]	Stroke Eccentric [mm]	Md Eccentric [Nm]	B	C	D	E	F	Weight [g]
70680	4000	2,5	0,86	9	20	-	5	15	25	29
70698	4000	7,5	0,86	9	20	2,5	10	15	25	29

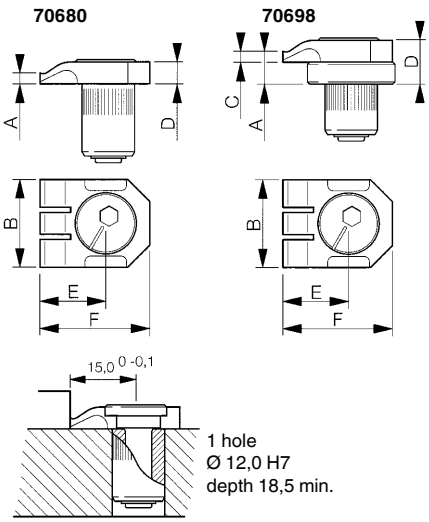
SW of the cam stroke = 4 mm

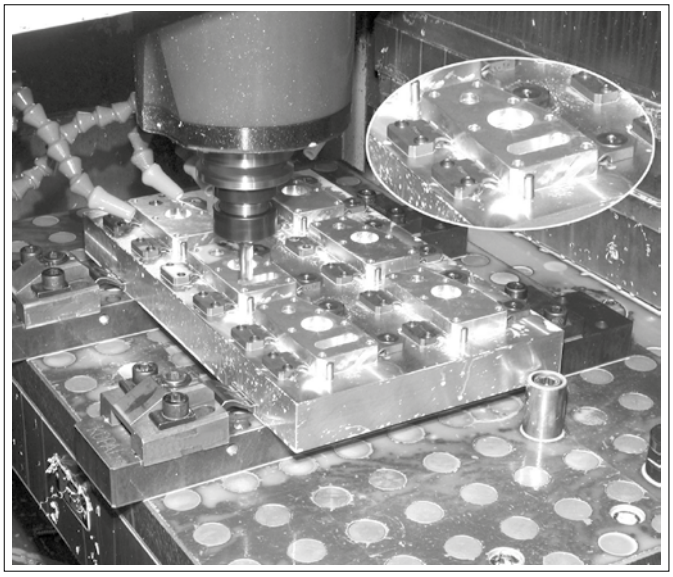


Application:

These hold-down clamps rotate around a camshaft that provides the clamping force. They can clamp in any direction.
Clamping element (1 rigid stop) enables the workpiece to lie flush with the stops.







CAD

Subject to technical alterations.

No. 6493F

Stop, fixed

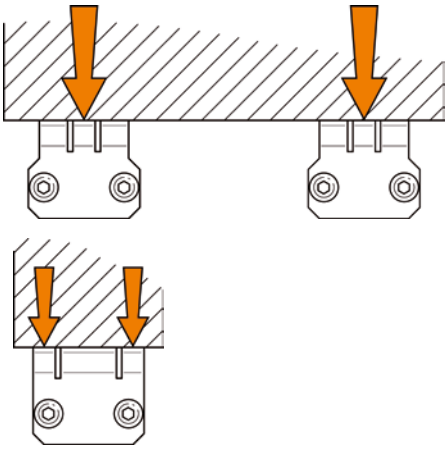
the ground, fixed stops are secured by special screws that guarantee high accuracy during installation.
Size 1 - Simple stop
Size 2 - Double stop

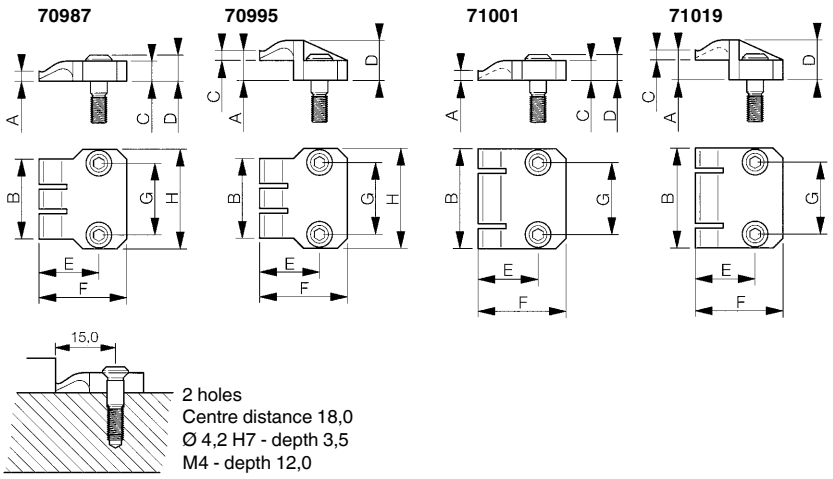
Order no.	Size	Clamping height A [mm]	B	C	D	E	F	G	H	Weight [g]
70987	1	2,5	20	5,0	6,5	15	22	18	25	23
70995	1	7,5	20	2,5	10,0	15	22	18	25	23
71001	2	2,5	25	5,0	6,5	15	22	18	-	23
71019	2	7,5	25	2,5	10,0	15	22	18	-	23

Application:

Size 1 - Single stop (1 rigid stop): Two stops are required to position a workpiece along a straight line.
Size 2 - Double stop (2 rigid stops): One stop is sufficient to position a workpiece along a straight line.



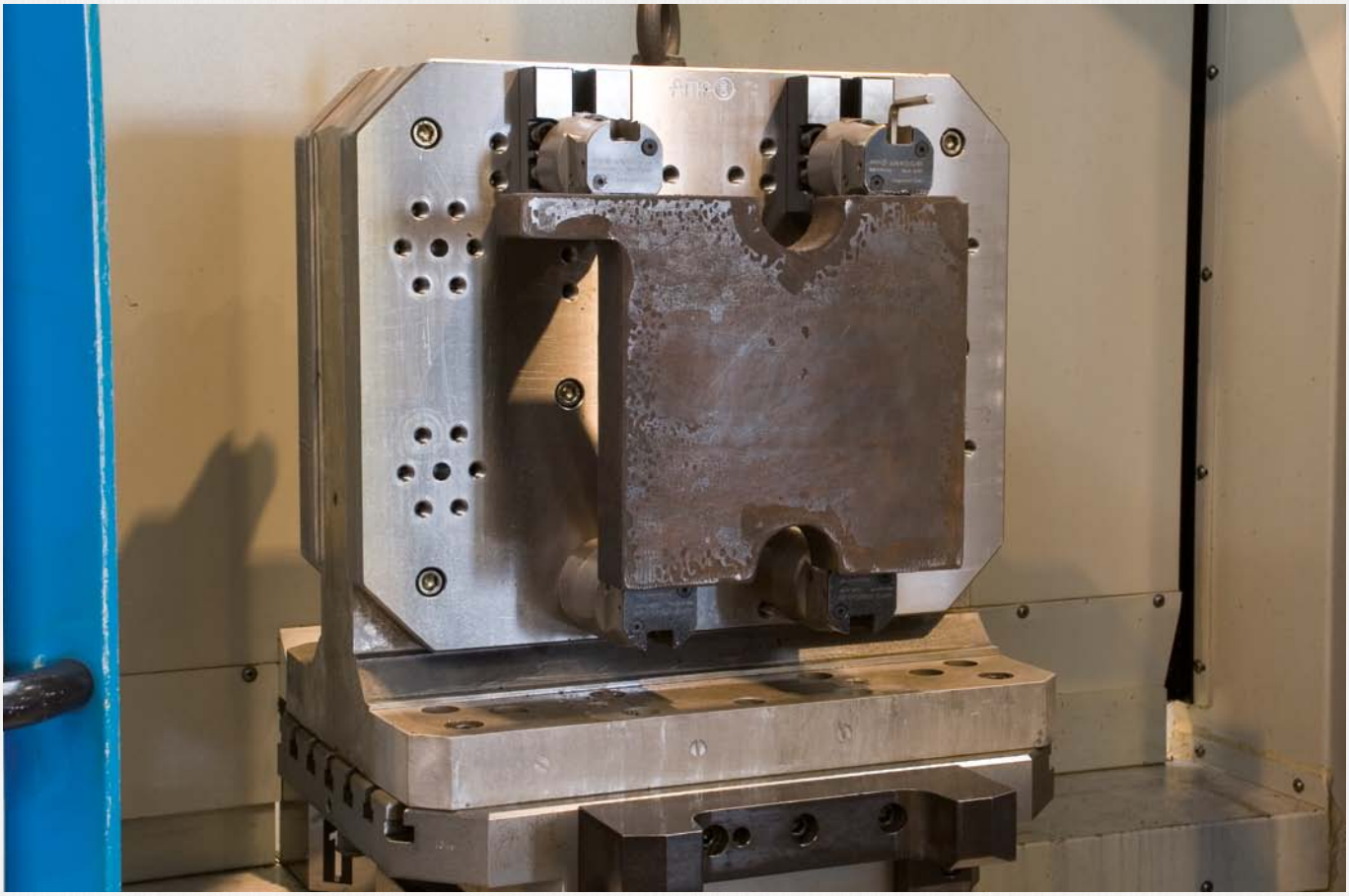


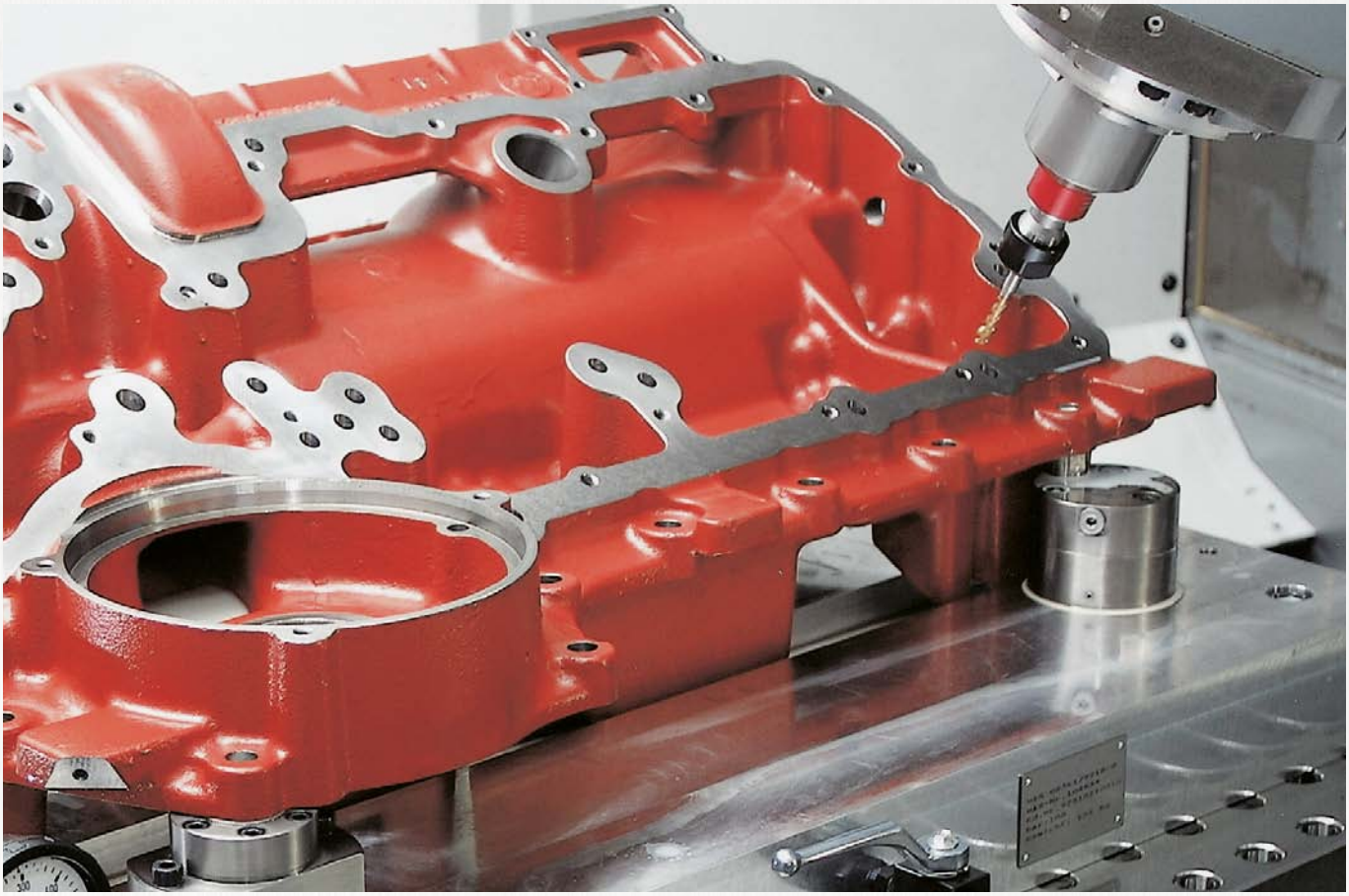


2 holes
Centre distance 18,0
Ø 4,2 H7 - depth 3,5
M4 - depth 12,0

CAD

Subject to technical alterations.





Subject to technical alterations.

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No. 6472

Side clamp with clamping point

(without pull-down action)
Complete with fastening bolts ISO4014 (10.9) and nuts for T-slots DIN508.



Order no.	Size	G	Slot	F1 [kN]	B	H	H1	L	Stroke	Weight [g]
565651	**14**	M10	12	14	40,0	50,0	25,5	85	4	1395
565580	**20**	M12	14	20	47,5	56,0	27,5	98	6	2105
565652	**30**	M16	18	30	67,0	71,5	34,0	134	10	5200

Application:

The mechanical side clamp without pull-down effect can be used as a clamping element and as a stop element.
When used in conjunction with the base plate with slot 6498FT, the side clamp can also be placed across the table slot.

Advantage:

- Compact design
- Can be used horizontally and vertically
- Changeable set screw

Note:

The clamping force is achieved with optimum design and utilisation of the max. tightening torque of the fastening bolts.
If larger T-nuts are used, pay attention to the screw length! Use of the flat sliding block no. 6322A enables the side clamp to be accurately positioned in the machine table groove.
Fastening takes place with a cylinder screw ISO 4762 M6 x 10.
Corresponding set screws:
7110DKX Set screw with ball, smooth
7110DFX Set screw with ball, striated

Recommendations



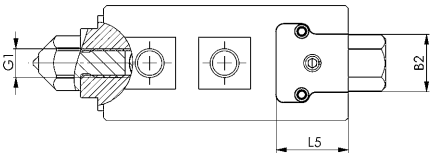
No. 6472DS, page 135

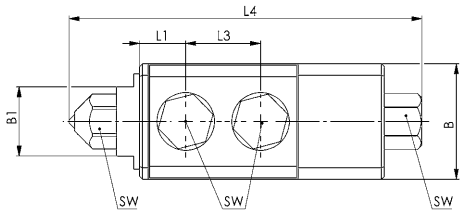


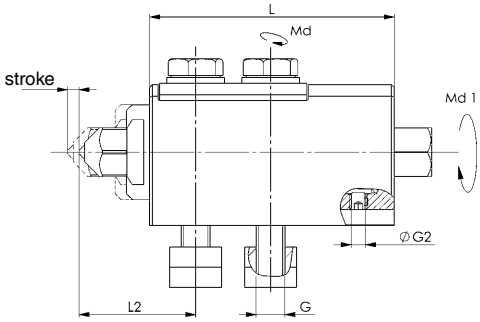
No. 7110DKX-**xM**, page 47

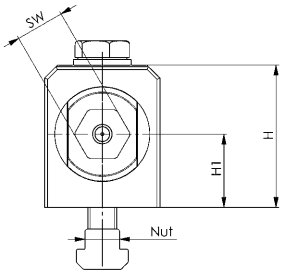


No. 7110DFX-**xM**, page 47









Dimensions:

Order no.	Size	B1	B2	G1	G2	L1	L2	L3	L4	L5	SW	torque Md [Nm]	Tightening torque Md1 [Nm]
565651	**14**	24	20	M10	M6	16,0	40,5 - 44,5	26	122,5 - 126,5	25	17	67	45
565580	**20**	27	20	M12	M6	18,2	43,7 - 50,4	30	139,0 - 146,0	25	19	83	60
565652	**30**	36	20	M16	M6	26,5	60,5 - 70,5	36	189,5 - 199,5	32	24	205	125

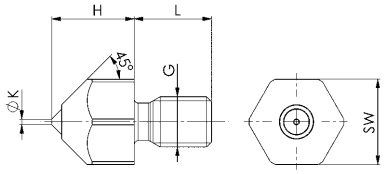
No. 6472DS

Set screw with clamping point for side clamp

Hardened and burnished.



Order no.	Size	G [mm]	H [mm]	dia. K [mm]	L [mm]	SW [mm]	max. load static [kN]	Max. tightening torque [Nm]	Weight [g]
571389	**14**	M10	16,5	1,1	15,5	17	14	46	33
571391	**20**	M12	16,5	1,1	17,5	19	20	82	44
571392	**30**	M16	24,0	1,5	16,0	24	30	206	90



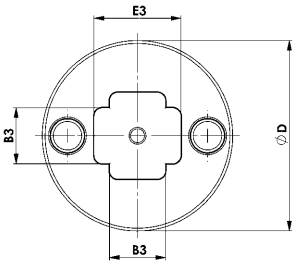
Subject to technical alterations.

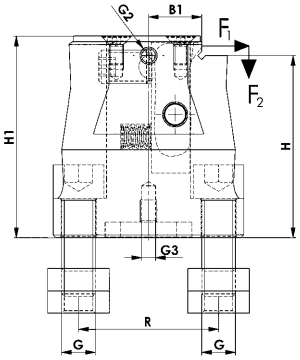
No. 6498

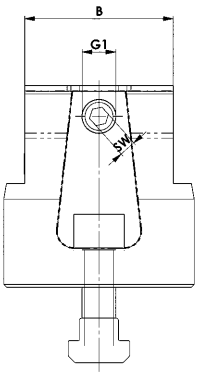
Edge Clamp

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









Order no.	Size	Slot	torque Md [Nm]	H ±0,1	F1 [kN]	F2 [kN]	Weight [g]
73890	M12x14	14	75	65	12	7	1530
375501	M16x18	18	80	75	20	10	2627
374355	M20x22*	22	160	100	25	17	5996

* Not a stock item

Application:

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

Advantage:

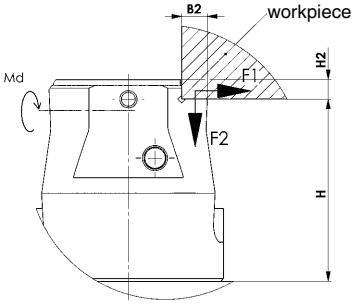
- compact dimensions
- workpiece fastened rigid and secure through pull-down effect
- plate tension increased to make holes and grooves
- lateral plate tension to completely finish surfaces without collision contour
- lateral thread enables a stop to be fastened
- can be used for horizontal and vertical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

Note:

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

On request:

Special versions (dimension H ±0.01) are available.



CAD

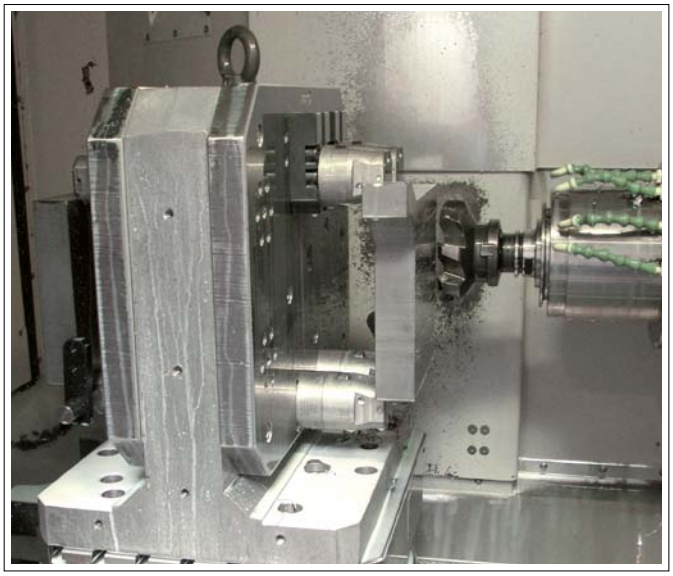
Recommendations



No. 911LG-H100F

Dimensions:

Order no.	Size	B	B1	B2	B3	D +2	E3	G	G1	G2	G3	H1	H2	R	SW
73890	M12x14	53	19,0	9,0	20	68	31,0	M12	M12	M6	M6	72	7	50	6
375501	M16x18	60	20,5	13,5	20	78	25,5	M16	M16	M6	M6	95	20	50	8
374355	M20x22*	88	28,5	18,0	20	108	38,0	M20	M16	M6	M6	118	18	75	10





Subject to technical alterations.

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No. 6498FR

Base plate, round

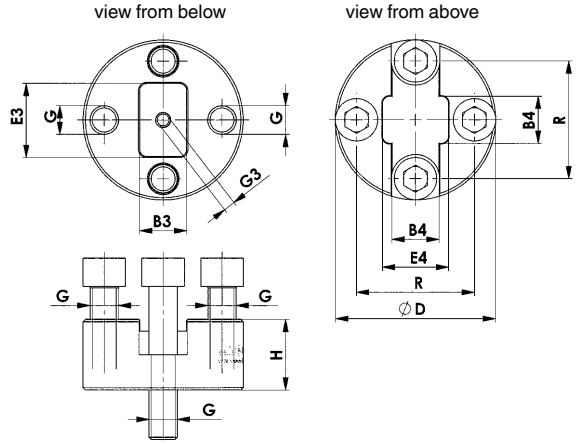
complete with fixing screws. Fastened with screws of strength class 10.9.

Order no.	Size	Slot	H ±0,1	B3	B4	D +2	E3	E4	G	G3	R	Weight [g]
73916	M12x14	14	30	20	18	68	31,0	28,0	M12	M6	50	930
375527	M16x18	18	50	20	18	78	25,5	25,5	M16	M6	50	1780
374371	M20x22 *	22	60	20	22	108	38,5	38,5	M20	M6	75	4680

* Not a stock item



CAD



Application:

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

Advantage:

- Increase in the workpiece mounting surface.

Note:

The flat T-nut no. 6322A-18 (71597) allows the side clamp to be connected exactly to the round base plate. The base plate can be positioned exactly on the machine table using the flat T-nuts 6322A or 6322B.

On request:

Special versions (dimension H ±0.01) are available.

Recommendations



No. 911LG-H100F

No. 6498FT

Base plate with groove

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

Order no.	Size	Slot	H ±0,1	B	E1	E2	G	L	R	Weight [g]
73908	M12x14	14	30	70	40	65	M12	110	50	1330
375543	M16x18	18	50	125	40	90	M16	130	100	4864
374397	M20x22 *	22	60	120	75	150	M20	200	85	7614

* Not a stock item



Application:

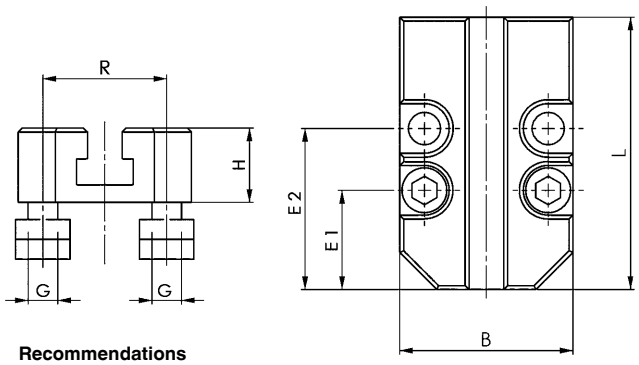
Used in conjunction with side clamp no. 6498 to also clamp across the table groove.

Advantage:

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

On request:

Special versions (dimension H ±0.01) are available.

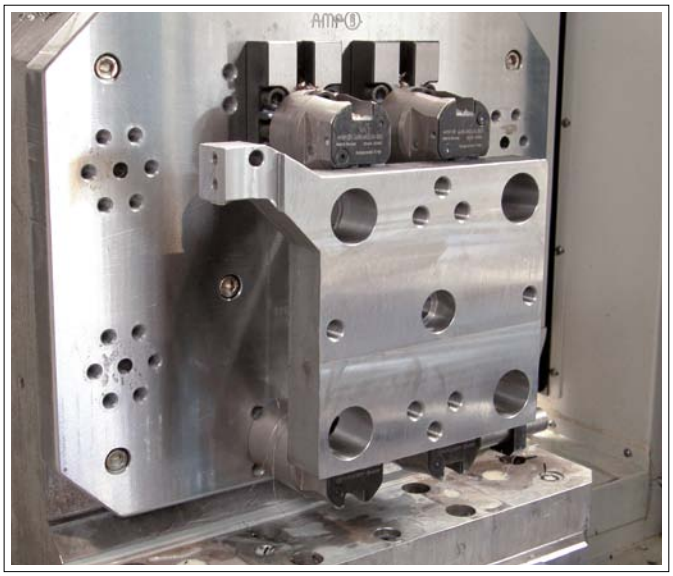


Recommendations



No. 911LG-H100F

CAD



Subject to technical alterations.

No. 6495

T-slot clamp

complete with mounting.
Steel, tempered and burnished.



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

Application:

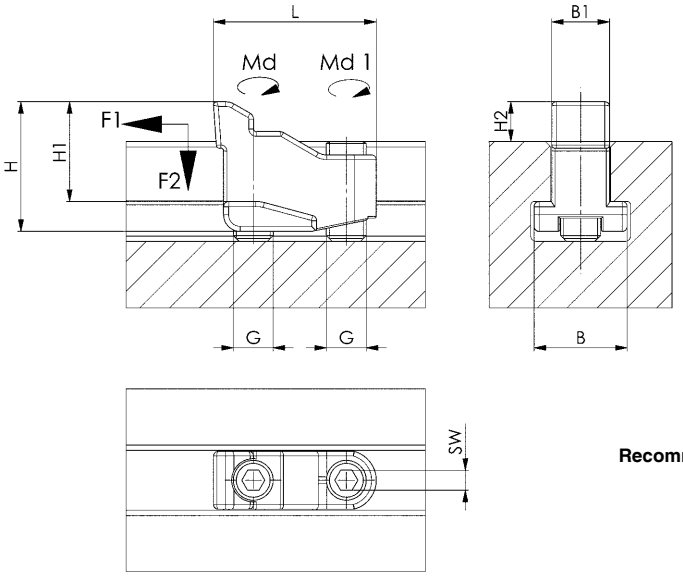
1. Slide T-slot clamp into T-slot of the machine table.
2. Position on workpiece.
3. Secure fastening bolt for machine table.
4. Actuating the clamping bolt clamps the workpiece.

Advantage:

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

Note:

- To reduce the wear on the fastening bolt, we recommend using AMF screw compound 6339. It possesses a synergistic combination of highly-effective solid lubricants and is heat-resistant and does not wash out.
- Use the associated AMF fastening bolt 6495S.



Recommendations



No. 911LG-H100F

Dimensions:

Order no.	Size	B	B1	G	H	H1	L	Md [Nm]	Md 1 [Nm]
374140	12	22	13,6	M10	31	24	40	18	9
374132	16	28	17,4	M12	39	30	49	32	15
374124	20	35	21,5	M16	50	37	63	75	35

CAD

No. 6495S

Fastening bolt for T-slot clamp

Strength class 10.9



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

Subject to technical alterations.

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No. 6496

Flat clamp

Complete with mounting.
Steel, tempered and burnished.



Order no.	Size	Slot	G	F1 [kN]	F2 [kN]	H min. [mm]	H max. [mm]	Weight [g]
374157	**M12x14**	14	M12	15	7,5	16	25	579
374165	**M12x16**	16	M12	15	7,5	16	25	600
374173	**M16x18**	18	M16	25	12,5	19	30	1011
374181	**M16x20**	20	M16	25	12,5	19	30	1055
374199	**M20x22**	22	M20	36	18,0	22	36	1670
374207	**M20x24**	24	M20	36	18,0	22	36	1705
374215	**M20x28**	28	M20	36	18,0	22	36	1807

Application:

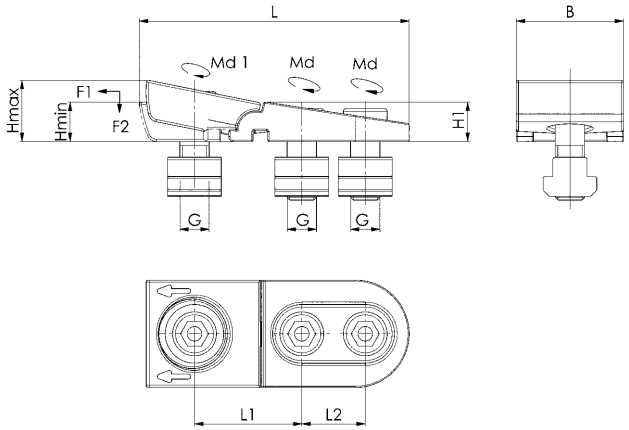
1. Slide flat clamp into T-groove of the machine table.
2. Position on workpiece.
3. Secure fastening bolts for machine table.
4. Actuating the clamping bolt clamps the workpiece.

Advantage:

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

Note:

- To reduce the wear on the fastening bolts, we recommend using AMF screw compound 6339. It possesses a synergistic combination of highly-effective solid lubricants and is heat-resistant and does not wash out.
- Use only the corresponding AMF mounting kit 6496BF.



Dimensions:

Order no.	Size	B	H1	L	L1 min.	L1 max.	L2	Md [Nm]	Md 1 [Nm]
374157	**M12x14**	44	16	110	45	48	26	65	52
374165	**M12x16**	44	16	110	45	48	26	65	52
374173	**M16x18**	56	19	130	50	54	33	150	120
374181	**M16x20**	56	19	130	50	54	33	150	120
374199	**M20x22**	62	22	152	58	63	41	300	240
374207	**M20x24**	62	22	152	58	63	41	300	240
374215	**M20x28**	62	22	152	58	63	41	300	240

CAD

No. 6496BF

Mounting kit for flat clamp

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



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

CAD

Recommendations



No. 911LG-H100F

Subject to technical alterations.

ABOUT ALIGNING AND POSITIONING

- **Design:** The skilfull graduation of sizes to DIN series figures allows for numerous combinations.
- **Quality:** AMF-parallels guarantee for long life due to their high wear resistance.
- **The right quality for any application:** Our parallel washers are available in three quality levels:

Standard	★
Precision	★★
Super-precision	★★★

AMF-parallels are used as packing blocks, stops or distance pieces on machine tools. They are indispensable for the parallel support of components in machine vices and on surface plastes.

- AMF parallel washers, stops and power clamp being used for drilling a base plate.



DIN 6346

Parallel supports-set

In wooden box with detachable folding lid.
Plain parallel, fine-ground, in pairs.
Size data on the product.
Case-hardened.

Pair tolerance in height tp2 and width tp1 to IT 5.
Rated dimensional tolerance in height and width to DIN ISO 2768m.
Remaining dimensions to DIN ISO 2768m.

Geometrical graduation enables full use of the support height.
2.5 - 25 mm over 40 different heights 2.5 - 45 mm
4 - 32 mm over 40 different heights 4 - 57 mm
4 - 40 mm over 40 different heights 4 - 72 mm
8 - 50 mm over 30 different heights 8 - 90 mm
8 - 63 mm over 40 different heights 8 - 113 mm
20 - 100 mm over 14 different heights 20 - 180 mm.

★★★



Order no.	Size	Pair	Case L x B x H	Weight [Kg]
72322	2,5-25	9	200x100x 36	1,3
72330	4-40	7	305x115x 50	3,8
72348	8-63	5	305x115x 70	7,4
72355	20-100	3	280x215x125	27,1
72165	4-32	5	132x145x 50	1,5
72173	8-50	4	192x158x 75	4,9

Note:

Workshop sets
Size 2.5-25 including (BxHxL):
2.5x8x63 / 3.2x10x63 / 4.0x12x63 / 5.0x16x63 / 6.3x20x63 / 4.0x12x100 / 5.0x16x100 / 6.3x20x100 / 8.0x25x100 mm
Size 4.0-40 including (BxHxL):
4.0x12x100 / 5.0x16x100 / 6.3x20x100 / 8.0x25x100 / 8.0x25x160 / 10.0x32x160 / 12.0x40x160 mm
Size 8.0-63 including (BxHxL):
8.0x25x100 / 10.0x32x100 / 12.0x40x100 / 16.0x50x160 / 20.0x63x160 mm
Size 20-100 including (BxHxL):
20.0x63x250 / 25.0x80x250 / 32.0x100x250 mm

Vice sets
Size 4.0-32 including (BxHxL):
4.0x12x100 / 5.0x16x100 / 6.3x20x100 / 8.0x25x100 / 10.0x32x100 mm
Size 8.0-50 including (BxHxL):
8.0x25x160 / 10.0x32x160 / 12.0x40x160 / 16.0x50x160 mm

DIN 6346P

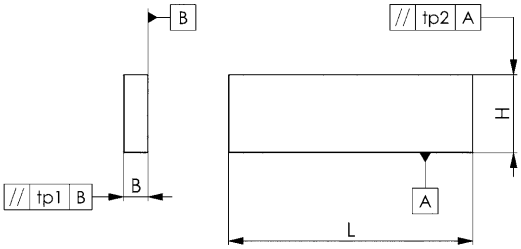
Parallel supports-pairs

Plain parallel, fine-ground, in pairs.
Size data on the product.
Case-hardened.

Pair tolerance in height tp2 and width tp1 to IT 5.
Rated dimensional tolerance in height and width to DIN ISO 2768m.
Remaining dimensions to DIN ISO 2768m.

★★★





Order no.	H	B	L	Pair tolerance (tp1 / /tp2)	Weight [g]
75309	8	2,5	63	IT5	20
75317	10	3,2	63	IT5	30
75325	12	4,0	63	IT5	45
75333	16	5,0	63	IT5	80
75341	20	6,3	63	IT5	125
72181	12	4,0	100	IT5	75
72199	16	5,0	100	IT5	125
72207	20	6,3	100	IT5	200
72215	25	8,0	100	IT5	315
72223	32	10,0	100	IT5	500
72231	40	12,0	100	IT5	750
72249	25	8,0	160	IT5	500
72256	32	10,0	160	IT5	800
72264	40	12,0	160	IT5	1200
72272	50	16,0	160	IT5	2000
72280	63	20,0	160	IT5	3170
72298	63	20,0	250	IT5	4950
72306	80	25,0	250	IT5	7900
72314	100	32,0	250	IT5	12680
72363	100	40,0	400	IT5	25300

CAD

Subject to technical alterations.

No. 6347

Parallel support set in wooden box

with 14 pairs of parallel supports.
Plain parallel, finely ground, in pairs.
Case-hardened.



Order no.	Quality level	H	H Rated dimensional tolerance	H Pair tolerance (tp)	B	L	Case [mm]	Weight [Kg]
558279	SP	14, 16, 18, 20, 22, 24, 26, 28, 30, 32, 35, 40, 45, 50	±0,004	0,004	10	150	435 x 200 x 64	10,9
558280	P	14, 16, 18, 20, 22, 24, 26, 28, 30, 32, 35, 40, 45, 50	±0,01	0,01	10	150	435 x 200 x 64	10,9
558281	S	14, 16, 18, 20, 22, 24, 26, 28, 30, 32, 35, 40, 45, 50	2768 - m	0,01	10	150	435 x 200 x 64	10,9

Design:

Content per 1 pair (WxH):
10x14 / 10x16 / 10x18 / 10x22 / 10x24 / 10x26 / 10x28 / 10x30 / 10x32 / 10x35 / 10x40 / 10x45 / 10x50 mm.

Quality level:
SP = Super-precision, P = Precision, S = Standard

Application:

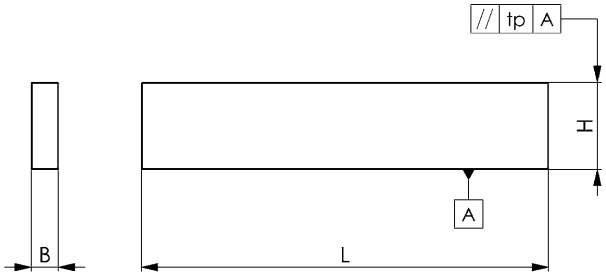
These documents are used as washers for workpieces exposed to diverse machining processes. The high precision of the parallel washers guarantees parallel workpiece clamping.

Advantage:

- high wear resistance and long service life
- wooden box with removable lid for perfect handling at the workplace and safe storage
- different quality levels for any application

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on the product.



Optimised wooden case for perfect handling!

Subject to technical alterations.

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No. 6347PSP

Parallel supports-pairs, super-precision

Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Super-precision ***

★★★



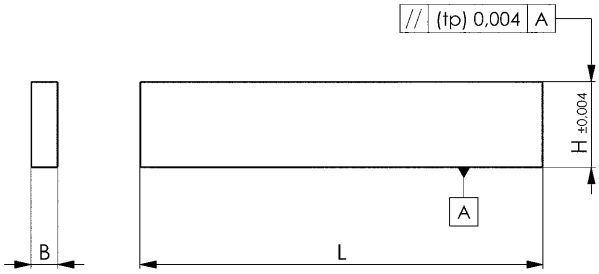
Order no.	H Rated dimensional tolerance ±0.004	H Pair tolerance (tp)	B	L	Weight [g]
75473	14	0,004	10	150	330
75481	16	0,004	10	150	380
75499	18	0,004	10	150	420
75507	20	0,004	10	150	470
75515	22	0,004	10	150	520
75523	24	0,004	10	150	570
75531	26	0,004	10	150	610
75549	28	0,004	10	150	660
75556	30	0,004	10	150	710
75564	32	0,004	10	150	750
75572	35	0,004	10	150	830
75580	40	0,004	10	150	940
75291	45	0,004	10	150	1060
75283	50	0,004	10	150	1180

Application:

These documents are used as washers for workpieces exposed to diverse machining processes. The high precision of the parallel washers guarantees parallel workpiece clamping.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on the product.



CAD

No. 6347PP

Parallel supports-pairs, precision

Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Precision **

★★



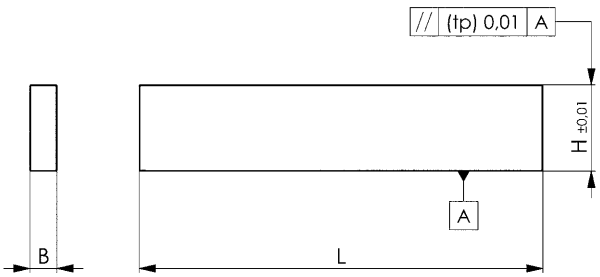
Order no.	H Rated dimensional tolerance ±0.01	H Pair tolerance (tp)	B	L	Weight [g]
370684	14	0,01	10	150	330
370692	16	0,01	10	150	380
370700	18	0,01	10	150	420
370718	20	0,01	10	150	470
370726	22	0,01	10	150	520
370734	24	0,01	10	150	570
370742	26	0,01	10	150	610
370759	28	0,01	10	150	660
370767	30	0,01	10	150	710
370775	32	0,01	10	150	750
370783	35	0,01	10	150	830
370791	40	0,01	10	150	940
370809	45	0,01	10	150	1060
370817	50	0,01	10	150	1180

Application:

These documents are used as washers for workpieces exposed to diverse machining processes.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on the product.



CAD

Subject to technical alterations.

No. 6347PS

Parallel supports-pairs, standard

Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Standard *



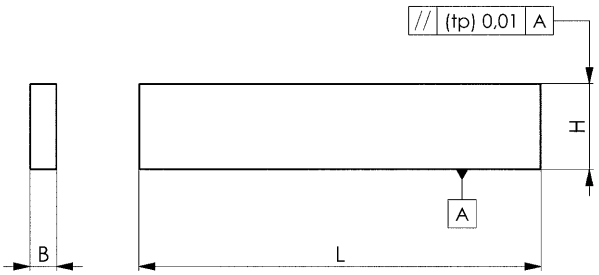
Order no.	H Rated dimensional tolerance DIN ISO 2768 - m	H Pair tolerance (tp)	B	L	Weight [g]
370825	14	0,01	10	150	330
370833	16	0,01	10	150	380
370841	18	0,01	10	150	420
370858	20	0,01	10	150	470
370866	22	0,01	10	150	520
370874	24	0,01	10	150	570
370882	26	0,01	10	150	610
370890	28	0,01	10	150	660
370908	30	0,01	10	150	710
370916	32	0,01	10	150	750
370924	35	0,01	10	150	830
370932	40	0,01	10	150	940
370940	45	0,01	10	150	1060
370957	50	0,01	10	150	1180

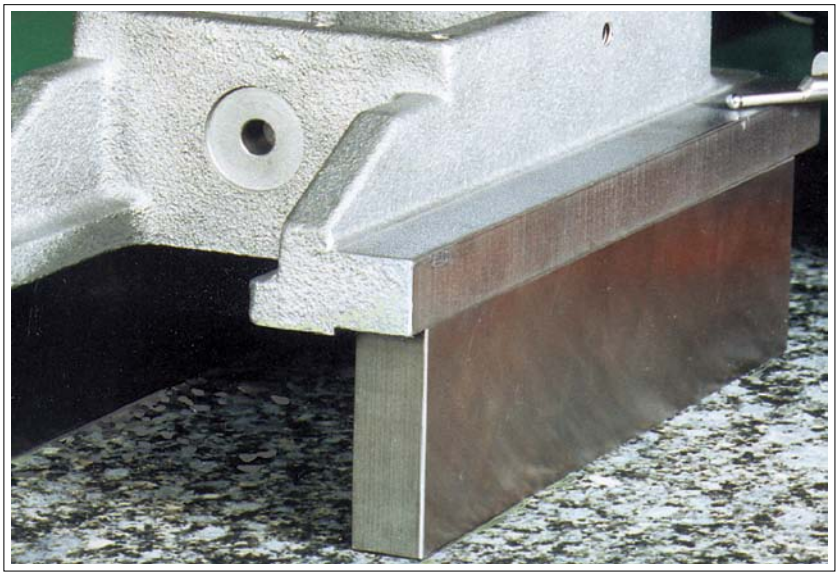
Application:

These documents are used as washers for workpieces exposed to diverse machining processes.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on the product.





CAD

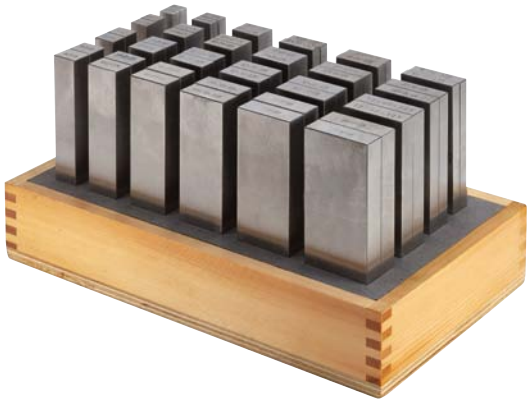
Subject to technical alterations.

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No. 6348

Parallel support set in wooden stand

Plain parallel, finely ground, in pairs.
Case-hardened.



Order no.	Quality level	Size	Pair	H Rated dimensional tolerance	H Pair tolerance (tp)	B Rated dimensional tolerance	L	Box LK x WK x HK [mm]	Weight [Kg]
75606	SP	100	20	±0,01	IT5	±0,01	100	142x123x56	2,2
75614	SP	125	24	±0,01	IT5	±0,01	125	276x162x55	14
75648	SP	150	24	±0,01	IT5	±0,01	150	276x162x55	17
371062	P	100	20	±0,01	IT5	2768 - m	100	142x123x56	2,2
371070	P	125	24	±0,01	IT5	2768 - m	125	276x162x55	14
371088	P	150	24	±0,01	IT5	2768 - m	150	276x162x55	17
371096	S	100	20	2768 - m	IT5	2768 - m	100	142x123x56	2,2
371104	S	125	24	2768 - m	IT5	2768 - m	125	276x162x55	14
371112	S	150	24	2768 - m	IT5	2768 - m	150	276x162x55	17

Design:

Size 100, content per 1 pair (WxH):
2x5 / 2x10/ 2x15/ 2x20/ 3x6 / 3x11 / 3x16 / 3x21 / 4x7 / 4x12 / 4x17 / 4x22 / 5x8 / 5x13 / 5x18 / 5x23 / 6x9 / 6x14 / 6x19 / 6x24 mm

Size 125 and 150, content per 1 pair (WxH):
8x11 / 8x16 / 8x21 / 8x26 / 8x31 / 8x36 / 10x13 / 10x18 / 10x23 / 10x28 / 10x33 / 10x38 / 12x15 / 12x20 / 12x25 / 12x30 / 12x35 / 12x40 / 14x17 / 14x22 / 14x27 / 14x32 / 14x37 / 14x42 mm

Quality level:
SP = Super-precision, P = Precision, S = Standard

Application:

These documents are used as washers for workpieces exposed to diverse machining processes. The high precision of the parallel washers guarantees parallel workpiece clamping.

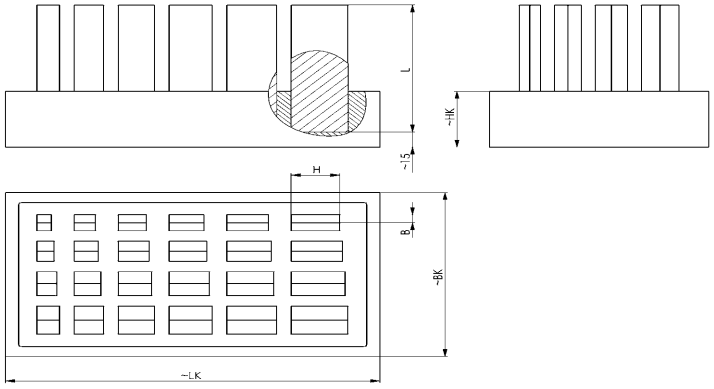
Advantage:

- high wear resistance and long service life
- wooden box for perfect handling at the workplace and safe storage
- different quality levels for any application

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on front of product.





Subject to technical alterations.

No. 6348PSP

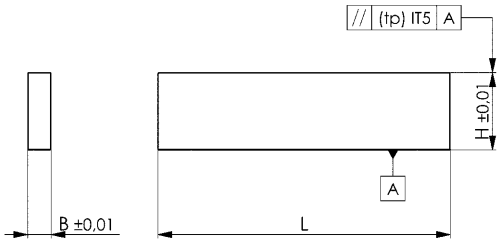
Parallel supports-pairs, super-precision, 100 mm long

Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Super-precision ***

★★★



Order no.	H Rated dimensional tolerance ±0.01	H Pair tolerance (tp)	B Rated dimensional tolerance ±0.01	L	Weight [g]
370007	5	IT5	2	100	16
370015	10	IT5	2	100	31
370023	15	IT5	2	100	47
370031	20	IT5	2	100	62
370049	6	IT5	3	100	28
370056	11	IT5	3	100	51
370064	16	IT5	3	100	75
370072	21	IT5	3	100	98
370080	7	IT5	4	100	44
370098	12	IT5	4	100	75
370106	17	IT5	4	100	106
370114	22	IT5	4	100	137
370122	8	IT5	5	100	62
370130	13	IT5	5	100	101
370148	18	IT5	5	100	140
370155	23	IT5	5	100	179
370163	9	IT5	6	100	84
370171	14	IT5	6	100	131
370189	19	IT5	6	100	178
370197	24	IT5	6	100	224



Application:

These documents are used as washers for workpieces exposed to diverse machining processes. The high precision of the parallel washers guarantees parallel workpiece clamping.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on the product.

CAD

No. 6348PSP

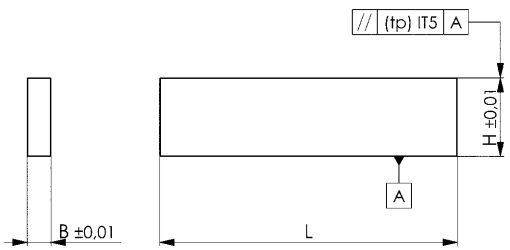
Parallel supports-pairs, super-precision, 125 mm long

Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Super-precision ***

★★★



Order no.	H Rated dimensional tolerance ±0.01	H Pair tolerance (tp)	B Rated dimensional tolerance ±0.01	L	Weight [g]
370205	11	IT5	8	125	171
370213	16	IT5	8	125	249
370221	21	IT5	8	125	326
370239	26	IT5	8	125	404
370247	31	IT5	8	125	482
370254	36	IT5	8	125	561
370262	13	IT5	10	125	253
370270	18	IT5	10	125	351
370288	23	IT5	10	125	448
370296	28	IT5	10	125	545
370304	33	IT5	10	125	642
370312	38	IT5	10	125	741
370320	15	IT5	12	125	350
370338	20	IT5	12	125	466
370346	25	IT5	12	125	583
370353	30	IT5	12	125	700
370361	35	IT5	12	125	817
370379	40	IT5	12	125	933
370387	17	IT5	14	125	462
370395	22	IT5	14	125	599
370403	27	IT5	14	125	734
370411	32	IT5	14	125	871
370429	37	IT5	14	125	1009
370437	42	IT5	14	125	1144



Application:

These documents are used as washers for workpieces exposed to diverse machining processes. The high precision of the parallel washers guarantees parallel workpiece clamping.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on the product.

CAD

Subject to technical alterations.

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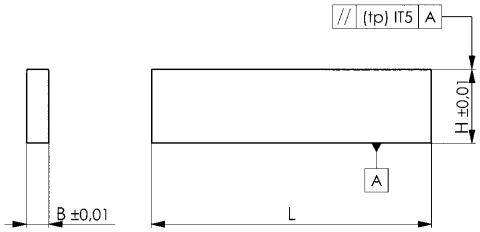
No. 6348PSP

Parallel supports-pairs, super-precision, 150 mm long

Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Super-precision ***

★★★





Order no.	H Rated dimensional tolerance ±0.01	H Pair tolerance (tp)	B Rated dimensional tolerance ±0.01	L	Weight [g]
370445	11	IT5	8	150	203
370452	16	IT5	8	150	295
370460	21	IT5	8	150	389
370478	26	IT5	8	150	482
370486	31	IT5	8	150	574
370494	36	IT5	8	150	668
370502	13	IT5	10	150	300
370510	18	IT5	10	150	417
370528	23	IT5	10	150	533
370536	28	IT5	10	150	649
370544	33	IT5	10	150	768
370551	38	IT5	10	150	884
370569	15	IT5	12	150	416
370577	20	IT5	12	150	556
370585	25	IT5	12	150	694
370593	30	IT5	12	150	835
370601	35	IT5	12	150	974
370619	40	IT5	12	150	1113
370627	17	IT5	14	150	550
370635	22	IT5	14	150	714
370643	27	IT5	14	150	879
370650	32	IT5	14	150	1040
370668	37	IT5	14	150	1203
370676	42	IT5	14	150	1369

Application:

These documents are used as washers for workpieces exposed to diverse machining processes. The high precision of the parallel washers guarantees parallel workpiece clamping.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on the product.

CAD

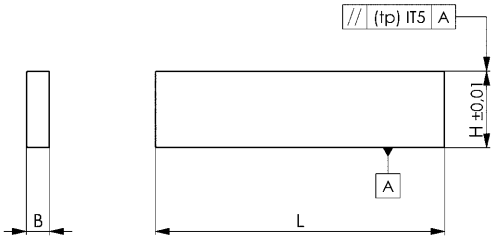
No. 6348PP

Parallel supports-pairs, precision, 100 mm long

Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Precision **

★★





Order no.	H Rated dimensional tolerance ±0.01	H Pair tolerance (tp)	B	L	Weight [g]
371120	5	IT5	2	100	16
371138	10	IT5	2	100	31
371146	15	IT5	2	100	47
371153	20	IT5	2	100	62
371161	6	IT5	3	100	28
371179	11	IT5	3	100	51
371187	16	IT5	3	100	75
371195	21	IT5	3	100	98
371203	7	IT5	4	100	44
371211	12	IT5	4	100	75
371229	17	IT5	4	100	106
371237	22	IT5	4	100	137
371245	8	IT5	5	100	62
371252	13	IT5	5	100	101
371260	18	IT5	5	100	140
371278	23	IT5	5	100	179
371286	9	IT5	6	100	84
371294	14	IT5	6	100	131
371302	19	IT5	6	100	178
371310	24	IT5	6	100	224

Application:

These documents are used as washers for workpieces exposed to diverse machining processes.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on front of product.

CAD

Subject to technical alterations.

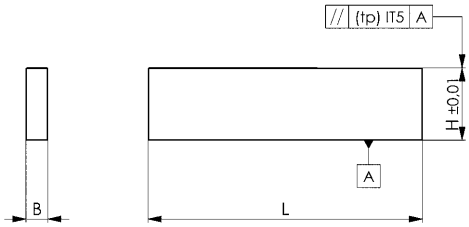
No. 6348PP

Parallel supports-pairs, precision, 125 mm long

Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Precision **

★★





Order no.	H Rated dimensional tolerance ±0.01	H Pair tolerance (tp)	B	L	Weight [g]
371328	11	IT5	8	125	171
371336	16	IT5	8	125	249
371344	21	IT5	8	125	326
371351	26	IT5	8	125	404
371369	31	IT5	8	125	482
371377	36	IT5	8	125	561
371385	13	IT5	10	125	253
371393	18	IT5	10	125	351
371401	23	IT5	10	125	448
371419	28	IT5	10	125	545
371427	33	IT5	10	125	642
371435	38	IT5	10	125	741
371443	15	IT5	12	125	350
371450	20	IT5	12	125	466
371468	25	IT5	12	125	583
371476	30	IT5	12	125	700
371484	35	IT5	12	125	817
371492	40	IT5	12	125	933
371500	17	IT5	14	125	462
371518	22	IT5	14	125	599
371526	27	IT5	14	125	734
371534	32	IT5	14	125	871
371542	37	IT5	14	125	1009
371559	42	IT5	14	125	1144

Application:

These documents are used as washers for workpieces exposed to diverse machining processes.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on front of product.

CAD

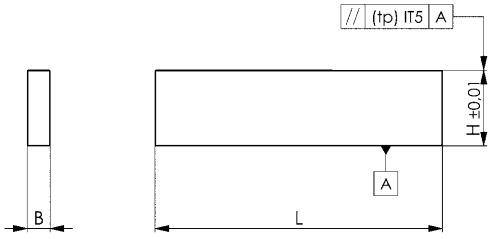
No. 6348PP

Parallel supports-pairs, precision, 150 mm long

Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Precision **

★★





Order no.	H Rated dimensional tolerance ±0.01	H Pair tolerance (tp)	B	L	Weight [g]
372243	11	IT5	8	150	203
372250	16	IT5	8	150	295
372268	21	IT5	8	150	389
372276	26	IT5	8	150	482
372284	31	IT5	8	150	574
372292	36	IT5	8	150	668
372300	13	IT5	10	150	300
372318	18	IT5	10	150	417
372326	23	IT5	10	150	533
372334	28	IT5	10	150	649
372342	33	IT5	10	150	768
372359	38	IT5	10	150	884
372367	15	IT5	12	150	416
372375	20	IT5	12	150	556
372383	25	IT5	12	150	694
372391	30	IT5	12	150	835
372409	35	IT5	12	150	974
372417	40	IT5	12	150	1113
372425	17	IT5	14	150	550
372433	22	IT5	14	150	714
372441	27	IT5	14	150	879
372458	32	IT5	14	150	1040
372466	37	IT5	14	150	1203
372474	42	IT5	14	150	1369

Application:

These documents are used as washers for workpieces exposed to diverse machining processes.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on front of product.

CAD

Subject to technical alterations.

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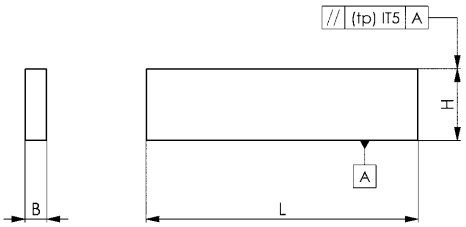
No. 6348PS

Parallel supports-pairs, standard, 100 mm long

Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Standard *



Order no.	H Rated dimensional tolerance DIN ISO 2768 - m	H Pair tolerance (tp)	B	L	Weight [g]
371807	5	IT5	2	100	16
371815	10	IT5	2	100	31
371823	15	IT5	2	100	47
371831	20	IT5	2	100	62
371849	6	IT5	3	100	28
371856	11	IT5	3	100	51
371864	16	IT5	3	100	75
371872	21	IT5	3	100	98
371880	7	IT5	4	100	44
371898	12	IT5	4	100	75
371906	17	IT5	4	100	106
371914	22	IT5	4	100	137
371922	8	IT5	5	100	62
371930	13	IT5	5	100	101
371948	18	IT5	5	100	140
371955	23	IT5	5	100	179
371963	9	IT5	6	100	84
371971	14	IT5	6	100	131
371989	19	IT5	6	100	178
371997	24	IT5	6	100	224



Application:

These documents are used as washers for workpieces exposed to diverse machining processes.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on front of product.

CAD

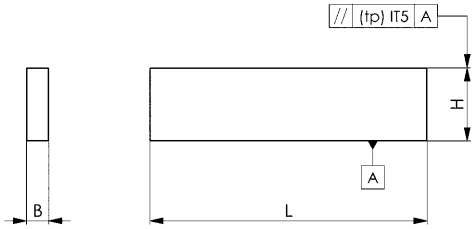
No. 6348PS

Parallel supports-pairs, standard, 125 mm long

Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Standard *



Order no.	H Rated dimensional tolerance DIN ISO 2768 - m	H Pair tolerance (tp)	B	L	Weight [g]
372003	11	IT5	8	125	171
372011	16	IT5	8	125	249
372029	21	IT5	8	125	326
372037	26	IT5	8	125	404
372045	31	IT5	8	125	482
372052	36	IT5	8	125	561
372060	13	IT5	10	125	253
372078	18	IT5	10	125	351
372086	23	IT5	10	125	448
372094	28	IT5	10	125	545
372102	33	IT5	10	125	642
372110	38	IT5	10	125	741
372128	15	IT5	12	125	350
372136	20	IT5	12	125	466
372144	25	IT5	12	125	583
372151	30	IT5	12	125	700
372169	35	IT5	12	125	817
372177	40	IT5	12	125	933
372185	17	IT5	14	125	462
372193	22	IT5	14	125	599
372201	27	IT5	14	125	734
372219	32	IT5	14	125	871
372227	37	IT5	14	125	1009
372235	42	IT5	14	125	1144



Application:

These documents are used as washers for workpieces exposed to diverse machining processes.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on front of product.

CAD

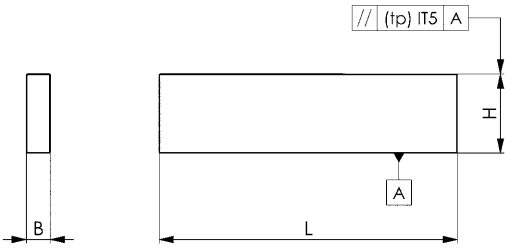
Subject to technical alterations.

No. 6348PS

Parallel supports-pairs, standard, 150 mm long

Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Standard *





Order no.	H Rated dimensional tolerance DIN ISO 2768 - m	H Pair tolerance (tp)	B	L	Weight [g]
371567	11	IT5	8	150	203
371575	16	IT5	8	150	295
371583	21	IT5	8	150	389
371591	26	IT5	8	150	482
371609	31	IT5	8	150	574
371617	36	IT5	8	150	668
371625	13	IT5	10	150	300
371633	18	IT5	10	150	417
371641	23	IT5	10	150	533
371658	28	IT5	10	150	649
371666	33	IT5	10	150	768
371674	38	IT5	10	150	884
371682	15	IT5	12	150	416
371690	20	IT5	12	150	556
371708	25	IT5	12	150	694
371716	30	IT5	12	150	835
371724	35	IT5	12	150	974
371732	40	IT5	12	150	1113
371740	17	IT5	14	150	550
371757	22	IT5	14	150	714
371765	27	IT5	14	150	879
371773	32	IT5	14	150	1040
371781	37	IT5	14	150	1203
371799	42	IT5	14	150	1369

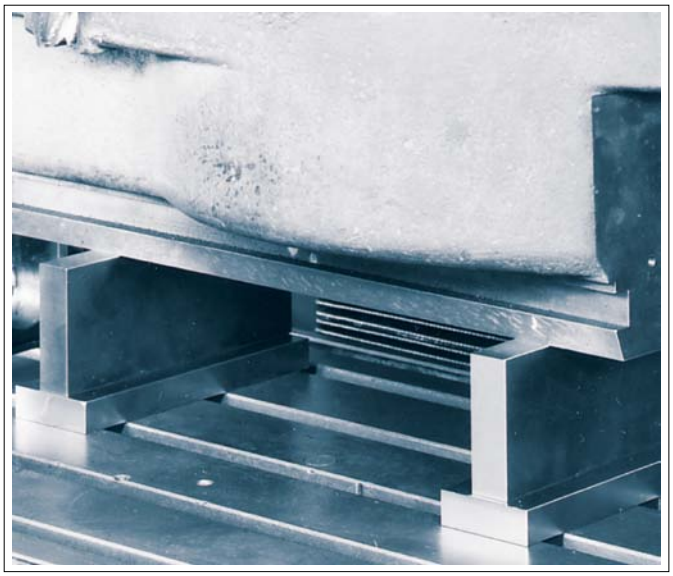
Application:

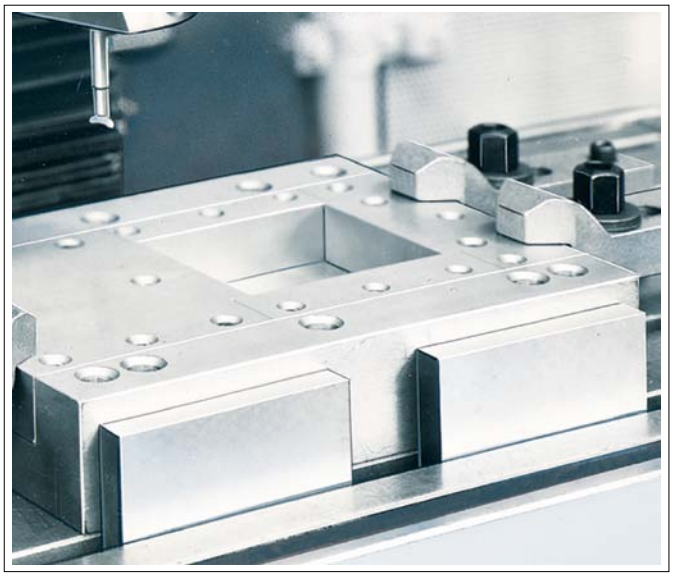
These documents are used as washers for workpieces exposed to diverse machining processes.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on front of product.

CAD





Subject to technical alterations.

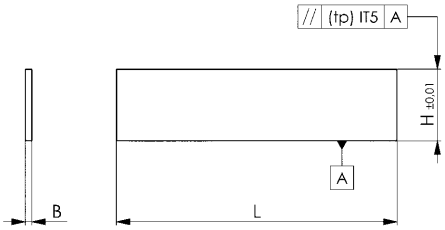
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No. 6349PP

Parallel supports-pairs, precision

Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Precision **





Order no.	H Rated dimensional tolerance ±0.01	H Pair tolerance (tp)	B	L	Weight [g]
372508	11	IT5	3	125	64
372516	12	IT5	3	125	70
372524	13	IT5	3	125	76
372532	14	IT5	3	125	82
372540	15	IT5	3	125	88
372557	16	IT5	3	125	94
372565	17	IT5	3	125	100
372573	18	IT5	3	125	106
372581	19	IT5	3	125	112
372599	20	IT5	3	125	118
372607	21	IT5	3	125	124
372615	22	IT5	3	125	130
372623	23	IT5	3	125	136
372631	24	IT5	3	125	142
372649	25	IT5	3	125	148
372656	26	IT5	3	125	154
372664	27	IT5	3	125	160
372672	28	IT5	3	125	164
372680	29	IT5	3	125	170
372698	30	IT5	3	125	176
372706	31	IT5	3	125	182
372714	32	IT5	3	125	188
372722	33	IT5	3	125	194
372730	34	IT5	3	125	200
372748	35	IT5	3	125	206
372755	36	IT5	3	125	212
372763	37	IT5	3	125	218
372771	38	IT5	3	125	224
372789	39	IT5	3	125	230
372797	40	IT5	3	125	236
372805	41	IT5	3	125	242
372813	42	IT5	3	125	248

Application:

These documents are used as washers for workpieces exposed to diverse machining processes.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on front of product.

CAD

Subject to technical alterations.

No. 6349P

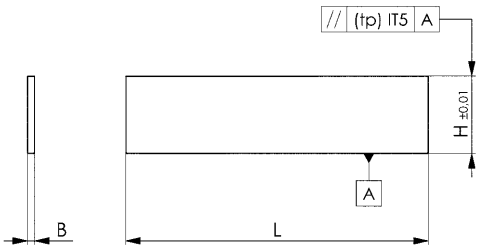
Parallel supports-pairs, precision

In wooden stand.
Plain parallel, finely ground, in pairs.
Case-hardened.
Quality level: Precision **

★★

Order no.	Size	Pair	H Rated dimensional tolerance ±0.01	H Pair tolerance (tp)	B	L	Weight [Kg]
372482	**24**	24	11, 13, 15, 16, 17, 18, 20, 21, 22, 23, 25, 26, 27, 28, 30, 31, 32, 33, 35, 36, 37, 38, 40, 42	IT5	3	125	4,5
372490	**32**	32	11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 42	IT5	3	125	5,5





Design:

Size 24, content per 1 pair (W x H):
3x11 / 3x13 / 3x15 / 3x16 / 3x17 / 3x18 / 3x20 / 3x21 / 3x22 / 3x23 / 3x25 / 3x26 / 3x27 / 3x28 / 3x30 / 3x31 / 3x32 / 3x33 / 3x35 / 3x36 / 3x37 / 3x38 / 3x40 / 3x42 mm.

Size 32 content per 1 pair (W x H):
3x11 / 3x12 / 3x13 / 3x14 / 3x15 / 3x16 / 3x17 / 3x18 / 3x19 / 3x20 / 3x21 / 3x22 / 3x23 / 3x24 / 3x25 / 3x26 / 3x27 / 3x28 / 3x29 / 3x30 / 3x31 / 3x32 / 3x33 / 3x34 / 3x35 / 3x36 / 3x37 / 3x38 / 3x39 / 3x40 / 3x41 / 3x42 mm.

Wooden stand: 276 x 162 x 55 mm

Application:

These documents are used as washers for workpieces exposed to diverse machining processes.

Advantage:

- high wear resistance and long service life
- Wooden stand for perfect handling at the workplace.

Note:

Remaining dimensions according to DIN ISO 2768 - m.
Size data on front of product.

No. 6344SP

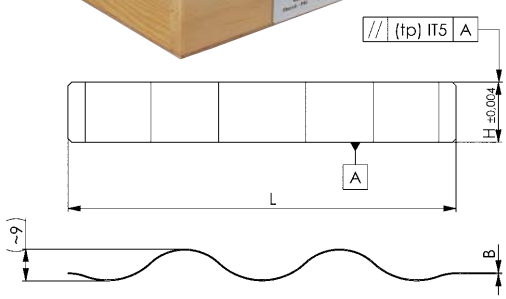
Parallel supports-set, corrugated

In wooden box with folding lid.
Hardened, tempered spring steel.
Precision ground.
Height graduation 2 mm.
Quality level: Super-precision ***

Pair tolerance tp in height IT 5.
Rated dimensional tolerance in height ±0.004 mm.
Remaining dimensions according to DIN ISO 2768 - m.

Order no.	Size	Pair	H ±0.004	H Pair tolerance (tp)	B	L	Weight [g]
372821	**9 -23**	8	9, 11, 13, 15, 17, 19, 21, 23	IT5	0,3	110	450
372839	**25-39**	8	25, 27, 29, 31, 33, 35, 37, 39	IT5	0,3	110	490





Design:

Size 9-23, 1 pair each (B x H):
0.3x9 / 0.3x11 / 0.3x13 / 0.3x15 / 0.3x17 / 0.3x19 / 0.3x21 / 0.3x23 mm.
Size 25-39, 1 pair each (B x H):
0.3x25 / 0.3x27 / 0.3x29 / 0.3x31 / 0.3x33 / 0.3x35 / 0.3x37 / 0.3x39 mm.

Application:

The corrugated parallel washers create a time-saving when clamping workpieces for grinding, milling, cutting, boring, etc.

Advantage:

- no swarf remains on the mounting surface
- parallelism of the clamped workpiece is not affected
- several flat or single thin workpieces can easily be clamped.

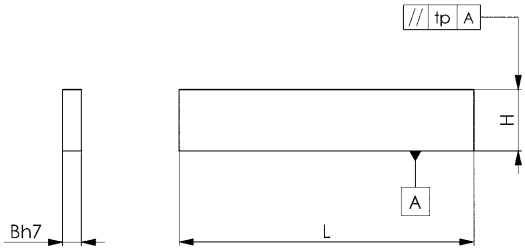
Subject to technical alterations.

No. 6350

Parallel stops in pairs

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





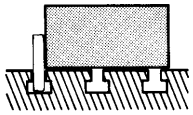
Order no.	B	H	H Pair tolerance (tp)	L	Weight [g]
74260	8	25	IT5	100	315
74278	10	32	IT5	100	500
74286	12	40	IT5	100	750
74294	14	50	IT5	100	1100
74302	16	50	IT5	160	2000
74310	18	63	IT5	160	2850
74328	20	63	IT5	160	3170
74336	22	80	IT5	160	4400
74344	24	80	IT5	160	4800
74351	28	100	IT5	160	7000

Application:

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

Note:

Rated dimensional tolerance in height according to DIN ISO 2768 - m.
Rated dimensional tolerance in width according to DIN EN ISO 286: h7.
Remaining dimensions according to DIN ISO 2768 -m.



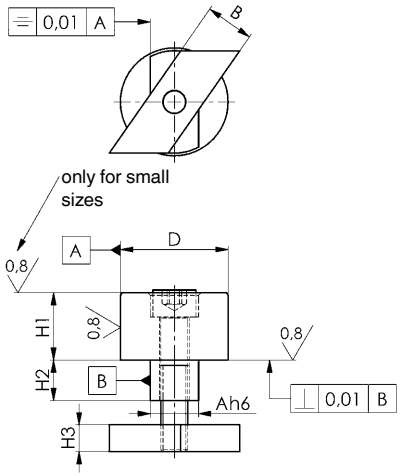
CAD

No. 6328

Cylindrical stop

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





CAD

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

On request:

Further sizes available.



Subject to technical alterations.

No. 6351

Parallel stop

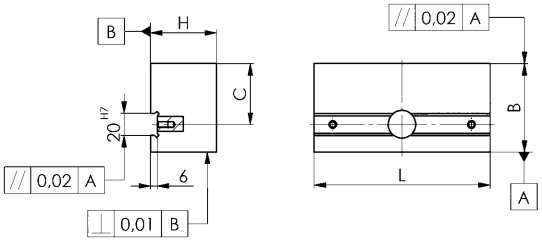
case hardened and ground. Parallelism within 0.02 mm. Nominal tolerance DIN 7168 medium.



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

Application:

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



CAD

No. 6353

Precision angle stop

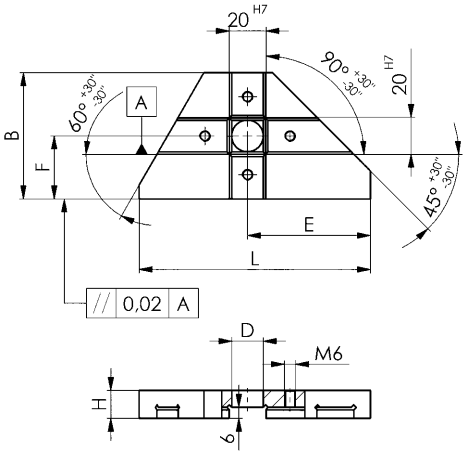
case hardened and ground.
Setting: parallel and at angles of 30, 45, 60 and 90° related to T-slots. Guaranteed precision for all faces according to slots ±30".

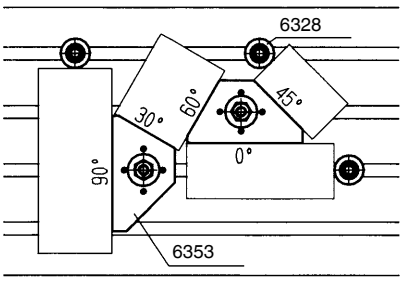


Order no.	Size	Slot	B	D	E	F	H	L	Weight [g]
74450	**125**	10-20	68	17	66,5	34	15	125	550
74468	**200**	12-36	98	25	100,0	49	20	200	1900

Application:

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





CAD

Subject to technical alterations.

No. 6355V

Prismatic clamping block

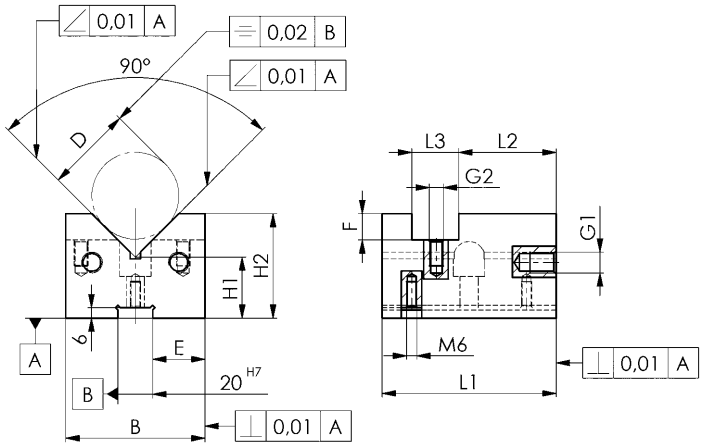
case hardened and ground

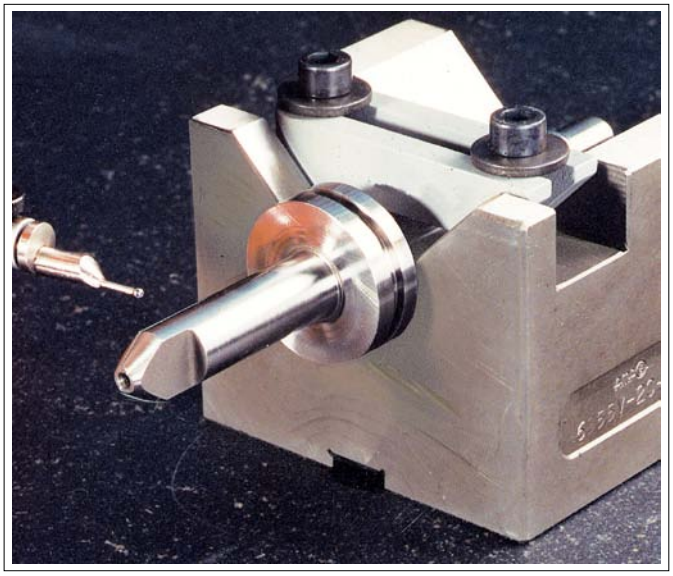
Order no.	Size	B	D	E ±0.01	F	G1	G2	H1 ±0.014	H2	L1	L2	L3	Weight [Kg]
75085	**12-65**	80	12-65	30,0	15	M 12	M 8	35	60	100	56	27	3,2
75093	**20-110**	125	20-110	52,5	25	M 16	M 10	55	100	100	53	32	8,1

Application:

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







CAD

Subject to technical alterations.

No. 6357

Stop, adjustable

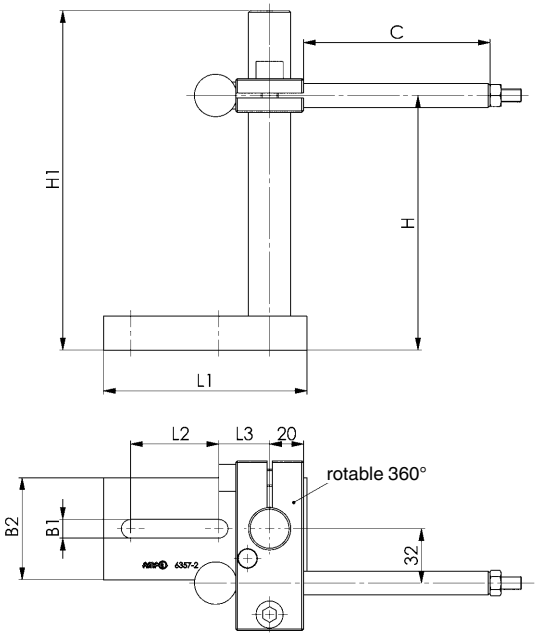
with hexagon key.
Tempering steel

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



Application:

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



CAD

No. 6358

Side stop

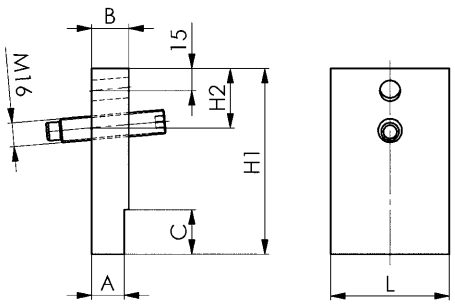
Tempering steel blued, with 2 threaded holes M16 for 2 positions. Set screw DIN 915 M16x80.

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

Application:

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





CAD

Subject to technical alterations.

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DIN 6323

Loose type tenons

Steel C15, case hardened and ground.



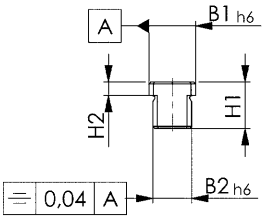
Order no.	Nominal width of T-slot on fixture B1	Nominal width of T-slot on machine B2	Form	H1	H2	H3	H4	L	Weight [g]
71811	12	10	A	12,0	3,6	-	-	20	20
71829	12	12	B	28,6	-	5,5	9	20	45
71837	20	12	A	14,0	5,5	-	-	32	50
71845	20	14	A	14,0	5,5	-	-	32	55
71852	20	16	A	14,0	5,5	-	-	32	60
71860	20	18	A	14,0	5,5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

Application:

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

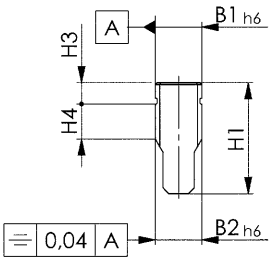
Form A

B1 > B2



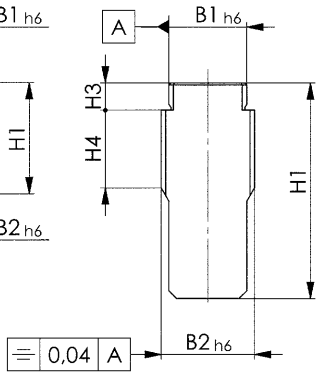
Form B

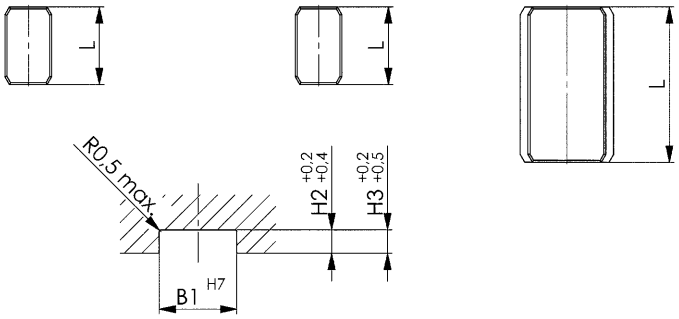
B1 = B2

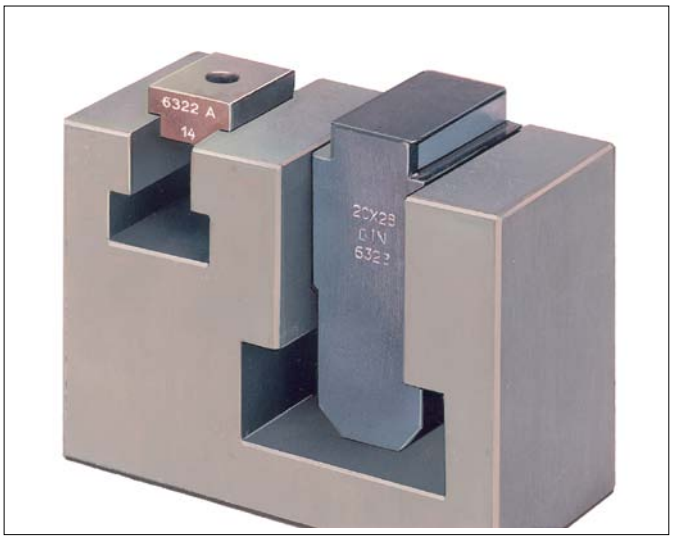


Form C

B1 < B2







CAD

Subject to technical alterations.

No. 6322A

Fixed type tenons

Steel C15, case hardened and ground.

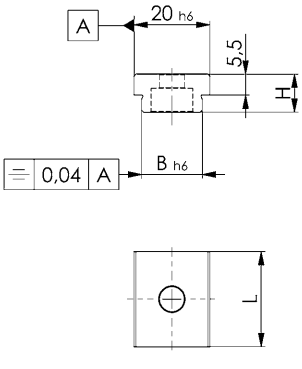


Order no.	Nominal width of T-slot on machine B	Nominal width of T-slot on fixture	Form	H	L	Screw DIN84 or ISO4762	Weight [g]
71555	10	20	A	10	22	M6x10	20
71563	12	20	A	10	22	M6x10	25
71571	14	20	A	10	25	M6x16	28
71589	16	20	A	10	25	M6x16	30
71597	18	20	A	10	25	M6x16	30
71613	22	20	C	12	32	M6x16	50
71621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

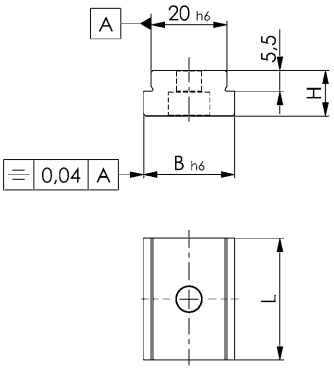
Application:

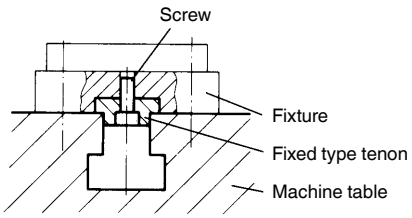
These fixed type tenons are screwed in pairs into the standard 20 mm wide set slots of vices or fixtures. By changing the tenons you can work on machines with different slot sizes. For very heavy fixtures we recommend the use of loose type tenons DIN 6323.

"A"



"C"





CAD

No. 6322B

Low type tenons

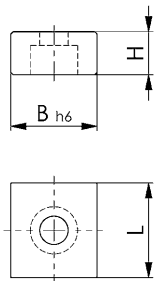
Steel C15, case hardened and ground.

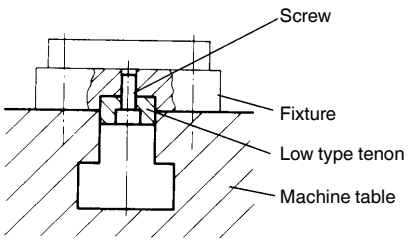


Order no.	B	H	L	Screw DIN84 or ISO4762	Weight [g]
71696	10	8	20	M4x10	11
71704	12	8	20	M5x12	12
71712	14	10	22	M6x16	18
71720	16	10	22	M6x16	22
71738	18	10	22	M6x16	25
71746	20	10	22	M6x16	30
71753	22	12	32	M6x16	60
71761	24	12	32	M6x16	65

Application:

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

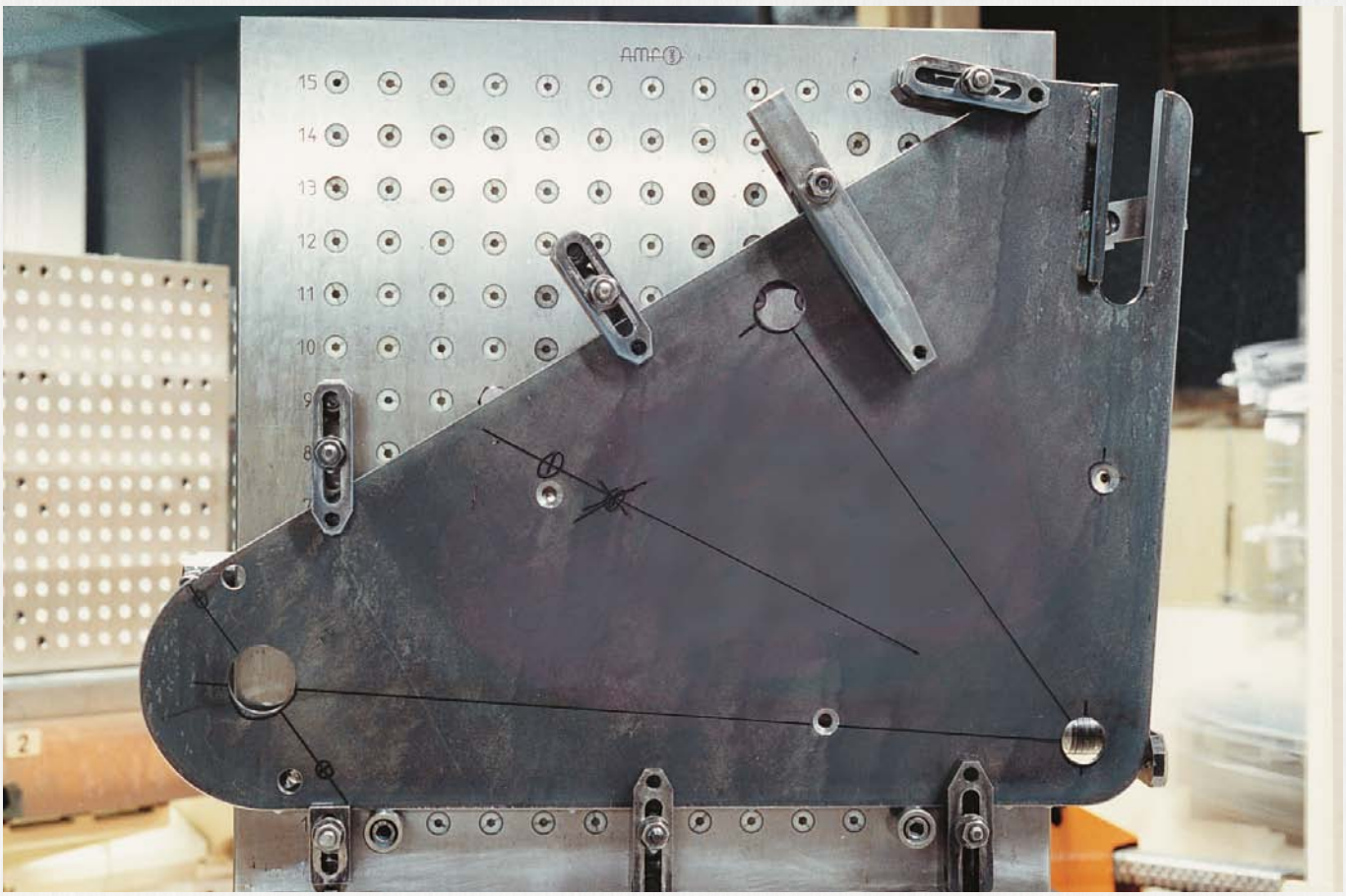


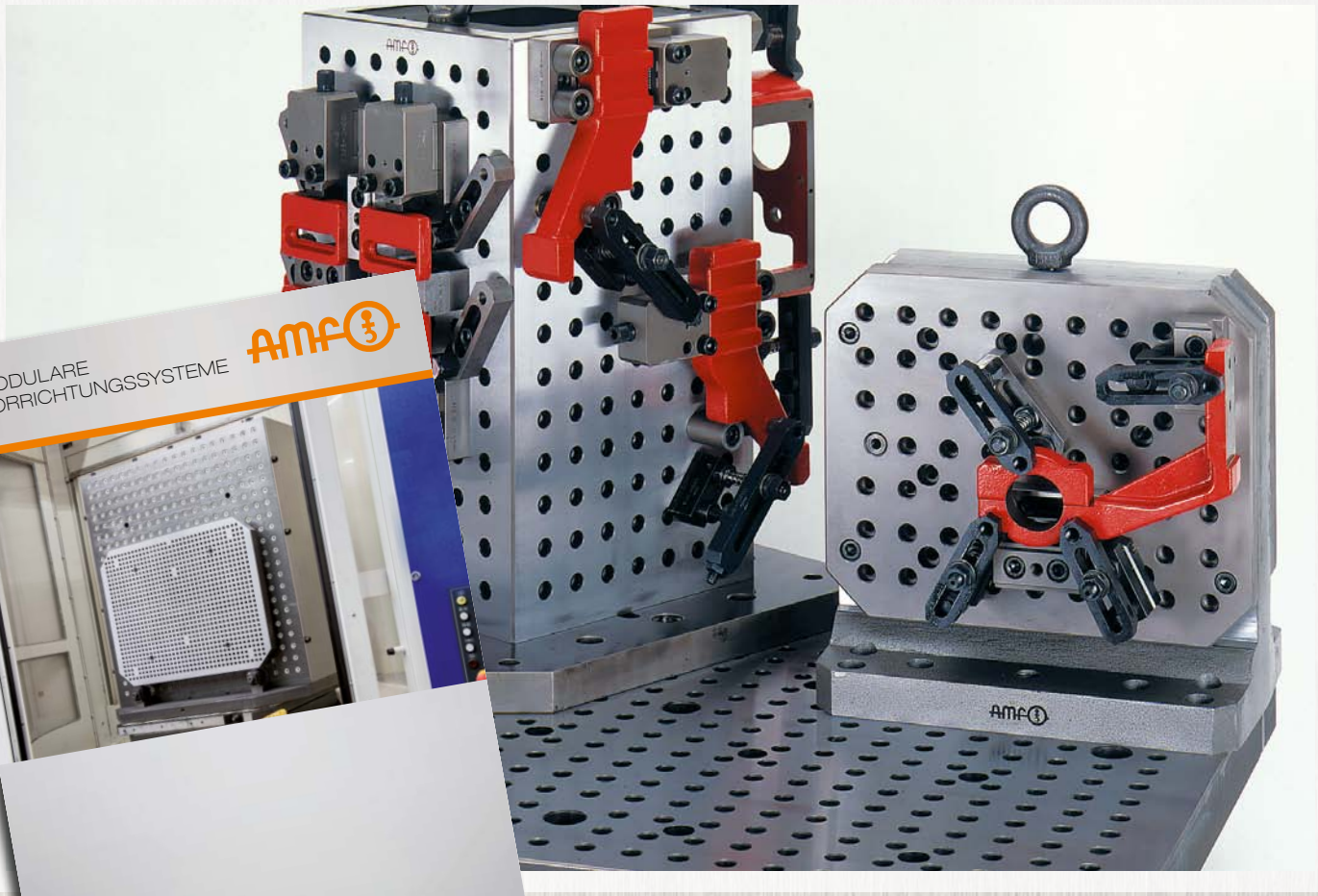


CAD

Subject to technical alterations.

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Subject to technical alterations.

No. 6600

Eccentric clamp with end clamping

hardened and burnished.

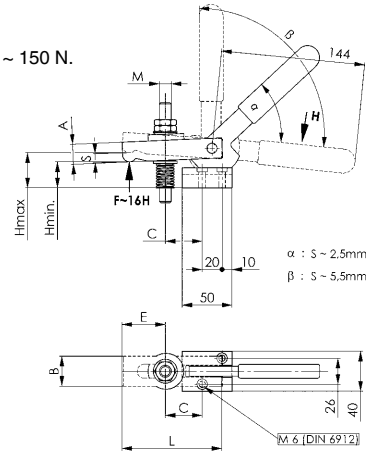
Order no.	Size	H min. [mm]	H max. [mm]	A	B	C	E	L	M	Weight [g]
73502	1	26	35	20	30	37	21-43	100	M12	1000
73510	2	26	35	20	40	45	34-66	125	M16	1400

Eccentric clamps are useful for specialized fixtures.



Note:

Actuation by hand - hand force ~ 150 N.



CAD

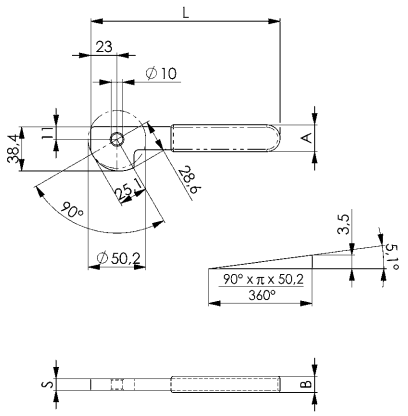
No. 6601

Eccentric lever, loose

for end clamping
(part of 6600)

Order no.	A	B	L	S	Weight [g]
73569	24	14	167	10	300





CAD

No. 6610

Eccentric clamp with middle clamping

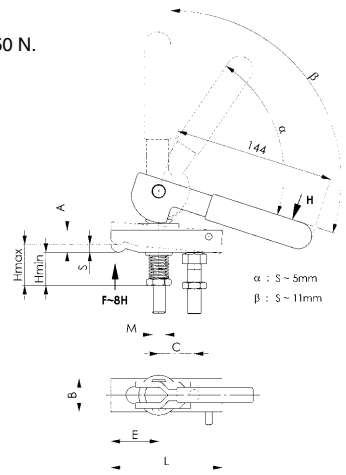
hardened and burnished, lever plastic coated.

Order no.	Size	H min. [mm]	H max. [mm]	A	B	C	E	L	M	Weight [g]
73619	1	30	45	20	30	32	21-43	100	M12	1000
73627	2	35	50	20	40	40	34-66	125	M16	1450

Note:

Actuation by hand - hand force ~ 150 N.





CAD

Subject to technical alterations.

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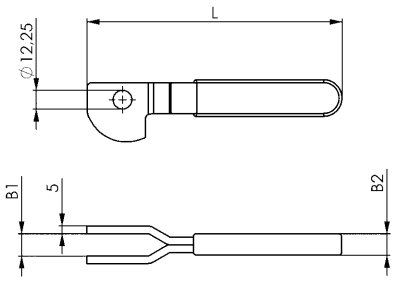
No. 6611

Eccentric lever, loose

for middle clamping
(part of 6610)

Order no.	B1	B2	L	Weight [g]
73676	14	14	167	310





CAD

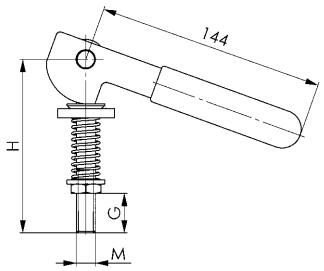
No. 6612

Eccentric lever with eye bolt

(part of 6610)

Order no.	Size	G	H	M	Weight [g]
74500	1	25	110	M12	500
74518	2	30	120	M16	610





CAD

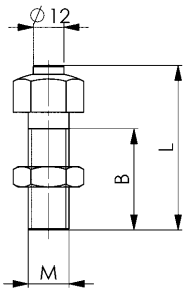
No. 6616

Set screw with nut

(part of 6610)

Order no.	Size	B	L	M	Weight [g]
74542	1	40	58,5	M12	70
74559	2	40	65,0	M16	135





CAD

Subject to technical alterations.

No. 6383ZEK

Centring clamp with ball

Can be used from above.
Repeatability ± 0.025 mm
Concentricity ±0.050 mm



Order no.	D min.	D max.	A min.	A max.	H	P [kN]	Weight [g]
373357	11,7	14,2	3,2	3,9	10,0	0,5	8,2
373365	14,5	18,5	8,6	9,8	14,2	3,5	19
373373	18,5	22,5	10,4	11,6	16,5	4,5	40
373381	22,5	26,5	12,9	14,1	19,6	5,0	73
373399	26,5	30,5	13,0	14,1	19,8	5,0	93
373407	30,5	38,5	11,8	14,1	23,2	5,0	118
373415	38,5	46,5	15,7	18,0	27,2	6,5	249
373423	46,5	54,5	15,7	18,0	27,1	6,5	342
373431	54,5	70,5	19,1	23,7	40,6	8,0	652
373449	70,5	86,5	23,7	28,3	46,1	10,0	1303
373456	86,5	102,5	25,6	30,3	51,2	10,0	1765

Application:

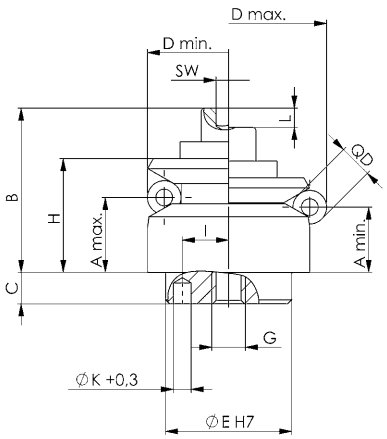
For centric positioning and clamping in holes, where light ball imprints can be accepted.

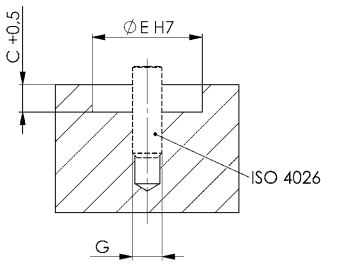
Advantage:

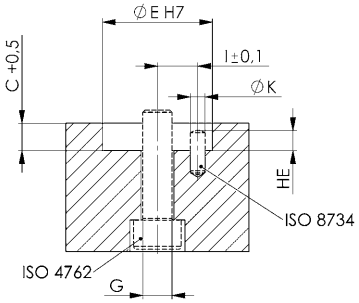
- Low installation height
- Clamping in the zero point
- Pull-down effect
- Distortion-free clamping

Note:

For deep installation, clearance D max. must be provided.
Installation tool: Retaining pin for determining the precise position of the balls. (supplied without installation tool)







Dimensions:

Order no.	B	C	E f7	G	HE	I ±0,1	K	L	Q	QD	SW
373357	14,7	3,5	10	M4	2,0	3,5	1,5	1,3	3	2,5	3
373365	19,2	5,5	12	M4	2,5	4,5	2,0	2,3	3	4,0	3
373373	22,7	7,5	15	M5	3,5	5,5	2,5	2,3	3	4,0	4
373381	28,6	6,0	20	M6	3,5	7,0	3,0	2,3	3	4,0	5
373399	28,8	6,0	20	M6	3,5	7,0	3,0	2,3	3	4,0	5
373407	32,2	7,0	25	M6	3,5	9,0	4,0	4,6	3	8,0	5
373415	39,2	7,5	30	M8	4,5	11,0	4,0	4,6	6	8,0	6
373423	39,2	7,5	30	M8	6,5	11,0	4,0	4,6	6	8,0	6
373431	54,6	9,0	45	M10	6,5	15,0	5,0	9,2	6	16,0	8
373449	63,1	10,0	60	M12	6,5	17,0	5,0	9,2	6	16,0	10
373456	72,2	10,0	60	M16	6,5	25,0	5,0	9,2	6	16,0	14

Q = number of balls

Subject to technical alterations.

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No. 6383ZES

Centring clamp with protective segments

Can be used from above.
Repeatability ± 0.025 mm
Concentricity ±0.050 mm



Order no.	D min.	D max.	A min.	A max.	H	P [kN]	Weight [g]
373464	14,5	18,5	8,6	9,8	14,3	3,5	26
373472	18,5	22,5	10,4	11,5	16,6	4,5	45
373480	22,5	26,5	13,0	14,1	19,7	5,0	73
373498	26,5	30,5	13,0	14,2	19,9	5,0	95
373506	30,5	38,5	11,7	14,0	23,2	5,0	131
373514	38,5	46,5	15,5	18,0	27,2	6,5	259
373522	46,5	54,5	15,7	18,0	27,2	6,5	343
373530	54,5	70,5	19,1	23,7	40,7	8,0	675
373548	70,5	86,5	23,6	28,3	46,0	10,0	1347
373555	86,5	102,5	25,6	30,3	51,1	10,0	2099

Application:

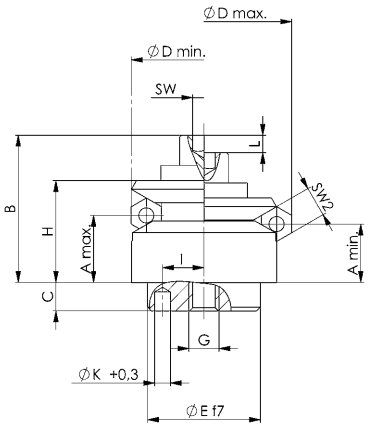
For surface-protecting and centric positioning and clamping in holes.

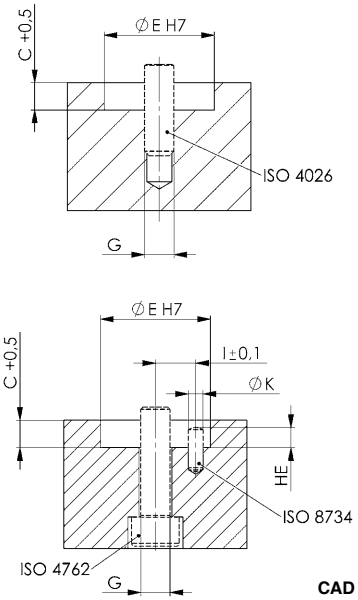
Advantage:

- Low installation height
- Clamping in the zero point
- Pull-down effect
- Distortion-free clamping

Note:

For deep installation, clearance D max. must be provided.
Installation tool: Retaining pin for determining the precise position of the segments. (supplied without installation tool)





CAD

Dimensions:

Order no.	B	C	E f7	G	HE	I ±0,1	K	L	Q	QD	SW	SW2
373464	19,3	5,5	12	M4	2,0	4,5	2,0	2,3	3	4	3	4
373472	22,8	7,5	15	M5	2,5	5,5	2,5	2,3	3	4	4	4
373480	28,7	6,0	20	M6	3,0	7,0	3,0	2,3	3	4	5	4
373498	28,9	6,0	20	M6	3,0	7,0	3,0	2,3	3	4	5	4
373506	32,2	7,0	25	M6	4,0	9,0	4,0	4,6	3	8	5	8
373514	39,2	7,5	30	M8	4,0	11,0	4,0	4,6	6	8	6	8
373522	39,2	7,5	30	M8	4,0	11,0	4,0	4,6	6	8	6	8
373530	54,7	9,0	45	M10	5,0	15,0	5,0	9,2	6	16	8	16
373548	63,0	10,0	60	M12	5,0	17,0	5,0	9,2	6	16	10	16
373555	72,1	10,0	60	M16	5,0	25,0	5,0	9,2	6	16	14	16

Q = number of segments

Subject to technical alterations.

THE FIRST STEP FOR USE AND EMPLOYMENT OF SIDE THRUST PIECES:

> What is being positioned or clamped?
> Which side thrust pieces will be used?
> What size corresponds to the workpiece?
> What tolerance does the workpiece have?
> How large is the dimension Y? (Workpiece height)
> How large is the dimension X? (See table)
> Should the spring deflection be completely used?
> How is the coordinate dimension determined?

EXAMPLE: POSITIONING OR CLAMPING A PLATE 100 X 50 X 8 MM

Should the pin diameter be 5, 6 or 8 mm?

> If nothing may extend over the plate	5 mm
> If projection would not be a problem	6 or 8 mm
> If clamping will be done additionally	6 mm
> If drilling will be performed without additional clamping	8 mm

Length / width of the workpiece?

> Length = 100 +0/ -0.4 = medium dimension 99,8 mm
> Width = 50 +0,2/-0.2 = medium dimension 50,0 mm

Workpiece height Y?

The tolerance can be ignored

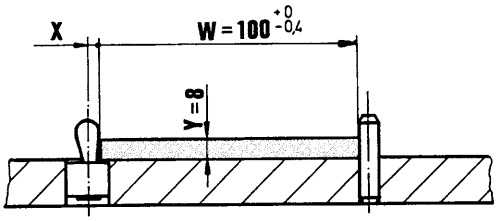
What force should be selected?

> For positioning tasks	30 - 60 N
> For clamping forces	90 - 150 N

Dimension X for side thrust pieces with steel spring?

> See table or formula below

.



W = workpiece (+/- tolerance)
- F = pre-tension
F = (-F) + (+F)

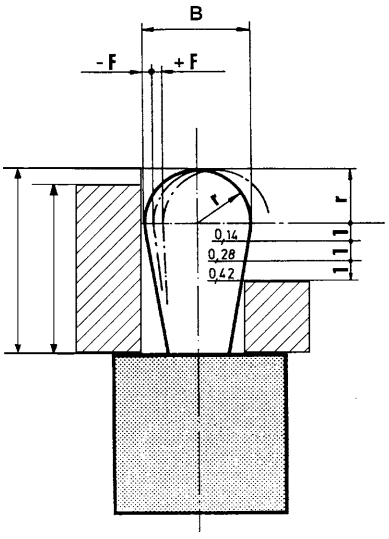
Y = workpiece height
+ F = clamping force (spring deflection for tolerance)
T = tolerance

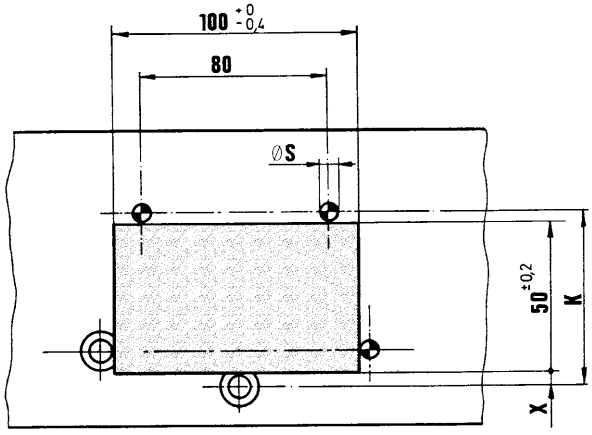
For workpieces that are higher than C minus r, the table values for dimension X or the formula X = B/2 - (-F) apply.

For workpieces that are smaller than C minus r, the table values for dimension X or the formula X = B/2 - (-F) - [(C - r - Y) x 0,123] apply.

Formula for coordinates:
K = W - T/2 + x + S/2

The table values are standard values that should ideally be checked using a sample clamping.





No. 6380D

Side thrust piece, with seal

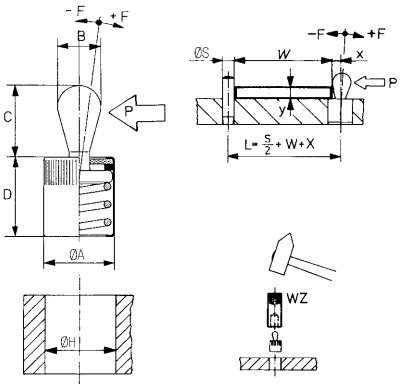
against chips and dirt.
Steel pin for clamping: hardened and galvanised
Sleeve: Aluminium



Order no.	dia. A	B	~P Spring force [N]	C	D -1	ØH H8	F	X	Tool 6380WZ	Weight [g]
373159	6	3	10	4	7	6	±0,5	0,9	03	0,6
373167	6	3	20	4	7	6	±0,5	0,9	03	0,6
373175	6	3	40	4	7	6	±0,5	0,9	03	0,7
373183	10	5	20	6	12	10	±0,8	1,6	05	2,7
373191	10	5	50	6	12	10	±0,8	1,6	05	2,9
373209	10	5	100	6	12	10	±0,8	1,6	05	2,9
373217	10	6	40	10	12	10	±1,0	1,8	06	3,1
373225	10	6	75	10	12	10	±1,0	1,8	06	3,6
373233	10	6	150	10	12	10	±1,0	1,8	06	3,7
373241	12	8	50	13	14	12	±1,3	2,6	08	3,9
373258	12	8	100	13	14	12	±1,3	2,6	08	7,1
373266	12	8	200	13	14	12	±1,3	2,6	08	7,3
373274	16	10	100	16	18	16	±1,6	3,2	10	7,6
373282	16	10	200	16	18	16	±1,6	3,2	10	15
373290	16	10	300	16	18	16	±1,6	3,2	10	15,4

Note:

With sealing for chip-producing operations with dirt, temperature-resistant up to 150°C.
Sealing: CR, black, 60 Shore. Installation by pressing in.



Recommendations



No. 6380WZ, page 166

CAD

Subject to technical alterations.

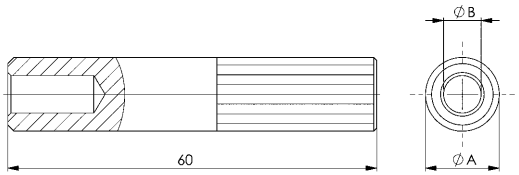
No. 6380WZ

Insertion tool

for pressing in the lateral pressure pad.



Order no.	Size	dia. A	B	Weight [g]
373308	03	8	3,1	16
373316	05/06	12	6,1	19
373332	08	14	8,1	64
373340	10	18	10,2	105



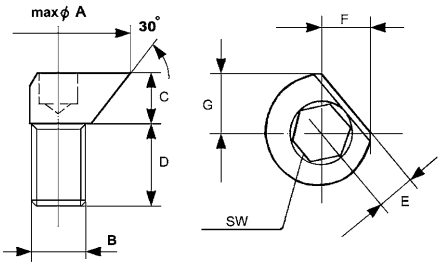
No. 6387

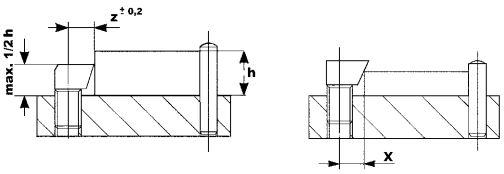
Eccentric clamping bolt

clamp in x-y direction with pull down effect.
Hardened steel 56±1 HRC.



Order no.	dia. A	B	C	D	E	F	G	SW	X	Z	max. holding force [kN]	Md [Nm]	Weight [g]
373779	9,2	M4	3	8	3,0	4,6	4,0	2,5	3,5	4,2	0,09	1,5	2
373787	14,2	M6	5	12	4,5	7,1	6,1	4,0	5,4	6,4	0,3	5,0	6
373795	18,0	M8	6	16	5,5	8,9	7,7	5,0	6,6	8,0	2,7	22,0	9
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Application:

- Clamping above the machining surface
- Clamping below the machining surface
- Clamping in holes.

Advantage:

- stepless adjustment with eccentric
- high wear resistance.

CAD

Clamping above the machining surface



Clamping below the machining surface



Subject to technical alterations.

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WE DEVELOP THE RIGHT SOLUTION –
POTENTIAL SAVINGS BY REDUCING SET-UP TIMES

As a system provider with its own production facility, not only do we have the right product for every need. With many years of experience from all fields of clamping technology we develop the perfect solution for different industries, special projects and for very individual requirements.

With full concentration on a single project, an entire team supports you at AMF, which unites all facets for a successful result.

In close cooperation and with short communication channels, our experienced experts from sales, proposal preparation and purchasing work together with our engineers and designers from the development and production departments.

Thus, we can always ensure that all criteria for a costeffective production process are met – our specialists look forward to exciting new challenges.
Just talk to us!



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Terms of Sale, Delivery and Payment

These Terms of Payment apply for companies, legal entities governed by public law and public law special funds. Our goods and services are supplied exclusively on the basis of the following conditions. Any deviating purchasing conditions of the customer not expressly recognised by us will not become part of the contract through acceptance of the order. By placing the order and accepting the goods we deliver, the customer confirms its consent to our terms and conditions.

1. Offer and contractual conclusion

All our offers are always subject to change without notice unless otherwise explicitly agreed. Our delivery contracts are based on the latest version of our catalogue. Dimension and weight values, as well as illustrations, drawings and data, are non-binding and can be changed by us at any time. Therefore, deviations cannot be ruled out and do not justify any compensation claims against us.
Orders are considered accepted only when confirmed by us in writing. If, for organisational reasons, the customer does not receive a separate confirmation upon the delivery of goods, the invoice shall also be deemed the order confirmation.

2. Prices

The prices are in EURO, ex-works, excluding VAT, packing, freight, postage and insurance. Unless otherwise agreed, our list prices valid on the day of delivery shall apply. For orders below 50 EUR goods net, we must make a minimum quantity surcharge of a 20 EURO for cost reasons.

3. Tool costs

Unless any other agreements have been reached, the tools fabricated for the purpose of executing the order shall remain our property in all cases, even if we have invoiced a tool cost component separately.

4. Payment

Unless otherwise stated on the invoice, the purchase price falls due for net payment within 30 days of the invoice date (without deduction of discount). Invoice amounts of below 50 EURO are due for payment immediately.
In case of payment default, we shall be entitled to charge default interest. The amount corresponds to our interest rate for current account credits at our main bank; the minimum however being 8 percentage points above the relevant base interest rate applied by the European Central Bank. Moreover, in case of default following written notice to the customer, we shall be entitled to cease to fulfil our obligations until payments are received.

5. No set-off

The customer can set-off only with legally confirmed or undisputed counterclaims.

6. Right of withdrawal in case of delayed acceptance or payment and insolvency

If the customer fails to accept the goods in due time, we shall be entitled to set a reasonable period of grace, after which we can dispose of the goods elsewhere and supply the customer on a reasonably longer term. Our rights to withdraw from the contract under the provisions of Section 326 BGB and demand damages for non-performance shall not be affected. If the customer fails to pay for the goods once payment is due, we shall be entitled, at the end of a reasonable period of grace we have set, to withdraw from the contract and demand the return of any goods already supplied. Section 323 BGB remains unaffected in all other cases.
If the customer applies for the opening of insolvency proceedings, we shall be entitled, prior to the ordering of security measures by the insolvency court, to withdraw from the contract and demand the immediate return of the goods.

7. Customer-specific fabrications/project fabrications (custom fabrications)

Customer-specific fabrications require binding information on design, quantity etc. in written form at the time of ordering. For manufacturing reasons, we reserve the right to supply up to 10% above or below the order quantity. Technical modifications or cancellations are subject to any costs incurred. The return of customer-specific fabrications is impossible.

8. Delivery and packaging, transfer of risk

The delivery date is non-binding; although stated to the best of our knowledge. It is subject to us receiving correct, defect-free and complete deliveries. The stated delivery dates relate to completion in the factory, starting on the day the order is accepted by us.
Delivery is EXW (ex-works) in accordance with Incoterms 2020. Therefore, the costs are borne by the customer. The risk is transferred to the customer when the goods are passed to the person, company or facility nominated to execute the shipment. This applies also for partial deliveries, or if we have assumed responsibility for delivery and installation. The risk shall be transferred to the customer even in the case of delayed acceptance.
In the absence of specific shipping instructions, we shall proceed as we deem fit and without any obligation to the cheapest or most expedient method. The customer agrees that the order can also be delivered in parts, insofar as this is reasonable for the customer. We shall charge a 10 EURO processing free for shipping to third parties that we supply on behalf of the customer.
The packaging complies with the packaging ordinance. Disposable packaging shall be charged at cost price. The packaging cannot be taken back.

9. Performance impediment and/or impossibility

If we are hindered in the fulfilment of our obligation due to the onset of unforeseeable circumstances, which we are unable to avoid despite reasonable effort in relation to the nature of the circumstances (e.g. operational interruption, delay in the delivery of important raw materials, defects in the delivery), the delivery time shall be extended by a reasonable period, insofar as the supply of goods or services is not rendered unreasonably difficult or impossible.
If we have to accept that these circumstances are not only temporary, we shall be entitled to withdraw from the contract either in whole or in part.
If the supply of goods or services becomes impossible, the customer shall not be obliged to furnish its own contractual service. Section 275 BGB applies mutatis mutandis. If, however, the customer is solely or predominantly responsible for the circumstances that led to impossibility, it shall remain under an obligation to render the return service. The same applies if this circumstance occurs at a time when the customer is behind schedule with acceptance.

10. Samples/returns

Samples shall be provided only against payment. If samples or models are provided, a credit note shall be issued with the subsequent order if the order value is 125 EURO net or more. Goods can be returned only by agreement, although custom fabrications are excluded from such return.
In the case of returns for which we are not responsible (e.g. incorrect order), we shall charge a processing fee of 10%, the minimum value, however, being 9.00 EURO.

11. Retention of title

The goods shall remain our property unless full payment of all claims and/or until the cheques provided for this purpose are honoured. The itemisation of claims in an ongoing invoice, as well as balancing the account and the recognition thereof does not affect the retention of title. The customer is entitled to sell on the retained goods during the ordinary course of business. However, the customer is not permitted to pledge the goods or transfer them by way of security. It shall assign its claim ensuing from the selling on of the retained goods to us in advance. The customer shall be entitled to collect the claim to the extent that it has fulfilled its obligations towards us. At our request, the customer shall be obliged to state third-party debtors and we shall be entitled to report this and the assignment.

12. Property rights

We reserve property rights and copyrights to all contractual documents such as drafts, drawings, calculations and cost estimates. Such documents must not be reproduced or disclosed to third parties without our consent. Any rights to patents, utility models etc. reside solely with us, insofar as such patents have not yet been filed. Our products are allowed to be replicated only with our written consent.
If objects are fabricated according to drawings or samples, the customer shall warrant that any third party property rights are not infringed by manufacture or delivery. If a third party forbids manufacture and delivery on account of property rights, we shall be entitled to stop manufacture and delivery immediately. The customer shall be obliged to reimburse us with all costs incurred and indemnify us from third party compensation claims. Compensation claims by the customer are impossible.

13. Warranty

If the customer agrees with us a particular quality of the goods, we shall base this agreement on our technical delivery specifications. If we have to deliver according to customer drawings, specifications, samples etc., the customer shall assume the risk for suitability for the intended purpose. If, after the contract is concluded, the scope of goods or services is changed at the customer‘s request and this impairs the quality or suitability of the goods, claims for defects on the part of the customer shall be ruled out, insofar as such impairments are caused by the customer‘s requests for change.
The time at which the risk is transferred is decisive for the contractual state of the goods. Wear and tear of wearing parts caused by ordinary use does not constitute a defect. Claims for defects are ruled out in the following cases in particular: Unsuitable or improper use, incorrect installation and/or commissioning by the customer or third party, normal wear and tear, incorrect or negligent handling - in particular excessive use -, unsuitable equipment, replacement materials, chemical, electrochemical or electrical influences, unless such defects are caused by ourselves.
If the goods contain a defects, we shall provide, following a reasonable period of grace set by the customer, either a replacement or a repair as we deem fit. If such subsequent performance fails, the customer shall be entitled to either reduce the purchase price or withdraw from the contract. Any further warranty claims are ruled out. In case of negligible deviations from the agreed quality, no claims for defects shall be recognised.
The discovery of defects must be communicated to us immediately in writing. In the case of recognisable defects, however, within 10 days of acceptance, in the case of non-recognisable defects immediately after they become evident. The warranty is 12 months, starting with delivery of the goods ex-works.

14. Liability

With the exception of harm to life, body or health on account of a breach of duty by ourselves, our liability shall be limited to intent or gross negligence.

15. Place of fulfilment, place or jurisdiction and governing law

The place of fulfilment for all obligations ensuing from this contractual relationship is D-70734 Fellbach.
The place of jurisdiction for all legal disputes ensuing from the contractual relationship is the court responsible for the headquarters of Andreas Maier GmbH & Co. KG.
All disputes ensuing from the contract or regarding the validity thereof shall be finally decided by a court of arbitration in accordance with the Court of Arbitration Ordinance of the German Committee for Arbitration Court Procedures or the Conciliation and Arbitration Arrangement of the International Chamber of Commerce, recourse to ordinary courts of law being excluded. The legal dunning process, however, remains permissible.
German law shall govern (BGB and HGB). The applicability of the UN Convention on Contracts for the International Sale of Goods (CISG) is ruled out.

16. Severability clause

If individual provisions become legally invalid, the remaining provisions shall not be affected. The legally invalid provision shall be replaced by regulations that most closely reflect the economic purpose of the contract with reasonable consideration for the mutual interests. The publication of these Terms of Sale, Delivery and Payment renders all previous versions invalid. This does not apply for any contracts concluded prior to announcement.

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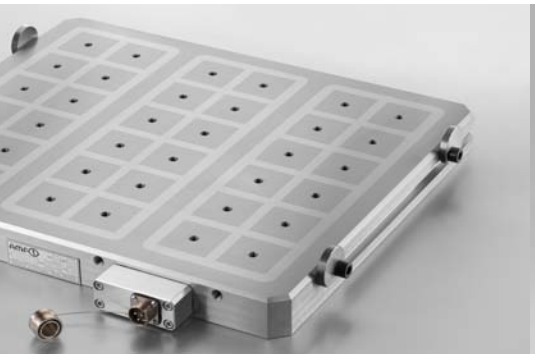
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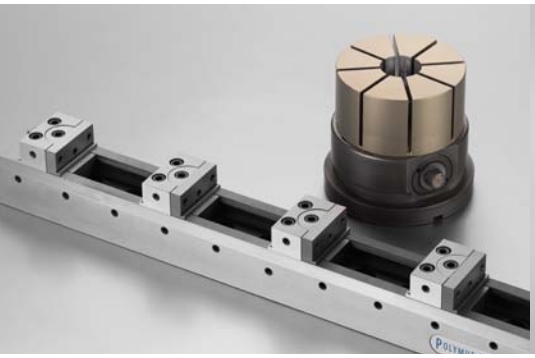
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