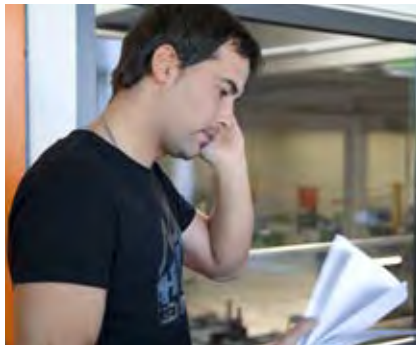




# CUSTOMER SERVICE – OUR SPECIALISTS AT YOUR DISPOSAL



*Mr Guggenmoos, Sales*



*Mr Orban, Production Control*



*Ms Guggenmoos, In-house Sales*

## **Telephone enquiries**

**+49(0)8377 929-0**

## **Ordering by fax**

**+49(0)8377 929-380**

## **Ordering by e-mail**

**order@allmatic.de**

## **Our repair service**

**+49(0)8377 929-358**

For information about delivery times, prices or technical questions, you can contact us Monday to Thursday 8 am – 5 pm and Friday 8 am – 3.30 pm.

Our Repairs Department is available daily from 8 am to 3.30 pm.

## **Delivery**

We deliver standard products to your premises anywhere in Germany free of charge.

## **Minimum order value**

Our minimum order value is €20.

## **Allmatic online: [www.allmatic.de](http://www.allmatic.de)**

On our website, you will find the latest special offers, new products, reduced sale items and service drawings for spare parts ordering.

## **Complaints**

If an incorrect order is placed, we charge a 5% processing fee or a minimum of €25. Items must be returned within three months. Custom-made products cannot be returned or exchanged.

## **Further information**

We also offer 3D data, brochures and operator instructions, which you can download at [www.allmatic.de](http://www.allmatic.de).

# THE ALLMATIC PICTOGRAPHS AND THEIR MEANING

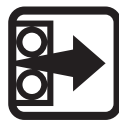
You will encounter various pictographs on our product information pages. They are explained on this fold-out flap, which you should keep open for ready reference when you look through your ALLMATIC catalogue!

# THE ALLMATIC PICTOGRAPHS



## Threaded spindle

Spindle without power intensification



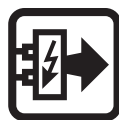
## Mechanical power intensification

Purely mechanical power intensifier



## Gripper spindle

Spindle with mechanical power intensification for clamping and machining unmachined workpieces



## Hydraulic power intensification

Single-acting cylinder



## Fully enclosed spindle

Scraper provides protection against dirt – enhanced functional reliability, optimal chip protection and minimal cleaning. Nitrated spindle!



## Spindle chamber cover

Sheet metal cover for dirt protection



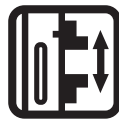
## Power preset

Spindle power can be preset in increments



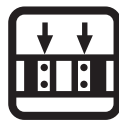
## Horizontal installation

Suitable for vertical machining centres



## Vertical installation

Suitable for horizontal machining centres



## Lateral installation

Lateral surfaces additionally ground and polished



## Click system

Quick-change system for false jaws and parallels



## Pull-down system

The pull-down guaranteed, that the parallelism of the guideway is transferred to the workpiece



## About us

Company management	2
Our philosophy	4
Process optimisation	8

## ALLMATIC basic – mechanical

Product information, technical data, accessories	10
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## ALLMATIC HD – mechanical

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## ALLMATIC NC series – mechanical

### LC version

Product information, technical data, accessories	28
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### TC version

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### NC 70 version

Product information, technical data, accessories	62
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### DUO 90 version

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## ALLMATIC GRIPP series – mechanical

### T-REX version

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### TITAN SC 125 version

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### TITAN 2 version

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### DUO Plus 125 version

Product information, technical data, accessories	144
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### CENTRO GRIPP version

Product information, technical data, accessories	160
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## ALLMATIC tombstones

### 3 x 120° Single Monobloc

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### 4 x 90° Single Monobloc

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### 4 x 90° DUO 90 Monobloc

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### 3 x 120° DUO Plus 125 Monobloc

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### 4 x 90° DUO Plus 125 Monobloc

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### Back-to-back set-up

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### Customised solutions

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## Automatable workholding

### LCH version

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### basic – HYDRAULIC

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**“ALLMATIC – DELIVERING QUALITY,  
PRECISION AND FLEXIBILITY SINCE 1973.”**

**1973**



*Company director: Bernhard Rösch*

### **We are specialists.**

At ALLMATIC, we specialise in work-holding systems and offer intelligent, innovative solutions. We develop precision clamping and holding systems that meet the highest quality standards for sophisticated machining in milling and machining centres. We are the market leader for high-pressure vices.

### **We pursue perfection.**

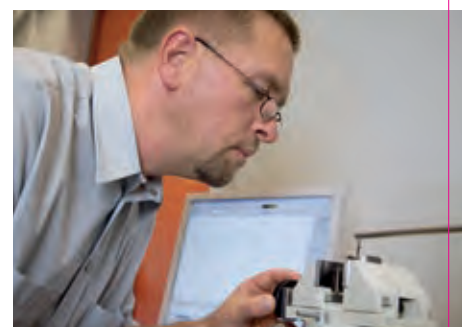
The core features of our brand are innovative strength and a passion for precision. The motivation to achieve top quality and reliability comes from the yardstick of perfection we set ourselves and from our enthusiasm for new technologies.

Reliable products, expert advice, first-class service and the candid and lasting relationships with our customers, business partners and staff are what characterise ALLMATIC.

### **We motivate.**

Our enthusiasm for the service capability of our products, our depth of specialist knowledge, our personal customer service and active contribution to the solutions of the future – these are your guarantees of a long and successful partnership.

**“EXPERIENCE, KNOW-HOW AND  
TECHNICAL EXPERTISE –  
TO THE BENEFIT OF OUR CUSTOMERS.”**



## Our philosophy:

Our many years of experience have produced a wealth of technical expertise that we are pleased to devote to the service of our customers. It is our objective to contribute to our customers' productivity and competitiveness through the products we supply. We are dedicated to working for our customers' success via our advice, support and innovation.

The key feature of our products is their high quality, which we achieve by always setting the bar high. Perfection, passion and enthusiasm provide the motivating force for us and our team. Fairness towards our workforce is as important to us as excellent relations with our suppliers and customers, achieved through being a reliable and trustworthy partner.



# “WE MANUFACTURE TO OUR CUSTOMERS’ SPECIFICATIONS.”

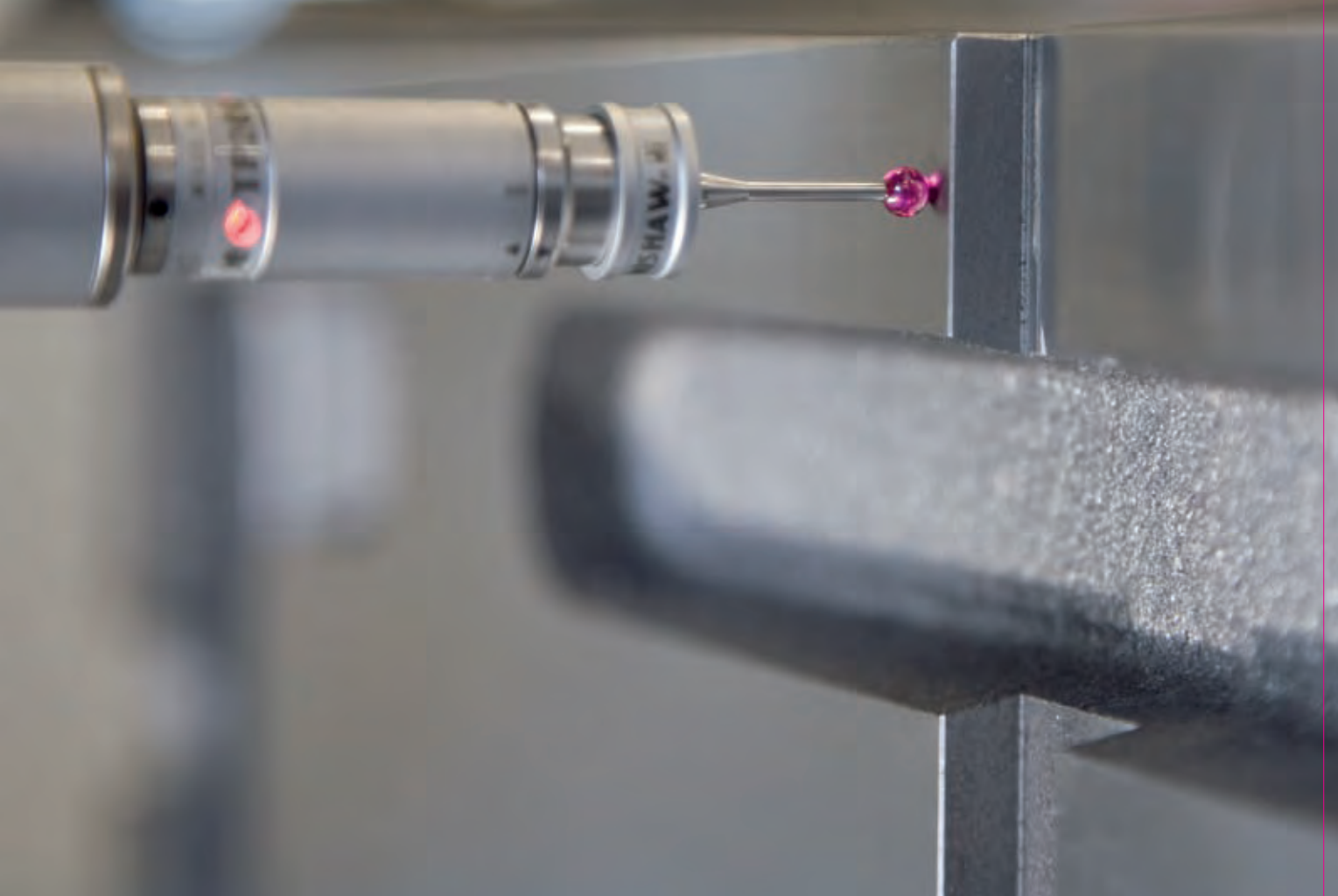


## **Product range.**

Our product range extends from simple high-pressure vices for conventional milling machines through to complex (multiple) workholding solutions for flexible manufacturing centres. These solutions offer an optimal price-performance ratio because they are mainly made from mass-produced standard components. Of course, we also manufacture to customers’ individual specifications. It is important to remember that the interfaces with the machine tool and workpiece are so flexible that they are easily adaptable to specific customer requirements.

## **Quality.**

A major advantage of our products is the purely mechanical power intensifier. Its design features and special lifetime lubrication mean that it is virtually wear-free and extremely reliable in operation. In addition, our vices feature a fully enclosed spindle, which ensures optimal chip protection and minimises cleaning, thus further enhancing their functional reliability.



*Fully enclosed spindle*



*Mechanical power intensifier*



1. After hardening, pre-machined blanks are placed on the magnets for profile grinding and polishing.



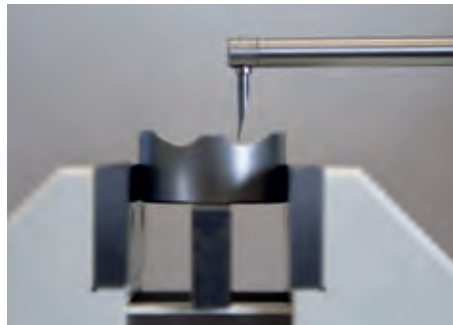
2. Grinding wheel during profile dressing



3. Fully automatic process for profile grinding and polishing



4. Finished profile



5. Checking the process



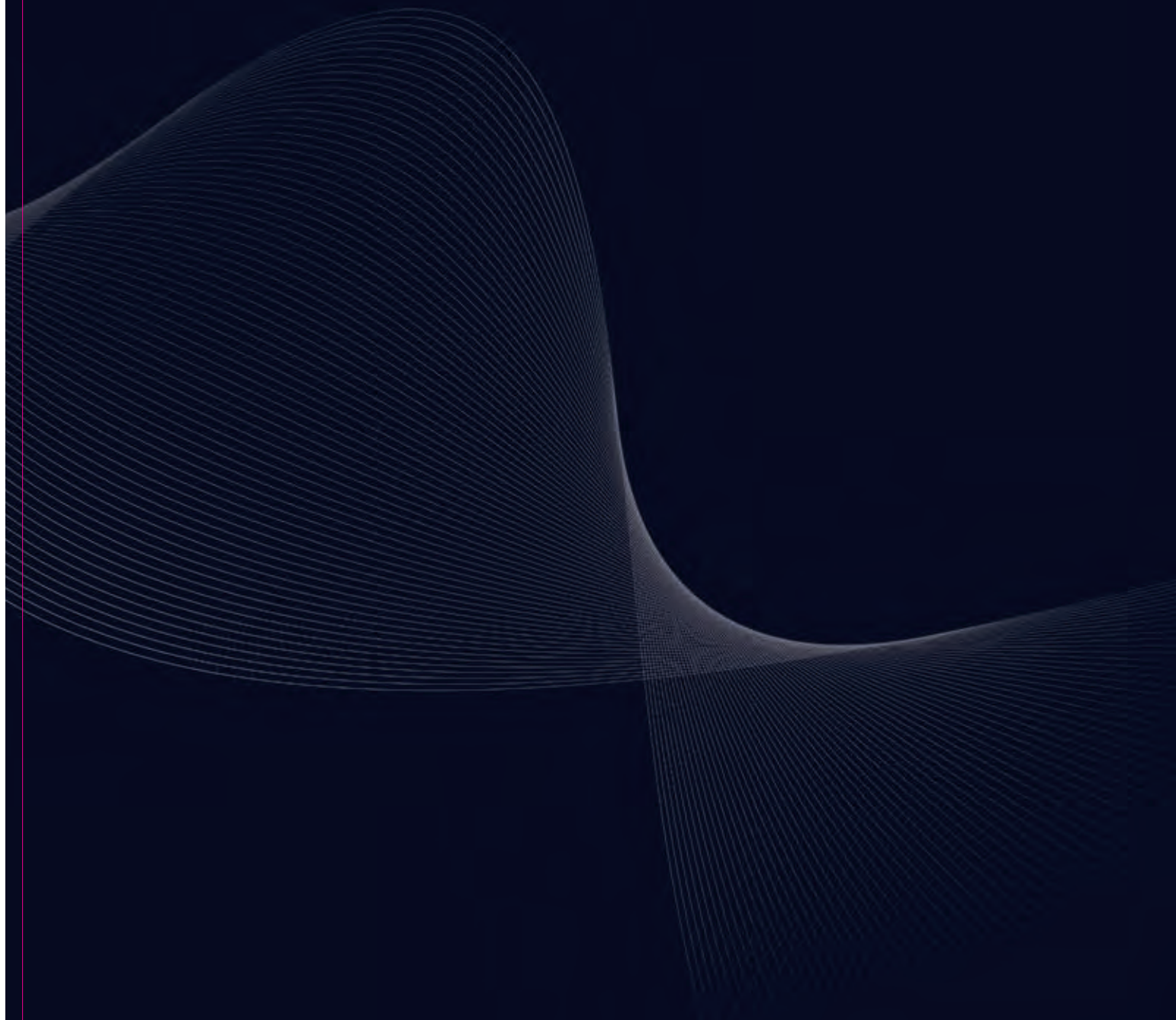
6. Finished part with test certificate

## Process optimisation

Finish-machining a power transmission housing: the priority in the manufacture of this housing is the durable high quality of the surface finish. Allmatic ensures that this is achieved by means of high process reliability. The profile is produced via profile grinding wheels, and the contour is checked with a profile measuring device. This is the only way to maintain the clamping forces within a specified tolerance range. All the production processes undergo continuous optimisation with regard to costs and quality.

**“PROCESS OPTIMISATION:  
FINISH-MACHINING A POWER  
TRANSMISSION HOUSING.”**

**TODAY**



# ALLMATIC basic – SIMPLE AND RELIABLE!

This motto fits the ALLMATIC basic to perfection. Because our "small" model offers big advantages.



# ALLMATIC basic – MECHANICAL

## Scope of application:

- Conventional and CNC-controlled milling machines – for efficient, precision machining
- Horizontal installation – great variability and flexibility

## Product features:

- Excellent ease of operation guarantees optimal handling for every application
- Fast adjustment for clamping range presetting
- Operation with the ring wrench supplied

- Reproducible clamping forces are achieved using a torque wrench
- Integrated scrapers ensure functional reliability and minimise cleaning
- Fixing on the machine table by means of mounting holes in the vice base. Additional holes can be made in the soft middle section of the vice base
- Optional centre jaw allows two or more workpieces to be clamped



M8 thread for workpiece stop

M10 thread for mounting HD jaws

Hardened, ground and polished guideway

An overview of the clamping jaws and other accessories is given on the following pages.

Robust base made of case-hardened steel

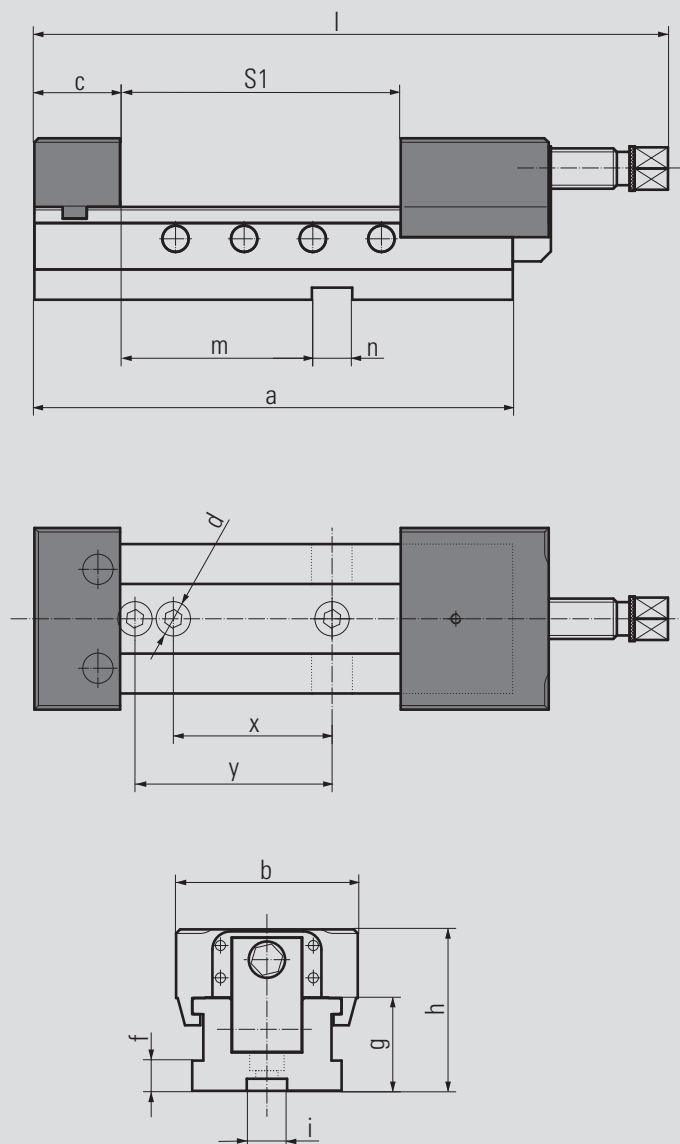
Precision aligning slots and mounting holes in the ground and polished bottom surface

Ground and polished undergrip

## Scope of supply:

- 1 basic vice with clamping jaws
- 1 pair of Click parallels
- 1 socket screw wrench
- 1 ring wrench
- M12 fastening bolts

**Order no. jaw width 125: 692118800055**  
**160: 692120800055**



## Technical data

Jaw width		125	160
Dimensions / tolerances in mm	a	310	405
	b	124	160
	c	50	66
	d	13	13
	f	15	15
	g	48	56
	h	87.5	105.5
	i	20	20
	l max	426	483
	m	120	128
	n	20	20
	x	100	100
	y	125	125

Jaw width	125	160
Clamping range S1 in mm	0 – 208	0 – 283
Torque in Nm	85	120
Max. clamping force in kN	35	50
Weight in kg	16	26

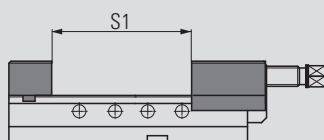


## ALLMATIC basic – mechanical (accessories)

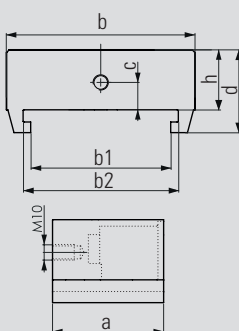
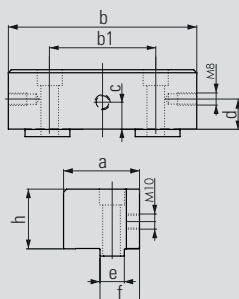
### Top jaws



- Material: hardened steel
- High side of jaw hardened
- Ground clamping surfaces
- Additional thread on the step side for mounting HD jaws



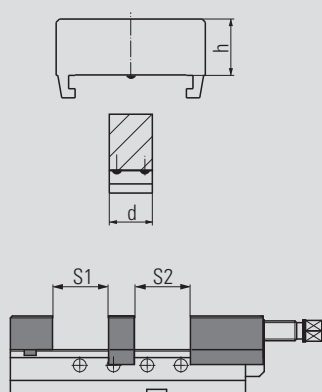
Jaw width	125	160
Clamping range S1	0 – 208	0 – 283



Jaw width			
fixed	125	160	
Ord. no.:	6921184005031	6921204005031	
In mm	a	50	66
	b	124	160
	b1	70	80
	c	18	20
	d	20	20
	e	16	18
	f	26	46
	h	39,5	49,5

Jaw width			
movable	125	160	
Ord. no.:	6921181002031	6921201002031	
In mm	a	73	73
	b	124	160
	b1	92	116
	b2	102	126
	c	18	20
	d	54,5	66,5
	h	39,5	49,5

### Intermediate jaw



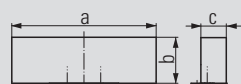
Order no. jaw width 125: 6921185024040  
160: 6921205024040

Jaw width	125	160	
Dimensions in mm	h	39.5	49.5
	d	33	41

Clamping range S1	0 – 87	0 – 121
Clamping range S2	0 – 87	0 – 121

- Material: hardened steel
- For clamping more than one part
- Installation between fixed and movable jaws of the vice
- Mount for Click system on both sides of the jaw

### Soft jaw



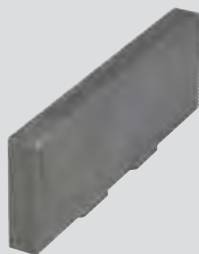
Order no. jaw width 125: 6921684023042

Jaw width	125	
Dimensions in mm	a	125
	b	39.8
	c	22

- Material: case-hardened steel 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Only for use with jaws with Click system

## ALLMATIC basic – mechanical (accessories)

### Jaw with cross grooving

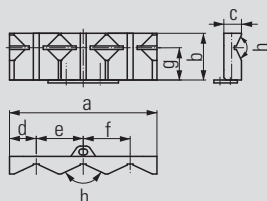


Order no. jaw width 125: 6921684032040

Jaw width	125	
Dimensions in mm	a	125.6
	b	40.1
	c	12

- Material: hardened steel
- Jaws with sharp serrations to increase the specific contact pressure per unit area
- Visual impressions on workpiece
- Only suitable for soft materials
- Only for use with jaws with Click system

### Prismatic jaws (pair)

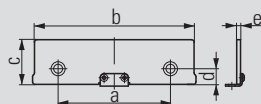


Order no. jaw width 125: 6921684024042

Jaw width	125	
Dimensions in mm	a	125.6
	b	39.8
	c	15
	d	22.8
	e	40
	f	40
	g	27.5
	h	130°

- Material: hardened steel
- Jaws for clamping round parts, vertical dia. 16 – 74 mm, horizontal dia. 12 – 40 mm
- Only for use with jaws with Click system

### Click parallels (pair)



Order no. jaw width 125: 6921185035042

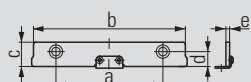
160: 6921205044042

Jaw width	125	160
Dimensions in mm	a	88
	b	125
	c -0.01	35
	d	12.25
	e	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Parallels with Click system

## ALLMATIC basic – mechanical (accessories)

### Click parallels (pair)



Order no. jaw width 125: 6921185020042

160: 6921205025042

Jaw width		125	160
Dimensions in mm	a	88	88
	b	125	160
	c -0.01	20	25
	d	12.25	12.25
	e	3	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Parallels with Click system

### Smooth jaws (pair)



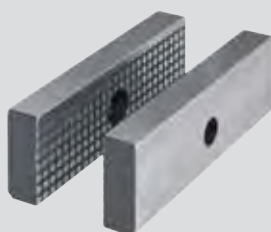
Order no. jaw width 125: 6921024022031

160: 6921034022031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

- Material: hardened steel
- For parts with delicate clamping surfaces
- Please order fastening bolts separately (order no. 6921011023000)

### Serrated jaws (pair)



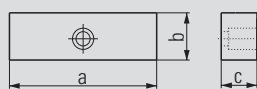
Order no. jaw width 125: 6921021005031

160: 6921031005031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

- Material: hardened steel
- Standard jaws with serration
- To increase the specific contact pressure per unit area
- Please order fastening bolts separately (order no. 6921011023000)

### Soft basic jaws (pair)



Order no. jaw width 125: 6921024023031

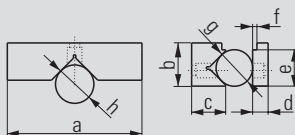
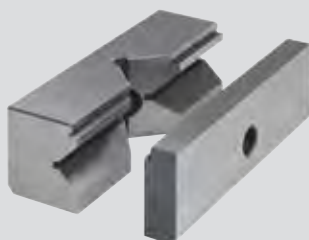
160: 6921034023031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	25	30

- Material: 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Please order fastening bolts separately (order no. 6921011023000)

## ALLMATIC basic – mechanical (accessories)

### Prismatic jaws (set)

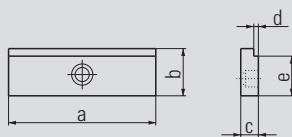


Order no. jaw width 125: 6921024024031  
160: 6921034024031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	35	45
	d	15	20
	e	35	45
	f	3	3
	g	Ø 12 – 28	Ø 15 – 40
	h	Ø 18 – 55	Ø 22 – 65

- Material: hardened steel
- For horizontal and vertical clamping of round and flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

### Step jaws (pair)



Order no. jaw width 125: 6921024025031  
160: 6921034025031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20
	d	3	3
	e	35	45

- Material: hardened steel
- For horizontal clamping of flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

### Roller pull-down jaws (pair)



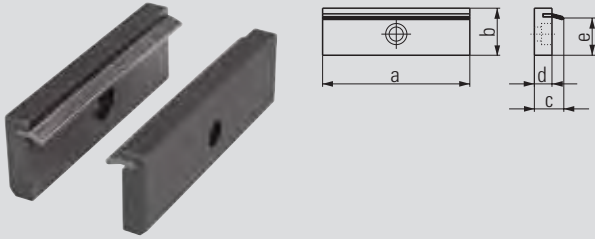
Order no. jaw width 125: 6921024005131  
160: 6921034005131

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	26	35.5
	d	35	45

- Material: hardened steel
- For parts with delicate clamping surfaces
- Jaw parts in contact with the workpiece press the workpiece onto the support surface
- Please order fastening bolts separately (order no. 6921011023000)

## ALLMATIC basic – mechanical (accessories)

### Spring leaf pull-down jaws (pair)



Order no. jaw width 125: 6921024001042  
160: 6921034001042

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	20	23
	d	12	15
	e	33	43

- Material: hardened steel
- For parts with rough clamping surfaces
- Spring leaves press the workpiece onto the support surface
- Spring leaves are interchangeable, see order no. 6921024002131 and 6921034002131 (see below)
- Please order fastening bolts separately (order no. 6921011023000)

### Spring leaves (pair)



Order no. jaw width  
125: 6921024002131  
160: 6921034002131

- Spring leaves (spare) for spring leaf pull-down jaws (see above)

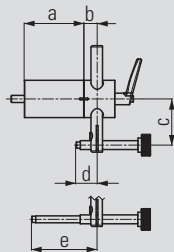
### Jaw fixing bolt



Order no. 6921011023000

- Bolt with shoulder – M10 x 23
- Suitable for all HD jaws, type 125 to 160

### Workpiece stop



Order no. 6921285650144

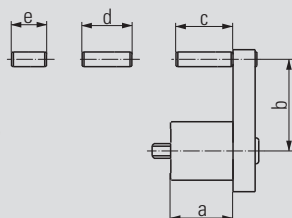
Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Position of the third workpiece axis can be preset and clamped
- Workpiece stop can be swivelled away once the workpiece has been clamped
- This allows the stop side of the workpiece to also be machined (repeating accuracy:  $\pm 0.01$ )



## ALLMATIC basic – mechanical (accessories)

### Workpiece stop



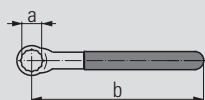
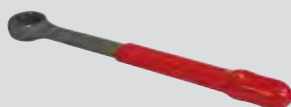
Order no. 6921685670042

Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Can be pre-mounted with various fixed dimensions
- Position of the third workpiece axis can be preset

### Ring wrench

Order no. 0651110811210

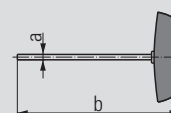


Dimensions in mm	a	SW 19
	b	192

- With grip sleeve made of soft plastic

### T-wrench

Order no. 0651112010536



Dimensions in mm	a	SW 6
	b	182

- For adjusting the clamping range

### Side clamps (pair)



Order no. 6921025000031

- For securing the vice on the machine table
- Supplied as a set of 2

Suitable for the Series 125 mm up to 200 mm

### Aligning and fixing set

Order no. – see table



T-slot	Order no.
12	6921185620031
14	6921185621031
16	6921185622031
18	6921185623031

- For securing through the base
- For aligning (positioning) and securing the basic vices on the machine table
- Size according to T-slot in the machine table

### Aligning and fixing set

Order no. – see table



T-slot	Order no.
12	6921185600031
14	6921185601031
16	6921185602031
18	6921185603031

- For securing with side clamps
- For aligning (positioning) and securing the basic vices on the machine table
- Size according to T-slot in the machine table

# ALLMATIC HD – EXTREMELY ROBUST AND RELIABLE

For more than 40 years now, ALLMATIC HD has been a watchword for reliability. Its sturdy design effectively makes it a lifetime investment.





# ALLMATIC HD – MECHANICAL

## Scope of application:

- Suitable for heavy machining work, single pieces and small batches
- Designed particularly for use on conventional milling machines

## Product features:

- Clamping force preselection, 2 to 4 increments, allows accurate repetition (type 100 – 2 increments; types 125, 160 – 4 increments)
- Our tried and tested HD vice enables problem-free working with high clamping force and long-term reliability



Hardened, ground and polished guideway

Robust base made of GGG 60

Clamping force presetting

M8 thread for workpiece stop

Precise aligning slots (longitudinal/transverse) in the bottom surface for optimal alignment on the machine table

Fixing bolt for presetting the clamping range

**Order no. jaw width 100: 6921011000055**  
**125: 6921021000055**  
**160: 6921031000055**

## Scope of supply:

- 1 high-pressure vice
- 4 side clamps
- 1 pair of serrated clamping jaws (1501)
- 1 hand crank

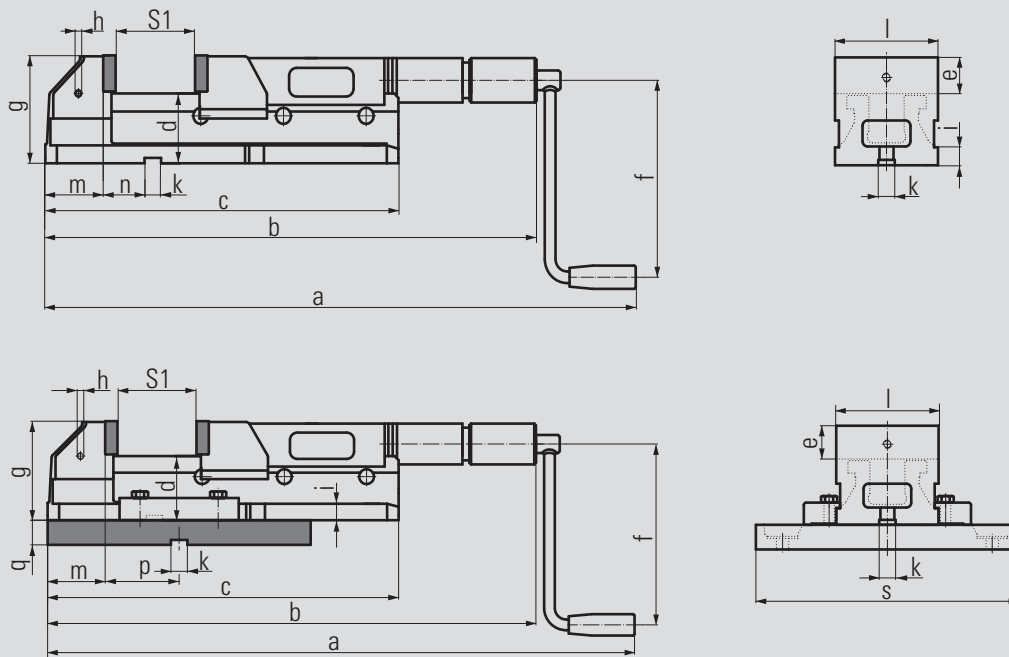
**with swivel base: order no. jaw width 100: 6921011000455**  
**125: 6921021000455**

## Scope of supply:

- 1 high-pressure vice
- 1 pair of serrated clamping jaws
- 1 swivel base
- 1 hand crank

An overview of the clamping jaws and other accessories is given on the following pages.





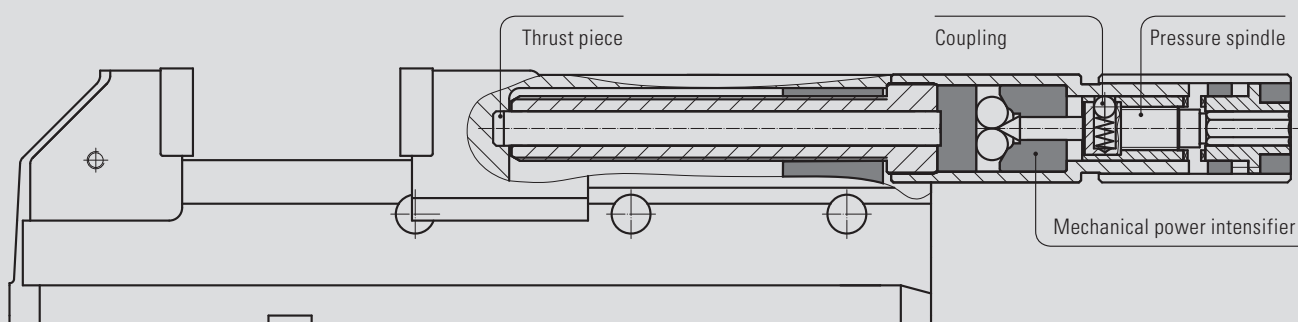
## Technical data

Jaw width		100	125	160
Dimensions / tolerances in mm	a min.	520	612	717
	a max.	682	814	1019
	b min.	419	507	613
	b max.	581	709	915
	c	362	427	582
	d	53.5	78	85
	e	32	40	50
	f	147	178	178
	g	87	120	137
	h	M8	M8	M8
	i	15	21	21
	k	20	20	20
	l	100	125	160
	m	52	70	88
	n	47	50	100
p	73	75	—	
q	26	30	—	
s	Ø 260	Ø 320	—	

Jaw width	100	125	160
Clamping range S1 in mm	0 – 82	0 – 102	0 – 152
Clamping range S2 in mm (can be changed by means of fixing bolt)	78 – 162	98 – 202	147 – 302

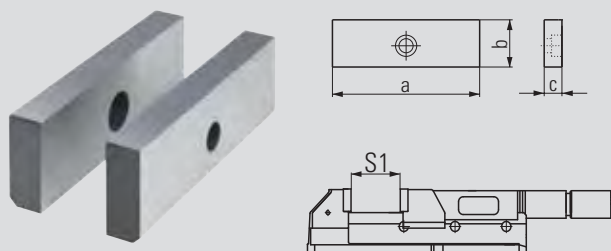
Clamping force increments	2	4	4
Max. clamping force in kN	30	40	60
Weight in kg HD	18	30	60
Weight in kg HD with swivel base	24	42	—

## Spindle cross-section



## ALLMATIC HD – mechanical (accessories)

### Smooth jaws (pair)



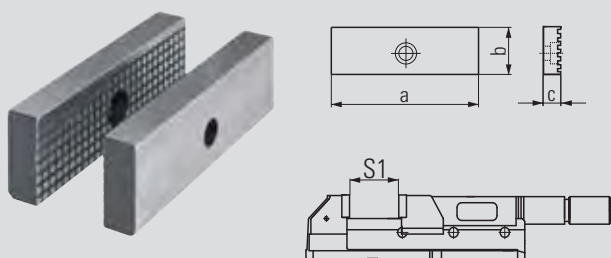
- Material: hardened steel
- For parts with delicate clamping surfaces
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 100: 6921014022031  
 125: 6921024022031  
 160: 6921034022031

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	12	15	20

Clamping range S1	0 – 82	0 – 102	0 – 152
Can be changed by means of fixing bolt	78 – 162	98 – 202	147 – 302

### Serrated jaws (pair)



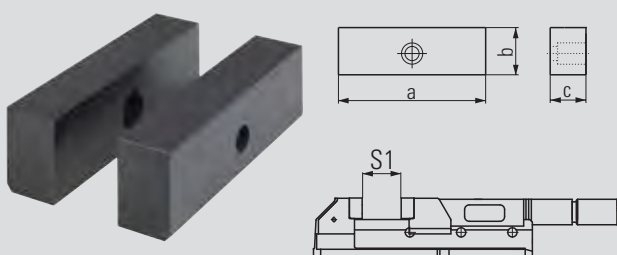
- Material: hardened steel
- Standard jaws with serration
- To increase the specific contact pressure per unit area
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 100: 6921011005031  
 125: 6921021005031  
 160: 6921031005031

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	12	15	20

Clamping range S1	0 – 82	0 – 102	0 – 152
Can be changed by means of fixing bolt	78 – 162	98 – 202	147 – 302

### Soft jaws (pair)



- Material: 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Please order fastening bolts separately (order no. 6921011023000)

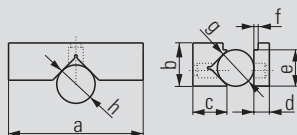
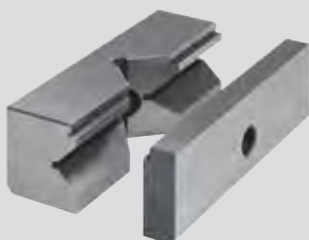
Order no. jaw width 100: 6921014023031  
 125: 6921024023031  
 160: 6921034023031

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	20	25	30

Clamping range S1	0 – 66	0 – 84	0 – 132
Can be changed by means of fixing bolt	62 – 146	80 – 184	127 – 282

## ALLMATIC HD – mechanical (accessories)

### Prismatic jaws (set)

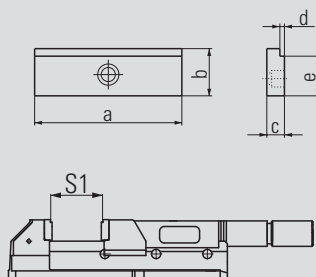


- Material: hardened steel
- For horizontal and vertical clamping of round and flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 100: 6921014024031  
 125: 6921024024031  
 160: 6921034024031

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	30	35	45
	d	12	15	20
	e	28	35	45
	f	3	3	3
	g	∅ 10 – 25	∅ 12 – 28	∅ 15 – 40
	h	∅ 15 – 45	∅ 18 – 55	∅ 22 – 65

### Step jaws (pair)



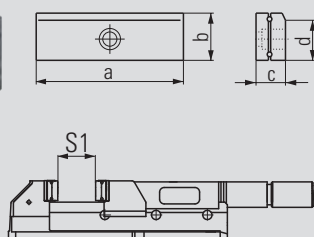
- Material: hardened steel
- For horizontal clamping of flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 100: 6921014025031  
 125: 6921024025031  
 160: 6921034025031

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	12	15	20
	d	3	3	3
	e	28	35	45

Clamping range S1	7 – 88	7 – 108	7 – 158
Can be changed by means of fixing bolt	84 – 168	104 – 208	153 – 308

### Roller pull-down jaws (pair)



- Material: hardened steel
- For parts with delicate clamping surfaces
- Jaw parts in contact with the workpiece press the workpiece onto the support surface
- Please order fastening bolts separately (order no. 6921011023000)

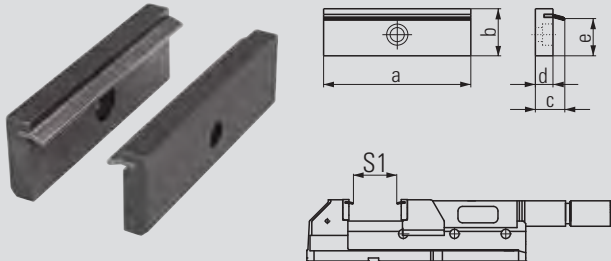
Order no. jaw width 125: 6921024005131  
 160: 6921034005131

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	26	35.5
	d	35	45

Clamping range S1	0 – 80	0 – 115
Can be changed by means of fixing bolt	76 – 180	110 – 265

## ALLMATIC HD – mechanical (accessories)

### Spring leaf pull-down jaws (pair)



- Material: hardened steel
- For parts with unmachined clamping surfaces
- Spring leaves press the workpiece onto the support surface
- Spring leaves are interchangeable, (see below)
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 100: 6921014001042  
 125: 6921024001042  
 160: 6921034001042

Jaw width	100	125	160
Dimensions in mm			
a	100	125	160
b	32	40	50
c	20	20	23
d	12	12	15
e	25	33	43

Clamping range S1	0 – 66	0 – 92	0 – 146
Can be changed by means of fixing bolt	62 – 146	88 – 192	141 – 296

### Spring leaves (pair)



Order no. jaw width  
 100: 6921014002131  
 125: 6921024002131  
 160: 6921034002131

- Spring leaves (spare)  
for the spring leaf pull-down jaws, (see above)

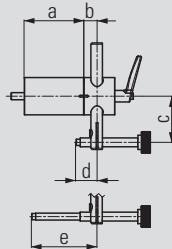
### Jaw fixing bolt



Order no. 6921011023000

- Bolt with shoulder – M10 x 23
- Suitable for all jaws, jaw width 090 mm to 160 mm

### Workpiece stop



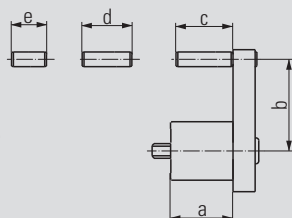
Order no. 6921285650144

Dimensions in mm	a	b
	67	15
	33 – 92	
	12 – 63.5	
	53.5 – 113.5	

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Position of the third workpiece axis can be preset and clamped
- Workpiece stop can be swivelled away once the workpiece has been clamped
- This allows the stop side of the workpiece to also be machined (repeating accuracy:  $\pm 0.01$ )

## ALLMATIC HD – mechanical (accessories)

### Workpiece stop

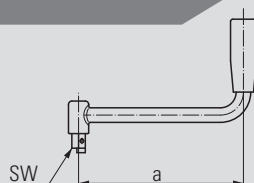
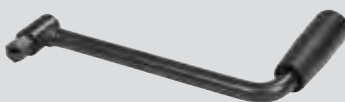


Order no. 6921685670042

Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Can be pre-mounted with various fixed dimensions
- Position of the third workpiece axis can be preset

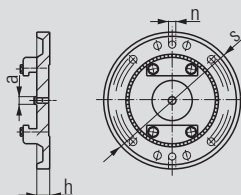
### Hand crank



Order no. jaw width 100: 6923015000131  
125 & 160: 6923025000131

Jaw width	100	125	160
Dimensions in mm	a	147	178
	SW	12	14

### Swivel base



Order no. jaw width 100: 6921013000044  
125: 6921023000044

Jaw width	100	125
Dimensions in mm	a	Ø 20
	h	26
	n	20
	s	Ø 260

- Particularly suitable for single-piece production if you wish to make your vice rotatable
- Can be removed at any time
- Swivel base supporting edge larger than the vice's maximum clamping range

- Swivels 360° without indexing
- Alignment on the machine with T-keys in slots in the swivel base
- Clamping slots arranged in the form of a ring for machines with different slot spacings

### Side clamps (pair)



Order no. jaw width  
100: 6921015000231  
125 & 160: 6921025000031

- For securing the HD high-pressure vice on the machine table

- Supplied as a set of 2

### Aligning and fixing set



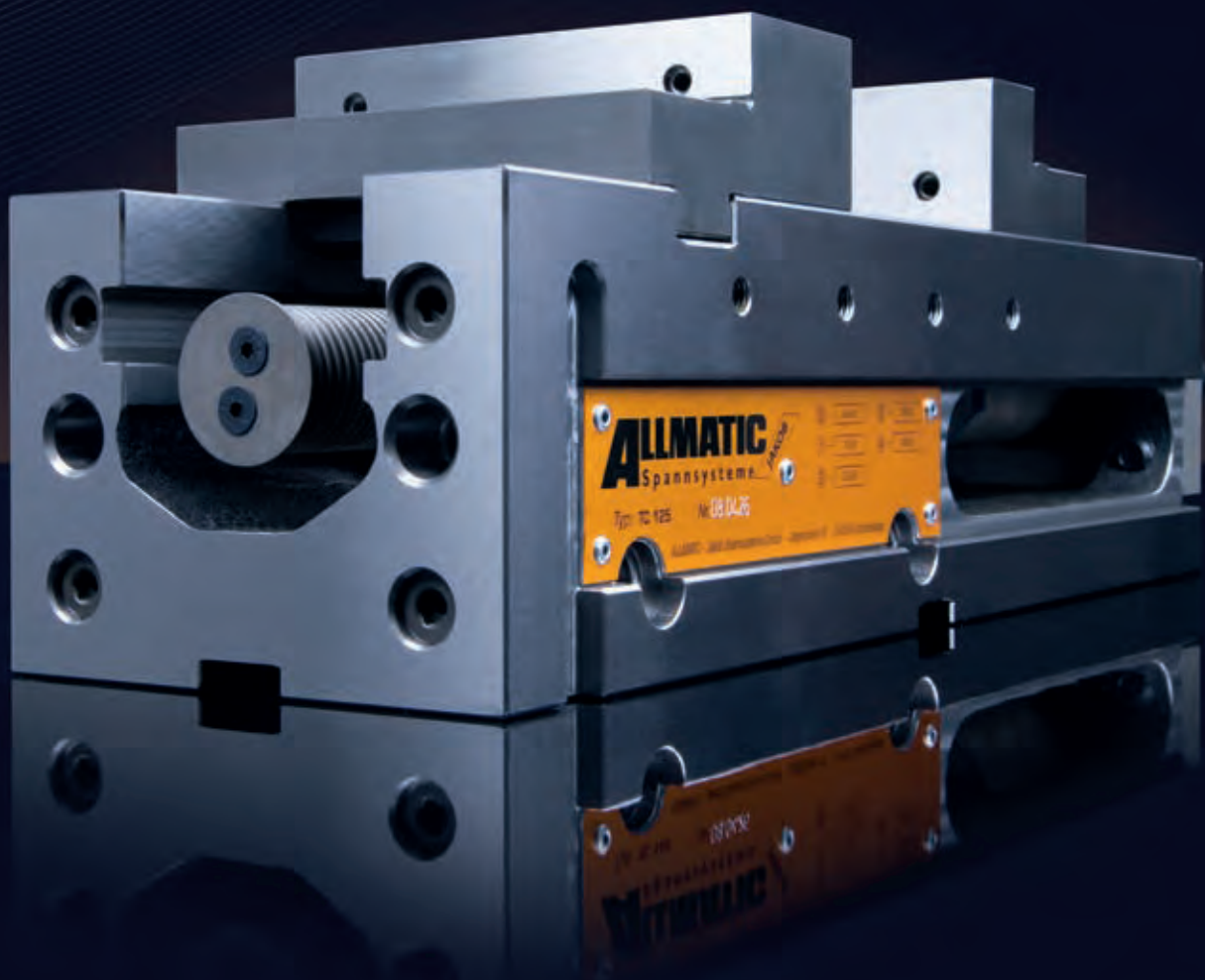
Order no. – see table

T-slot/thread	Order no.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

- For aligning (positioning) and securing the vice on pallet and machine table
- Size according to T-slot or thread in the machine table

# ALLMATIC NC SERIES – HIGH PRECISION AND POWER

The ALLMATIC NC series of vices  
offers outstanding flexibility.





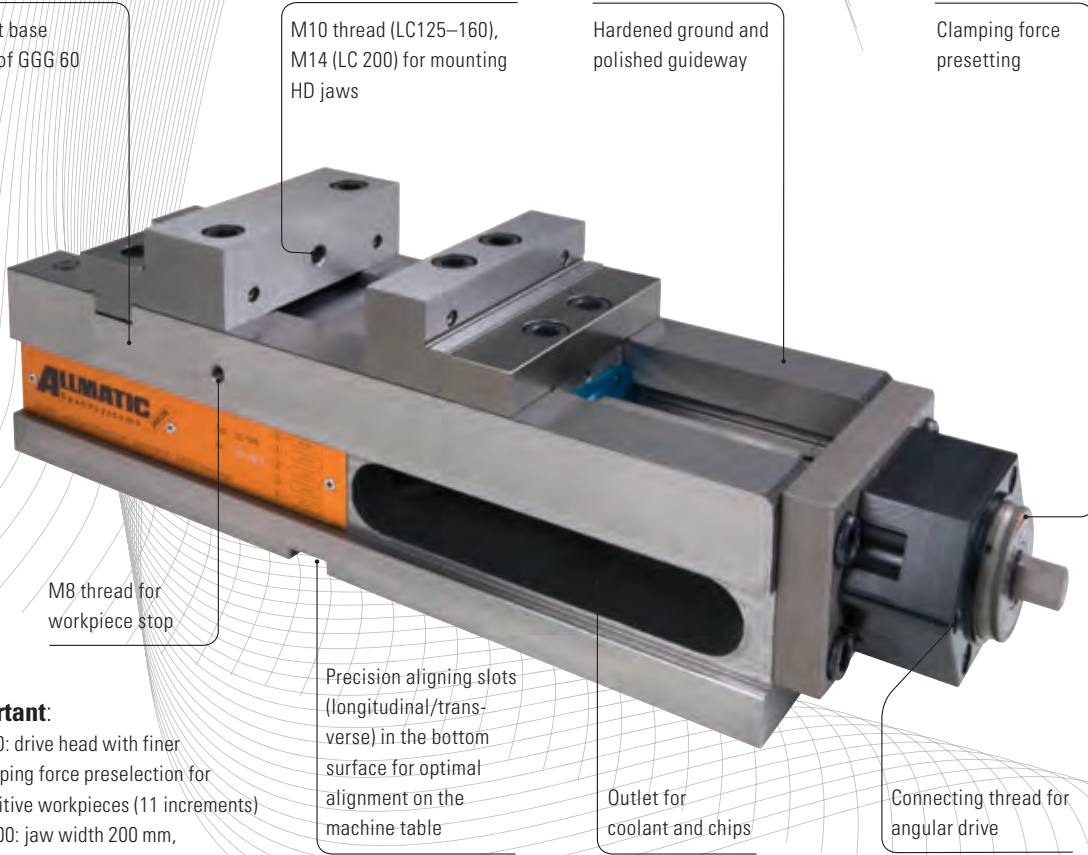
# ALLMATIC NC – MECHANICAL LC VERSION

### Scope of application:

- Horizontal installation – suitable for vertical CNC-controlled milling machines

### Product features:

- Extreme accuracy for your machining
- Clamping force can be preset in 4 to 11 increments. At most, 2 revolutions are required to reach the max. clamping force
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within a tolerance of less than 0.01 mm



### Important:

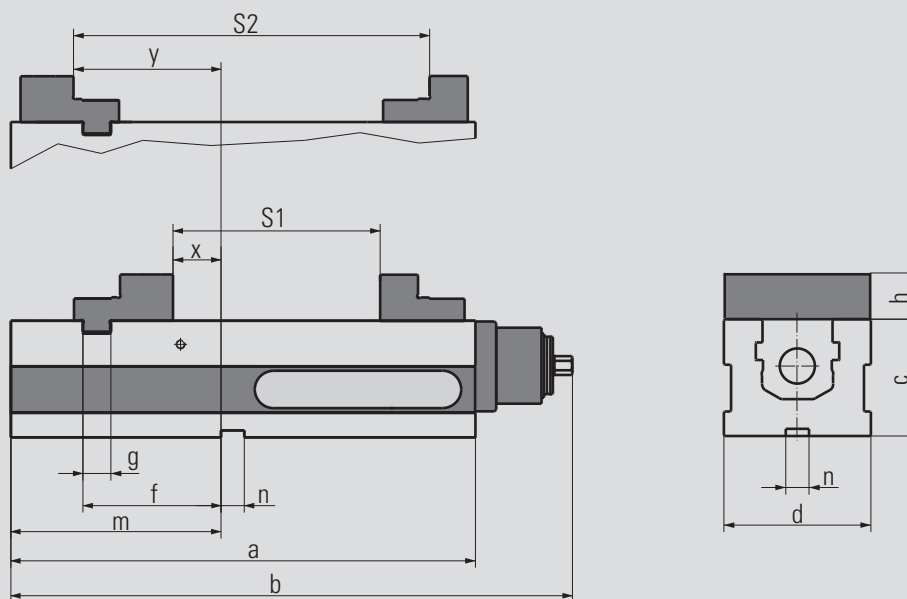
- LC 90: drive head with finer clamping force preselection for sensitive workpieces (11 increments)
- LC 200: jaw width 200 mm, width of vice base 164 mm

<b>Order no. jaw width</b>	<b>90:</b>	<b>6921678000955</b>
	<b>125:</b>	<b>6921688000955</b>
	<b>160:</b>	<b>6921708000955</b>
	<b>200:</b>	<b>6921698000955</b>

### Scope of supply:

- 1 high-pressure vice with step jaws
- 1 hand crank
- 4 side clamps
- 2 socket screw wrenches
- 1 compensation jaw for clamping range from 0 mm – only LC 160 and 200

An overview of the clamping jaws and other accessories is given on the following pages.

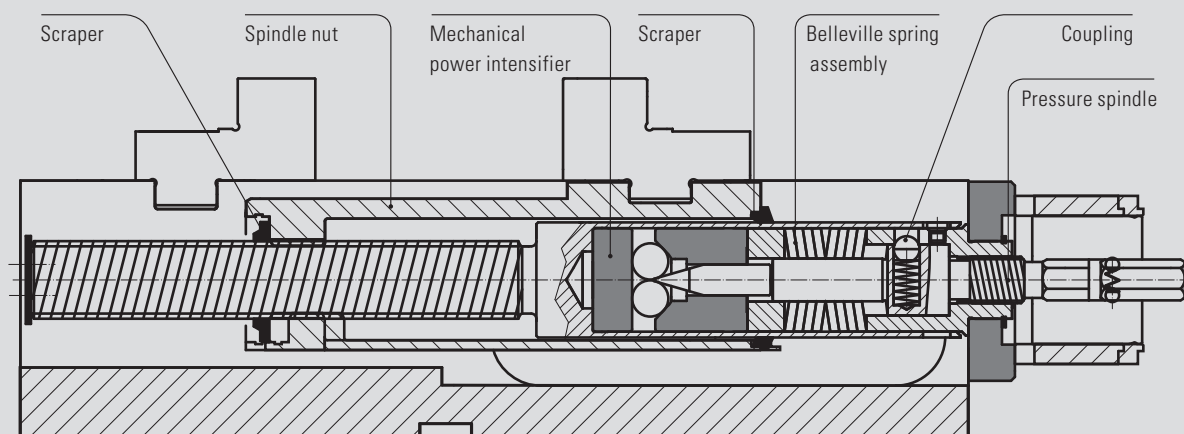


## Technical data

Jaw width		90	125	160	200
Dimensions in mm	a	283	398	530	530
	b	339	483	616	616
	c	80	100	115	115
	d	90	126	164	164
	f	73	118	164	164
	g	20	24	30	30
	h	34	39.5	49.8	60
	m	112	180	234	234
	n	20	20	20	20
	x	15	36	70	70
	y	75	127	178	178

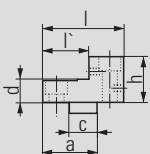
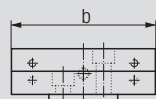
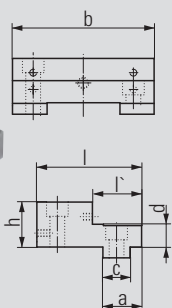
Jaw width	90	125	160	200
Clamping range S1 in mm	0–126	0–182	(0) 17–263	(0) 15–261
Clamping range S2 in mm	93–217	131–313	189–435	188–434
Clamping force increments	11	4	4	4
Max. clamping force in kN	28	40	60	60
Weight in kg	16	36	67,2	71

## Spindle cross-section

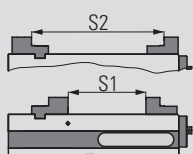


## ALLMATIC NC – mechanical /LC version (accessories)

### Step jaws



- Material: hardened steel
- High and step sides with thread for parallels
- Ground and polished clamping surfaces
- Additional thread on the high side for mounting HD jaws (Types 125 – 200)
- Click system on the high side

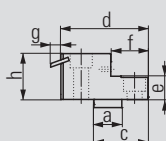
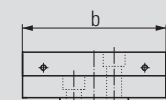
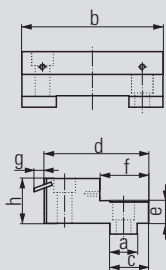


Jaw width	90	125	160	200
Clamping range S1	0 – 126	0 – 182	17 – 263	15 – 261
Clamping range S2	93 – 217	131 – 313	189 – 435	188 – 434

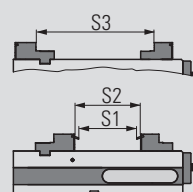
		Jaw width			
fixed		90	125	160	200
Ord. no.:		6921674006731	6921684006731	6921704006731	6921694006031
In mm	a	30	34	40	40
	b	89,5	124,4	160,4	200,4
	c	20	24	30	30
	d	16	20	25	25
	h	34	39,5	49,8	60
	l	68	92	104	104
	l'	32	43	54	54

		Jaw width			
movable		90	125	160	200
Ord. no.:		6921474002731	6921484002731	6921304002731	6921294002231
In mm	a	38	47	63	65
	b	89,5	124,4	160,4	200,4
	c	20	24	30	30
	d	16	20	25	25
	h	34	39,5	49,8	60
	l	56	70	96	100
	l'	31	40	64	65

### Pull-down jaws



- Material: hardened steel
- Pull-down with ground and polished spring leaves for machined and unmachined clamping surfaces
- Ground and polished clamping surfaces
- High clamping accuracy for parallel and accurate angle machining
- Click system on the high side



Jaw width	125
Clamping range S1	0 – 159
Clamping range S2	0 – 176
Clamping range S3	124 – 305

		Jaw width	
fixed		125	
Ord. no.:		6921684106031	
In mm	a	24	
	b	124,4	
	c	34	
	d	92	
	e	20	
	f	43	
	g	8,8	
	h	39,5	

		Jaw width	
movable		125	
Ord. no.:		6921684102031	
In mm	a	24	
	b	124,4	
	c	46,5	
	d	75	
	e	20	
	f	32	
	g	8,8	
	h	39,5	

## ALLMATIC NC – mechanical / LC version (accessories)

### Spring leaves (pair)



Order no. jaw width 90: 6921884103031

- Hardened spring leaves
- Spring leaves (spare) for pull-down jaws Type 90 (see left)

### Spring leaves (pair)



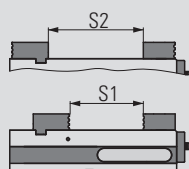
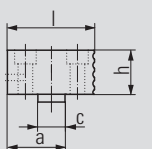
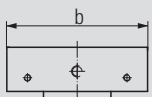
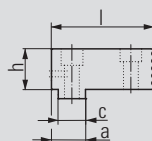
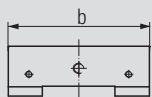
Order no. jaw width 125: 6921684103031  
160: 6921704103031

- Hardened spring leaves
- Spring leaves (spare) for pull-down jaws Type 125 and 160 (see left)

### Hard basic jaws



- Material: hardened steel
- One side smooth, ground and polished; one side serrated
- Additional thread for parallels and for mounting HD jaws on the smooth side
- Mounts for Click system on both sides of the jaw



		Jaw width		
fixed		90	125	160
Ord. no.:		6921674005731	6921684005731	6921704005731
In mm	a	26	30	40
	b	89,5	124,4	160,4
	c	20	24	30
	h	34	39,5	49,8
	l	63	88	104

		Jaw width		
movable		90	125	160
Ord. no.:		6921674004731	6921684004731	6921704004731
In mm	a	40	50	65
	b	89,5	124,4	160,4
	c	20	24	30
	h	34	39,5	49,8
	l	60	76	100

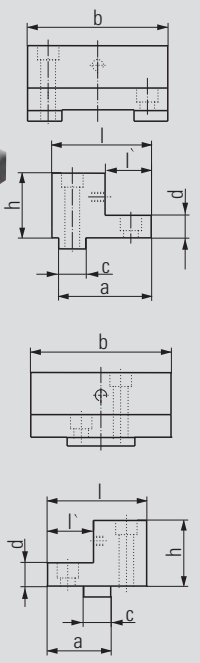
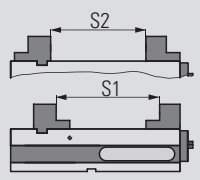
Clamping range S1	0 – 125	0 – 179	15 - 261
Clamping range S2	30 – 156	49 – 231	69 - 315

## ALLMATIC NC – mechanical /LC version (accessories)

### Master jaw adapters



- Material: hardened steel
- High side of jaw hardened
- Ground clamping surfaces
- Additional thread on the step side for mounting HD jaws
- Click system on the high side



Jaw width	90	125	160	200
Clamping range S1	62 – 186	64 – 246	88 - 334	92 - 338
Clamping range S2	26 – 152	45 – 227	68 - 314	68 - 314

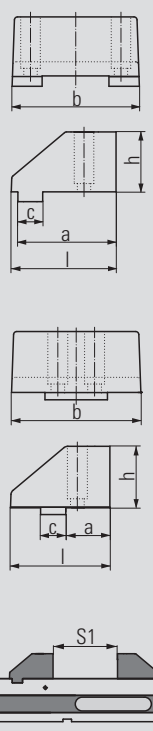
Jaw width				
fixed	90	125	160	200
Ord. no.:	6921674012231	6921684012231	6921704012231	6921694012231
In mm				
a	56	77	89	89
b	90	126	164	202
c	20	24	30	30
d	16	20	24	24
h	46	58	73	85
l	66	85	100	100
l'	30	32	34	34

Jaw width				
movable	90	125	160	200
Ord. no.:	6921274011231	6921284011231	6921304011231	6921294011231
In mm				
a	40	52	65	45
b	90	126	164	202
c	20	24	30	30
d	16	20	24	24
h	46	58	73	85
l	60	80	100	100
l'	30	32	34	38

### Soft jaws



- Material: GGG40
- For production of special jaws by the customer
- Chamfer provides very good accessibility to the workpiece



Order no. fixed: 6921684088031

Jaw width	125	
Dimensions in mm	a	95
	b	124
	c	24
	h	58
	l	101.5

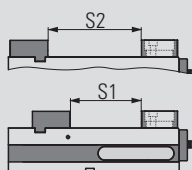
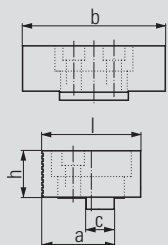
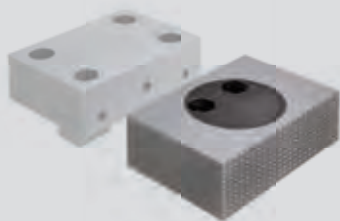
Order no. movable: 6921484087031

Jaw width	125	
Dimensions in mm	a	42
	b	124
	c	24
	h	58
	l	94.5

Clamping range S1	0 – 150
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## ALLMATIC NC – mechanical /LC version (accessories)

### Pivot jaw, movable



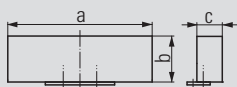
- Material: hardened steel
- With Click-System on both sides
- One side smooth, ground and polished; one side serrated
- Rotatable through 360°
- Picture with hard basic jaw (see page 71)

Order no. jaw width 90: 6921674020142  
 125: 6921684020042  
 160: 6921704020042

Jaw width		90	125	160
Dimensions in mm	a	49.5	62	86
	b	90	124.4	160.4
	c	20	24	30
	h	34	39.5	49.8
	l	68	84	118

Clamping range S1	0 – 115	0 – 167	0 – 240
Clamping range S2	21 – 146	37 – 219	48 – 294

### Soft jaw

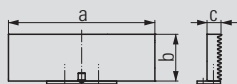
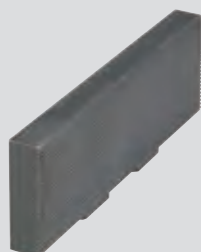


Order no. 6921684023042

Jaw width		125
Dimensions in mm	a	125
	b	39.8
	c	22

- Material: case-hardened steel 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Only for use with jaws with Click system

### Jaw with cross grooving



Order no. 6921684032040

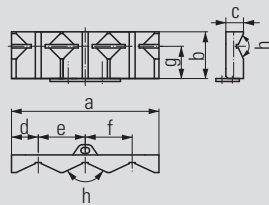
Jaw width		125
Dimensions in mm	a	125.6
	b	40.1
	c	12

- Material: hardened steel
- Jaws with sharp serrations to increase the specific contact pressure per unit area
- Visible impressions on workpiece
- Only suitable for soft materials
- Only for use with jaws with Click system

## ALLMATIC NC – mechanical /LC version (accessories)

### Prismatic jaws (pair)

Order no. 6921684024042

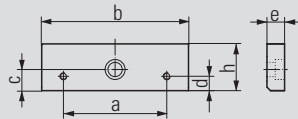


- Material: hardened steel
- Jaws for clamping round parts, vertical dia. 16-74 mm, horizontal dia. 12-40 mm
- Only for use with jaws with Click system

c		125
Dimensions in mm	a	125.6
	b	39.8
	c	15
	d	22.8
	e	40
	f	40
	g	27.5
	h	130°

### Compensation jaw

Order no. jaw width 160: 6921704022031  
200: 6921694022031

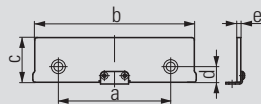


- Material: hardened steel
- Ground and polished clamping surfaces
- For clamping range from 0 mm
- With the LC 160 and 200 vices, this jaw is included

Jaw width	160	200	
Dimensions in mm	a	88	110
	b	160.4	200.4
	c	20	25
	d	12.25	18
	e	18	18
	h	49.8	60

### Click parallels (pair)

Order no. jaw width 90: 6921175029042  
125: 6921185035042  
160: 6921205044042

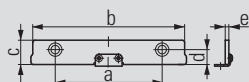


- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels with Click system
- For the high side of the jaws

Jaw width	90	125	160	
Dimensions in mm	a	48	88	88
	b	90	125	160
	c -0.01	29	35	44
	d	8.75	12.25	12.25
	e	3	3	3

## ALLMATIC NC – mechanical / LC version (accessories)

### Click parallels (pair)

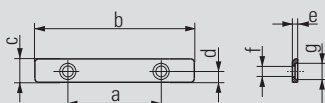


- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels with Click system
- For the high side of the jaws

Order no. jaw width 90: 6921175016042  
 125: 6921185020042  
 160: 6921205025042

Jaw width	90	125	160
Dimensions in mm			
a	48	88	88
b	90	125	160
c-0.01	16	20	25
d	8.75	12.25	12.25
e	3	3	3

### Parallels (pair)

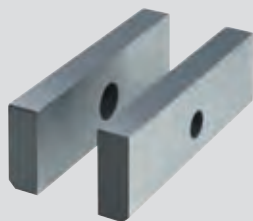


- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels
- For the step side of the jaws

Order no. jaw width 90: 6921475013031  
 125: 6921485015031  
 160: 6921305019031

Jaw width	90	125	160
Dimensions in mm			
a	52	88	88
b	89	124	160
c	13	15	19
d	6	6	6
e	3	3	3
f	Ø 6	Ø 6	Ø 6
g	Ø 9	Ø 9	Ø 9

### Smooth jaws (pair)



- Material: hardened steel
- For parts with delicate clamping surfaces
- Please order fastening bolts separately (order no. 6921011023000)

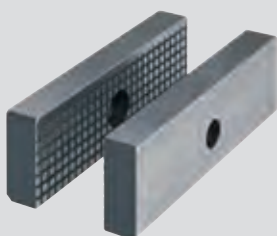
Order no. jaw width 125: 6921024022031  
 160: 6921034022031

Jaw width	125	160
Dimensions in mm		
a	125	160
b	40	50
c	15	20



## ALLMATIC NC – mechanical / LC version (accessories)

### Serrated jaws (pair)



Order no. jaw width 125: 6921021005031  
160: 6921031005031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

- Material: hardened steel
- Standard jaws with serration
- To increase the specific contact pressure per unit area
- Please order fastening bolts separately (order no. 6921011023000)

### Soft jaws (pair)

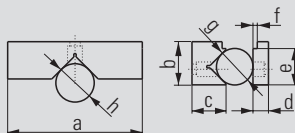
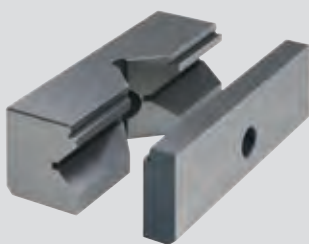


Order no. jaw width 125: 6921024023031  
160: 6921034023031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	25	30

- Material: 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Please order fastening bolts separately (order no. 6921011023000)

### Prismatic jaws (set)



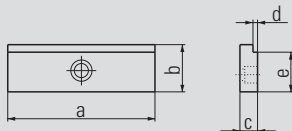
Order no. jaw width 125: 6921024024031  
160: 6921034024031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	35	45
	d	15	20
	e	35	45
	f	3	3
	g	∅ 12 – 28	∅ 15 – 40
	h	∅ 18 – 55	∅ 22 – 65

- Material: hardened steel
- For horizontal and vertical clamping of round and flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

## ALLMATIC NC – mechanical / LC version (accessories)

### Step jaws (pair)

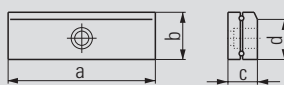


Order no. jaw width 125: 6921024025031  
160: 6921034025031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20
	d	3	3
	e	35	45

- Material: hardened steel
- For horizontal clamping of flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

### Roller pull-down jaws (pair)

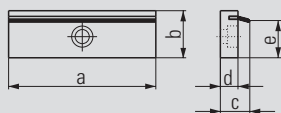


Order no. jaw width 125: 6921024005131  
160: 6921034005131

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	26	35.5
	d	35	45

- Material: hardened steel
- For parts with delicate clamping surfaces
- Jaw parts in contact with the workpiece press the workpiece onto the support surface
- Please order fastening bolts separately (order no. 6921011023000)

### Spring leaf pull-down jaws (pair)




Order no. jaw width 125: 6921024001042  
160: 6921034001042

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	20	23
	d	12	15
	e	33	43

- Material: hardened steel
- For parts with unmachined clamping surfaces
- Spring leaves press the workpiece onto the support surface
- Spring leaves are interchangeable, (see the next page)
- Please order fastening bolts separately (order no. 6921011023000)

**ALLMATIC NC – mechanical / LC version (accessories)**

### Spring leaves (pair)



**Order no. jaw width**  
 125: 6921024002131  
 160: 6921034002131

- Spring leaves (spare) for spring leaf pull-down jaws (see previous page)

### Jaw fixing bolt



**Order no. 6921011023000**

Bolt with shoulder – M10 x 23

- Suitable for all jaws, jaw width 090 mm to 160 mm

### Workpiece stop

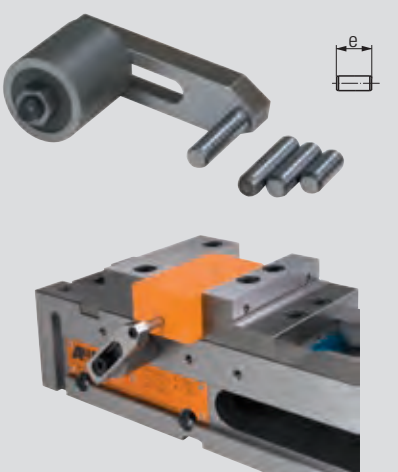
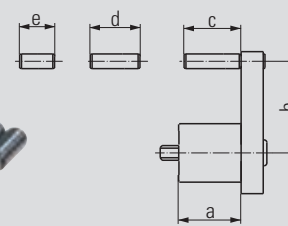



**Order no. 6921285650144**

Dimensions in mm	a	b
	67	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Position of the third workpiece axis can be preset and clamped
- Workpiece stop can be swivelled away once the workpiece has been clamped
- This allows the stop side of the workpiece to also be machined (repeating accuracy:  $\pm 0.01$ )

### Workpiece stop

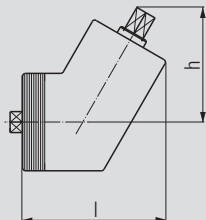
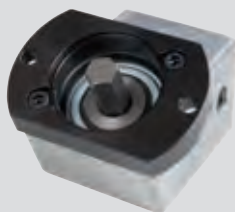
**Order no. 6921685670042**

Dimensions in mm	a	b
	34	27 – 59
	c	31
	d	27
	e	19

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Can be pre-mounted with various fixed dimensions
- Position of the third workpiece axis can be preset

## ALLMATIC NC – mechanical / LC version (accessories)

### Angular drive

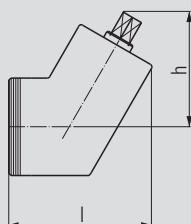


Order no. jaw width 125 to 200: 6921285700143

Jaw width		125	160	200
Dimensions in mm	l	97	97	97
	h	75	75	75

- For jaw width 125 – 200
- Wrench size 14
- Can be bolted to the end of the spindle if access is difficult
- Step-down ratio 2 : 1

### Angular drive

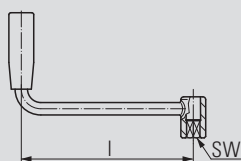


Order no. jaw width 90: 6921675700043

Jaw width		90
Dimensions in mm	l	87
	h	75

- For jaw width 90
- Wrench size 12
- Can be bolted to the end of the spindle if access is difficult
- Step-down ratio 2 : 1

### Hand crank

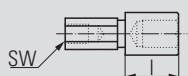


Order no. jaw width 90: 6921675508031  
125 - 200: 6921685508031

Jaw width		90	125
Dimensions in mm	l	150	180
	SW	12	14

- Suitable for jaw width 125 – 200 mm

### Hexagonal extension



Order no. 6921685512040

Jaw width		125
Dimensions in mm	l	30
	SW	14

- Improves access for the hand crank
- Is secured to the hand crank with a bolt

- Suitable for jaw width 125 – 200 mm

## ALLMATIC NC – mechanical / LC version (accessories)

### Hexagonal extension



Order no. 6921685512140

Jaw width	125	
Dimensions in mm	I	60
	SW	14

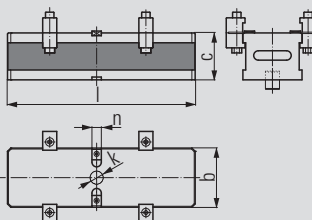
- Improves access for the hand crank
- Is secured to the hand crank with a bolt

- Suitable for jaw width 125 – 200 mm

### XL console



Order no. 6921885010042



- Material: GG30
- For raising the vice
- Improved access for 5-sided machining
- Optional preparation for zero-point clamping systems
- Scope of supply: console incl. fixing bolt for positioning the vice, 4 pairs of DUO side clamps, 2 socket screw wrenches

Jaw width	125	
Dimensions in mm	b	126
	c	100
	k	Ø 30
	l	400
	n	20

### Side clamps (pair)



Order no. jaw width 90: 6921015000231  
125 - 200: 6921025000031

- For securing the vice on the machine table
- Supplied as a set of 2

### DUO side clamps



Order no. jaw width 90: 6921675000031  
125 - 200: 6921285000031

- For securing the vice on a console or machine table
- 1 set consists of 2 pairs of side clamps incl. screw connections

## ALLMATIC NC – mechanical / LC version (accessories)

### Aligning and fixing set



Order no. – see table

T-slot/ thread	Order no.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

- For aligning (positioning) and fastening the vice on pallet and machine table
- Size according to T-slot or thread in the machine table

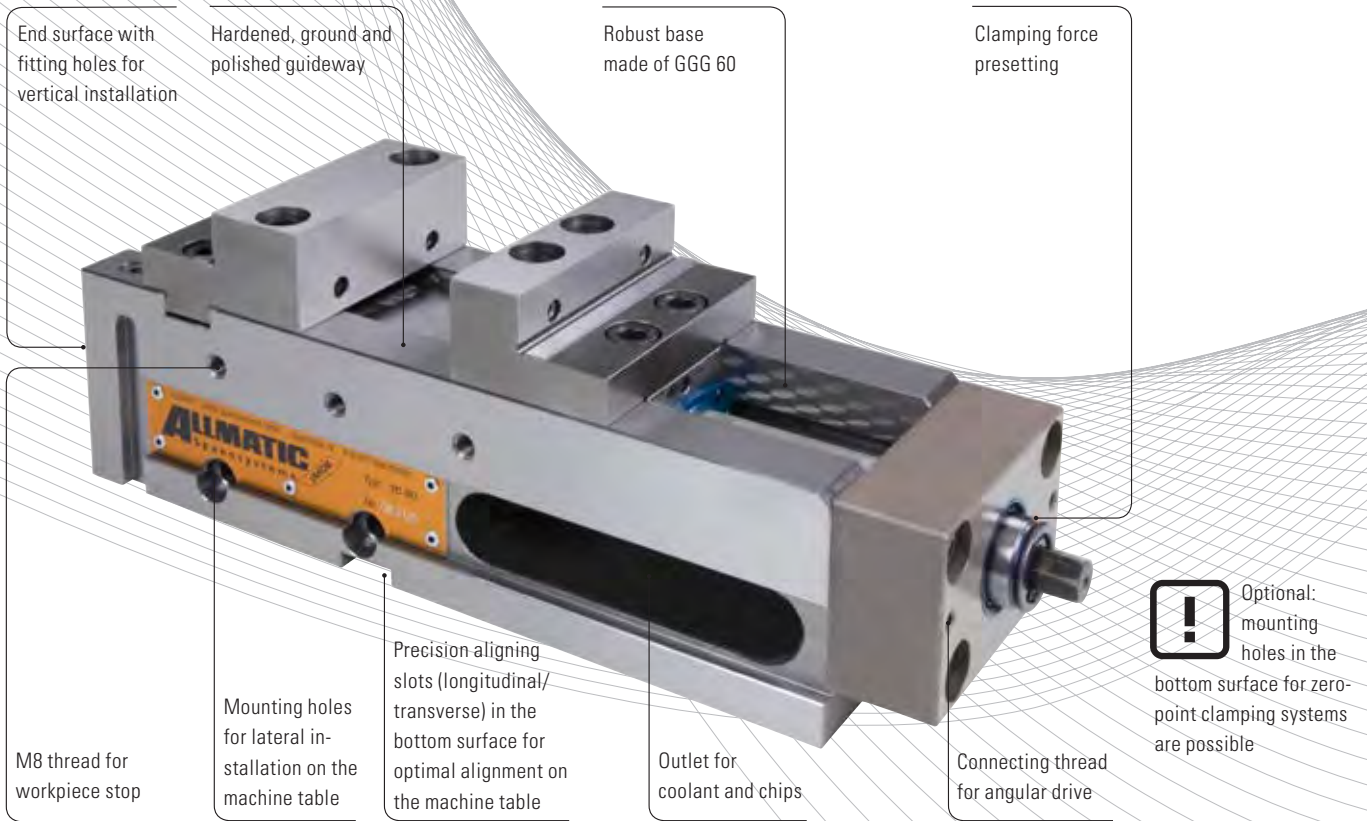
# ALLMATIC NC – MECHANICAL TC VERSION, TYPE 90

**Scope of application:**

- Horizontal and vertical installation – suitable for both vertical and horizontal CNC-controlled milling machines
- Lateral installation is also possible

**Product features:**

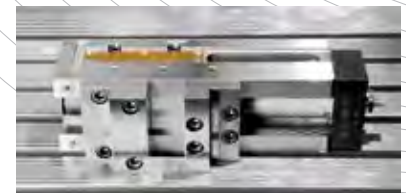
- Extreme accuracy for your machining
- The TC vice is ground and polished on all sides
- Clamping force can be preset in 11 increments – fine gradations for delicate workpieces. At most, one revolution is required to reach the max. clamping force
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within a tolerance of less than 0.01 mm



**Order no. jaw width 90: 6921678000055**

**Scope of supply:**

- 1 high-pressure vice with step jaws
- 1 hand crank
- 4 side clamps
- 1 socket screw wrench



Vice in lateral clamping position

An overview of the clamping jaws and other accessories is given on the following pages.

# ALLMATIC NC – MECHANICAL TC VERSION, TYPE 125

## Scope of application:

- Horizontal and vertical installation – suitable for both vertical and horizontal CNC-controlled milling machines
- Lateral installation is also possible

## Product features:

- Extreme accuracy for your machining
- The TC vice is ground and polished on all sides
- Clamping force can be preset in 4 increments. At most, 2 revolutions are required to reach the max. clamping force
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within a tolerance of less than 0.01 mm



End surface with fitting holes for vertical installation and connecting thread for extension

M10 thread for mounting HD jaws

Hardened, ground and polished guideway

Robust base made of GGG 60

Clamping force presetting


M8 thread for workpiece stop

Mounting holes for lateral installation on the machine table

Precision aligning slots (longitudinal/transverse) in the bottom surface for optimal alignment on the machine table

Outlet for coolant and chips

Connecting thread for angular drive

 Optional: mounting holes in the bottom surface for zero-point clamping systems are possible

**Order no. jaw width 125: 6921688000055**

## Scope of supply:

- 1 high-pressure vice with step jaws
- 1 hand crank
- 4 side clamps
- 2 socket screw wrenches



Vice in lateral clamping position

An overview of the clamping jaws and other accessories is given on the following pages.



# ALLMATIC NC – MECHANICAL TC VERSION, TYPE 160

## Scope of application:

- Horizontal and vertical installation – suitable for both vertical and horizontal CNC-controlled milling machines
- Lateral installation is also possible

## Product features:

- The TC vice is ground and polished on all sides
- Extreme accuracy for your machining
- Clamping force can be preset in 4 increments  
At most, 2 revolutions are required to reach the max. clamping force
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within a tolerance of less than 0.01 mm



End surface with fitting holes for vertical installation and connecting thread for extension

M10 thread for mounting HD jaws

Hardened, ground and polished guideway

Robust base made of GGG 60


Clamping force presetting

M8 thread for workpiece stop

Precision aligning slots (longitudinal/transverse) in the bottom surface for optimal alignment on the machine table

Outlet for coolant and chips

Connecting thread for angular drive

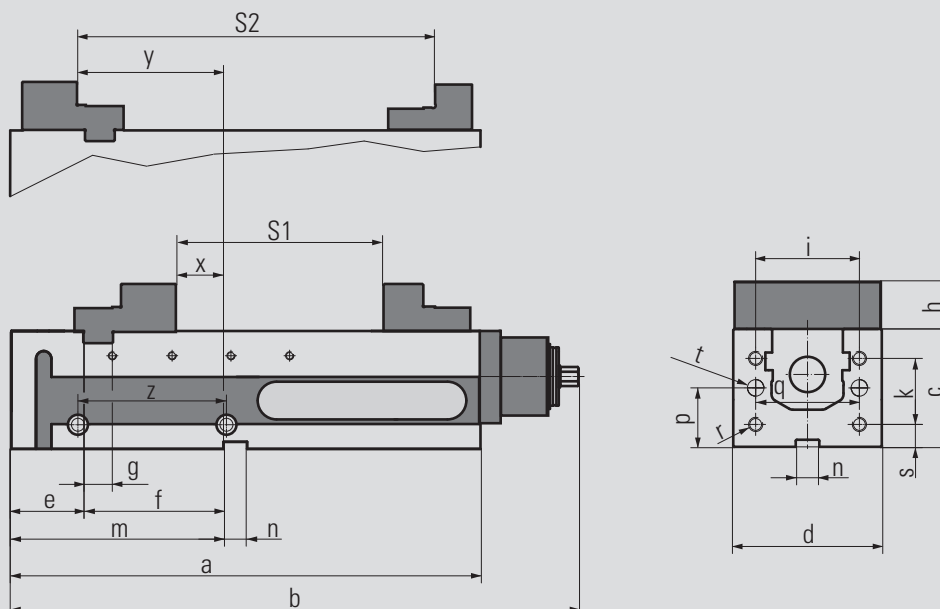
 Optional: mounting holes in the bottom surface for zero-point clamping systems are possible

**Order no. jaw width 160: 6921708000055**

## Scope of supply:

- 1 high-pressure vice with step jaws
- 1 hand crank
- 4 side clamps
- 3 socket screw wrenches
- 1 compensation jaw for clamping range from 0 mm

An overview of the clamping jaws and other accessories is given on the following pages.



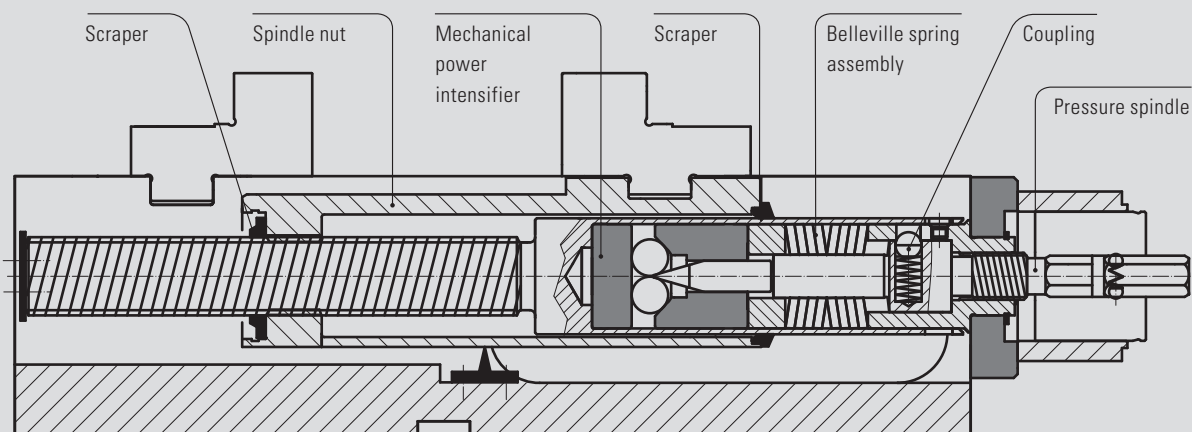
## Technical Data

Jaw width		90	125	160
Dimensions / tolerances in mm	a	283	398	530
	b	339	483	616
	c	80	100	115
	d	90	126	164
	e	39	62	70
	f	73	118	164
	g	20	24	30
	h	34	39.5	49.8
	i	65	88	128
	k	–	56	67
	m	112	180	234
	n	20	20	20
	p	12	50	55
	q	63	88	128
	r	M12	M12	M16
	s	40	19	17
t	dia. 14	dia. 14	dia. 14	
x	15	36	70	
y	75	127	178	
z	63	126	–	

Jaw width	90	125	160
Clamping width S1 in mm	0–126	0–182	(0)17–263
Clamping width S2 in mm	93–217	131–313	189–435
Clamping force increments	11	4	4
Max. clamping force in kN	28	40	60
Weight in kg	16	36	67,2

• Clamping width 0 can be reached using the compensation jaw

## Spindle cross-section



# ALLMATIC NC – MECHANICAL TC VERSION, TYPE 200

## Scope of application:

- Horizontal and vertical installation – suitable for both vertical and horizontal CNC-controlled milling machines
- Lateral installation is also possible

## Product features:

- Extreme accuracy for your machining
- The TC vice is ground and polished on all sides
- Clamping force can be preset in 4 increments. At most, 2 revolutions are required to reach the max. clamping force
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within a tolerance of less than 0.01 mm



End surface with fitting holes for vertical installation

M14 thread for mounting false jaws

Hardened, ground and polished guideway

Robust base made of GGG 60

Clamping force presetting

M8 thread for workpiece stop

### Important:

Information on compatibility with earlier series of NC 200 (prior to 1998) is available online at [www.allmatic.de](http://www.allmatic.de)

Precision aligning slots (longitudinal/transverse) in the bottom surface for optimal alignment on the machine table

Outlet for coolant and chips

Connecting thread for angular drive



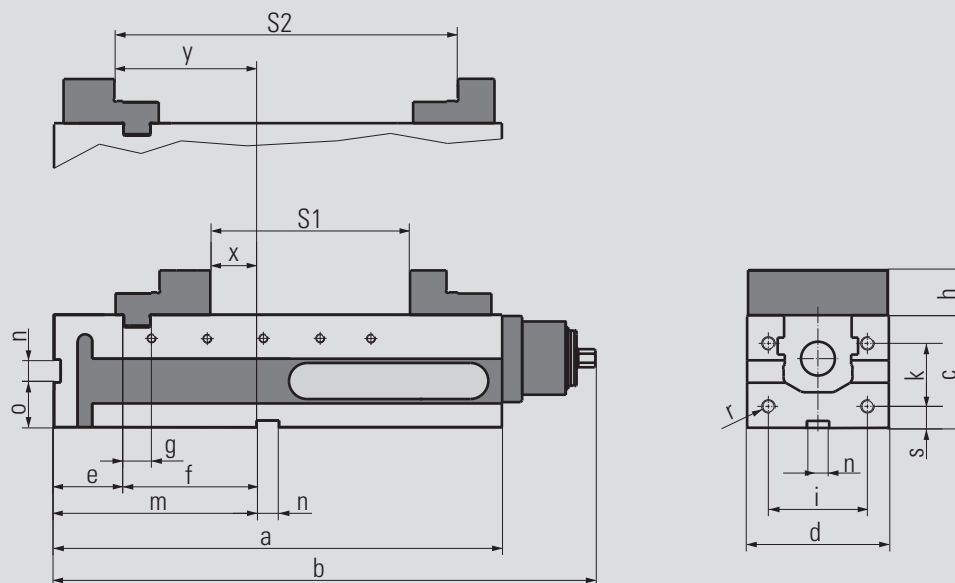
Optional: mounting holes in the bottom surface for zero-point clamping systems are possible

**Order no. jaw width 200: 6921698000155**

## Scope of supply:

- 1 high-pressure vice with step jaws
- 1 hand crank
- 4 side clamps
- 3 socket screw wrenches
- 1 compensation jaw for clamping range from 0 mm

An overview of the clamping jaws and other accessories is given on the following pages.



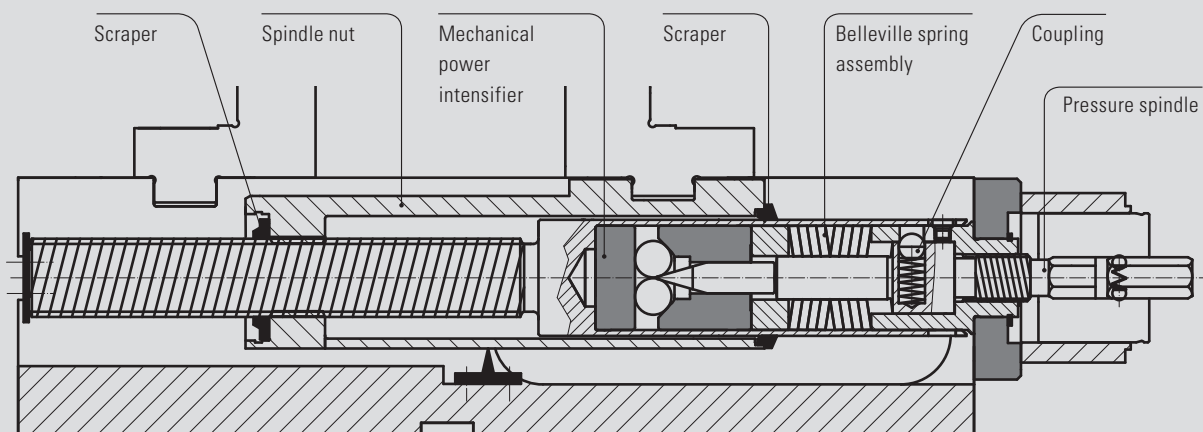
## Technical data

Jaw width		200
Dimensions / tolerances in mm	a	530
	b	620
	c	140
	d	202
	e	70
	f	164
	g	30
	h	60
	i	140
	k	85
	m	234
	n	20
	o	60
	r	M16
s	22	
x	70	
y	178	

Jaw width		200
Clamping range S1 in mm	(0) 15 - 261	
Clamping range S2 in mm	188 - 434	
Clamping force increments	4	
Max. clamping force in kN	80	
Weight in kg	87,4	

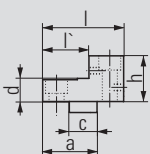
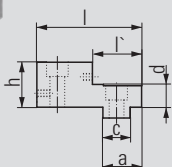
• Clamping width 0 can be reached using the compensation jaw

## Spindle cross-section

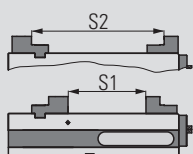


## ALLMATIC NC –mechanical/TC version (accessories)

### Step jaws



- Material: hardened steel
- High and step sides with thread for parallels
- Ground and polished clamping surfaces
- Additional thread on the high side for mounting HD jaws (Types 125 – 200)
- Click system on the high side

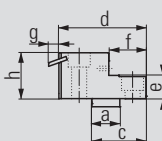
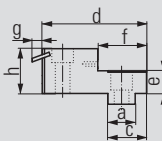
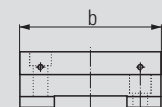


Jaw width	90	125	160	200
Clamping range S1	0 – 126	0 – 182	17 – 263	15 - 261
Clamping range S2	93 – 217	131 – 313	189 – 435	188 - 434

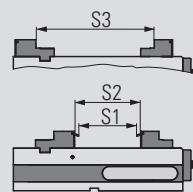
		Jaw width			
fixed		90	125	160	200
Ord. no.:		6921674006731	6921684006731	6921704006731	6921694006031
In mm	a	30	34	40	40
	b	89,5	124,4	160,4	200,4
	c	20	24	30	30
	d	16	20	25	25
	h	34	39,5	49,8	60
	l	68	92	104	104
	l'	32	43	54	54

		Jaw width			
movable		90	125	160	200
Ord. no.:		6921474002731	6921484002731	6921304002731	6921294002231
In mm	a	38	47	63	65
	b	89,5	124,4	160,4	200,4
	c	20	24	30	30
	d	16	20	25	25
	h	34	39,5	49,8	60
	l	56	70	96	100
	l'	31	40	64	65

### Pull-down jaws



- Material: hardened steel
- Pull-down with ground and polished spring leaves for machined and unmachined clamping surfaces
- Ground and polished clamping surfaces
- High clamping accuracy for parallel and accurate angle machining
- Click system on the high side



Jaw width	125
Clamping range S1	0 – 159
Clamping range S2	0 – 176
Clamping range S3	124 – 305

		Jaw width	
fixed		125	
Ord. no.:		6921684106031	
In mm	a	24	
	b	124,4	
	c	34	
	d	92	
	e	20	
	f	43	
	g	8,8	
	h	39,5	

		Jaw width	
movable		125	
Ord. no.:		6921684102031	
In mm	a	24	
	b	124,4	
	c	46,5	
	d	75	
	e	20	
	f	32	
	g	8,8	
	h	39,5	

## ALLMATIC NC – mechanical / TC version (accessories)

### Spring leaves (pair)



Order no. jaw width 90: 6921884103031

- Hardened spring leaves
- Spring leaves (spare) for pull-down jaws Type 90 (see left)

### Spring leaves (pair)



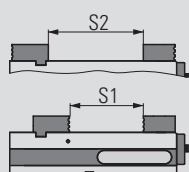
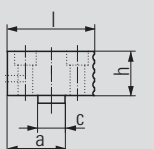
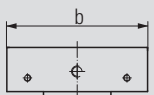
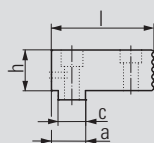
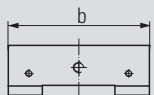
Order no. jaw width 125: 6921684103031  
160: 6921704103031

- Hardened spring leaves
- Spring leaves (spare) for pull-down jaws Type 125 and 160 (see left)

### Hard basic jaws



- Material: hardened steel
- One side smooth, ground and polished; one side serrated
- Additional thread for parallels and for mounting HD jaws on the smooth side
- Mounts for Click system on both sides of the jaw



		Jaw width		
fixed		90	125	160
Ord. no.:		6921674005731	6921684005731	6921704005731
In mm	a	26	30	40
	b	89,5	124,4	160,4
	c	20	24	30
	h	34	39,5	49,8
	l	63	88	104

		Jaw width		
movable		90	125	160
Ord. no.:		6921674004731	6921684004731	6921704004731
In mm	a	40	50	65
	b	89,5	124,4	160,4
	c	20	24	30
	h	34	39,5	49,8
	l	60	76	100

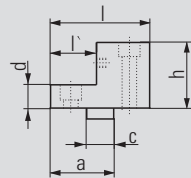
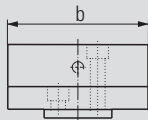
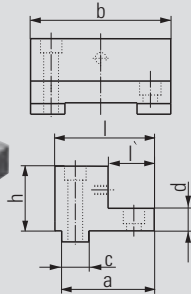
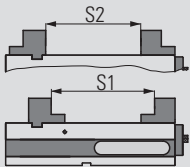
Clamping range S1	0 – 125	0 – 179	15 - 261
Clamping range S2	30 – 156	49 – 231	69 - 315

## ALLMATIC NC – mechanical / TC version (accessories)

### Master jaw adapters



- Material: hardened steel
- High side of jaw hardened
- Ground clamping surfaces
- Additional thread on the step side for mounting HD jaws
- Click system on the high side

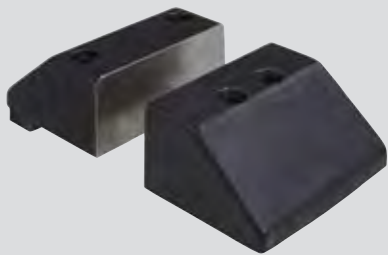


Jaw width	90	125	160	200
Clamping range S1	62 – 186	64 – 246	88 - 334	92 - 338
Clamping range S2	26 – 152	45 – 227	68 - 314	68 - 314

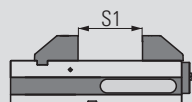
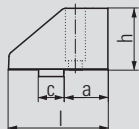
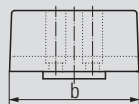
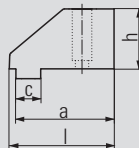
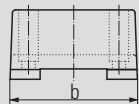
Jaw width					
fixed	90	125	160	200	
Ord. no.:	6921674012231	6921684012231	6921704012231	6921694012231	
In mm	a	56	77	89	89
	b	90	126	164	202
	c	20	24	30	30
	d	16	20	24	24
	h	46	58	73	85
	l	66	85	100	100
	l'	30	32	34	34

Jaw width					
movable	90	125	160	200	
Ord. no.:	6921274011231	6921284011231	6921304011231	6921294011231	
In mm	a	40	52	65	45
	b	90	126	164	202
	c	20	24	30	30
	d	16	20	24	24
	h	46	58	73	85
	l	60	80	100	100
	l'	30	32	34	38

### Soft jaws



- Material: GGG40
- For production of special jaws by the customer
- Chamfer provides very good accessibility to the workpiece



Order no. fixed: 6921684088031

Jaw width	125	
Dimensions in mm	a	95
	b	124
	c	24
	h	58
	l	101.5

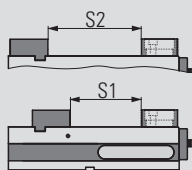
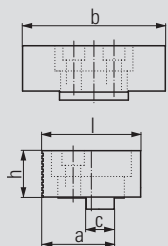
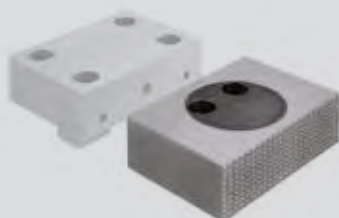
Order no. movable: 6921484087031

Jaw width	125	
Dimensions in mm	a	42
	b	124
	c	24
	h	58
	l	94.5

Clamping range S1	0 – 150
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## ALLMATIC NC – mechanical / TC version (accessories)

### Pivot jaw, movable



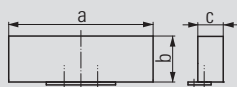
- Material: hardened steel
- With Click-System on both sides
- One side smooth, ground and polished; one side serrated
- Rotatable through 360°
- Picture with hard basic jaw (see page 89)

Order no. jaw width 90: 6921674020142  
 125: 6921684020042  
 160: 6921704020042

Jaw width		90	125	160
Dimensions in mm	a	49.5	62	86
	b	90	124.4	160.4
	c	20	24	30
	h	34	39.5	49.8
	l	68	84	118

Clamping range S1	0 – 115	0 – 167	0 – 240
Clamping range S2	21 – 146	37 – 219	48 – 294

### Soft jaw



- Material: case-hardened steel 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Only for use with jaws with Click system

Order no. 6921684023042

Jaw width		125
Dimensions in mm	a	125
	b	39.8
	c	22

### Jaw with cross grooving



- Material: hardened steel
- Jaws with sharp serrations to increase the specific contact pressure per unit area
- Visible impressions on workpiece
- Only suitable for soft materials
- Only for use with jaws with Click system

Order no. 6921684032040

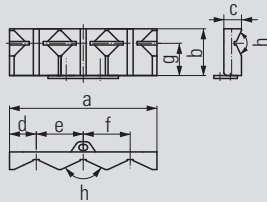
Jaw width		125
Dimensions in mm	a	125.6
	b	40.1
	c	12



**ALLMATIC NC – mechanical /TC version (accessories)**

**Prismatic jaws (pair)**

**Order no. 6921684024042**

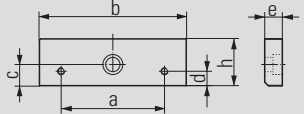


- Material: hardened steel
- Jaws for clamping round parts, vertical dia. 16-74 mm, horizontal dia. 12-40 mm
- Only for use with jaws with Click system

c		125
Dimensions in mm	a	125.6
	b	39.8
	c	15
	d	22.8
	e	40
	f	40
	g	27.5
	h	130°

**Compensation jaw**

**Order no. jaw width 160: 6921704022031**  
**200: 6921694022031**

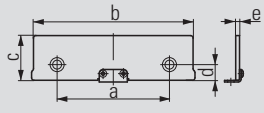


- Material: hardened steel
- Ground and polished clamping surfaces
- For clamping range from 0 mm
- With the LC 160 and 200 vices, this jaw is included

Jaw width	160	200
Dimensions in mm	a	110
	b	200.4
	c	25
	d	18
	e	18
	h	60

**Click parallels (pair)**

**Order no. jaw width 90: 6921175029042**  
**125: 6921185035042**  
**160: 6921205044042**

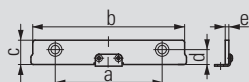


- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels with Click system
- For the high side of the jaws

Jaw width	90	125	160
Dimensions in mm	a	88	88
	b	125	160
	c -0.01	35	44
	d	12.25	12.25
	e	3	3

## ALLMATIC NC – mechanical / TC version (accessories)

### Click parallels (pair)

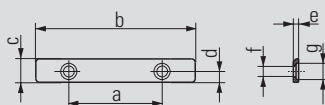


Order no. jaw width 90: 6921175016042  
 125: 6921185020042  
 160: 6921205025042

Jaw width	90	125	160
Dimensions in mm			
a	48	88	88
b	90	125	160
c-0.01	16	20	25
d	8.75	12.25	12.25
e	3	3	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels with Click system
- For the high side of the jaws

### Parallels (pair)



Order no. jaw width 90: 6921475013031  
 125: 6921485015031  
 160: 6921305019031

Jaw width	90	125	160
Dimensions in mm			
a	52	88	88
b	89	124	160
c	13	15	19
d	6	6	6
e	3	3	3
f	Ø 6	Ø 6	Ø 6
g	Ø 9	Ø 9	Ø 9

- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels
- For the step side of the jaws

### Smooth jaws (pair)



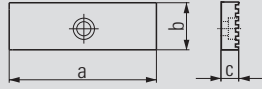
Order no. jaw width 125: 6921024022031  
 160: 6921034022031

Jaw width	125	160
Dimensions in mm		
a	125	160
b	40	50
c	15	20

- Material: hardened steel
- For parts with delicate clamping surfaces
- Please order fastening bolts separately (order no. 6921011023000)

## ALLMATIC NC – mechanical / TC version (accessories)

### Serrated jaws (pair)

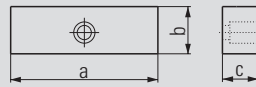


Order no. jaw width 125: 6921021005031  
160: 6921031005031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

- Material: hardened steel
- Standard jaws with serration
- To increase the specific contact pressure per unit area
- Please order fastening bolts separately (order no. 6921011023000)

### Soft jaws (pair)

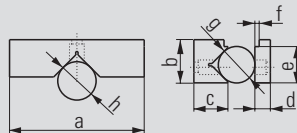
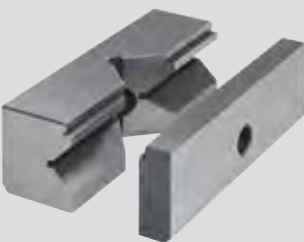


Order no. jaw width 125: 6921024023031  
160: 6921034023031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	25	30

- Material: 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Please order fastening bolts separately (order no. 6921011023000)

### Prismatic jaws (set)



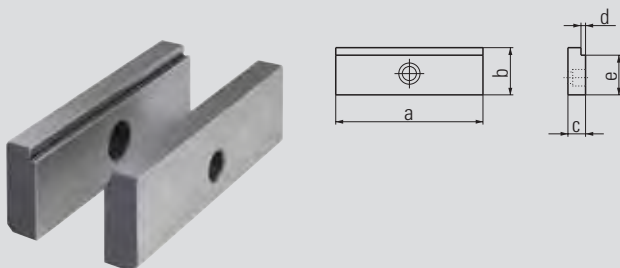
Order no. jaw width 125: 6921024024031  
160: 6921034024031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	35	45
	d	15	20
	e	35	45
	f	3	3
	g	∅ 12 – 28	∅ 15 – 40
	h	∅ 18 – 55	∅ 22 – 65

- Material: hardened steel
- For horizontal and vertical clamping of round and flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

## ALLMATIC NC – mechanical / TC version (accessories)

### Step jaws (pair)

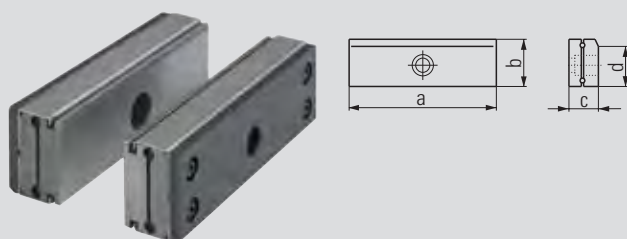


Order no. jaw width 125: 6921024025031  
160: 6921034025031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20
	d	3	3
	e	35	45

- Material: hardened steel
- For horizontal clamping of flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

### Roller pull-down jaws (pair)

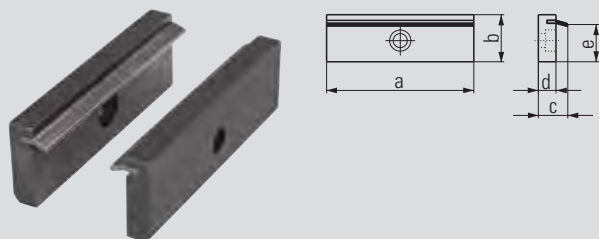


Order no. jaw width 125: 6921024005131  
160: 6921034005131

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	26	35.5
	d	35	45

- Material: hardened steel
- For parts with delicate clamping surfaces
- Jaw parts in contact with the workpiece press the workpiece onto the support surface
- Please order fastening bolts separately (order no. 6921011023000)

### Spring leaf pull-down jaws (pair)




Order no. jaw width 125: 6921024001042  
160: 6921034001042

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	20	23
	d	12	15
	e	33	43

- Material: hardened steel
- For parts with unmachined clamping surfaces
- Spring leaves press the workpiece onto the support surface
- Spring leaves are interchangeable, (see the next page)
- Please order fastening bolts separately (order no. 6921011023000)

**ALLMATIC NC – mechanical / TC version (accessories)**

### Spring leaves (pair)



Order no. jaw width  
 125: 6921024002131  
 160: 6921034002131

- Spring leaves (spare) for spring leaf pull-down jaws (see previous page)

### Jaw fixing bolt



Order no. 6921011023000

Bolt with shoulder – M10 x 23

- Suitable for all jaws, jaw width 090 mm to 160 mm

### Workpiece stop


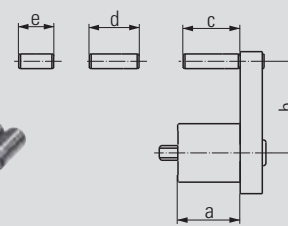



Order no. 6921285650144

Dimensions in mm		
a	67	
b	15	
c	33 – 92	
d	12 – 63.5	
e	53.5 – 113.5	

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Position of the third workpiece axis can be preset and clamped
- Workpiece stop can be swivelled away once the workpiece has been clamped
- This allows the stop side of the workpiece to also be machined (repeating accuracy: ± 0.01)

### Workpiece stop

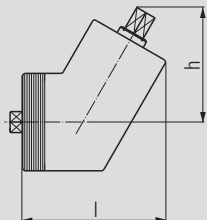
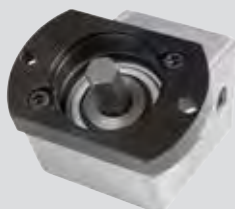
Order no. 6921685670042

Dimensions in mm		
a	34	
b	27 – 59	
c	31	
d	27	
e	19	

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Can be pre-mounted with various fixed dimensions
- Position of the third workpiece axis can be preset

## ALLMATIC NC – mechanical / TC version (accessories)

### Angular drive

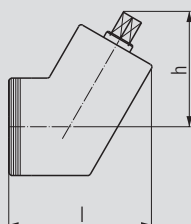


- For jaw width 125 – 200
- Wrench size 14
- Can be bolted to the end of the spindle if access is difficult
- Step-down ratio 2 : 1

Order no. jaw width 125 to 200: 6921285700143

Jaw width		125	160	200
Dimensions in mm	l	97	97	97
	h	75	75	75

### Angular drive

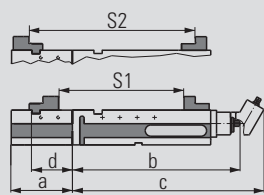


- For type 90
- Wrench size 12
- Can be bolted to the end of the spindle if access is difficult
- Step-down ratio 2 : 1

Order no. 6921675700043

Jaw width		90
Dimensions in mm	l	87
	h	75

### Clamping range enlargement



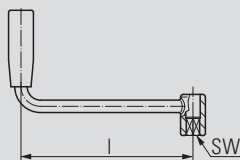
- For increasing the clamping range of the NC vice TC version
- Is attached to the end of the TC vice
- No transmission of clamping forces to the machine table
- Scope of supply: 1 pair side clamps

Order no. jaw width 125: 6921685008055  
160: 6921705008055

Jaw width		125	160
Dimensions in mm	a	176	237
	b	483	620
	c	552	683
	d	117	172

Clamping range S1	179 – 361	259 – 505
Clamping range S2	310 – 492	431 – 677

### Hand crank



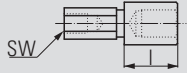
Order no. jaw width 90: 6921675508031  
125 - 200: 6921685508031

Jaw width		90	125
Dimensions in mm	l	150	180
	SW	12	14

- Suitable for jaw width 125 – 200 mm

## ALLMATIC NC – mechanical / TC version (accessories)

### Hexagonal extension



- Improves access for the hand crank
- Is secured to the hand crank with a bolt

Order no. 6921685512040

Jaw width	125	
Dimensions in mm	l	30
	SW	14

- Suitable for jaw width 125 – 200 mm

### Hexagonal extension



- Improves access for the hand crank
- Is secured to the hand crank with a bolt

Order no. 6921685512140

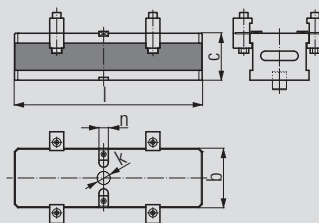
Jaw width	125	
Dimensions in mm	l	60
	SW	14

- Suitable for jaw width 125 – 200 mm

### XL console



Order no. 6921885010042



- Material: GG30
- For raising the vice
- Improvement of access for 5-sided machining
- Optional preparation for zero-point clamping systems
- Scope of supply: console incl. fixing bolt for positioning the vice, 4 pairs of Duo side clamps, 2 socket screw wrenches

Jaw width	125	
Dimensions in mm	b	126
	c	100
	k	Ø 30
	l	400
	n	20

### Side clamps (pair)



Order no. jaw width 90: 6921015000231  
125 - 200: 6921025000031

- For securing the vice on the machine table
- Supplied as a set of 2

## ALLMATIC NC – mechanical / TC version (accessories)

### DUO side clamps



**Order no. jaw width 90:** 6921675000031  
**125 - 200:** 6921285000031

- For securing the vice on a console or machine table
- 1 set consists of 2 pairs of side clamps incl. screw connections

### Aligning and fixing set



- For aligning (positioning) and fastening the vice on pallet and machine table
- Size according to T-slot or thread in the machine table

**Order no. – see table**

T-slot/ thread	Order no.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031



# ALLMATIC NC – MECHANICAL NC 70 VERSION

## Scope of application:

- Horizontal installation – suitable for vertical CNC-controlled milling machines
- Lateral installation is also possible

## Product features:

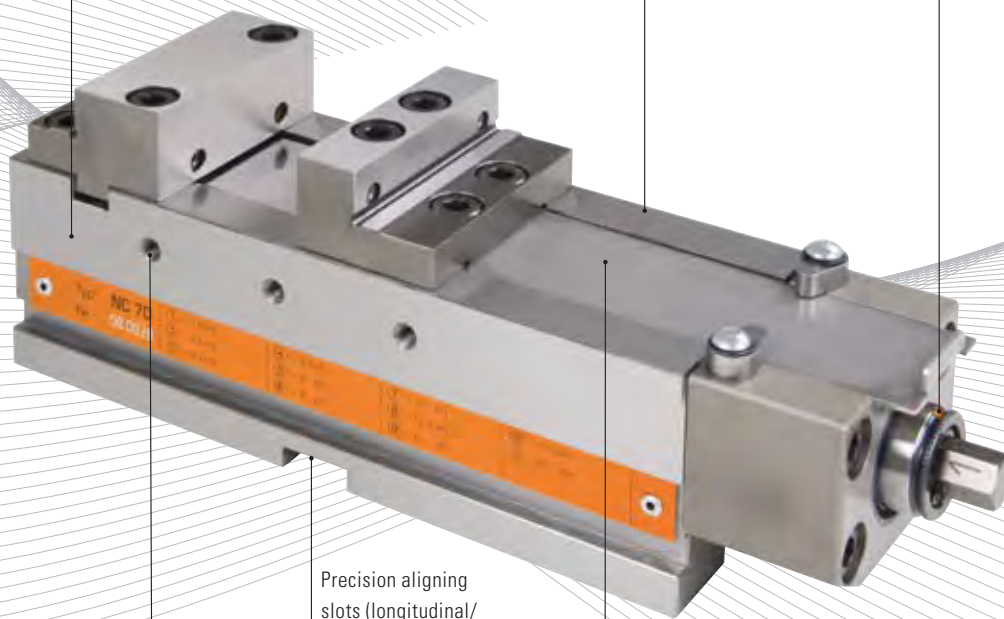
- Extreme accuracy for your machining
- Clamping force can be preset in 11 increments; fine gradations for delicate workpieces. At most, 1 revolution is required max. to reach the max. clamping force
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within a tolerance of less than 0.01 mm



Robust base  
made of GGG 60

Hardened, ground and  
polished guideway

Clamping force  
presetting



M6 thread

Precision aligning  
slots (longitudinal/  
transverse) in the  
bottom surface for  
optimal alignment on  
the machine table

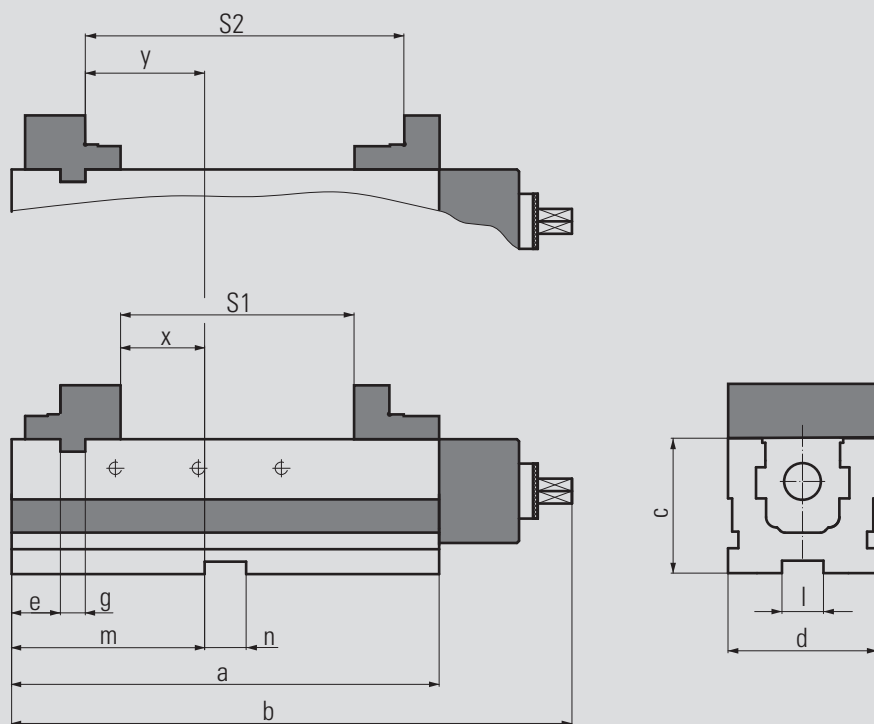
Spindle chamber cover

**Order no. jaw width 70: 6921268000055**

## Scope of supply:

- 1 high-pressure vice with step jaws
- 1 hand crank
- 4 side clamps
- 1 socket screw wrench

An overview of the clamping jaws and other accessories is given on the following pages.

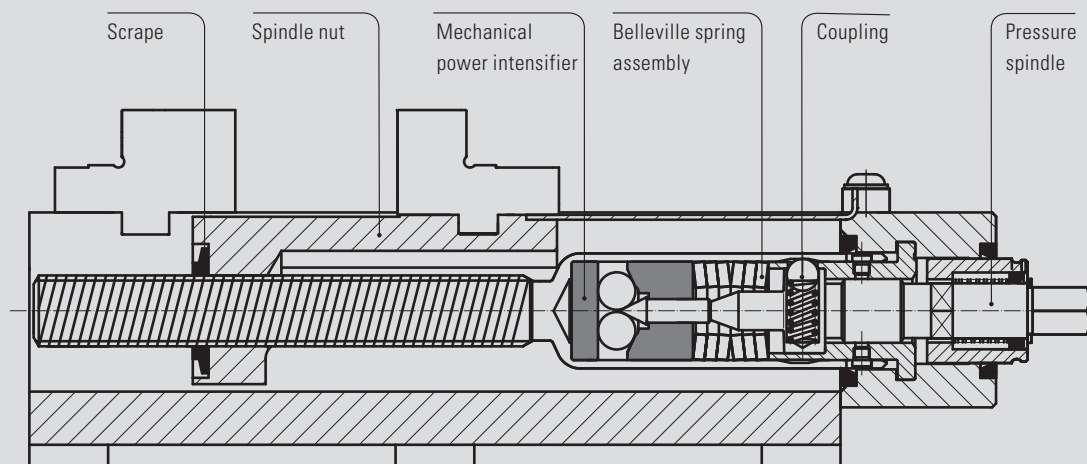


## Technical data

Jaw width	70	
Dimensions / tolerances in mm	a	206
	b	270
	c	65
	d	72
	e	23.5
	g	12
	l	20
	m	93
	n	20
	x	40.5
y	57.5	

Jaw width	70
Clamping range S1 in mm	0 – 112
Clamping range S2 in mm	41 – 152
Clamping force increments	11
Max. clamping force in kN	20
Weight in kg	10

## Spindle cross-section

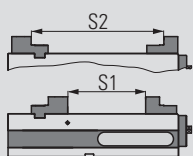


## ALLMATIC NC – mechanical / NC 70 version (accessories)

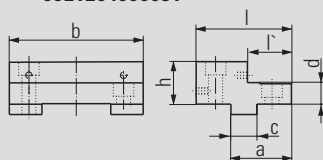
### Step jaws



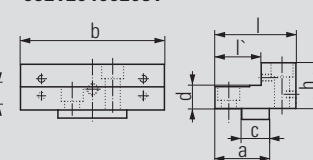
- Material: hardened steel
- Ground and polished clamping surfaces
- High and step sides with M5 thread for parallels



Order no. fixed:  
6921264006031



Order no. movable:  
6921264002031

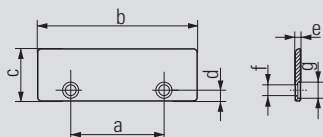


Jaw width		70
Dimensions in mm	a	29
	b	69.4
	c	12
	d	12
	h	26
	l	46
	l'	17

Jaw width		70
Dimensions in mm	a	25.5
	b	69.4
	c	10
	d	12
	h	26
	l	41
	l'	23.5

Clamping range S1	0 – 112
Clamping range S2	41 – 152

### Parallels (pair)

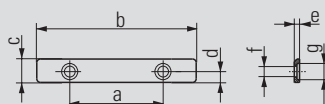


- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels
- For the high side of the jaws

Order no. 6921265022031

Jaw width		70
Dimensions in mm	a	37
	b	69.6
	c	22
	d	6
	e	2.5
	f	Ø 6
	g	Ø 9

### Parallels (pair)



- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels
- For the step side of the jaws

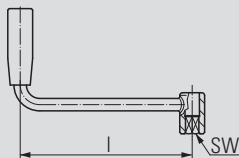
Order no. 6921265010031

Jaw width		70
Dimensions in mm	a	52
	b	69.6
	c	10
	d	4.5
	e	2.5
	f	Ø 6
	g	Ø 9

## ALLMATIC NC – mechanical / NC 70 version (accessories)

### Hand crank

Order no. 6921675508031



Jaw width	70	
Dimensions in mm	l	150
	SW	12

### Aligning and fixing set

Order no. – see table



T-slot/ thread	Order no.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

- For aligning (positioning) and securing the vice on pallet and machine table
- Size according to T-slot or thread in the machine table

# ALLMATIC NC – MECHANICAL DUO 90 VERSION

## Scope of application:

- Horizontal installation – suitable for vertical CNC-controlled milling machines
- Lateral installation is also possible



## Product features:

- Extreme accuracy for your machining
- Clamping force can be preset in four to six increments. At most, one revolutions are required to reach the max. clamping force
- For clamping two identical parts (dimensional differences of up to  $\pm 3$  mm are compensated for)
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within a tolerance of less than 0.01 mm

Robust base  
made of GGG 60

Hardened, ground and  
polished guideway

Clamping force  
presetting

M8 thread for  
workpiece stop

Precision aligning slots  
(longitudinal/trans-  
verse) in the bottom  
surface for optimal  
alignment on the  
machine table

Outlet for  
coolant and chips

Connecting thread  
for angular drive

Optional:  
mounting  
holes in  
the bottom  
surface for zero-point  
clamping system are  
possible

## Important:

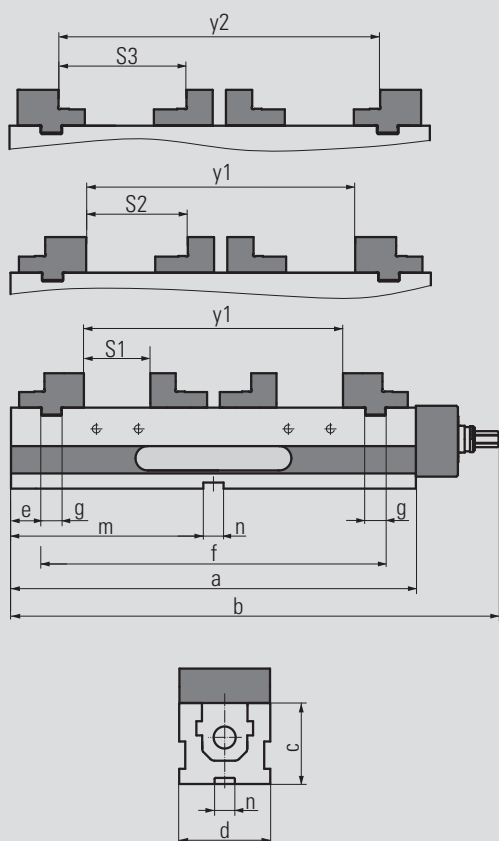
- Workpieces must be placed in both stations before clamping begins.
- Type 90: drive head with finer clamping force presetting for delicate workpieces (6 increments)

**Order no. jaw width 90: 6921478000955**

## Scope of supply:

- 1 high-pressure vice with step jaws
- 1 hand crank
- 4 side clamps
- 2 socket screw wrenches

An overview of the clamping jaws and other accessories is given on the following pages.



## Technical data

Jaw width		90
Dimensions / tolerances in mm	a	400
	b	482
	c	80
	d	90
	e	30
	f	340
	g	20
	m	190
	n	20
	y1	256
y2	306	

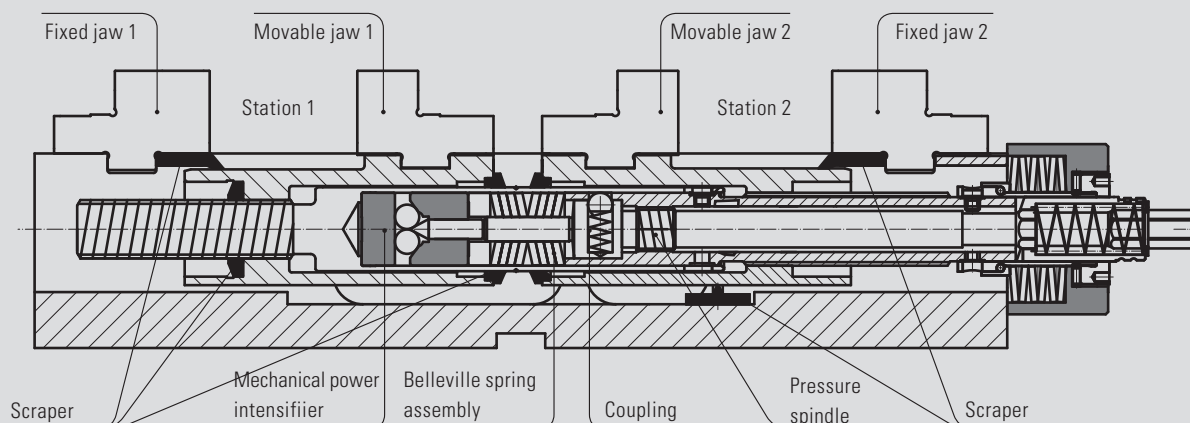
Jaw width		90
Clamping range S1 in mm		0 – 64
Clamping range S2 in mm		31 – 95
Clamping range S3 in mm		56 – 120
Clamping force increments		6
Max. clamping force in kN		28
Weight in kg		24

Turn the hand crank clockwise to bring movable jaw one up against the workpiece in station one. The workpiece is fixed with a force of approx. 1000 N. Turn the hand crank further to bring movable jaw two up against the workpiece in station two and fix it there. If you continue turning beyond the "locking point", the coupling will disengage. The pressure spindle activates the mechanical power intensifier. Turning as far as the limit stop produces a controlled clamping force build-up.

Workpieces must be placed in both stations before clamping begins. Dimensional differences between workpiece one and workpiece two are compensated for:

*NC DUO 90 ± 3 mm*

## Spindle cross-section

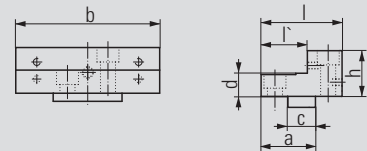
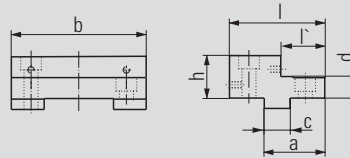


## ALLMATIC NC – mechanical / DUO 90 version (accessories)

### Step jaws

Order no. fixed:  
6921474006731

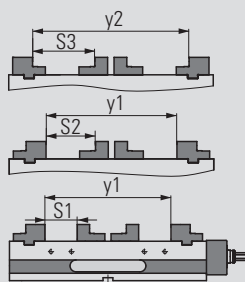
Order no. movable:  
6921474002731



- Material: hardened steel
- Ground and polished clamping surfaces
- High and step sides with thread for parallels

Jaw width		90
Dimensions in mm	a	42
	b	89.5
	c	20
	d	16
	h	34
	l	64
	l'	25

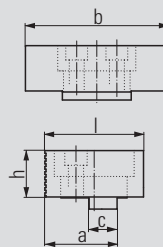
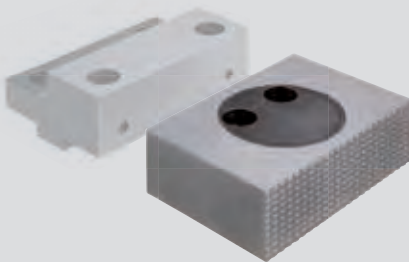
Jaw width		90
Dimensions in mm	a	38
	b	89.5
	c	20
	d	16
	h	34
	l	56
	l'	31



y1	256
y2	306
Clamping range S1	0 – 64
Clamping range S2	31 – 95
Clamping range S3	56 – 120

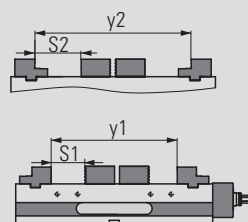
### Pivot jaw, movable

Order no. movable: 6921674020142



Jaw width		90
Dimensions in mm	a	49.5
	b	90
	c	20
	h	34
	l	68

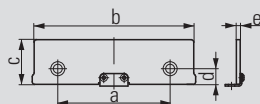
- Material: hardened steel
- With Click-System
- One side smooth, ground and polished; one side serrated
- Rotatable through 360°
- Picture with step jaw (see above)



y1	256
y2	306
Clamping range S1	0 – 52
Clamping range S2	34 – 77

## ALLMATIC NC – mechanical / DUO 90 version (accessories)

### Click parallels (pair)



Order no. 6921175029042

Jaw width	90	
Dimensions in mm	a	48
	b	90
	c -0.01	29
	d	8.75
	e	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels with Click system
- For the high side of the jaws

### Click parallels (pair)

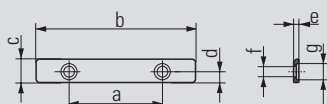


Order no. 6921175016042

Jaw width	90	
Dimensions in mm	a	48
	b	90
	c -0.01	16
	d	8.75
	e	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels with Click system
- For the high side of the jaws

### Parallels (pair)



Order no. 6921475013031

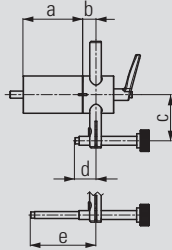
Jaw width	90	
Dimensions in mm	a	52
	b	89
	c	13
	d	6
	e	3
	f	Ø6
	g	Ø9

- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels
- For the step side of the jaws



## ALLMATIC NC – mechanical / DUO 90 version (accessories)

### Workpiece stop

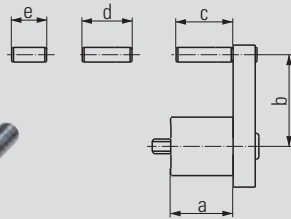
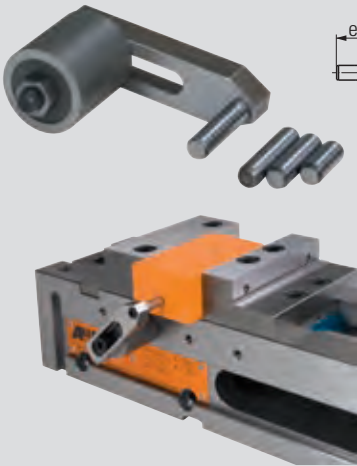


Order no. 6921285650144

Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Position of the third workpiece axis can be preset and clamped
- Workpiece stop can be swivelled away once the workpiece has been clamped
- This allows the stop side of the workpiece to also be machined (repeating accuracy:  $\pm 0.01$ )

### Workpiece stop

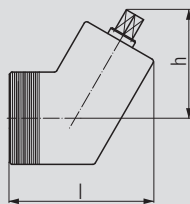
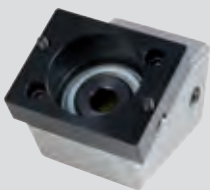


Order no. 6921685670042

Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Can be pre-mounted with various fixed dimensions
- Position of the third workpiece axis can be preset

### Angular drive



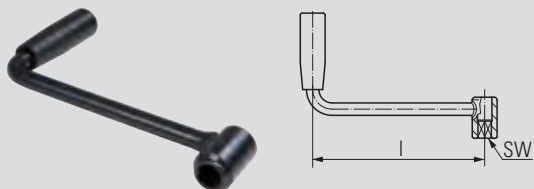
Order no. 6921485700043

Jaw width	90	
Dimensions in mm	h	75
	l	102

- Wrench size 14
- Can be bolted to the end of the spindle if access is difficult
- Step-down ratio 2 : 1

## ALLMATIC NC – mechanical / DUO 90 version (accessories)

### Hand crank



Order no. 6921685508031

Jaw width	90	
Dimensions in mm	l	180
	SW	14

### Hexagonal extension



Order no. 6921685512040

Jaw width	90	
Dimensions in mm	l	30
	SW	14

- Improves access for the hand crank
- Is secured to the hand crank with a bolt

### Hexagonal extension



Order no. 6921685512140

Jaw width	90	
Dimensions in mm	l	60
	SW	14

- Improves access for the hand crank
- Is secured to the hand crank with a bolt

### Side clamps (pair)



Order no. 6921015000231

- For securing the vice on the machine table
- Supplied as a set of 2

### DUO side clamps



Order no. 6921675000031

- For securing the vice on the machine table
- 1 set consists of 2 pairs of side clamps incl. screw connections

### Aligning and fixing set



Order no. – see table

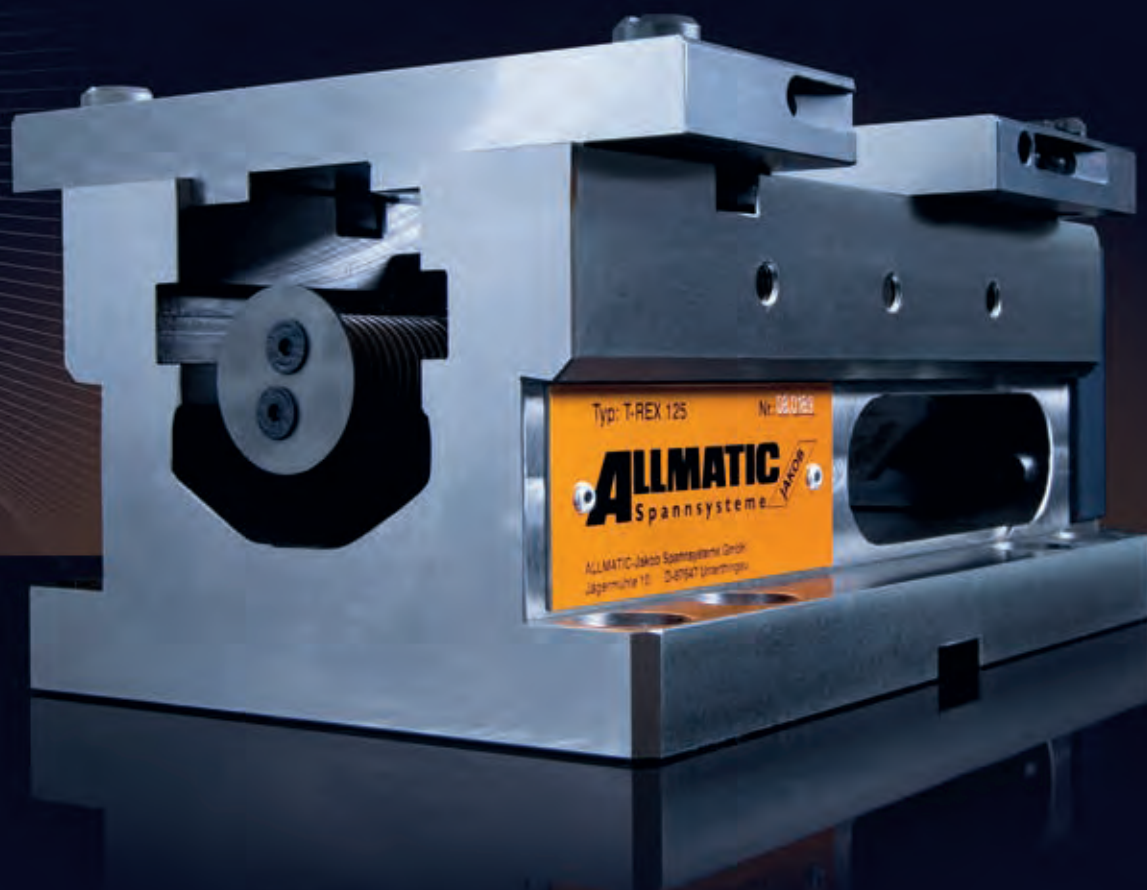
T-slot/ thread	Order no.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

- For aligning (positioning) and fastening the vice on pallet and machine table
- Size according to T-slot or thread in the machine table



# ALLMATIC T-REX – MIND THE JAWS!

This compact vice sinks the sharp “teeth” of its gripper into your workpiece. The ALLMATIC T-REX is indispensable for clamping unmachined parts for 5-sided machining.



# ALLMATIC GRIPP – MECHANICAL T-REX VERSION

## Scope of application:

- Horizontal installation – suitable for vertical CNC-controlled milling machines
- Ideal for use on 5-axis machining centres
- Reliable and fast clamping of unmachined parts, flame-cut and sawn materials with gripper jaws
- Clamping of parallel pre-machined workpieces with optional step jaws
- Gripper studs suitable for materials with a strength of up to approx. 1000N/mm<sup>2</sup>



## Product features:

- Optimum accessibility for 5-sided machining thanks to the combination of compact base and large clamping width
- Stamping and clamping in a single process, in the working area itself, without any additional accessories
- The movable/pivot support jaw allows different workpiece contours to be clamped
- Gripper studs can be changed without tools and are easy to adjust by hand
- Operation with a torque wrench – max. 30 Nm
- High-pressure spindle with power intensification

Robust and compact base made of GGG 60

M8 thread for workpiece stop

Hardened, ground and polished guideway



Holes in the clamping shoulder for fastening to the machine table itself

Precision aligning slots (longitudinal/transverse) and a positioning hole in the bottom surface for optimal alignment on the machine table

Outlet for coolant and chips



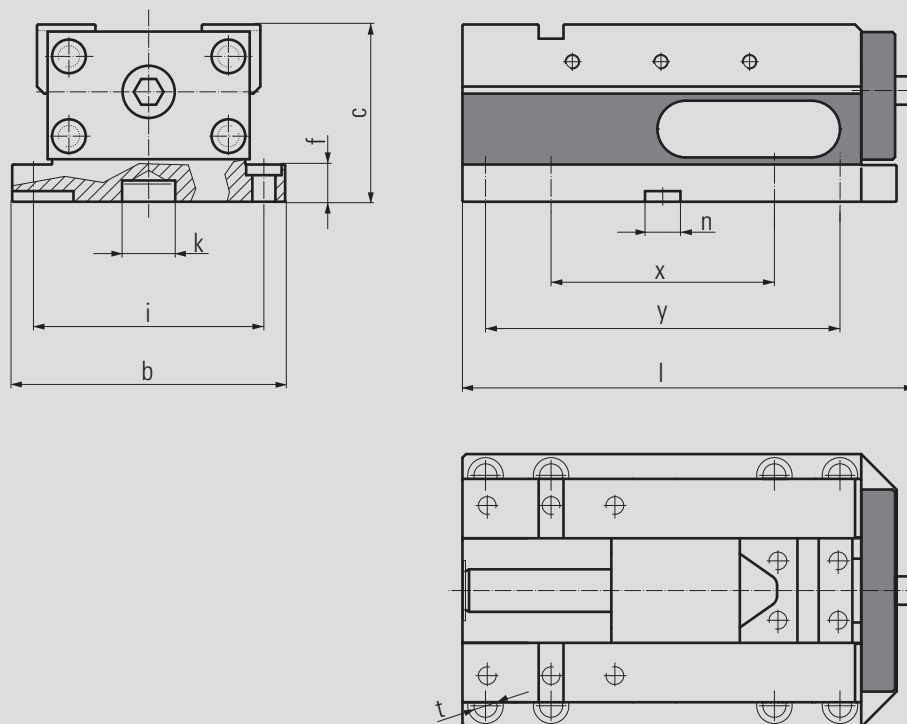
Optional: mounting holes in the bottom surface for zero-point clamping systems are possible

**Order no. jaw width 125: 6921888000155**

## Scope of supply:

- 1 high-pressure vice without jaws
- 4 fastening bolts M12 x 35 mm
- 3 socket screw wrenches  
(Please order clamping jaws separately)

An overview of the clamping jaws and other accessories is given on the following pages.

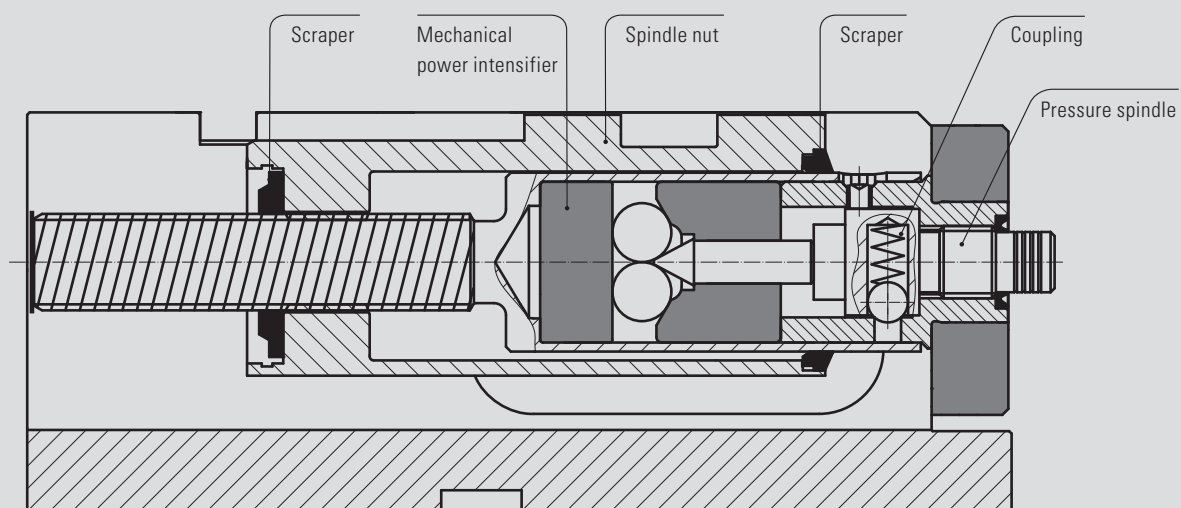


## Technical data

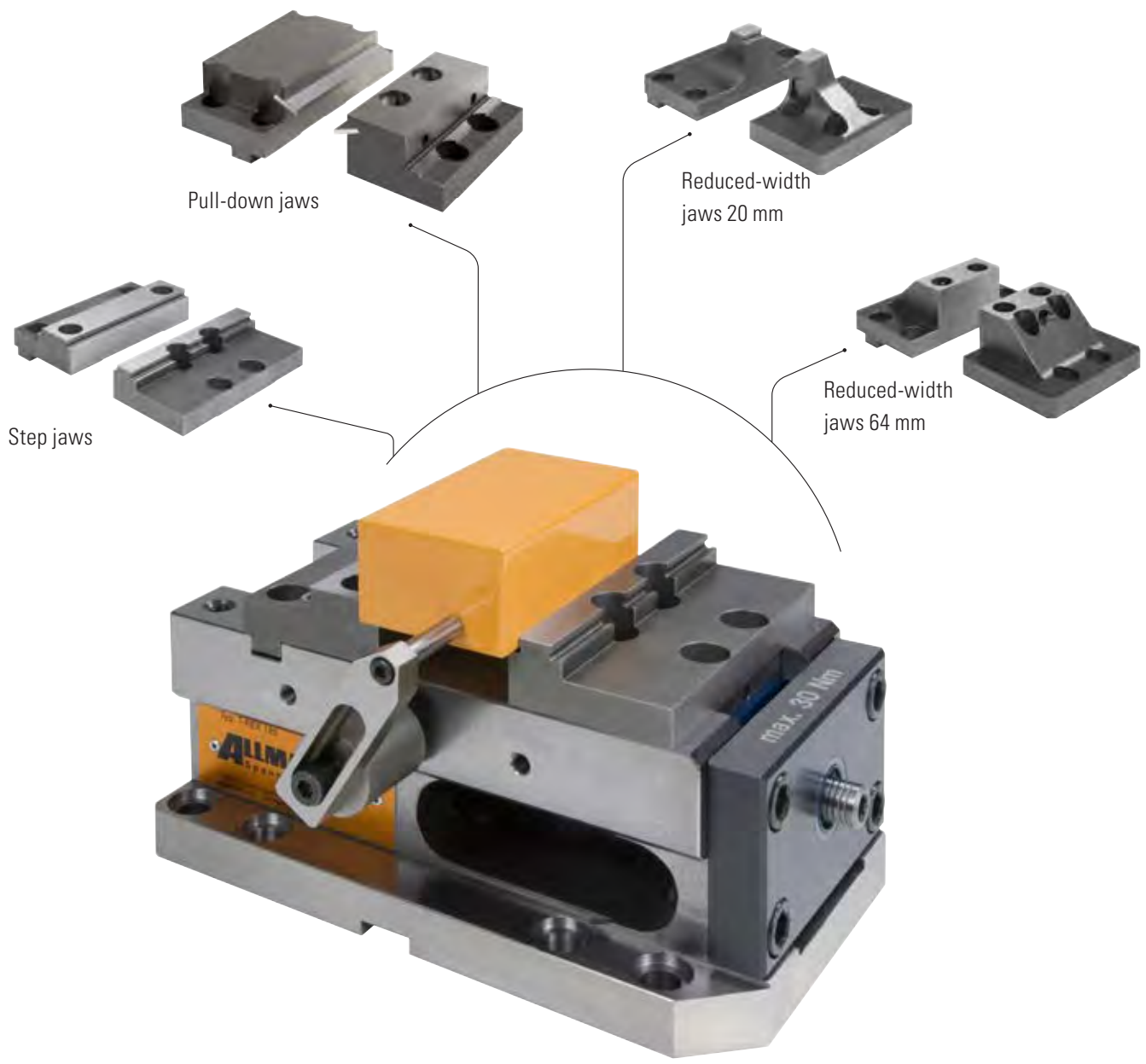
Jaw width		125
Dimensions / tolerances in mm	b	154
	c	100
	f	21
	i	130
	k	∅ 30 H8
	l	256
	n	20 H7
	t	∅ 13
	x	127
y	200	

Jaw width		125
Max. torque in Nm		30
Max. clamping force in kN		40
Weight in kg		18

## Spindle cross-section



# ALLMATIC GRIPP – MECHANICAL/T-REX



### For conventional clamping of workpieces

On the following pages you will find a wide range of jaws suitable for clamping pre-machined workpieces.



### For clamping complex unmachined parts

Varying types of unmachined parts can be clamped quickly and securely using the support jaws and the reduced-width jaws. Jaws for gripper clamping can be found on the following pages.

### Gripper clamping:

- Support jaws are used to mount different gripper studs (threaded gripper studs or universal gripper set)
- Gripper studs can be screwed onto grid plates in variable positions to securely clamp a wide variety of workpiece geometries
- Additional pivot function of the movable clamping jaw compensates for non-parallel clamping surfaces and is necessary for clamping uneven workpieces



# CLAMPING RANGES – T-REX

## Support jaws with gripper studs

You can find the clamping ranges of the other T-REX jaws for conventional clamping on the following pages of accessories



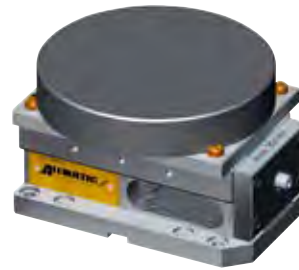
min. clamping range	26 mm
min. clamping width	73 mm



max. clamping range	185 mm
max. clamping width	at least 150 mm or larger



min. clamping range	Ø 80 mm
---------------------	---------



max. clamping range	Ø 190 mm
---------------------	----------

## Support jaws with universal gripper set



min. clamping range	0 mm
min. clamping width	88 mm



max. clamping range	152 mm
max. clamping width	at least 165 mm or larger



min. clamping range	Ø 100 mm
---------------------	----------



max. clamping range	Ø 160 mm
---------------------	----------

# APPLICATION EXAMPLES – T-REX



## Application examples

1. The T-REX support jaws and the universal gripper set permit clamping and machining of very complex unmachined parts.
2. The T-REX vice with console and support jaws for gripper studs permits extremely adaptable clamping possibilities.
3. Perfect clamping solutions for use in mould making.
4. The T-REX vice guarantees secure clamping in difficult situations and for horizontal machining.
5. Efficient clamping of unmachined parts with the T-REX vice on horizontal machining centres opens up new possibilities.
6. Fully integrated into the machines working area, the T-REX is an absolutely reliable clamping device for unmachined and pre-machined workpieces.

## ALLMATIC GRIPP –mechanical / T-REX version (accessories)

### Support jaws for gripper studs



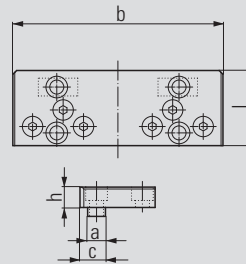
- Material: hardened steel
- For mounting various studs (pointed/smooth)
- Front surface can be used as clamping surface (hardened, ground and polished)

**Pivot jaw:**

- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- Studs (pointed/smooth) **not** included

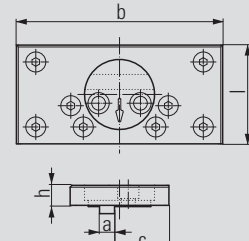
Dimensions of the individual items of the gripper set can be found at [www.allmatic.de](http://www.allmatic.de)

Order no. fixed:  
6921884005042



Jaw width	125
Dimensions in mm	
a	14
b	165
c	20
h	16
l	59

Order no. movable, pivot:  
6921884072042



Jaw width	125
Dimensions in mm	
a	12
b	165
c	43.5
h	16
l	79



Please order gripper studs separately.

### Support jaws for universal gripper set



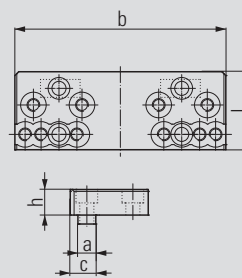
- Material: hardened steel
- For mounting various studs (pointed/smooth)
- Front surface can be used as clamping surface (hardened, ground and polished)

**Pivot jaw:**

- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- Gripper set **not** included

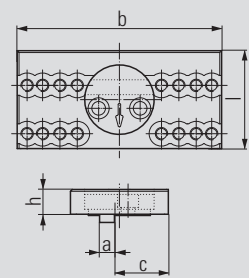
Dimensions of the individual items of the gripper set can be found at [www.allmatic.de](http://www.allmatic.de)

Order no. fixed:  
6921884005242



Jaw width	125
Dimensions in mm	
a	14
b	165
c	20
h	20
l	61

Order no. movable, pivot:  
6921884072242



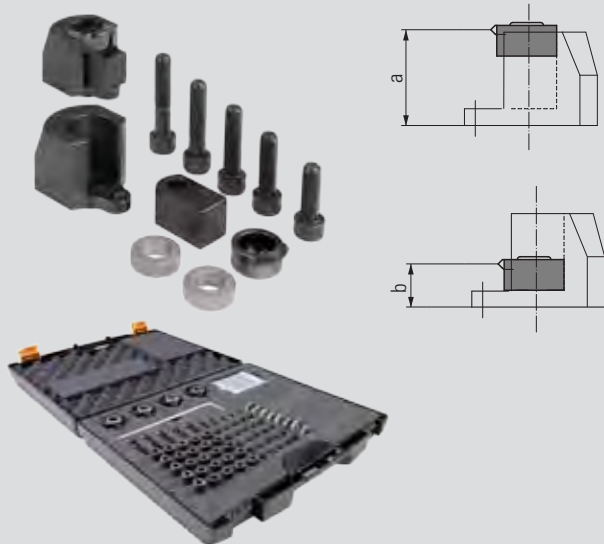
Jaw width	125
Dimensions in mm	
a	12
b	165
c	35.5
h	20
l	79



Please order universal gripper set separately.

## ALLMATIC GRIPP – mechanical / T-REX version (accessories)

### Universal gripper set



Order no. 6921884027031

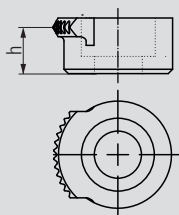
Jaw width	125	
Dimensions in mm	a	40
	b	18

- For clamping complex unmachined parts
- The individual elements of the universal gripper set can be reworked in order to vary both gripper height and support height of the workpiece

Comprising:

- 4 x gripper studs 6921884026000
- 4 x gripper stud mounts 6921884072000
- 4 x supports 6921884028000
- 8 x shims
- Support bolts
- M10 fastening bolts in various lengths
- M6 threaded pins in various lengths
- Socket screw wrench
- Storage case

### Gripper stud

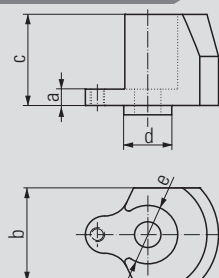


Order no. 6921884026000

Dimensions in mm	h	11
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- Gripper stud for universal gripper set

### Gripper stud mount

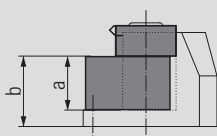
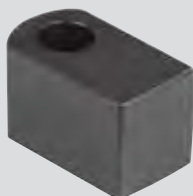


Order no. 6921884072000

Dimensions in mm	a	7
	b	40
	c	39
	d	Ø 20
	e	Ø 25

- Mount for gripper stud 2306/001

### Support



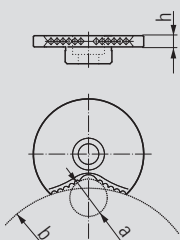
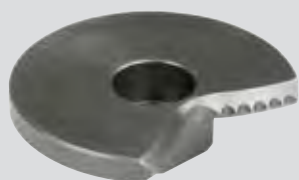
Order no. 6921884028000

Dimensions in mm	a	22
	b	29

- Support for universal gripper set

## ALLMATIC GRIPP – mechanical / T-REX version (accessories)

### Prismatic gripper

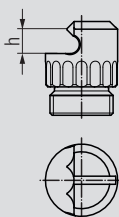


Order no. 6921884029031

Dimensions in mm		
a	Ø 20	
b	Ø 120	
h	6	

- Replaces gripper stud 2306/001 in the universal gripper set
- Special shape distributes the applied clamping force – particularly advantageous for clamping workpieces for which fits have to be made

### Gripper stud, pointed

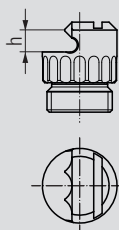


Order no. 6921884036000

Dimensions in mm		
h	5.5	

- For clamping unmachined parts
- Minimum clamping edge loss
- Gripping height: adjustable from 4.5 to 6.0 mm

### Gripper stud, low-level

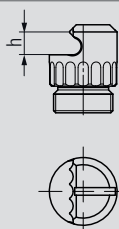


Order no. 6921884036100

Dimensions in mm		
h	5	

- For clamping unmachined parts
- Minimum clamping edge loss
- Gripping height: adjustable from 3.0 to 4.5 mm

### Gripper stud, four-point

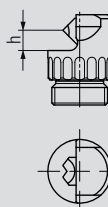


Order no. 6921884036500

Dimensions in mm		
h	5,4	

- For clamping unmachined parts
- For soft materials like aluminum
- Minimum clamping edge loss
- Clamping height: adjustable from 4.5 mm to 6.0 mm

### Gripper stud, carbide coated



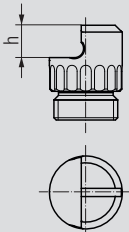
Order no. 6921884036841

Dimensions in mm		
h	5,1	

- For clamping unmachined parts
- For high quality coated materials and flame cuts
- Minimum clamping edge loss
- Clamping height: adjustable from 4.2 mm to 5.7 mm

## ALLMATIC GRIPP – mechanical / T-REX version (accessories)

### Clamping insert, smooth

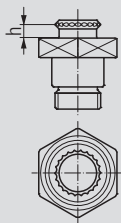


Order no. 6921884037000

Dimensions in mm	h	7
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- With carbide coating for clamping pre-machined or hardened workpieces

### Gripper stud, round



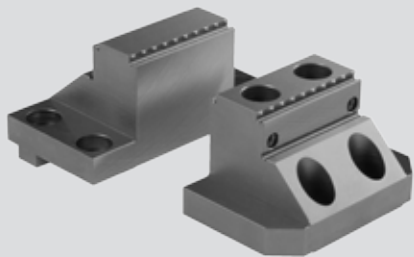
Order no. 6921884038000

Dimensions in mm	h	4
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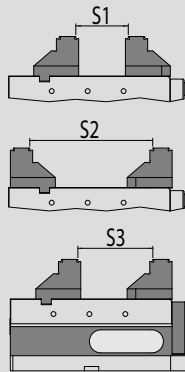
- For clamping unmachined parts
- For through-drilling close to the edge
- Offers 6 mm space below workpiece

## ALLMATIC GRIPP – mechanical / T-REX version (accessories)

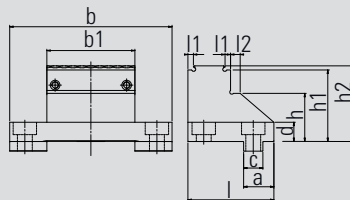
### Jaw 64 mm, with integrated gripper row



- For rectangular workpieces (sawn material)  $\leq 0.5$  mm
- Rigid design to prevent vibrations when parts are clamped upright
- Additional clamping surfaces, ground on both sides
- For five-sided machining, ensuring best possible accessibility to the workpiece
- Positive locking through penetration of the centres into the material
- Minimal lost clamping margin of approx. 3 mm.
- Suitable for material strength of up to 1000 N/mm<sup>2</sup>

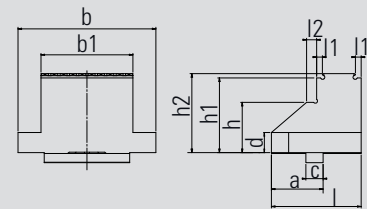


Order no. fixed:  
6921884034031



Jaw width	125	
Dimensions in mm	a	22
	b	118
	b1	64
	c	14
	d	14
	h	35
	h1	52
	h2	55
	l	62,5
	l1	4
l2	7	

Order no. movable:  
6921534036031



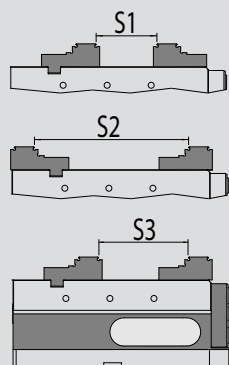
Jaw width	125	
Dimensions in mm	a	36
	b	96
	b1	64
	c	12
	d	14
	h	35
	h1	52
	h2	55
	l	62,5
	l1	4
l2	7	

Clamping range S1	10 - 71
Clamping range S2	90 - 169
Clamping range S3	40 - 105

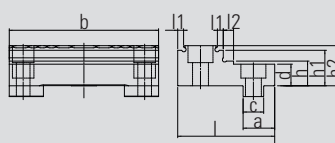
### Gripper jaw with integrated gripper row



- For rectangular workpieces (sawn material)  $\leq 0.5$  mm
- Rigid design to prevent vibrations when parts are clamped upright
- Additional clamping surfaces, ground on both sides
- For five-sided machining, ensuring best possible accessibility to the workpiece
- Positive locking through penetration of the centres into the material
- Minimal lost clamping margin of approx. 4 mm.
- Suitable for material strength of up to 1000 N/mm<sup>2</sup>

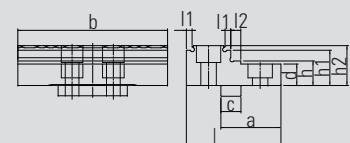


Order no. fixed:  
6921884034931



Jaw width	125	
Dimensions in mm	a	21,5
	b	118
	c	14
	d	14
	h	16
	h1	23
	h2	26
	l	66
	l1	4
	l2	7

Order no. movable:  
6921534036931

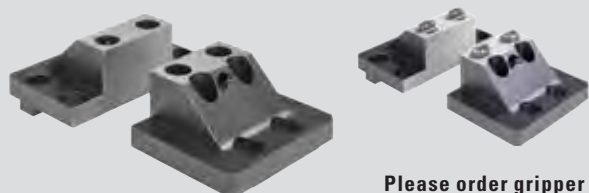


Jaw width	125	
Dimensions in mm	a	34
	b	118
	c	12
	d	14
	h	16
	h1	23
	h2	26
	l	60,6
	l1	4
	l2	7

Clamping range S1	10 - 67
Clamping range S2	94 - 173
Clamping range S3	38 - 101

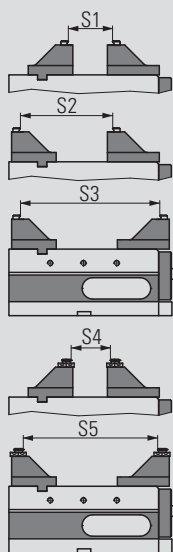
## ALLMATIC GRIPP – mechanical / T-REX version (accessories)

### Reduced-width jaws, 64 mm

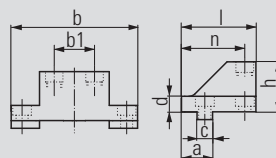


Please order gripper studs separately.

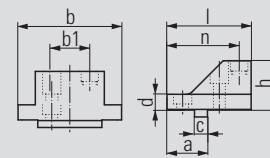
- Material: hardened steel
- Allows unhindered access to the workpiece, even with short tools
- For clamping small to medium-sized workpieces
- The clamping of unmachined parts (incl. round material) is supported via 2 adjustable gripper studs in each case (gripper studs not supplied with the jaws)
- Jaws with Click system for parallels
- Front surface can be used as clamping surface (hardened, ground and polished)
- Studs (pointed/smooth) **not** included



Order no. fixed:  
6921884040140



Order no. movable:  
6921884040040

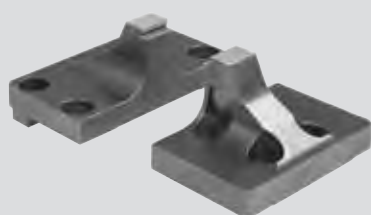


Jaw width	125	
Dimensions in mm	a	28
	b	116
	b1	37
	c	14
	d	14
	h	45
	l	67
	n	56

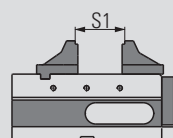
Jaw width	125	
Dimensions in mm	a	37.5
	b	96
	b1	37
	c	12
	d	14
	h	45
	l	79
	n	67

Clamping range S1	21 – 68
Clamping range S2	66 – 138
Clamping range S3	131 – 209
Clamping range S4	21 – 68
Clamping range S5	131 – 209

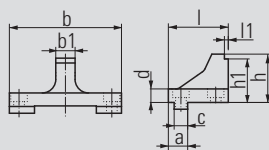
### Reduced-width jaws, 20 mm



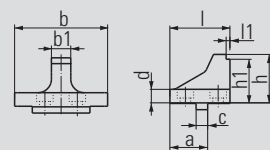
- Material: Hardened steel
- For clamping parallel pre-machined small workpieces
- Further enhanced accessibility to the workpiece thanks to slim, tall shape – also optimal for short tools
- Front surface (step) additionally carbide-coated to ensure secure clamping – holding force increased by at least a factor of 2 compared to smooth clamping surfaces



Order no. fixed:  
6921884041141



Order no. movable:  
6921884041041



Jaw width	125	
Dimensions in mm	a	20
	b	116
	b1	20
	c	14
	d	14
	h	50
	h1	45
	l	62
	l1	4

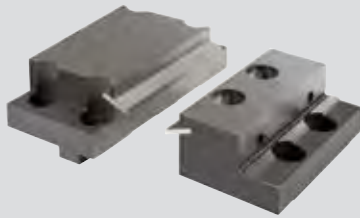
Jaw width	125	
Dimensions in mm	a	39
	b	96
	b1	20
	c	12
	d	14
	h	50
	h1	45
	l	62
	l1	4

Clamping range S1	9 – 75
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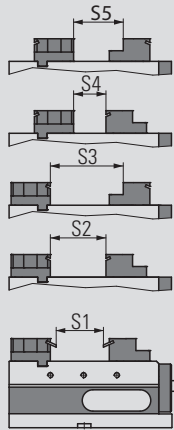


## ALLMATIC GRIPP – mechanical / T-REX version (accessories)

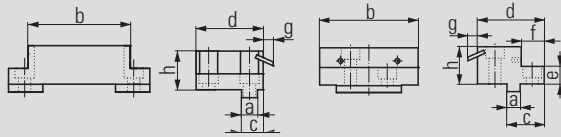
### Universal pull-down jaws



- Material: hardened steel
- Reduced-width jaws 90 mm
- Ground and polished clamping surfaces
- Pull-down with ground and polished spring leaves for machined and unmachined clamping surfaces
- 1-Click spring leaves
- High clamping accuracy for parallel and accurate angle machining



Order no. fixed: 6921884106031 Order no. movable: 6921884102031



Jaw width	125	
Dimensions in mm	a	14
	b	90
	c	19
	d	59
	g	8,8
	h	34

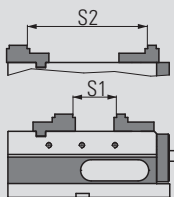
Jaw width	125	
Dimensions in mm	a	12
	b	90
	c	34
	d	61
	e	16
	f	21
	g	8,8
	h	34

Clamping range S1	0 – 82
Clamping range S2	18 – 100
Clamping range S3	44 – 126
Clamping range S4	0 – 65
Clamping range S5	23 – 88

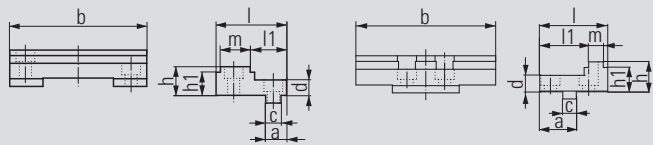
### Step jaws HM - coated



- Material: hardened steel
- For clamping parallel pre-machined workpieces
- Clamping surfaces (step) additionally carbide – coated to ensure secure clamping – this increases the holding force by a factor of at least 2 compared to smooth clamping surface



Order no. fixed: 6921884006041 Order no. movable: 6921884002041



Jaw width	125	
Abmessungen in mm	a	19
	b	124,4
	c	14
	d	14
	h	26
	h1	21
	l	64
	l1	33
	m	27

Jaw width	125	
Abmessungen in mm	a	32,5
	b	124,4
	c	12
	d	14
	h	26
	h1	21
	l	60,5
	l1	43,5
m	13	

Clamping range S1	9 – 67
Clamping range S2	100 – 183

## ALLMATIC GRIPP – mechanical / T-REX version (accessories)

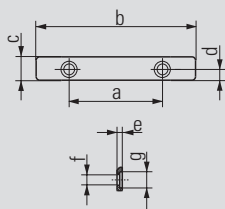
### Spring leaves (pair)



Order no. 6921884103031

- Hardened spring leaves
- Spring leaves (spare) for the pull-down jaws (see left)

### Parallels (pair)



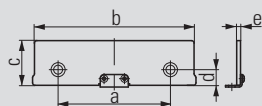
Order no. 6921475013031

Jaw width	90	
Dimensions in mm	a	52
	b	89
	c	13
	d	6
	e	3
	f	Ø 6
	g	Ø 9

- Suitable only for the universal pull-down jaws
- For parallel raising of workpieces
- Hardened, ground and polished parallels

- Bolt-on parallels
- For the high side of the jaws

### Click parallels (pair)



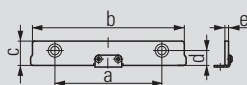
Order no. 6921175029042

Jaw width	90	
Dimensions in mm	a	48
	b	90
	c	29
	d	8.75
	e	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels

- Parallels with Click system
- For the high side of the jaws

### Click parallels (pair)



Order no. 6921175016042

Jaw width	90	
Dimensions in mm	a	48
	b	90
	c	16
	d	8.75
	e	3

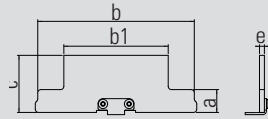
- For parallel raising of workpieces
- Hardened, ground and polished parallels

- Parallels with Click system
- For the high side of the jaws

## ALLMATIC GRIPP – mechanical / T-REX version (accessories)

### Click parallels (pair)

Order no. 6921535035042



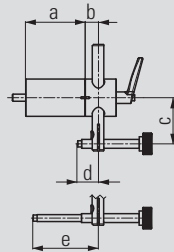
Jaw width	90	
Dimensions in mm	a	14
	b	96
	b1	64
	c	35
	e	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels

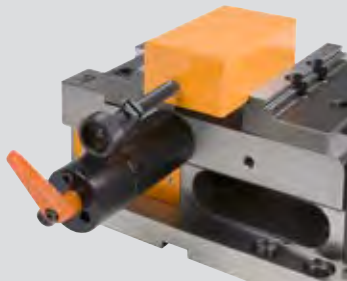
- Parallels with Click system
- For the high side of jaw

### Workpiece stop

Order no. 6921285650144



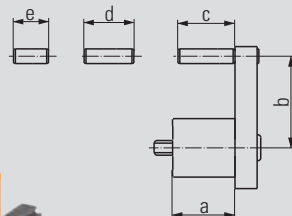
Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63,5
	e	53,5 – 113,5



- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Position of the third workpiece axis can be preset and clamped
- Workpiece stop can be swivelled away once the workpiece has been clamped
- This allows the stop side of the workpiece to also be machined (repeating accuracy:  $\pm 0.01$ )

### Workpiece stop

Order no. 6921685670042



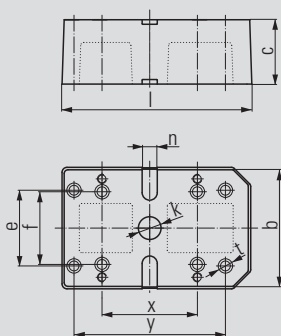
Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19



- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Can be pre-mounted with various fixed dimensions
- Position of the third workpiece axis can be preset

## ALLMATIC GRIPP – mechanical / T-REX version (accessories)

### Console



Order no. 6921885009042

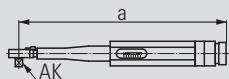
Jaw width	125	
Dimensions in mm	b	154
	c	85
	e	100
	f	96
	l	250
	n	20 H7
	k	Ø 30 H7
	t	13
	x	125.5
	y	200

- Material: GG30
- For raising the T-REX 125 vice
- Improvement of accessibility for five-sided machining
- The mounting hole pattern of T-REX and console are not in alignment

Scope of supply:

- Console incl. fixing bolt
- 2 socket screw wrenches
- 4 bolts

### Torque wrench



Order no. 0651114113188

Dimensions in mm	a	307
	AK (Drive square)	3/8"

- Can be preset to 10 – 60 Nm
- For use on the high-pressure gripper spindles T-REX, TITAN and DUO Plus 125

### Aligning and fixing set



Order no. – see table

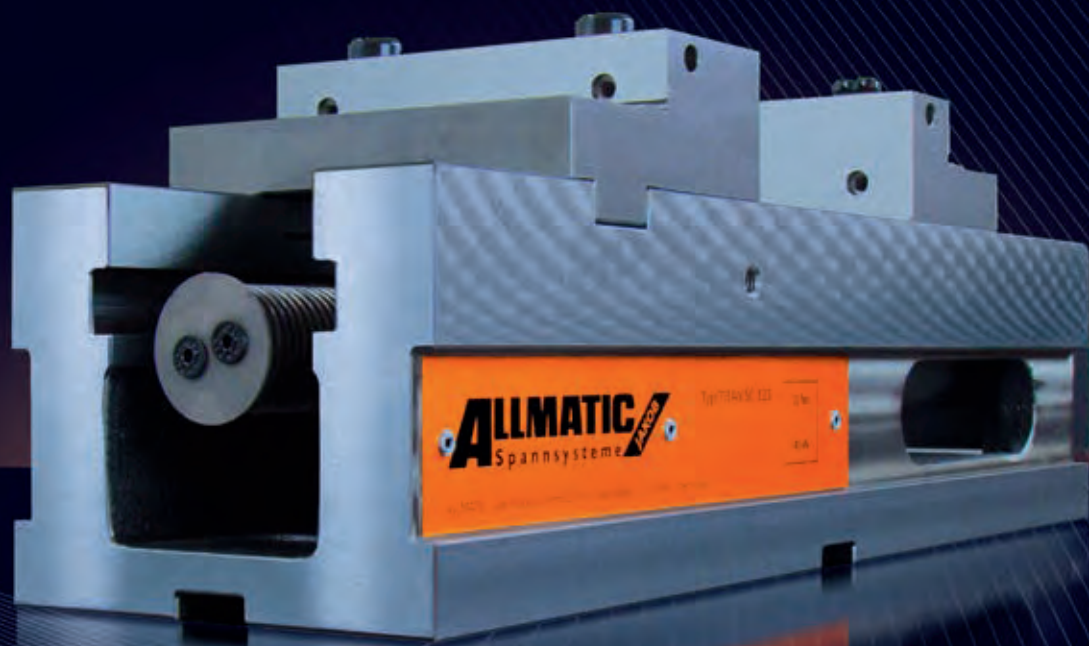
T-slot/ thread	Order no.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

- For aligning (positioning) and fastening the vice on pallet and machine table
- Size according to T-slot or thread in the machine table

# ALLMATIC TITAN SC 125 – SPEED GUARANTEED

The ALLMATIC TITAN SC 125 is designed for quick machining of raw parts to finished product. It can be used equally for the Gripp Clamping in the first operation, as well as for conventional clamping in the second clamping station without conversion.





**ALLMATIC**  
Spannsysteme

Typ TITAN SC 125

125 kN

125 kN

www.allmatic.com

# ALLMATIC GRIPP – MECHANICAL VERSION TITAN SC 125

## Scope of application:

- The classical, universal clamp, for vertical 3 axis machining centres
- Conventional clamping and gripp clamping possible
- Clamping of raw parts, burn and saw cuts by penetrating hardened and interchangeable gripp elements into the workpiece

## Customer advantages:

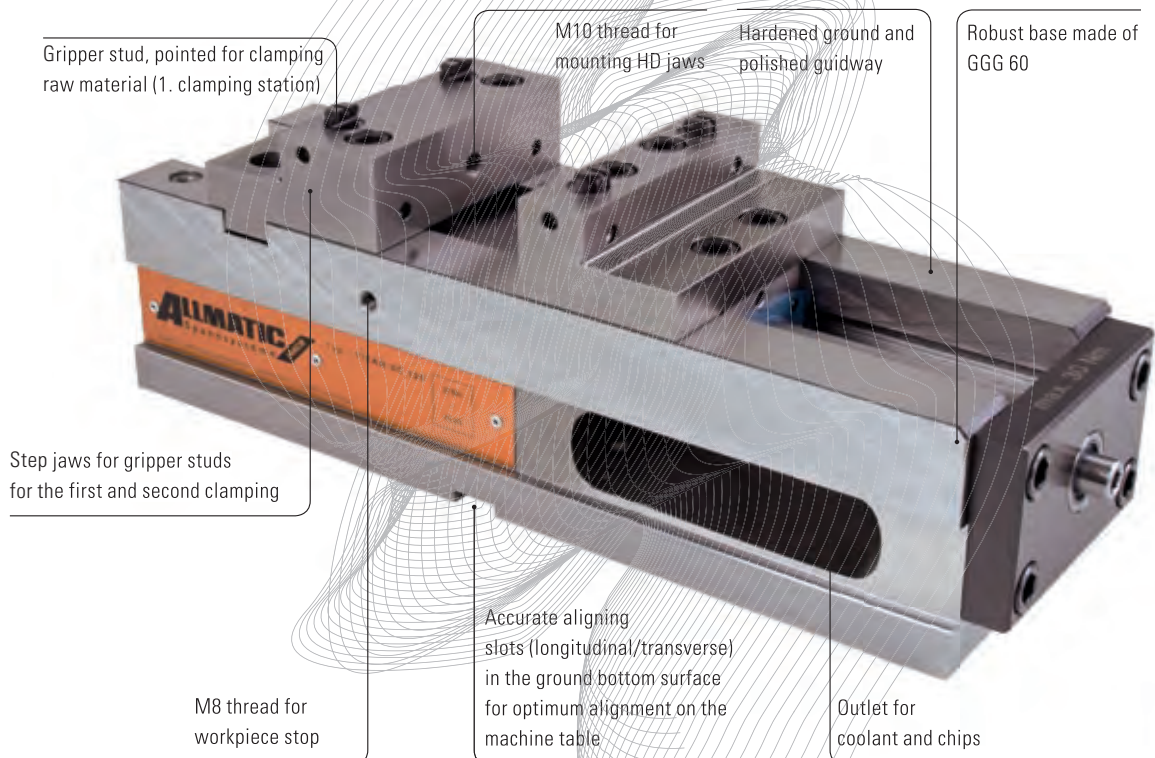
- Free of charge introduction to gripp technology in comparison to conventional clamping (LC)
- **Existing** step jaw systems of product series LC / TC / Titan **can be used**
- First and second clamping stations without retrofitting the step jaws
- Clamping of raw parts such as burn & saw cuts (materials up to approx. 1000N/mm<sup>2</sup>) through screwable clamping applications (first clamping station)



- Parallel clamping to machined workpieces with the step jaws (2. clamping station)
- Upgrade to full clamping function with optional clamping jaws

## Product features:

- With grounded jaws, the TITAN SC 125 has the precision which is necessary for machining workpieces
- Fully enclosed **gripp spindle** for clamping and forming raw material
- The **high-pressure spindle** allows you to, with a **mechanical force amplifier** (using the torque wrench), to work and clamp to a table
- Stable GGG60 body, grounded top and bottom
- Double-sided M8 thread for workpiece stoppage
- Precise tracks in the grounded surface of the soles for optimum alignment on the machining table
- Click-quick-change system for attaching jaws and click parallels




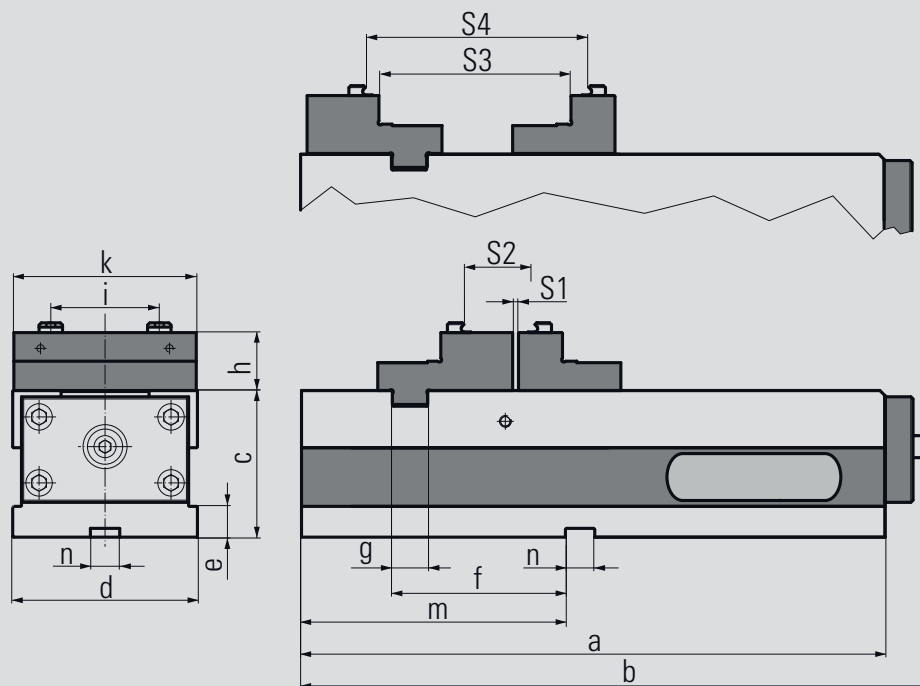
**Order no. 6921888010755**

## Scope of supply:

- 1 TITAN SC 125 with step jaws for gripper studs
- 4 Gripper studs
- 1 set of side clamps
- 3 Socket screw wrench

**Note:** The movable jaw has no pendulum compensation. It is suitable for rectangular workpieces (saw cuts) // <= 0.5 (concurrency less than or equal to 0.5 mm) or cylindrical workpieces  $\text{O} \leq 0.5$  (roundness less than or equal to 0.5 mm)

 Optional: Mounting holes for zero-point clamping systems are possible.

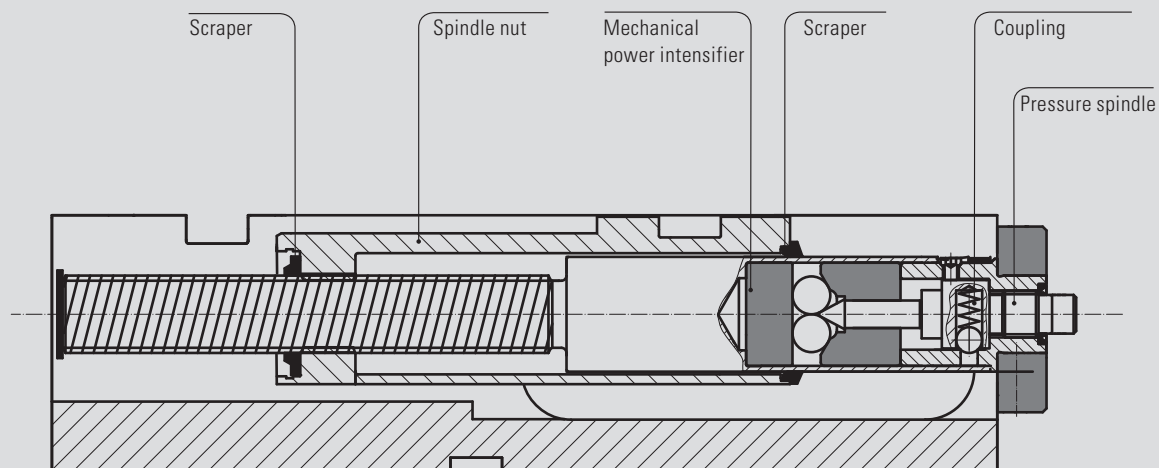


## Technical data

Typ	SC 125	
Dimensions / tolerances in mm	a	398
	b	429
	c	100
	d	126
	e	21
	f	118
	g	24
	h	39,5
	i	74
	k	124,4
	m	180
	n	20

Typ	SC 125
Clamping range S1 in mm	0 - 182
Clamping range S2 in mm	52 - 224
Clamping range S2 round workpiece in mm	Ø88 - 220
Clamping range S3 in mm	131 - 313
Clamping range S4 in mm	160 - 332
Max. torque in Nm	30
Max. clamping force in kN	40
Weight in kg	35

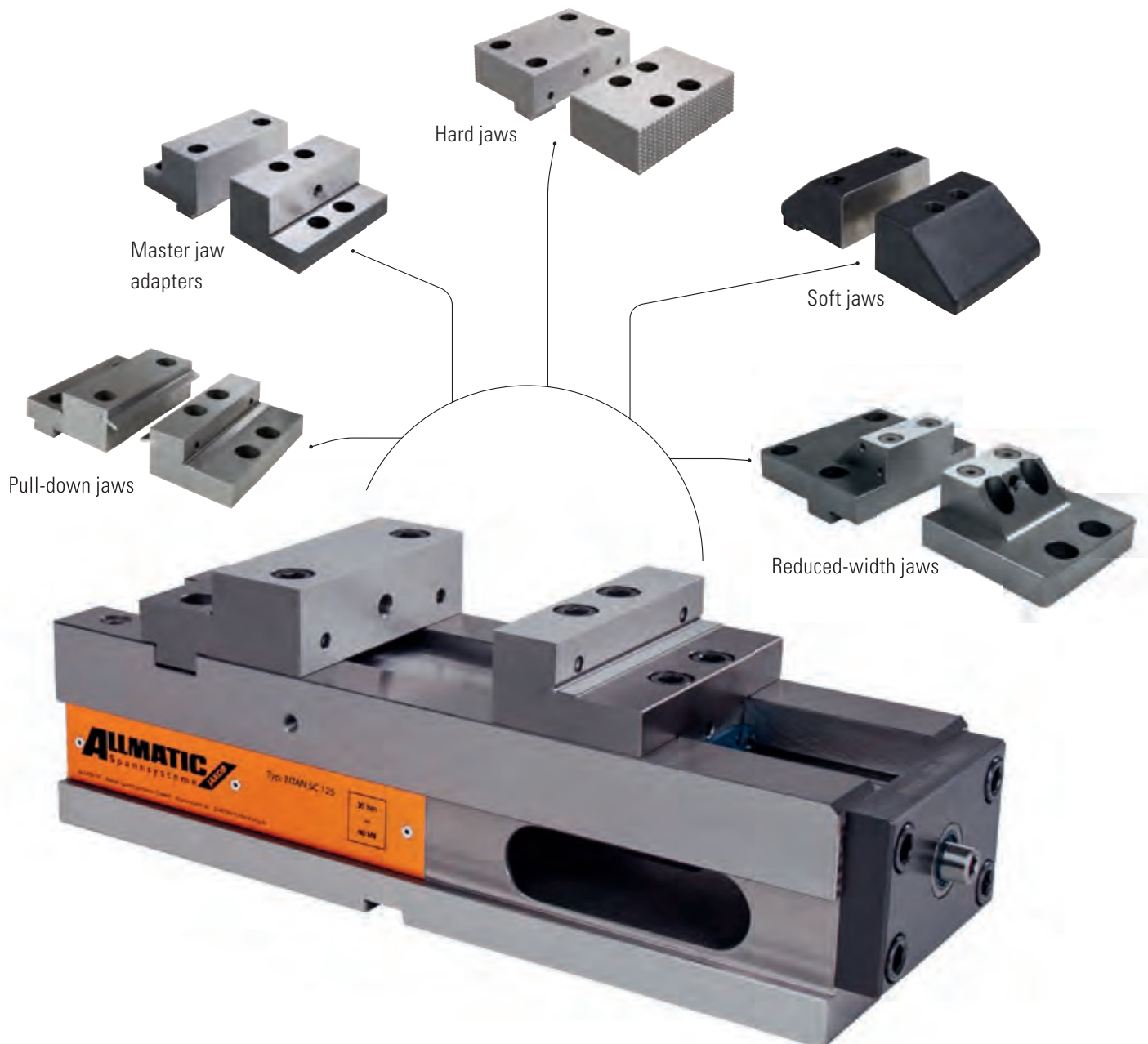
## Spindle cross-section





# TITAN SC 125

## CONVENTIONAL CLAMPING



### For conventional clamping of workpieces

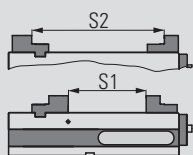
On the following pages you will find a wide range of jaws suitable for clamping pre-machined workpieces.

## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (conventional clamping accessories)

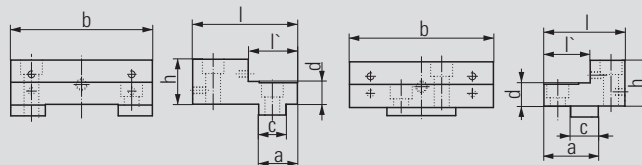
### Step jaws



- Material: hardened steel
- High and stepped side with thread for parallels
- Ground clamping surfaces
- Additional thread on the high side for mounting the HD jaws
- Click system on the high side



Order no. fixed: 6921684006731 Order no. movable: 6921484002731



Jaw width		125
Dimen- sions in mm	a	34
	b	124,4
	c	24
	d	20
	h	39,5
	l	92
	l'	43

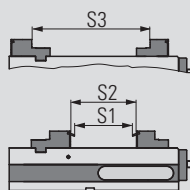
Jaw width		125
Dimen- sions in mm	a	47
	b	124,4
	c	24
	d	20
	h	39,5
	l	70
	l'	40

Clamping width S1	0 – 182
Clamping width S2	131 – 313

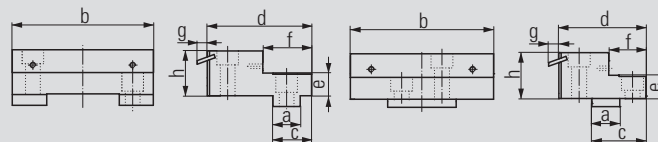
### Pull-down jaws



- Material: hardened steel
- Pull-down with ground spring leaves for unmachined and machined clamping surfaces
- Ground clamping surfaces
- High clamping precision for parallel or precise-angle machining
- Click system on the high side



Order no. fixed: 6921684106031 Order no. movable: 6921684102031



Jaw width		125
Dimen- sions in mm	a	24
	b	124,4
	c	34
	d	92
	e	20
	f	43
	g	8,8
	h	39,5

Jaw width		125
Dimen- sions in mm	a	24
	b	124,4
	c	46,5
	d	75
	e	20
	f	32
	g	8,8
	h	39,5

Clamping width S1	0 – 159
Clamping width S2	0 – 176
Clamping width S3	124 – 305

### Spring leaves (pair)



Order no. 6921684103031

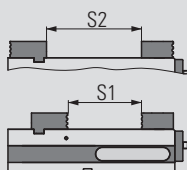
- Hardened spring leaves
- Spring leaves (replacement) for the pull-down jaws  
Order no.: 6921684106031 and 6921684102031

## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (conventional clamping accessories)

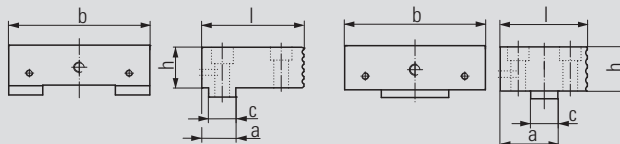
### Hard base jaws



- Material: hardened steel
- One side smooth and ground, one side serrated
- Additional thread for parallels and for mounting the HD jaws on the smooth side
- Mountings for click system on both sides of the jaw



Order no. fixed: 6921684005731 Order no. movable: 6921684004731



Jaw width		125
Dimensions in mm	a	30
	b	124,4
	c	24
	h	39,5
	l	88

Jaw width		125
Dimensions in mm	a	50
	b	124,4
	c	24
	h	39,5
	l	76

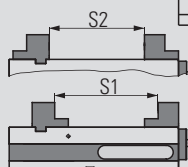
Clamping width S1	0 – 179
Clamping width S2	49 – 231

### Adapterbacken

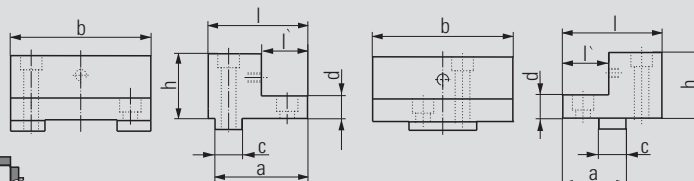


- Material: steel
- High side of the jaw hardened
- Additional thread for mounting the HD jaws

- Ground clamping surfaces
- Click system on the high side



Order no. fixed: 6921684012231 Order no. movable: 6921284011231



Jaw width		125
Dimensions in mm	a	77
	b	126
	c	24
	d	20
	h	58
	l	85
	l'	32

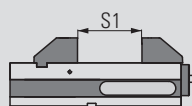
Jaw width		125
Dimensions in mm	a	52
	b	126
	c	24
	d	20
	h	58
	l	80
	l'	32

Clamping width S1	64 – 246
Clamping width S2	45 – 227

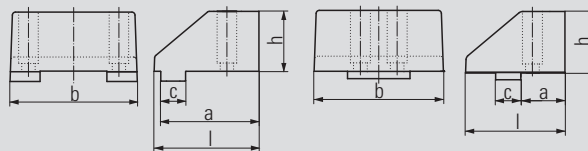
### Weiche Backen



- Material: GGG40 SG iron
- For self-made special jaws
- Chamfer provides very good accessibility to the workpiece



Order no. fixed: 6921684088031 Order no. movable: 6921484087031



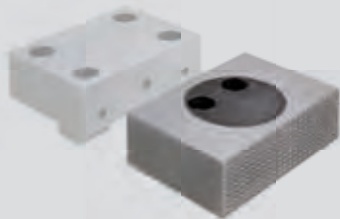
Jaw width		125
Dimensions in mm	a	95
	b	124
	c	24
	h	58
	l	101,5

Jaw width		125
Dimensions in mm	a	42
	b	124
	c	24
	h	58
	l	94,5

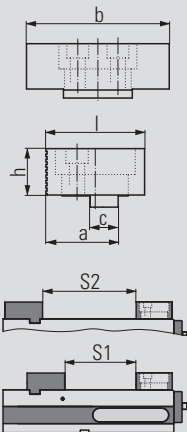
Clamping width S1	0 – 150
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## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (conventional clamping accessories)

### Pivot jaw, movable



- Material: Hardened steel
- With click system
- One side smooth and ground, one side serrated
- 360° rotatable
- Picture with hard base jaw (see order no.: 6921684005731)



Order no. 6921684020042

Jaw width		125
Dimensions in mm	a	62
	b	124,4
	c	24
	h	39,5
	l	84

Clamping width S1	0 – 167
Clamping width S2	37 – 219

### Soft jaw

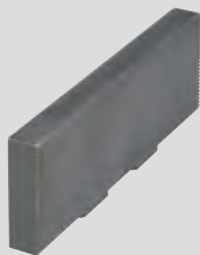


- Material: case-hardened steel 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Only for use with jaws with Click system

Order no. 6921684023042

Jaw width		125
Dimensions in mm	a	125
	b	39,8
	c	22

### Jaw with cross grooving



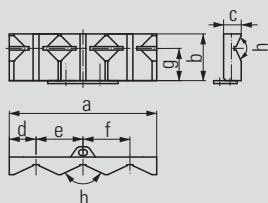
- Material: hardened steel
- Jaws with sharp serrations to increase the specific contact pressure per unit area
- Visible impressions on workpiece
- Only suitable for soft materials
- Only for use with jaws with Click system

Order no. 6921684032040

Jaw width		125
Dimensions in mm	a	125,6
	b	40,1
	c	12

## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (conventional clamping accessories)

### Prismatic jaws (pair)

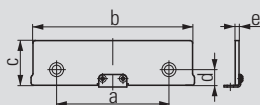


- Material: hardened steel
- Jaws for clamping round parts, vertical dia. 16-74 mm, horizontal dia. 12-40 mm
- Only for use with jaws with Click system

Order no. 6921684024042

Jaw width		125
Dimensions in mm	a	125,6
	b	39,8
	c	15
	d	22,8
	e	40
	f	40
	g	27,5
	h	130°

### Click parallels (pair)



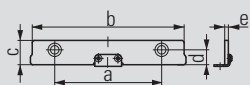
- For parallel raising of workpieces
- Hardened and ground parallels

Order no. 6921185035042

Jaw width		125
Dimensions in mm	a	88
	b	125
	c -0,01	35
	d	12,25
	e	3

- Parallels with click system or screw-on
- For the high side of the jaws

### Click parallels (pair)



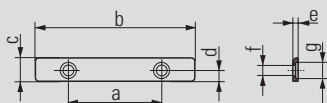
- For parallel raising of workpieces
- Hardened and ground parallels

Order no. 6921185020042

Jaw width		125
Dimensions in mm	a	88
	b	125
	c -0,01	20
	d	12,25
	e	3

- Parallels with click system or screw-on
- For the high side of the jaws

### Parallels (pair)



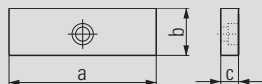
- For parallel raising of workpieces
- Hardened and ground parallels
- Parallels for screwing on
- For the stepped side of the jaws

Order no. 6921485015031

Jaw width		125
Dimensions in mm	a	88
	b	124
	c	15
	d	6
	e	3
	f	∅ 6
	g	∅ 9

## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (conventional clamping accessories)

### Smooth jaws (pair)

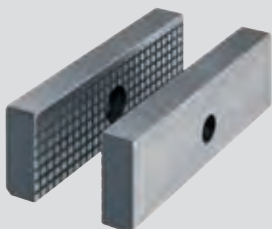


Order no. 6921024022031

Jaw width	125	
Dimensions in mm	a	125
	b	40
	c	15

- Material: hardened steel
- For parts with delicate clamping surfaces
- Please order fastening bolts separately (order no. 6921011023000)

### Serrated jaws (pair)



Order no. 6921021005031

Jaw width	125	
Dimensions in mm	a	125
	b	40
	c	15

- Material: hardened steel
- Standard jaws with small surface area
- To increase the specific contact pressure
- Please order fastening bolts separately (order no. 6921011023000)

### Soft jaws (pair)

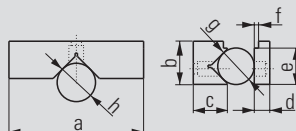
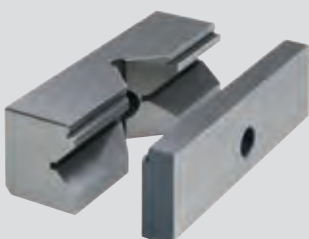


Order no. 6921024023031

Jaw width	125	
Dimensions in mm	a	125
	b	40
	c	25

- Material: 21MnCr5G, type 1.23162 steel
- Jaws of case-hardening steel
- For self-made special jaws
- Please order fastening bolts separately (order no. 6921011023000)

### Prismatic jaws (set)



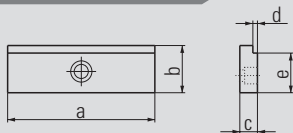
Order no. 6921024024031

Jaw width	125	
Dimensions in mm	a	125
	b	40
	c	35
	d	15
	e	35
	f	3
	g	Ø 12 – 28
	h	Ø 18 – 55

- Material: hardened steel
- For horizontal and vertical clamping of round and flat workpieces
- Please order fastening bolts separately (Order no.: 6921011023000)

## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (conventional clamping accessories)

### Step jaws (pair)



Order no. 6921024025031

Jaw width		125
Dimensions in mm	a	125
	b	40
	c	15
	d	3
	e	35

- Material: hardened steel
- For horizontal clamping of flat workpieces
- Please order fastening bolts separately (order no.: 6921011023000)

### Roller pull-down jaws (pair)

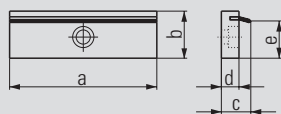


Order no. 6921024005131

Jaw width		125
Dimensions in mm	a	125
	b	40
	c	26
	d	35

- Material: hardened steel
- For parts with delicate clamping surfaces
- Jaw parts in contact with the workpiece press the workpiece onto the support surface
- Please order fastening bolts separately (order no.: 6921011023000)

### Spring leaf pull-down jaws (pair)



Order no. 6921024001042

Jaw width		125
Dimensions in mm	a	125
	b	40
	c	20
	d	12
	e	33

- Material: hardened steel
- For parts with rough clamping surfaces
- Spring leaves press the workpiece onto the support surface
- Spring leaves are replaceable (see below)
- Please order fastening bolts separately (order no.: 6921011023000)

### Spring leaves (pair)



Order no. 6921024002131

- Spring leaves (replacement) for the spring leaf pull-down jaws (see above)

### Jaw fixing screw



Order no. 6921011023000

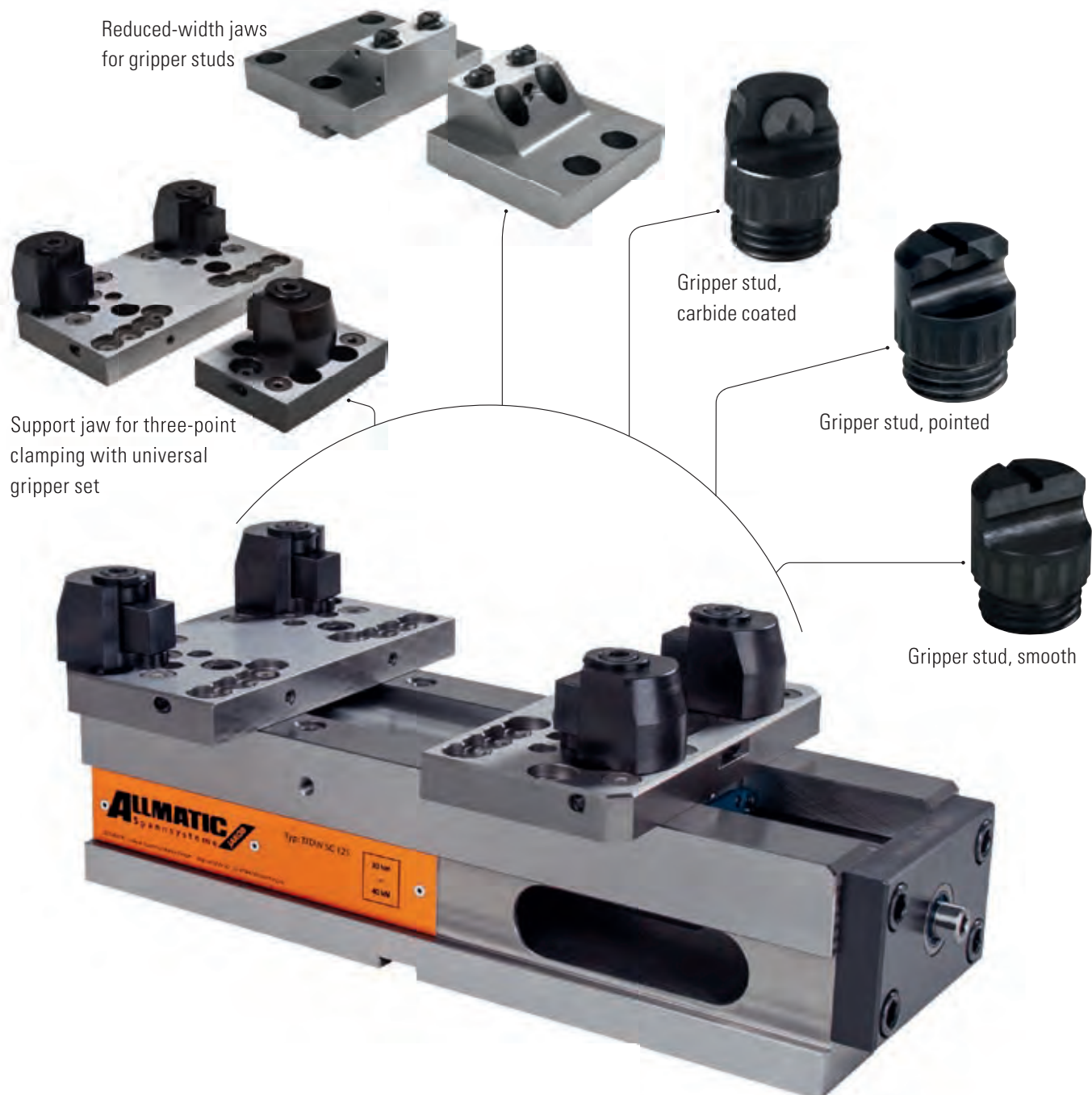
- Bolt with shoulder – M10 x 23
- Suitable for all jaws in the 090, 100, 125 and 160 mm series

**ALLMATIC GRIPP – mechanical / version TITAN SC 125 (conventional clamping accessories)**



# TITAN SC 125

## GRIPP CLAMPING



### For clamping complex unmachined parts

The support jaws enable you to clamp different unmachined parts quickly and securely. You will find jaws for gripper clamping on the following pages.

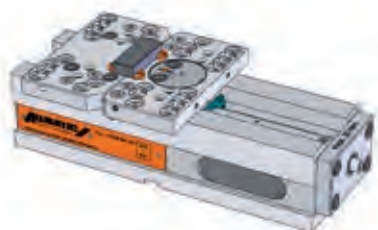
### GRIPP clamping

- Support jaws are used to mount different gripper studs (threaded gripper studs or universal gripper set)
- Gripper studs can be screwed in various positions on the grid plate in order to clamp various workpiece geometries securely
- Additional pivot function of the support jaws compensates for non-parallel clamping surfaces and is required to clamp uneven workpieces
- Three-point clamping is possible due to the rigid support jaw

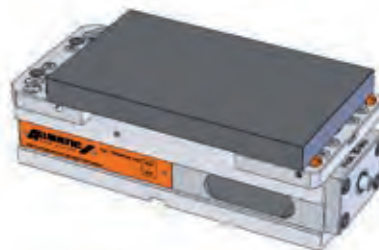
# CLAMPING WIDTHS – GRIPP CLAMPING

## Support jaws with gripper studs

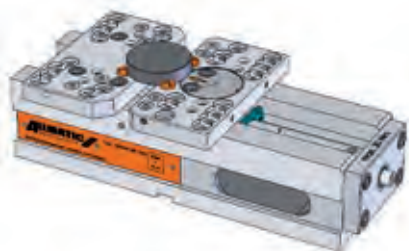
You can find the clamping ranges of the other TITAN SC 125 jaws for conventional clamping on the following pages of accessories



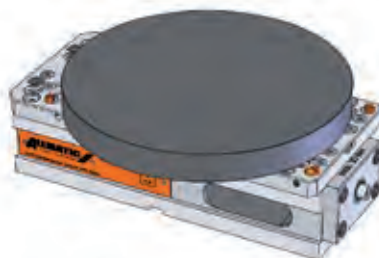
min. clamping range	29 mm
min. clamping width	70 mm



max. clamping range	322 mm
max. clamping width	at least 160 mm or larger

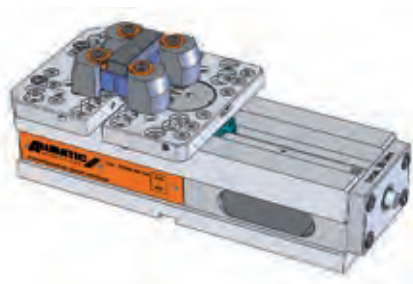


min. clamping range	Ø 70 mm
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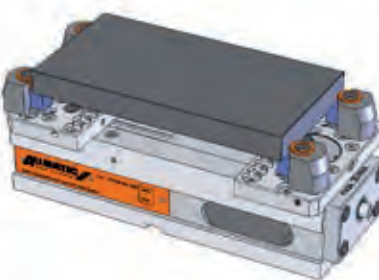


max. clamping range	Ø 330 mm
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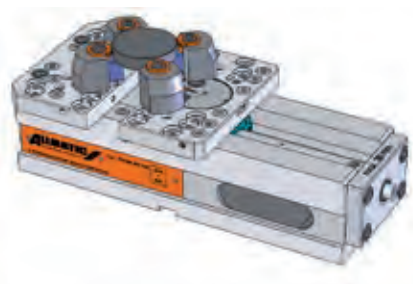
## Support jaws with universal gripper set



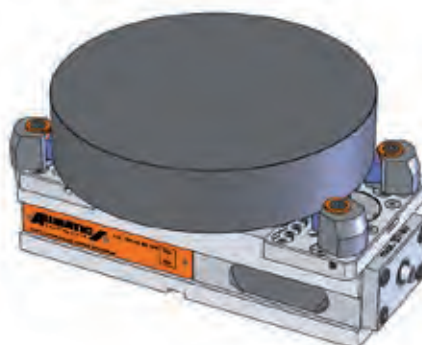
min. clamping range	25 mm
min. clamping width	88 mm



max. clamping range	312 mm
max. clamping width	at least 165 mm or larger



min. clamping range	Ø 70 mm
---------------------	---------



max. clamping range	Ø 330 mm
---------------------	----------

## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (GRIPP clamping accessories)

### Support jaws



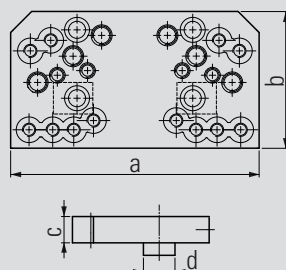
- Material: hardened steel
- For mounting various pull-down wedge elements, universal gripper set and gripper studs (pointed/smooth)
- Front surface can be used as clamping surface (hardened and ground)

#### Pivot jaw:

- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- Supplied **without** wedge elements, gripper set and gripper studs (pointed/smooth)

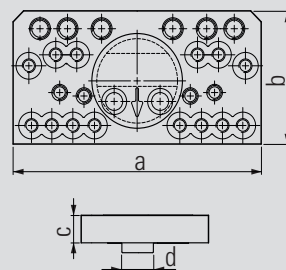
You will find dimensions of the individual gripper items and the gripper studs at [www.allmatic.de](http://www.allmatic.de)

Order no. fixed:  
6921734005842



Jaw width	125	
Dimensions in mm	a	189
	b	104
	c	20
	d	24

Order no. movable, pivoting:  
6921734072842



Jaw width	125	
Dimensions in mm	a	189
	b	97
	c	20
	d	24



Please order universal gripper set or gripper studs separately

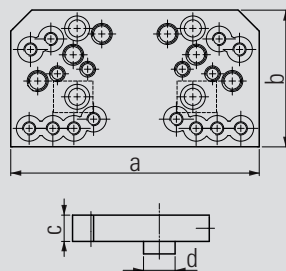
### Support jaws



- Material: hardened steel
- For mounting various studs (pointed/smooth) or a universal gripper set
- For three-point clamping
- Front surface can be used as clamping surface (hardened and ground)
- Supplied **without** studs (pointed/smooth) or gripper set

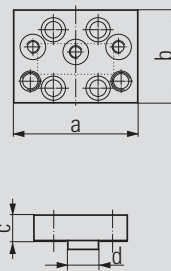
You will find dimensions of the individual gripper items and the gripper studs at [www.allmatic.de](http://www.allmatic.de)

Order no. fixed:  
6921734005842



Jaw width	125	
Dimensions in mm	a	189
	b	104
	c	20
	d	24

Order no. movable, rigid:  
6921884004842



Jaw width	125	
Dimensions in mm	a	97
	b	73
	c	20
	d	24



Please order universal gripper set or gripper studs separately

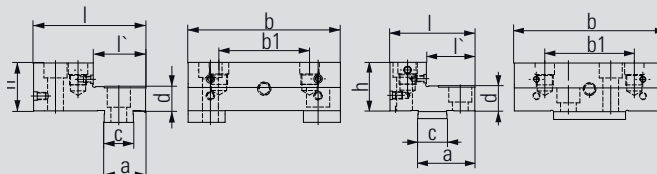
## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (GRIPP clamping accessories)

### Step jaws for gripper studs



Order no. fixed:  
6921884051031

Order no. movable :  
6921884050031



Jaw width		125
Dimen- sions in mm	a	34
	b	124,4
	b1	74
	c	24
	d	20
	h	39,5
	l	92
	l'	43

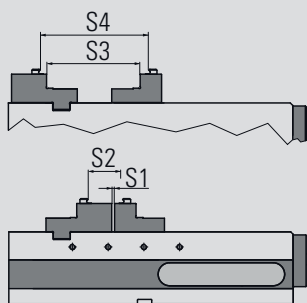
Jaw width		125
Dimen- sions in mm	a	47
	b	124,4
	b1	74
	c	24
	d	20
	h	39,5
	l	70
	l'	40

- Material: Hardened steel
- High and stepped sides with thread for parallels
- Ground clamping surfaces
- Additional thread on the high side for mounting the HD jaws (Typ 125 – 200)
- Suitable for screw-in gripper studs
- First and second clamping steps are possible without changing jaws
- Click system on the high side

Note: The movable jaw has no pendulum compensation. It is suitable for rectangular workpieces (saw cuts) / /  $\leq 0.5$  (concurrency less than or equal to 0.5 mm) or cylindrical workpieces  $\text{O} \leq 0.5$  (roundness less than or equal to 0.5 mm)



Please order gripper studs separately

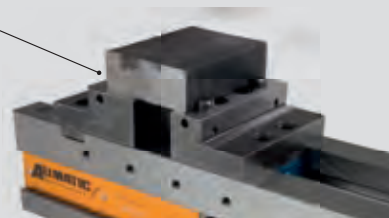


Clamping width S1	0 – 182
Clamping width S2	49-226
Clamping width S2 round workpiece	$\text{Ø} 88-220$
Clamping width S3	131 - 313
Clamping width S4	157-334



clamping unmachined parts round

No  
retooling necessary!  
Set-up times will be  
reduced



clamping unmachined parts quadratic



clamping pre-machined workpieces

## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (GRIPP clamping accessories)

### Reduced-width jaws for gripper studs

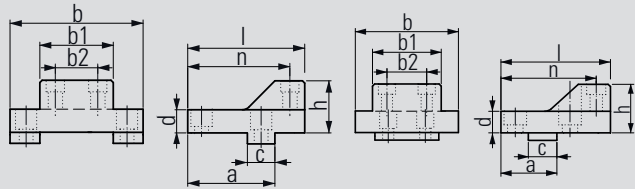


- Material: hardened steel
- Allows unhindered access to the workpiece, even with short tools
- For clamping small to medium-sized workpieces
- Suitable for screw-in gripper studs
- First and second clamping steps are possible without changing jaws
- Click system on the high side

Note: The movable jaw has no pendulum compensation. It is suitable for rectangular workpieces (saw cuts)  $// \leq 0.5$  (concurrency less than or equal to 0.5 mm) or cylindrical workpieces  $\text{O} \leq 0.5$  (roundness less than or equal to 0.5 mm)

Order no. fixed:  
6921834040140

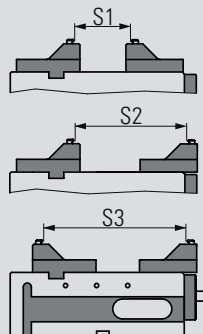
Order no. movable:  
6921834040040



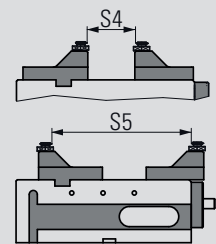
Jaw width		125	Jaw width		125
Dimen- sions in mm	a	76	Dimen- sions in mm	a	47
	b	116		b	96
	b1	64		b1	64
	b2	37		b2	37
	c	24		c	24
	d	20		d	20
	h	45		h	45
	l	102		l	92
n	89	n	80		



Please order gripper studs separately



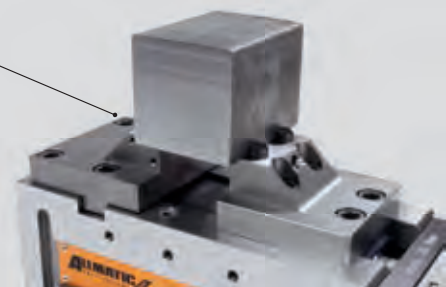
Clamping range S1	31 - 210
Clamping range S2	123 - 300
Clamping range S3	173 - 350
Clamping range S4	25 - 203
Clamping range S5	165 - 343



No  
retooling necessary!  
For optimal accessibility  
also with short tools!



clamping unmachined parts round



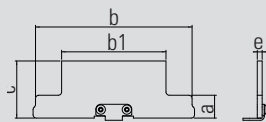
clamping unmachined parts quadratic



clamping pre-machined workpieces

## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (GRIPP clamping accessories)

### Click parallels (pair)



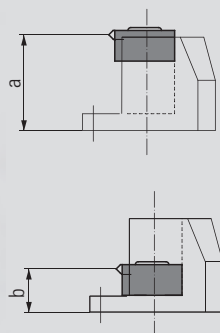
- For parallel raising of workpieces
- Hardened, ground and polished parallels

Order no. 6921535035042

Jaw width	125	
Abmessungen in mm	a	14
	b	96
	b1	64
	c	35
	e	3

- Parallels with Click system
- For the high side of jaw

### Universal gripper set



Order no. 6921884027031

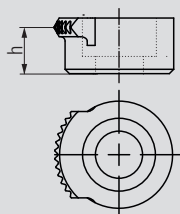
Jaw width	125	
Dimensions in mm	a	40
	b	18

- For clamping complex unmachined parts
- By reworking the individual elements of the universal gripper set, both the gripper height and the support height of the workpiece can be varied

Consisting of:

- 4 x gripper studs 6921884026000
- 4 x gripper stud mounting 6921884027000
- 4 x supports 6921884028000
- 8 x shims
- Support bolts
- M10 fastening bolts in various lengths
- M6 threaded rods in various lengths
- Socket screw wrench
- Storage case

### Gripper stud

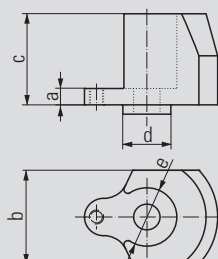


Order no. 6921884026000

Dimensions in mm	h	11
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- Gripper stud for universal gripper set

### Gripper stud mount



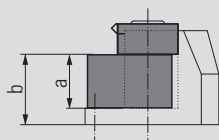
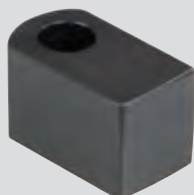
Order no. 6921884027000

Dimensions in mm	a	7
	b	40
	c	39
	d	∅ 20
	e	∅ 25

- Mounting for gripper stud 2306/001

## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (GRIPP clamping accessories)

### Support

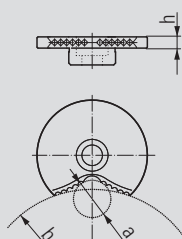


Order no. 6921884028000

Dimensions in mm	a	22
	b	29

- Support for universal gripper set

### Prismatic gripper

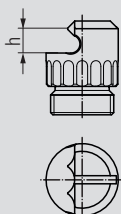


Order no. 6921884029031

Dimensions in mm	a	∅ 20
	b	∅ 120
	h	6

- Replaces gripper stud 6921884026000 in the universal gripper set
- Special shape distributes the applied clamping force – particularly advantageous for clamping workpieces that require fits to be made

### Gripper stud, pointed

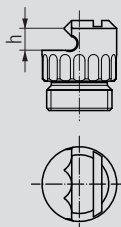


Order no. 6921884036000

Dimensions in mm	h	5,5
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- For clamping unmachined parts
- Least possible lost clamping margin
- Clamping height: adjustable from 4.5 to 6.0 mm

### Gripper stud, low

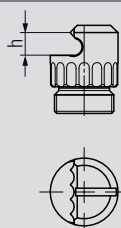


Order no. 6921884036100

Dimensions in mm	h	5
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- For clamping unmachined parts
- Least possible lost clamping margin
- Clamping height: adjustable from 3.0 to 4.5 mm

### Clamping insert, four-point



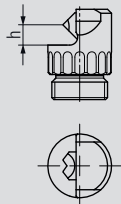
Order no. 6921884036500

Dimensions in mm	h	5,4
------------------	---	-----

- For clamping unmachined parts
- For soft materials such as aluminium
- Least possible lost clamping margin
- Clamping height approx. 4.5 mm to 6.0 mm

## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (GRIPP clamping accessories)

### Gripper stud, carbide coated

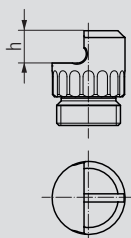


Order no. 6921884036841

Dimensions in mm	h	5,1
------------------	---	-----

- For clamping unmachined parts
- For quenched and tempered materials and flame-cut materials
- Least possible lost clamping margin, clamping height approx. 4.2 mm to 5.7 mm

### Clamping insert, smooth

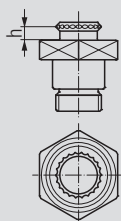


Order no. 6921884037000

Dimensions in mm	h	7
------------------	---	---

- With carbide coating for clamping pre-machined or hardened workpieces

### Gripper stud, round



Order no. 6921884038000

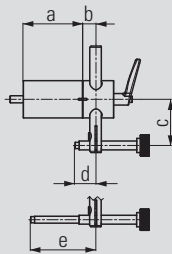
Dimensions in mm	h	4
------------------	---	---

- For clamping unmachined parts
- For drilling through close to the edge
- Offers 6 mm clear space under the workpiece



## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (accessories)

### Workpiece stop

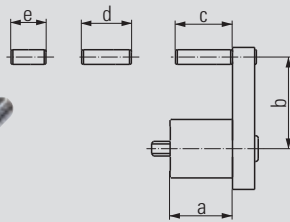


Order no. 6921285650144

Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63,5
	e	53,5 – 113,5

- Can be mounted at the positions provided on both sides of the vice
- Fastening thread M8
- Position of the third workpiece access can be preset and clamped. Workpiece stop can be swivelled away once the workpiece has been clamped.
- This allows the stop side of workpiece to be machined as well (repeating accuracy:  $\pm 0.01$ )

### Workpiece stop

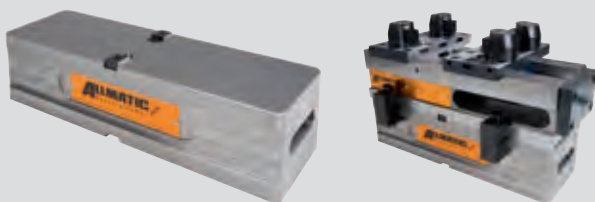


Order no. 6921685670042

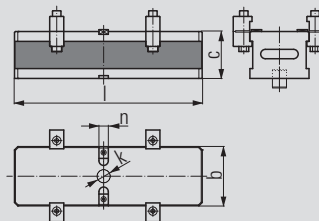
Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

- Can be mounted at the positions provided on both sides of the vice
- Fastening thread M8
- Can be pre-mounted with various fixed dimensions
- Presettable position of the third axis of the workpiece

### Console XL



Order no. 6921885010042

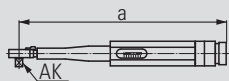


Jaw width	125	
Dimensions in mm	b	126
	c	100
	k	$\varnothing 30$
	l	400
	n	20

- Material: GG30
- For raising the TITAN 2 K vice
- Improvement of accessibility with five-sided machining
- Scope of supply: console incl. fixing bolt for positioning the vice, 2 socket screw wrenches, 4 screws

## ALLMATIC GRIPP – mechanical / version TITAN SC 125 (accessories)

### Torque wrench



Order no. 0651114113188

Dimensions in mm	a	307
	AK (Drive square)	3/8"

- Adjustable between 10 – 60 Nm
- Only for operating the T-REX, TITAN and DUO Plus 125 high-pressure spindles

### Side clamps (pair)



Order no. 6921025000031

- For fastening the vice to the machine table
- Scope of supply includes 2 items

### DUO side clamps



Order no. 6921285000031

- For fastening device to a bracket or onto a machine table
- 1 set consists of 2 pairs of side clamps, including screw connections

### Ausricht- und Fixiersatz



- For aligning (positioning) and fastening the vice on the pallet and machine table
- Size according to T-slot or thread in the machine table

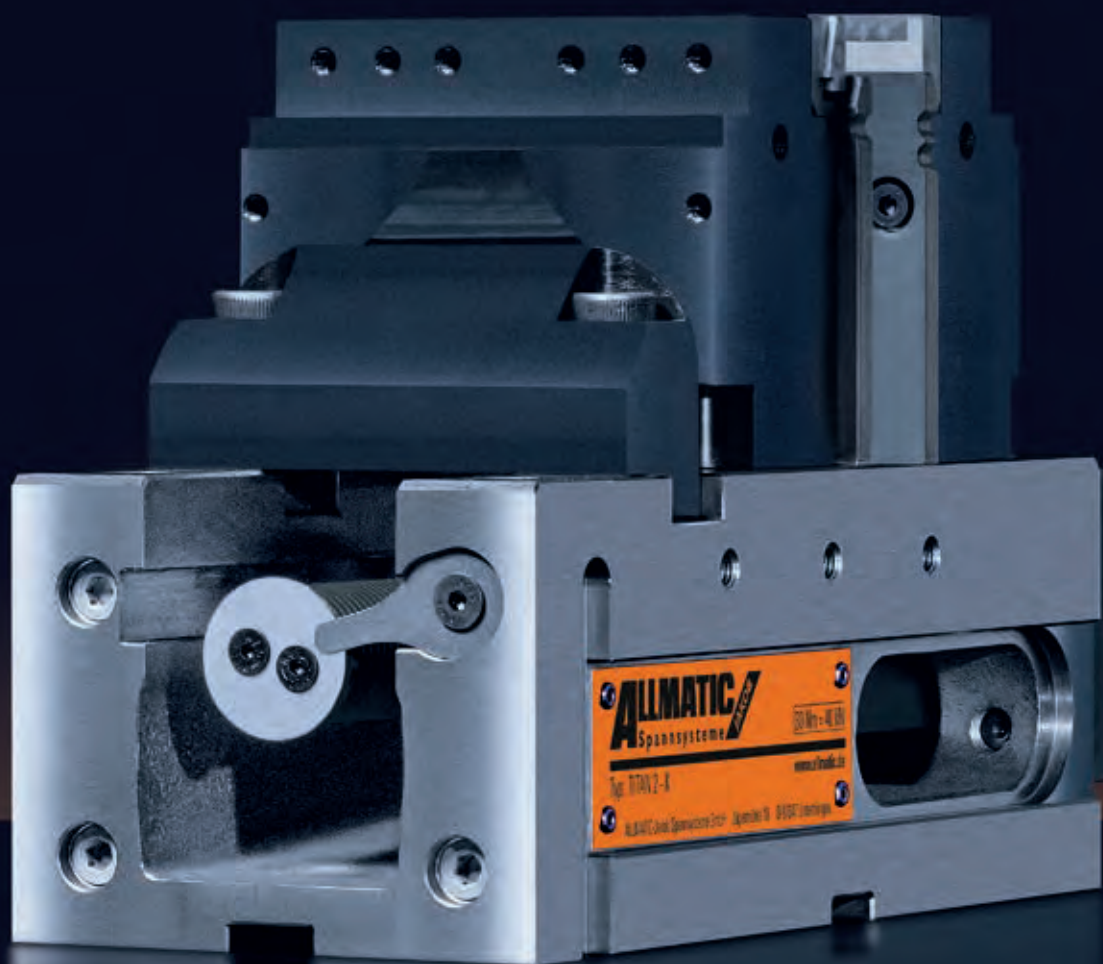
Order no. – see table

T-slot/ Thread	Order no.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

# ALLMATIC TITAN 2 – THREE LENGTHS – THE CRUCIAL ADVANTAGE FOR YOUR MACHINING

More universal – more flexible. The ALLMATIC TITAN 2 K/M/L – whether in height or in length, conventional clamping or gripper clamping – it leaves nothing to be desired





# ALLMATIC GRIPP – MECHANICAL VERSION TITAN 2 K/M/L

## Scope of application:

- Can be applied horizontally or vertically – therefore suitable for vertical and horizontal CNC milling machines
- Conventional clamping, gripper clamping or pull-down clamping are all possible
- TITAN 2 K – ideal for use on five-axis machining centres
- Clamping unmachined parts, saw-cut or flame-cut material by penetration of hardened, replaceable gripper elements into the workpiece
- With the support jaws, unmachined parts in highly varied materials, or with complex geometries, can be clamped securely and economically.

## Product features:

- High versatility – the modular clamping system combines practically all the possibilities of our tried-and-tested models
- The TITAN 2 M is ground and polished on all sides
- TITAN 2 K and M can be used vertically
- High-pressure spindle with power intensification. Clamping force does not slacken
- Enlarged clamping span for secure clamping of unmachined parts
- Lost clamping margin 8 mm with pull-down, 3 mm with GRIPPER
- Clamping with torque wrench – max. 30 Nm. This makes it possible to work above the table with an unfavourable clamping arrangement on the tool



Accurate slots for fastening the range of clamping jaws

Inductively hardened and polished guideway

Rigid spindle nut

Robust base made of GGG 60

Accurate spindle nut guidance

For initial positioning of the movable jaw with heavy workpieces (wrench size 22) Distance separated from power intensifier. (TITAN2 M & L)


Clamping shoulder for vertical use (TITAN 2 K & M)

M8 thread for work-piece stop

Model K: accurate aligning slot (transverse) and a positioning hole in the bottom surface for optimum alignment on the machine table

Models M & L: accurate aligning slots (longitudinal/transverse) in the ground bottom surface for optimum alignment on the machine table

Outlet for coolant and chips

 Optional: Mounting holes for zero-point clamping systems are possible.

## Order no. jaw width 125:

**TITAN 2 K: 6921738000055**

**TITAN 2 M: 6921838000755**

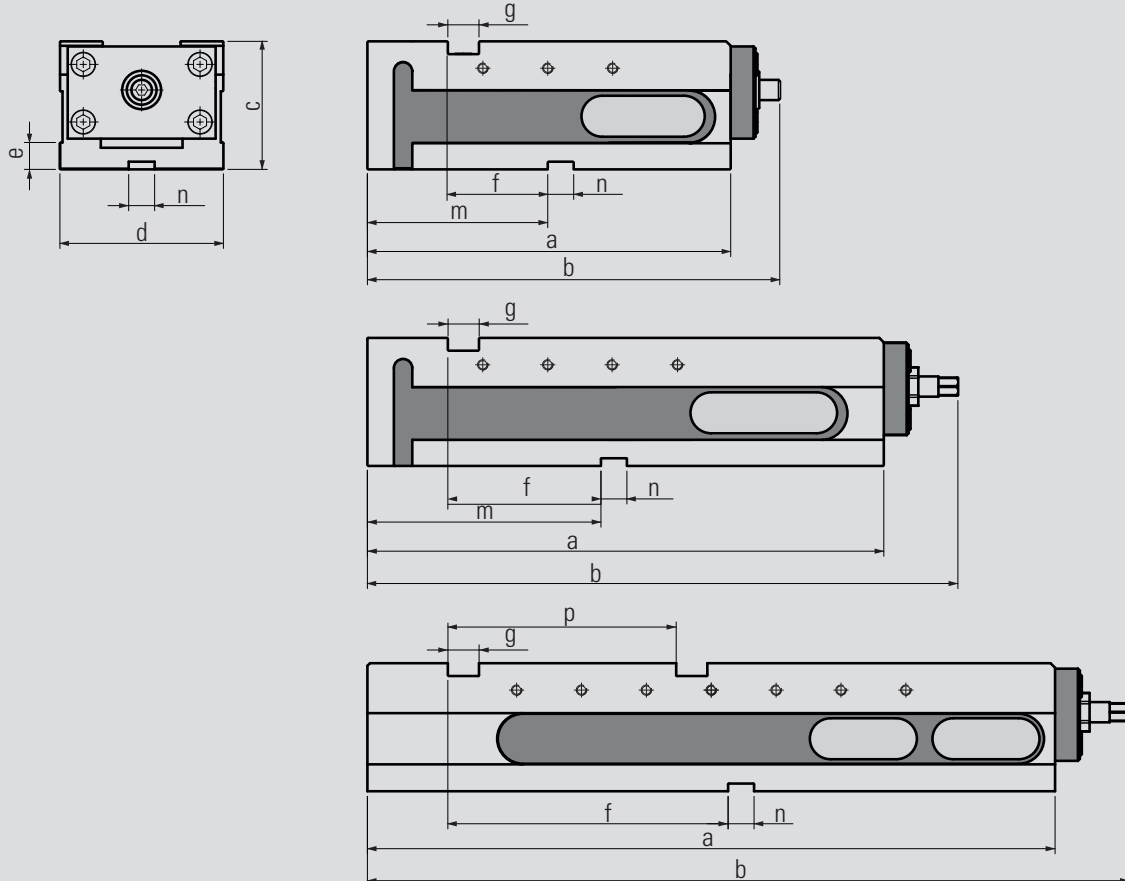
**TITAN 2 L: 6921838000055**

## Scope of supply:

- 1 high-pressure vice without jaws
- 1 set of side clamps
- 3 socket screw wrenches
- Hexagonal insert for torque wrench 3/8"

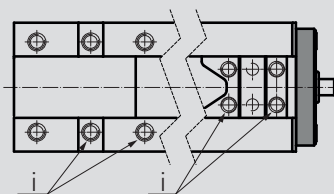
## Please order the clamping jaws separately.

An overview of the clamping jaws and other accessories is given on the following pages.



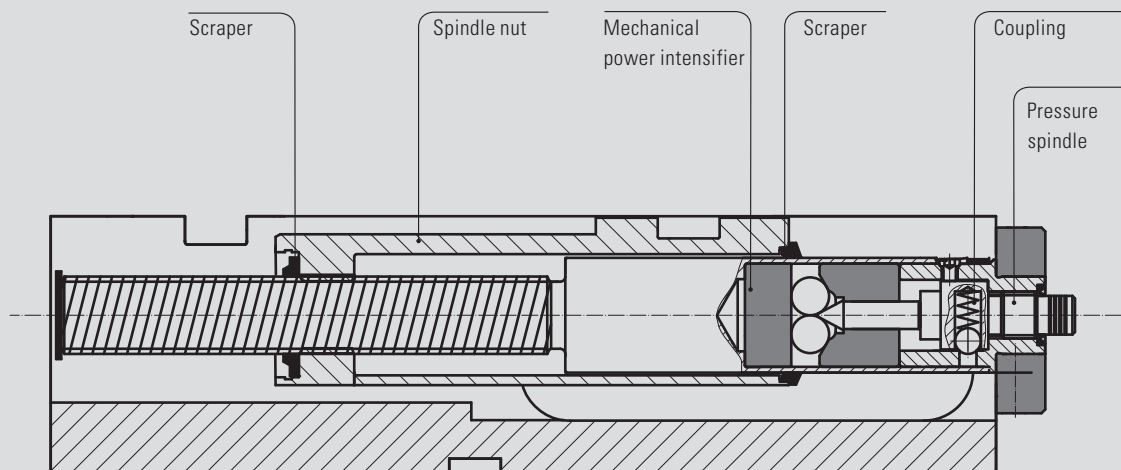
### Technical data

TITAN 2	K	M	L	
<b>Jaw width</b>	<b>125</b>			
Dimensions / tolerances in mm	a	280	398	530
	b	318	455	587
	c	100	100	100
	d	126	126	126
	e	21	21	21
	f	77	118	216
	g	24	24	24
	m	139	180	-
	i	M 12	M12	M12
	n	20	20	20
	p	-	-	176



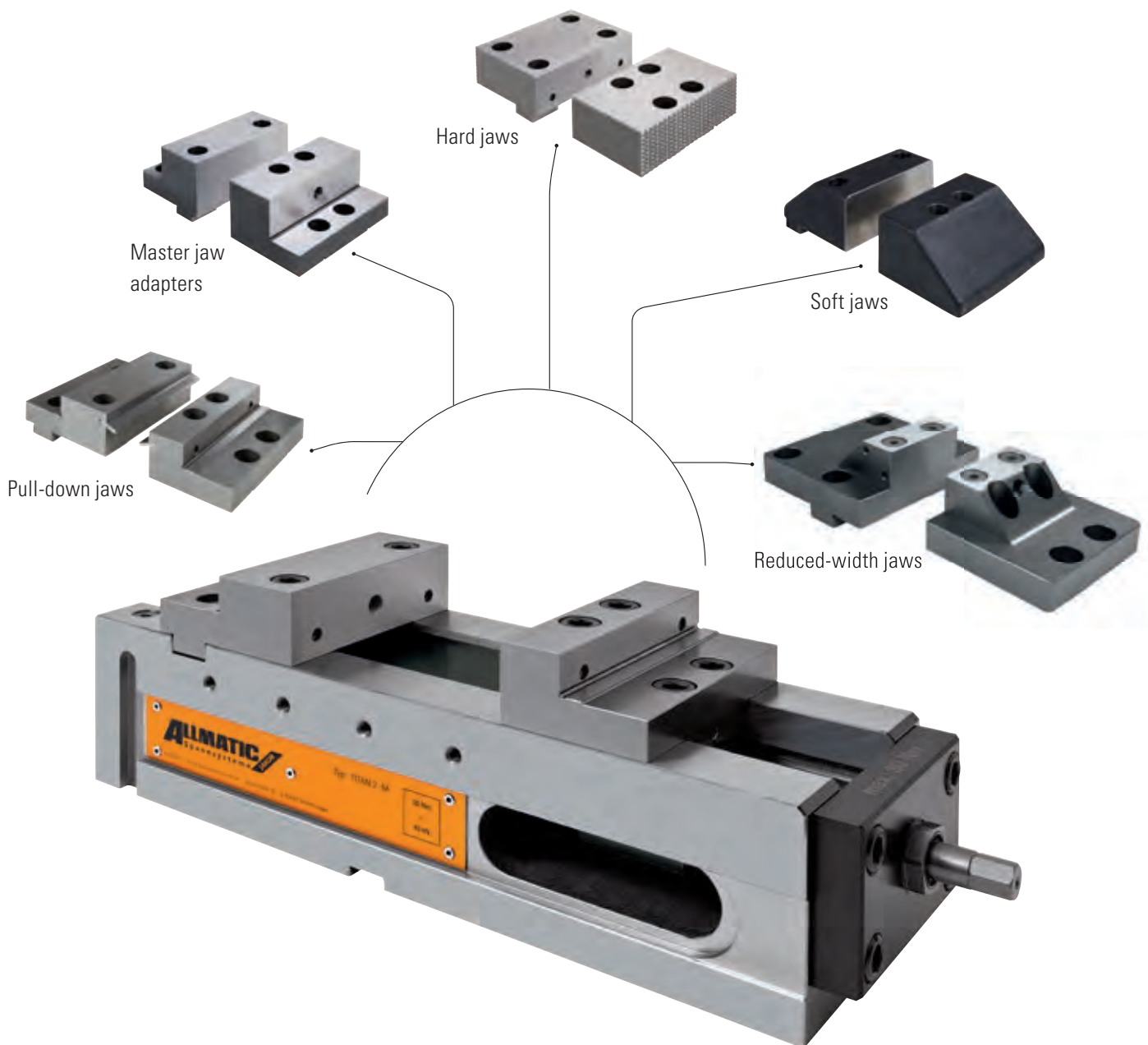
Jaw width	125
Max. torque in Nm	30
Max. clamping force in kN	40
Weight in kg TITAN 2 K	22
Weight in kg TITAN 2 M	30
Weight in kg TITAN 2 L	38

### Spindle cross-section



# TITAN 2 K/M/L

## CONVENTIONAL CLAMPING



### For conventional clamping of workpieces

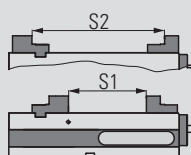
On the following pages you will find a wide range of jaws suitable for clamping pre-machined workpieces.

## ALLMATIC GRIPP – mechanical / version TITAN 2 (conventional clamping accessories)

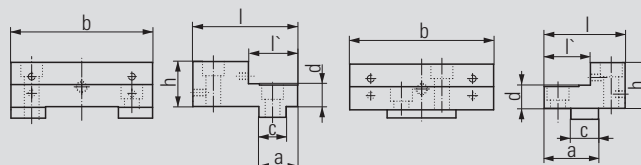
### Step jaws



- Material: hardened steel
- High and stepped sides with thread for parallels
- Ground clamping surfaces
- Additional thread on the high side for mounting the HD jaws
- Click system on the high side



Order no. fixed: 6921684006731 Order no. movable: 6921484002731



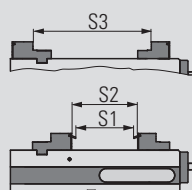
Jaw width		125	Jaw width		125
Dimen- sions in mm	a	34	Dimen- sions in mm	a	47
	b	124,4		b	124,4
	c	24		c	24
	d	20		d	20
	h	39,5		h	39,5
	l	92		l	70
	l'	43		l'	40

	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	0 – 64	0 – 182	0 – 314
Clamping width S2	83 – 195	131 – 313	87 – 445

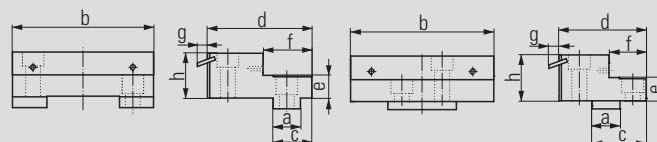
### Pull-down jaws



- Material: hardened steel
- Pull-down with ground spring leaves for unmachined and machined clamping surfaces
- Ground clamping surfaces
- High clamping precision for parallel or precise-angle machining
- Click system on the high side



Order no. fixed: 6921684106031 Order no. movable: 6921684102031



Jaw width		125	Jaw width		125
Dimen- sions in mm	a	24	Dimen- sions in mm	a	24
	b	124,4		b	124,4
	c	34		c	46,5
	d	92		d	75
	e	20		e	20
	f	43		f	32
	g	8,8		g	8,8
	h	39,5		h	39,5

	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	0 – 41	0 – 159	0 – 291
Clamping width S2	0 – 58	0 – 176	0 – 308
Clamping width S3	75 – 187	124 – 305	80 – 437

### Spring leaves (pair)



Order no. 6921684103031

- Hardened spring leaves
- Spring leaves (replacement) for the pull-down jaws  
Order no.: 6921684106031 and 6921684102031

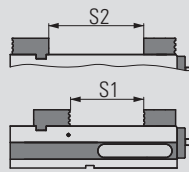


**ALLMATIC GRIPP – mechanical / version TITAN 2 (conventional clamping accessories)**

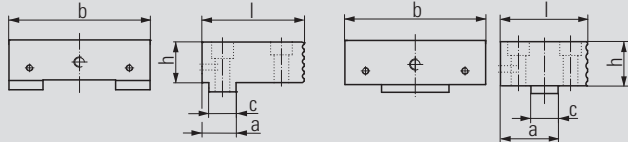
**Hard base jaws**



- Material: hardened steel
- One side smooth and ground, one side serrated
- Additional thread for parallels and for mounting the HD jaws on the smooth side
- Mountings for click system on both sides of the jaw



Order no. fixed: 6921684005731 Order no. movable: 6921684004731



Jaw width		125	Jaw width		125
Dimen- sions in mm	a	30	Dimen- sions in mm	a	50
	b	124.4		b	124.4
	c	24		c	24
	h	39.5		h	39.5
	l	88		l	76

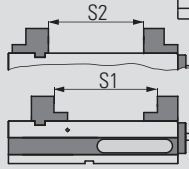
	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	0 – 61	0 – 179	0 – 311
Clamping width S2	0 – 113	49 – 231	5 – 363

**Master jaw adapters**

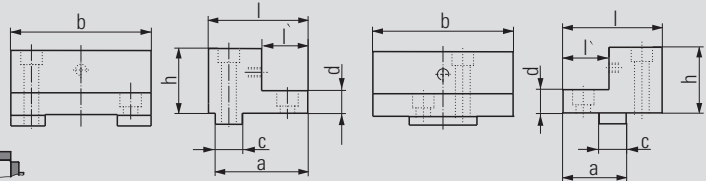


- Material: steel
- High side of the jaw hardened
- Additional thread for mounting the HD jaws

- Ground clamping surfaces
- Click system on the high side



Order no. fixed: 6921684012231 Order no. movable: 6921284011231



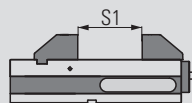
Jaw width		125	Jaw width		125
Dimen- sions in mm	a	77	Dimen- sions in mm	a	52
	b	126		b	126
	c	24		c	24
	d	20		d	20
	h	58		h	58
	l	85		l	80
	l'	32		l'	32

	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	64 – 128	64 – 246	64 – 378
Clamping width S2	0 – 109	45 – 227	0 – 359

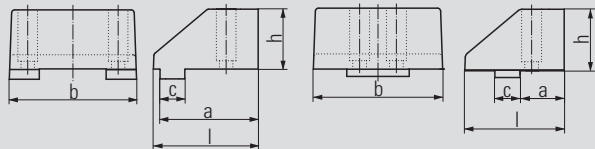
**Soft jaws**



- Material: GGG40 SG iron
- For self-made special jaws
- Chamfer provides very good accessibility to the workpiece



Order no. fixed: 6921684088031 Order no. movable: 6921484087031

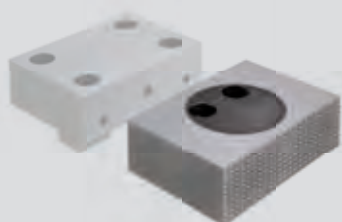


Jaw width		125	Jaw width		125
Dimen- sions in mm	a	95	Dimen- sions in mm	a	42
	b	124		b	124
	c	24		c	24
	h	58		h	58
	l	101.5		l	94.5

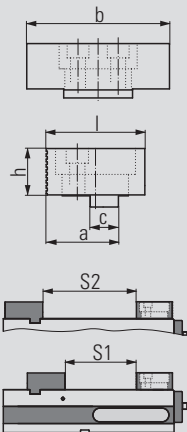
	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	0 – 32	0 – 150	0 – 282

## ALLMATIC GRIPP – mechanical / version TITAN 2 (conventional clamping accessories)

### Pivot jaw, movable



- Material: Hardened steel
- With click system
- One side smooth and ground, one side serrated
- 360° rotatable
- Picture with hard base jaw (see order no.: 6921684005731)



Order no. 6921684020042

Jaw width		125
Dimensions in mm	a	62
	b	124,4
	c	24
	h	39,5
	l	84

	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	0 – 49	0 – 167	0 – 299
Clamping width S2	0 – 101	37 – 219	0 – 351

### Soft jaw

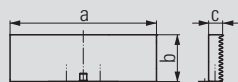


- Material: case-hardened steel 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Only for use with jaws with Click system

Order no. 6921684023042

Jaw width		125
Dimensions in mm	a	125
	b	39,8
	c	22

### Jaw with cross grooving



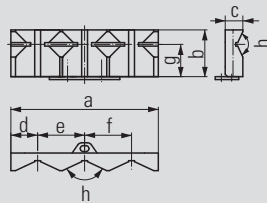
- Material: hardened steel
- Jaws with sharp serrations to increase the specific contact pressure per unit area
- Visible impressions on workpiece
- Only suitable for soft materials
- Only for use with jaws with Click system

Order no. 6921684032040

Jaw width		125
Dimensions in mm	a	125,6
	b	40,1
	c	12

## ALLMATIC GRIPP – mechanical / version TITAN 2 (conventional clamping accessories)

### Prismatic jaws (pair)

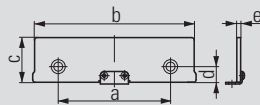


- Material: hardened steel
- Jaws for clamping round parts, vertical dia. 16-74 mm, horizontal dia. 12-40 mm
- Only for use with jaws with Click system

Order no. 6921684024042

Jaw width		125
Dimensions in mm	a	125,6
	b	39,8
	c	15
	d	22,8
	e	40
	f	40
	g	27,5
	h	130°

### Click parallels (pair)



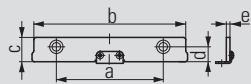
- For parallel raising of workpieces
- Hardened and ground parallels

Order no. 6921185035042

Jaw width		125
Dimensions in mm	a	88
	b	125
	c -0,01	35
	d	12,25
	e	3

- Parallels with click system or screw-on
- For the high side of the jaws

### Click parallels (pair)



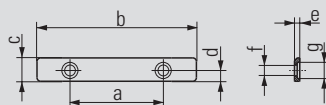
- For parallel raising of workpieces
- Hardened and ground parallels

Order no. 6921185020042

Jaw width		125
Dimensions in mm	a	88
	b	125
	c -0,01	20
	d	12,25
	e	3

- Parallels with click system or screw-on
- For the high side of the jaws

### Parallels (pair)



- For parallel raising of workpieces
- Hardened and ground parallels
- Parallels for screwing on
- For the stepped side of the jaws

Order no. 6921485015031

Jaw width		125
Dimensions in mm	a	88
	b	124
	c	15
	d	6
	e	3
	f	∅ 6
	g	∅ 9

## ALLMATIC GRIPP – mechanical /version TITAN 2 (conventional clamping accessories)

### Smooth jaws (pair)

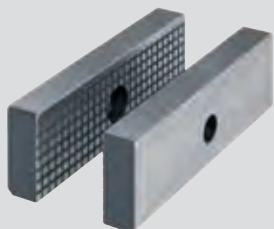


Order no. 6921024022031

Jaw width	125	
Dimensions in mm	a	125
	b	40
	c	15

- Material: hardened steel
- For parts with delicate clamping surfaces
- Please order fastening bolts separately (order no. 6921011023000)

### Serrated jaws (pair)



Order no. 6921021005031

Jaw width	125	
Dimensions in mm	a	125
	b	40
	c	15

- Material: hardened steel
- Standard jaws with small surface area
- To increase the specific contact pressure
- Please order fastening bolts separately (order no. 6921011023000)

### Soft jaws (pair)

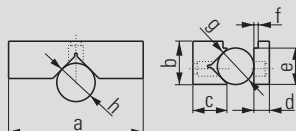
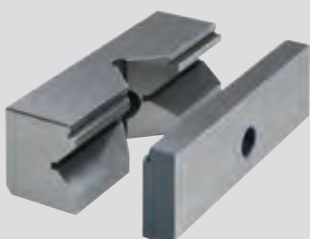


Order no. 6921024023031

Jaw width	125	
Dimensions in mm	a	125
	b	40
	c	25

- Material: 21MnCr5G, type 1.23162 steel
- Jaws of case-hardening steel
- For self-made special jaws
- Please order fastening bolts separately (order no. 6921011023000)

### Prismatic jaws (set)



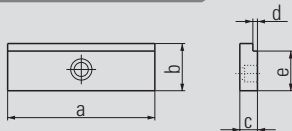
Order no. 6921024024031

Jaw width	125	
Dimensions in mm	a	125
	b	40
	c	35
	d	15
	e	35
	f	3
	g	Ø 12 – 28
	h	Ø 18 – 55

- Material: hardened steel
- For horizontal and vertical clamping of round and flat workpieces
- Please order fastening bolts separately (Order no.: 6921011023000)

## ALLMATIC GRIPP – mechanical / version TITAN 2 (conventional clamping accessories)

### Step jaws (pair)



Order no. 6921024025031

Jaw width		125
Dimensions in mm	a	125
	b	40
	c	15
	d	3
	e	35

- Material: hardened steel
- For horizontal clamping of flat workpieces
- Please order fastening bolts separately (order no.: 6921011023000)

### Roller pull-down jaws (pair)

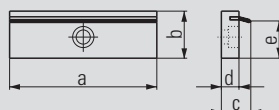


Order no. 6921024005131

Jaw width		125
Dimensions in mm	a	125
	b	40
	c	26
	d	35

- Material: hardened steel
- For parts with delicate clamping surfaces
- Jaw parts in contact with the workpiece press the workpiece onto the support surface
- Please order fastening bolts separately (order no.: 6921011023000)

### Spring leaf pull-down jaws (pair)



Order no. 6921024001042

Jaw width		125
Dimensions in mm	a	125
	b	40
	c	20
	d	12
	e	33

- Material: hardened steel
- For parts with rough clamping surfaces
- Spring leaves press the workpiece onto the support surface
- Spring leaves are replaceable (see below)
- Please order fastening bolts separately (order no.: 6921011023000)

### Spring leaves (pair)



Order no. 6921024002131

- Spring leaves (replacement) for the spring leaf pull-down jaws (see above)

### Jaw fixing screw



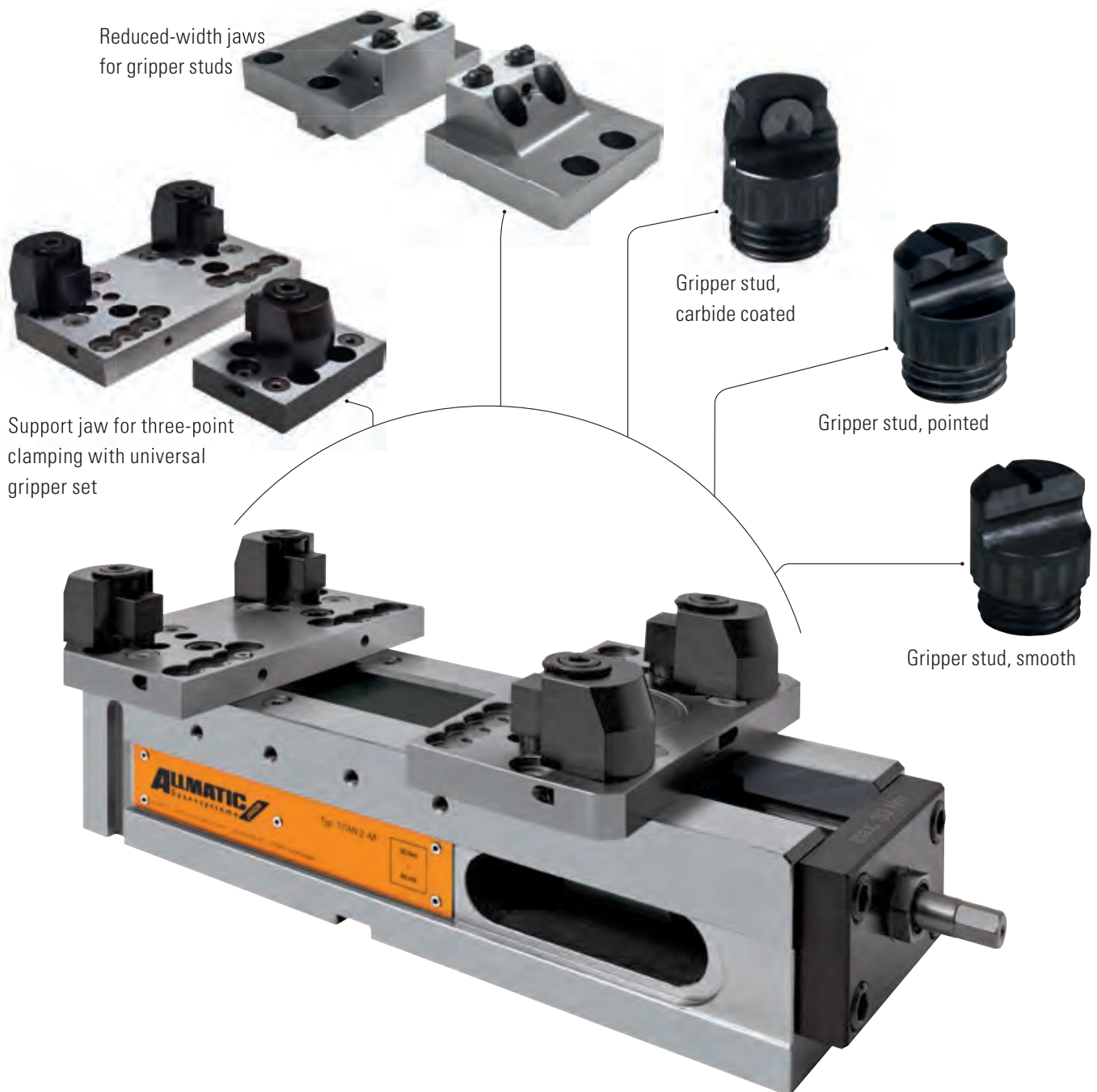
Order no. 6921011023000

- Bolt with shoulder – M10 x 23
- Suitable for all jaws in the 090, 100, 125 and 160 mm series

## **ALLMATIC GRIPP – mechanical / version TITAN 2 (conventional clamping accessories)**

# TITAN 2 K/M/L

## GRIPP CLAMPING



Reduced-width jaws  
for gripper studs

Support jaw for three-point  
clamping with universal  
gripper set

Gripper stud,  
carbide coated

Gripper stud, pointed

Gripper stud, smooth

### For clamping complex unmachined parts

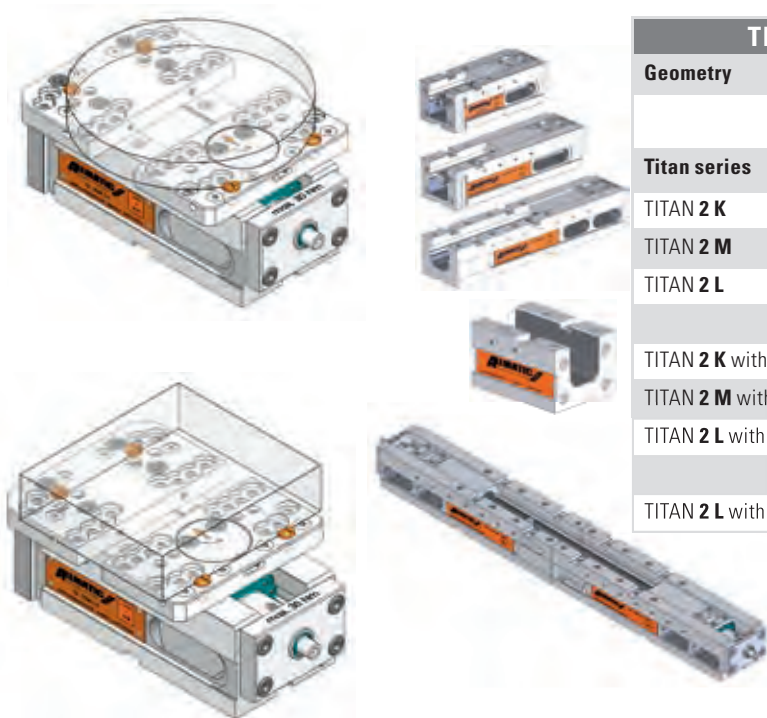
The support jaws enable you to clamp different unmachined parts quickly and securely. You will find jaws for gripper clamping on the following pages.

### GRIPP clamping

- Support jaws are used to mount different gripper studs (threaded gripper studs or universal gripper set)
- Gripper studs can be screwed in various positions on the grid plate in order to clamp various workpiece geometries securely
- Additional pivot function of the support jaws compensates for non-parallel clamping surfaces and is required to clamp uneven workpieces
- Three-point clamping is possible due to the rigid support jaw

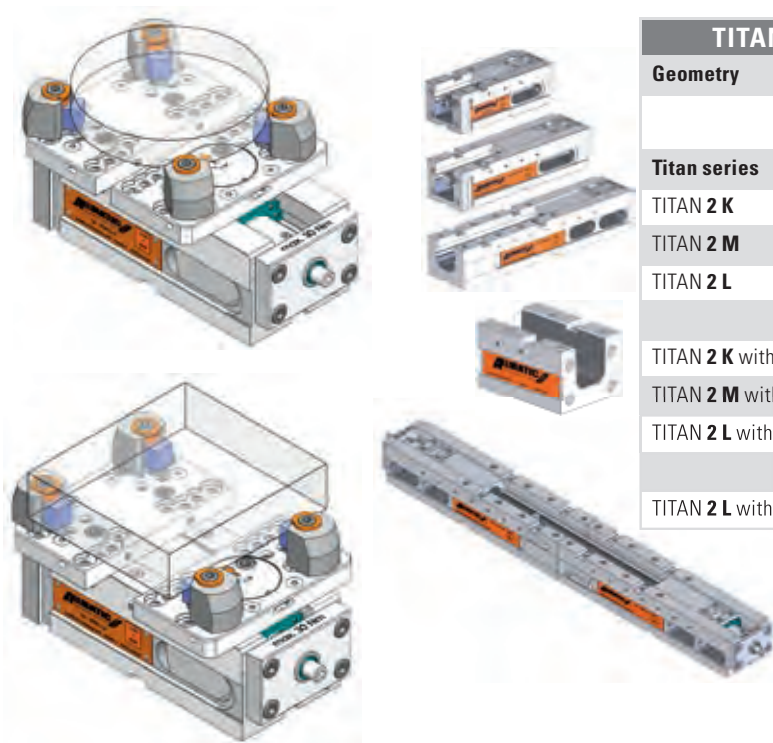
# CLAMPING WIDTHS – GRIPP CLAMPING

## Support jaws with gripper studs



TITAN 2 – Support jaws with gripper studs					
Geometry	Rectangular workpiece		Round workpiece		
	Clamping range (in mm)		Clamping width (in mm)	Clamping range (in mm)	
Titan series	min.	max.	min.	min.	max.
TITAN 2 K	29	204	70	dia. 70	dia. 240
TITAN 2 M	29	322	70	dia. 70	dia. 330
TITAN 2 L	29	454	70	dia. 70	dia. 330
TITAN 2 K with extension	-	419	70	-	dia. 330
TITAN 2 M with extension	-	501	70	-	dia. 330
TITAN 2 L with extension	-	633	70	-	dia. 330
TITAN 2 L with 2 <sup>nd</sup> vice base	-	1039	70	-	-

## Support jaws with universal gripper set



TITAN 2 – Support jaw with universal gripper set					
Geometry	Square workpiece		Round workpiece		
	Clamping range (in mm)		Clamping width (in mm)	Clamping range (in mm)	
Titan series	min.	max.	min.	min.	max.
TITAN 2 K	25	194	88	dia. 70	dia. 230
TITAN 2 M	25	312	88	dia. 70	dia. 330
TITAN 2 L	25	444	88	dia. 70	dia. 330
TITAN 2 K with extension	-	373	88	-	dia. 330
TITAN 2 M with extension	-	491	88	-	dia. 330
TITAN 2 L with extension	-	623	88	-	dia. 330
TITAN 2 L with 2 <sup>nd</sup> vice base	-	978	88	-	-



## ALLMATIC GRIPP – mechanical / version TITAN 2 (GRIPP clamping accessories)

### Support jaws



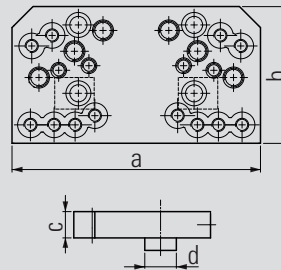
- Material: hardened steel
- For mounting various pull-down wedge elements, universal gripper set and gripper studs (pointed/smooth)
- Front surface can be used as clamping surface (hardened and ground)

**Pivot jaw:**

- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- Supplied **without** wedge elements, gripper set and gripper studs (pointed/smooth)

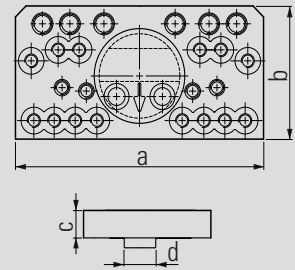
**You will find dimensions of the individual gripper items and the gripper studs at [www.allmatic.de](http://www.allmatic.de)**

**Order no. fixed:**  
6921734005842



Jaw width		125
Dimensions in mm	a	189
	b	104
	c	20
	d	24

**Order no. movable, pivoting:**  
6921734072842



Jaw width		125
Dimensions in mm	a	189
	b	97
	c	20
	d	24



**Please order universal gripper set or gripper studs separately**

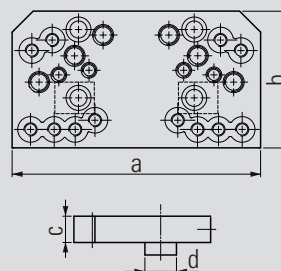
### Support jaws



- Material: hardened steel
- For mounting various studs (pointed/smooth) or a universal gripper set
- For three-point clamping
- Front surface can be used as clamping surface (hardened and ground)
- Supplied **without** studs (pointed/smooth) or gripper set

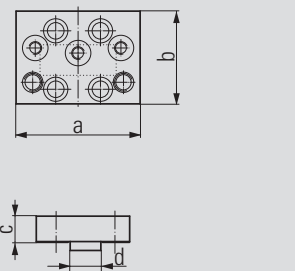
**You will find dimensions of the individual gripper items and the gripper studs at [www.allmatic.de](http://www.allmatic.de)**

**Order no. fixed:**  
6921734005842



Jaw width		125
Dimensions in mm	a	189
	b	104
	c	20
	d	24

**Order no. movable, rigid:**  
6921884004842



Jaw width		125
Dimensions in mm	a	97
	b	73
	c	20
	d	24



**Please order universal gripper set or gripper studs separately**

**ALLMATIC GRIPP – mechanical / version TITAN 2 (GRIPP clamping accessories)**

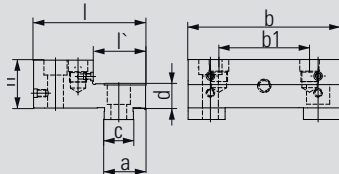
**Step jaws for gripper studs**



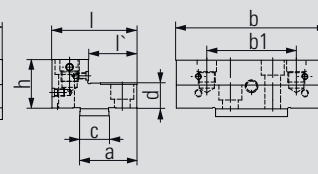
- Material: Hardened steel
- High and stepped sides with thread for parallels
- Ground clamping surfaces
- Additional thread on the high side for mounting the HD jaws (Typ 125 – 200)
- Suitable for screw-in gripper studs
- First and second clamping steps are possible without changing jaws
- Click system on the high side

Note: The movable jaw has no pendulum compensation. It is suitable for rectangular workpieces (saw cuts) / /  $\leq 0.5$  (concurrency less than or equal to 0.5 mm) or cylindrical workpieces  $O \leq 0.5$  (roundness less than or equal to 0.5 mm)

Order no. fixed:  
6921884051031



Order no. movable :  
6921884050031

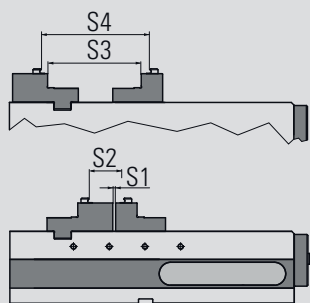


Jaw width	125
Dimensions in mm	
a	34
b	124,4
b1	74
c	24
d	20
h	39,5
l	92
l'	43

Jaw width	125
Dimensions in mm	
a	47
b	124,4
b1	74
c	24
d	20
h	39,5
l	70
l'	40



Please order gripper studs separately

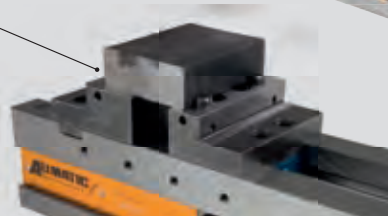


	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	0 – 64	0 – 182	0 – 314
Clamping width S2	49 - 108,5	49 - 226	49 - 358
Clamping width S2 round workpiece	Ø 88-220	Ø 88-220	Ø 88-220
Clamping width S3	83 - 195	131 - 313	87 - 445
Clamping width S3 * with enlargement	174 - 287	228 - 405	360 - 537
Clamping width S4	108,5 - 216	157 - 334	113 - 466
Clamping width S4 * with enlargement	282 - 395	336 - 513	442 - 624

\* Clamping width enlargement: 6921685008055



clamping unmachined parts round



clamping unmachined parts quadratic



clamping pre-machined workpieces

No retooling necessary!  
Set-up times will be reduced

## ALLMATIC GRIPP – mechanical / version TITAN 2 (GRIPP clamping accessories)

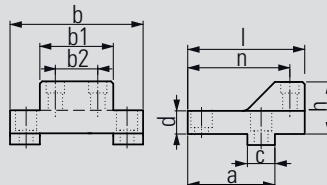
### Reduced-width jaws for gripper studs



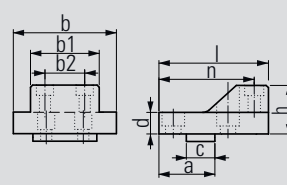
- Material: hardened steel
- Allows unhindered access to the workpiece, even with short tools
- For clamping small to medium-sized workpieces
- Suitable for screw-in gripper studs
- First and second clamping steps are possible without changing jaws
- Click system on the high side

Note: The movable jaw has no pendulum compensation. It is suitable for rectangular workpieces (saw cuts)  $l / l \leq 0.5$  (concurrency less than or equal to 0.5 mm) or cylindrical workpieces  $O \leq 0.5$  (roundness less than or equal to 0.5 mm)

Order no. fixed:  
6921834040140



Order no. movable:  
6921834040040



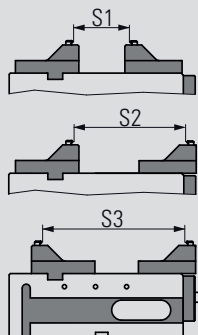
Jaw width	125	
Dimensions in mm	a	76
	b	116
	b1	64
	b2	37
	c	24
	d	20
	h	45
	l	102
n	89	

Jaw width	125	
Dimensions in mm	a	47
	b	96
	b1	64
	b2	37
	c	24
	d	20
	h	45
	l	92
n	80	

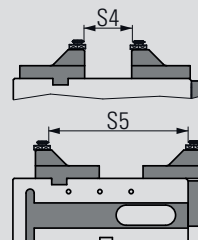


Please order gripper studs separately

\* Clamping width enlargement:  
6921685008055



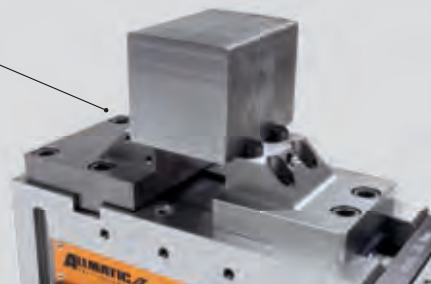
	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	23 - 92	31 - 210	23 - 342
S1 <b>with enlargement*</b>	158 - 271	212 - 389	344 - 521
Clamping width S2	91 - 182	123 - 300	91 - 432
Clamping width S3	167 - 232	173 - 350	167 - 482
S3 <b>with enlargement*</b>	298 - 411	352 - 529	484 - 661
Clamping width S4	15 - 85	25 - 203	15 - 335
Clamping width S5	159 - 225	165 - 343	159 - 475



No retooling necessary!  
For optimal accessibility also with short tools!



clamping unmachined parts round



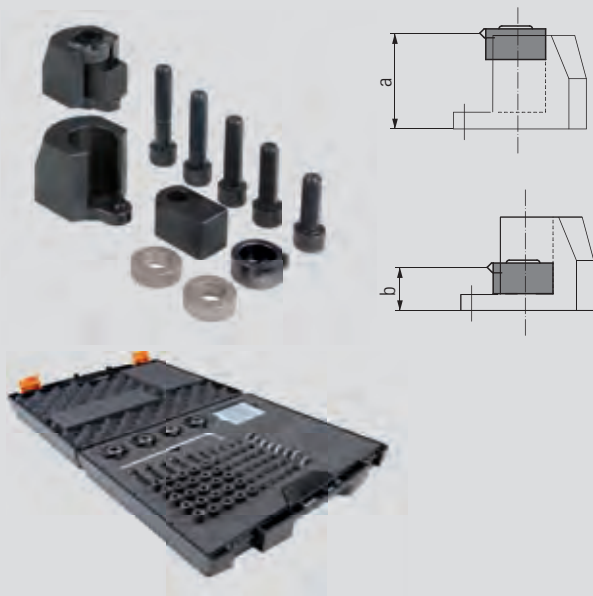
clamping unmachined parts quadric



clamping pre-machined workpieces

## ALLMATIC GRIPP – mechanical / version TITAN 2 (GRIPP clamping accessories)

### Universal gripper set



Order no. 6921884027031

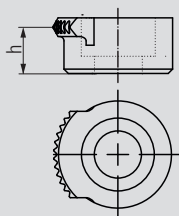
Jaw width		125
Dimensions in mm	a	40
	b	18

- For clamping complex unmachined parts
- By reworking the individual elements of the universal gripper set, both the gripper height and the support height of the workpiece can be varied

Consisting of:

- 4 x gripper studs 6921884026000
- 4 x gripper stud mounting 6921884027000
- 4 x supports 6921884028000
- 8 x shims
- Support bolts
- M10 fastening bolts in various lengths
- M6 threaded rods in various lengths
- Socket screw wrench
- Storage case

### Gripper stud

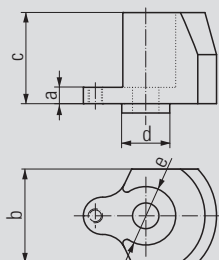


Order no. 6921884026000

Dimensions in mm	h	11
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- Gripper stud for universal gripper set

### Gripper stud mount

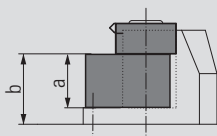
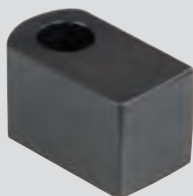


Order no. 6921884027000

Dimensions in mm	a	7
	b	40
	c	39
	d	Ø 20
	e	Ø 25

- Mounting for gripper stud 6921884026000

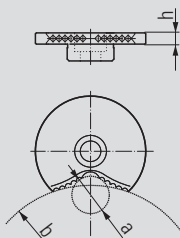
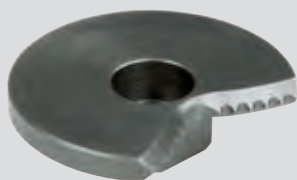
### Support



Order no. 6921884028000

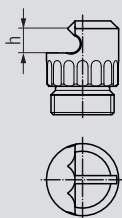
Dimensions in mm	a	22
	b	29

- Support for universal gripper set

**ALLMATIC GRIPP – mechanical / version TITAN 2 (GRIPP clamping accessories)****Prismatic gripper****Order no. 6921884029031**

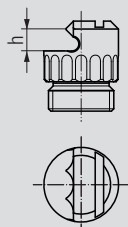
Dimensions in mm	a	dia. 20
	b	dia. 120
	h	6

- Replaces gripper stud 6921884026000 in the universal gripper set
- Special shape distributes the applied clamping force – particularly advantageous for clamping workpieces that require fits to be made

**Gripper stud, pointed****Order no. 6921884036000**

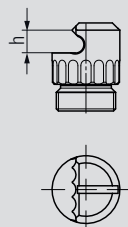
Dimensions in mm	h	5.5
------------------	---	-----

- For clamping unmachined parts
- Least possible lost clamping margin
- Clamping height: adjustable from 4.5 to 6.0 mm

**Gripper stud, low****Order no. 6921884036100**

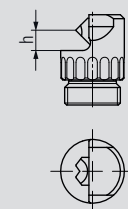
Dimensions in mm	h	5
------------------	---	---

- For clamping unmachined parts
- Least possible lost clamping margin
- Clamping height: adjustable from 3.0 to 4.5 mm

**Clamping insert, four-point****Order no. 6921884036500**

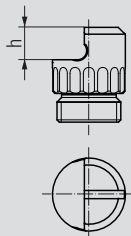
Dimensions in mm	h	5.4
------------------	---	-----

- For clamping unmachined parts
- For soft materials such as aluminium
- Least possible lost clamping margin
- Clamping height approx. 4.5 mm to 6.0 mm

**Gripper stud, carbide coated****Order no. 6921884036841**

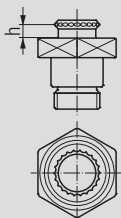
Dimensions in mm	h	5.1
------------------	---	-----

- For clamping unmachined parts
- For quenched and tempered materials and flame-cut materials
- Least possible lost clamping margin, clamping height approx. 4.2 mm to 5.7 mm

**ALLMATIC GRIPP – mechanical / version TITAN 2 (GRIPP clamping accessories)****Clamping insert, smooth****Order no. 6921884037000**

Dimensions in mm	h	7
------------------	---	---

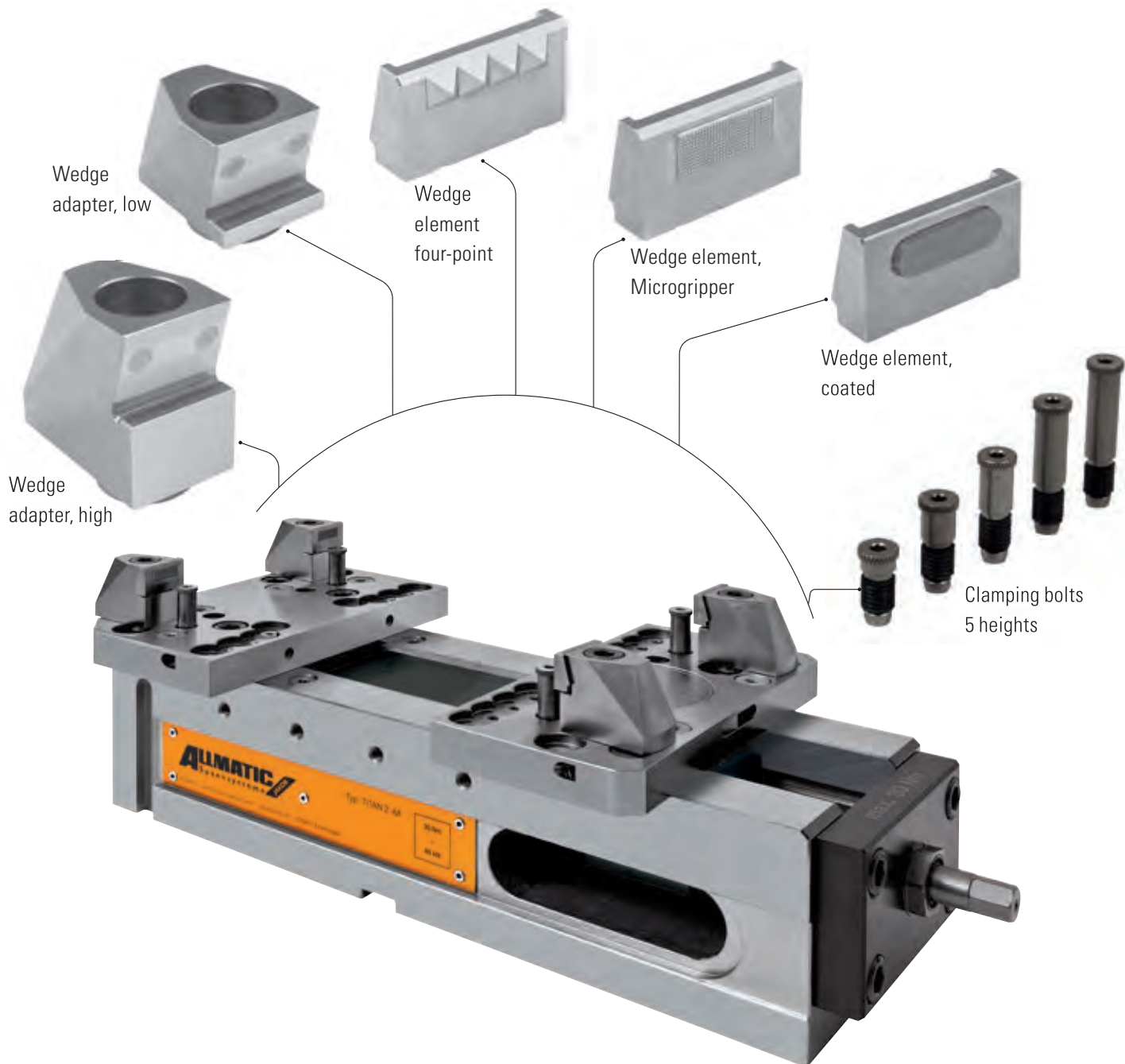
- With carbide coating for clamping pre-machined or hardened workpieces

**Gripper stud, round****Order no. 6921884038000**

Dimensions in mm	h	4
------------------	---	---

- For clamping unmachined parts
- For drilling through close to the edge
- Offers 6 mm clear space under the workpiece

# TITAN 2 K/M/L PULL-DOWN CLAMPING



## Accuracy through pull-down

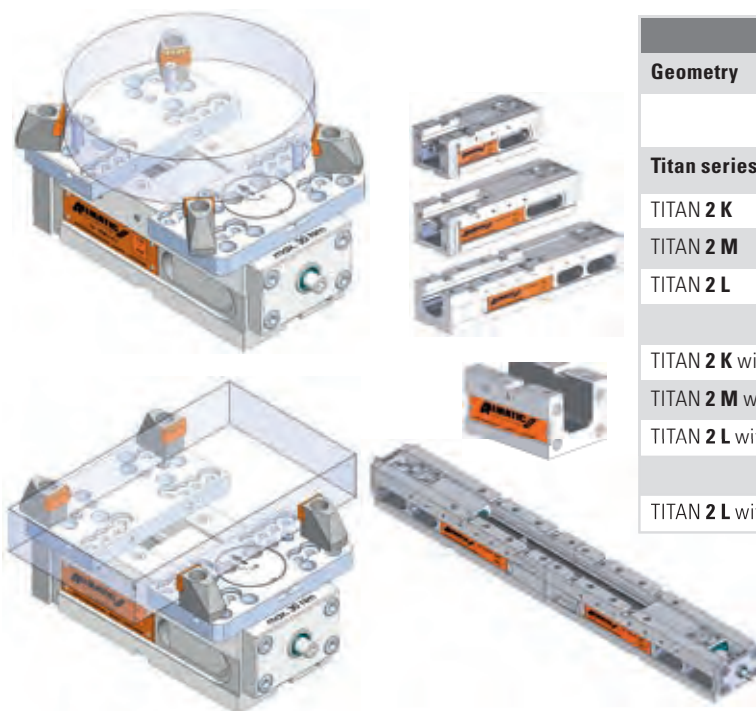
The support jaws and the pull-down system ensure accurate, versatile and secure clamping of the unmachined parts. The workpiece is positioned on ground clamping bolts which make the connection to the guideway. In this way, the parallelism of the guideway or of the machine table is transferred to the workpiece, thus achieving even greater clamping accuracy. Vibrations in the workpiece during machining are to a large extent avoided. The pull-down system can be found on the following pages.

## Pull-down clamping:

- Support jaws are used to mount various wedge adapters and clamping bolts
- Wedge adapters can be bolted in various positions on the grid plate
- The various wedge elements can be changed quickly on the wedge adapters
- Additional pivot function of the support jaws compensates for non-parallel clamping surfaces and is required to clamp uneven workpieces
- Accuracy through pull-down
- Clamping in the neutral filament can be optimised using the 5 different heights of the clamping bolts

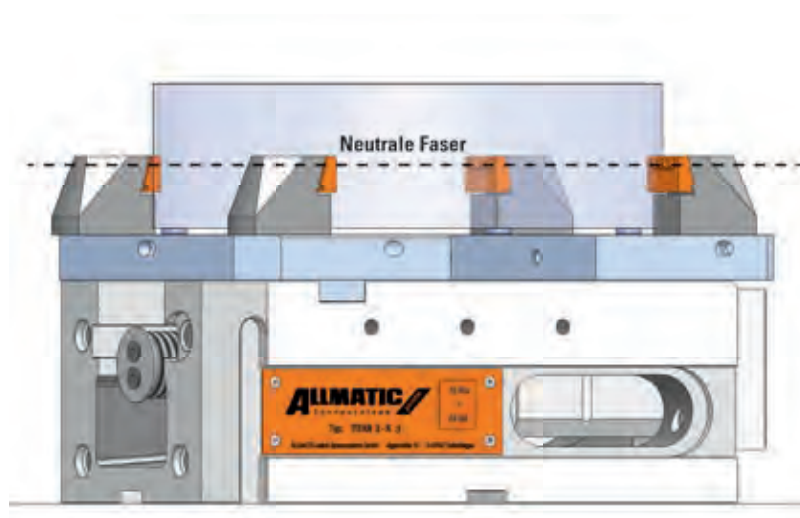
# CLAMPING WIDTHS – PULL-DOWN CLAMPING

## Support jaws with pull-down



TITAN 2 - Support jaws with pull-down					
Geometry	Square workpiece		Round workpiece		
	Clamping range (in mm)		Clamping range (in mm)	Clamping range (in mm)	
Titan series	min.	max.	min.	min.	max.
TITAN 2 K	19	188	96	Ø 65	Ø 226
TITAN 2 M	19	306	96	Ø 65	Ø 330
TITAN 2 L	19	438	96	Ø 65	Ø 330
TITAN 2 K with extension	-	367	96	-	Ø 330
TITAN 2 M with extension	-	485	96	-	Ø 330
TITAN 2 L with extension	-	617	96	-	Ø 330
TITAN 2 L with 2nd vice base	-	972	96	-	-

## Clamping in the neutral filament





## ALLMATIC GRIPP – mechanical / version TITAN 2 (pull-down clamping accessories)

### Support jaws



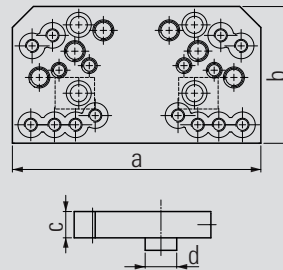
- Material: hardened steel
- For mounting various pull-down wedge elements, universal gripper set and gripper studs with thread (pointed/smooth)
- Front surface can be used as clamping surface (hardened and ground)

#### Pivot jaw:

- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- Supplied **without** clamping elements

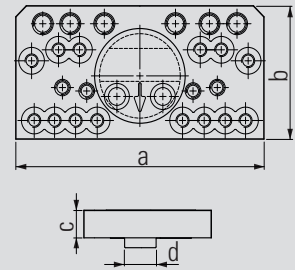
You will find dimensions of the individual gripper items and the gripper studs at [www.allmatic.de](http://www.allmatic.de)

Order no. fixed:  
6921734005842



Jaw width	125	
Dimensions in mm	a	189
	b	104
	c	20
	d	24

Order no. movable, pivoting:  
6921734072842

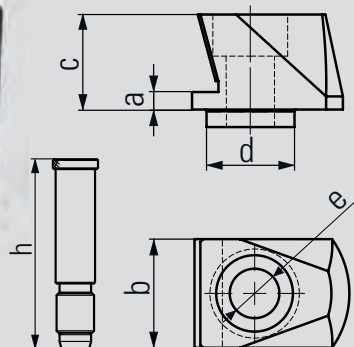


Jaw width	125	
Dimensions in mm	a	189
	b	97
	c	20
	d	24



Please order universal gripper set, pull-down studs, or gripper studs separately

### Pull-down set case, low



Order no. 6921734027031

Jaw width	125	
Dimensions in mm	a	4
	b	24
	c	21.7
	d	dia. 20
	e	dia. 11
	h	23 / 34

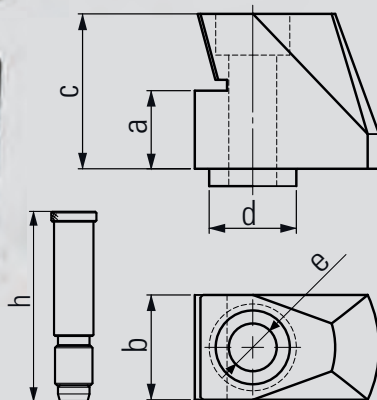
- Pull-down elements suitable for clamping and pulling down clamping surfaces that are unmachined or pre-machined onto the guideway or onto the supplied clamping bolts
- In this way, workpieces can be clamped almost exactly parallel to the guideway for machining
- The direct contact to the clamping bolts largely avoids vibrations in the workpiece

Pull-down set consisting of:

- 1 x foamed case
- 4 x wedge adapter, low
- 4 x bolts, M10 x 30 mm
- 4 x wedge element, 4 point
- 4 x wedge element Microgripper
- 4 x clamping bolts 23 mm
- 4 x clamping bolts 34 mm

## ALLMATIC GRIPP – mechanical / version TITAN 2 (pull-down clamping accessories)

### Pull-down set case, high



Order no. 6921734027131

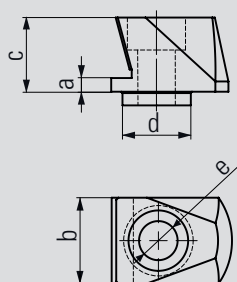
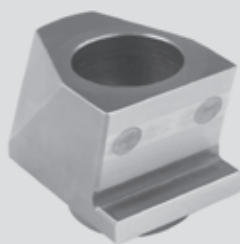
Jaw width		125
Dimensions in mm	a	18
	b	24
	c	35.7
	d	dia. 20
	e	dia. 11
	h	34 / 48

- Pull-down elements suitable for clamping and pulling down clamping surfaces that are unmachined or pre-machined onto the guideway or onto the supplied clamping bolts
- In this way workpieces can be clamped almost exactly parallel to the guideway for machining
- The direct contact to the clamping bolts largely avoids vibrations in the workpiece

Pull-down set consisting of:

- 1 x foamed case
- 4 x wedge adapter, high
- 4 x bolts, M10 x 45 mm
- 4 x wedge element, 4 point
- 4 x wedge element Microgripper
- 4 x clamping bolts 48 mm
- 4 x clamping bolts 34 mm

### Wedge adapter, low

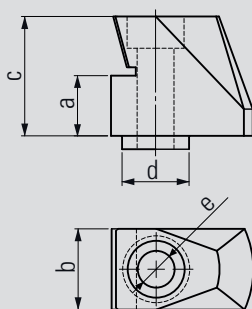
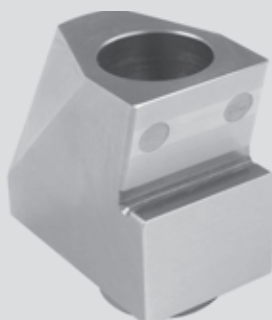


Order no. 6921834027041

Dimensions in mm	a	4
	b	24
	c	21.7
	d	dia. 20
	e	dia. 11

- Wedge adapter, low, for use on support jaws. For mounting the four-point, Microgripper, round and coated wedge elements supplied **without** M10 x 30 mm fastening bolt (see next page)

### Wedge adapter, high



Order no. 6921834027141

Dimensions in mm	a	18
	b	24
	c	35.7
	d	dia. 20
	e	dia. 11

- Wedge adapter, high, for use on support jaws. For mounting the four-point, Microgripper, round and coated wedge elements supplied **without** M10 x 45 mm fastening bolt (see next page)

## ALLMATIC GRIPP – mechanical / version TITAN 2 (pull-down clamping accessories)

### Fastening bolt, low



**Order no. 8006101030050**

- For fastening the wedge adapter, low, on the support jaws
- M 10 X 30 mm

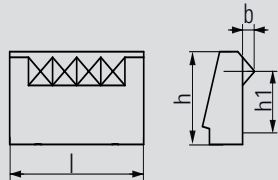
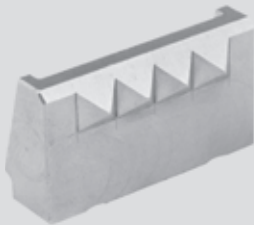
### Fastening bolt, high



**Order no. 8006101045050**

- For fastening the wedge adapter, high, on the support jaws
- M 10 X 45 mm

### Wedge element, four-point

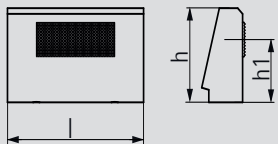
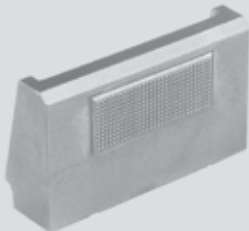


**Order no. 6921834025040**

Dimensions in mm	b	2.4
	h	16.5
	h1	13
	l	27.8

- Wedge elements for various shapes, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm

### Wedge element, Microgripper

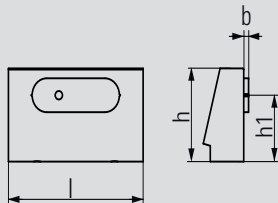


**Order no. 6921834025140**

Dimensions in mm	h	16.5
	h1	11
	l	27.8

- Wedge elements for various shapes, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm

### Wedge element, coated



**Order no. 6921834025240**

Dimensions in mm	b	1
	h	16.5
	h1	11.75
	l	27.8

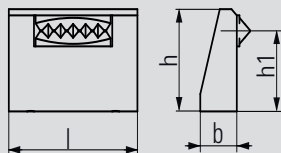
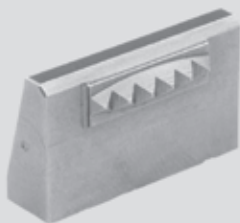
- Wedge elements for pre-machined, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm
- Please order the pads separately (see below)

### Blister-pads, diamond-coated



**Order no. 6921834028141**

- Diamond-coated pads for secure clamping of machined surfaces without a visible impression
- Blister contents: 20 pads

**ALLMATIC GRIPP – mechanical /version TITAN 2 (pull-down clamping accessories)****Wedge element, round****Order no. 6921834026340**

Dimensions in mm		
b	2.4	
h	16.5	
h1	13	
l	27.8	

- Wedge elements for round shapes or radii, irrespective of surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm

**Clamping bolts****6921735048040**

h | 48

**6921735043040**

h | 43

**6921735034040**

h | 34

**6921735029040**

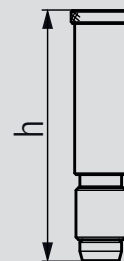
h | 29

**6921735023040**

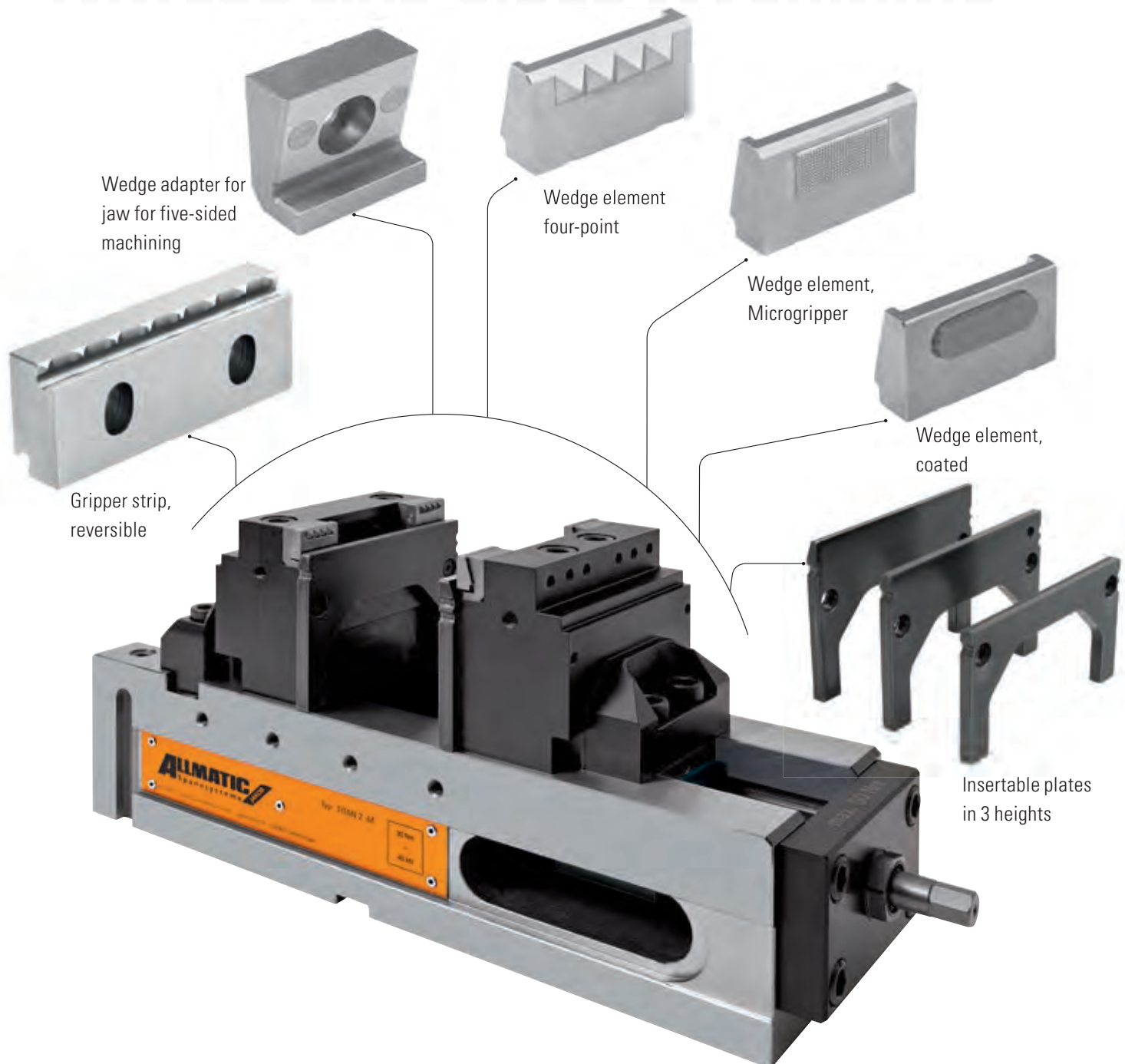
h | 23

**See table for order no.**

- Five support heights
- For levelling the workpiece on the guideway
- Material: hardened steel
- Ground to high accuracy



# TITAN 2 K/M/L JAW FOR FIVE-SIDED MACHINING



## Five-sided machining plus pull-down

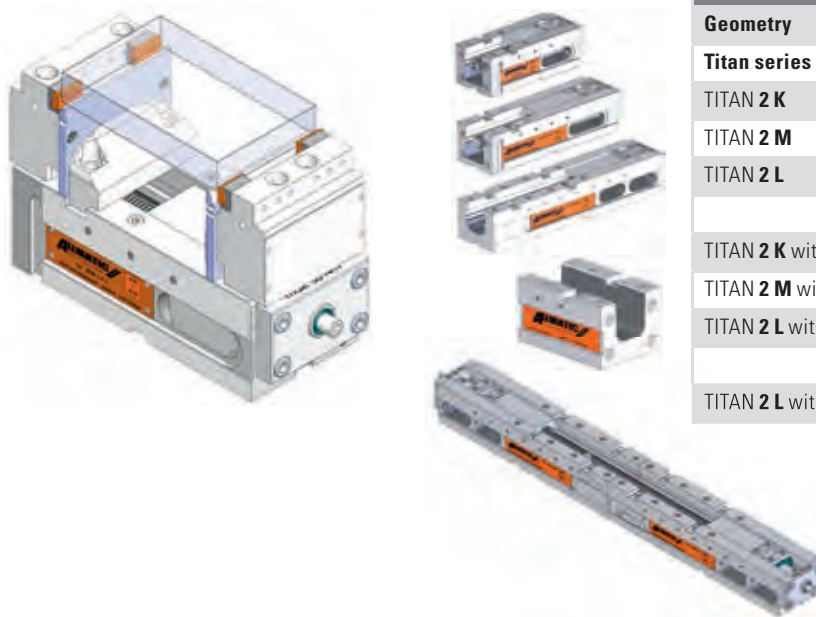
The five-sided machining jaw with pull-down can clamp workpieces up to a height of 90 mm onto the guideway of the TITAN 2. The insertable plates are pressed onto the guideway using the pull-down effect, thus establishing an accurate parallel workpiece position. This largely avoids any vibration of the workpiece during machining. Accessibility with short tools is a particular advantage of the five-sided machining jaw. You will find jaws for five-sided machining on the following pages.

## Clamping for five-sided machining:

- Five-sided machining jaws are used to mount the wedge adapters and the insertable plates
- Wedge adapters can be bolted in various positions on the grid plate
- The various wedge elements can be quickly changed on the wedge adapters
- Suitable for five-sided machining with short tools
- Accuracy through pull-down
- Stability through form-locking
- Clamping in the neutral filament can be optimised using the three support heights of the insertable plates

# CLAMPING WIDTHS – JAW FOR FIVE-SIDED MACHINING

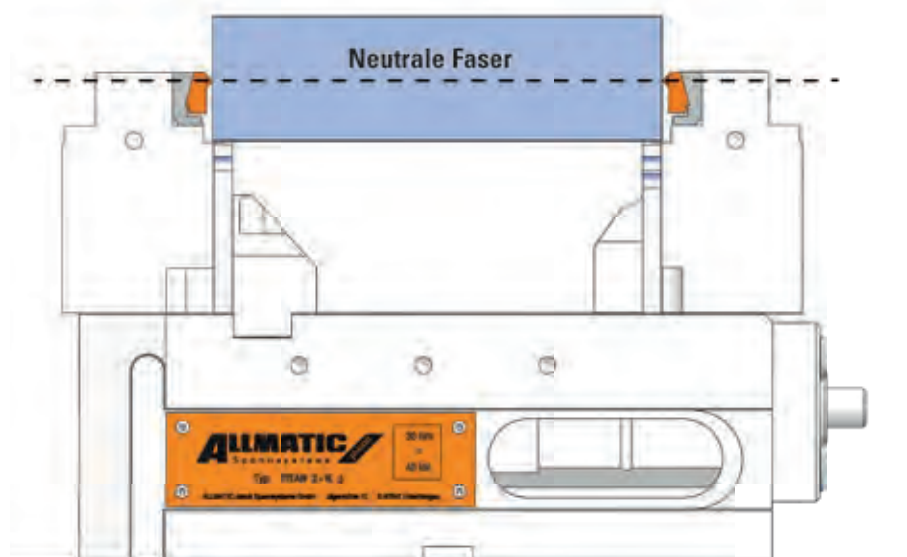
## 90-mm jaw for five-sided machining with pull-down



**TITAN 2 – Jaw for five-sided machining with pull-down**

Titan series	Square workpiece	
	min. [mm]	max. [mm]
TITAN 2 <b>K</b>	16	181
TITAN 2 <b>M</b>	16	299
TITAN 2 <b>L</b>	16	431
TITAN 2 <b>K</b> with extension	-	360
TITAN 2 <b>M</b> with extension	-	478
TITAN 2 <b>L</b> with extension	-	610
TITAN 2 <b>L</b> with 2 <sup>nd</sup> vice base	-	970

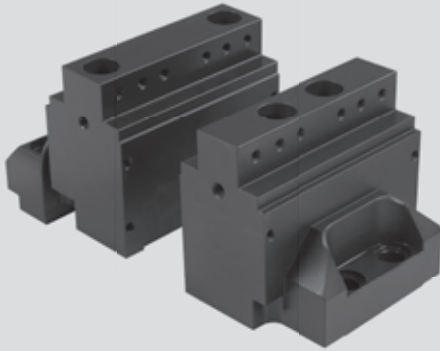
## Clamping in the neutral filament



**ALLMATIC GRIPP – mechanical / version TITAN 2 (five-sided machining jaws)**

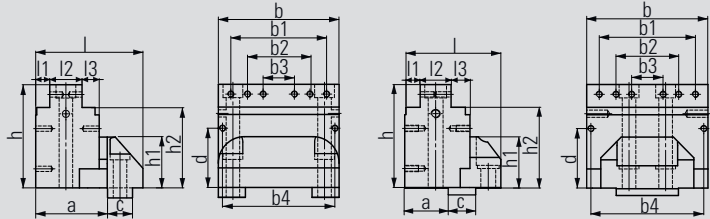
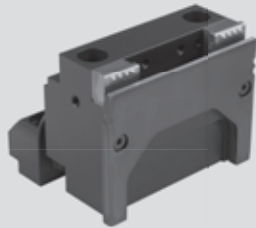
**Jaws for five-sided machining**

Order no. fixed: 6921734047031 Order no. movable: 6921734048031



- Material: plasma-nitrided steel
- Particularly suitable for five-side machining
- Better accessibility for tools
- Ground clamping surfaces
- Additional thread for parallels
- Accuracy through pull-down
- Stability through form-locking

**Please order wedge elements and insertable plates separately**



Jaw width		125
Dimensions in mm	a	69
	b	116
	b1	90
	b2	60
	b3	30
	b4	108
	c	24
	d	56
	h	97.5
	h1	48
	h2	76
	l	103
	l1	13.5
l2	31	
l3	16.5	

Jaw width		125
Dimensions in mm	a	38
	b	116
	b1	92
	b2	60
	b3	30
	b4	108
	c	24
	d	56
	h	97.5
	h1	48
	h2	76
	l	84
	l1	13.5
l2	27	
l3	16.5	

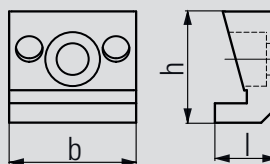
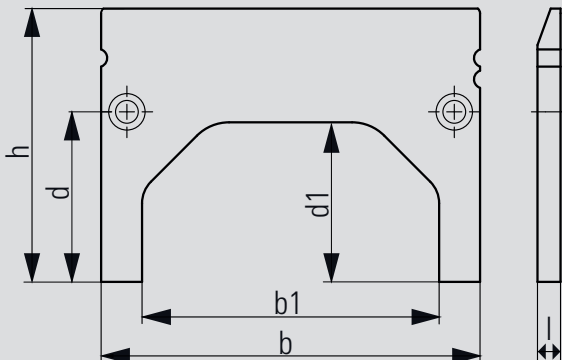
**Case set for five-sided machining jaw**

Order no. 6921734027531



Jaw width 125	Insertable plate	Wedge adapter	
Dimensions in mm	b	125	24.15
	b1	98	-
	d	56	-
	d1	53	-
	h	90	21.45
	l	7.6	11.8

- Pull-down elements suitable for clamping and pulling unmachined clamping surfaces down onto the guideway or onto the 90-mm support plates supplied
- In this way workpieces can be clamped almost exactly parallel to the guideway for machining
- The direct contact to the support plates largely avoids vibrations in the workpiece

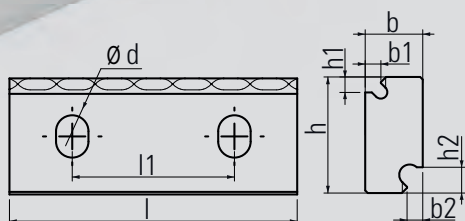


Pull-down set consisting of:

- 1 x foamed case
- 4 x wedge adapters
- 4 x wedge element, four-point
- 4 x wedge element, Microgripper
- 2 x insertable plates (H=90 mm)
- 20 x cheese-head screws M 6 x 8

## ALLMATIC GRIPP – mechanical / version TITAN 2 (five-sided machining jaws)

### Gripper strip, reversible

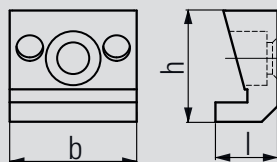
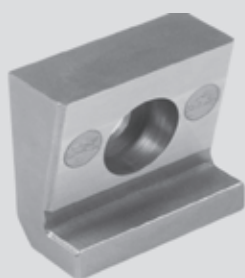


Order no. 6921734036031

Dimensions in mm		
b	11	
b1	3	
b2	3	
d	6.2	
h	22.5	
h1	3	
h2	5	
l	55	
l1	311	

- Gripper strip can be reversed for mounting on the five-sided machining jaw (4 of them are required)
- For clamping unmachined parts close to the edge, 3 or 5 mm
- Incl. 2 bolts M 6 x 16 each

### Wedge adapter for jaw for five-sided machining

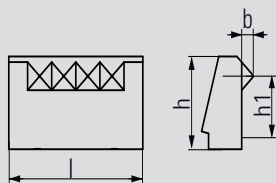


Order no. 6921834027540

Dimensions in mm		
b	24.15	
h	21.45	
l	11.8	

- Wedge adapter for use five-sided machining jaws. For mounting the 4-point, Microgripper, round and coated wedge elements
- Supplied **without** M6 x 8 mm fastening bolt (see next page)

### Wedge element, four-point

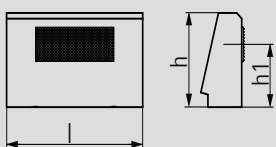
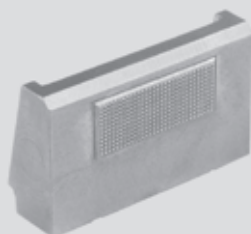


Order no. 6921834025040

Dimensions in mm		
b	2.4	
h	16.5	
h1	13	
l	27.8	

- Wedge elements for various shapes, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm

### Wedge element, Microgripper



Order no. 6921834025140

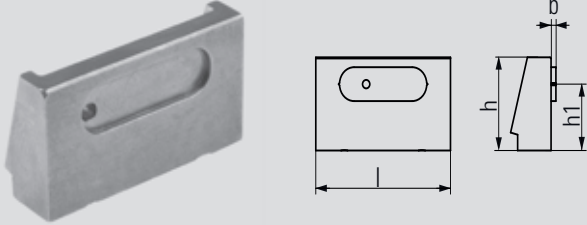
Dimensions in mm		
h	16.5	
h1	11	
l	27.8	

- Wedge elements for various shapes, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm



**ALLMATIC GRIPP – mechanical / version TITAN 2 (five-sided machining jaws)**

**Wedge element, coated**




**Order no. 6921834025240**

Dimensions in mm		b	1
	h	16.5	
	h1	11.75	
	l	27.8	

- Wedge elements for pre-machined, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm
- Please order the pads separately (see below)

**Pads, diamond-coated, in blister pack**



**Order no. 6921834028141**

- Diamond-coated pads for secure clamping of machined surfaces without a visible impression
- Blister contents: 20 pads

**Insertable plates**

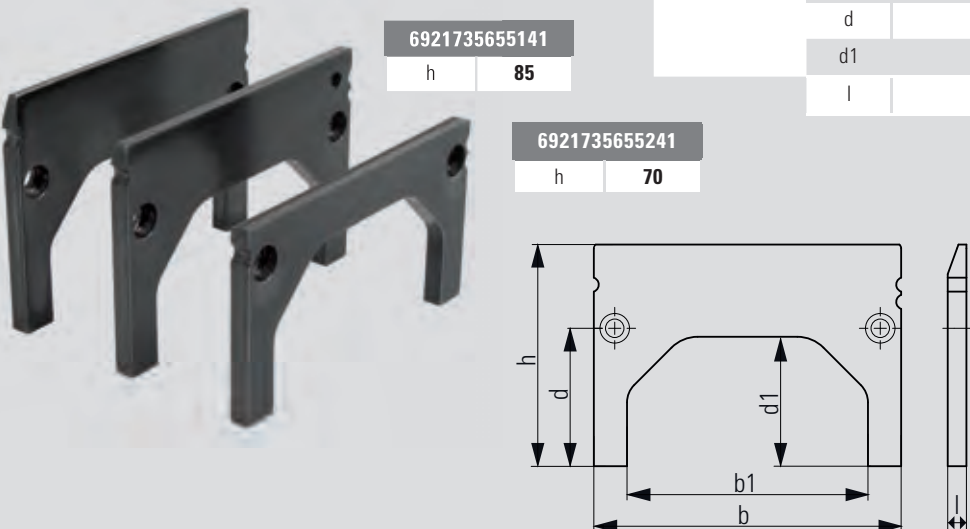
**See table for order nos.**

Insertable plate height	90	85	70
Dimensions in mm	b	125	
	b1	98	
	d	56	
	d1	53	
	l	7.6	

6921735655041  
h 90

6921735655141  
h 85

6921735655241  
h 70



- Three support heights
- For levelling the workpiece on the five-sided machining jaws
- Material: hardened steel
- Ground to high accuracy
- Supplied **without** M6 x 8 mm fastening bolt (see next page)

**Fastening bolt for five-sided machining**

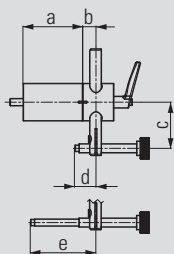


**Order no. 8006300068800**

- For fastening the wedge adapters on the five-sided machining jaws
- For fastening the insertable plates on the five-sided machining jaws
- M 6 x 8 mm

## ALLMATIC GRIPP – mechanical / version TITAN 2 (accessories)

### Workpiece stop

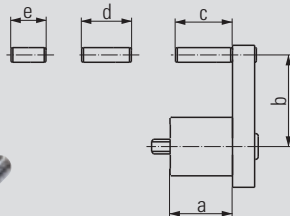


Order no. 6921285650144

Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

- Can be mounted at the positions provided on both sides of the vice
- Fastening thread M8
- Position of the third workpiece access can be preset and clamped. Workpiece stop can be swivelled away once the workpiece has been clamped.
- This allows the stop side of workpiece to be machined as well (repeating accuracy:  $\pm 0.01$ )

### Workpiece stop

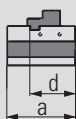


Order no. 6921685670042

Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

- Can be mounted at the positions provided on both sides of the vice
- Fastening thread M8
- Can be pre-mounted with various fixed dimensions
- Presettable position of the third axis of the workpiece

### Clamping width enlargement



Order no. 6921685008055

Jaw width		125
Dimensions in mm	a	176
	d	117

- For increasing the clamping width of the TITAN 2 K & M (optional L)
- Is attached to the end face of the TITAN 2 vice
- Clamping forces are not transmitted to the machine table
- Included: 1 pair of side clamps

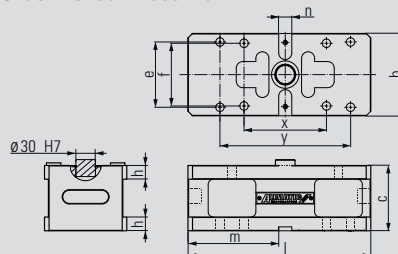
## ALLMATIC GRIPP – mechanical / version TITAN 2 (accessories)

### Console TITAN 2 K



- Material: GG30
- For raising the TITAN 2 K vice
- Improvement of accessibility with five-sided machining
- Scope of supply: console incl. fixing bolt for positioning the vice, 2 socket screw wrenches, 4 screws

Order no. 6921735011042



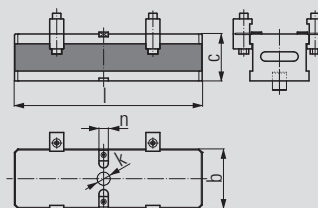
Jaw width	125	
Dimensions in mm	b	126
	c	100
	e	100
	f	96
	h	21
	l	280
	m	139
	n	20 H7
	x	126,2
	y	200

### Console TITAN 2 M



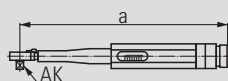
- For TITAN 2 M
- Material: GG30
- For raising the vice
- Improvement of accessibility with five-sided machining
- Optional preparation for zero-point clamping system
- Scope of supply: console incl. fixing bolt for positioning the vice, 4 pairs of Duo side clamps, 2 socket screw wrenches

Order no. 6921885010042



Jaw width	125	
Dimensions in mm	b	126
	c	100
	k	dia. 30
	l	400
	n	20

### Torque wrench



Order no. 0651114113188

Dimensions in mm	a	307
	AK (Drive square)	3/8"

- Adjustable between 10 – 60 Nm
- Only for operating the T-REX, TITAN and DUO Plus 125 high-pressure spindles

**ALLMATIC GRIPP – mechanical / version TITAN 2 (accessories)****Side clamps (pair)****Order no. 6921025000031**

- For fastening the vice to the machine table
- Scope of supply includes 2 items

**DUO side clamps****Order no. 6921285000031**

- For fastening device to a bracket or onto a machine table
- 1 set consists of 2 pairs of side clamps, including screw connections

**Aligning and fixing set****Order no. – see table**

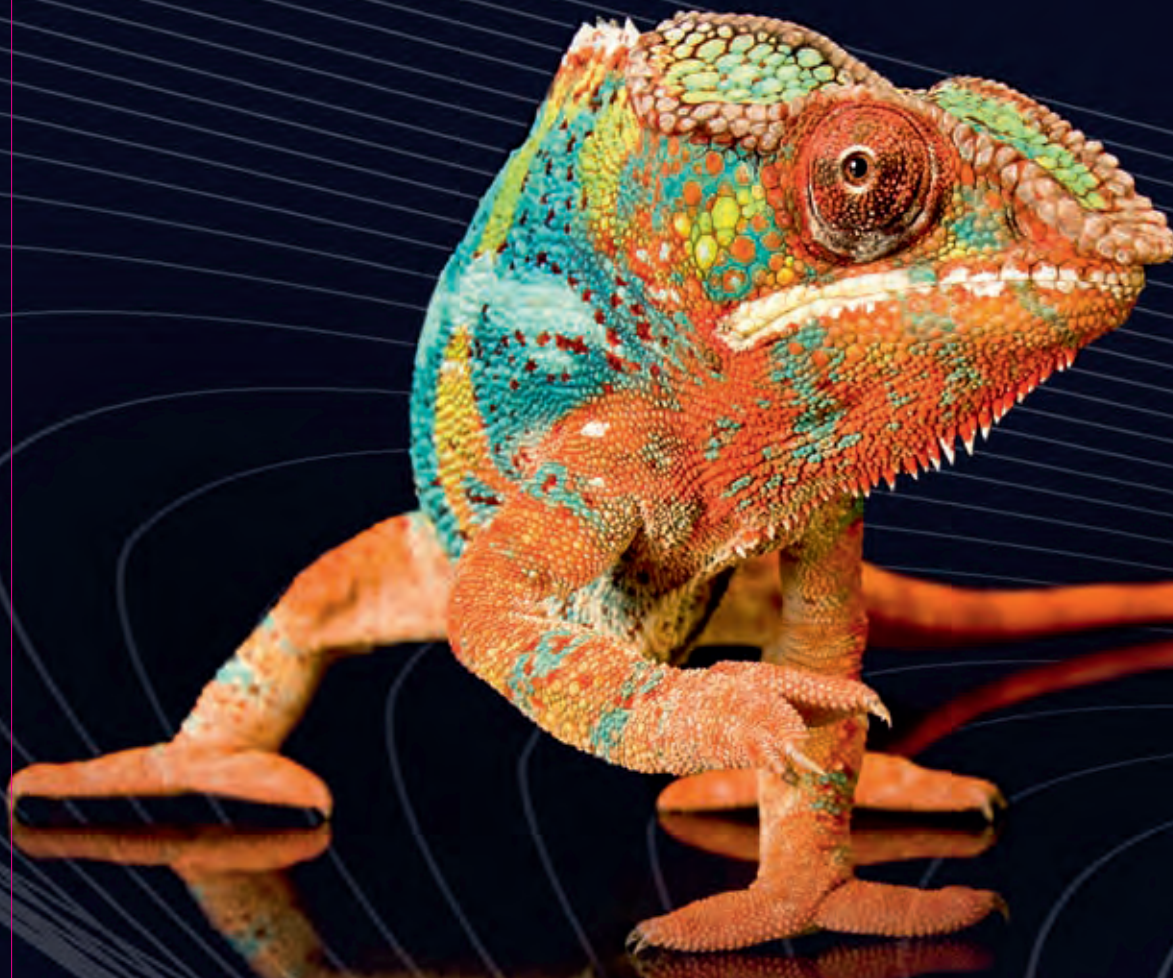
T-slot/ Thread	Order No.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

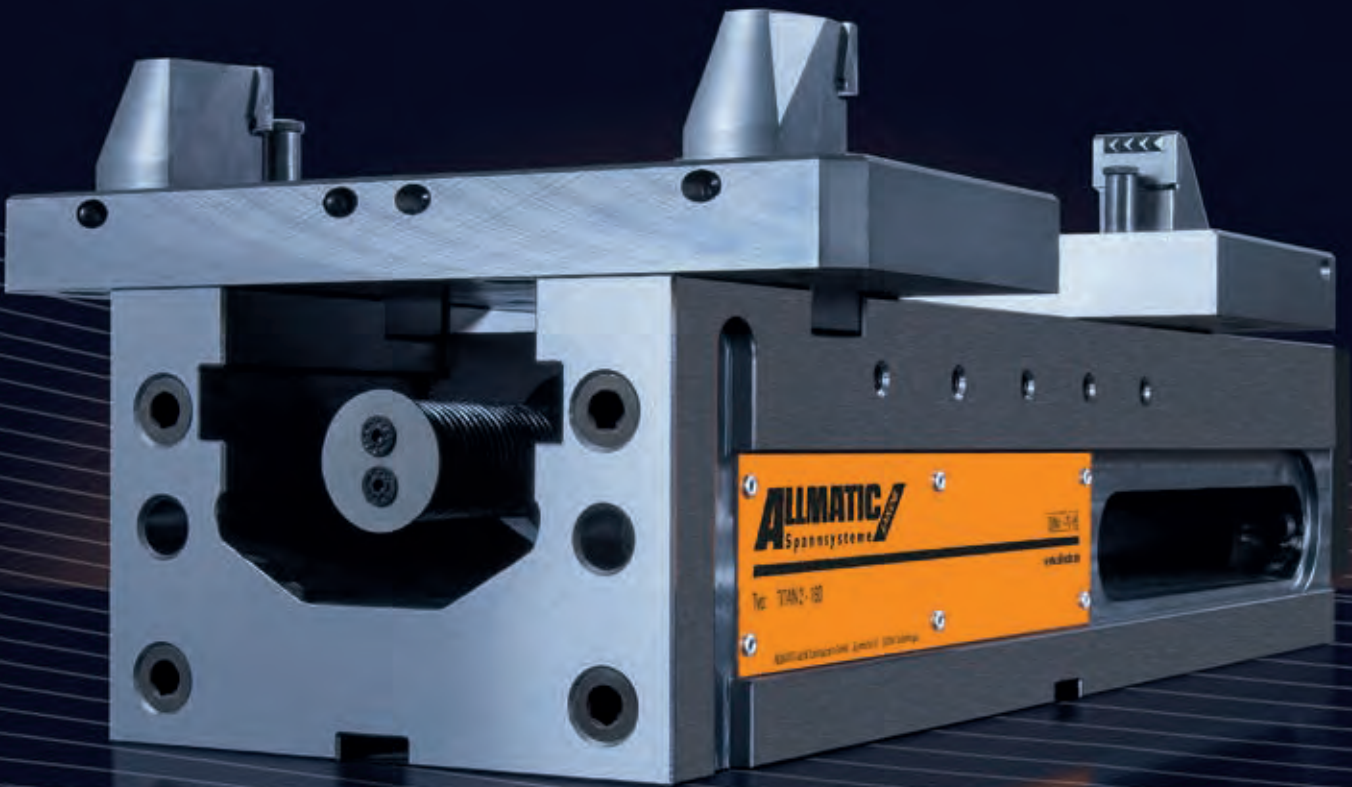
- For aligning (positioning) and fastening the vice on the pallet and machine table
- Size according to T-slot or thread in the machine table

# ALLMATIC TITAN 2-160 – HEAVY DUTY CUTTING. MADE FOR WHAT IS BIG!

Large workpieces - big machines - this is its world.

The TITAN 2-160 opens new doors in the segment of the clamping of large parts. It combines the advantages of raw material clamping and the accuracy of its little brother the TITAN 2-125 with the stability of the basic 160 body.





# ALLMATIC GRIPP – MECHANICAL VERSION TITAN 2-160

## Scope of application:

- For horizontal and vertical usage - suitable for CNC controlled milling machines and large machining centres.
- Clamping unmachined parts, saw-cut or flame-cut material by penetration of hardened, replaceable gripper elements into the workpiece
- With the support jaws, unmachined parts in highly varied materials, or with complex geometries, can be clamped securely and economically.
- Gripper studs suitable for materials with a strength of up to approx. 1700N/mm<sup>2</sup>

## Product features:

- High versatility – the modular clamping system combines practically all the possibilities of our tried-and-tested models
- Fully compatible with the accessories of the LC/TC 160 series, for example gripper studs, universal gripper set and pull down sets
- Grounded sides so that all sides can be used
- High-pressure spindle with mechanical force amplifier (increased power stroke) for the safe clamping of raw parts in combination with gripping and pull down spring function
- Lost clamping margin 8 mm with pull-down, 3 mm with GRIPPER
- Clamping fixture extension possible (This is on the TITAN 2-160 attached to the front of the titanium clamp.)
- Clamping with torque wrench – max. 30 Nm.

This makes it possible to work above the table with an unfavourable clamping arrangement on the tool



Accurate slots for fastening the range of clamping jaws

Inductively hardened and polished guideway

Rigid spindle nut

Robust base made of GGG 60

Accurate spindle nut guidance


For initial positioning of the movable jaw with heavy workpieces (wrench size 22) Distance separated from power intensifier

Clamping shoulder for vertical use

M8 thread for workpiece stop

Accurate aligning slots (longitudinal/transverse) in the ground bottom surface for optimum alignment on the machine table

Outlet for coolant and chips

 Optional: Mounting holes for zero-point clamping systems are possible.

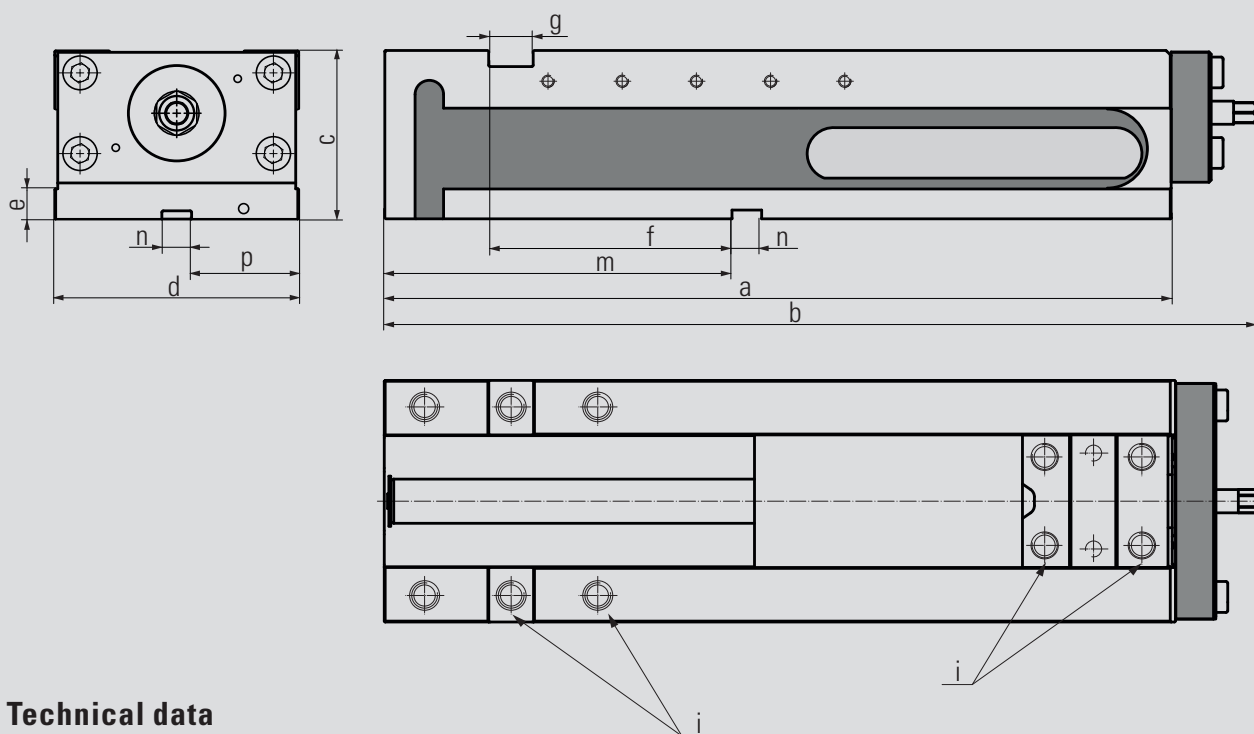
**Order no. jaw width 160: 6921848000055**

## Scope of supply:

- 1 high-pressure vice without jaws
- 4 side clamps
- 5 socket screw wrenches

**Please order the clamping jaws separately.**

An overview of the clamping jaws and other accessories is given on the following pages.

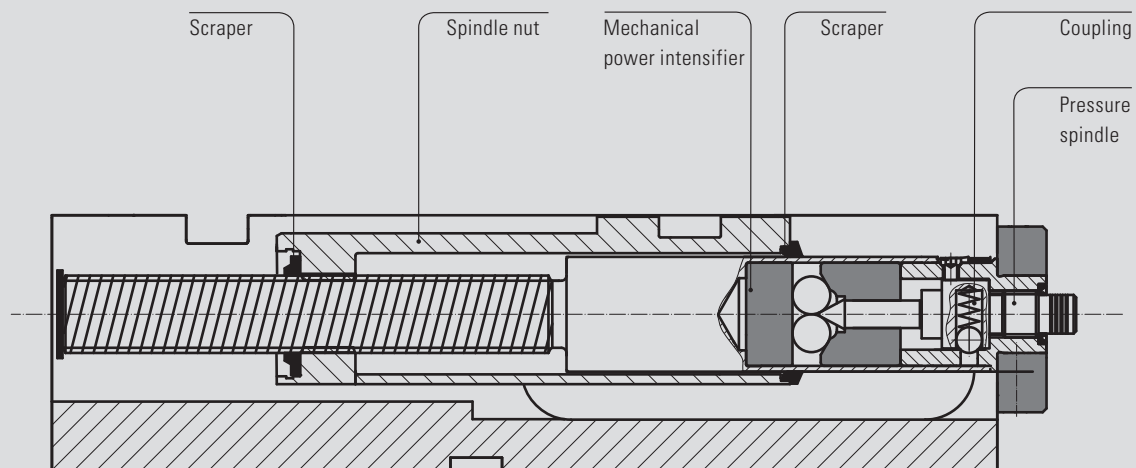


### Technical data

Jaw width		160
Dimensions / tolerances in mm	a	530
	b	587
	c	115
	d	164
	e	21
	f	164
	g	30
	m	234
	i	M 16
	n	20
p	72	

Jaw width		160
Max. torque in Nm		30
Max. clamping force in kN		40
Weight in kg		68

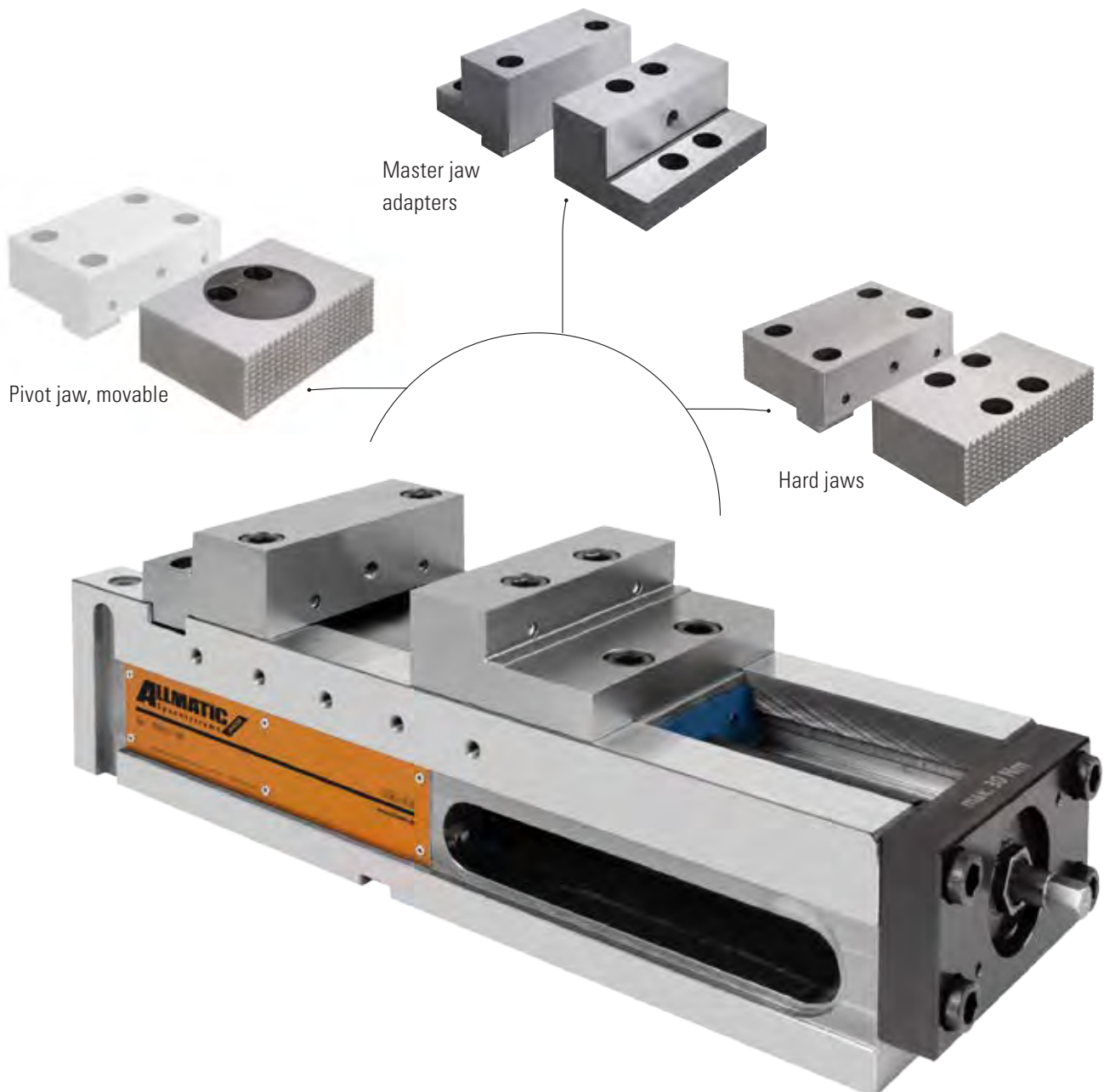
### Spindle cross-section





# TITAN 2-160

## CONVENTIONAL CLAMPING



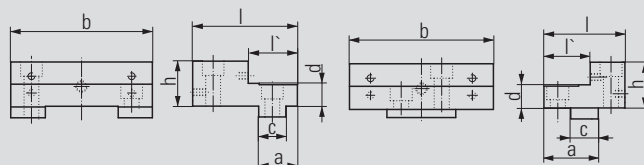
### For conventional clamping of workpieces

On the following pages you will find a wide range of jaws suitable for clamping pre-machined workpieces.

**ALLMATIC GRIPP – mechanical / version TITAN 2-160 (conventional clamping accessories)**

**Step jaws**

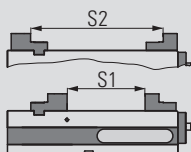
Order no. fixed: 6921704006731 Order no. movable: 6921304002731



- Material: hardened steel
- High and stepped sides with thread for parallels
- Ground clamping surfaces
- Additional thread on the high side for mounting the HD jaws
- Click system on the high side

Jaw width	160
Dimensions in mm	
a	40
b	160,4
c	30
d	25
h	49,8
l	104
l'	54

Jaw width	160
Dimensions in mm	
a	63
b	160,4
c	30
d	25
h	49,8
l	96
l'	64

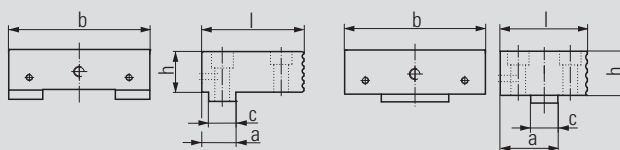


Clamping width S1	17 – 263
Clamping width S1 with enlargement*	259 – 505
Clamping width S2	189 – 435
Clamping width S2 with enlargement*	431 – 677

\*Clamping range enlargement: 6921705008055

**Hard base jaws**

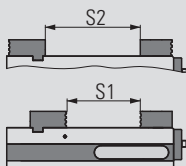
Order no. fixed: 6921704005731 Order no. movable: 6921704004731



- Material: hardened steel
- One side smooth and ground, one side errated
- Additional thread for parallels and for mounting the HD jaws on the smooth side
- Mountings for click system on both sides of the jaw

Jaw width	160
Dimensions in mm	
a	40
b	160,4
c	30
h	49,8
l	104

Jaw width	160
Dimensions in mm	
a	65
b	160,4
c	30
h	49,8
l	100



Clamping width S1	15 – 261
Clamping width S1 with enlargement*	257 – 503
Clamping width S2	69 – 315
Clamping width S2 with enlargement*	311 – 557

\*Clamping range enlargement: 6921705008055

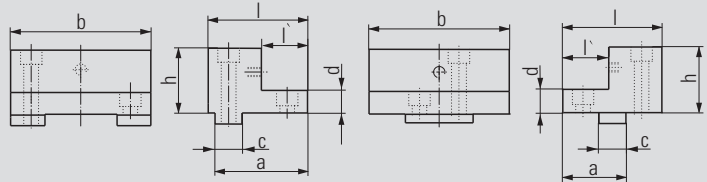
## ALLMATIC GRIPP – mechanical / version TITAN 2-160 (conventional clamping accessories)

### Master jaw adapters

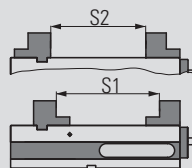
Order no. fixed: 6921704012231 Order no. movable: 6921304011231



- Material: steel
- High side of the jaw hardened
- Additional thread for mounting the HD jaws
- Ground clamping surfaces
- Click system on the high side



Jaw width		160	Jaw width		160
Dimen- sions in mm	a	89	Dimen- sions in mm	a	65
	b	164		b	164
	c	30		c	30
	d	24		d	24
	h	73		h	73
	l	100		l	100
	l'	34		l'	34

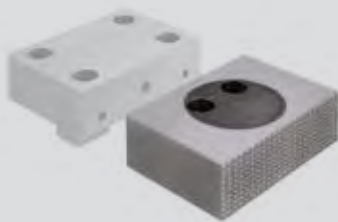


Clamping width S1	88 – 334
Clamping width S1 with enlargement*	330 – 576
Clamping width S2	68 – 314
Clamping width S2 with enlargement*	210 – 556

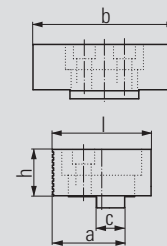
\*Clamping range enlargement: **6921705008055**

### Pivot jaw, movable

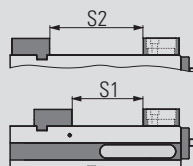
Order no. 6921704020042



- Material: Hardened steel
- With click system
- One side smooth and ground, one side serrated
- 360° rotatable
- Picture with hard base jaw  
(see order no.: 6921704005731)



Jaw width		160
Dimensions in mm	a	86
	b	160,4
	c	30
	h	49,8
	l	118



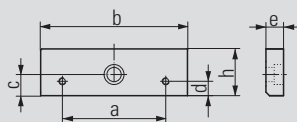
Clamping width S1	0 – 240
Clamping width S1 with enlargement*	236 – 482
Clamping width S2	48 – 294
Clamping width S2 with enlargement*	290 – 536

\*Clamping range enlargement: **6921705008055**

## ALLMATIC GRIPP – mechanical / version TITAN 2-160 (conventional clamping accessories)

### Compensation jaw

Order no. 6921704022031

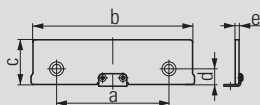


Jaw width	160	
Dimensions in mm	a	88
	b	160,4
	c	20
	d	12,25
	e	18
	h	49,8

- Material: hardened steel
- Ground and polished clamping surfaces
- For clamping range from 0 mm

### Click parallels (pair)

Order no. 6921205044042



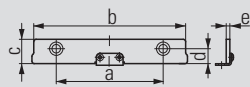
Jaw width	160	
Dimensions in mm	a	88
	b	160
	c -0,01	44
	d	12,25
	e	3

- For parallel raising of workpieces
- Hardened and ground parallels

- Parallels with click system or screw-on
- For the high side of the jaws

### Click parallels (pair)

Order no. 6921205025042



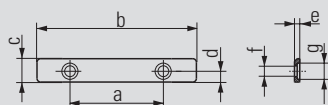
Jaw width	160	
Dimensions in mm	a	88
	b	160
	c -0,01	25
	d	12,25
	e	3

- For parallel raising of workpieces
- Hardened and ground parallels

- Parallels with click system or screw-on
- For the high side of the jaws

### Parallels (pair)

Order no. 6921305019031



Jaw width	160	
Dimensions in mm	a	88
	b	160
	c	19
	d	6
	e	3
	f	Ø 6
	g	Ø 9

- For parallel raising of workpieces
- Hardened and ground parallels
- Parallels for screwing on
- For the stepped side of the jaws

## ALLMATIC GRIPP – mechanical / version TITAN 2-160 (conventional clamping accessories)

### Smooth jaws (pair)



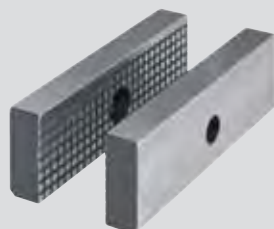
- Material: hardened steel
- For parts with delicate clamping surfaces

Order no. 6921034022031

Jaw width	160	
Dimensions in mm	a	160
	b	50
	c	20

- Please order fastening bolts separately (order no. 6921011023000)

### Serrated jaws (pair)



- Material: hardened steel
- Standard jaws with small surface area

Order no. 6921031005031

Jaw width	160	
Dimensions in mm	a	160
	b	50
	c	20

- To increase the specific contact pressure
- Please order fastening bolts separately (order no. 6921011023000)

### Soft jaws (pair)



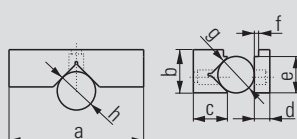
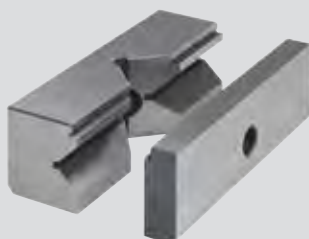
- Material: 21MnCr5G, type 1.23162 steel
- Jaws of case-hardening steel

Order no. 6921034023031

Jaw width	160	
Dimensions in mm	a	160
	b	50
	c	30

- For self-made special jaws
- Please order fastening bolts separately (order no. 6921011023000)

### Prismatic jaws (set)



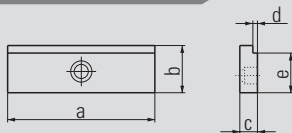
- Material: hardened steel
- For horizontal and vertical clamping of round and flat workpieces
- Please order fastening bolts separately (Order no.: 6921011023000)

Order no. 6921034024031

Jaw width	160	
Dimensions in mm	a	160
	b	50
	c	45
	d	20
	e	45
	f	3
	g	Ø 15 – 40
	h	Ø 22 – 65

## ALLMATIC GRIPP – mechanical / version TITAN 2-160 (conventional clamping accessories)

### Step jaws (pair)



Order no. 6921034025031

Jaw width		160
Dimensions in mm	a	160
	b	50
	c	20
	d	3
	e	45

- Material: hardened steel
- For horizontal clamping of flat workpieces
- Please order fastening bolts separately (order no.: 6921011023000)

### Roller pull-down jaws (pair)

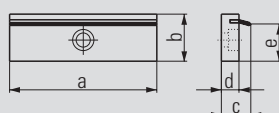


Order no. 6921034005131

Jaw width		160
Dimensions in mm	a	160
	b	50
	c	35,5
	d	45

- Material: hardened steel
- For parts with delicate clamping surfaces
- Jaw parts in contact with the workpiece press the workpiece onto the support surface
- Please order fastening bolts separately (order no.: 6921011023000)

### Spring leaf pull-down jaws (pair)



Order no. 6921034001042

Jaw width		160
Dimensions in mm	a	160
	b	50
	c	23
	d	15
	e	43

- Material: hardened steel
- For parts with rough clamping surfaces
- Spring leaves press the workpiece onto the support surface
- Spring leaves are replaceable (see 6921034002131 below)
- Please order fastening bolts separately (order no.: 6921011023000)

### Spring leaves (pair)



Order no. 6921034002131

- Spring leaves (replacement) for the spring leaf pull-down jaws (see above)

### Jaw fixing screw

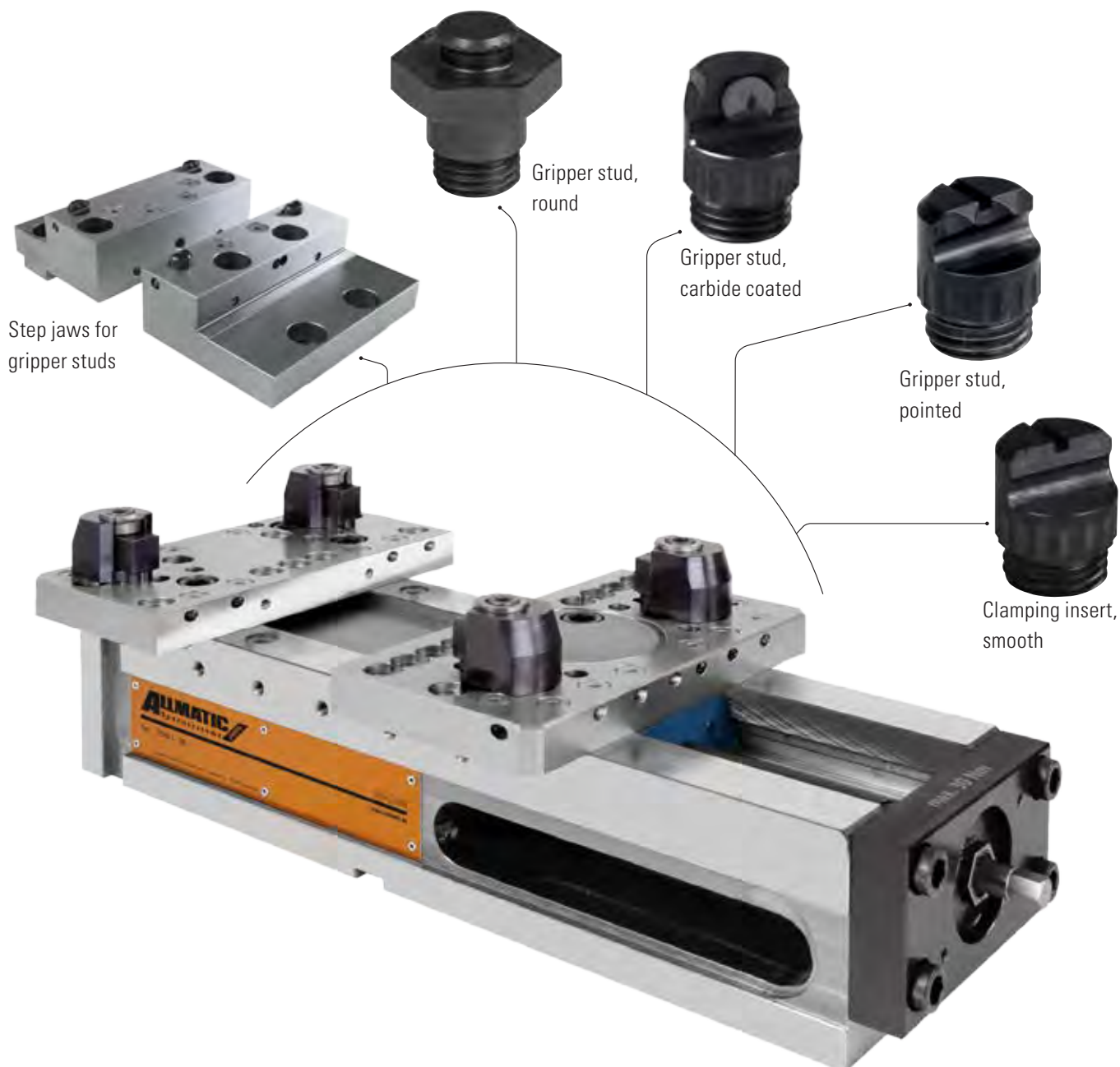


Order no. 6921011023000

- Bolt with shoulder – M10 x 23
- Suitable for all jaws in the 090, 100, 125 and 160 mm series

# TITAN 2-160

## GRIPP CLAMPING



### For clamping complex unmachined parts

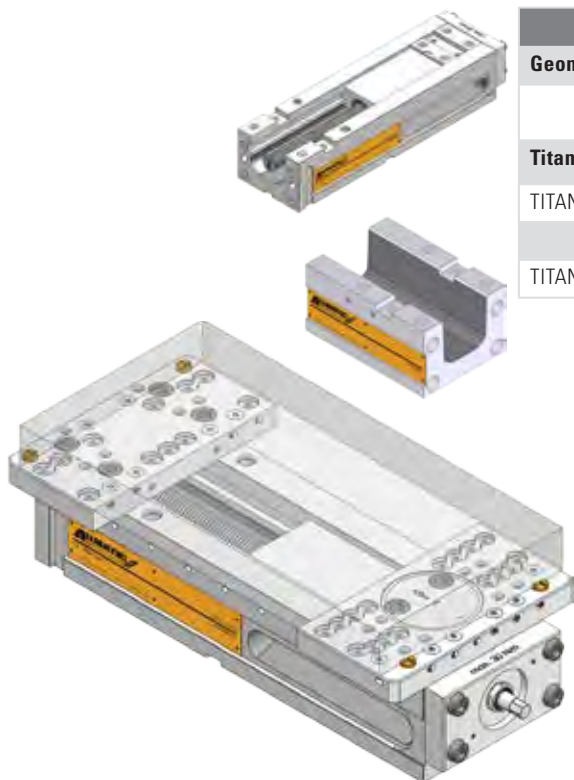
The support jaws enable you to clamp different unmachined parts quickly and securely. You will find jaws for gripper clamping on the following pages.

### GRIPP clamping

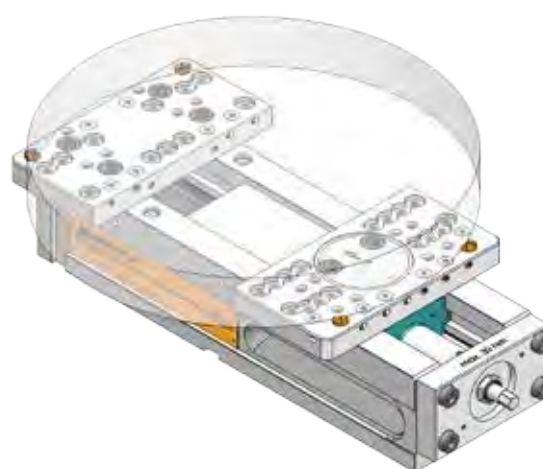
- Support jaws are used to mount different gripper studs (threaded gripper studs or universal gripper set)
- Gripper studs can be screwed in various positions on the grid plate in order to clamp various workpiece geometries securely
- Additional pivot function of the support jaws compensates for non-parallel clamping surfaces and is required to clamp uneven workpieces
- Short set-up times due to the multiple use of the jaws

# CLAMPING WIDTHS – GRIPP CLAMPING

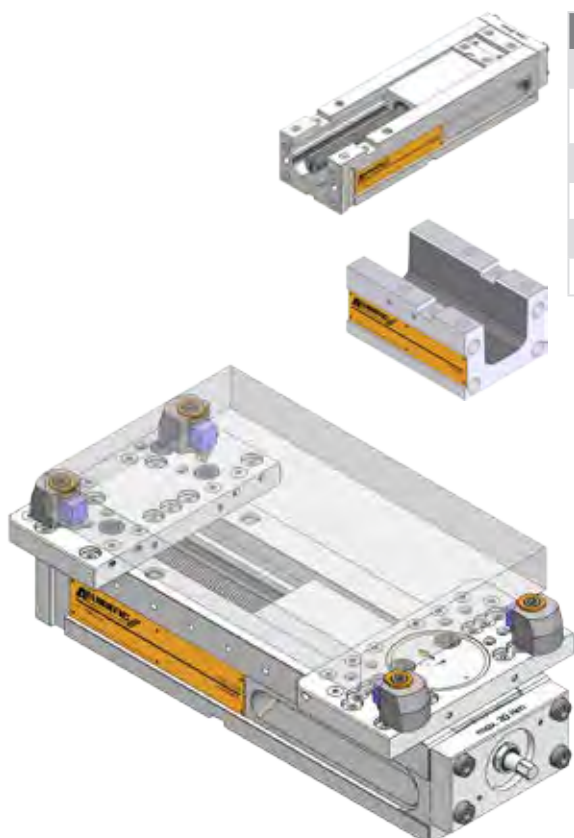
## Support jaws with gripper studs



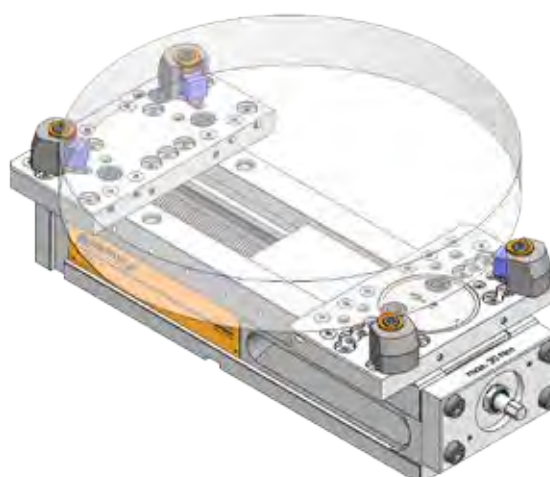
TITAN 2-160 - Support jaws with gripper studs					
Geometry	Rectangular workpiece		Round workpiece		
	Clamping range (in mm)		Clamping width (in mm)	Clamping range (in mm)	
Titan series	min.	max.	min.	min.	max.
TITAN 2-160	33	493	70	Ø 75	Ø 450
TITAN 2-160 with extension	-	735	70	-	Ø 450



## Support jaws with universal gripper set



TITAN 2-160 - Support jaw with universal gripper set					
Geometry	Rectangular workpiece		Round workpiece		
	Clamping range (in mm)		Clamping width (in mm)	Clamping range (in mm)	
Titan series	min.	max.	min.	min.	max.
TITAN 2-160	34	426	122	Ø 120	Ø 450
TITAN 2-160 with extension	-	668	122	-	Ø 450





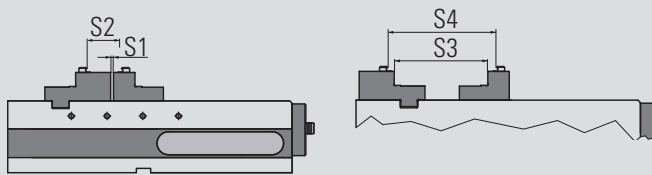
**ALLMATIC GRIPP – mechanical / version TITAN 2-160 (GRIPP clamping accessories)**

**Step jaws for gripper studs**



- Material: Hardened steel
- High and stepped sides with thread for parallels
- Ground clamping surfaces
- Additional thread on the high side for mounting the HD jaws (Typ 160)
- Suitable for screw-in gripper studs
- First and second clamping steps are possible without changing jaws
- Click system on the high side (see conventional clamping)

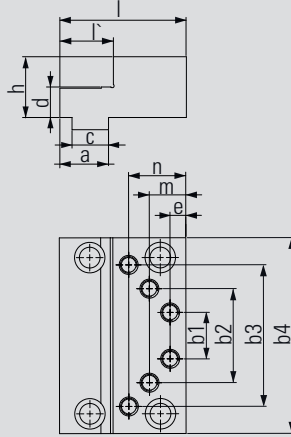
Note: The movable jaw has no pendulum compensation. It is suitable for rectangular workpieces (saw cuts) // <= 0.5 (concurrency less than or equal to 0.5 mm) or cylindrical workpieces O <= 0.5 (roundness less than or equal to 0.5 mm)



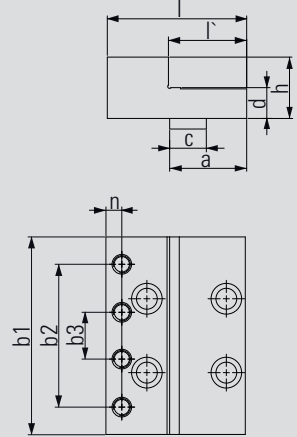
in mm	S1	S2	Round workpiece	S3	S4
Clamping width	0-245	24-264	Ø 55-400	179-425	227-468
with enlargement *	0-487	262-506	Ø 55-400	421-667	469-710
Clamping range	-	min. 54	-	-	min. 54

\*Clamping range enlargement: **6921705008055**

Order no. fixed:  
**6921844051031**



Order no. movable :  
**6921844050031**



Jaw width	160
Dimensions in mm	
a	40
b1	38
b2	77
b3	116
b4	160,4
c	30
d	25
e	13
h	49,8
l	104
l'	44
m	47
n	30

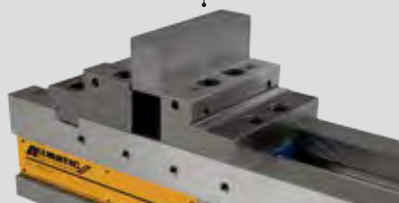
Jaw width	160
Dimensions in mm	
a	63
b1	160,4
b2	116
b3	38
c	30
d	25
h	49,8
l	114
l'	64
n	13



clamping unmachined parts round



clamping unmachined parts quadratic



clamping pre-machined workpieces

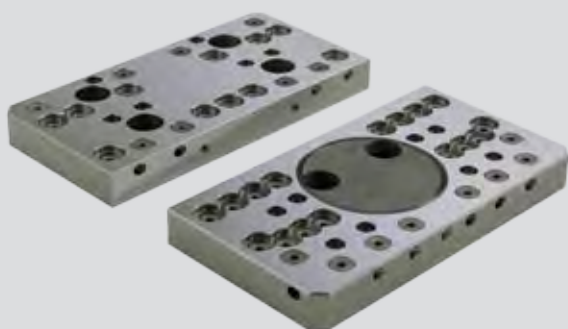


Please order gripper studs separately

No retooling necessary!  
Set-up times will be reduced

## ALLMATIC GRIPP – mechanical / version TITAN 2-160 (GRIPP clamping accessories)

### Support jaws



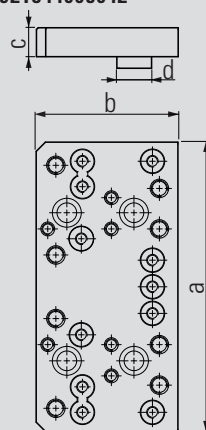
- Material: hardened steel
- For mounting various pull-down wedge elements, universal gripper set and gripper studs (pointed/smooth)
- Front surface can be used as clamping surface (hardened and ground)

#### Pivot jaw:

- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- Supplied **without** wedge elements, gripper set and gripper studs (pointed/smooth)

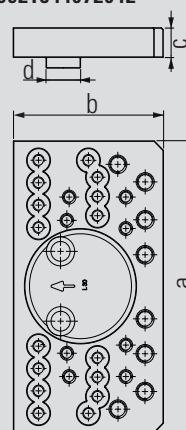
You will find dimensions of the individual gripper items and the gripper studs at [www.allmatic.de](http://www.allmatic.de)

Order no. fixed:  
6921844005042



Jaw width	160
Dimensions in mm	
a	250
b	122,5
c	25
d	30

Order no. movable, pivoting:  
6921844072042

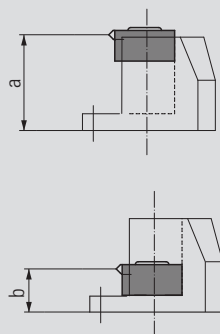


Jaw width	160
Dimensions in mm	
a	250
b	132
c	25
d	30



Please order universal gripper set or gripper studs separately

### Universal gripper set



Order no. 6921884027031

Jaw width	160
Dimensions in mm	
a	40
b	18

- For clamping complex unmachined parts
- By reworking the individual elements of the universal gripper set, both the gripper height and the support height of the workpiece can be varied

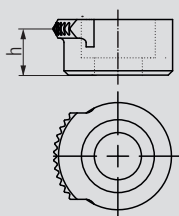
#### Consisting of:

- 4 x gripper studs 6921884026000
- 4 x gripper stud mounting 6921884027000
- 4 x supports 6921884028000
- 8 x shims
- Support bolts
- M10 fastening bolts in various lengths
- M6 threaded rods in various lengths
- Socket screw wrench
- Storage case



## ALLMATIC GRIPP – mechanical / version TITAN 2-160 (GRIPP clamping accessories)

### Gripper stud

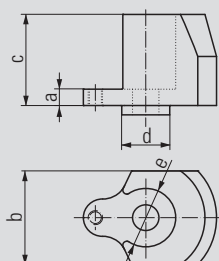


Order no. 6921884026000

Dimensions in mm	h	11
------------------	---	----

- Gripper stud for universal gripper set

### Gripper stud mount

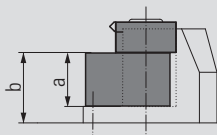
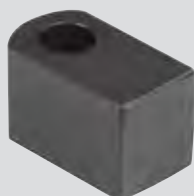


Order no. 6921884027000

Dimensions in mm	a	7
	b	40
	c	39
	d	Ø 20
	e	Ø 25

- Mounting for gripper stud 6921884026000

### Support

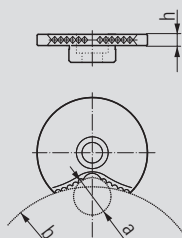


Order no. 6921884028000

Dimensions in mm	a	22
	b	29

- Support for universal gripper set

### Prismatic gripper

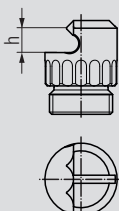


Order no. 6921884029031

Dimensions in mm	a	Ø 20
	b	Ø 120
	h	6

- Replaces gripper stud 6921884026000 in the universal gripper set
- Special shape distributes the applied clamping force – particularly advantageous for clamping workpieces that require fits to be made

### Gripper stud, pointed



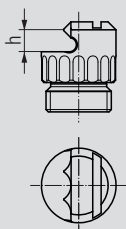
Order no. 6921884036000

Dimensions in mm	h	5,5
------------------	---	-----

- For clamping unmachined parts
- Least possible lost clamping margin
- Clamping height: adjustable from 4.5 to 6.0 mm

## ALLMATIC GRIPP – mechanical / version TITAN 2-160 (GRIPP clamping accessories)

### Gripper stud, low

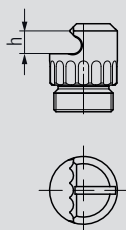


Order no. 6921884036100

Dimensions in mm	h	5
------------------	---	---

- For clamping unmachined parts
- Least possible lost clamping margin
- Clamping height: adjustable from 3.0 to 4.5 mm

### Clamping insert, four-point

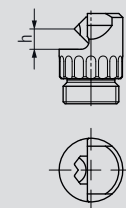


Order no. 6921884036500

Dimensions in mm	h	5.4
------------------	---	-----

- For clamping unmachined parts
- For soft materials such as aluminium
- Least possible lost clamping margin
- Clamping height approx. 4.5 mm to 6.0 mm

### Gripper stud, carbide coated

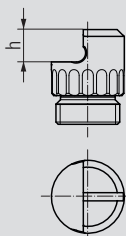


Order no. 6921884036841

Dimensions in mm	h	5.1
------------------	---	-----

- For clamping unmachined parts
- For quenched and tempered materials and flame-cut materials
- Least possible lost clamping margin, clamping height approx. 4.2 mm to 5.7 mm

### Clamping insert, smooth

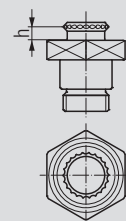


Order no. 6921884037000

Dimensions in mm	h	7
------------------	---	---

- With carbide coating for clamping pre-machined or hardened workpieces

### Gripper stud, round



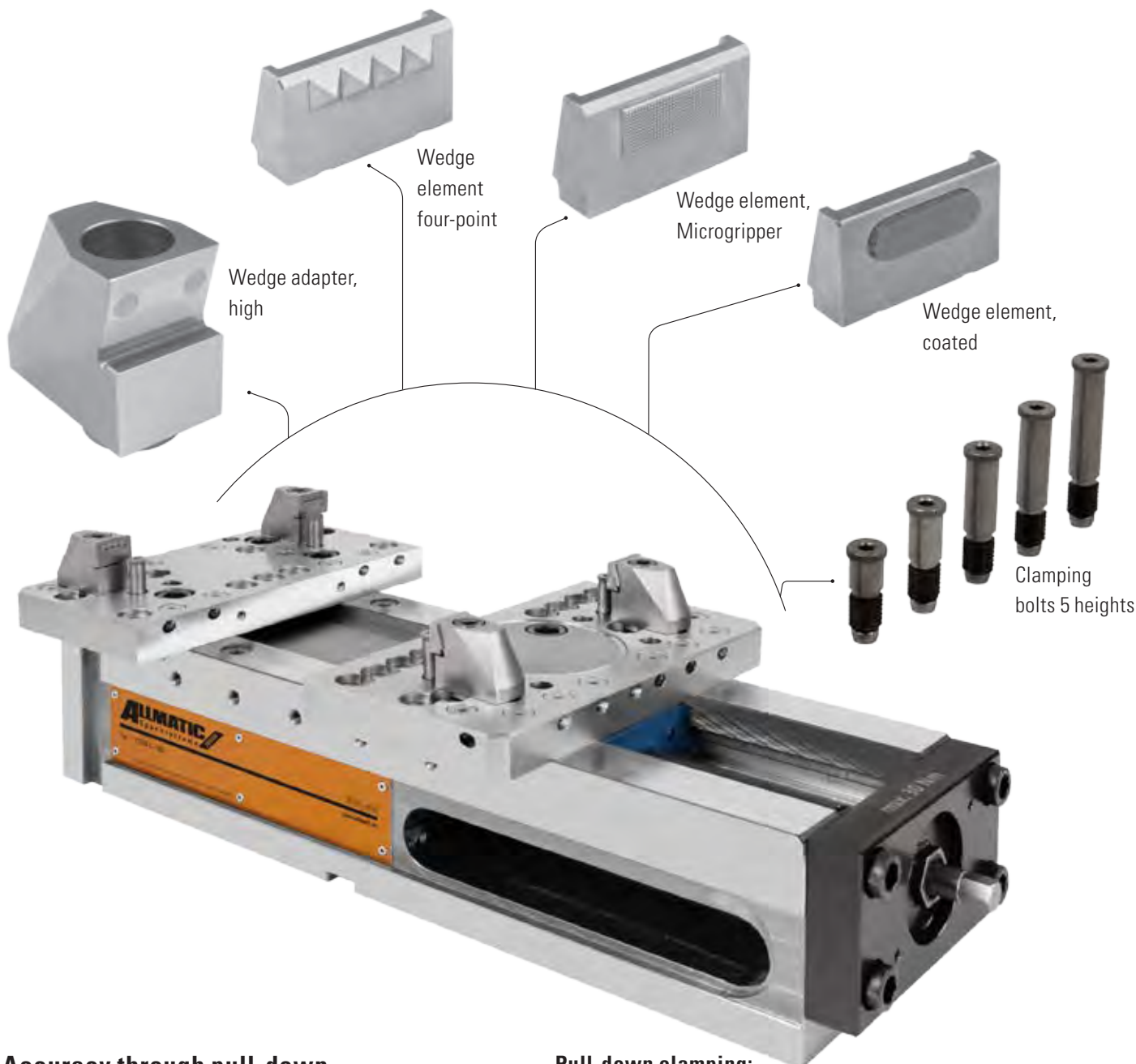
Order no. 6921884038000

Dimensions in mm	h	4
------------------	---	---

- For clamping unmachined parts
- For drilling through close to the edge
- Offers 6 mm clear space under the workpiece

# TITAN 2-160

## PULL-DOWN CLAMPING



### Accuracy through pull-down

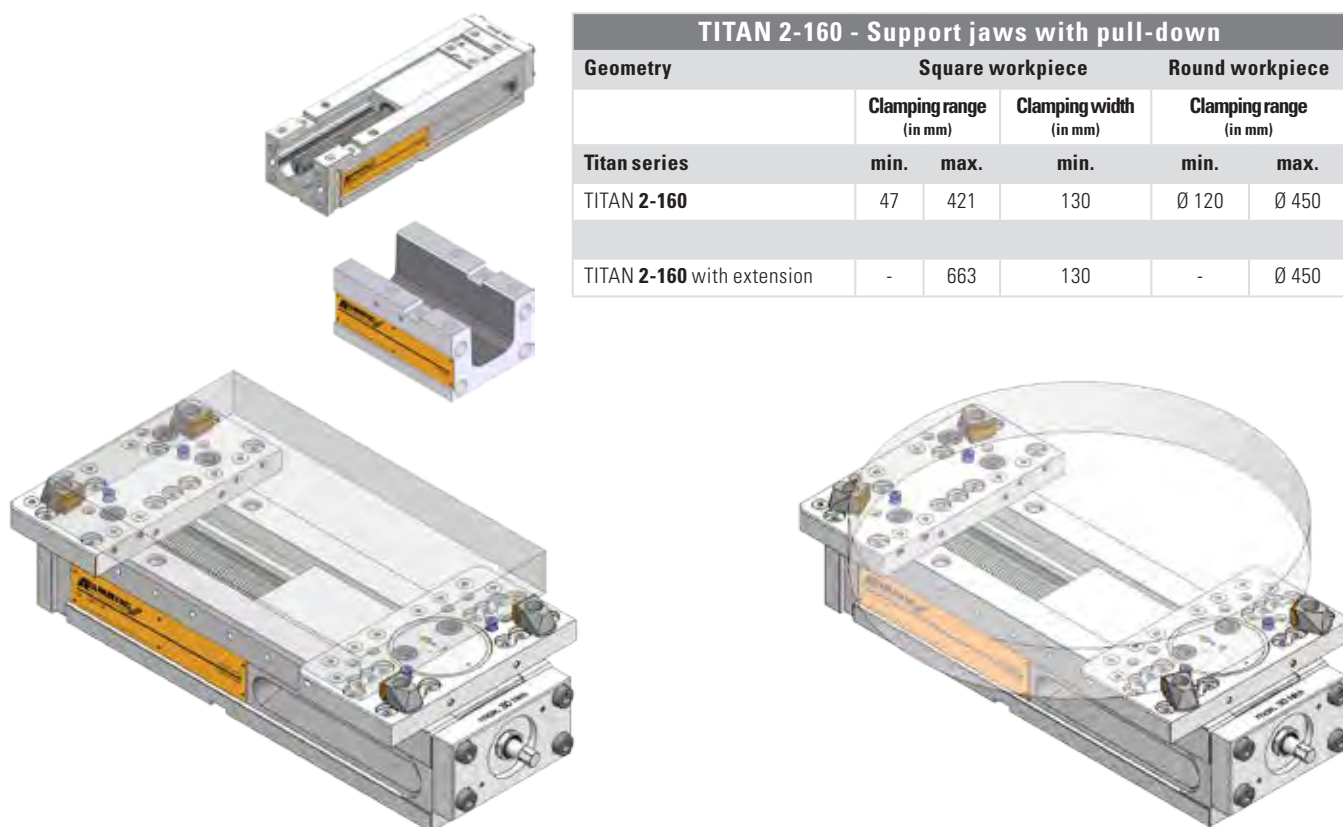
The support jaws and the pull-down system ensure accurate, versatile and secure clamping of the unmachined parts. The workpiece is positioned on ground clamping bolts which make the connection to the guideway. In this way, the parallelism of the guideway or of the machine table is transferred to the workpiece, thus achieving even greater clamping accuracy. Vibrations in the workpiece during machining are to a large extent avoided. The pull-down system can be found on the following pages.

### Pull-down clamping:

- Support jaws are used to mount various wedge adapters and clamping bolts
- Wedge adapters can be bolted in various positions on the grid plate
- The various wedge elements can be changed quickly on the wedge adapters
- Additional pivot function of the support jaws compensates for non-parallel clamping surfaces and is required to clamp uneven workpieces
- Accuracy through pull-down
- Clamping in the neutral filament can be optimised using the 5 different heights of the clamping bolts

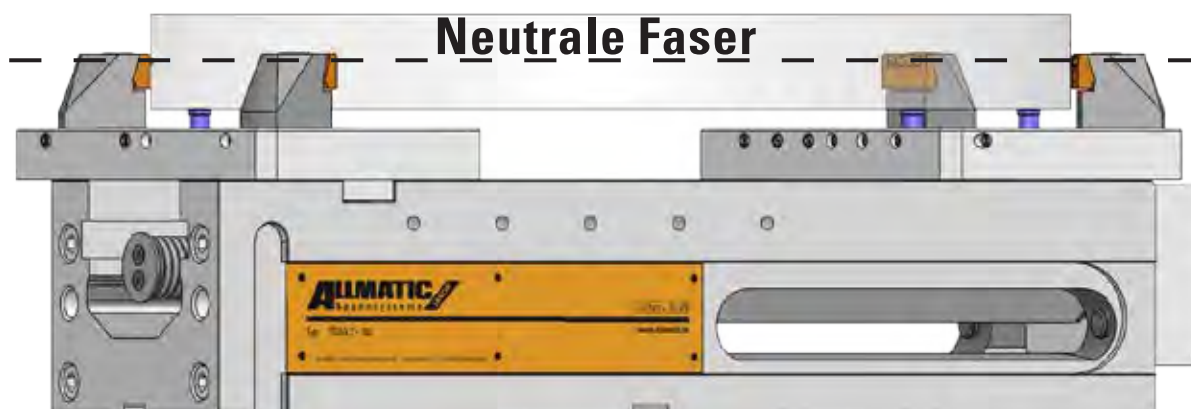
# CLAMPING WIDTHS – PULL-DOWN CLAMPING

Support jaws with pull-down



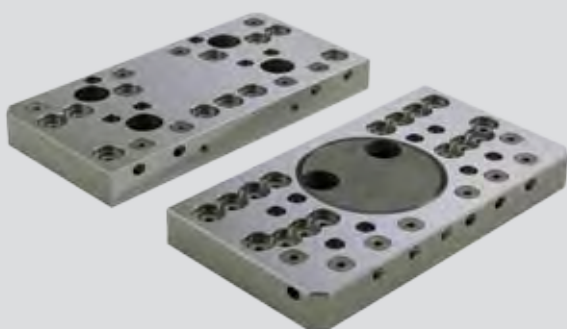
TITAN 2-160 - Support jaws with pull-down					
Geometry	Square workpiece		Round workpiece		
	Clamping range (in mm)		Clamping width (in mm)	Clamping range (in mm)	
Titan series	min.	max.	min.	min.	max.
TITAN 2-160	47	421	130	Ø 120	Ø 450
TITAN 2-160 with extension	-	663	130	-	Ø 450

Clamping in the neutral filament



## ALLMATIC GRIPP – mechanical / version TITAN 2-160 (pull-down clamping accessories)

### Support jaws



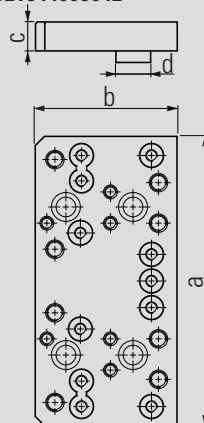
- Material: hardened steel
- For mounting various pull-down wedge elements, universal gripper set and gripper studs with thread (pointed/smooth)
- Front surface can be used as clamping surface (hardened and ground)

#### Pivot jaw:

- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- Supplied **without** clamping elements

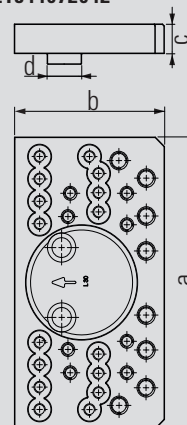
You will find dimensions of the individual gripper items and the gripper studs at [www.allmatic.de](http://www.allmatic.de)

Order no. fixed:  
6921844005042



Jaw width	160	
Dimensions in mm	a	250
	b	122,5
	c	25
	d	30

Order no. movable, pivoting:  
6921844072042

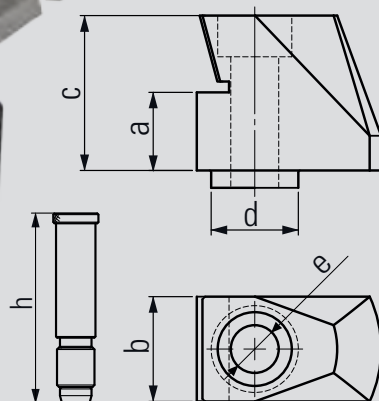


Jaw width	160	
Dimensions in mm	a	250
	b	132
	c	25
	d	30



Please order pull-down studs separately

### Pull-down set case, 160



Order no. 6921734027231

Jaw width	160	
Dimensions in mm	a	18
	b	24
	c	35,7
	d	Ø 20
	e	Ø 11
	h	34 / 53

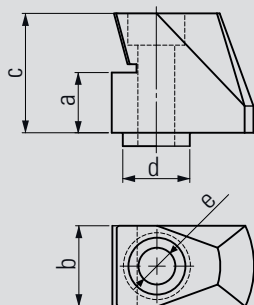
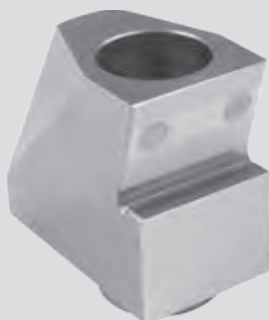
- Pull-down elements suitable for clamping and pulling down clamping surfaces that are unmachined or pre-machined onto the guideway or onto the supplied clamping bolts
- In this way workpieces can be clamped almost exactly parallel to the guideway for machining
- The direct contact to the clamping bolts largely avoids vibrations in the workpiece

Pull-down set consisting of:

- 1 x foamed case
- 4 x wedge adapter, high
- 4 x bolts, M10 x 45 mm
- 4 x wedge element, 4 point
- 4 x wedge element Microgripper
- 4 x clamping bolts 53 mm
- 4 x clamping bolts 34 mm

## ALLMATIC GRIPP – mechanical / version TITAN 2-160 (pull-down clamping accessories)

### Wedge adapter, high



Order no. 6921834027141

Dimensions in mm		
a	18	
b	24	
c	35,7	
d	Ø 20	
e	Ø 11	

- Wedge adapter, high, for use on support jaws. For mounting the four-point, Microgripper, round and coated wedge elements supplied **without** M10 x 45 mm fastening bolt (see next page)

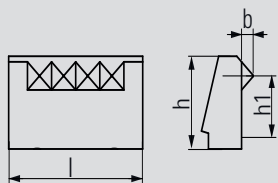
### Fastening bolt, high



Order no. 8006101045050

- For fastening the wedge adapter, high, on the support jaws
- M 10 X 45 mm

### Wedge element, four-point

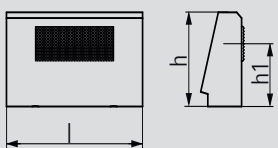
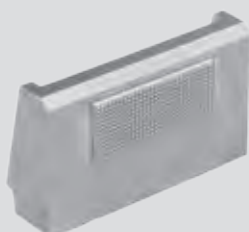


Order no. 6921834025040

Dimensions in mm		
b	2,4	
h	16,5	
h1	13	
l	27,8	

- Wedge elements for various shapes, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm

### Wedge element, Microgripper



Order no. 6921834025140

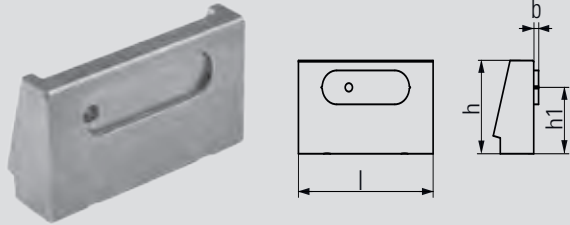
Dimensions in mm		
h	16,5	
h1	11	
l	27,8	

- Wedge elements for various shapes, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm



## ALLMATIC GRIPP – mechanical / version TITAN 2-160 (pull-down clamping accessories)

### Wedge element, coated



Order no. 6921834025240

Dimensions in mm	b	1
	h	16,5
	h1	11,75
	l	27,8

- Wedge elements for pre-machined, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm
- Please order the pads separately (see below)

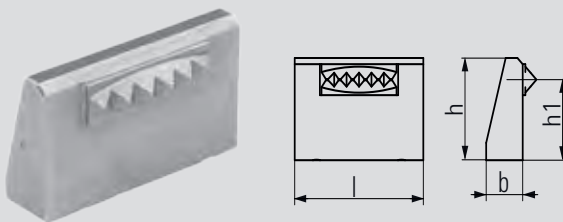
### Blister-pads, diamond-coated



Order no. 6921834028141

- Diamond-coated pads for secure clamping of machined surfaces without a visible impression
- Blister contents: 20 pads

### Wedge element, round



Order no. 6921834026340

Dimensions in mm	b	2,4
	h	16,5
	h1	13
	l	27,8

- Wedge elements for round shapes or radii, irrespective of surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm

### Clamping bolts



6921735053040

h	53
---	----

6921735048040

h	48
---	----

6921735043040

h	43
---	----

6921735034040

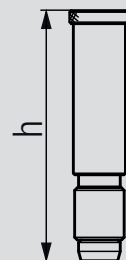
h	34
---	----

6921735029040

h	29
---	----

See table for order no.

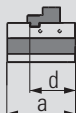
- Five support heights
- For levelling the workpiece on the guideway
- Material: hardened steel
- Ground to high accuracy



**ALLMATIC GRIPP – mechanical / version TITAN 2-160 (pull-down clamping accessories)**

## ALLMATIC GRIPP – mechanical / version TITAN 2-160 (accessories)

### Clamping width enlargement



Order no. 6921705008055

Jaw width		160
Dimensions in mm	a	237
	d	172

- For increasing the clamping width of the TITAN 2-160
- Is attached to the end face of the TITAN 2 vice
- Clamping forces are not transmitted to the machine table
- Included: 1 pair of side clamps



Clamping range at conventional clamping	
Clamping range S1 / S2	+242 mm

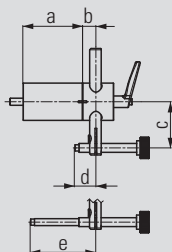
Clamping range at Gripp clamping  
See chapter TITAN2-160 Gripp clamping



Clamping range at pull-down clamping  
See chapter TITAN2-160 pull-down clamping



### Workpiece stop



Order no. 6921285650144

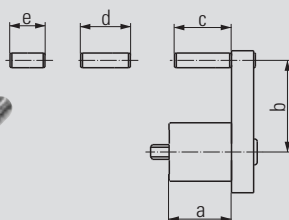
Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63,5
	e	53,5 – 113,5

- Can be mounted at the positions provided on both sides of the vice
- Fastening thread M8
- Position of the third workpiece access can be preset and clamped. Workpiece stop can be swivelled away once the workpiece has been clamped.
- This allows the stop side of workpiece to be machined as well (repeating accuracy:  $\pm 0.01$ )



## ALLMATIC GRIPP – mechanical / version TITAN 2-160 (accessories)

### Workpiece stop

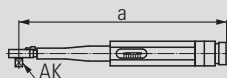


Order no. 6921685670042

Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

- Can be mounted at the positions provided on both sides of the vice
- Fastening thread M8
- Can be pre-mounted with various fixed dimensions
- Presettable position of the third axis of the workpiece

### Torque wrench



Order no. 0651114113188

Dimensions in mm	a	307
	AK (Drive square)	3/8"

- Adjustable between 10 – 60 Nm
- Only for operating the T-REX, TITAN and DUO Plus 125 high-pressure spindles

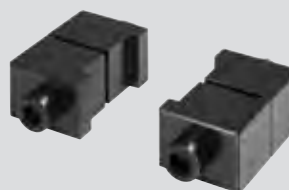
### Side clamps (pair)



Order no. 6921025000031

- For fastening the vice to the machine table
- Scope of supply includes 2 items

### DUO side clamps



Order no. 6921285000031

- For fastening device to a bracket or onto a machine table
- 1 set consists of 2 pairs of side clamps, including screw connections

### Aligning and fixing set



Order no. – see table

T-slot/ Thread	Order No.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

- For aligning (positioning) and fastening the vice on the pallet and machine table
- Size according to T-slot or thread in the machine table

# ALLMATIC DUO PLUS 125 – TOTAL FLEXIBILITY!

The new DUO Plus 125 from ALLMATIC  
is robust, durable and opens up completely  
new possibilities in the field of clamping technology.



# ALLMATIC GRIPP – MECHANICAL DUO PLUS 125 VERSION

## Scope of application:

- Horizontal installation
- Suitable for conventional clamping and for gripper clamping or a combination of both
- The support jaws enable a wide range of unmachined parts from flame-cut and sawn materials through to complex castings to be clamped securely and economically. Gripper studs suitable for materials with a strength of up to approx. 1,000 N/mm<sup>2</sup>

## Product features:

- Clamping range adjustment for clamping two workpieces of different sizes
- Reproducible clamping forces enable excellent repeating accuracy of the workpiece position
- Mechanical power-transfer device
- Fully enclosed and maintenance-free high-pressure spindle – high chip protection, minimum cleaning requirements, constant clamping forces up to 40 kN
- Use with a torque wrench – max. 40 Nm



Robust and compact base made of GGG 60

Outlet for coolant and chips

Hardened, ground and polished guideway

M8 thread for workpiece stop

Precision aligning slots (longitudinal/transverse) in the bottom surface for optimal alignment on the machine table

Setting and adjusting the spindle position

Optional: mounting holes in the bottom surface for zero-point clamping system are possible

**Order No. jaw width 125: 6921438000055**

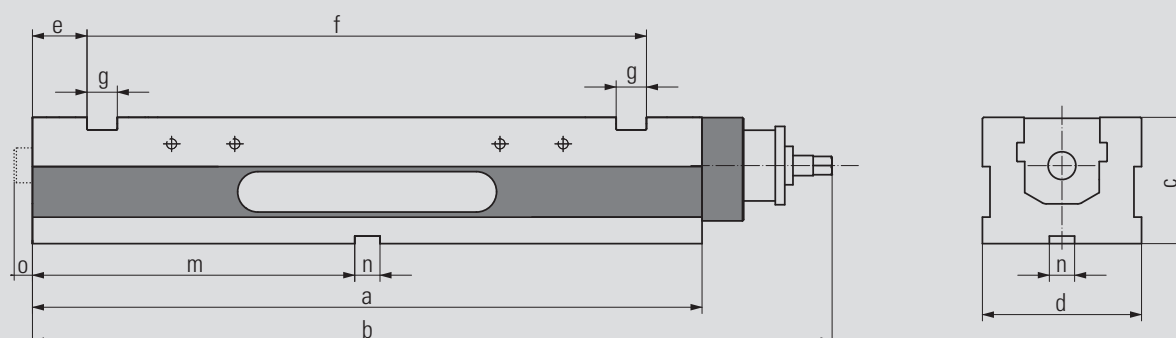
## Scope of supply:

- 1 high-pressure vice without jaws
  - 4 side clamps
  - 3 socket screw wrenches
  - 1 wrench socket WS 14
- (Please order clamping jaws separately)

## Note:

Delivery does not include a torque wrench (see accessories).

An overview of the clamping jaws and other accessories is given on the following pages.



## Technical data

Jaw width	125	
Dimensions / tolerances in mm	a	530
	b	633
	c	100
	d	126
	e	43.2
	f	443
	g	24
	m	255.2
	n	20
o	0 – 15	

Jaw width	125
Max. torque in Nm	40
Max. clamping force in kN	40
Weight in kg	40

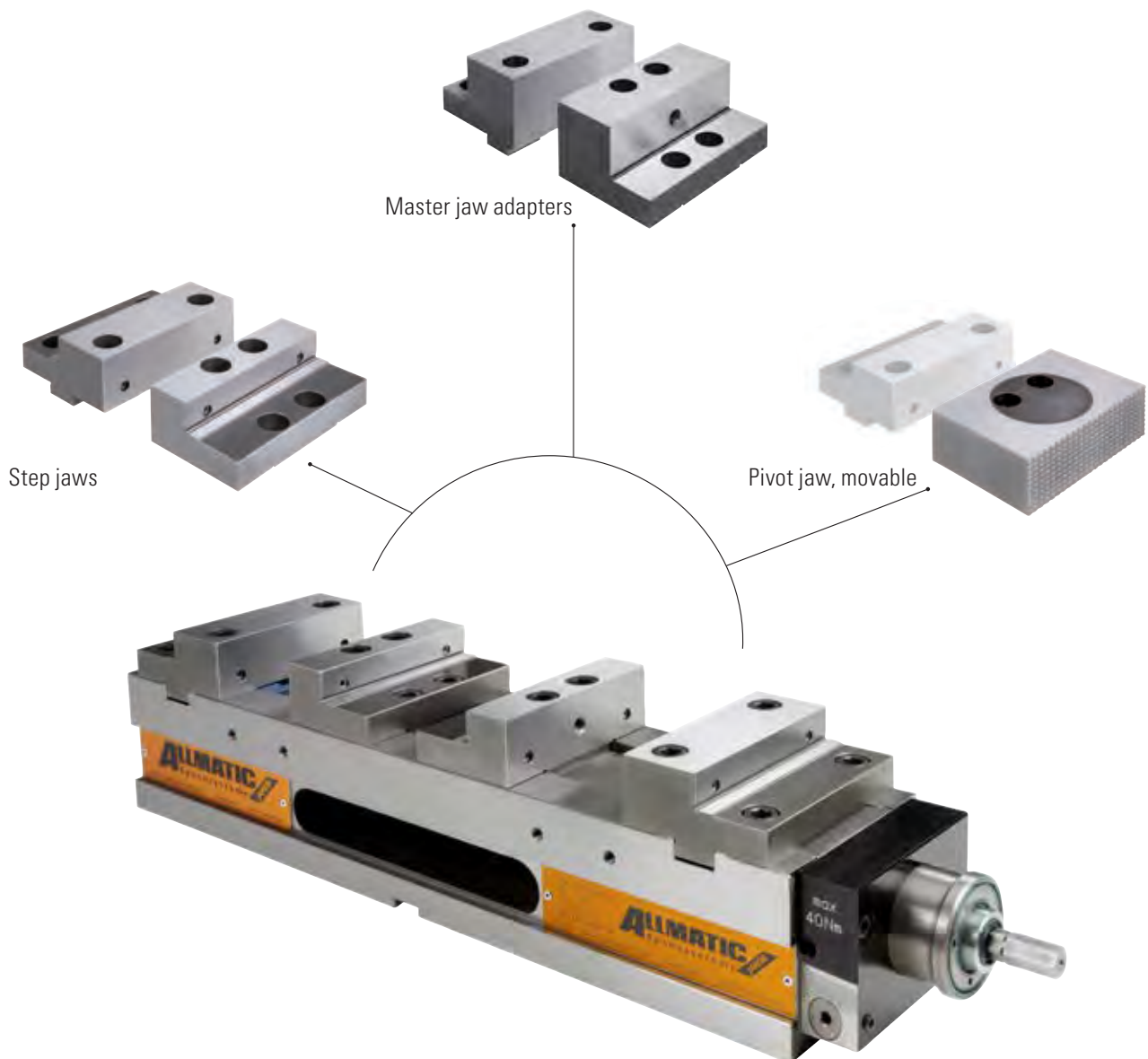
With the spindle in a symmetrical position, turn the torque wrench clockwise to bring movable jaw 1 up against the workpiece in station 1 (see page 6). The workpiece is fixed with a force of approx. 1000 N. Turn the torque wrench further to bring movable jaw 2 up against the workpiece in station 2 and fix it there. If you continue turning beyond the "locking point", the coupling will disengage. The pressure spindle activates the mechanical power intensifier.

Turning as far as the preset torque level (max. 40 Nm) produces a controlled clamping force build-up. Workpieces must be placed in both stations before clamping begins. Tolerances of  $\pm 2.5$  mm between workpiece 1 and workpiece 2 are compensated for. The new function of the clamping range adjustment enables the clamping of two differently sized workpieces.





# ALLMATIC GRIPP – MECHANICAL/DUO PLUS 125



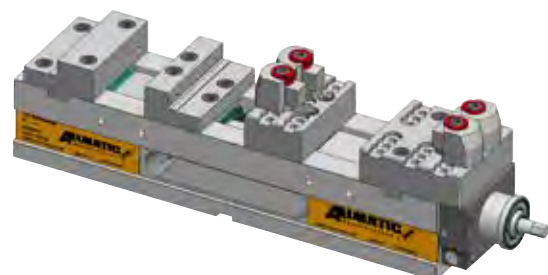
## For conventional clamping of workpieces

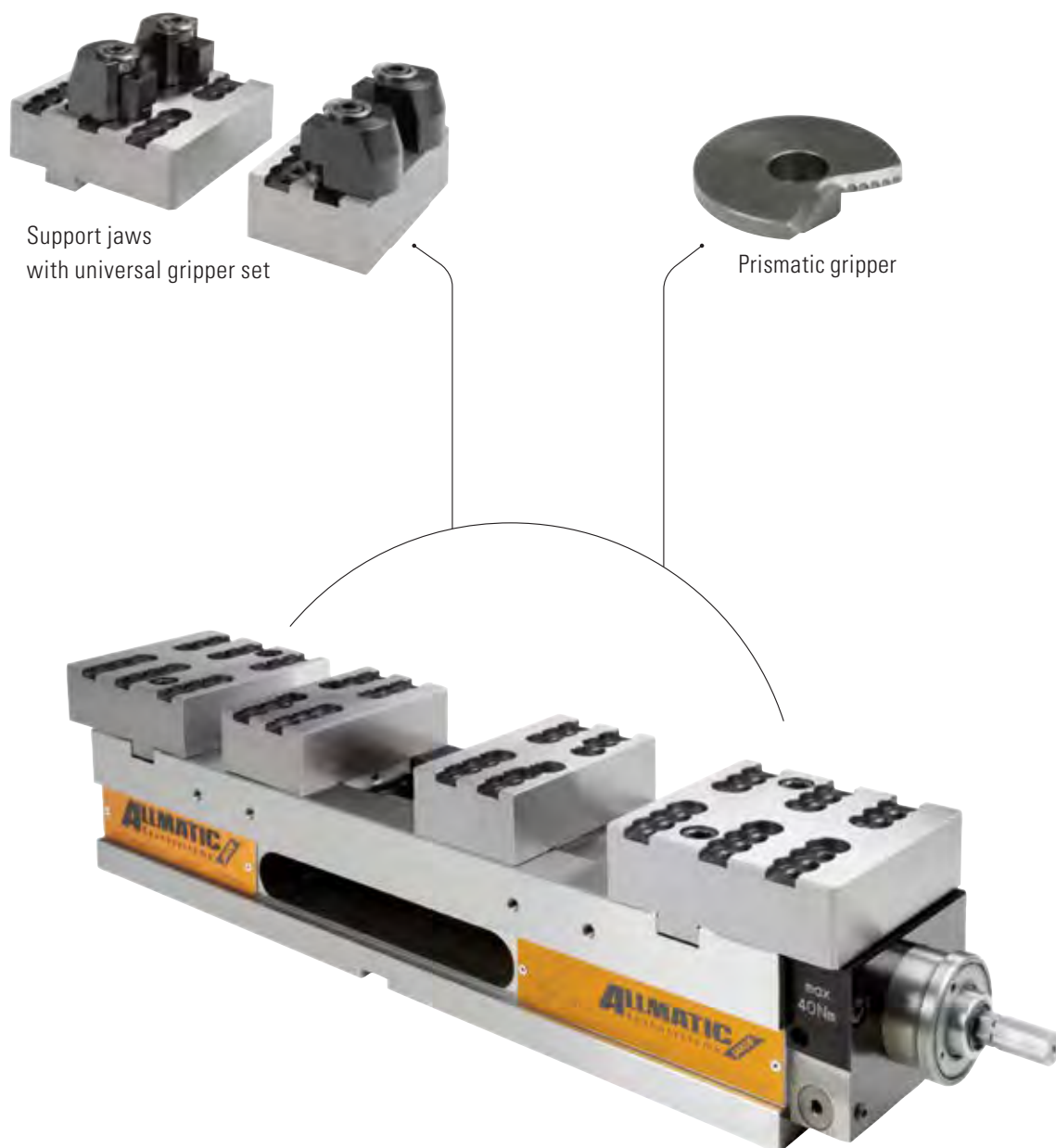
On the following pages, you will find a wide range of jaws, suitable for clamping pre-machined workpieces.



### IMPORTANT

A combination of both clamping options is possible!





### For clamping complex unmachined parts

The support jaws and gripper studs enable you to clamp different unmachined parts quickly and securely.

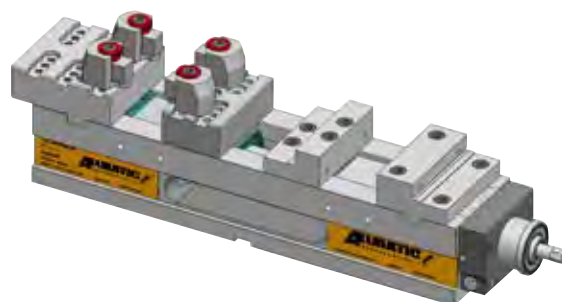
### Gripper clamping

- Support jaws are used to mount the universal gripper set
- Gripper studs can be screwed onto grid plates in variable positions, to clamp unmachined workpieces of different sizes



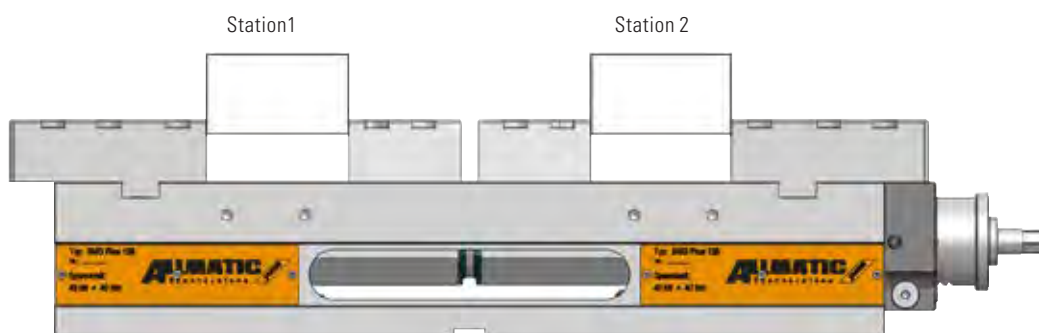
#### IMPORTANT

A combination of both clamping options is possible!

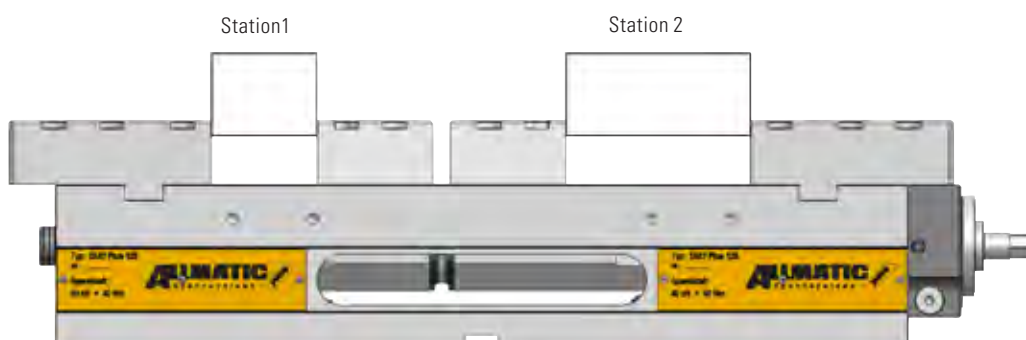


# CLAMPING RANGES – DUO PLUS 125

With symmetrical spindle position



With loaded spindle position



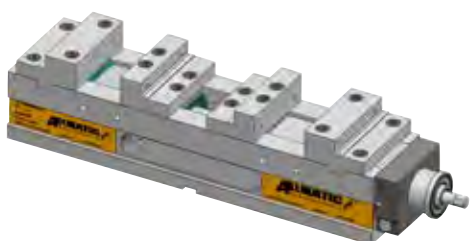
## Clamping range adjustment

For the first time, the new DUO Plus 125 enables you to adjust the clamping range by changing the spindle position. This makes it possible to clamp workpieces of different sizes. The greatest workpiece differences are reached when using the support jaws in combination with the universal gripper set.

In view of the endless clamping combination possibilities, we have developed a **clamping width calculator** for you. All you need to do is enter the type and size of the workpiece. The program then suggests a complete range of clamping possibilities. This includes the recommendation for jaws with grippers, the requirement to adjust the spindle, and a detailed description of the clamping set-up. Visit us at:

[www.allmatic.de](http://www.allmatic.de)

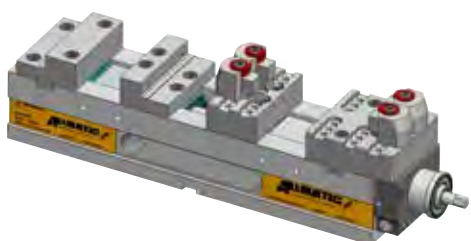
# CLAMPING RANGES – DUO PLUS 125



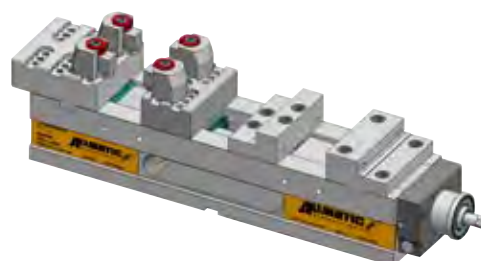
	Station 1	Station 2
Clamping ranges	0 – 89 mm	0 – 89 mm
Clamping ranges with spindle adjustment	0 – 64 mm	50 – 114 mm



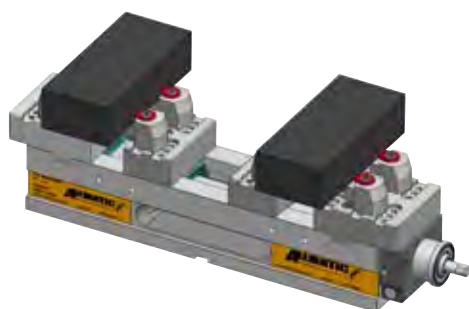
	Station 1	Station 2
Clamping ranges	82 – 172 mm	82 – 172 mm
Clamping ranges with spindle adjustment	43 – 147 mm	93 – 197 mm



	Station 1	Station 2
Clamping ranges	0 – 89 mm	10 – 202 mm
Clamping ranges with spindle adjustment	0 – 64 mm	60 – 225 mm



	Station 1	Station 2
Clamping ranges	10 – 202 mm	0 – 89 mm
Clamping ranges with spindle adjustment	10 – 175 mm	93 – 197 mm



	Station 1	Station 2
Clamping ranges	10 – 202 mm	10 – 202 mm
Clamping ranges with spindle adjustment	10 – 175 mm	60 – 225 mm



	Station 1	Station 2
Clamping ranges	∅ 60 – 220 mm	60 – 220 mm
Clamping ranges with spindle adjustment	∅ 60 – 190 mm	80 – 240 mm



## IMPORTANT

Combining the clamping ranges at Station one and Station two is not always possible when the spindle is adjusted!

Use our clamping range calculator at: [www.allmatic.de](http://www.allmatic.de)

# APPLICATION EXAMPLES – DUO PLUS 125

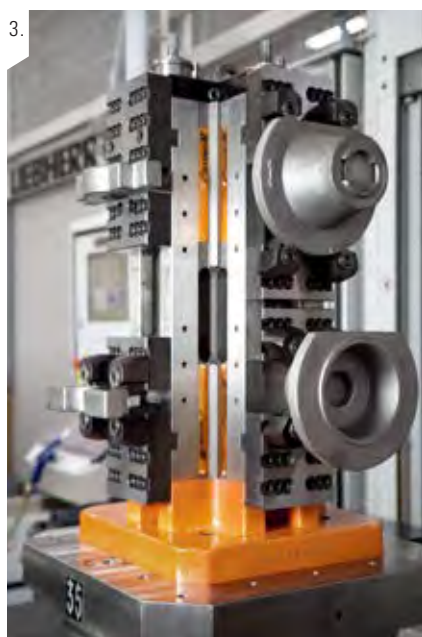
1.



2.



# APPLICATION EXAMPLES – DUO PLUS 125



## Application examples

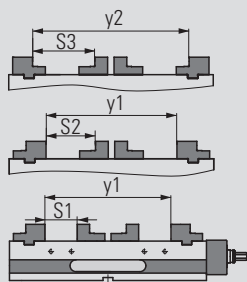
1. First and second clamping of a round casting with different diameters on support jaws and using the universal gripper set.
2. Complete machining of a workpiece in a second clamping by combining the clamping of unmachined parts and conventional clamping.
- 3.– 5. Wide variety of clamping possibilities with the DUO Plus 125 as a monobloc with step jaws, support jaws with the universal gripper set, and soft inserts.

## ALLMATIC GRIPP – mechanical / DUO Plus 125 version (accessories)

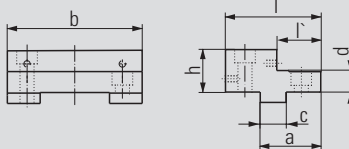
### Step jaws



- Material: hardened steel
- Ground and polished clamping surfaces
- High and step sides with thread for parallels

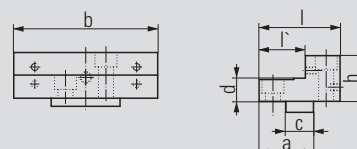


Order no. fixed:  
6921484006731



Jaw width	125	
Dimensions in mm	a	55
	b	124.4
	c	24
	d	20
	h	39.5
	l	87
	l'	42

Order no. movable:  
6921484002731



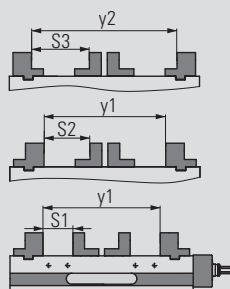
Jaw width	125	
Dimensions in mm	a	47
	b	124.4
	c	24
	d	20
	h	39.5
	l	70
	l'	40

y1	331
y2	417
Clamping range S1	0 – 89
Clamping range S2	40 – 129
Clamping range S3	82 – 172

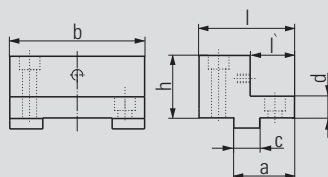
### Master jaw adapters



- Material: hardened steel
- High side of jaw hardened
- Additional thread on the high clamping surface for mounting the HD jaws
- Ground and polished clamping surfaces
- Click system on the high side

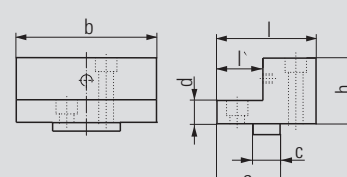


Order no. fixed:  
6921284012131



Jaw width	125	
Dimensions in mm	a	77
	b	126
	c	24
	d	20
	h	58
	l	85
	l'	32

Order no. movable:  
6921284012131

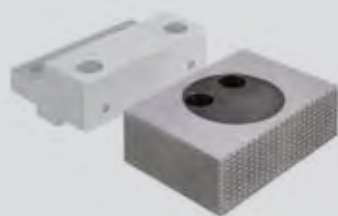


Jaw width	125	
Dimensions in mm	a	52
	b	126
	c	24
	d	20
	h	58
	l	80
	l'	32

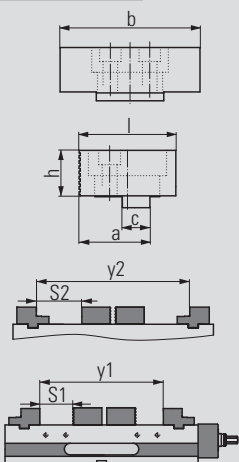
y1	331
y2	401
Clamping range S1	0 – 84
Clamping range S2	28 – 117
Clamping range S3	66 – 151

## ALLMATIC GRIPP – mechanical / DUO Plus 125 version (accessories)

### Pivot jaw, movable



- Material: hardened steel
- With Click-System
- One side smooth, ground and polished; one side serrated
- Rotatable through 360°
- Picture with step jaw (see order no. 2530)



Order no. 6921684020042

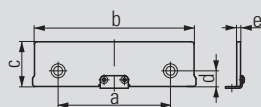
Jaw width	125	
Dimensions in mm	a	62
	b	124.4
	c	24
	h	39.5
	l	84

y1	331
y2	417
Clamping range S1	0 – 74
Clamping range S2	42 – 117

### Click parallels (pair)



- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels with Click system
- For the high side of the jaws



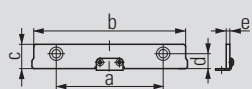
Order no. 6921185035042

Jaw width	125	
Dimensions in mm	a	88
	b	125
	c -0.01	35
	d	12.25
	e	3

### Click parallels (pair)



- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels with Click system
- For the high side of the jaws



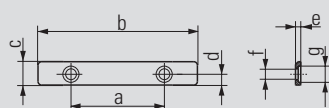
Order no. 6921185020042

Jaw width	125	
Dimensions in mm	a	88
	b	125
	c -0.01	20
	d	12.25
	e	3

### Parallels (pair)



- For parallel raising of workpieces
- Hardened and ground parallels
- Screw-fastened parallels
- For the step side of the jaws



Order no. 6921485015031

Jaw width	125	
Dimensions in mm	a	88
	b	124
	c	15
	d	6
	e	3
	f	Ø 6
	g	Ø 9

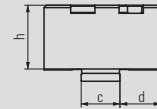
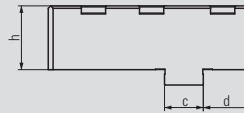
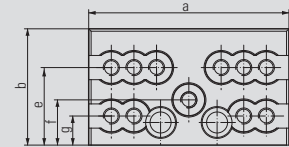
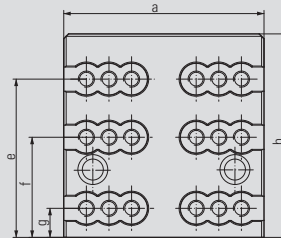


**ALLMATIC GRIPP – mechanical / DUO Plus 125 version (accessories)**

**Support jaws for universal gripper set**

**Order no. fixed:**  
6921484005042

**Order no. movable:**  
6921484004042

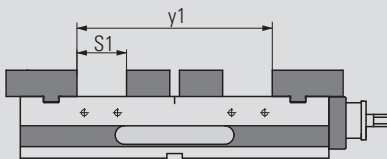


- Material: hardened steel
- For mounting the universal gripper set and the prismatic gripper
- For clamping unmachined parts
- For clamping pre-machined workpieces
- Front surface can be used as clamping surface
- Use of the Click system
- Universal gripper set **not** included



Jaw width		125
Dimensions in mm	a	124
	b	126
	c	24
	d	30
	e	98
	f	62
	g	18
	h	39.5

Jaw width		125
Dimensions in mm	a	124
	b	72
	c	24
	d	25
	e	48
	f	28
	g	18
	h	39.5



y1	335
Clamping range S1	0 – 89

**The clamping range dimensions change due to spindle adjustment!**

**Soft jaws**

**Order no. available on request**

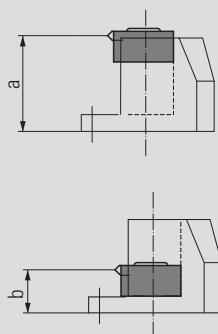


- For mounting onto the support jaws



## ALLMATIC GRIPP – mechanical / DUO Plus 125 version (accessories)

### Universal gripper set



Order no. 6921884027031

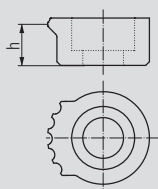
Jaw width	125	
Dimensions in mm	a	40
	b	18

- For clamping complex unmachined parts
- The individual elements of the universal gripper set can be reworked in order to vary both gripper height and support height of the workpiece

Comprising:

- 4 x gripper studs 6921884026000
- 4 x gripper stud mounts 6921884072000
- 4 x supports 6921884028000
- 8 x shims
- Support bolts
- M10 fastening bolts in various lengths
- M6 threaded pins in various lengths
- Socket screw wrench
- Storage case

### Gripper stud

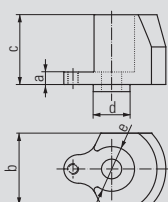


Order no. 6921884026000

Dimensions in mm	h	11
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- Gripper stud for universal gripper set

### Gripper stud mount

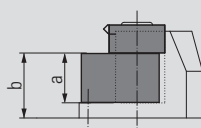
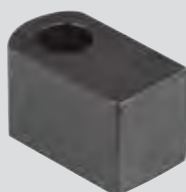


Order no. 6921884027000

Dimensions in mm	a	7
	b	40
	c	39
	d	Ø 20
	e	Ø 25

- Mount for gripper stud 6921884026000

### Support



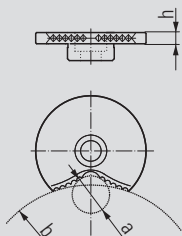
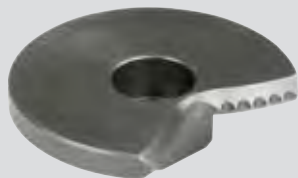
Order no. 6921884028000

Dimensions in mm	a	22
	b	29

- Support for universal gripper set

## ALLMATIC GRIPP – mechanical / DUO Plus 125 version (accessories)

### Prismatic gripper

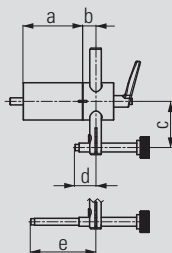


Order no. 6921884029031

Dimensions in mm	a	Ø 20
	b	Ø 120
	h	6

- Replaces gripper stud 6921884026000 in the universal gripper set
- Special shape distributes the applied clamping force – particularly advantageous for clamping workpieces that require fits to be made

### Workpiece stop

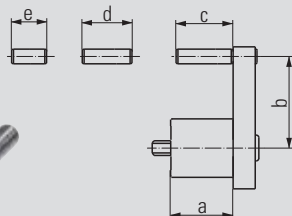
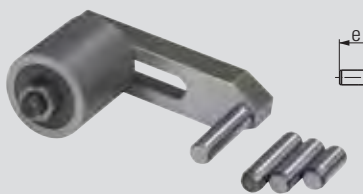


Order no. 6921285650144

Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Position of the third workpiece axis can be preset and clamped  
Workpiece stop can be swivelled away once the workpiece has been clamped
- This allows the stop side of the workpiece to also be machined (repeating accuracy:  $\pm 0.01$ )

### Workpiece stop



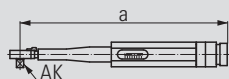
Order no. 6921685670042

Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Can be pre-mounted with various fixed dimensions
- Position of the third workpiece axis can be preset

## ALLMATIC GRIPP – mechanical / DUO Plus 125 version (accessories)

### Torque wrench

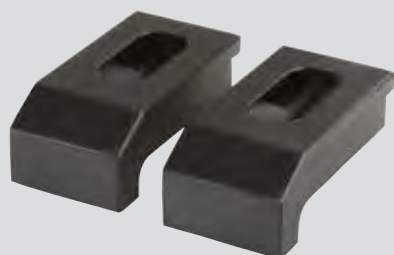


Order no. 0651114113188

Dimensions in mm	a	307
	AK (Drive square)	3/8"

- Can be preset to 10 – 60 Nm
- For use on the high-pressure gripper spindle DUO Plus 125

### Side clamps (pair)



Order no. 6921025000031

- For securing the vice on the machine table
- Supplied as a set of 2 items

### Aligning and fixing set



Order no. – see table

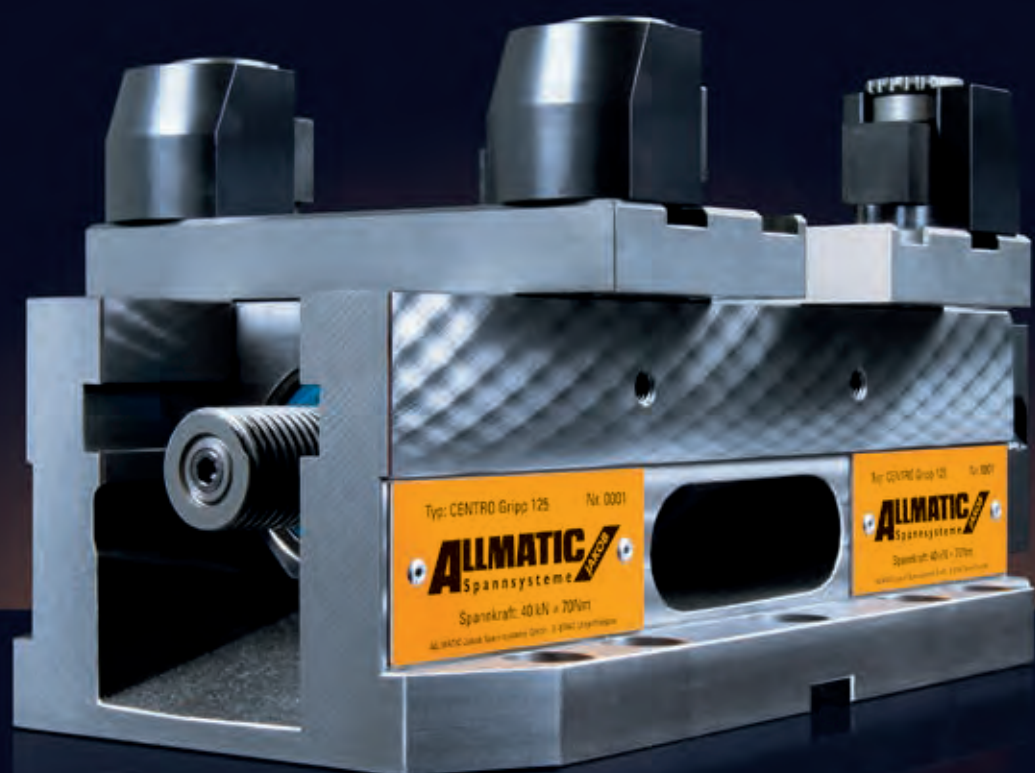
T-slot/ Thread	Cat. no.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

- For aligning (positioning) and securing the vice on the machine table
- Size according to T-slot or thread in the machine table

# ALLMATIC CENTRO GRIPP – FOR CENTRAL GRIPPING

Our „all-rounder“ stands out for its superb precision and durability. Central clamping of workpiece – for conventional clamping and clamping of unmachined parts. Ideal for five-sided machining.





# ALLMATIC GRIPP – MECHANICAL CENTRO GRIPP VERSION

## Scope of application:

- Horizontal installation – suitable for vertical CNC milling machines
- Ideal for use on five-axis machining centres due to its compact design
- Depending on the clamping jaws, both pre-machined workpieces and unmachined parts can be clamped
- With support jaws, unmachined parts with varying types of flame-cut and sawn materials and even complex castings can be clamped safely and economically. Gripper studs suitable for materials of mechanical strength of up to approx. 1000 N/mm<sup>2</sup>.



## Product features:

- The centre is adjustable. The position of the workpiece stays within set boundaries.
- Repeating accuracy  $\pm 1/100$  mm for angled workpieces
- Guides ground, polished and paired
- Clamping range presetting via adjustment of clamping jaws along transverse slots of spindle nuts
- Moulding and clamping in a single step, directly in the work area – no auxiliary aids required
- Use with a torque wrench – max. 70 Nm
- Fully enclosed and maintenance-free high-pressure spindle – high chip protection, minimum cleaning requirements, constant clamping forces up to 40 kN

Robust and compact base made of GGG 60

M8 thread for workpiece stop

Inductively hardened, ground and polished guideway

Holes in the clamping shoulder for fastening to the machine table itself

Precision aligning slots and a positioning hole in the bottom surface for optimal alignment on the machine table

Outlet for coolant and chips

**Order No.**  
**jaw width 125: 6921538000055**

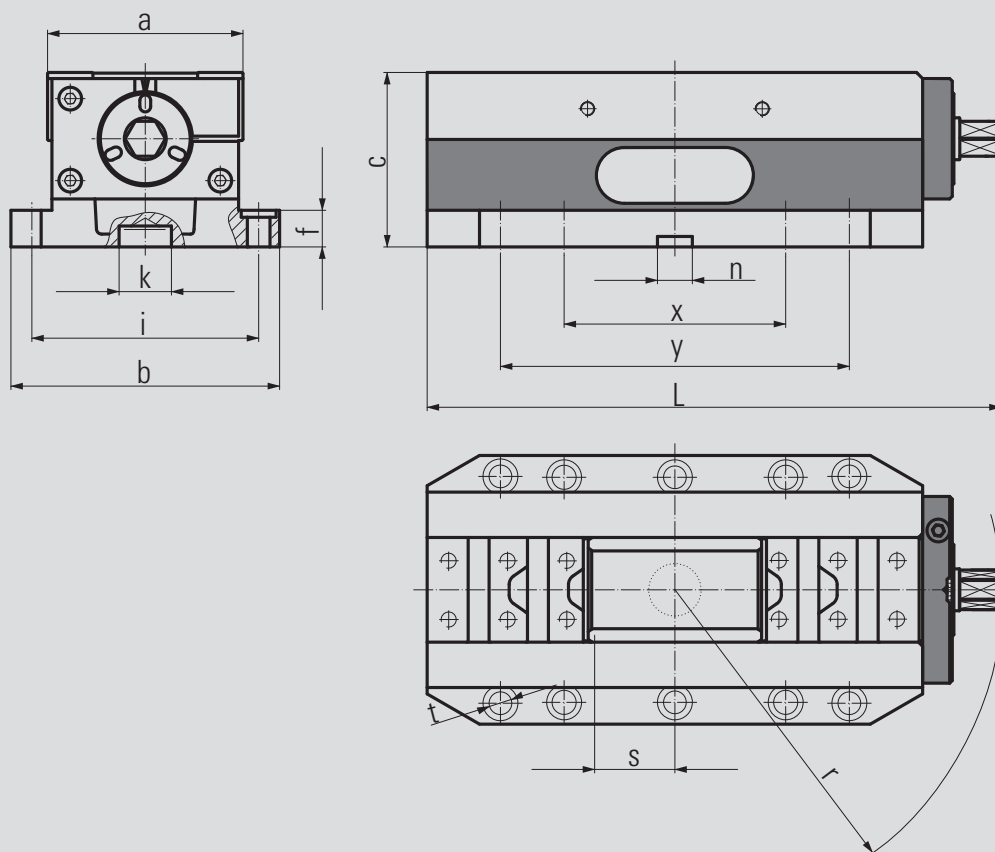
## Scope of delivery:

- 1 high-pressure vice without jaws
  - 2 combination wrenches
  - 6 fastening screws, M12 x 35 mm
  - 2 socket screw wrenches
  - 1 wrench socket
- (Please order clamping jaws separately)

## Note:

Delivery does not include a torque wrench (see accessories).  
An overview of the clamping jaws and other accessories is given on the following pages.





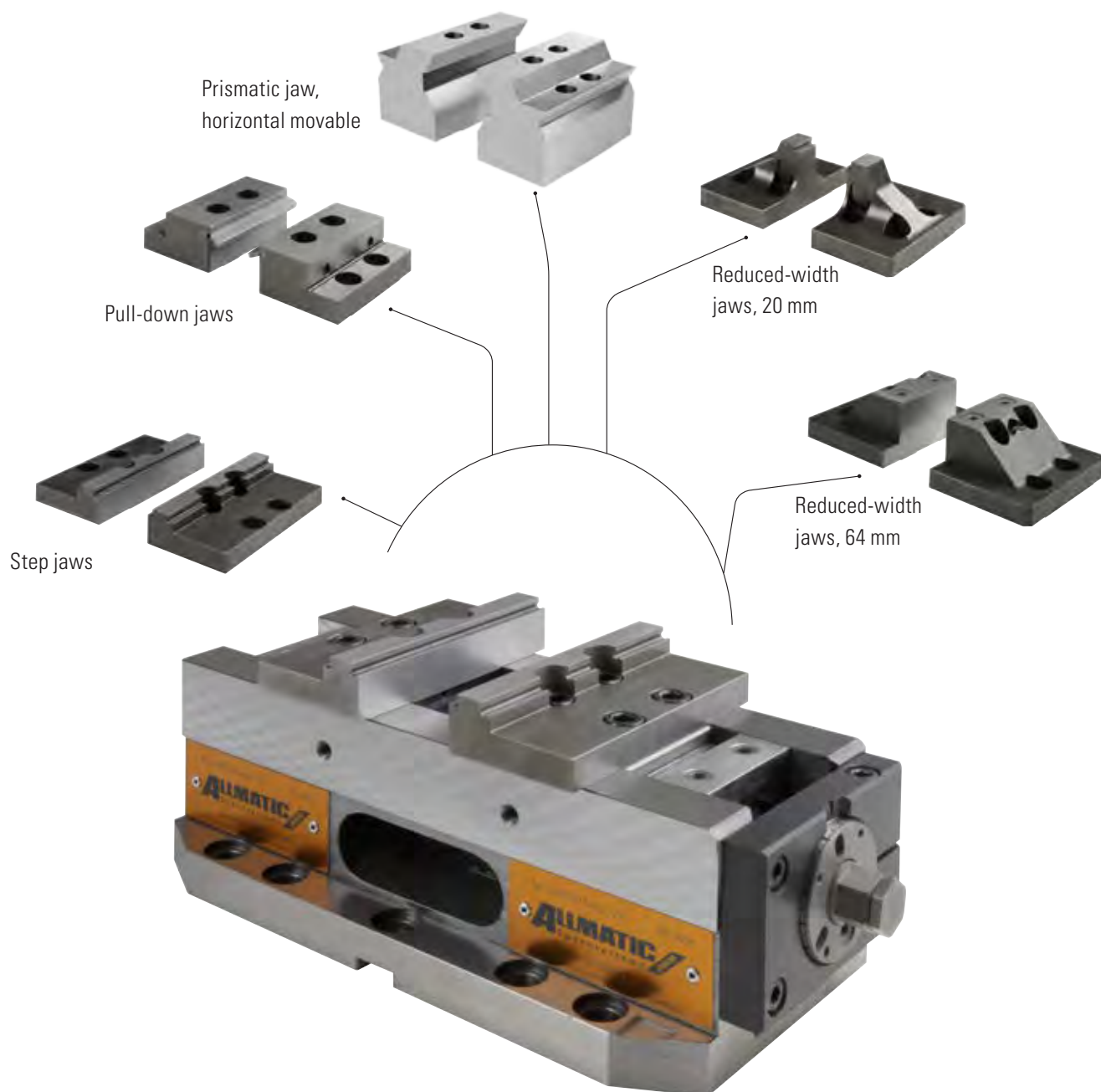
## Technical data

Jaw width	125	
Dimensions / tolerances in mm	a	112
	b	154
	c	100
	f	21
	i	129/130
	k	Ø 30 H8
	L	329
	n	20 H7
	r	182
	s (traverse)	46
	t	Ø 13
	y	200

Jaw width	125
Max. torque in Nm	70
Max. clamping force in kN	40
Weight in kg	20,7

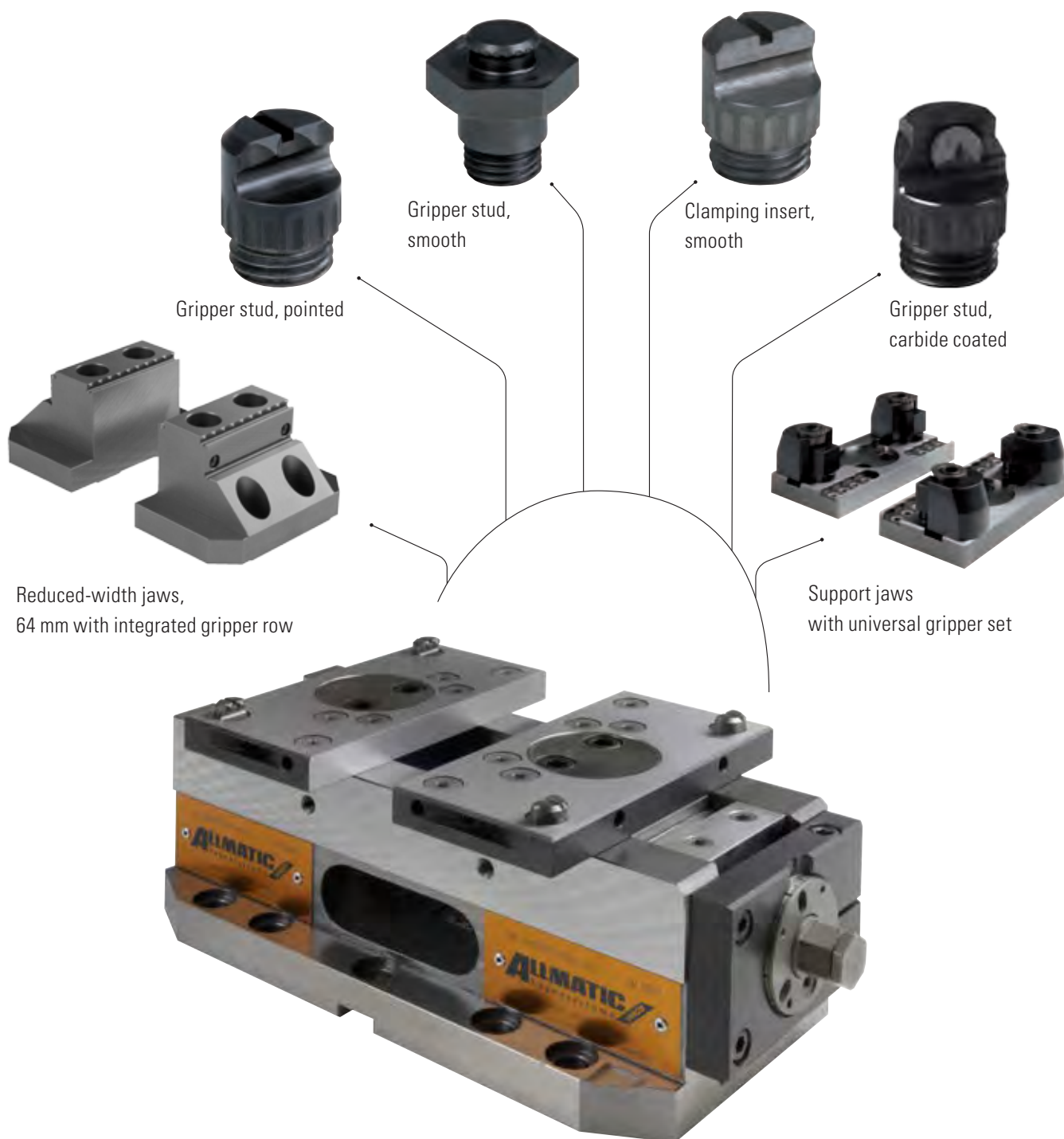


# ALLMATIC GRIPP – MECHANICAL/CENTRO GRIPP



## For conventional clamping of workpieces

On the following pages you will find a wide range of jaws suitable for clamping pre-machined workpieces.



### For clamping complex unmachined parts

Varying types of unmachined parts can be clamped quickly and securely using the support jaws and the reduced-width jaws. Jaws for gripper clamping can be found on the following pages.

### Gripper clamping:

- Support jaws are used to mount different gripper studs (threaded gripper studs or universal gripper set)
- Gripper studs can be screwed onto grid plates in variable positions to securely clamp a wide variety of workpiece geometries
- Additional pivot function of the support jaws compensates for non-parallel clamping surfaces and is required to clamp uneven workpieces

# CLAMPING RANGES – CENTRO GRIPP

## Support jaws with gripper studs

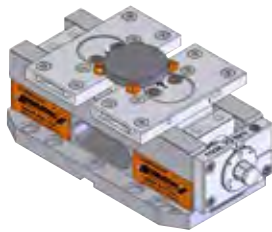
You can find the clamping ranges of the other jaws for conventional clamping on the following pages of accessories.



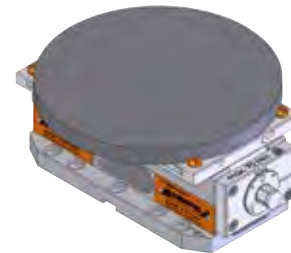
Min. clamping range	25 mm
Min. clamping width	73 mm



Max. clamping range	247 mm
Max. clamping width	at least 150 mm or larger



Min. clamping range	Ø 80 mm
---------------------	---------

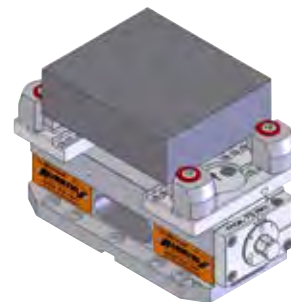


Max. clamping range	Ø 250 mm
---------------------	----------

## Support jaws with universal gripper set



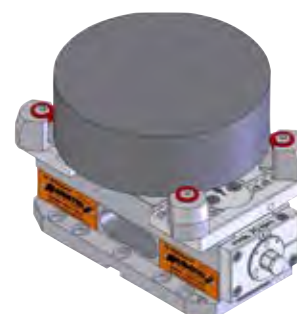
Min. clamping range	0 mm
Min. clamping width	90 mm



Max. clamping range	195 mm
Max. clamping width	at least 165 mm or larger

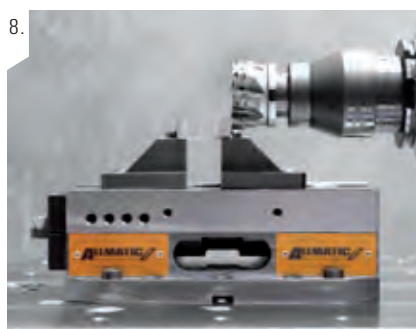


Min. clamping range	Ø 100 mm
---------------------	----------



Max. clamping range	Ø 230 mm
---------------------	----------

# APPLICATION EXAMPLES – CENTRO GRIPP



## Application examples

1. – 3. Flexible – from the unmachined part through to the finished product

Supports complete machining – from the reliable positive-locking clamping of unmachined parts by means of our tried and tested gripper technology through to the clamping of the machined part in smooth jaws or studs on modern CNC machines with just a single clamping device. Reliable clamping of large workpieces (even for heavy-duty machining work) thanks to the power spindle

4. Flexible gripper studs combined with pivot jaws enable reliable clamping of unmachined parts of very diverse geometries and materials

5. The concentric function enables clamping of unmachined parts of small dimensions. The clamping of unmachined parts is fast, simple and, above all, reliable thanks to the use of tried and tested components

6. – 7. Reliable positive-locking clamping with defined clamping force on clamping edge loss for five-sided machining, irrespective of whether the part is round or angular

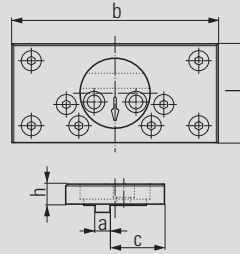
8. – 9. Optimum accessibility to the workpiece from all five sides with standard tools

## ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

### Support jaws for gripper studs



Order No. movable, pivot (1 piece): 6921884072042



- Material: hardened steel
- For mounting various studs (pointed/smooth)
- Front surface can be used as clamping surface (hardened, ground and polished)
- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- If using 2 pivot jaws, one pivot jaw must be manually aligned and blocked
- Studs (pointed/smooth) **not** included

Jaw width	125
Dimensions in mm	
a	12
b	165
c	43.5
h	16
l	79



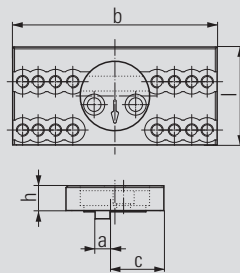
Dimensions of the individual items of the gripper set can be found at [www.allmatic.de](http://www.allmatic.de)

Please order gripper studs separately.

### Support jaws for universal gripper set



Order No. movable, pivot (1 piece): 6921884072242



- Material: hardened steel
- For mounting the universal gripper set
- Front surface can be used as clamping surface (hardened, ground and polished)
- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- If using 2 pivot jaws, one pivot jaw must be manually aligned and blocked
- Studs (pointed/smooth) **not** included

Type	125
Dimensions in mm	
a	12
b	165
c	35.5
h	20
l	79

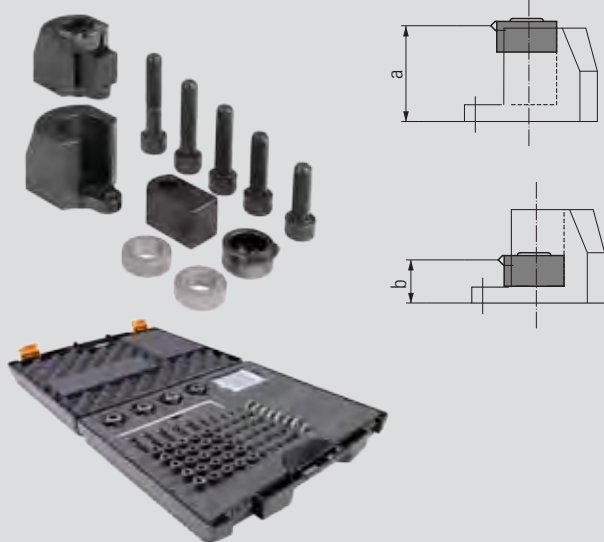


Dimensions of the individual items of the gripper set can be found at [www.allmatic.de](http://www.allmatic.de)

Please order universal gripper set separately.

## ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

### Universal gripper set



Order no. 6921884027031

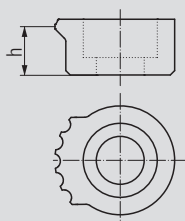
Jaw width	125	
Dimensions in mm	a	40
	b	18

- For clamping complex unmachined parts
- The individual elements of the universal gripper set can be reworked in order to vary both gripper height and support height of the workpiece

Comprising:

- 4 x gripper studs 6921884026000
- 4 x gripper stud mounts 6921884072000
- 4 x supports 6921884028000
- 8 x shims
- Support bolts
- M10 fastening bolts in various lengths
- M6 threaded pins in various lengths
- Socket screw wrench
- Storage case

### Gripper stud

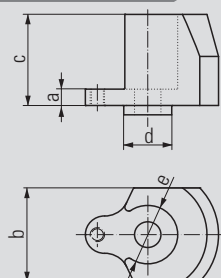


Order no. 6921884026000

Dimensions in mm	h	11
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- Gripper stud for universal gripper set

### Gripper stud mount

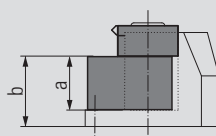
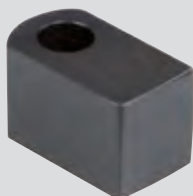


Order no. 6921884027000

Dimensions in mm	a	7
	b	40
	c	39
	d	Ø 20
	e	Ø 25

- Mount for gripper stud 6921884026000

### Support



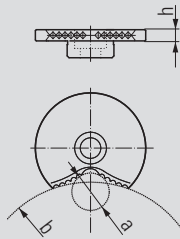
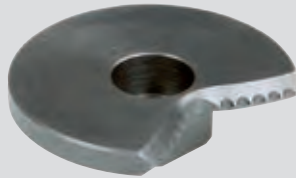
Order no. 6921884028000

Dimensions in mm	a	22
	b	29

- Support for universal gripper set

## ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

### Prismatic gripper

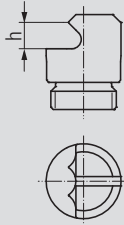


Order no. 6921884029031

Dimensions in mm		
a	Ø 20	
b	Ø 120	
h	6	

- Replaces gripper stud 2306/001 in the universal gripper set
- Special shape distributes the applied clamping force – particularly advantageous for clamping workpieces that require fits to be made

### Gripper stud, pointed

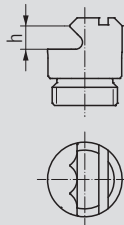


Order no. 6921884036000

Dimensions in mm		
h	5.5	

- For clamping unmachined parts
- Minimum clamping edge loss
- Clamping height: adjustable from 4.5 to 6.0 mm

### Gripper stud, low-level

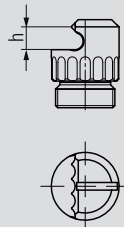


Order no. 6921884036100

Dimensions in mm		
h	5	

- For clamping unmachined parts
- Minimum clamping edge loss
- Clamping height: adjustable from 3.0 to 4.5 mm

### Gripper stud, four-point

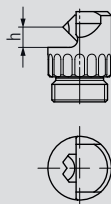


Order no. 6921884036500

Dimensions in mm		
h	5,4	

- For clamping unmachined parts
- For soft materials like aluminum
- Minimum clamping edge loss
- Clamping height: adjustable from 4.5 mm to 6.0 mm

### Gripper stud, carbide coated



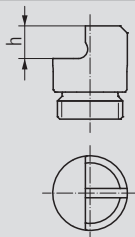
Order no. 6921884036841

Dimensions in mm		
h	5,1	

- For clamping unmachined parts
- For high quality coated materials and flame cuts
- Minimum clamping edge loss
- Clamping height: adjustable from 4.2 mm to 5.7 mm

## ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

### Clamping insert, smooth

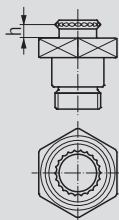


Order no. 6921884037000

Dimensions in mm	h	7
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- With carbide coating for clamping pre-machined or hardened workpieces

### Gripper stud, round



Order no. 6921884038000

Dimensions in mm	h	4
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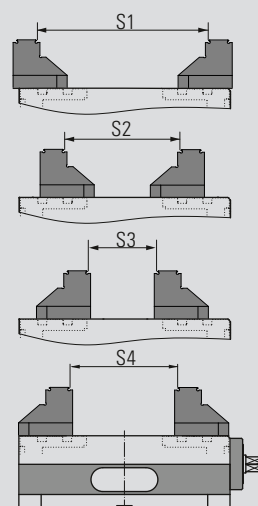
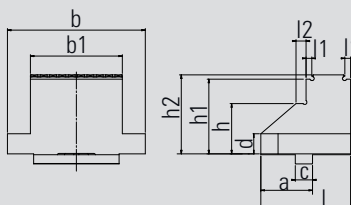
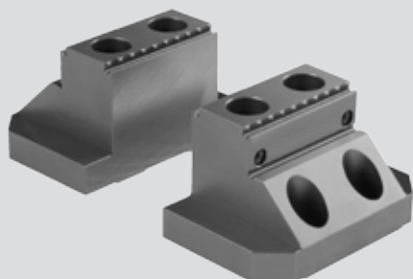
- For clamping unmachined parts
- For through-drilling close to the edge
- Offers 6 mm space below workpiece



## ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

### Jaw 64 mm, with integrated gripper row

Order no. movable: 6921534036031



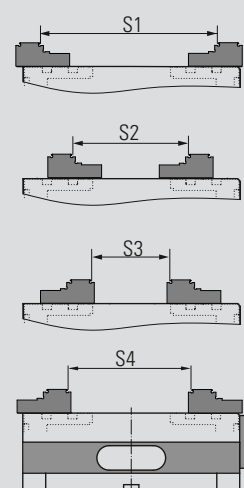
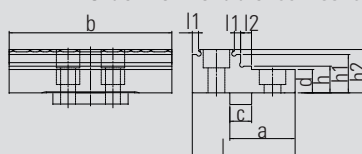
- For rectangular workpieces (sawn material)  $\leq 0.5$  mm
- Rigid design to prevent vibrations when parts are clamped upright
- Additional clamping surfaces, ground on both sides
- For five-sided machining, ensuring best possible accessibility to the workpiece
- Positive locking through penetration of the centres into the material
- Minimal lost clamping margin of approx. 3 mm.
- Suitable for material strength of up to 1000 N/mm<sup>2</sup>

Jaw width		125
Dimen- sions in mm	a	36
	b	96
	b1	64
	c	12
	d	14
	h	35
	h1	52
	h2	55
	l	62,5
	l1	4
l2	7	

Clamping range S1	146 - 229
Clamping range S2	78 - 161
Clamping range S3	10 - 93
Clamping range S4	78 - 161

### Jaw with integrated gripper row

Order no. movable: 6921534036931



- For rectangular workpieces (sawn material)  $\leq 0.5$  mm
- Rigid design to prevent vibrations when parts are clamped upright
- Additional clamping surfaces, ground on both sides
- For five-sided machining, ensuring best possible accessibility to the workpiece
- Positive locking through penetration of the centres into the material
- Minimal lost clamping margin of approx. 4 mm.
- Suitable for material strength of up to 1000 N/mm<sup>2</sup>

Jaw width		125
Dimen- sions in mm	a	34
	b	118
	c	12
	d	14
	h	16
	h1	23
	h2	26
	l	60,6
	l1	4
	l2	7

Clamping range S1	146 - 229
Clamping range S2	78 - 161
Clamping range S3	10 - 93
Clamping range S4	78 - 161

## ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

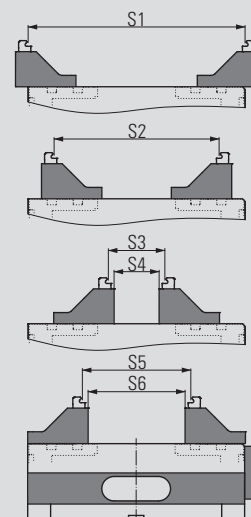
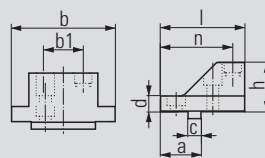
### Reduced-width jaws 64 mm



- Material: hardened steel
- Allows unhindered access to the workpiece, even with short tools
- For clamping small to medium-sized workpieces
- The clamping of unmachined parts (incl. round material) is supported via 2 adjustable gripper studs in each case
- Front surface can be used as clamping surface (hardened, ground and polished)
- Gripper Studs (pointed/smooth) **not** included

Please order gripper studs separately

Order no. movable: 6921884040040



Jaw width	125	
Dimensions in mm	a	37.5
	b	96
	b1	37
	c	12
	d	14
	h	45
	l	79
	n	67

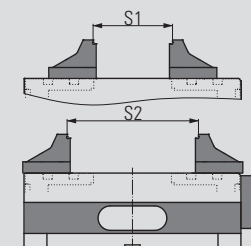
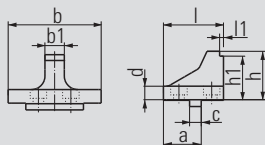
Clamping range S1	196 – 284
Clamping range S2	128 – 216
Clamping range S3	21 – 74
Clamping range S4	0 – 59
Clamping range S5	54 – 142
Clamping range S6	41 – 127

### Reduced-width jaws 20 mm



- Material: hardened steel
- For clamping parallel pre-machined small workpieces
- Further enhanced accessibility to the workpiece thanks to slim, tall shape – also optimal for short tools
- Front surface (step) additionally carbide-coated to ensure secure clamping – this increases the holding force by a factor of at least 2 compared to smooth clamping surfaces

Order no. movable: 6921884041041



Jaw width	125	
Dimensions in mm	a	39
	b	96
	b1	20
	c	12
	d	14
	h	50
	h1	45
	l	62
	l1	4

Clamping range S1	19 – 104
Clamping range S2	86 – 172

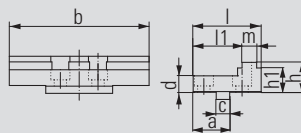
## ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

### Step jaws, carbide-coated

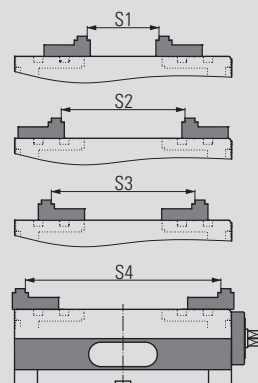


- Material: hardened steel
- For clamping parallel pre-machined workpieces
- Clamping surfaces (step) additionally carbide-coated to ensure secure clamping – this increases the holding force by a factor of at least 2 compared to smooth clamping surface

Order no. movable: 6921884002041



Jaw width	125	
Dimensions in mm	a	32.5
	b	124.4
	c	12
	d	14
	h	26
	h1	21
	l	60.5
	l1	43.5
	m	13



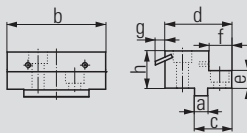
Clamping range S1	9 – 94
Clamping range S2	76 – 162
Clamping range S3	102 – 188
Clamping range S4	170 – 256

### Universal pull-down jaws

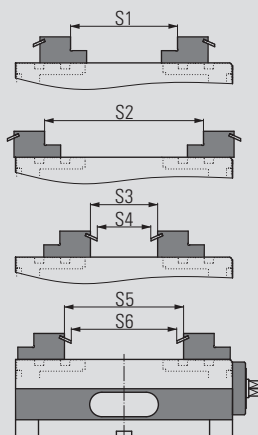


- Material: hardened steel
- Reduced-width jaws 90 mm
- Ground and polished clamping surfaces
- Pull-down with ground and polished spring leaves for machined and unmachined clamping surfaces
- 1-Click spring leaves
- High clamping accuracy for parallel and accurate angle machining

Order no. movable: 6921884102031



Jaw width	125	
Dimensions in mm	a	12
	b	90
	c	34
	d	61
	e	16
	f	21
	g	8.8
	h	34



Clamping range S1	54 – 140
Clamping range S2	122 – 208
Clamping range S3	0 – 88
Clamping range S4	0 – 72
Clamping range S5	70 – 156
Clamping range S6	54 – 138

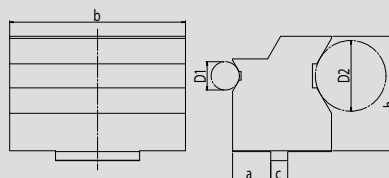
## ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

### Prismatic jaw, horizontal movable



- Prism angle 120° - shaft height 53 mm on both sides
- Hardened and ground
- Jaws open far enough to allow the workpiece to be removed from above – even at maximum diameter
- Ideally suited for machining keyways on stepped shafts, for example, using two vices side-by-side

Order no. movable: 6921534001031



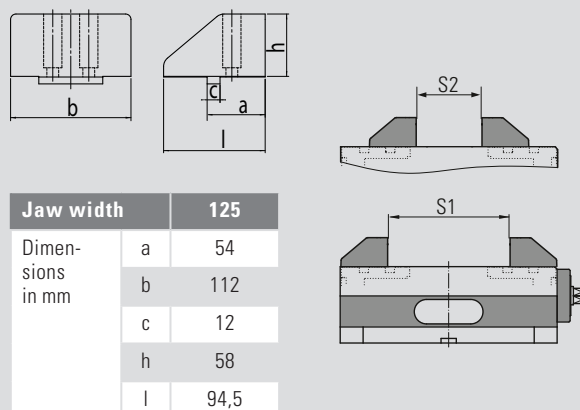
Jaw width	125	
Dimensions in mm	a	27
	b	124,4
	c	12
	h	81
	D1	ø 17 - 42
	D2	ø 38 - 104

### Soft jaw movable



- Material: GGG40
- For production of special jaws by the customer
- Chamfer provides very good accessibility to the workpiece

Order no. movable: 6921534087031



Jaw width	125	
Dimensions in mm	a	54
	b	112
	c	12
	h	58
	l	94,5

Clamping range S1	0 - 58
Clamping range S2	40 - 126

## ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

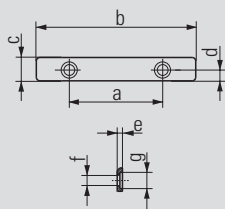
### Spring leaves (pair)



Order no. 6921884103031

- Hardened spring leaves
- Spring leaves (spare) for the pull-down jaws (see page 140 below)

### Parallels (pair)



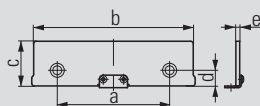
Order no. 6921475013031

Jaw width		90
Dimensions in mm	a	52
	b	89
	c	13
	d	6
	e	3
	f	Ø 6
	g	Ø 9

- Suitable only for the universal pull-down jaws
- For parallel raising of workpieces
- Hardened, ground and polished parallels

- Bolt-on parallels
- For the high side of the jaws

### Click parallels (pair)



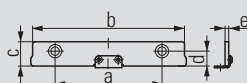
Order no. 6921175029042

Jaw width		90
Dimensions in mm	a	48
	b	90
	c	29
	d	8.75
	e	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels

- Parallels with Click system
- For the high side of the jaws

### Click parallels (pair)



Order no. 6921175016042

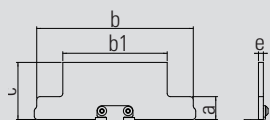
Jaw width		90
Dimensions in mm	a	48
	b	90
	c	16
	d	8.75
	e	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels

- Parallels with Click system
- For the high side of the jaws

## ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

### Click parallels (pair)



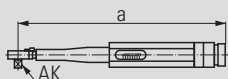
- For parallel raising of workpieces
- Hardened, ground and polished parallels

Order no. 6921535035042

Jaw width	90	
Dimensions in mm	a	14
	b	96
	b1	64
	c	35
	e	3

- Parallels with Click system
- For the high side of jaw

### Torque wrench

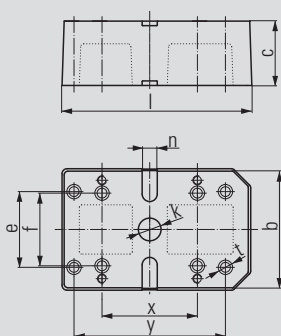


Order no. 0651114113153

Dimensions in mm	a	410
	AK (Drive square)	1/2"

- Can be preset to 20 – 120 Nm
- Only for use on the CENTRO Gripp high-pressure gripper spindle
- Use a smaller torque wrench for more precise presetting of the spindle power

### Console



Order no. 6921885009042

Jaw width	125	
Dimensions in mm	b	154
	c	85
	e	100
	f	96
	l	250
	n	20 H7
	k	Ø 30 H7
	t	13
	x	125,5
	y	200

- Material: GG30
- For raising the CENTRO Gripp 125
- Improved access for five-sided machining
- The mounting hole pattern of CENTRO Gripp and console is offset slightly in order to enable mounting in tables with parallel T-slots as well as in tables with cross slots.

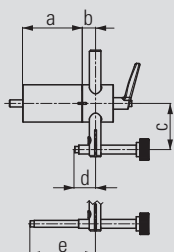
Scope of supply:

- Console incl. fixing bolt
- 2 socket screw wrenches
- 4 bolts

## ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

### Workpiece stop

Order no. 6921285650144



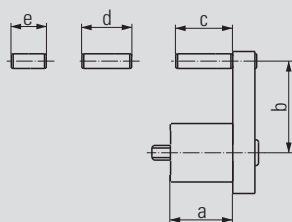
Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

- Can be mounted on either side of the vice at the designated positions
- M8 fastening thread
- Position of the third workpiece axis can be preset and clamped
- Workpiece stop can be swivelled away once the workpiece has been clamped
- This allows the stop side of the workpiece to be machined as well.  
(Repeating accuracy:  $\pm 0.01$ )



### Workpiece stop

Order no. 6921685670042



Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Can be pre-mounted with various fixed dimensions
- Position of the third workpiece axis can be preset



## ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

### Aligning and fixing set

Order no. – see table



T-slot/ Thread	Order No.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

- For alignment (positioning) and for mounting the vice on the pallet and the machine table
- Size according to T-slot or thread in the machine table





# TOMBSTONES FOR HORIZONTAL MACHINING

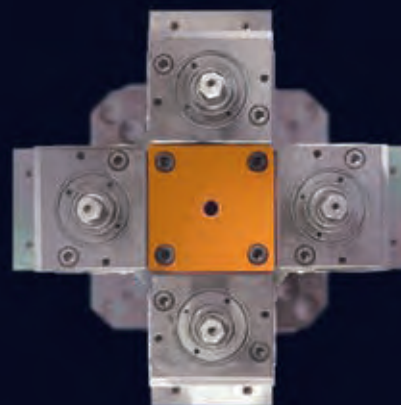
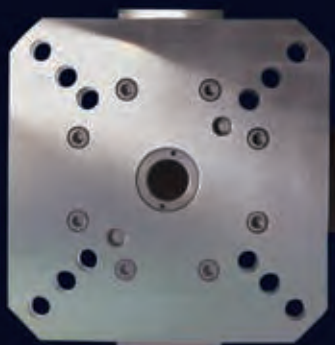
In addition to our standard products, ALLMATIC offers a wide range of customised solutions, each of which can be individually tailored to your machine, workpiece and machining techniques.

**The majority of these solutions are monoblocs and set-ups.**

- Monoblocs are made from a single piece, are long-time gas nitrated and ground and polished on all sides. This ensures a very high stability and produces optimal machining results.
- Set-ups are tombstones comprising several standard vices.

The base plates are suitably adapted to ensure exact positioning on the machine table or on a pallet. According to your requirements, we can manufacture base plates with an elevation, with a different spacing of the mounting holes, with a centering mechanism (possibly with a second index) or with a JIS stop system.

To give you even greater flexibility, we will manufacture special clamping jaws adapted to the geometry of your workpieces. Similarly, in customised solutions, the clamping force of the spindles can be adapted to suit your machining requirements. In addition to the set-ups for conventional clamping, we can also offer you solutions for clamping unmachined parts. For this, we employ the functions of our tried and tested T-REX, TITAN and DUO Plus 125 vices.



The set-ups described on the following pages are just a few examples of already realised clamping solutions. We shall be pleased to provide you with a customised solution – let us know your requirements!

# MONOBLOC – 3 x 120° SINGLE TITAN 2

## Scope of application:

- Modular clamping system for horizontal machining centres

## Product features:

- High stability from base cast as one piece-maximum precision or workpiece machining
- Very good accessibility, even with large workpieces
- Conventional clamping, gripper clamping or pull-down clamping are all possible (see TITAN 2)
- High-pressure spindle with mechanical power-transfer device
- Stepless adjustment of the clamping force with torque wrench
- Individual adaptation to your machine (pallet, traverses and workpieces) is possible
- Three clamping points permit three-sided machining



Clamping is carried out using a torque wrench - max. 30 Nm

Accurate spindle nut guidance

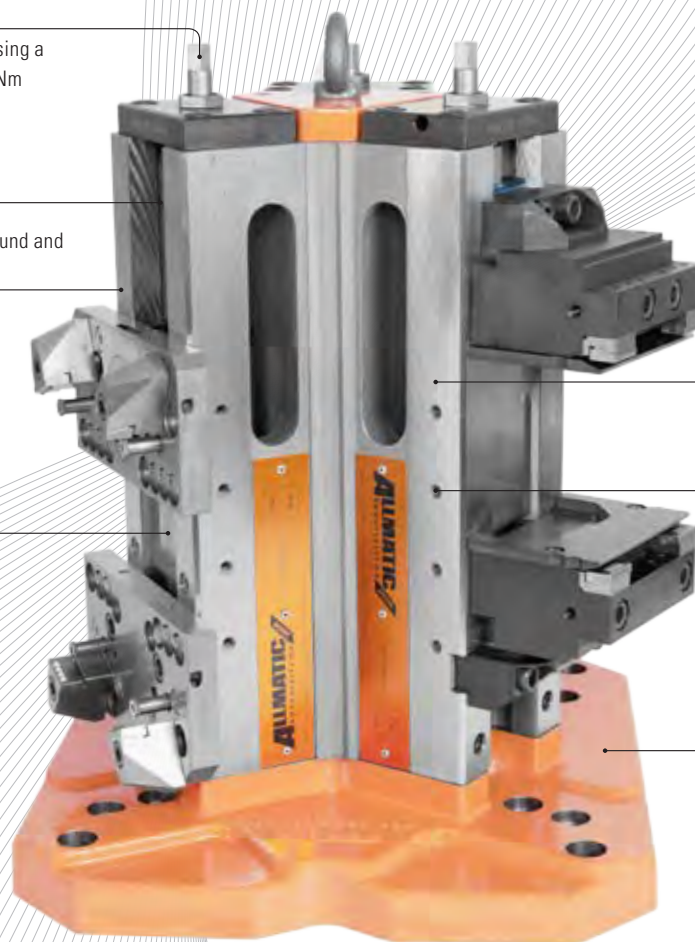
Inductively hardened, ground and polished guideway

Rigid spindle nut

Robust base made of GGG 60

M8 thread for workpiece stop


Base plate can be adapted to suit your requirements



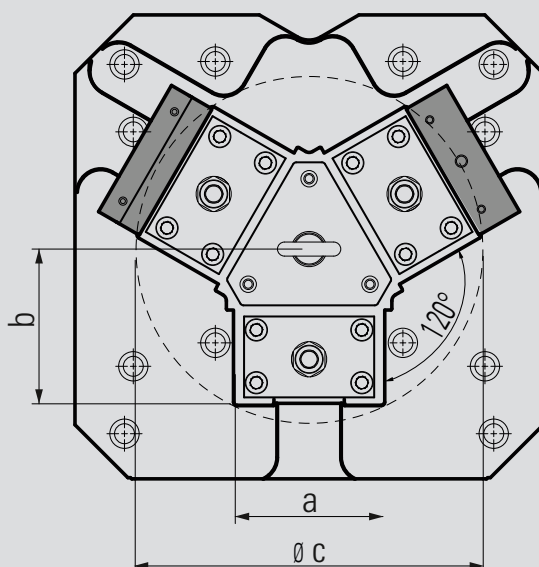
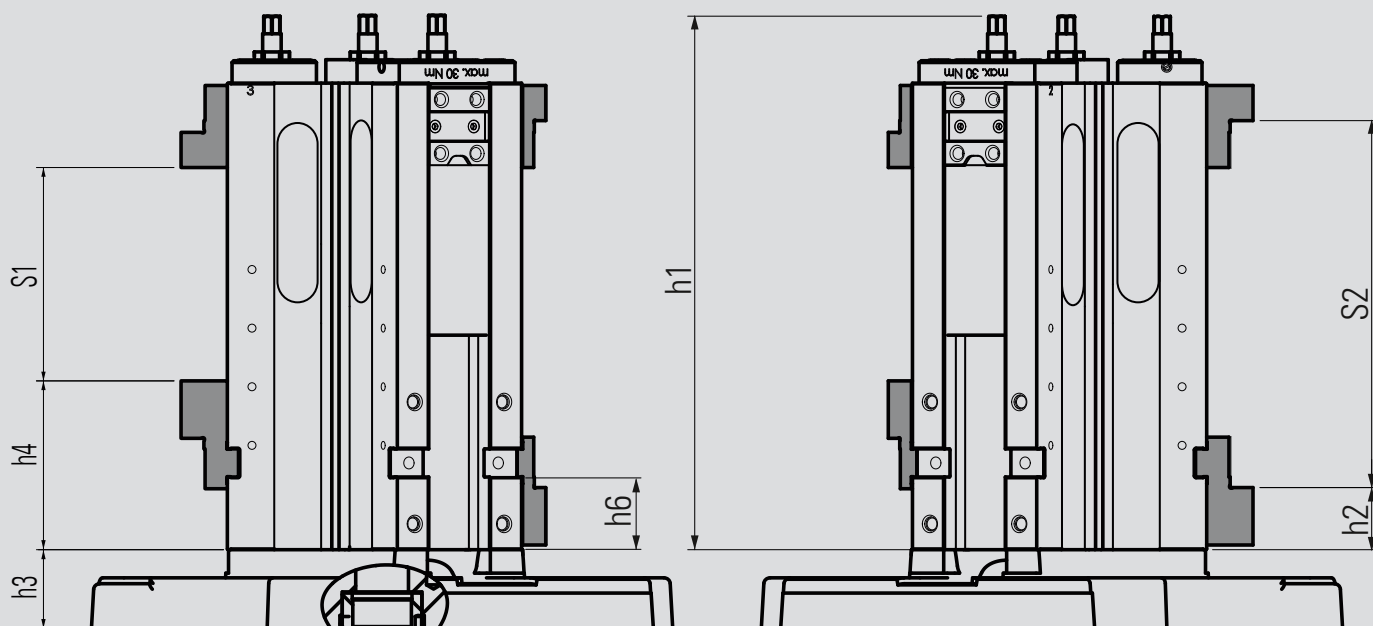
**Order no.: available on request**

## Scope of supply:

- Monobloc without jaws
- 3 socket screw wrench
- Hexagonal insert for torque wrench, 3/8"

 The Monoblock, type TITAN 2, is also available with the LC/TC spindle (see version LC/TC, photos on page 28)

An overview of the clamping jaws and other accessories is given in the section: Accessories for the ALLMATIC TITAN 2 K-M-L.



## Technical data

Jaw width TITAN 2 M	125	
Dimensions in mm	a	126
	b	132
	c (swing circle)	dia. 300
	h1	456
	h2	53
	h3	67
	h4	144
h5	62	

Jaw width with step jaws	125
Clamping width S1 in mm	0 – 182
Clamping width S2 in mm	131 – 313
Max. torque in Nm	30
Max. clamping force in kN	40

# MONOBLOC – 4 x 90° SINGLE

## Scope of application:

- Modular clamping system for horizontal machining centres

## Product features:

- Base gives high stability and extreme accuracy for your machining
- Clamping force can be preset in 4 to 11 increments. At most, two revolutions are required to reach the max. clamping force
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within a tolerance of less than 0.01 mm
- Individual adaptation to your machine (pallet, traverses and workpieces) is possible
- Four clamping points permit three-sided machining



Clamping force presetting

Robust base  
made of GGG 60

Connecting thread for  
angular drive

Hardened,  
ground and polished  
guideway

M8 thread for work-  
piece stop

Base plate can be  
adapted to suit your  
requirements

## Important:

- Type 90: drive head with finer clamping force presetting for sensitive workpieces (11 increments)
- Type 125: drive head with clamping force presetting in 4 increments



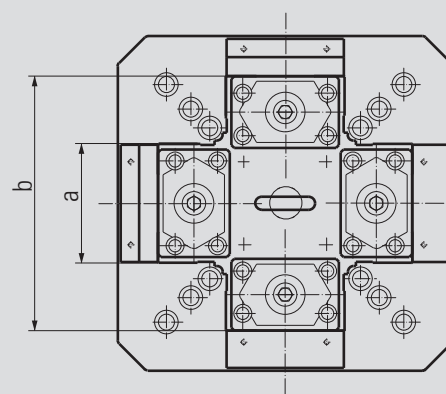
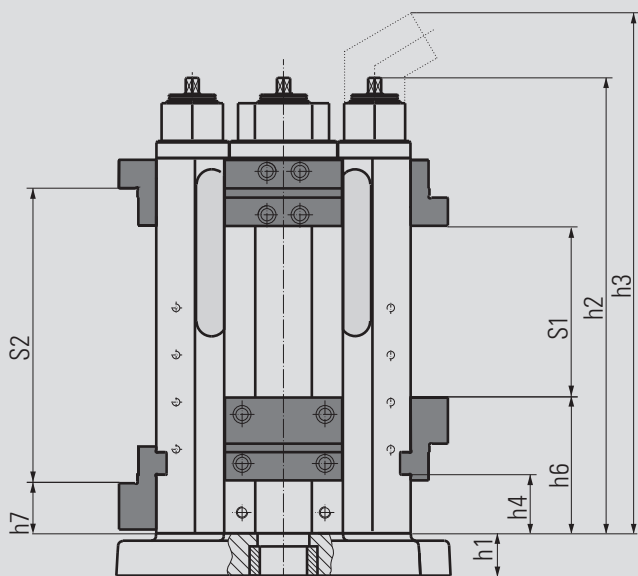
The monobloc, type 125, is also available with gripper spindle (see TITAN 2 version, photos on p.90)

**Order no.: on request**

## Scope of supply:

- Monobloc with step jaws
- 1 hand crank
- Socket screw wrench

An overview of the clamping jaws and other accessories is given in the section: Accessories ALLMATIC NC – mechanical / TC.



## Technical data

Jaw width		90	125
Dimensions in mm	a	90	126
	b	220	270
	h1	min. 45	min. 45
	h2	340	483
	h3	403	452
	h4	39	62
	h6	97	144
	h7	37	53

Jaw width	90	125
Clamping range S1 in mm	0 – 126	0 – 182
Clamping range S2 in mm	91 – 217	131 – 313
Clamping force levels	11	4
Max. clamping force in kN	28	40

# MONOBLOC – 4 x 90° DUO 90

## Scope of application:

- Modular clamping system for horizontal machining centres

## Product features:

- Base gives high stability and extreme accuracy for your machining
- Clamping force can be preset in 4 to 6 increments  
At most, two revolutions are required to reach the max. clamping force
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within a tolerance of less than 0.01 mm
- Individual adaptation to your machine (pallet, traverses and workpieces) is possible
- Eight clamping points permit Three-sided machining



Clamping force presetting

Connecting thread for angular drive

Robust base made of GGG 60

Hardened, ground and polished guideway

M8 thread for workpiece stop

Base plate can be adapted to suit your requirements

## Important:

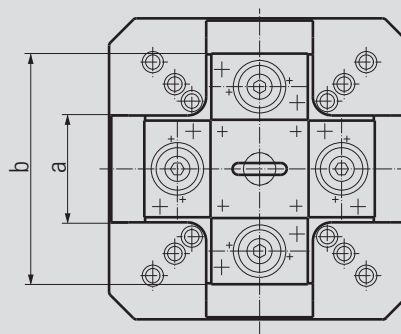
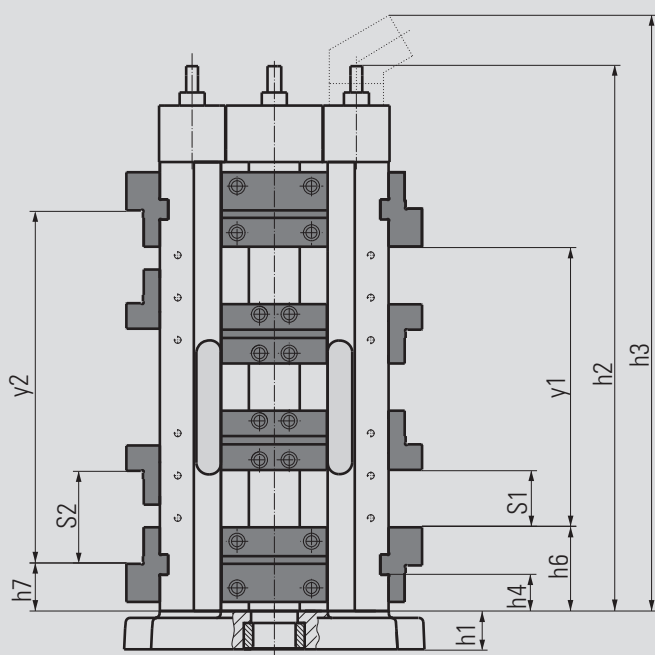
- Type 90: drive head with finer clamping force preselection for sensitive workpieces (6 increments)

## Order no.: on request

## Scope of supply:

- Monobloc with step jaws
- 1 hand crank
- Socket screw wrench

An overview of the clamping jaws and other accessories is given in the section: Accessories ALLMATIC NC – mechanical / DUO.



As an alternative to the star set-ups (see customised solutions), we offer the monobloc 4 x 90° DUO with a larger square dimension:

## Technical data

Jaw width		90
Dimensions in mm	a	90
	<b>b (square dimension)</b>	<b>220</b>
	h1	min. 45
	h2	482
	h3	547
	h4	30
	h6	72
	h7	47
	y1	256
	y2	306

Jaw width		90
Clamping range S1 in mm		0 – 64
Clamping range S2 in mm		56 – 120
Clamping force increments		6
Max. clamping force in kN		28

Jaw width		90
Dimensions in mm	a	90
	<b>b (square dimension)</b>	<b>326</b>
	h1	min. 45
	h2	482
	h3	547
	h4	30
	h6	72
	h7	47
	y1	256
	y2	306

Jaw width		90
Clamping range S1 in mm		0 – 64
Clamping range S2 in mm		56 – 120
Clamping force increments		6
Max. clamping force in kN		28



# MONOBLOC – 3 x 120° DUO PLUS 125

## Scope of application:

- Modular clamping system for horizontal machining centres

## Product features:

- Base gives high stability and extreme accuracy for your machining
- Clamping width adjustment for clamping two workpieces of different sizes
- Reproducible clamping forces enable excellent repeating accuracy of the workpiece position
- Individual adaptation to your machine (pallet, traverses and workpieces) is possible
- Six clamping points



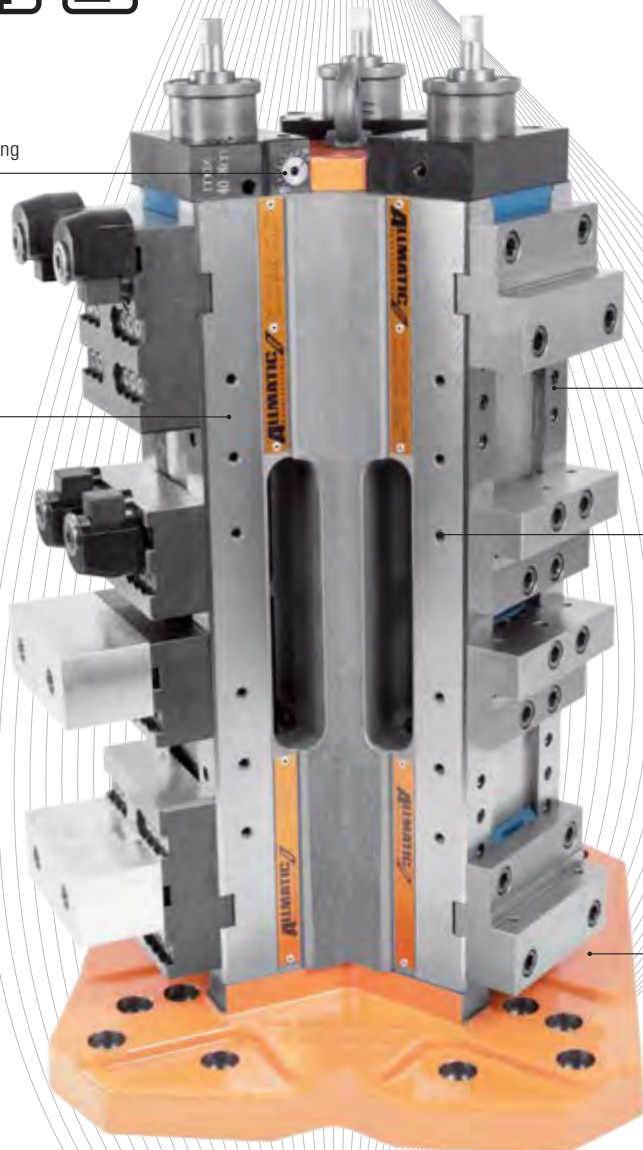
Clamping force presetting

Robust base  
made of GGG 60

Hardened,  
ground and polished  
guideway

M8 thread for work-  
piece stop

Base plate can be  
adapted to suit your  
requirements



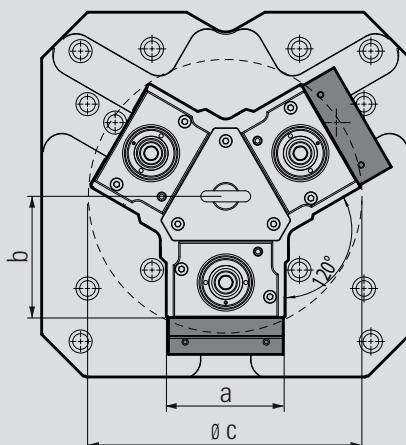
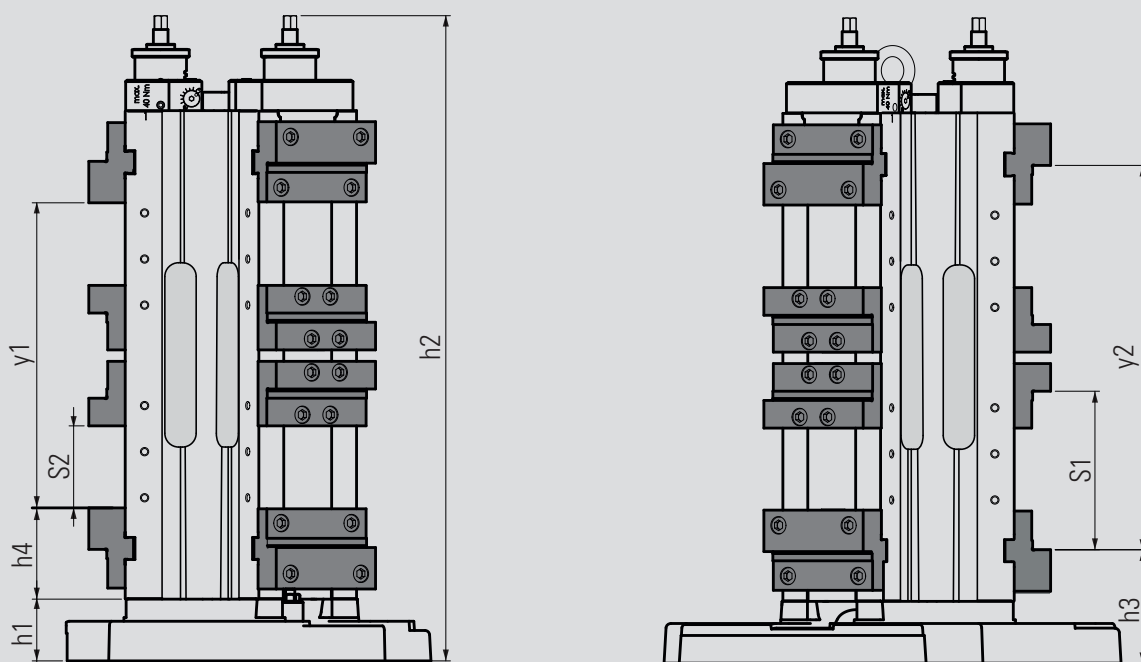
**Order no.: on request**

## Scope of supply:

- Monobloc without jaws
- 1 hand crank
- Socket screw wrench

## Note:

Delivery does not include a torque wrench. An overview of the clamping jaws and other accessories is given in the section: Accessories ALLMATIC NC – mechanical / DUO Plus.



## Technical data

Jaw width		125
Dimensions in mm	a	126
	b	132
	c (swing circle)	dia. 300
	h1	67
	h2	700
	h3	123
	h4	99
	y1	331
y2	417	

Jaw width with step jaws	125
Clamping range S1 in mm	0 – 89*
Clamping range S2 in mm	43 – 172*
Max. clamping force in kN	28

\* When using step jaws without clamping width adjustment

# MONOBLOC – 4 x 90° DUO PLUS 125

## Scope of application:

- Modular clamping system for horizontal machining centres

## Product features:

- Base gives high stability and extreme accuracy for your machining
- Clamping width adjustment for clamping two workpieces of different sizes
- Reproducible clamping forces enable excellent repeating accuracy of the workpiece position
- Individual adaptation to your machine (pallet, traverses and workpieces) is possible
- Eight clamping points



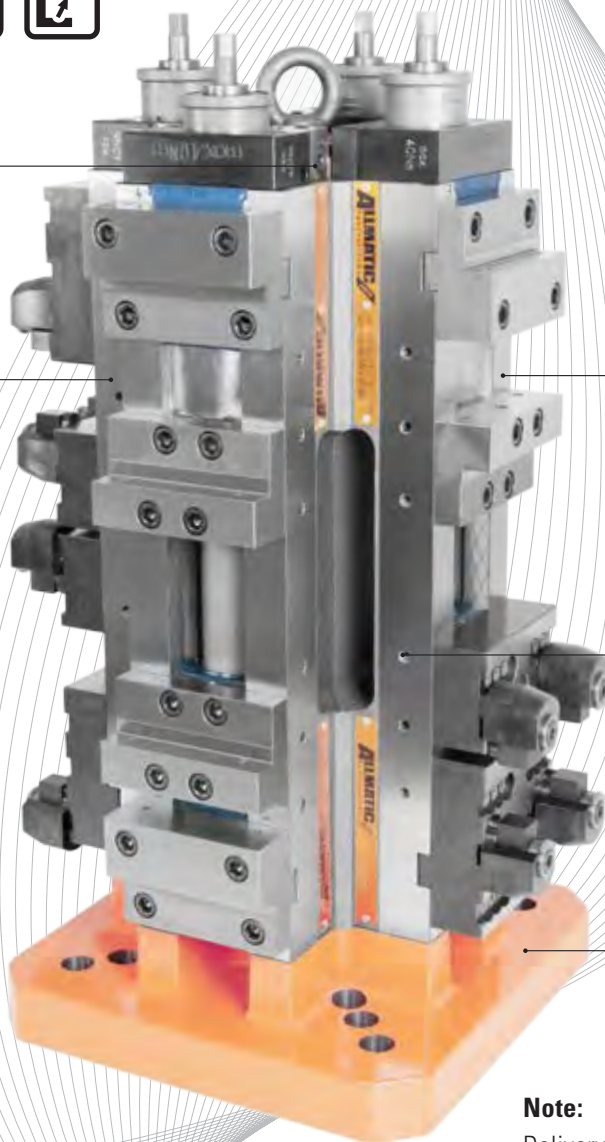
Setting and adjusting the spindle position

Robust base

Hardened, ground and polished guideway

M8 thread for workpiece stop

Base plate can be adapted to suit your requirements



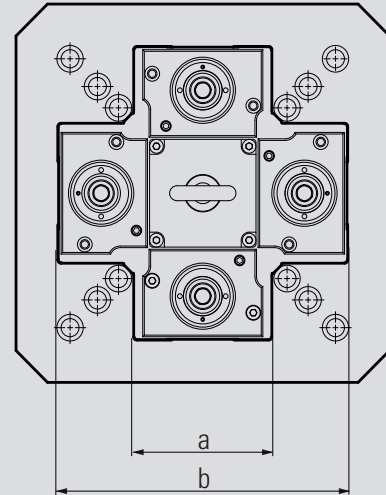
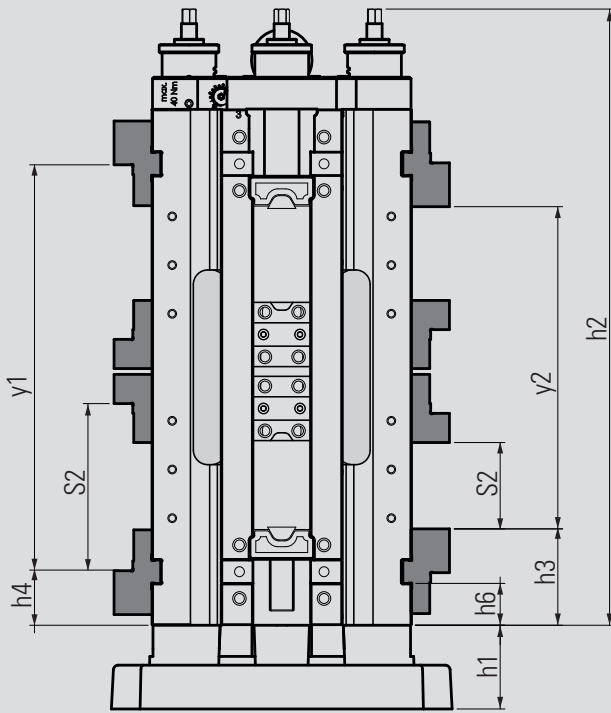
**Order no.: on request**

## Scope of supply:

- Monobloc without jaws
- 1 wrench socket WS 14
- 3 socket screw wrenches

## Note:

Delivery does not include a torque wrench. An overview of the clamping jaws and other accessories is given in the section: Accessories ALLMATIC NC – mechanical /DUO Plus.



As an alternative to the star set-ups (see customised solutions), we offer the monobloc 4 x 90° DUO Plus with a larger square dimension:

### Technical data

Jaw width		125
Dimensions in mm	a	126
	<b>b (square dimension)</b>	<b>270</b>
	h1	min. 86
	h2	633
	h3	99
	h4	56
	h6	43
	y1	417
	y2	331

Jaw width with step jaws		125
Clamping range S1 in mm		0 – 89 *
Clamping range S2 in mm		43-172 *
Max. clamping force in kN		40

\* When using step jaws without clamping width adjustment

Jaw width		125
Dimensions in mm	a	126
	<b>b (square dimension)</b>	<b>360</b>
	h1	min. 86
	h2	633
	h3	99
	h4	56
	h6	43
	y1	417
	y2	331

Jaw width with step jaws		125
Clamping range S1 in mm		0 – 89 *
Clamping range S2 in mm		43-172 *
Max. clamping force in kN		40

The DUO Plus 125 monobloc offers a huge number of clamping possibilities (see DUO Plus p. 122). For exact details on the resulting clamping widths, see our clamping width calculator at:

[www.allmatic.de](http://www.allmatic.de)

# BACK-TO-BACK SET-UP

## Scope of application:

- Modular clamping system for horizontal machining centres

## Product features:

- Comprises standard Single (TC series) or DUO vices
- Clamping force increments can be preset. At most, two revolutions are required to reach the max. clamping force
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within a tolerance of less than 0.01 mm
- Individual adaptation to your machine (pallet, traverses and workpieces) is possible
- Two or four clamping points permit 3-sided machining



Clamping force presetting

Connecting thread for angular drive

Robust base made of GGG 60

Hardened, ground and polished guideway

M8 thread for work-piece stop

Base plate can be adapted to suit your requirements



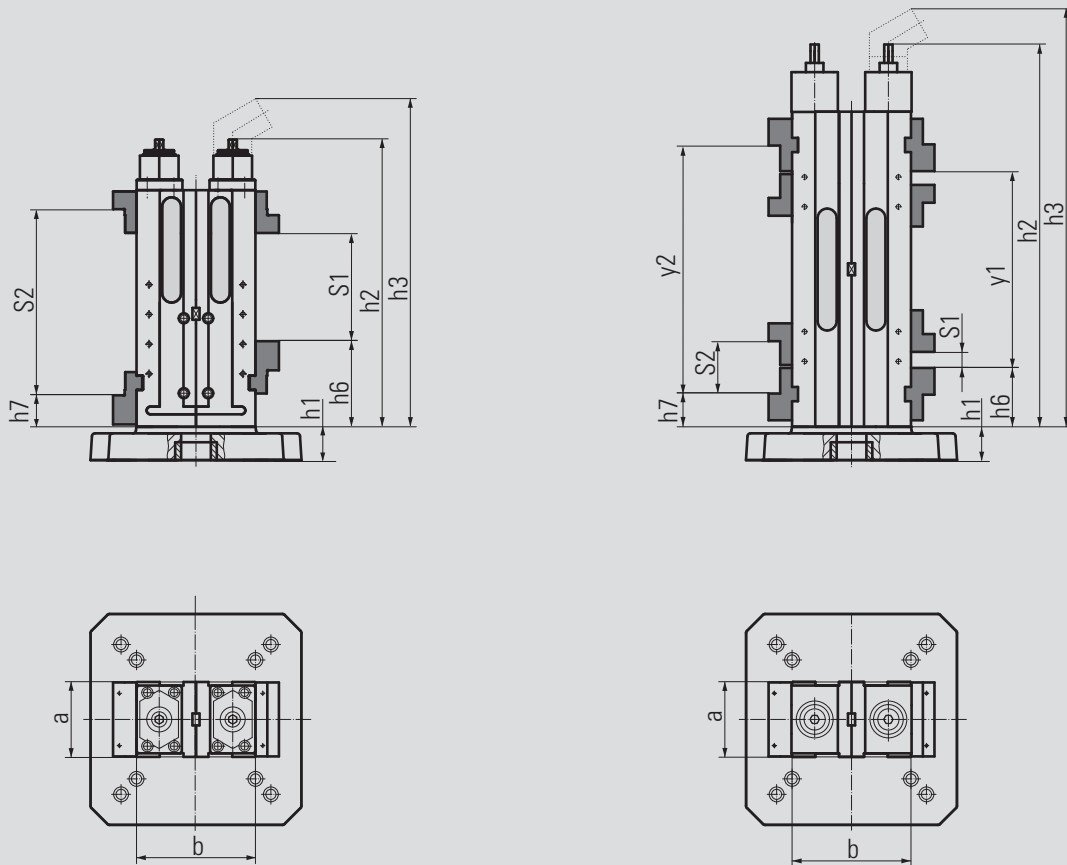
**Order no.: on request**

## Scope of supply:

### Back-to-back set-up Single / DUO

- 1 back-to-back set-up Single / DUO
- 1 hand crank
- Socket screw wrench

If you are interested in a Single or DUO back-to-back set-up, you will find an overview of the clamping jaws and other accessories in the respective section: Accessories ALLMATIC NC – mechanical / TC or DUO.



**Technical data**

Jaw width Single	90	125	160	200	
Dimensions in mm	a	90	125	160	200
	b	160	200	230	280
	h1	min. 45	min. 45	min. 45	min. 74
	h2	340	483	615	615
	h3	403	552	683	683
	h6	97	144	164	164
	h7	37	53	56	56

Jaw width	DUO 90	DUO Plus 125	
Dimensions in mm	a	90	125
	b	160	200
	h1	min. 45	min. 86
	h2	482	633
	h3	547	–
	h6	72	99
	h7	47	56
	y1	256	331
	y2	306	417

Type	90	125	160	200
Clamping range S1 in mm	0 – 126	0 – 182	17 – 263	17 – 263
Clamping range S2 in mm	91 – 217	131 – 313	189 – 435	189 – 435
Clamping force increments	11	4	4	4
Max. clamping force in kN	28	40	60	80

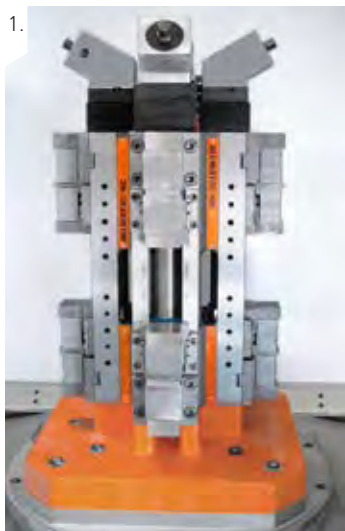
Type	DUO 90	DUO Plus 125
Clamping range S1 in mm	0 – 64	0 – 89 *
Clamping range S2 in mm	56 – 120	43-172 *
Clamping force increments	6	–
Max. clamping force in kN	28	40

\* When using step jaws without clamping width adjustment

The DUO Plus 125 back-to-back set-up offers a huge number of clamping possibilities. For exact details on the resulting clamping ranges, see our clamping range calculator at:

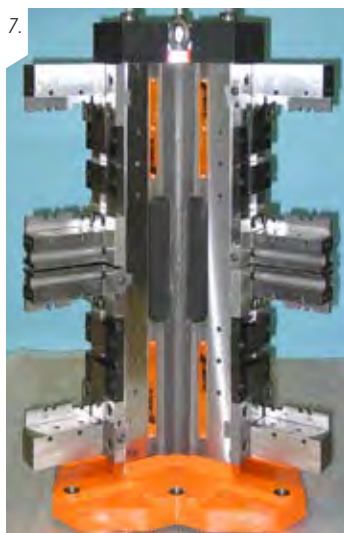
[www.allmatic.de](http://www.allmatic.de)

# CUSTOMISED SOLUTIONS – APPLICATION EXAMPLES



## Application examples

1. Monobloc DUO 125 4 x 90° with reduced-width special jaws and floating centre jaw (sixteenfold clamping)
2. Monobloc DUO 125 4 x 90° special version: stacked mounting of 40 workpieces
3. Monobloc Single 90 4 x 90° with reduced-width special jaws for manufacturing small workpieces
4. Monobloc DUO 125 4 x 90° special version for machining complex castings
5. Monobloc DUO 125 4 x 90° with special jaws
6. 6-fold set-up DUO 125 on double-angle tower



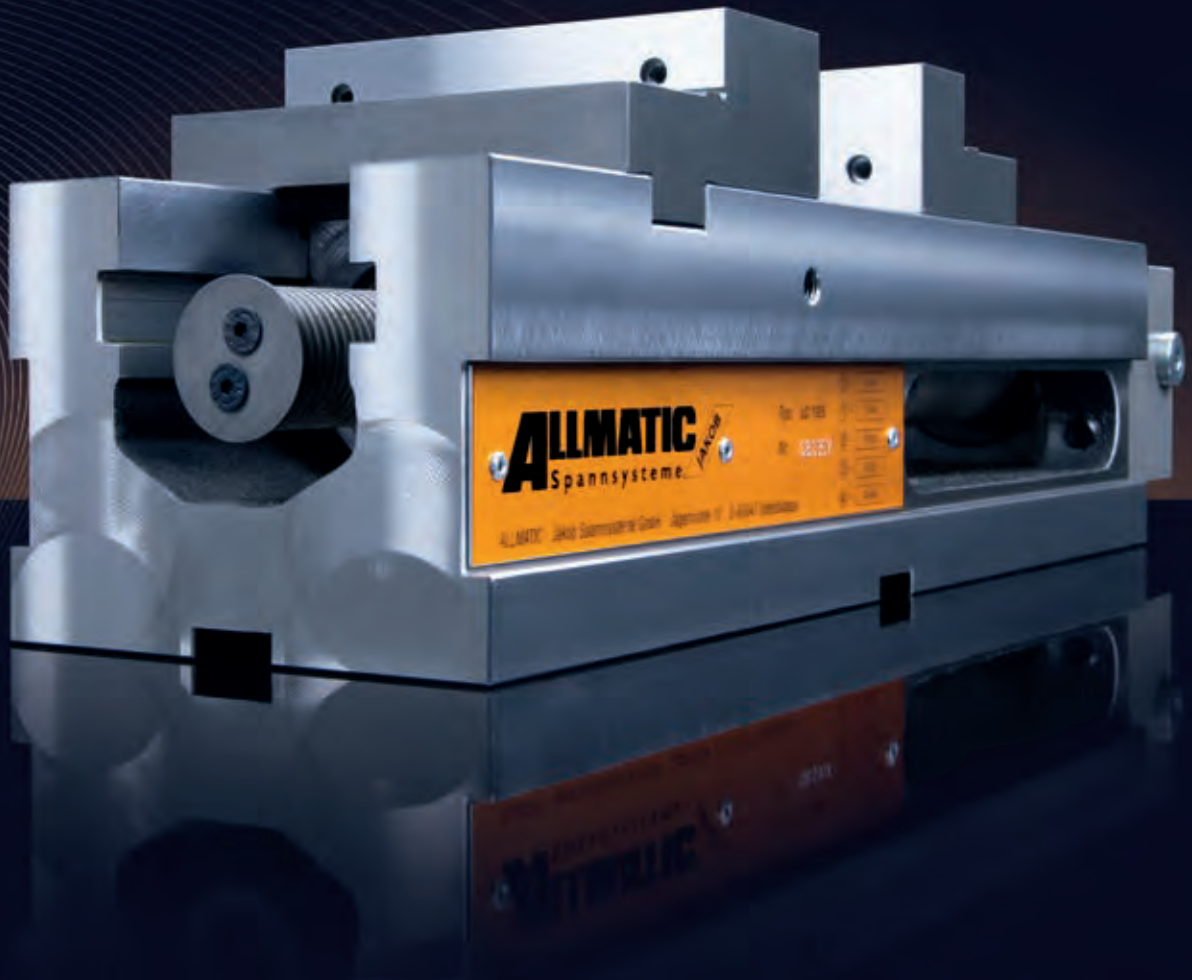
### Application examples

7. Monobloc DUO 125 3 x 120° with special clamping jaws for machining valve housings
8. 4-fold set-up TC 160 with extension on the double-angle for machining very large workpieces
9. Monobloc DUO 125 4 x 90° with reduced-width special jaws for 1st and 2nd clamping
10. Star set-up Single 160 4 x 90° on grid body with extended vice base, special jaws with positioning bolt
11. Wide variety of clamping possibilities with the DUO Plus 125 as a monobloc with step jaws, support jaws with the universal gripper set and soft inserts.
12. Monobloc Single TITAN 2 125 3 x 120° with pull-down jaw system and workpiece (pump case)



# AUTOMATABLE WORKHOLDING

Flexible, precise and very easy to operate –  
hydraulic vices from ALLMATIC.  
Ideal for batch production.



# ALLMATIC NC – HYDRAULIC LCH VERSION

## Scope of application:

- Horizontal installation – suitable for vertical CNC-controlled milling machines
- For automation of machining centres – particularly suitable for batch production
- The hydraulic spindle also enables the use of support jaws with which a wide range of unmachined parts, from flame-cut and sawn materials through to complex castings, can be clamped securely and economically. Suitable for materials with a strength of up to approx. 1000 N/mm<sup>2</sup>.



## Product features:

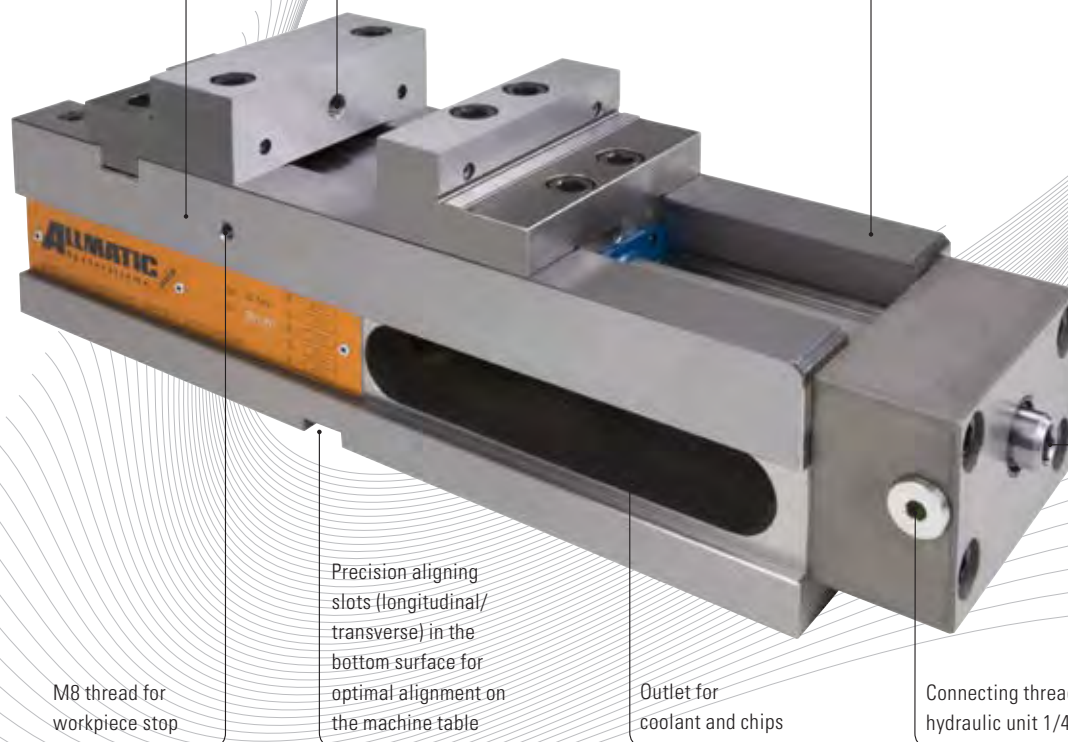
- Extreme accuracy for your machining
- The clamping force is generated via the hydraulic pressure of a hydraulic aggregate (this is required as an hydraulic source to press the vise)
- The hydraulic clamping stroke is limited due to safety regulations to a maximum of 4.5 mm
- The variable adjustment of the clamping force is achieved by hydraulic pressure found on the hydraulic power unit. The rough adjustment of the clamping range is via the control tool
- The spindle contains a single-acting hydraulic piston and an additional Belleville spring assembly

Robust base  
made of GGG 60

M10 thread for  
mounting HD jaws  
(LCH 125 – 160)

Hardened,  
ground and polished  
guideway

Coarse adjustment  
of the clamping  
range



M8 thread for  
workpiece stop

Precision aligning  
slots (longitudinal/  
transverse) in the  
bottom surface for  
optimal alignment on  
the machine table

Outlet for  
coolant and chips

Connecting thread for  
hydraulic unit 1/4" (3-sided)



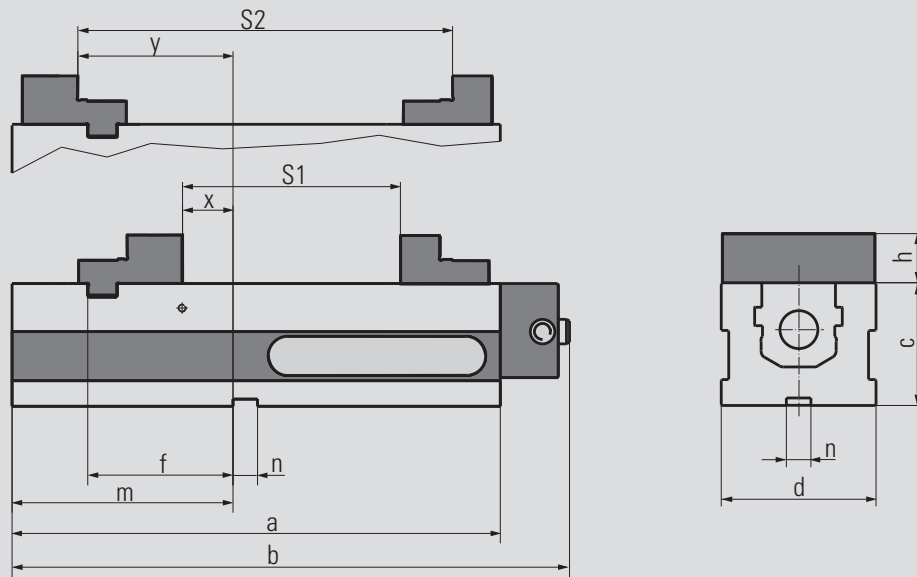
Optional:  
mounting holes  
for zero-point  
clamping systems are possible.  
On request, also available in TC  
version (vertical installation).

**Order no. jaw width 90: 6921678000655**  
**125: 6921688000655**  
**160: 6921708000655**

## Scope of supply:

- 1 high-pressure vice with step jaws
- 1 hand crank
- 4 side clamps
- 1 socket screw wrench
- 1 compensation jaw for clamping range from 0 mm – only LCH 160

An overview of the clamping jaws and other accessories is given on the following pages.



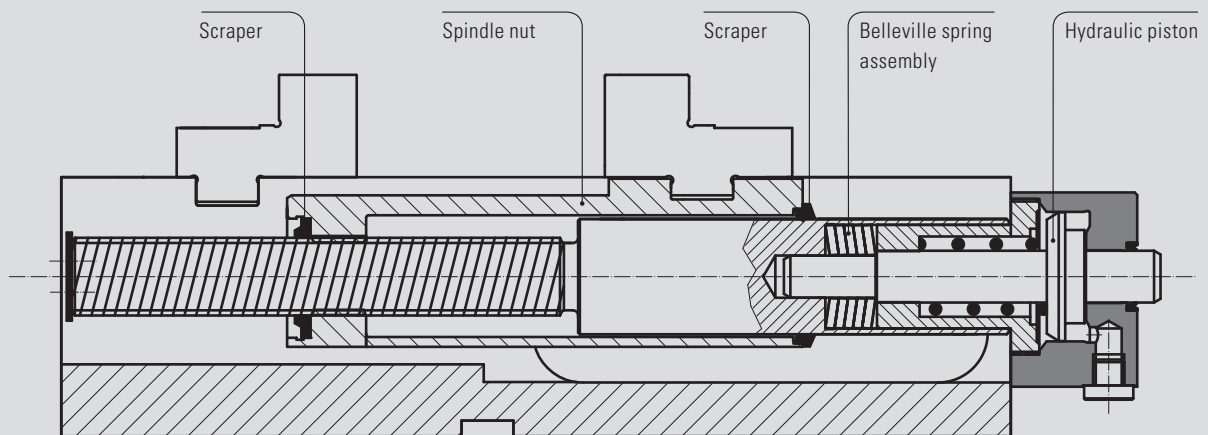
**Technical data**

Jaw width		90	125	160
Dimensions in mm	a	283	398	530
	b	340	456	596
	c	80	100	115
	d	90	126	164
	f	73	118	164
	h	34	39.5	49.8
	m	112	180	234
	n	20	20	20
	x	15	36	70
	y	75	127	178

Jaw width	90	125	160
Clamping range S1 in mm	0 – 126	0 – 182	(0) 17 – 263
Clamping range S2 in mm	93 – 217	131 – 313	189 – 435
Hydraulic movement in mm	4.5	4.5	4.5
Max. clamping force in kN	24	40	60
At hydr. pressure in bar	240	240	240
Weight in kg	16,4	35,6	65

• Clamping width 0 can be reached using the compensation jaw

**Spindle cross-section**

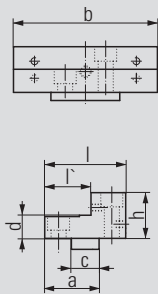
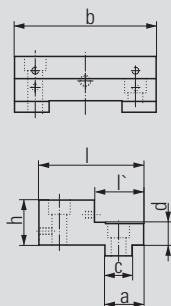
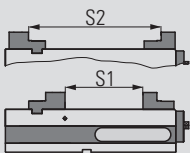


## ALLMATIC NC – hydraulic / LCH version (accessories)

### Step jaws



- Material: hardened steel
- High and step sides with thread for parallels
- Ground and polished clamping surfaces
- Additional thread on the high side for mounting HD jaws (Types 125 – 200)
- Click system on the high side



Jaw width	90	125	160
Clamping range S1	0 – 126	0 – 182	17 – 263
Clamping range S2	93 – 217	131 – 313	189 – 435

#### Jaw width

fixed	90	125	160	
Ord. no.:	6921674006731	6921674006731	6921704006731	
Dimensions in mm	a	30	34	40
	b	89,5	124,4	160,4
	c	20	24	30
	d	16	20	25
	h	34	39,5	49,8
	l	68	92	104
	l'	32	43	54

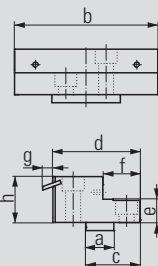
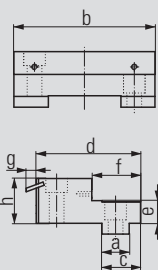
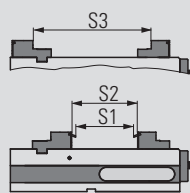
#### Jaw width

movable	90	125	160	
Ord. no.:	6921474002731	6921484002731	6921304002731	
Dimensions in mm	a	38	47	63
	b	89,5	124,4	160,4
	c	20	24	30
	d	16	20	25
	h	34	39,5	49,8
	l	56	70	96
	l'	31	40	64

### Pull-down jaws



- Material: hardened steel
- Pull-down with ground and polished spring leaves for machined and unmachined clamping surfaces
- Ground and polished clamping surfaces
- High clamping accuracy for parallel and accurate angle machining
- Click system on the high side



Jaw width	125
Clamping range S1	0 – 159
Clamping range S2	0 – 176
Clamping range S3	124 – 305

#### Jaw width

fixed	90	125	160	
Ord. no.:	6921674106031	6921684106031	6921704109031	
Dimensions in mm	a	20	24	30
	b	89,5	124,4	160,4
	c	30	34	40
	d	69	92	104
	e	16	20	25
	f	37	43	54
	g	8,8	8,8	8,8
	h	34	39,5	49,8

#### Jaw width

movable	125	
Ord. no.:	6921684102031	
Dimensions in mm	a	24
	b	124,4
	c	46,5
	d	75
	e	20
	f	32
	g	8,8
	h	39,5

## ALLMATIC NC – hydraulic / LCH version (accessories)

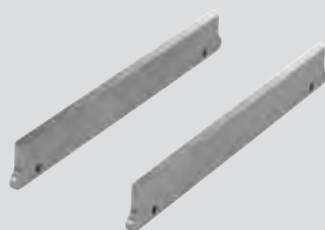
### Spring leaves (pair)



Order no. jaw width 90: 6921884103031

- Hardened spring leaves
- Spring leaves (spare) for pull-down jaws Type 90 (see left)

### Spring leaves (pair)



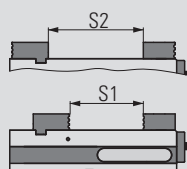
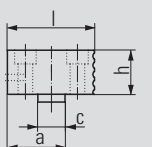
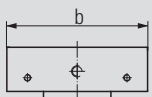
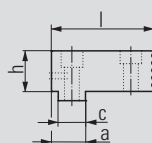
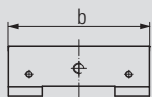
Order no. jaw width 125: 6921684103031  
160: 6921704103031

- Hardened spring leaves
- Spring leaves (spare) for pull-down jaws Type 125 and 160 (see left)

### Hard basic jaws



- Material: hardened steel
- One side smooth, ground and polished; one side serrated
- Additional thread for parallels and for mounting HD jaws on the smooth side
- Mounts for Click system on both sides of the jaw



		Jaw width		
fixed		90	125	160
Ord. no.:		6921674005731	6921684005731	6921704005731
Dimen- sions in mm	a	26	30	40
	b	89,5	124,4	160,4
	c	20	24	30
	h	34	39,5	49,8
	l	63	88	104

		Jaw width		
movable		90	125	160
Ord. no.:		6921674004731	6921684004731	6921704004731
Dimen- sions in mm	a	40	50	65
	b	89,5	124,4	160,4
	c	20	24	30
	h	34	39,5	49,8
	l	60	76	100

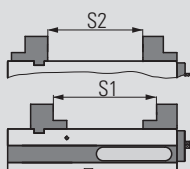
Clamping range S1	0 – 125	0 – 179	15 - 261
Clamping range S2	30 – 156	49 – 231	69 - 315

## ALLMATIC NC – hydraulic / LCH version (accessories)

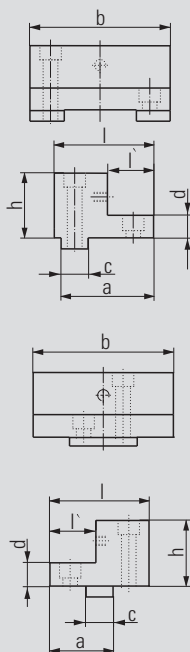
### Master jaw adapters



- Material: hardened steel
- High side of jaw hardened
- Ground clamping surfaces
- Additional thread on the step side for mounting HD jaws
- Click system on the high side



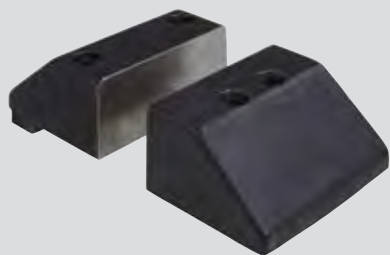
Jaw width	90	125	160
Clamping range S1	62 – 186	64 – 246	88 – 334
Clamping range S2	26 – 152	45 – 227	68 – 314



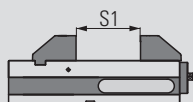
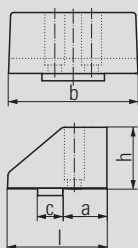
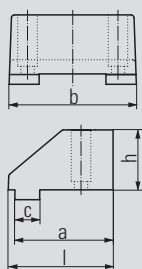
Jaw width				
fixed	90	125	160	
Ord. no.:	6921674012231	6921684012231	6921704012231	
Dimensions in mm	a	56	77	89
	b	90	126	164
	c	20	24	30
	d	16	20	24
	h	46	58	73
	l	66	85	100
	l'	30	32	34

Jaw width				
movable	90	125	160	
Ord. no.:	6921274011231	6921284011231	6921304011231	
Dimensions in mm	a	40	52	65
	b	90	126	164
	c	20	24	30
	d	16	20	24
	h	46	58	73
	l	60	80	100
	l'	30	32	34

### Soft jaws



- Material: GGG40
- For production of special jaws by the customer
- Chamfer provides very good accessibility to the workpiece



Order no. fixed: 6921684088031

Jaw width	125	
Dimensions in mm	a	95
	b	124
	c	24
	h	58
	l	101.5

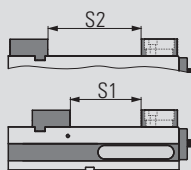
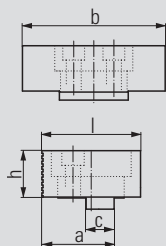
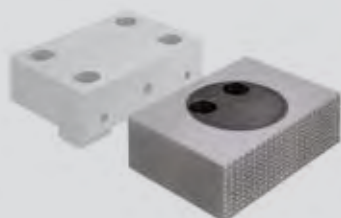
Order no. movable: 6921484087031

Jaw width	125	
Dimensions in mm	a	42
	b	124
	c	24
	h	58
	l	94.5

Clamping range S1	0 – 150
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## ALLMATIC NC – hydraulic / LCH version (accessories)

### Pivot jaw, movable



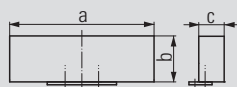
- Material: hardened steel
- With Click-System on both sides
- One side smooth, ground and polished; one side serrated
- Rotatable through 360°
- Picture with hard basic jaw (see page 71)

Order no. jaw width 90: 6921674020142  
 125: 6921684020042  
 160: 6921704020042

Jaw width		90	125	160
Dimensions in mm	a	49.5	62	86
	b	90	124.4	160.4
	c	20	24	30
	h	34	39.5	49.8
	l	68	84	118

Clamping range S1	0 – 115	0 – 167	0 – 240
Clamping range S2	21 – 146	37 – 219	48 – 294

### Soft jaw

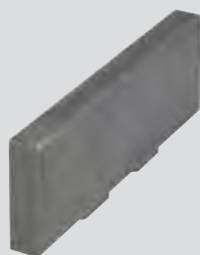


- Material: case-hardened steel 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Only for use with jaws with Click system

Order no. 6921684023042

Jaw width		125
Dimensions in mm	a	125
	b	39.8
	c	22

### Jaw with cross grooving



- Material: hardened steel
- Jaws with sharp serrations to increase the specific contact pressure per unit area
- Visible impressions on workpiece
- Only suitable for soft materials
- Only for use with jaws with Click system

Order no. 6921684032040

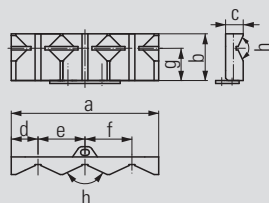
Jaw width		125
Dimensions in mm	a	125.6
	b	40.1
	c	12



## ALLMATIC NC – hydraulic / LCH version (accessories)

### Prismatic jaws (pair)

Order no. 6921684024042

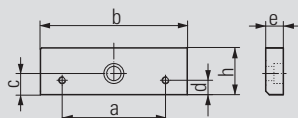


- Material: hardened steel
- Jaws for clamping round parts, vertical dia. 16-74 mm, horizontal dia. 12-40 mm
- Only for use with jaws with Click system

c		125
Dimensions in mm	a	125.6
	b	39.8
	c	15
	d	22.8
	e	40
	f	40
	g	27.5
	h	130°

### Compensation jaw

Order no. jaw width 160: 6921704022031  
200: 6921694022031

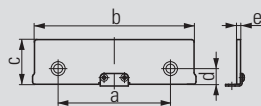


- Material: hardened steel
- Ground and polished clamping surfaces
- For clamping range from 0 mm
- With the LC 160 and 200 vices, this jaw is included

Jaw width	160	200	
Dimensions in mm	a	88	110
	b	160.4	200.4
	c	20	25
	d	12.25	18
	e	18	18
	h	49.8	60

### Click parallels (pair)

Order no. jaw width 90: 6921175029042  
125: 6921185035042  
160: 6921205044042

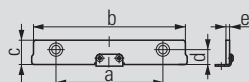


- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels with Click system
- For the high side of the jaws

Jaw width	90	125	160	
Dimensions in mm	a	48	88	88
	b	90	125	160
	c -0.01	29	35	44
	d	8.75	12.25	12.25
	e	3	3	3

## ALLMATIC NC – hydraulic / LCH version (accessories)

### Click parallels (pair)

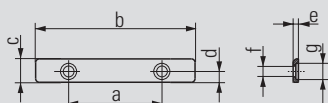


Order no. jaw width 90: 6921175016042  
 125: 6921185020042  
 160: 6921205025042

Jaw width	90	125	160
Dimensions in mm			
a	48	88	88
b	90	125	160
c -0.01	16	20	25
d	8.75	12.25	12.25
e	3	3	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels with Click system
- For the high side of the jaws

### Parallels (pair)



Order no. jaw width 90: 6921475013031  
 125: 6921485015031  
 160: 6921305019031

Jaw width	90	125	160
Dimensions in mm			
a	52	88	88
b	89	124	160
c	13	15	19
d	6	6	6
e	3	3	3
f	Ø 6	Ø 6	Ø 6
g	Ø 9	Ø 9	Ø 9

- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels
- For the step side of the jaws

### Smooth jaws (pair)



Order no. jaw width 125: 6921024022031  
 160: 6921034022031

Jaw width	125	160
Dimensions in mm		
a	125	160
b	40	50
c	15	20

- Material: hardened steel
- For parts with delicate clamping surfaces
- Please order fastening bolts separately (order no. 6921011023000)

## ALLMATIC NC – hydraulic / LCH version (accessories)

### Serrated jaws (pair)



Order no. jaw width 125: 6921021005031

160: 6921031005031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

- Material: hardened steel
- Standard jaws with serration
- To increase the specific contact pressure per unit area
- Please order fastening bolts separately (order no. 6921011023000)

### Soft jaws (pair)



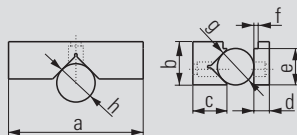
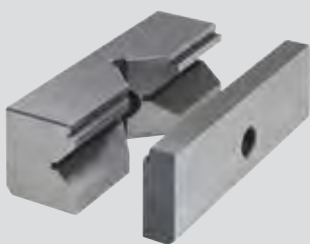
Order no. jaw width 125: 6921024023031

160: 6921034023031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	25	30

- Material: 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Please order fastening bolts separately (order no. 6921011023000)

### Prismatic jaws (set)



Order no. jaw width 125: 6921024024031

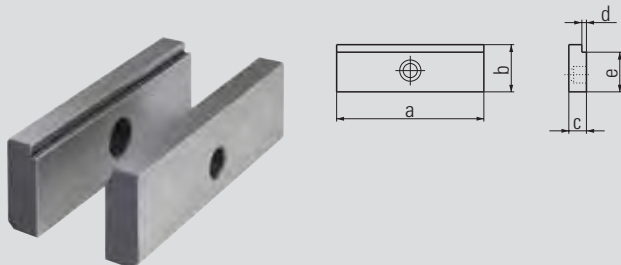
160: 6921034024031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	35	45
	d	15	20
	e	35	45
	f	3	3
	g	∅ 12 – 28	∅ 15 – 40
	h	∅ 18 – 55	∅ 22 – 65

- Material: hardened steel
- For horizontal and vertical clamping of round and flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

## ALLMATIC NC – hydraulic / LCH version (accessories)

### Step jaws (pair)

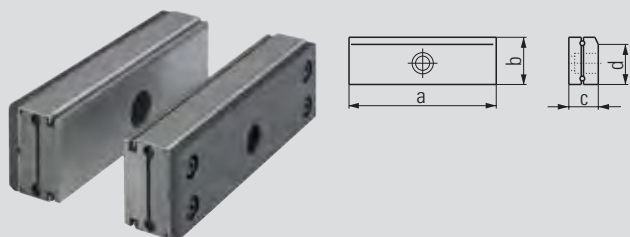


Order no. jaw width 125: 6921024025031  
160: 6921034025031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20
	d	3	3
	e	35	45

- Material: hardened steel
- For horizontal clamping of flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

### Roller pull-down jaws (pair)

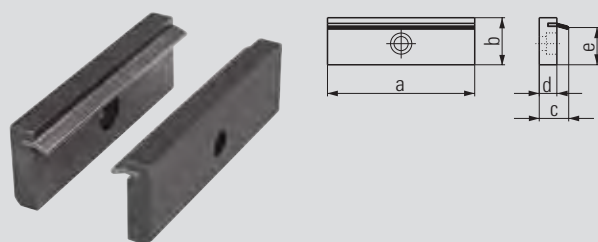


Order no. jaw width 125: 6921024005131  
160: 6921034005131

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	26	35.5
	d	35	45

- Material: hardened steel
- For parts with delicate clamping surfaces
- Jaw parts in contact with the workpiece press the workpiece onto the support surface
- Please order fastening bolts separately (order no. 6921011023000)

### Spring leaf pull-down jaws (pair)



Order no. jaw width 125: 6921024001042  
160: 6921034001042

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	20	23
	d	12	15
	e	33	43

- Material: hardened steel
- For parts with unmachined clamping surfaces
- Spring leaves press the workpiece onto the support surface
- Spring leaves are interchangeable, (see the next page)
- Please order fastening bolts separately (order no. 6921011023000)

**ALLMATIC NC – hydraulic / LCH version (accessories)****Spring leaves (pair)****Order no. jaw width****125: 6921024002131****160: 6921034002131**

- Spring leaves (spare)  
for spring leaf pull-down jaws  
(see previous page)

**Jaw fixing bolt****Order no. 6921011023000****Bolt with shoulder –  
M10 x 23**

- Suitable for all jaws,  
jaw width 090 mm to 160 mm

## ALLMATIC NC – hydraulic /LCH version (GRIPP clamping accessories)

### Support jaws



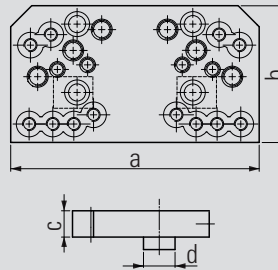
- Material: hardened steel
- For mounting various pull-down wedge elements, universal gripper set and gripper studs (pointed/smooth)
- Front surface can be used as clamping surface (hardened and ground)

**Pivot jaw:**

- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- Supplied **without** wedge elements, gripper set and gripper studs (pointed/smooth)

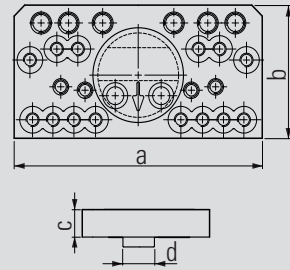
You will find dimensions of the individual gripper items and the gripper studs at [www.allmatic.de](http://www.allmatic.de)

Order no. fixed:  
6921734005842



Jaw width	125
Dimensions in mm	
a	189
b	104
c	20
d	24

Order no. movable, pivoting:  
6921734072842



Jaw width	125
Dimensions in mm	
a	189
b	97
c	20
d	24



Please order universal gripper set or gripper studs separately

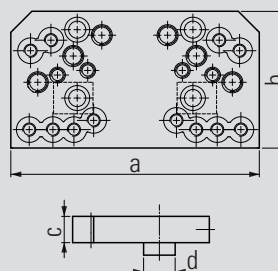
### Support jaws



- Material: hardened steel
- For mounting various studs (pointed/smooth) or a universal gripper set
- For three-point clamping
- Front surface can be used as clamping surface (hardened and ground)
- Supplied **without** studs (pointed/smooth) or gripper set

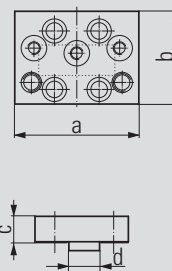
You will find dimensions of the individual gripper items and the gripper studs at [www.allmatic.de](http://www.allmatic.de)

Order no. fixed:  
6921734005842



Jaw width	125
Dimensions in mm	
a	189
b	104
c	20
d	24

Order no. movable, rigid:  
6921884004842



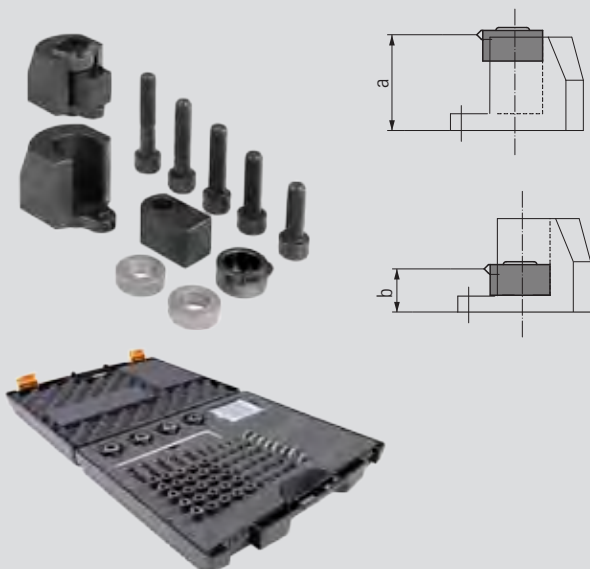
Jaw width	125
Dimensions in mm	
a	97
b	73
c	20
d	24



Please order universal gripper set or gripper studs separately

## ALLMATIC NC – hydraulic /LCH version (GRIPP clamping accessories)

### Universal gripper set



Order no. 6921884027031

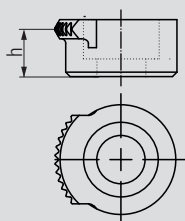
Jaw width	125	
Dimensions in mm	a	40
	b	18

- For clamping complex unmachined parts
- The individual elements of the universal gripper set can be reworked in order to vary both gripper height and support height of the workpiece

Comprising:

- 4 x gripper studs 6921884026000
- 4 x gripper stud mounts 6921884072000
- 4 x supports 6921884028000
- 8 x shims
- Support bolts
- M10 fastening bolts in various lengths
- M6 threaded pins in various lengths
- Socket screw wrench
- Storage case

### Gripper stud

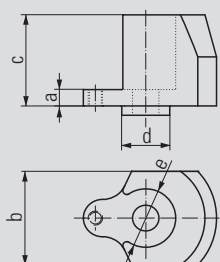


Order no. 6921884026000

Dimensions in mm	h	11
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- Gripper stud for universal gripper set

### Gripper stud mount

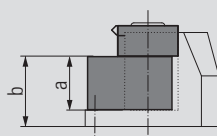


Order no. 6921884027000

Dimensions in mm	a	7
	b	40
	c	39
	d	Ø 20
	e	Ø 25

- Mount for gripper stud 2306/001

### Support



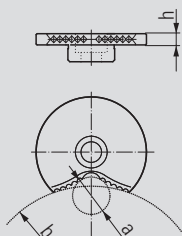
Order no. 6921884028000

Dimensions in mm	a	22
	b	29

- Support for universal gripper set

## ALLMATIC NC – hydraulic / LCH version (GRIPP clamping accessories)

### Prismatic gripper

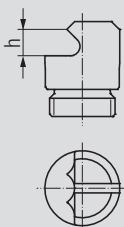


Order no. 6921884029031

Dimensions in mm		
a	Ø 20	
b	Ø 120	
h	6	

- Replaces gripper stud 6921884026000 in the universal gripper set
- Special shape distributes the applied clamping force – particularly advantageous for clamping workpieces for which fits have to be made

### Gripper stud, pointed

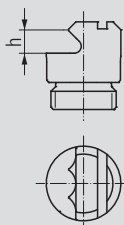


Order no. 6921884036000

Dimensions in mm		
h	5.5	

- For clamping unmachined parts
- Minimum clamping edge loss
- Gripping height: adjustable from 4.5 to 6.0 mm

### Gripper stud, low-level

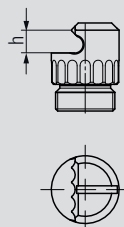


Order no. 6921884036100

Dimensions in mm		
h	5	

- For clamping unmachined parts
- Minimum clamping edge loss
- Gripping height: adjustable from 3.0 to 4.5 mm

### Gripper stud, four-point

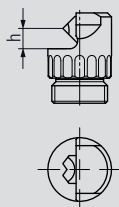


Order no. 6921884036500

Dimensions in mm		
h	5,4	

- For clamping unmachined parts
- For soft materials like aluminum
- Minimum clamping edge loss
- Clamping height: adjustable from 4.5 mm to 6.0 mm

### Gripper stud, carbide coated



Order no. 6921884036841

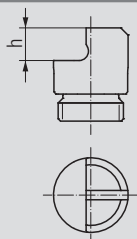
Dimensions in mm		
h	5,1	

- For clamping unmachined parts
- For high quality coated materials and flame cuts
- Minimum clamping edge loss
- Clamping height: adjustable from 4.2 mm to 5.7 mm



## ALLMATIC NC – hydraulic / LCH version (GRIPP clamping accessories)

### Clamping insert, smooth

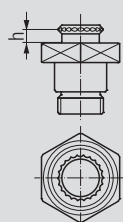


Order no. 6921884037000

Dimensions in mm	h	7
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- With carbide coating, for clamping pre-machined or hardened workpieces

### Gripper stud, round

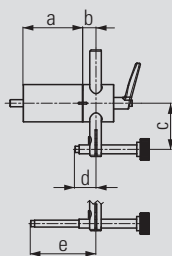


Order no. 6921884038000

Dimensions in mm	h	4
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- For clamping unmachined parts
- For through-drilling close to the edge
- Offers 6 mm space below workpiece

### Workpiece stop

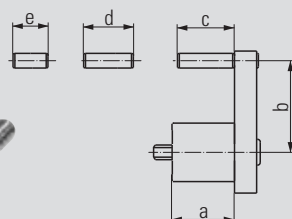


Order no. 6921285650144

Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63,5
	e	53,5 – 113,5

- Can be installed on either side of the vice in the designated positions
- M8 fastening thread
- Position of the third workpiece axis can be preset and clamped
- Workpiece stop can be swivelled away once the workpiece has been clamped
- This allows the stop side of the workpiece to also be machined (repeating accuracy:  $\pm 0.01$ )

### Workpiece stop



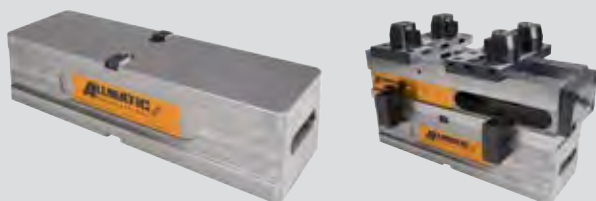
Order no. 6921685670042

Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

- Can be installed on either side of the vice in the designated positions
- M8 fastening thread
- Can be pre-mounted with various fixed dimensions
- Position of the third workpiece axis can be preset

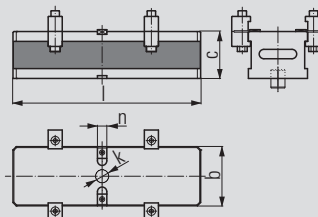
## ALLMATIC NC – hydraulic /LCH version (GRIPP clamping accessories)

### XL console



- Material: GG30
- For raising the vice
- Improvement of access for 5-sided machining
- Optional preparation for zero-point clamping systems
- Scope of supply: console incl. fixing bolt for positioning the vice, 4 pairs of Duo side clamps, 2 socket screw wrenches

Order no. 6921885010042



Jaw width	125	
Dimensions in mm	b	126
	c	100
	k	Ø 30
	l	400
	n	20

### Hand crank



Bestell-Nr. 6923015000131

Jaw width	90 - 160	
Dimensions in mm	a	147
	SW	12

- Hand crank for the series NC-LCH hydraulic (90mm - 160mm)

### Side clamps (pair)



Order no. 6921025000031

- For securing the vice on the machine table
- Supplied as a set of 2 items

### DUO side clamps



Order no. 6921285000031

- For securing the vice on a console or machine table
- 1 set consists of 2 pairs of side clamps incl. screw connections

### Aligning and fixing set



- For aligning (positioning) and securing the vice on pallet and machine table
- Size according to T-slot or thread in the machine table

Order no. – see table

T-slot/thread	Order no.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

# ALLMATIC basic – HYDRAULIC

## Scope of application:

- Conventional and CNC-controlled milling machines – for efficient precision machining
- Horizontal installation – great variability and flexibility

## Product features :

- Excellent ease of operation guarantees optimal handling in every situation
- Fast adjustment for clamping range preselection
- The clamping force is generated via the hydraulic pressure of a hydraulic aggregate (this is required as an hydraulic source to press the vise)

- The hydraulic clamping stroke is limited due to safety regulations to a maximum of 4.5 mm
- The variable adjustment of the clamping force is achieved by hydraulic pressure found on the hydraulic power unit. The rough adjustment of the clamping range is via the control tool
- Integrated scrapers ensure functional reliability and minimise cleaning
- Fixing on the machine table by means of mounting holes in the vice base. Additional holes can be made in the soft middle section of the vice base
- Optional centre jaw allows two or more workpieces to be clamped



Robust base made of case-hardened steel

M10 thread for mounting HD jaws

Hardened, ground and polished guideway

M8 thread for workpiece stop

Precision aligning slots (longitudinal/transverse) and mounting holes in the ground and polished bottom surface

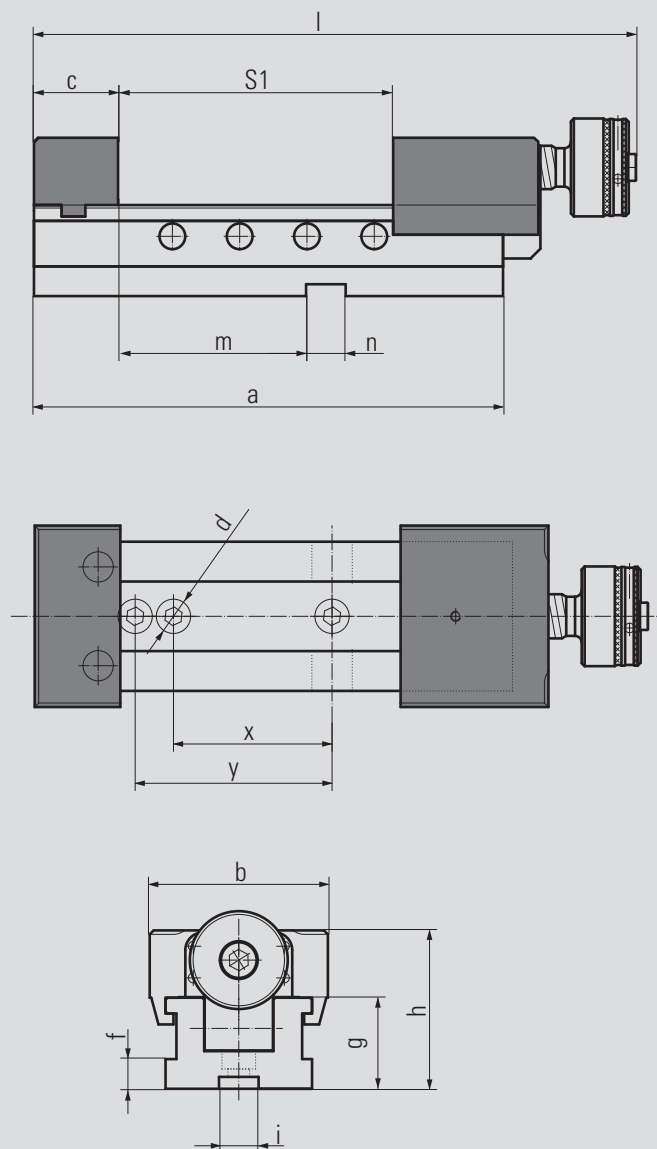
Ground and polished undergrip

**Order no. jaw width 125: 6921188000655**  
**160: 6921208000655**

## Scope of supply:

- 1 basic vice with clamping jaws
- 1 pair of Click parallels
- 1 socket screw wrench
- M12 fastening bolts

An overview of the clamping jaws and other accessories is given on the following pages.



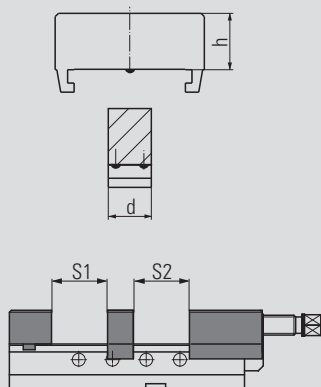
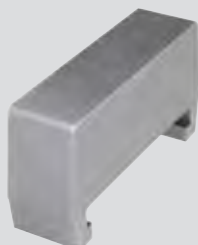
## Technical Data

Jaw width		125	160
Dimensions in mm	a	310	405
	b	124	160
	c	50	66
	d	13	13
	f	15	15
	g	48	56
	h	87.5	105.5
	i	20	20
	l max	454	510
	m	120	128
	n	20	20
	x	100	100
	y	125	125

Jaw width	125	160
Clamping range S1 in mm	0 – 208	0 – 283
Hydraulic movement in mm	4.5	4.5
Max. clamping force in kN	35	50
At hydr. pressure in bar	240	220
Weight in kg	15	28

## ALLMATIC basic – hydraulic (accessories)

### Intermediate jaw



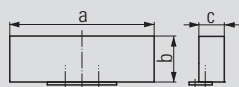
Order no. jaw width 125: 6921185024040  
160: 6921205024040

Jaw width		125	160
Dimensions in mm	h	39.5	49.5
	d	33	41

Clamping range S1	0 – 87	0 – 121
Clamping range S2	0 – 87	0 – 121

- Material: hardened steel
- For clamping more than one part
- Installation between fixed and movable jaws of the vice
- Mount for Click system on both sides of the jaw

### Soft jaw



Order no. jaw width 125: 6921684023042

Jaw width		125
Dimensions in mm	a	125
	b	39.8
	c	22

- Material: case-hardened steel 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Only for use with jaws with Click system

### Jaw with cross grooving



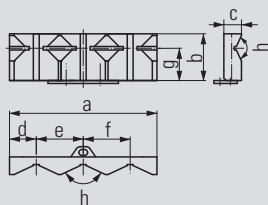
Order no. jaw width 125: 6921684032040

Jaw width		125
Dimensions in mm	a	125.6
	b	40.1
	c	12

- Material: hardened steel
- Jaws with sharp serrations to increase the specific contact pressure per unit area
- Visible impressions on workpiece
- Only suitable for soft materials
- Only for use with jaws with Click system

## ALLMATIC basic – hydraulic (accessories)

### Prismatic jaws (pair)

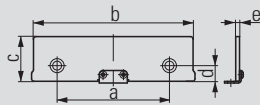


Order no. jaw width 125: 6921684024042

Jaw width	125	
Dimensions in mm	a	125.6
	b	39.8
	c	15
	d	22.8
	e	40
	f	40
	g	27.5
	h	130°

- Material: hardened steel
- Jaws for clamping round parts, vertical dia. 16 – 74 mm, horizontal dia. 12 – 40 mm
- Only for use with jaws with Click system

### Click parallels (pair)

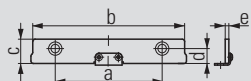


Order no. jaw width 125: 6921185035042  
160: 6921205044042

Jaw width	125	160	
Dimensions in mm	a	88	88
	b	125	160
	c -0.01	35	44
	d	12.25	12.25
	e	3	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Parallels with Click system

### Click parallels (pair)



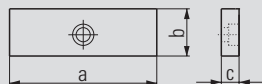
Order no. jaw width 125: 6921185020042  
160: 6921205025042

Jaw width	125	160	
Dimensions in mm	a	88	88
	b	125	160
	c -0.01	20	25
	d	12.25	12.25
	e	3	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Parallels with Click system

## ALLMATIC basic –hydraulic (accessories)

### Smooth jaws (pair)



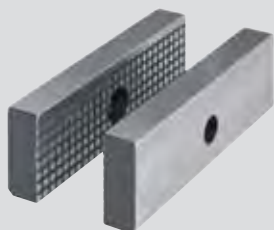
Order no. jaw width 125: 6921024022031

160: 6921034022031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

- Material: hardened steel
- For parts with delicate clamping surfaces
- Please order fastening bolts separately (order no. 6921011023000)

### Serrated jaws (pair)



Order no. jaw width 125: 6921021005031

160: 6921031005031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

- Material: hardened steel
- Standard jaws with small surface area
- To increase the specific contact pressure per unit area
- Please order fastening bolts separately (order no. 6921011023000)

### Soft basic jaws (pair)



Order no. jaw width 125: 6921024023031

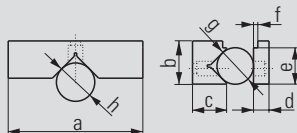
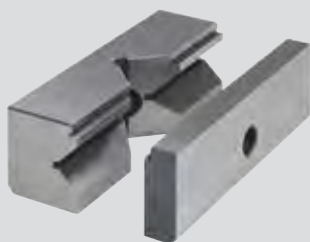
160: 6921034023031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	25	30

- Material: 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Please order fastening bolts separately (order no. 6921011023000)

## ALLMATIC basic – hydraulic (accessories)

### Prismatic jaws (set)



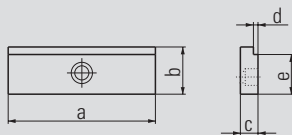
- Material: hardened steel
- For horizontal and vertical clamping of round and flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 125: 6921024024031

160: 6921034024031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	35	45
	d	15	20
	e	35	45
	f	3	3
	g	Ø 12 – 28	Ø 15 – 40
	h	Ø 18 – 55	Ø 22 – 65

### Step jaws (pair)



- Material: hardened steel
- For horizontal clamping of flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 125: 6921024025031

160: 6921034025031

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20
	d	3	3
	e	35	45

### Roller pull-down jaws (pair)



- Material: hardened steel
- For parts with delicate clamping surfaces
- Jaw parts in contact with the workpiece press the workpiece onto the support surface
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 125: 6921024005131

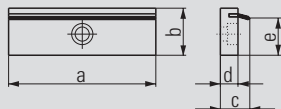
160: 6921034005131

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	26	35.5
	d	35	45



## ALLMATIC basic –hydraulic (accessories)

### Spring leaf pull-down jaws (pair)



Order no. jaw width 125: 6921024001042

160: 6921034001042

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	20	23
	d	12	15
	e	33	43

- Material: hardened steel
- For parts with rough clamping surfaces
- Spring leaves press the workpiece onto the support surface
- Spring leaves are interchangeable, see order no. 6921024002131 and 6921034002131 (see below)
- Please order fastening bolts separately (order no. 6921011023000)

### Spring leaves (pair)



Order no. jaw width

125: 6921024002131

160: 6921034002131

- Spring leaves (spare) for spring leaf pull-down jaws (see above)

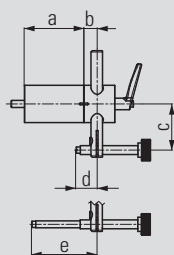
### Jaw fixing bolt



Order no. 6921011023000

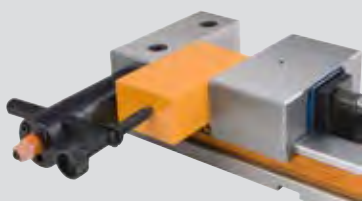
- Bolt with shoulder – M10 x 23
- Suitable for all HD jaws, type 125 to 160

### Workpiece stop



Order no. 6921285650144

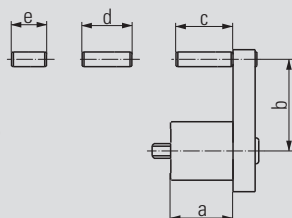
Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5



- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Position of the third workpiece axis can be preset and clamped
- Workpiece stop can be swivelled away once the workpiece has been clamped
- This allows the stop side of the workpiece to also be machined (repeating accuracy:  $\pm 0.01$ )

## ALLMATIC basic – hydraulic (accessories)

### Workpiece stop



Order no. 6921685670042

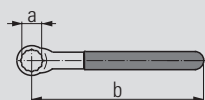
Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Can be pre-mounted with various fixed dimensions
- Position of the third workpiece axis can be preset

### Ring wrench



Order no. 0651110811210



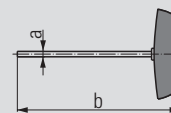
Dimensions in mm	a	SW 19
	b	192

- With grip sleeve made of soft plastic

### T-wrench



Order no. 0651112010536



Dimensions in mm	a	SW 6
	b	182

- For adjusting the clamping range

### Side clamps (pair)



Order no. 6921025000031

- For securing the vice on the machine table
- Supplied as a set of 2 items

Suitable for the Series 125 mm up to 200 mm

### Aligning and fixing set



Order no. – see table

T-slot	Order no.
12	6921185620031
14	6921185621031
16	6921185622031
18	6921185623031

- For securing through the base
- For aligning (positioning) and securing the basic vices on the machine table
- Size according to T-slot in the machine table

### Aligning and fixing set



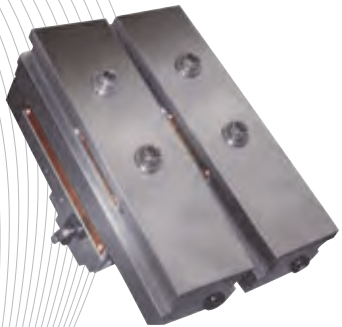
Order no. – see table

T-slot	Order no.
12	6921185600031
14	6921185601031
16	6921185602031
18	6921185603031

- For securing with side clamps
- For aligning (positioning) and securing the basic vices on the machine table
- Size according to T-slot in the machine table

# ZERO-POINT CLAMPING SYSTEMS – IMPORTANT INFORMATION

All our NC-series high-pressure vices can be retrofitted with mounting holes for all standard zero-point clamping systems. Please contact us!



NC vice LC version



NC vice DUO 90 version



NC vice TC version



NC vice DUO Plus version



NC vice T-REX version



NC vice CENTRO Gripp version



Gripp vice TITAN 2 K-M-L version



GRIPP Vice TITAN 2SC 125 version

# STANDARD TERMS AND CONDITIONS OF DELIVERY, ASSEMBLY AND PAYMENT

In these terms and conditions, the term "entrepreneur" shall be defined according to section 14 of the German Civil Code ("BGB") and it shall also include legal entities incorporated under public law special governmental trusts (section 310 (1) sentence, (-1-) of the German Civil Code).

## § 1 Conclusion of contract (general terms of contract, scope of delivery)

- (1) Our deliveries, which also include services, suggestions, consultation and ancillary services, are made only on the basis of the Terms and Conditions laid out below. We hereby reject any contradictory or alternative terms and conditions of the Customer; they shall not be accepted even if we fail to reject them again after we have received them. Upon placement of the order, but at the latest upon acceptance of delivery, the Customer accepts these Terms and Conditions.
- (2) Our offers are non-binding. Alterations and additions to the contract must be made in writing. This also applies to a decision to dispense with this requirement for written form.
- (3) The rights of the Customer arising out of this Contract can only be transferred to third parties with our consent.
- (4) The scope of delivery is in accordance with our written acknowledgement. We are only obliged to deliver in so far as it is possible to acquire the required raw materials, supplies and fuel with the relevant currency. Any reference to DIN (German Institute for Standardization) regulations is to be understood as a description of the contractual performance and not a warranty of specific characteristics. Drawings, illustrations, technical data, details of weight, dimensions and performance are meant only as a guide, unless they are expressly stated to be binding in the order acknowledgement. We retain rights of ownership and copyright to this documentation; third parties must not be granted access to it without our express authorisation.

## § 2 Prices

- (1) Unless agreed otherwise, our quoted prices include loading ex works or warehouse, and excluding statutory value-added tax and all other packaging and freight costs, customs duties and transportation insurance premiums, which are to be charged to the Customer.
- (2) Should the costs connected with the order increase substantially after conclusion of the contract, the contracting parties are obliged to agree an appropriate adjustment of the prices. If no agreement is reached, the contracting parties are entitled to withdraw from the contract. Any further claims are excluded.

## § 3 Payment terms

- (1) Unless an alternative written agreement has been reached, payment is to be made without any deduction within 30 days.
- (2) The withholding of payment or set-off against any possible counterclaims of the Customer that are disputed by us is not permissible. We are entitled, even contrary to the stipulation of the Customer, to set off his payments against another claim. Should the Customer default on payment to the sum of at least 10% of our overall claims against him, it shall be deemed agreed that: All our claims shall become payable immediately. We shall be entitled to make the further processing of all orders from the Customer subject to an advance payment or the furnishing of security, or to refuse further fulfilment after the expiry of a reasonable set additional period.

## § 4 Time limits for delivery, acceptance and call-offs

- (1) If delivery periods are agreed, these are to be calculated from the date on which the goods are made available ex works. Furthermore, they are only approximate. If the Customer does not fulfil his obligations, or if delivery is delayed as a result of unforeseeable or extraordinary events or events over which we have no control in our company or in any of our supplier or transport companies, then an appropriate extension of the delivery date shall be deemed agreed. The same applies in the case of strike or lock-out. Should the hindrance continue for longer than one month, we are entitled to withdraw from the contract. The delivery period begins on the date our order acknowledgement is issued, but not before all technical and commercial details have been settled. Any changes requested by the Customer in the execution of the product ordered have the effect of interrupting and extending the delivery date accordingly. Delays in returning documentation sent for approval also extend the delivery time.
- (2) Should the Customer default on acceptance of goods or services offered to him in accordance with the terms of the contract, he will be required to reimburse our costs at a rate of 25% of the invoice value of the goods, beginning one month after notification that the goods are ready for dispatch, without proof of how such costs have been incurred or the extent of such costs. The Customer is entitled to prove that we have incurred no losses or considerably lower losses.
- (3) We are entitled to otherwise dispose of the delivery goods after the granting and fruitless expiry of a reasonable period of time.

## § 5 Intellectual property rights

In the case of delivery on the basis of drawings, models or details supplied by the Customer, the Customer exempts us from all third-party rights. In the case of breach of contract by the Customer, his intellectual property rights shall not prevent our utilisation of the goods.

## § 6 Transfer of risk

All risk shall pass to the Customer as soon as the goods leave the supplier factory. If goods are taken back for reasons over which we have no control, then the Customer shall bear all risk until the goods are received by us.

## § 7 Warranty

- (1) Standard trade tolerances with regard to dimensions, amounts, weight, grain size, quality, colour, etc., are not grounds for complaint by the Customer. In case of doubt, the weight established by us is applicable. In case of complaint, the specifications agreed with the Customer are applicable.
- (2) Our technical advice and recommendations are based on appropriate examination, but are given without contractual obligation. In particular, checking whether the goods ordered or those suggested by us are suited to the purpose intended by the Customer is the sole responsibility of the Customer. A warranty of specific characteristics must always be given in writing. This also applies to any decision to dispense with the requirement for written form. The characteristics of the purchased object and the purpose for which it is intended are based solely upon our product description. Any other agreements reached must be confirmed in writing.
- (3) Complaints must be made in writing no later than two weeks after receipt of the goods. Hidden defects must be reported immediately when they are discovered. We have a right to examine goods about which complaints are made. Should the Customer not permit this, his claims shall lapse. In the case of a justified complaint, the Customer's rights are restricted to supply of replacement goods free of charge and free of freight costs, or repair by us.

- (4) Should repair or replacement fail, the Customer shall grant a reasonable additional period of time and can, after fruitless expiry of this period, demand either termination of the contract or reduction of the purchase price, at his option. More far-reaching claims by the Customer, particularly to reimbursement of processing costs, costs of assembly and disassembly and for damage not affecting the object supplied, are excluded as far as legally permissible.
- (5) If a partial delivery is defective, no rights in respect of the remaining partial delivery can be derived. We are entitled to refuse to fulfil claims based on defective performance as long as the Customer does not fulfil his obligations.
- (6) The following circumstances do not constitute defects:
  - damage resulting from normal wear and tear to wearing parts
  - damage caused by improper handling, particularly as a result of inadequate maintenance or lack of maintenance
  - damage caused by electrical connections in the building which do not conform to the regulations of the Federation of German Electrical Engineers (VDE)
  - damage caused by a failure to observe our operating and maintenance instructions.
- (7) In order that all repairs and replacement deliveries can be made which appear necessary to us in our fair judgment, the Customer must, after consultation with us, provide sufficient time and opportunity, otherwise we are released from liability for the defects. Only in the case of an emergency which endangers operational safety and to prevent disproportionately serious damage, in which case we must be informed immediately, or if we are in default regarding the rectification of defects, does the Customer have the right to rectify the fault himself or to have the fault rectified by a third party and demand reimbursement from us for the costs incurred.
- (8) Warranty claims lapse 24 months from the date on which the Customer takes possession of the goods. In the case of deliveries and services that are subject to contracts for work and services, the warranty period is 24 months from acceptance. If acceptance does not take place in our factory, it is deemed to have taken place if a declaration is made to us after delivery or if the goods supplied are utilised for the purpose intended.

## § 8 General limitation of liability

We restrict our liability for negligent breach of obligations by us or by our servants or agents to liability for contractually typical, foreseeable damage.

## § 9 Liability under the German Product Liability Law

- (1) Exclusions of liability under these Standard Terms and Conditions of Delivery, Assembly and Payment do not apply to claims of private consumers and users, irrespective of fault, under German Product Liability Law (Produkthaftungsgesetz).
- (2) We are only liable to the Customer for compensatory and recourse claims if it can be proven that we are responsible for a defect in the goods supplied by us.

## § 10 Retention of title

- (1) All the goods supplied by us remain our property (goods subject to retention of title) until all claims are fulfilled, in particular the balance claims due to us, regardless of the legal basis under which these claims arise. This also applies if payments are made in respect of specifically identified claims. The Customer is obliged to store and label separately the goods subject to retention of title.
- (2) Handling and processing of goods subject to retention of title are done for us as the manufacturer according to § 950 BGB (German Civil Code), without imposing any obligations on us. The processed goods are deemed goods subject to retention of title according to Clause 1 above. If the Customer processes, combines or mixes goods subject to retention of title with other goods, we attain co-ownership of the new object in proportion to the ratio between the invoice value of the goods subject to retention of title and the invoice value of the other goods used. If our ownership is extinguished through mixing or combination, the Customer herewith assigns to us his rights of ownership of the new object to the extent of the invoice value and holds them in safe custody for us free of charge. The rights of co-ownership arising under this clause are deemed goods subject to retention of title according to Clause 1 above.
- (3) The Customer may only sell the goods subject to retention of title in the ordinary course of business under his standard terms and conditions and as long as he is not in default, and only provided that the claims arising out of the resale in accordance with Clauses 4 and 5 are assigned to us. He is not entitled to dispose of the goods subject to retention of title in any other way.
- (4) The Customer's claims arising out of the resale of the goods are herewith assigned to us. They serve as security to the same extent as the goods subject to retention of title themselves. Any further assignment of these claims is excluded. We accept the claims.
- (5) If the goods in which we have co-ownership under Clause 2 above are sold, the assignment of claims applies in the amount of the co-ownership share or the invoice value. At our request, the Customer is obliged to immediately inform his buyer of the assignment to us and to provide us with the information and documentation required to enforce these claims. The Customer is obliged to inform us immediately of any seizure or impairment by third parties.
- (6) If the value of the existing securities exceeds the secured claims by more than 10% in total, we are to this extent obliged to release securities of our choice upon request by the Customer

## § 11 Place of fulfilment and jurisdiction

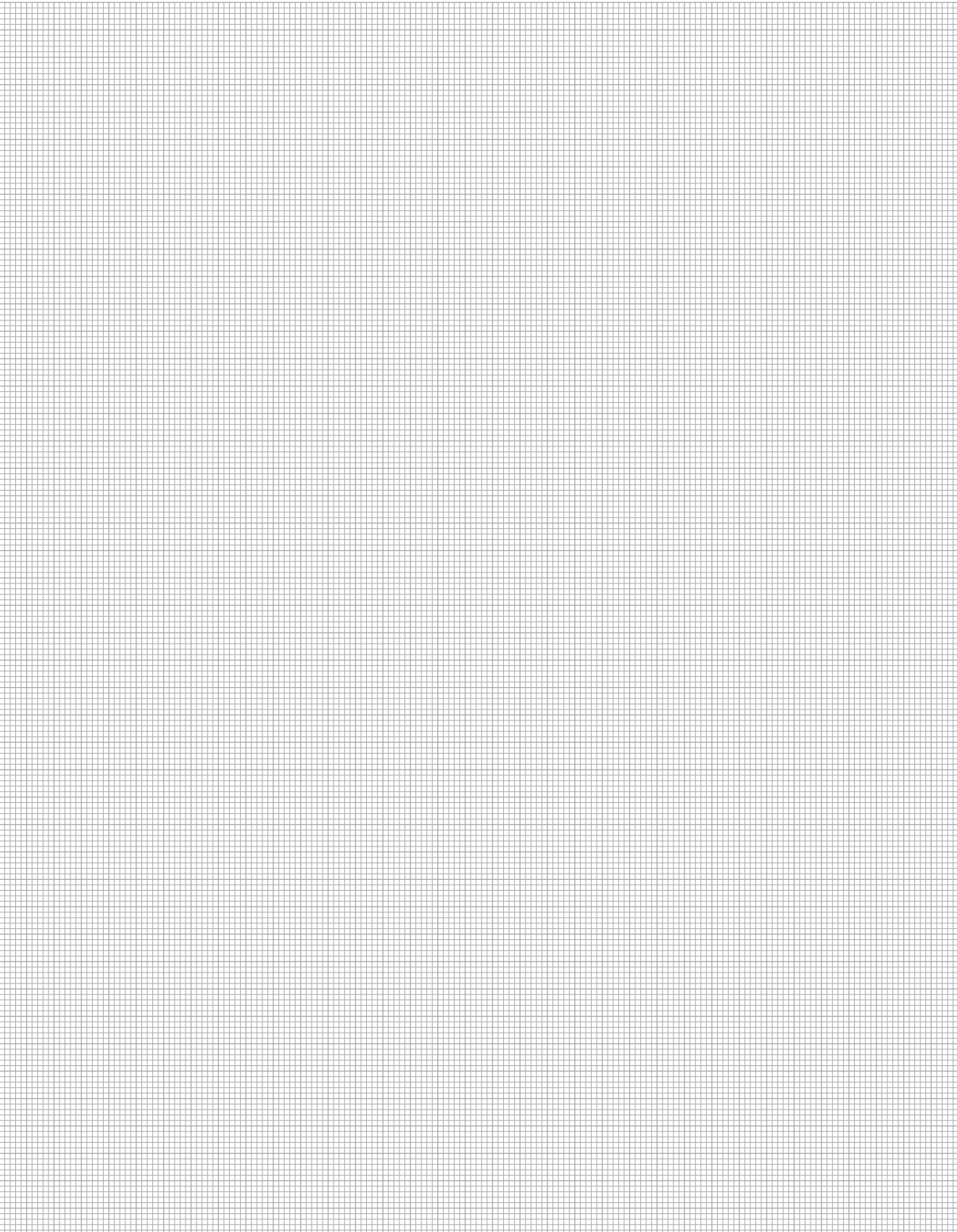
- (1) The place of fulfilment for payments and for all other obligations is our registered office.
- (2) Jurisdiction is that of our registered office, including for actions filed under the special procedure for claims arising from bills of exchange and cheque payments. We are entitled to take action against the Customer at his place of general jurisdiction. This is applicable unless otherwise stipulated in an arbitration agreement in individual cases.
- (3) The law of the Federal Republic of Germany is exclusively applicable to all legal relations between the Customer and ourselves; application of the UN Convention on Contracts for the International Sale of Goods is excluded.

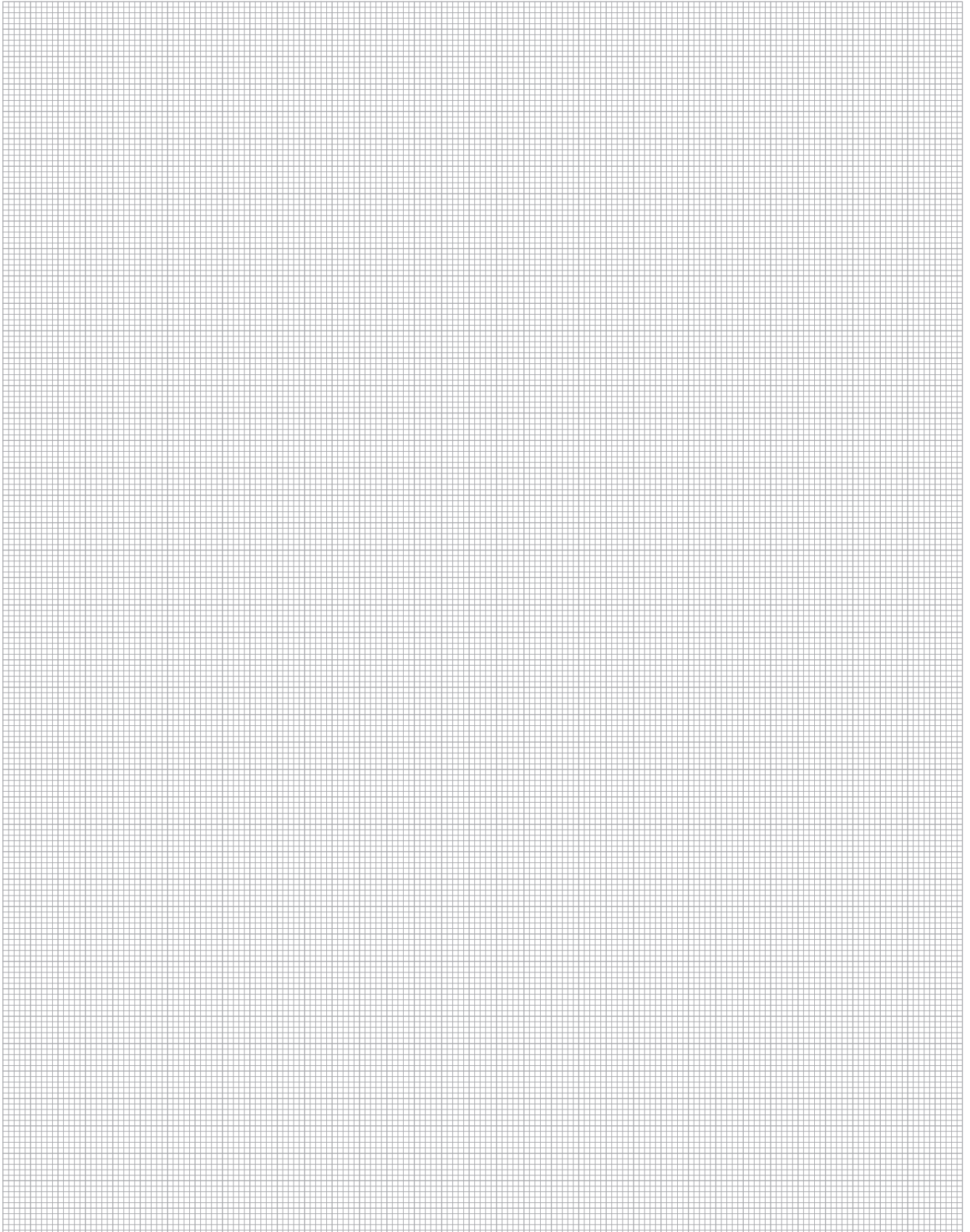
## § 12 Severability

Should individual provisions of these standard delivery and payment terms be completely or partially invalid or void, then the contracting parties are obliged to agree a provision by which the purpose and aim of the invalid or void provision is best achieved. For the rest, the valid contractual agreements are upheld.

# SPACE FOR YOUR NOTES AND SKETCHES

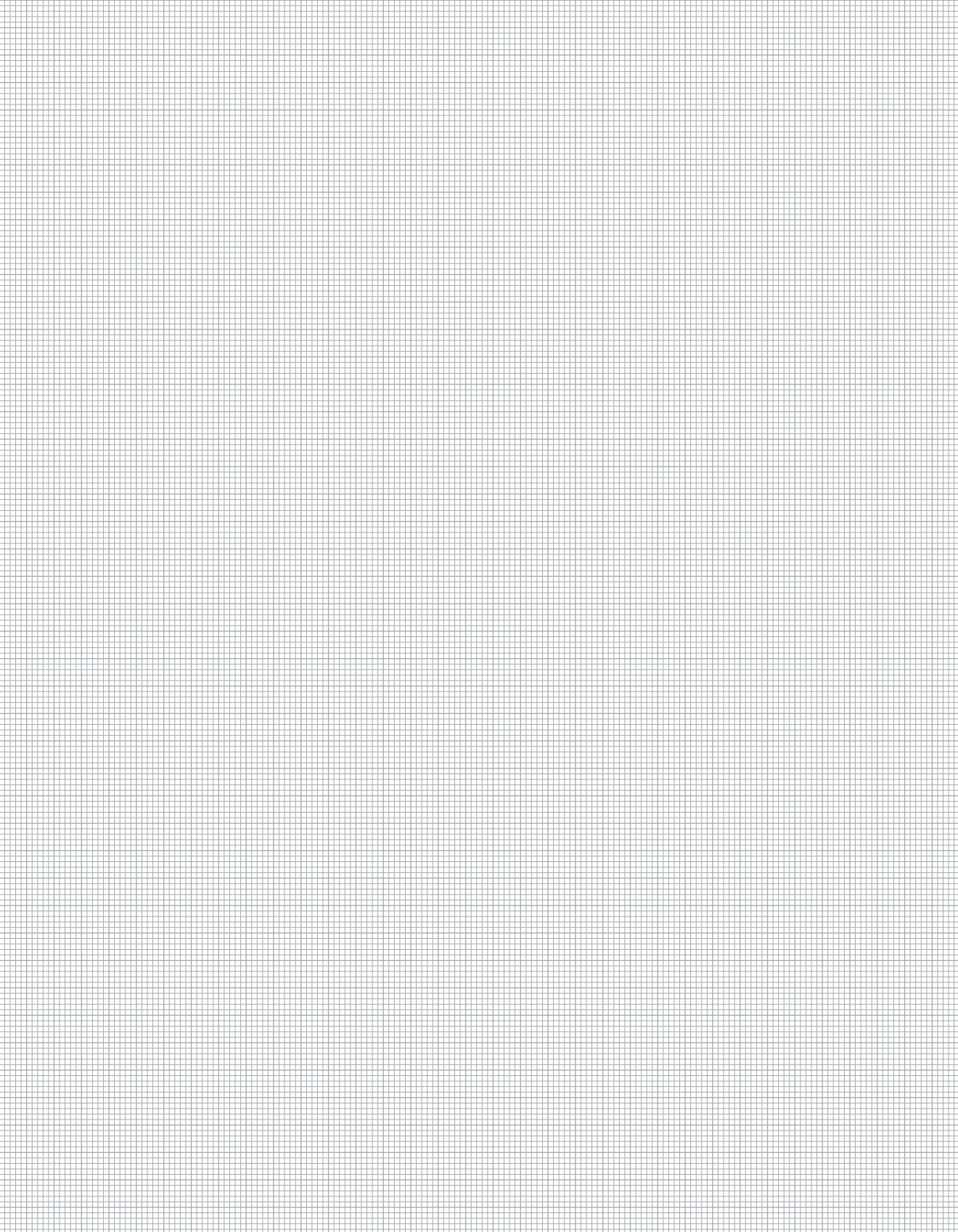
NOTES AND SKETCHES





# SPACE FOR YOUR NOTES AND SKETCHES

NOTES AND SKETCHES



Distributor's stamp

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