ZERO-POINT-SYSTEMS

CLAMPING. SCREWING. LOCKING.

Catalogue 2015/2016

WE GENERATE EXCITEMENT

Since its founding by Andreas Maier in 1890, our company has lived though many exciting times. Today we are the leading manufacturer in Europe, supplying over 5,000 different products from the fields of clamping, hand tools and locks. With this extensive product range we can meet all of our customers' needs and requirements. But providing optimal quality means meeting the challenges at all levels: Expert consultation, modern team organisation, individual solutions (including special developments), flexibility in response to changing conditions, etc. And we ourselves find this so exciting that we look forward every day to shaping the market together with our employees and our customers – both now and in the future. That is something you can count on.

COMPANY HISTORY

1890 Company founded as a lock manufacturer by Andreas Maier.

1920 Product range extended to include spanners.

1928 Production line assembly of „Fellbach locks".

1951 AMF introduces clamping elements and diversifies into workpiece and tool clamping technology.

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

1975 Further specialisation into hydraulic clamping technology.

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

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

2001 AMF Service Guarantee for all products.

2004 Introduction of the ZPS zero-point clamping system.

2007 The magnetic clamping technology extends the AMF product range.

2009 Development and marketing of AMF Vacuum clamping technology

2012 AMF-Writer and AMF-Cleaner for automated labelling and cleaning via the tool spindle

MANAGING DIRECTORS

> Johannes Maier
Volker Göbel

THE AMF SERVICE GUARANTEE

> Assuredly on the way to the top

5 Individual development
And if the product you need doesn't exist? Just ask us: We will find the best solution for you – whether it is a special version or a completely new development.

4 Warranty
We stand by our high quality standards. We handle customer complaints very liberally and without red tape – whenever possible even after the end of the warranty period.

3 Guaranteed quality standard
AMF stands for manufacturing in-house with the utmost care. A tradition we have upheld since 1890 – and naturally for many years now with a modern quality management system to ISO 9001.

2 Short delivery times
AMF's finished goods inventory with over 5,000 items guarantees a delivery readiness of 98%. You can also count on each warehouse item you order being shipped to you on the same day.

1 Service from genuine experts
„Different tasks, different solutions. In AMF's professional product range, you can find the right solution quickly and reliably:
either from your local dealer or with help from the specialists in our teams. A phone call is all it takes."

E Made in Germany
It goes without saying that our range of products is developed and manufactured by our team of employees in Germany.

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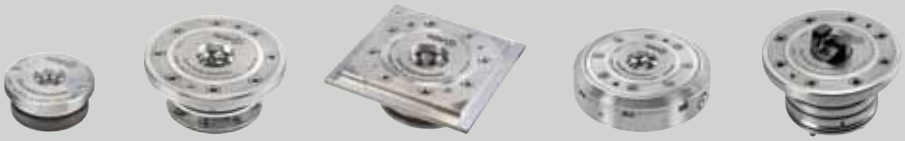

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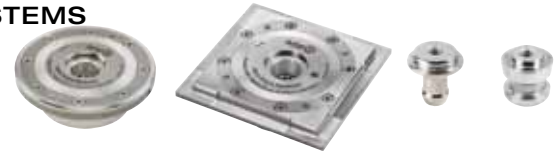

NEW!

COVER RING FOR CLAMPING MODULES

No.6210ZN, page 117

NEW!

COVER RING FOR CLAMPING MODULES

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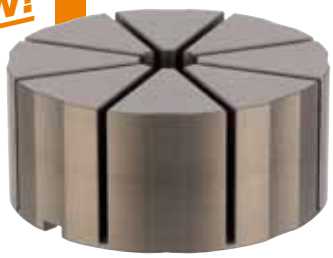
NEW!

NEW!

COLLET ATTACHMENT

No. 6370ZSZ-112, page 106



4-POINT CLAMPING STATION, MECHANICAL

No. 6207S4, page 142

NEW!

NEW!

CLAMPING MODULE, MECHANICAL

No. 6208M / No. 6208IM, Pages 114-115

NEW!

DOUBLE CLAMPING MODULE, MECHANICAL

No. 6208MD, page 116

INSTALLATION CLAMPING MODULE WITH CENTRAL LOCK FOR AUTOMATION SOLUTIONS

No. 6107HA-20-07, page 74

NEW!

INSTALLATION CLAMPING MODULE FOR AUTOMATION SOLUTIONS

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NEW!

NEW!

PNEUMATIC CLAMPING STATIONS K10.3 / K20.3

Pages 82-83

NEW!

CLAMPING MODULE WITH SENSOR MONITOR

No. 6104L, No. 6105L, No. 6106L, Pages 78-80

QUADRUPLE CLAMPING STATION

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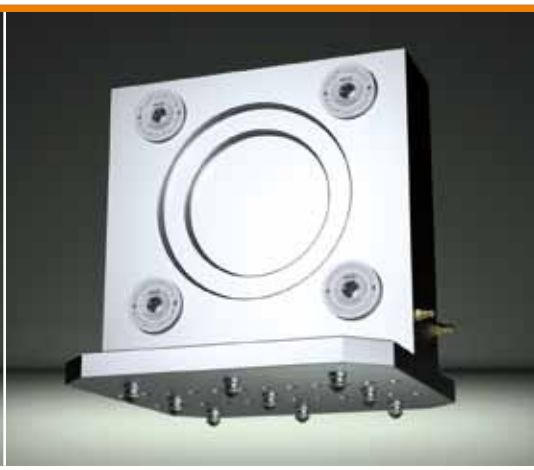
NEW!



ECONOMICAL, PRECISE, QUICK
- THE AMF ZERO-POINT SYSTEM

By using modern AMF zero-point systems, you optimize fixture and workpiece changeover in your production, correspondingly reduce set-up times on the machine and so save money!

The benefits of zero-point clamping technology are obvious:

> Increase in machine run-time

> Very fast workpiece or fixture changeover

> High repeatability

> A uniform interface for all machines

> Positioning and clamping in a single step

> The clamping nipple in our zero-point system is the interface between the machine table and the workpiece or fixture. It ensures exact positioning and secure clamping. The resulting work forces are transferred through the clamping nipple to the clamping module.

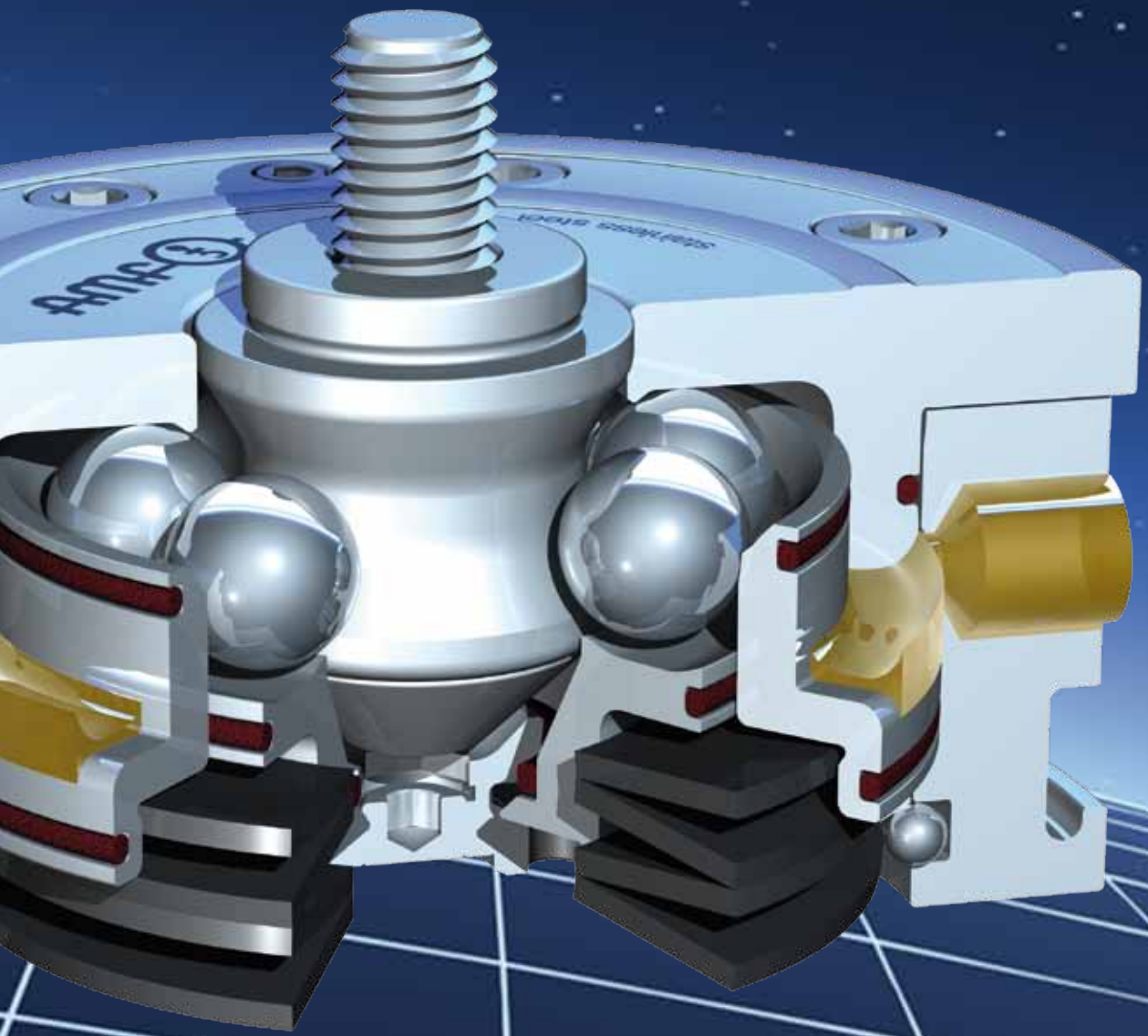
> The precisely manufactured clamping modules of the AMF Zero-Point System ensure a secure and firm hold of the workpiece or fixture to be clamped. With the high pull-in, closing and holding forces, they are suitable for every application.

Subject to technical alterations.

YOUR ADVANTAGES - THOUGHT THROUGH IN

Experience a zero point clamping system that, through its innovative and forward-looking features, presents its strengths in use in an advanced way.

Numerous advantages speak for themselves and make the AMF zero-point system into a technology that revolutionizes the zero-point clamping technology market.



DETAIL

LARGE INTAKE CATCHMENT

No laborious searching for the holes anymore - self-centring via the diagonal side surfaces of the engagement nipple screw.

SWING-FREE

Swing-free run-in and run-out through the optimal contour of the clamping nipple.

MEDIA FEED

Due to the lateral media feed, low pallet thicknesses are possible and fewer feed holes are necessary.

FORM FIT

The balls are optimally encapsulated on 3 sides. As a result, the clamping nipple always remains firmly clamped in the module.

THREE-POINT PRINCIPLE

Power transmission by means of the three-point principle! This optimised force distribution prevents shearing load on the balls.

NO BALL CAGE

The balls lie freely in the ball canal. This freedom of movement enables the balls to continuously re-position themselves.

STAINLESS STEEL

High-alloy, hardened tool steel - and so no corrosion.

BLOW OUT

Our system has a pneumatic blow-out installed at the factory. As a result, chips and dirt inside are effectively blown out.

SIMPLE CLEANING

Our zero-point clamping sytems can be blown out very simply with a commercially available compressed air cleaning pistol and do not require complicated suctioning out.

GOOD HOLDING, PULL-IN AND LOCKING FORCES

Size	Holding force	Pull-in/locking force	
		hydr.	pneum.
K5	13	5	1,5
K10	25	10	8
K20	55	20	17
K40	105	40	30

LARGE BALL DIAMETER

Ball surface is 784% greater than with traditional ball systems.

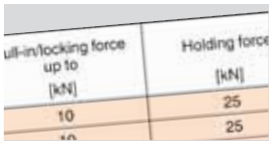
SAFETY SYSTEM

Process reliability - Clamping module always opens. A piston blockade is thus impossible.

^!^!Subject to technical alterations.^!

FAQS ABOUT ZERO-POINT CLAMPS AND THE AMF ZERO-POINT SYSTEM

WHAT IS PULL-IN FORCE / HOLDING FORCE?



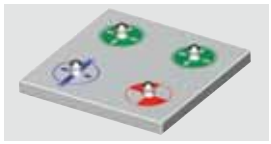
ull-in/locking force up to [kN]	Holding force [kN]
10	25
	25

> The pull-in force describes the force with which the nipple is pulled in and clamped with positive interlocking in the clamping module. The holding force, in contrast, specifies the maximum permissible pull force of the engagement nipple screw.

WHAT IS REPEATABILITY?

> The repeatability specifies the tolerance range within which the recorded reference points on the workpiece lie after removal and reclamping of the same workpiece. The repeatability, also called repetition accuracy, is below 0.005mm.

WHAT ADVANTAGES RESULT FROM THE USE OF ZERO-POINT, SLIT AND UNDERSIZE NIPPLES?

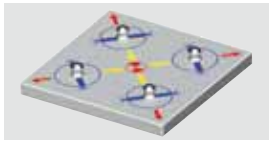


> These different types of nipples offset the spacing tolerances of nipples and clamping modules. The fixed reference point is achieved through the zero-point nipple; the timing nipple serves to compensate for the still-free axis. The undersize nipple does not have a centring function, but only a clamping and holding function.

CAN I INSERT THE CLAMPING NIPPLE DIRECTLY INTO THE WORKPIECE FOR MACHINE PROCESSING?

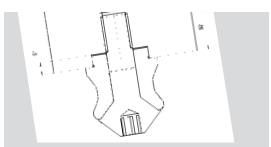
> The high costs for chucking fixtures and workpiece clamping can be effectively saved here if the clamping nipples are mounted in the workpiece, which is clamped directly using the clamping modules. As a result, a complete 5-sided processing of the workpiece is possible in one chucking. With the different nipple sizes (attaching thread M6 to M16), workpieces of different sizes can be clamped..

HOW DOES THE SYSTEM COMPENSATE FOR HEAT, SUCH AS FROM METAL CUTTING?



> Through the different clamping nipple designs, the system can compensate for temperature differences between the workpiece and the clamping module easily and controllably. For a graphic depiction of the nipple array, see page 47 of the catalogue. If you have other technical questions, please contact us at any time.

WHAT SHOULD BE THE SPACING TOLERANCE OF THE CLAMPING NIPPLES AND THE CLAMPING MODULES IF SELF-PRODUCED?



> The recommended spacing tolerance of clamping nipples and clamping modules is +/- 0.01mm.

WHERE CAN I GET AN INSTALLATION DIAGRAM OR INSTALLATION MANUAL?

> We are happy to send them immediately when customers request them by e-mail..

IS THE CLAMPING MODULE SUITABLE FOR ERODING?

> The module is optimally suited for all normal processes, such as eroding, grinding, cutting and turning. Through the complete sealing, the clamping module can be used in liquids and under rough ambient conditions.

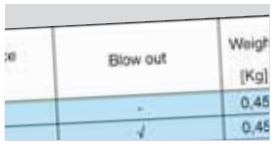
IS THE CLAMPING MODULE SUITABLE FOR USE ON INJECTION MOULDING MACHINES?

> Especially when injection moulds are changed frequently, the costs for a zero-point solution are amortized within the shortest of times for such machines. Unlike with mechanical clamps, clamping takes place quickly and easily just by pressing a button.

HOW HIGH IS THE MAX. OPERATING TEMPERATURE OF THE CLAMPING MODULES?

> The maximum processing temperature is 80°C in the standard design. Clamping modules for use at higher temperatures can be requested at any time.

WHAT IS BLOW-OUT AND HOW DOES IT WORK?



> Blow-out using compressed air is guided through the floor of the clamping module and blows out contamination, such as chips, coolant or the like from the central opening and from the sphere

WHEN DO I USE THE HYDRAULIC PRESSURE INTENSIFIER AND WHEN THE PNEUMATIC PRESSURE INTENSIFIER?

> Hydraulic pressure intensifier: This transforms the pneumatic into hydraulic pressure in a ratio of 1:8 to open hydraulic modules. Pneumatic pressure intensifier: This is used to intensify the pneumatic pressure in the ratio of 1:2 for pneumatic clamping modules and compensates for pressure fluctuations in the supply line.

HOW DOES THE PATENTED SAFETY SYSTEM WORK IN THE HYDRAULIC CLAMPING MODULE AND WHEN IS IT USED?

> If the piston seal begins to leak, the spring space quickly fills with oil. The result is: The piston blocks and the module can no longer be opened. Destruction of the clamped fixture of the of clamping module would then be unavoidable. Here, the patented safety system ensures that the oil in the spring space can escape and the piston can be operated.

ARE YOU PRODUCING YET OR STILL SETTING UP?

THE CALCULATION IS VERY SIMPLE!

It has been shown that you can reduce your set-up times by over 90% through the use of the AMF Zero-Point System. High machine standstill times are avoided, set-up times minimized and cash saved...

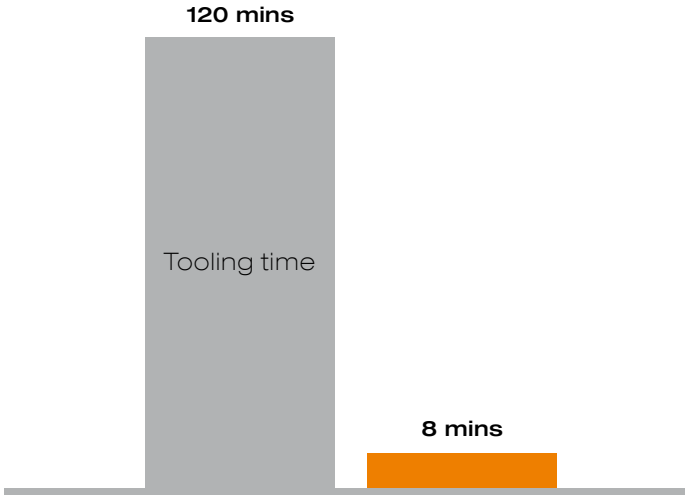
Take the time to calculate your savings potential with the AMF Zero-Point System very simply.

SAMPLE CALCULATION OF A CUSTOMER BEFORE AND AFTER USE OF THE ZERO-POINT SYSTEM

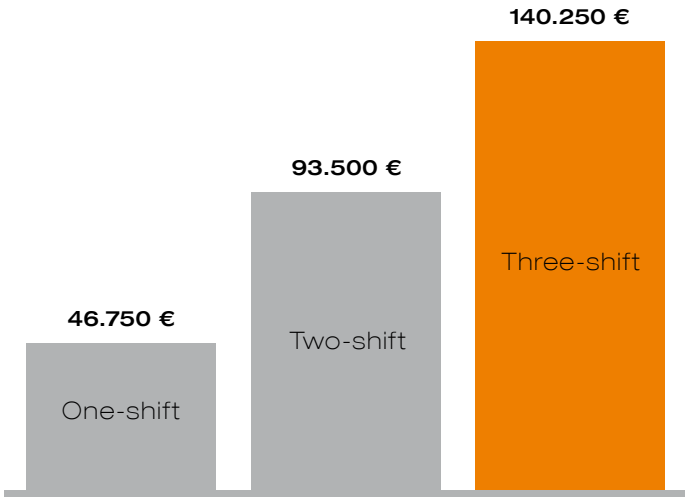
Procedure	Without zero-point clamping system	With the AMF Zero Point System
Machine costs	€ 100,–– / h	€ 100,–– / h
Number of set-ups per shift (8h)	4 x	4 x
Set-up time per procedure	30 mins	2 mins
Set-up time per shift (8h)	120 mins (2 h)	8 mins (0,13 h)
Set-up costs per shift (8h)	€ 200,––	€ 13,––
Set-up costs per shift each year (250 working days)	€ 50.000,––	€ 3.250,––
Annual savings per shift (8h)	**€ 46.750,--**	

DRASTICALLY REDUCED SET-UP TIMES GUARANTEE YOU WILL EXPERIENCE A RAPID RATIONALISATION EFFECT

If previously 120 mins had to be invested in four tooling procedures in a shift, the use of the AMF Zero Point System will reduce this to only 8 mins. Rapid switching of equipment and workpieces as well as tooling in parallel with operating time outside of the machine results in the rationalisation effect described. The savings in our customer example of €140.250 per year, for three-shift production utilisation, guarantees rapid amortisation of the invested amounts of approx. €3,750 for a 4-capacity clamping station including accessories.



Tooling times drastically reduced from 120 mins to 8 mins - through the use of the AMF Zero Point System.



Whether one, two or three-shift operation - the savings from the AMF Zero Point System speak for themselves!

Subject to technical alterations.

COLOUR CODING SYSTEM FOR HYDRAULIC AND PNEUMATIC CLAMPING MODULES.

Table portion with bright ORANGE background: Open hydraulically!

Table portion with bright BLUE background: Open pneumatically!

	K02	K5		K10 and K10.2		K10.3	K20		K20.3	K40	
	pneum.	hydr.	pneum.	hydr.	pneum.	pneum.	hydr.	pneum.	pneum.	hydr.	pneum.
Pull-in/locking force in the system up to [kN]	0,23	5,0	1,5	10,0	8,5	10,0	20,0	17,0	17,0	40,0	30,0
Holding force [kN]	6,0	13,0	13,0	25,0	25,0	25,0	55,0	55,0	55,0	105,0	105,0
Service according to ... clamping cycles [pc.]	2.500.000	250.000	2.000.000	2.500.000	400.000	4.000.000	1.500.000	150.000	4.000.000	100.000	150.000
Min./max. operating pressure for opening [bar]	6 / 14	50 / 60	8 / 12	50 / 60	8 / 12	5 / 12	50 / 60	8 / 12	4,5 / 12,0	50 / 60	8 / 12
Min./max. operating pressure for reclamping [bar]	-	-	5 / 6	-	5 / 6	-	-	5 / 6	-	-	5 / 6
Opening volume [cm³]	1,0	1,5	1,5	3,0	3,0	17,0	10,0	10,0	37,0	27,0	27,0
Closing volume [cm³]	-	-	-	-	-	-	-	-	-	-	-
Pre-positioning [mm]	1,0	4,0	4,0	6,5	6,5	6,5	12,0	12,0	12,0	12,0	12,0
Repeatability [mm]	< 0,02	< 0,005	< 0,005	< 0,005	< 0,005	< 0,005	< 0,005	< 0,005	< 0,005	< 0,005	< 0,005

	Horizontal K20	Horizontal K40	Compact K10	Turbine K23	Heavy duty K20
	hydr.	hydr.	hydr.	hydr.	hydr.
Pull-in/locking force in the system up to [kN]	20	40	13	23	20
Holding force [kN]	55	105	25	23	105
Service according to ... clamping cycles [pc.]	1.500.000	100.000	150.000	150.000	150.000
Min./max. operating pressure for opening [bar]	50 / 60	50 / 60	50 / 60	25 / 50	50 / 60
Min./max. operating pressure for reclamping [bar]	-	-	-	20	-
Opening volume [cm³]	10,0	27,0	3,5	7,5	10,0
Closing volume [cm³]	-	-	-	10,7	-
Pre-positioning [mm]	11,0	11,0	4,0	1,0	12,0
Repeatability [mm]	< 0,005	< 0,005	< 0,005	< 0,005	< 0,005

Subject to technical alterations.

REPRESENTS GOOD VALUE FROM THE GROUND UP
- THE K10.2 CLAMPING MODULE

Zero-point clamping does not have to be expensive. With the K10.2 clamping module we offer you the best technology at a favourable price.

The advantages speak for themselves:

> Outstanding price-performance ratio

> Drastically reduced tooling time

> Immediate improvement of productivity

> Repeat accuracy < 5um

> Stainless steel

> Form fit

> Fitting depth of only 22 mm!

6 COMPONENTS FOR PERFECT CLAMPING - 5 BAR COMPRESSED AIR FOR OPENING WITH THE AIR HYDRAULIC PUMP

1 Absolutely insensitive to lateral and pull forces that arise. Precision ground support surfaces made of hardened stainless steel for plane-parallel clamping ≤ 0.005 mm.

2 Hardened piston - the combination of form fit and self-locking results in reliable and constant clamping.

3 Precision balls for optimal power transmission as well as vibration-inhibiting and wear-resistant use.

4 Ball support made of stainless steel seals the clamping module against dirt and liquids..

5 Robust plate springs for maximum pull-in, closing and holding forces.

6 Module floor with integrated air jet function.

A The low installation depth of the clamping modules of 22 mm permits a height of the base plate of only 28 mm (without blow out, only 24 mm)..

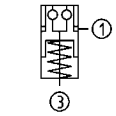
Subject to technical alterations.

No. 6204HA

Installation clamping module K10.2

Hydraulic opening.
Pneumatic blow-out.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
427369	K10.2	10	25	●	0,6

Application:

Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

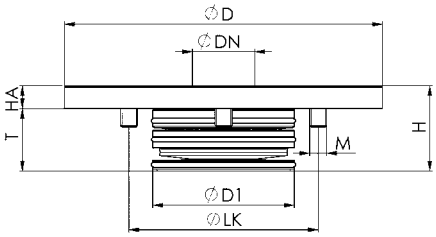
Note:

The installation clamping module K10.2 is opened with the air-hydraulic pump, order no. 426569, with 5 bar pneumatic input pressure.
The clamping module has high holding, pull-in and locking forces. It is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module with blow-out and support control has two connections: 1x hydr. opening (1) / 1x pneum. blow-out and support control (3). (The pneumatic blow-out and support control can optionally be connected.)

On request:

- Installation diagrams

CAD



Dimensions:

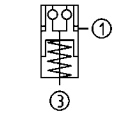
Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	M	T
427369	K10.2	112	22	50	30	8	77	M6	22

No. 6204IHA

Installation clamping module K10.2 with 4-way indexing

Hydraulic opening.
Pneumatic blow-out.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
428490	K10.2	10	25	●	0,6

Application:

Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.
The indexing function of the clamping module prevents the pallet from twisting, enabling exact positioning every 90°.

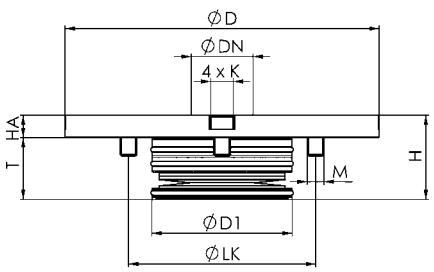
Note:

The installation clamping module K10.2 with 4-way indexing is opened with the air-hydraulic pump, order no. 426569, with 5 bar pneumatic input pressure.
The clamping module has high holding, pull-in and locking forces. It is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module with blow-out and support control has two connections: 1x hydr. opening (1) / 1x pneum. blow-out and support control (3). (The pneumatic blow-out and support control can optionally be connected.)

On request:

- Installation diagrams

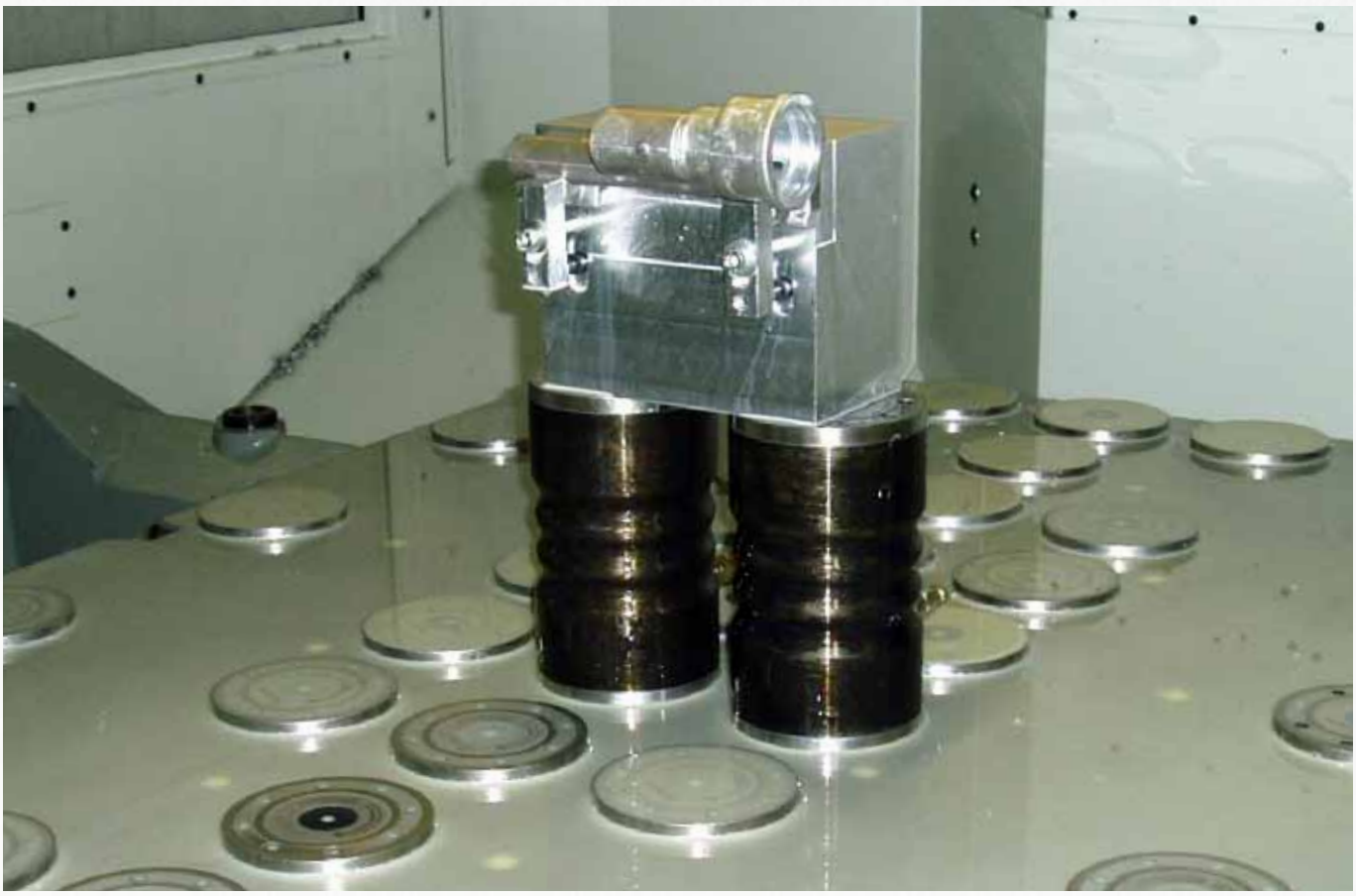
CAD



Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	K F6	dia. LK	M	T
428490	K10.2	112	22	50	30	8	8	77	M6	22

Subject to technical alterations.

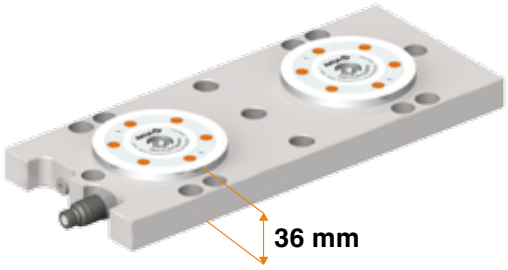


Subject to technical alterations.

No. 6204S2HA-001

Double clamping station

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.



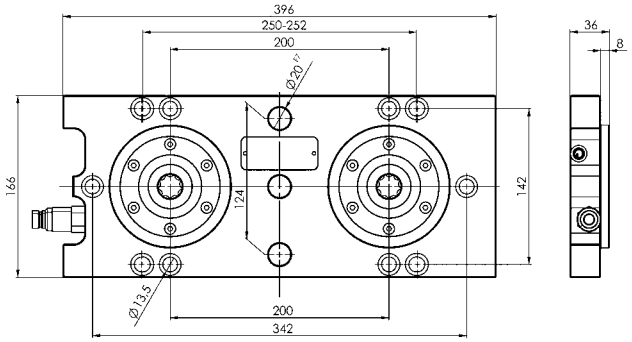
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
427484	K10.2	2 x 10	2 x 25	●	14

Design:

Hydraulic clamping station for optimised clamping times on machine tables with distance between slots of 63, 100 and 125 mm. Clamping is with M12 socket head screws. At least two fitting holes are attached for alignment.
The insertion dimension of the clamping modules is 200 mm. The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.

Advantage:

Low overall height of only 36 mm.

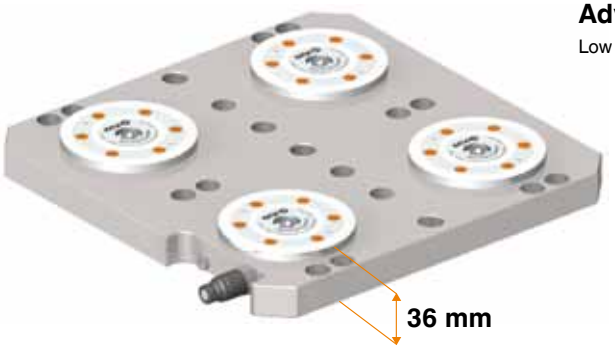


CAD

No. 6204S4HA-001

Quadruple clamping station

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.



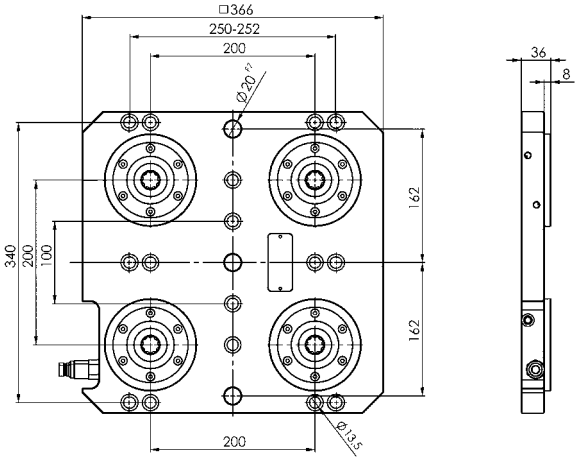
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
427500	K10.2	4 x 10	4 x 25	●	30

Design:

Hydraulic clamping station for optimised clamping times on machine tables with distance between slots of 63, 100 and 125 mm. Clamping is with M12 socket head screws. At least two fitting holes are attached for alignment.
The insertion dimension of the clamping modules is 200 mm. The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.

Advantage:

Low overall height of only 36 mm.



CAD

Subject to technical alterations.

No. 6204S6HA-001

Sextuple clamping station

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

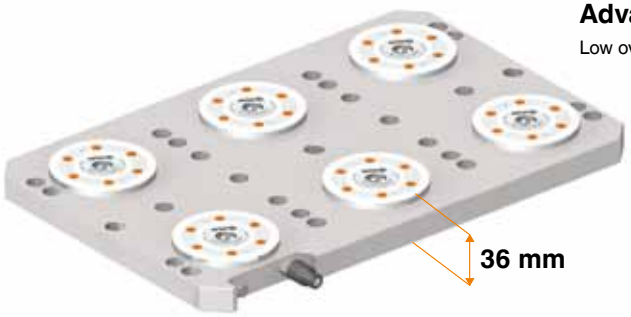
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
427526	K10.2	6 x 10	6 x 25	●	46

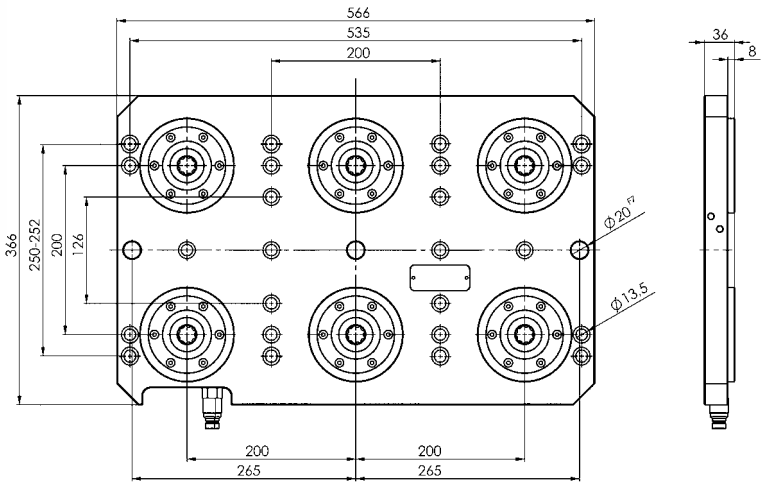
Design:

Hydraulic clamping station for optimised clamping times on machine tables with distance between slots of 63, 100 and 125 mm. Clamping is with M12 socket head screws. At least two fitting holes are attached for alignment.
The insertion dimension of the clamping modules is 200 mm. The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.

Advantage:

Low overall height of only 36 mm.





CAD

No. 6204S8HA-001

8-fold clamping station

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

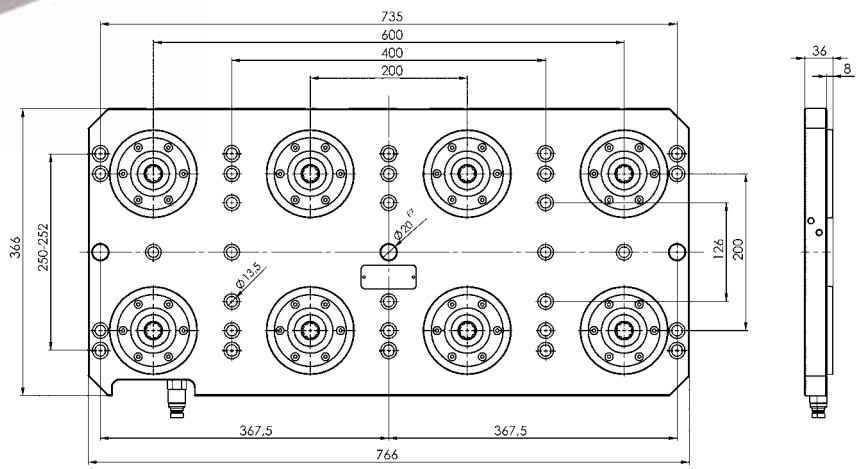
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
427542	K10.2	8 x 10	8 x 25	●	63

Design:

Hydraulic clamping station for optimised clamping times on machine tables with distance between slots of 63, 100 and 125 mm. Clamping is with M12 socket head screws. At least two fitting holes are attached for alignment.
The insertion dimension of the clamping modules is 200 mm. The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.

Advantage:

Low overall height of only 36 mm.



CAD

Subject to technical alterations.

No. 6204S4HA-002

Quadruple clamping station

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
427492	K10.2	4 x 10	4 x 25	●	37

Design:

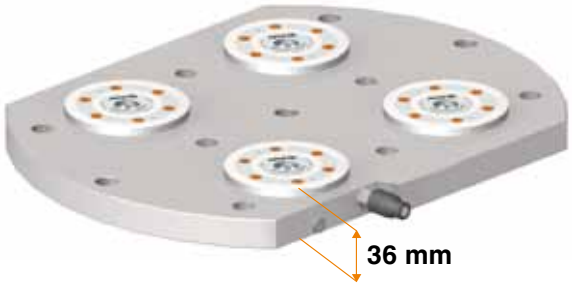
Hydraulic clamping station for optimised clamping times on machine tables with distance between slots of 63 mm. Clamping is with M12 socket head screws. At least two fitting holes are attached for alignment.
The insertion dimension of the clamping modules is 200 mm. The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.

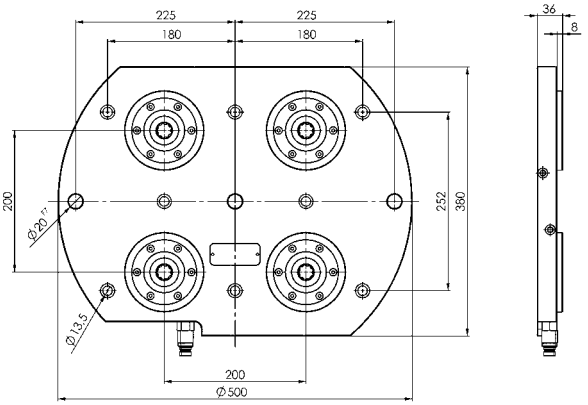
Application:

e.g. for DMG / DMU 50 EVO

Advantage:

Low overall height of only 36 mm.





CAD

No. 6204S4HA-003

Quadruple clamping station

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
427518	K10.2	4 x 10	4 x 25	●	38

Design:

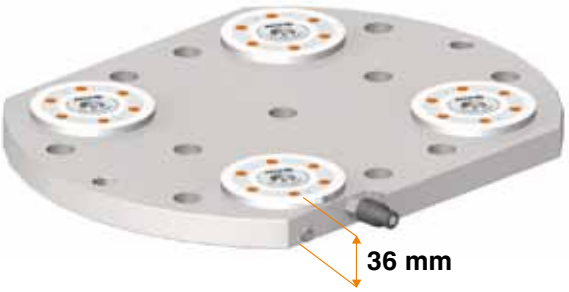
Hydraulic clamping station for optimised clamping times on machine tables with distance between slots of 80 mm. Clamping is with M16 socket head screws. At least two fitting holes are attached for alignment.
The insertion dimension of the clamping modules is 240 mm. The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.

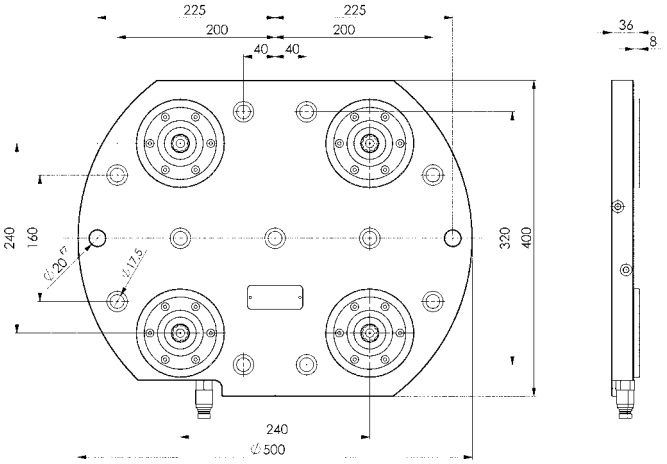
Application:

e.g. for Mazak Variaxis 500

Advantage:

Low overall height of only 36 mm.





CAD

Subject to technical alterations.

No. 6204S6HA-002

Sextuple clamping station

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
427534	K10.2	6 x 10	6 x 25	●	62

Design:

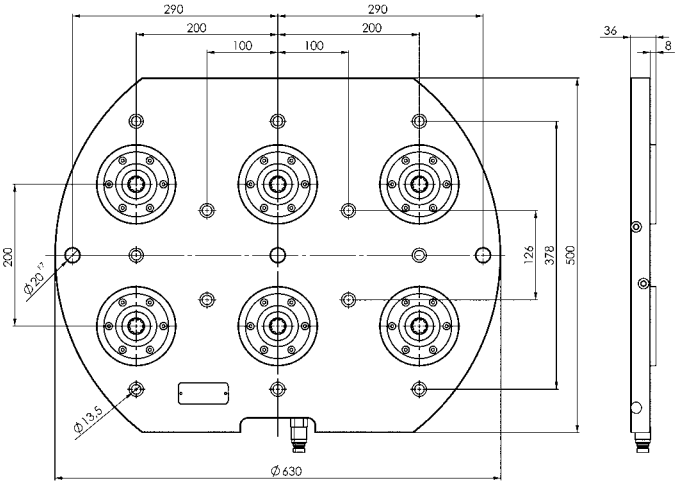
Hydraulic clamping station for optimised clamping times on machine tables with distance between slots of 63 mm. Clamping is with M12 socket head screws. At least two fitting holes are attached for alignment.
The insertion dimension of the clamping modules is 200 mm. The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.

Application:

e.g. for DMG / DMU 50

Advantage:

Low overall height of only 36 mm.



CAD

No. 6204S6HA-003

Sextuple clamping station

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
427559	K10.2	6 x 10	6 x 25	●	62

Design:

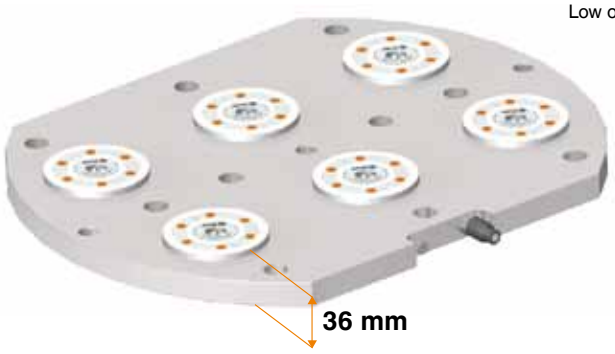
Hydraulic clamping station for optimised clamping times on machine tables with distance between slots of 100 mm. Clamping is with M16 socket head screws. At least two fitting holes are attached for alignment.
The insertion dimension of the clamping modules is 200 mm. The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.

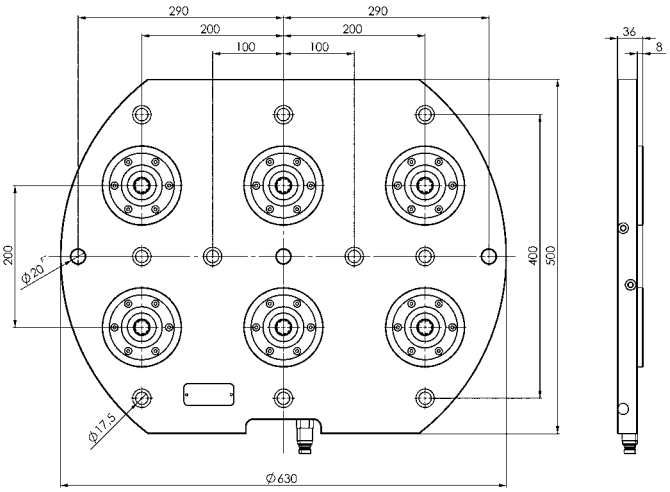
Application:

e.g. for Mazak Variaxis 630

Advantage:

Low overall height of only 36 mm.





CAD

Subject to technical alterations.

No. 6204S6HA-004

Sextuple clamping station

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
427567	K10.2	6 x 10	6 x 25	●	62

Design:

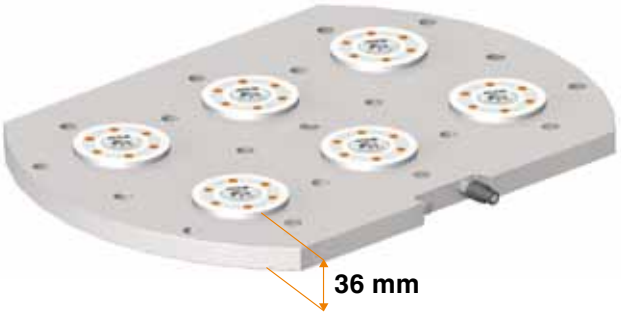
Hydraulic clamping station for optimised clamping times on machine tables with distance between slots of 63 mm. Clamping is with M12 socket head screws. At least two fitting holes are attached for alignment.
The insertion dimension of the clamping modules is 200 mm. The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.

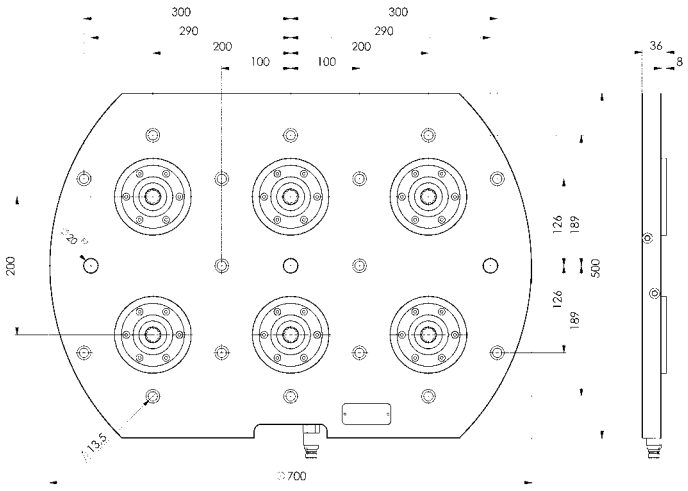
Application:

e.g. for DMG / DMU 70 EVO

Advantage:

Low overall height of only 36 mm.





CAD

No. 6204K2HA-015

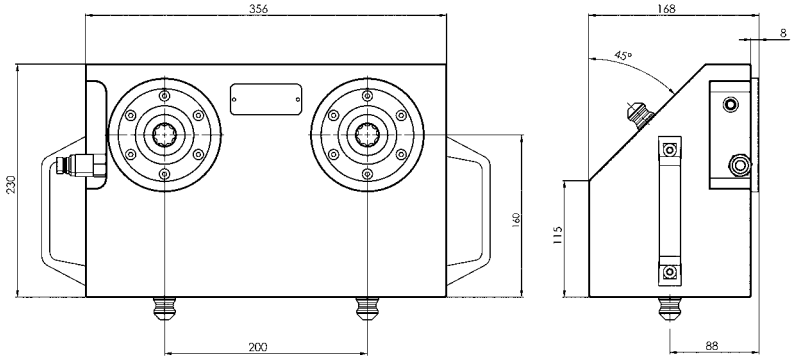
Double clamping bracket

Hydraulic unlocking.
Pneumatic blow-out.
High-strength aluminium.
Repeatability < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
427591	K10.2	2 x 10	2 x 25	●	31

Design:

Hydraulic clamping bracket for optimised clamping times on K10.2 clamping stations. Bottom-mounted clamping nipple.
The insertion dimension of the clamping modules is 200 mm. The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.



CAD

Subject to technical alterations.

No. 6204K1HA-001

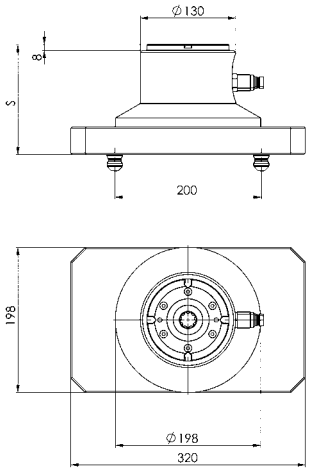
Single clamping bracket

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	S [mm]	Weight [Kg]
428060	K10.2	10	25	●	150	32
428086	K10.2	10	25	●	200	38
428102	K10.2	10	25	●	240	42

Design:

Hydraulic clamping bracket for optimised clamping times on K10.2 clamping stations. Installation clamping module K10.2 with 4-way indexing. Bottom-mounted clamping nipple.
The insertion dimension is 200 mm. The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.



CAD

No. 6204K1HA-004

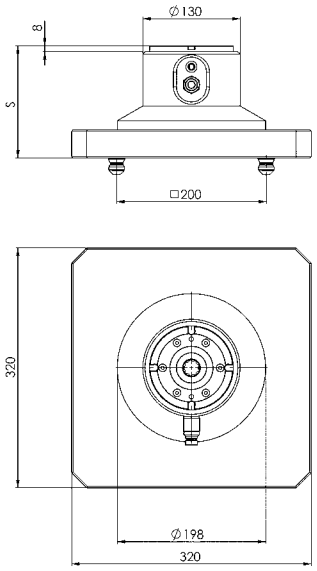
Single clamping bracket

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	S [mm]	Weight [Kg]
428128	K10.2	10	25	●	150	45
428144	K10.2	10	25	●	200	50
428169	K10.2	10	25	●	240	54

Design:

Hydraulic clamping bracket for optimised clamping times on K10.2 clamping stations. Installation clamping module K10.2 with 4-way indexing. Bottom-mounted clamping nipple.
The insertion dimension is 200 mm. The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.



CAD

Subject to technical alterations.

No. 6204K2HA-011

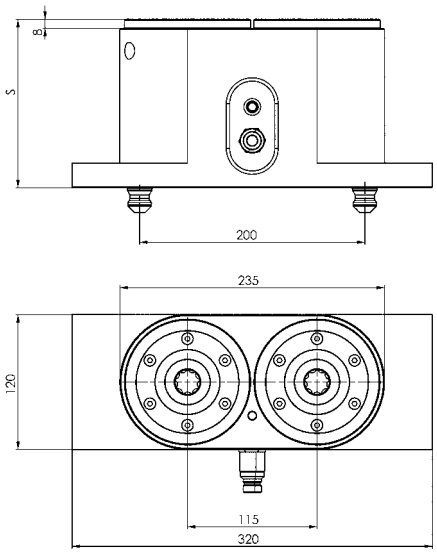
Double clamping bracket

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	S [mm]	Weight [Kg]
427864	K10.2	2 x 10	2 x 25	●	150	31
427880	K10.2	2 x 10	2 x 25	●	180	37

Design:

Hydraulic clamping bracket for optimised clamping times on K10.2 clamping stations. Bottom-mounted clamping nipple.
The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.



No. 6204K2HA-013

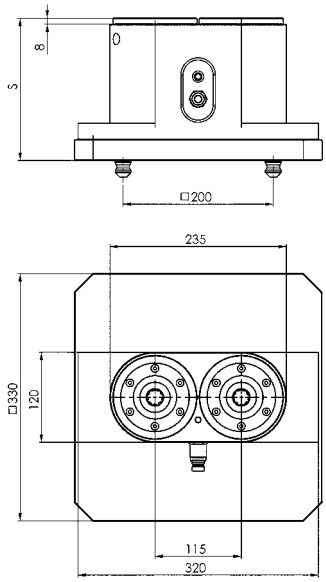
Double clamping bracket

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	S [mm]	Weight [Kg]
427906	K10.2	2 x 10	2 x 25	●	190	57
427575	K10.2	2 x 10	2 x 25	●	220	63

Design:

Hydraulic clamping bracket for optimised clamping times on K10.2 clamping stations. Bottom-mounted clamping nipple.
The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.



Subject to technical alterations.

No. 6204K2HA-001

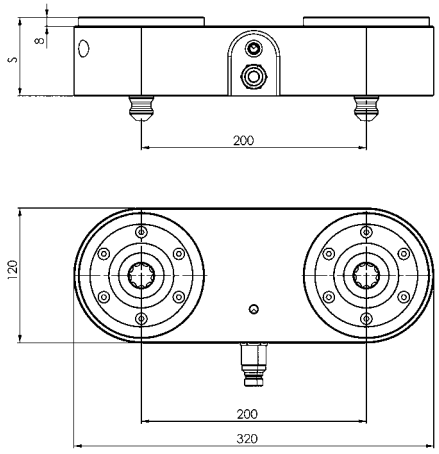
Double clamping bracket

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	S [mm]	Weight [Kg]
427666	K10.2	2 x 10	2 x 25	●	70	18
427682	K10.2	2 x 10	2 x 25	●	100	26
427708	K10.2	2 x 10	2 x 25	●	120	31
427724	K10.2	2 x 10	2 x 25	●	160	42
427740	K10.2	2 x 10	2 x 25	●	200	54

Design:

Hydraulic clamping bracket for optimised clamping times on K10.2 clamping stations. Bottom-mounted clamping nipple.
The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.



No. 6204K2HA-006

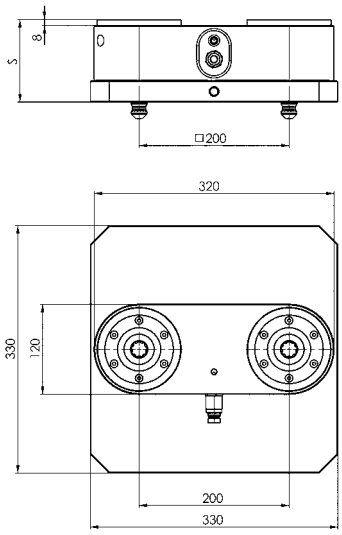
Double clamping bracket

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	S [mm]	Weight [Kg]
427765	K10.2	2 x 10	2 x 25	●	110	45
427781	K10.2	2 x 10	2 x 25	●	140	53
427807	K10.2	2 x 10	2 x 25	●	160	58
427823	K10.2	2 x 10	2 x 25	●	200	69
427849	K10.2	2 x 10	2 x 25	●	240	81

Design:

Hydraulic clamping bracket for optimised clamping times on K10.2 clamping stations. Bottom-mounted clamping nipple.
The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.



Subject to technical alterations.

No. 6204S6HA-008

Sextuple clamping station

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

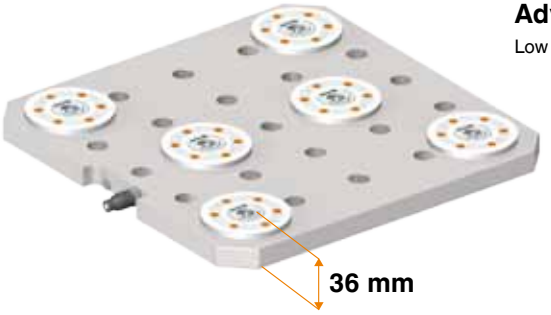
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
427625	K10.2	6x10	6x25	●	55

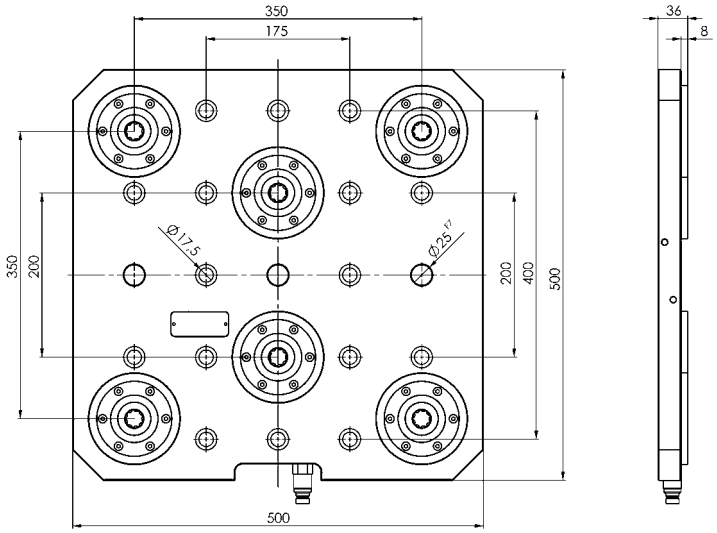
Design:

Hydraulic clamping station for optimised clamping times on machine tables with distance between slots of 100 mm. Clamping is with M16 socket head screws. At least two fitting holes are attached for alignment.
The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.

Advantage:

Low overall height of only 36 mm.





CAD

No. 6204WU12HA-001

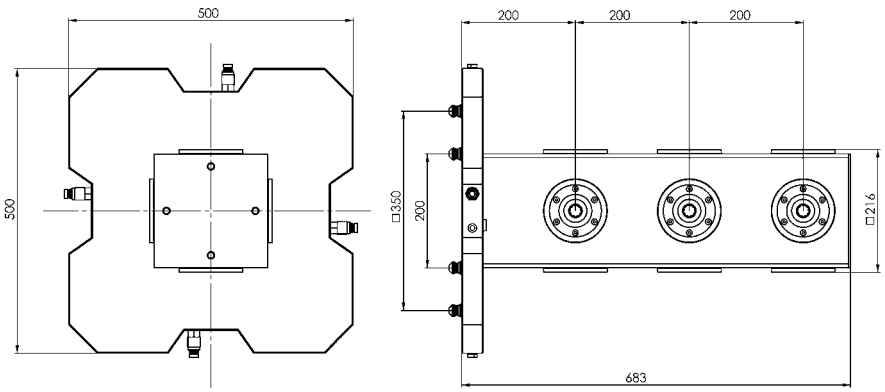
12-fold clamping cube

Hydraulic unlocking.
Pneumatic blow-out.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
427641	K10.2	12x10	12x25	●	210

Design:

Hydraulic clamping cube for set-up-time-optimized clamping on clamping station 6204S6HA-008. It is fastened with the clamping nipple below.
The insertion dimension of the clamping modules is 200 mm. The quick coupling plug is pre-mounted, and the integrated blow-out function can be individually connected.



Subject to technical alterations.

No. 6204P-S2

Fixture plate

High-strength aluminium, suitable for double clamping station K10.2

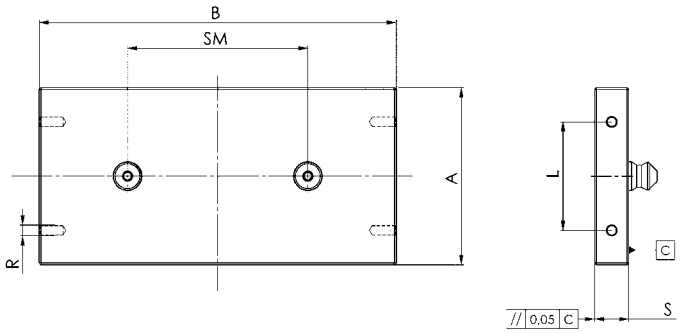
Order no.	Size	A	B	L	R	S	SM	Weight [Kg]
429266	K10.2	166	396	120	M12	30	200	6

Note:

On request, we can incorporate mounting holes according to your specifications in the fixture plate.

On request:

Other dimensions, insertion dimensions and number of clamping nipples equipped.



CAD

No. 6204P-S4

Fixture plate

High-strength aluminium, suitable for quadruple clamping station K10.2

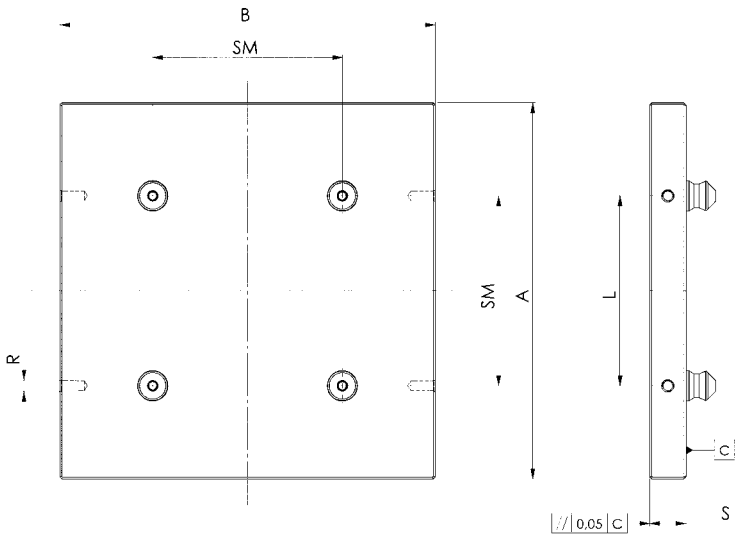
Order no.	Size	A	B	L	R	S	SM	Weight [Kg]
429282	K10.2	366	366	200	M12	30	200	10

Note:

On request, we can incorporate mounting holes according to your specifications in the fixture plate.

On request:

Other dimensions, insertion dimensions and number of clamping nipples equipped.



CAD

Subject to technical alterations.

No. 6204P-S6

Fixture plate

High-strength aluminium, suitable for sextuple clamping station K10.2

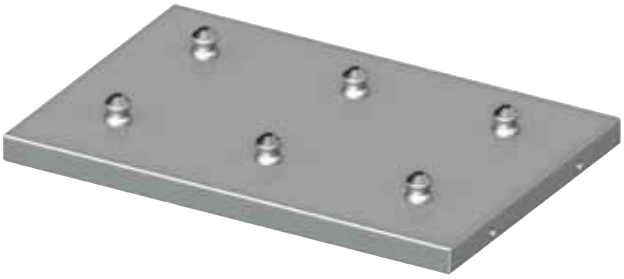
Order no.	Size	A	B	L	R	S	SM	Weight [Kg]
429308	**K10.2**	366	566	200	M12	30	200	16

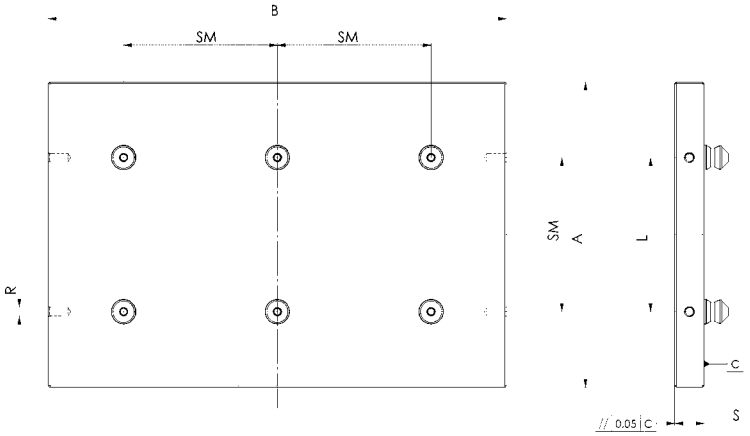
Note:

On request, we can incorporate mounting holes according to your specifications in the fixture plate.

On request:

Other dimensions, insertion dimensions and number of clamping nipples equipped.





CAD

No. 6204P-S8

Fixture plate

High-strength aluminium, suitable for octuple clamping station K10.2

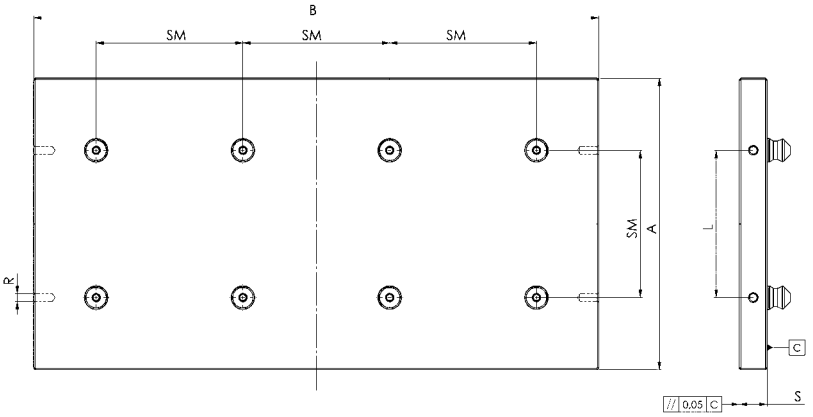
Order no.	Size	A	B	L	R	S	SM	Weight [Kg]
429324	**K10.2**	366	770	200	M12	30	200	22

Note:

On request, we can incorporate mounting holes according to your specifications in the fixture plate.

On request:

Other dimensions, insertion dimensions and number of clamping nipples equipped.



CAD

Subject to technical alterations.

AMF-Clean-Stick in use: automated cleaning of clamping fixture and machine table

Subject to technical alterations.

No. 6370ZN-10

Clamping nipple for clamping modules K10

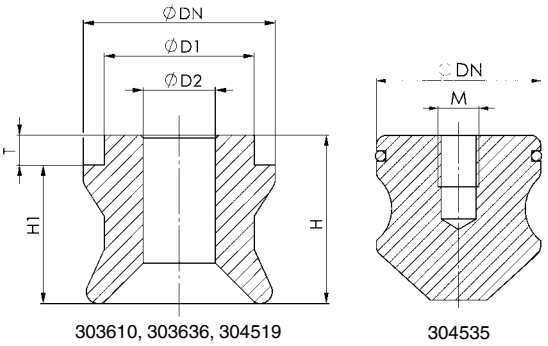
Hardened, for hydraulic and pneumatic clamping modules size K10.

EDELSTAHL Rostfrei

Order no.	Size	dia. DN	dia. D1	dia. D2	H	H1	M	T	Weight [g]
303610	K10	22,0	15	8	19	16	-	3	30
303636	K10	22,0	15	8	19	16	-	3	30
304519	K10	21,8	15	8	19	16	-	3	30
304535	K10	21,8	-	-	-	-	M 8	-	30

Design:

Order no. 303610: Zero point nipple
Order no. 303636: Timing nipple
Order no. 304519: Undersized nipple
Order no. 304535: Protection nipple



303610, 303636, 304519 | 304535

CAD

No. 6370ZNS-001

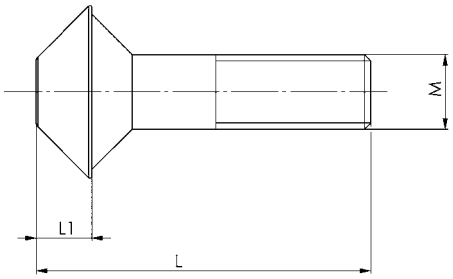
Engagement nipple screw

Strength class 10.9.
Suitable for clamping nipple, article no. 6370ZN.

Order no.	Size	M	L	L1	Weight [g]
303578	K10	M 8	37	6	30

On request:

Engagement nipple screws in various lengths and materials (e.g. high-grade stainless steel).



CAD

Subject to technical alterations.

No. 6370ZNM

Clamping female nipple

Strength class 10.
Suitable for clamping nipple No. 6370ZN

NEW!

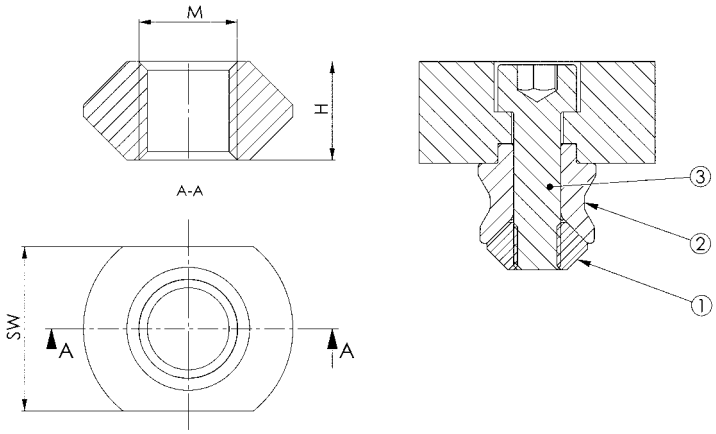
Order no.	Size	M	SW	H	Weight [g]
429985	K10	M8	14	8	8

Application:

Clamping female nipple for fastening the clamping nipple.

Note:

By gluing the clamping female nipple in the clamping nipple with medium adhesive it is protected against twisting when loosening the socket head screw.
1 = Clamping female nipple
2 = Clamping nipple
3 = Socket head screw



CAD

No. 6204ZS

Cover cap for clamping modules

Material: polyethylene

Order no.	Packaging unit [pc]	Weight [g]
428664	8	4

Application:

Cover and protective caps for mounting screws of the K10.2, K10.3, K20.3 clamping modules.

No. 6204ZS-02

Cover cap for clamping modules

Polyethylene

Order no.	Size	Packaging unit [pc]	Weight [g]
430165	M12	12	15
430181	M16	12	15

Application:

Cover and protective cap for cylinder and positioning boreholes in clamping stations.

Subject to technical alterations.

No. 6370ZS-06-2000

Hose set, hydraulic

Max. operating pressure 100 bar.

Order no.	Length [m]	Weight [g]
430082	2	730

Design:

The connection set includes:
1x hydraulic connecting tube, length 2 m
2x straight screw pipe connections
2x straight screwed sockets
1x T-screw connection
1x manometer 0-100 bar
1x straight female stud coupling
2x quick fitting coupling sleeves
2x quick fitting coupling plugs
2x Cu sealing washers for G1/4

Application:

This set is used for the hydraulic connection of extension clamping modules or clamping stations for pressure generators such as pressure boosters or air-hydraulic pumps.

Subject to technical alterations.

No. 6370ZD-004

Air-Hydraulic Pump

Max. operating pressure 60 bar.

Order no.	Pneum. pressure min. [bar]	Pneum. pressure max. [bar]	Oil capacity usable [cm³]	Flow rate max. [cm³/min]	Weight [Kg]	€/Pce. from 1
426569	4	6	1000	750	5,9	595,00

Design:

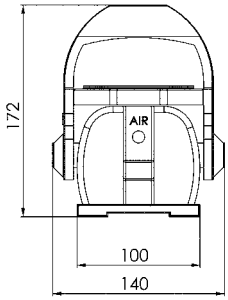
Compact, air-pressure-operated hydraulic intensification pump for single-acting circuits. The pump is fitted with an integrated safety valve that regulates the hydraulic output pressure. The safety valve is set in the factory to the max. operating pressure of 60 bar.
The extension element in the oil tank allows the pump to be adjusted horizontally and vertically.
Air connection thread: G1/4
Oil connection thread: G1/4

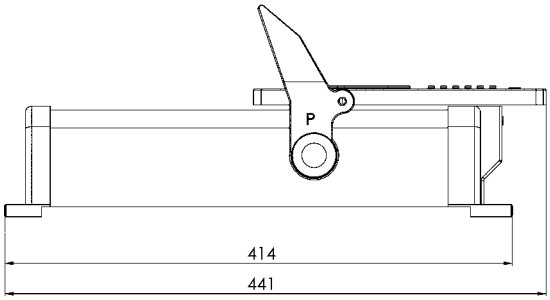
Application:

The air-hydraulic pump is used for opening for hydraulic clamping modules or hydraulic clamping stations.

Note:

The use of purified, lubricated compressed air is recommended for operation of the pump.





Subject to technical alterations.

COMPONENTS FOR EVERY REQUIREMENT
– THE ZERO POINT SYSTEM FROM AMF

The market requirements for a modern zero-point system are widely varied. Different model sizes, holding forces or integrated automation solutions - with our “Zero Point” system we offer components for every requirement and for every standard.

Convince yourself!

TRY IT FOR YOURSELF AND TAKE ADVANTAGE OF THE MANY FEATURES THAT MAKE THE AMF ZERO POINT SYSTEM SO SPECIAL:

- Clamping module in built-in or external mount versions
- Various model sizes for different processing forces and applications
- Heavy-load clamping module for even more extreme holding forces
- Clamping module as flange version for simplified installation
- Horizontal rapid-clamp cylinder for fast, vertical palettisation
- A wide range of automated solutions
- High-end clamping module for full automation
- Various hydraulic clamping stations
- Air-hydraulic pump for rapid opening of the clamping module
- Comprehensive accessories offer the perfect complement

Subject to technical alterations.

Subject to technical alterations.

INSTALLATION CLAMPING MODULES

The AMF installation clamping modules are used with low space requirement and low overall height. For installation in pallets, machine tables, clamping brackets and cubes. Usable when cutting, grinding, eroding and on plastic-processing machines as well as for fixture construction with mounting fixtures and handling systems. The AMF clamping modules can be installed in all positions. Whether vertical or overhead - mounting works completely without assembly tools.

Installation clamping modules are available in five different sizes:

- **Clamping modules K40** - dia. 148 mm - pull-in/locking force up to 40 kN - holding force 105 kN
- **Clamping modules K20** - dia. 112 mm - pull-in/locking force up to 20 kN - holding force 55 kN
- **Clamping modules K10** - dia. 78 mm - pull-in/locking force up to 10 kN - holding force 25 kN
- **Clamping modules K5** - dia. 45 mm - pull-in/locking force up to 5 kN - holding force 13 kN
- **Clamping modules K02** - dia. 22 mm - pull-in/locking force up to 0,23 kN - holding force 6 kN

FLEXIBLE SYSTEM - THE ZERO-POINT-SYSTEM ADAPTS PERFECTLY TO YOUR REQUIREMENTS

> Differing AMF clamping modules from Ø 22 to Ø 148 mm can be used in combination.
> Smallest depth gauges from 23 mm are realised simply, flexibly and quickly.
> Thanks to the innumerable possible combinations between differently sized clamping modules and nipples, direct workpiece clamping is straightforward and specific.

Subject to technical alterations.

No. 6203L-02

Built-in clamping module, round, screw-in version

Pneumatic opening.
Opening operating pressure: min. 6 bar - max. 14 bar.
Cover and piston hardened.
Repeatability < 0.02 mm.

EDELSTAHL Rostfrei
STAINLESS STEEL

Order no.	Size	Pull-in/locking force up to [N]	Holding force [N]	Weight [g]
427286	K02	235	6000	48

Application:

Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

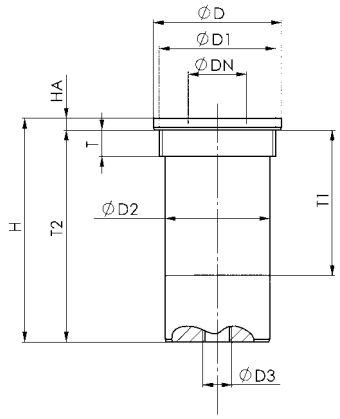
The installation clamping module has high holding, pull-in and locking forces. This is opened pneumatically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module has one connection:
1x pneum. opening (1).
For simple installation, we recommend the AMF face spanner under order no. 50914.

On request:

- Installation diagrams

Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	dia. D2	dia. D3	H	HA	T	T1	T2
427286	K02	22	10	M20x1,5	18	M5	38,5	2,05	4,5	25	36,45



CAD

Subject to technical alterations.

No. 6203S4L-001

4-point clamping station

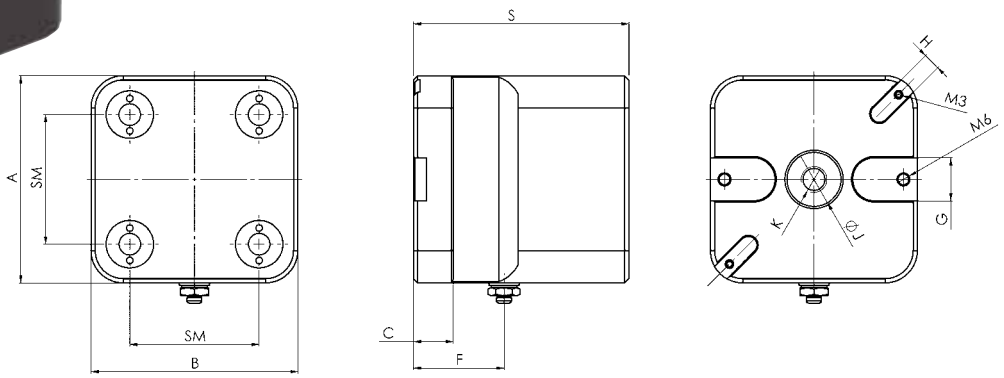
Main body: Aluminium, anodised
Repeat accuracy <0.02 mm

NEW!

Order no.	Size	Pull-in/locking force up to [N]	Holding force [N]	Weight [g]
533034	K02	4 x 235	4 x 6000	2400

Design:

Pneumatic 4-point clamping station with air gun valve for quick opening and closing via air gun. The clamping station has two clamping grooves on the side for fastening to the machine table. In addition, positioning grooves for aligning on the machine table are made on the underside. The holder for a K20 clamping nipple is also provided.



Dimensions:

Order no.	Size	A	B	C	F	G	H	dia. J	K	S	SM
533034	K02	96	96	15	42	20	8	25	M12	100	60

CAD

No. 6203PS4-001

Interchangeable pallet

High-strength aluminium, anodised

NEW!

Order no.	Size	A	B	S	SM	Weight [g]
533059	K02	98	98	20	60	530

Design:

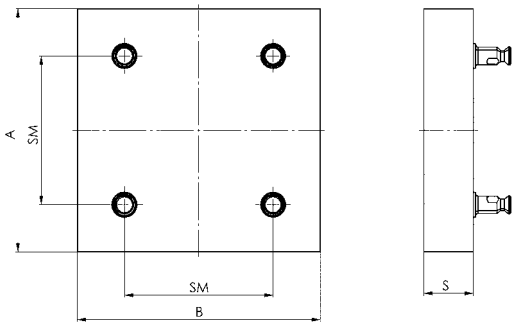
Interchangeable pallet for 4-point clamping station K02 with 4 clamping nipples.

Note:

On request, we can incorporate mounting holes according to your specifications in the change pallet.

On request:

Further dimensions, actual dimensions and number of clamping nipple tips.



CAD

Subject to technical alterations.

No. 6370EARH

Installation clamping module, round, screw-in version

Hydraulic opening.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [g]
305953	K 5	5	13	150

Application:

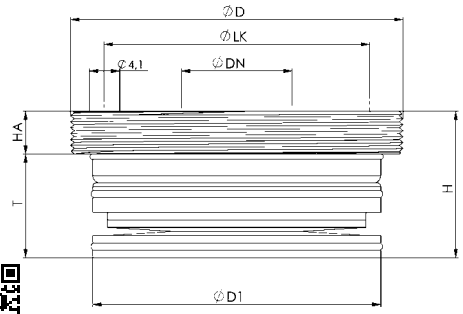
Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry. With small space requirement and low overall height.

Note:

The installation clamping module has high holding, pull-in and locking forces. This is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The contact surface is the upper surface of the housing.
The clamping module has one connection: 1x hydr. opening (1).
For simple installation, we recommend the AMF face spanner under order no. 41046.

On request:

- Installation diagrams



CAD

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	T
305953	K 5	M45 x 1	15	39	19,8	5,8	36	14

No. 6370EARL

Installation clamping module, round, screw-in version

Pneumatic opening.
Opening operating pressure: min. 8 bar - max. 12 bar
Retensioning operating pressure (turbo): min. 5 bar - max. 6 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [g]
305979	K 5	1,5	13	150

Application:

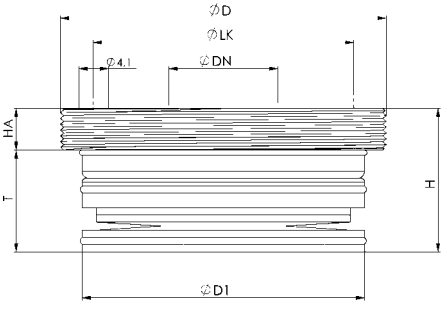
Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry. With small space requirement and low overall height.

Note:

The installation clamping module has high holding, pull-in and locking forces. This is opened pneumatically (1) and mechanically locked through spring force. To achieve the specified pull-in and locking forces, it must be briefly retensioned pneumatically (turbo) (2). Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free). The contact surface is the upper surface of the housing. Use of the pneumatic pressure booster 6370ZVL is recommended.
The clamping module has two connections:
1x pneum. opening (1) / 1x pneum. retensioning (turbo) (2).
For simple installation, we recommend the AMF face spanner under order no. 41046.

On request:

- Installation diagrams



CAD

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	T
305979	K 5	M45 x 1	15	39	19,8	5,8	36	14

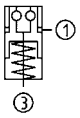
Subject to technical alterations.

No. 6370EARHA

Installation clamping module, round

Hydraulic opening.
Pneumatic blow-out.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
428680	K10	10	25	●	0,45
427971	K20	20	55	●	1,40
429845	K40	40	105	●	3,40

Application:

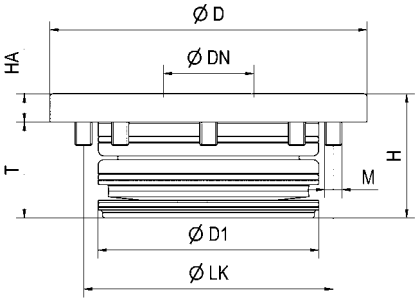
Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

The installation clamping module has high holding, pull-in and locking forces. This is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module with blow-out and support control has two connections: 1x hydr. opening (1) / 1x pneum. blow-out and support control (3). (The pneumatic blow-out and support control can optionally be connected.)
Installation clamping module in flange version for simplified installation, see 6151HA.

On request:

- Installation diagrams
- Automation solutions



CAD

Dimensions:

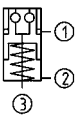
Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	M	T
428680	K10	78	22	50	30	7	60	M5	23
427971	K20	112	32	78	44	10	88	M6	34
429845	K40	148	40	102	57	15	118	M8	42

No. 6370EARLA

Installation clamping module, round

Pneumatic opening.
Pneumatic blow-out.
Opening operating pressure: min. 8 bar - max. 12 bar
Retensioning operating pressure (turbo): min. 5 bar - max. 6 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
305375	K10	8	25	●	0,45
303016	K20	17	55	●	1,40
303057	K40	30	105	●	3,40

Application:

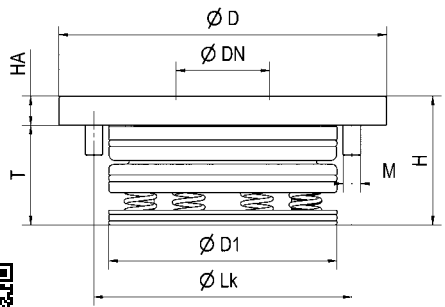
Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

The installation clamping module has high holding, pull-in and locking forces. This is opened pneumatically (1) and mechanically locked through spring force. To achieve the specified pull-in and locking forces, it must be briefly retensioned pneumatically (turbo) (2). Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free). Use of the pneumatic pressure booster 6370ZVL is recommended.
The clamping module with blow-out and support control has three connections:
1x pneum. opening (1) / 1x pneum. retensioning (turbo) (2), 1x pneum. blow-out and support control (3). (The pneumatic blow-out and support control can optionally be connected.)
Installation clamping module in flange version for simplified installation, see no. 6151L.

On request:

- Installation diagrams
- Automation solutions



CAD

Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	M	T
305375	K10	78	22	50	30	7	60	M5	23
303016	K20	112	32	78	44	10	88	M6	34
303057	K40	148	40	102	57	15	118	M8	42

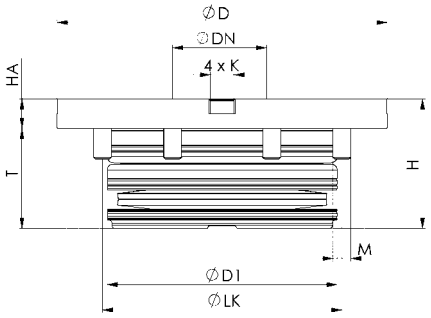
Subject to technical alterations.

No. 6370EAIHA

Installation clamping module with indexing

Hydraulic opening.
Pneumatic blow-out.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
428425	K20	20	55	●	1,4



CAD

Application:

Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

The installation clamping module has high holding, pull-in and locking forces. This is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module with blow-out and support control has two connections: 1x hydr. opening (1) / 1x pneum. blow-out and support control (3). (The pneumatic blow-out and support control can optionally be connected.)

On request:

- Installation diagrams

Dimensions:

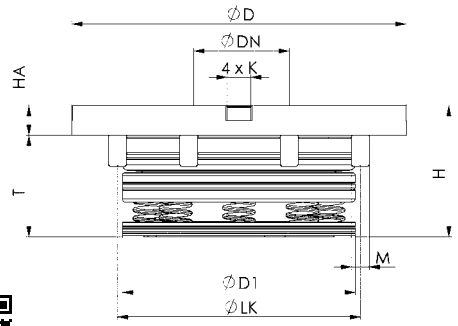
Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	K F6	dia. LK	M	T
428425	K20	112	32	78	44	10	8	88	M6	34

No. 6370EAILA

Installation clamping module with indexing

Pneumatic opening.
Pneumatic blow-out.
Opening operating pressure: min. 8 bar - max. 12 bar
Retensioning operating pressure (turbo): min. 5 bar - max. 6 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
428441	K20	17	55	●	1,4



CAD

Application:

Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

The installation clamping module has high holding, pull-in and locking forces. This is opened pneumatically (1) and mechanically locked through spring force. To achieve the specified pull-in and locking forces, it must be briefly retensioned pneumatically (turbo) (2). Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free). Use of the pneumatic pressure booster 6370ZVL is recommended.
The clamping module with blow-out and support control has three connections:
1x pneum. opening (1) / 1x pneum. retensioning (turbo) (2), 1x pneum. blow-out and support control (3). (The pneumatic blow-out and support control can optionally be connected.)

On request:

- Installation diagrams

Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	K F6	dia. LK	M	T
428441	K20	112	32	78	44	10	8	88	M6	34

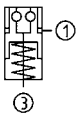
Subject to technical alterations.

No. 6206LA

Installation clamping module, round

Pneumatic opening.
Pneumatic blow-out.
Opening operating pressure:
K10.3 min. 5 bar - max. 12 bar
K20.3 min. 4.5 bar - max. 12 bar
Cover and piston hardened.
Repeat accuracy < 0.005 mm.

EDELSTAHL Rostfrei
STAINLESS STEEL



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
428730	**K10.3**	10	25	●	1,4
428755	**K20.3**	17	55	●	2,6

Application:

Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

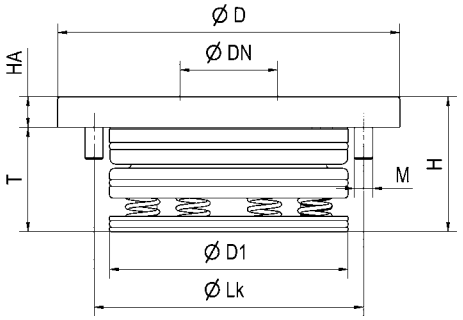
The installation clamping module has high holding, pull-in and locking forces. This is opened pneumatically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module with blow-out and support control has two connections:
1x opening (1), 1x pneum. blow-out and support control (3). (The pneumatic blow-out and support control can optionally be connected.)

On request:

- Installation diagrams

K20.3

K10.3



Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	M	T
428730	**K10.3**	112	22	78	35	10	88	6xM6	25
428755	**K20.3**	138	32	102	49	15	115	8xM6	34

CAD

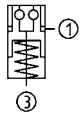
Subject to technical alterations.

No. 6206ILA

Installation clamping module, round, with indexing

Pneumatic opening.
Pneumatic blow-out.
Opening operating pressure:
K10.3 min. 5 bar - max. 12 bar
K20.3 min. 4.5 bar - max. 12 bar
Cover and piston hardened.
Repeat accuracy < 0.005 mm.

EDELSTAHL Rost frei
STAINLESS STEEL



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
428771	**K10.3**	10	25	●	1,4
428797	**K20.3**	17	55	●	2,6

Application:

Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.
The indexing function of the clamping module prevents the pallet from twisting, enabling exact positioning every 90°.

Note:

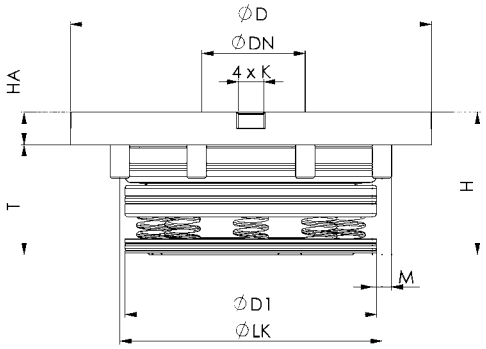
The installation clamping module has high holding, pull-in and locking forces. This is opened pneumatically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module with blow-out and support control has two connections:
1x opening (1), 1x pneum. blow-out and support control (3). (The pneumatic blow-out and support control can optionally be connected.)

On request:

- Installation diagrams

K20.3

K10.3



Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	K F6	dia. LK	M	T
428771	**K10.3**	112	22	78	35	10	8	88	6xM6	25
428797	**K20.3**	138	32	102	49	15	10	115	8xM6	34

CAD

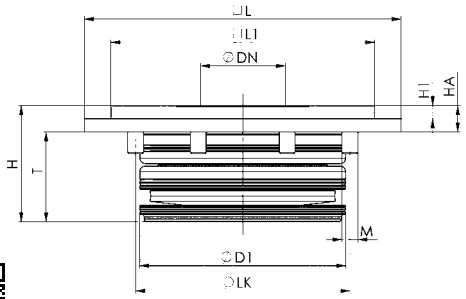
Subject to technical alterations.

No. 6370EAQHA

Installation clamping module, square

Hydraulic opening.
Pneumatic blow-out.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL



CAD

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
305250	K10	10	25	●	0,55
305276	K20	20	55	●	1,70
305292	K40	40	105	●	3,55

Application:

Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry. A square clamping module prevents the pallet from twisting. The indexing function enables exact positioning every 90°.

Note:

The installation clamping module has high holding, pull-in and locking forces. This is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module with blow-out and support control has two connections: 1x hydr. opening (1) / 1x pneum. blow-out and support control (3). (The pneumatic blow-out and support control can optionally be connected.)

On request:

- Installation diagrams
- Automation solutions

Dimensions:

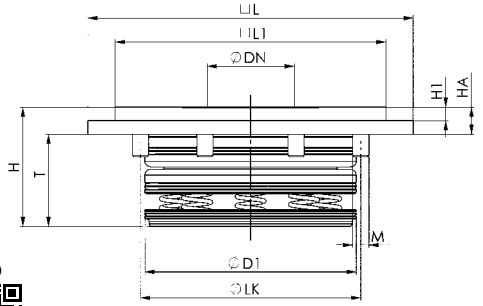
Order no.	Size	dia. DN	dia. D1	H	HA	H1	L	L1	dia. LK	M	T
305250	K10	22	50	30	7	3,5	85	70	60	M5	23
305276	K20	32	78	44	10	5,0	120	100	88	M6	34
305292	K40	40	102	57	15	5,0	150	130	118	M8	42

No. 6370EAQLA

Installation clamping module, square

Pneumatic opening.
Pneumatic blow-out.
Opening operating pressure: min. 8 bar - max. 12 bar
Retensioning operating pressure (turbo): min. 5 bar - max. 6 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL



CAD

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
305318	K10	8	25	●	0,55
305334	K20	17	55	●	1,80
305359	K40	30	105	●	3,40

Application:

Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry. A square clamping module prevents the pallet from twisting. The indexing function enables exact positioning every 90°.

Note:

The installation clamping module has high holding, pull-in and locking forces. This is opened pneumatically (1) and mechanically locked through spring force. To achieve the specified pull-in and locking forces, it must be briefly retensioned pneumatically (turbo) (2). Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free). Use of the pneumatic pressure booster 6370ZVL is recommended.
The clamping module with blow-out and support control has three connections:
1x pneum. opening (1) / 1x pneum. retensioning (turbo) (2), 1x pneum. blow-out and support control (3). (The pneumatic blow-out and support control can optionally be connected.)

On request:

- Installation diagrams
- Automation solutions

Dimensions:

Order no.	Size	dia. DN	dia. D1	H	HA	H1	L	L1	dia. LK	M	T
305318	K10	22	50	30	7	3,5	85	70	60	M5	23
305334	K20	32	78	44	10	5,0	120	100	88	M6	34
305359	K40	40	102	57	15	5,0	150	130	118	M8	42

Subject to technical alterations.

Subject to technical alterations.

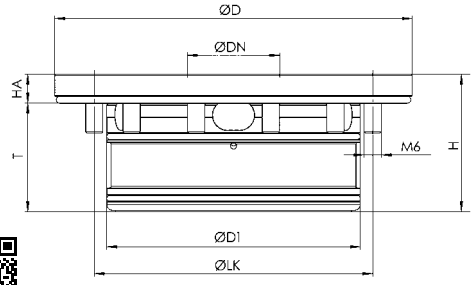
Subject to technical alterations.

No. 6201H

Installation clamping module, heavy-duty, round

Hydraulic opening.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei
STAINLESS STEEL



CAD

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
306084	K20	20	105	1,94

Application:

Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry. The installed heavy-duty clamping module K20 has the same max. holding force as the clamping module K40. The example here is that the clamping nipple has the same outside dimensions as the clamping nipple in the clamping module K20. As a result, a uniform clamping nipple size can be achieved in all fixtures, and the same module size can be achieved on the machine tables.

Note:

The heavy duty installation clamping module, despite small installation dimensions, has increased holding force through the reinforced design. Due to the cartridge construction, simplified installation in the body is possible.

The clamping module is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free). The clamping module has one connection: 1x hydr. opening (1).

On request:

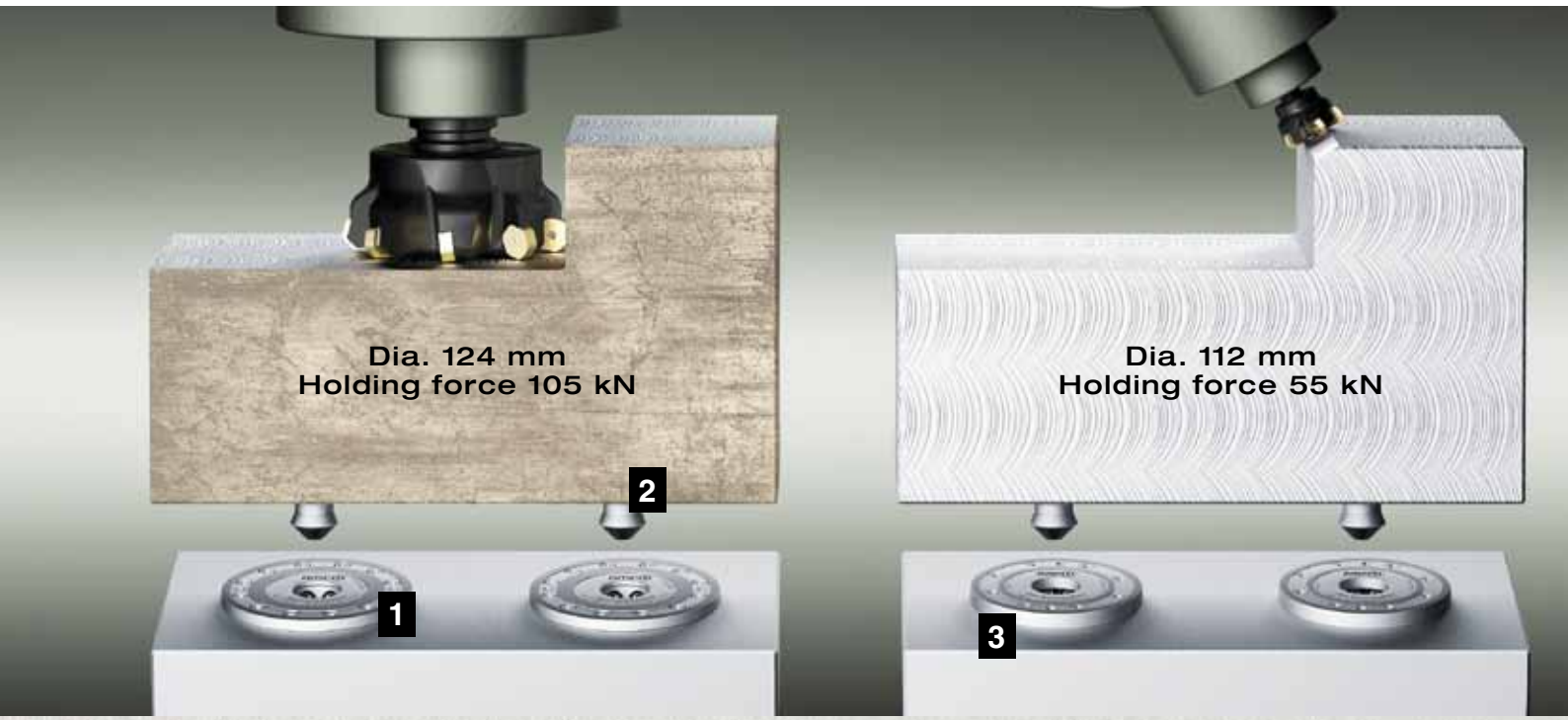
- Installation diagrams
- Automation solutions

Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	T
306084	K20	124	32	88	47,8	10	100	37,8

MORE EXTREME HOLDING FORCES - WITH SAME INTERFACE

1. Heavy duty clamping modules for extreme processing forces
2. Clamping nipple K20 as the same interface between the two clamping modules
3. Clamping module K20 for all other applications



Subject to technical alterations.

SIMPLIFIED INSTALLATION IN THE BODY

- THE INSTALLATION CLAMPING MODULE AS FLANGE VERSION

The flange version of the installation clamping module has a centring ring on the underside. This allows simplified and precisely positioned installation of the module in the body. Through the low depth of the required mounting hole for the centring ring, existing fixtures and be easily and inexpensively refitted with the AMF Zero-Point System. The clamping module can be operated from the outside via a tube connection or from the bottom via an O-ring connection.

No. 6151HA

Installation clamping module, round, flange version

Hydraulic opening.
Pneumatic blow-out.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL

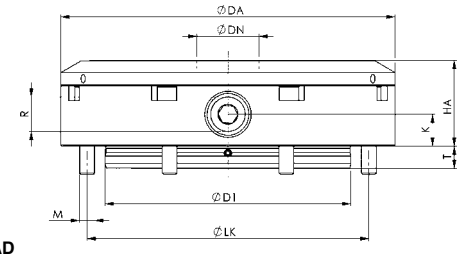
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
424085	K10	10	25	●	1,35
423962	K20	20	55	●	3,75
424143	K40	40	105	●	4,97

Application:

Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

The flange version permits a simplified installation in the body. This is exactly positioned via the centring function. The clamping module can be operated from the outside via a tube connection or from the bottom via an O-ring connection.
This is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module with blow-out and support control has two connections:
1x hydr. opening (1) / 1x pneum. blow-out and support control (3). (The pneumatic blow-out and support control can optionally be connected.)



CAD

Dimensions:

Order no.	Size	dia. DA	dia. DN	dia. D1	HA	K	dia. LK	M	R	T
424085	K10	100	22	67	24	9	90	M5	G1/8	5,9
423962	K20	136	32	100	35	13	124	M6	G1/8	8,9
424143	K40	180	40	125	45	15	163	M8	G1/4	11,9

No. 6151L

Installation clamping module, round, flange version

Pneumatic opening.
Opening operating pressure: min. 8 bar - max. 12 bar
Retensioning operating pressure (turbo): min. 5 bar - max. 6 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL

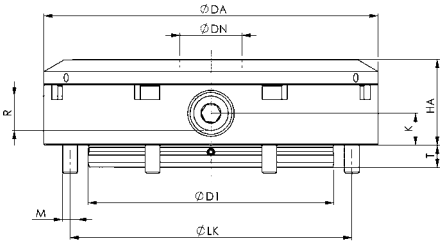
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
424101	K10	8	25	1,35
423988	K20	17	55	3,75
424168	K40	30	105	4,97

Application:

Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

The flange version permits a simplified installation in the body. This is exactly positioned via the centring function. This is opened pneumatically (1) and mechanically locked through spring force. To achieve the specified pull-in and locking forces, this must be briefly retensioned pneumatically (turbo) (2). Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
Use of the pneumatic pressure booster 6370ZVL is recommended.
The clamping module has two connections:
1x pneum. opening (1) / 1x pneum. retensioning (turbo) (2).



CAD

Dimensions:

Order no.	Size	dia. DA	dia. DN	dia. D1	HA	K	dia. LK	M	R	T
424101	K10	100	22	67	24	9	90	M5	G1/8	5,9
423988	K20	136	32	100	35	13	124	M6	G1/8	8,9
424168	K40	180	40	125	45	15	163	M8	G1/4	11,9

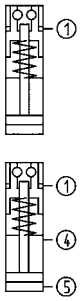
Subject to technical alterations.

No. 6370HARH

Horizontal rapid-clamping cylinder

Hydraulic opening.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei
STAINLESS STEEL



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Advance motion, hydr. suspension piston	max. weight per catching piston [kN]	Weight [Kg]
303065	K20	20	55	-	5	2,1
306217	K20	20	55	●	5	2,1
303107	K40	40	105	-	8	5,2
306258	K40	40	105	●	8	5,2

Design:

As standard, there is a manaul (hand power) or hydraulic run-out and run-in movements of the suspension piston.
- Cylinder has one connection: 1x hydr. opening (1),
- Cylinder with hydraulic advance motion has three connections: 1x hydr. opening (1),
Run out 1x hydr. suspension piston opening (5), run in 1x hydr. suspension piston opening (4).

Application:

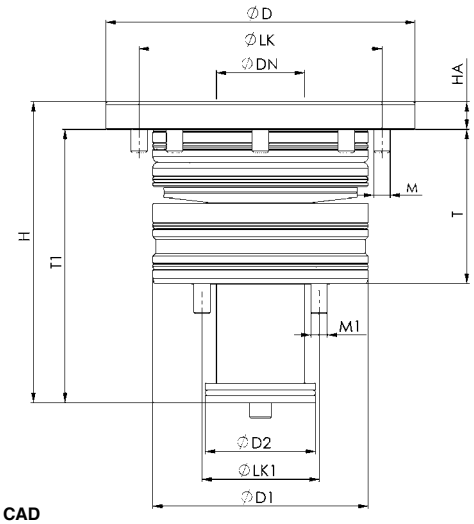
Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry. For installation in clamping brackets, cubes and towers. The horizontal rapid-clamping cylinder is used to change fixtures quickly and easily by means of the suspension piston with manual power, hydraulic or handling device.

Note:

The horizontal rapid-clamping cylinder has high holding, pull-in and locking forces. This is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free). The maximum weight per suspension piston must not exceed 5 kN at K20 and 8 kN at K40.

On request:

- Installation diagrams

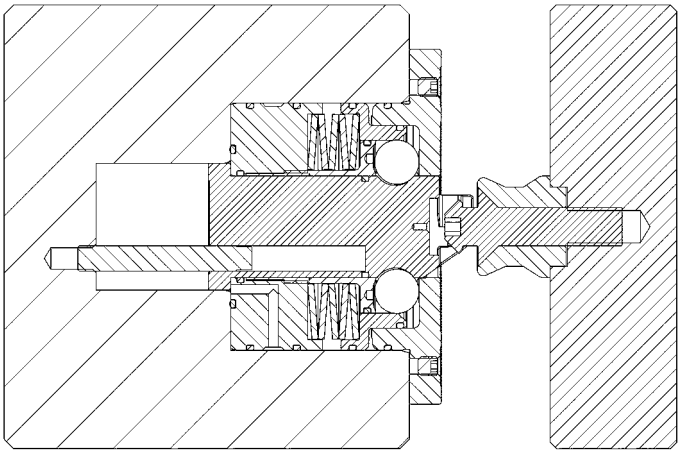


CAD

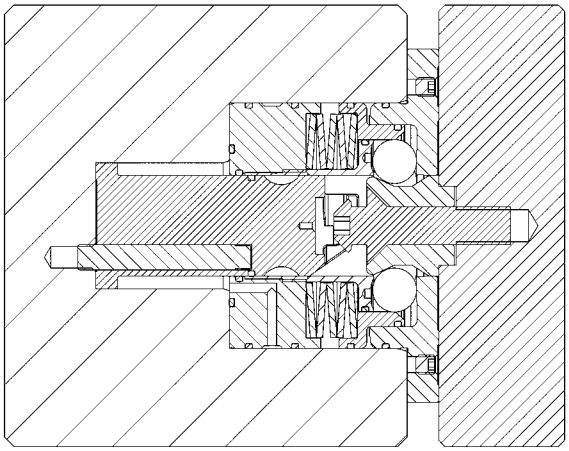
Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	dia. D2	H	HA	dia. LK	dia. LK1	M	M1	T	T1
303065	K20	112	32	78	40	109	10	88	60	M6	M6	56,5	99
306217	K20	112	32	78	40	109	10	88	60	M6	M6	56,5	99
303107	K40	148	40	102	48	144	15	118	76	M8	M8	73,0	129
306258	K40	148	40	102	48	144	15	118	76	M8	M8	73,0	129

... extended condition



... retracted and locked condition



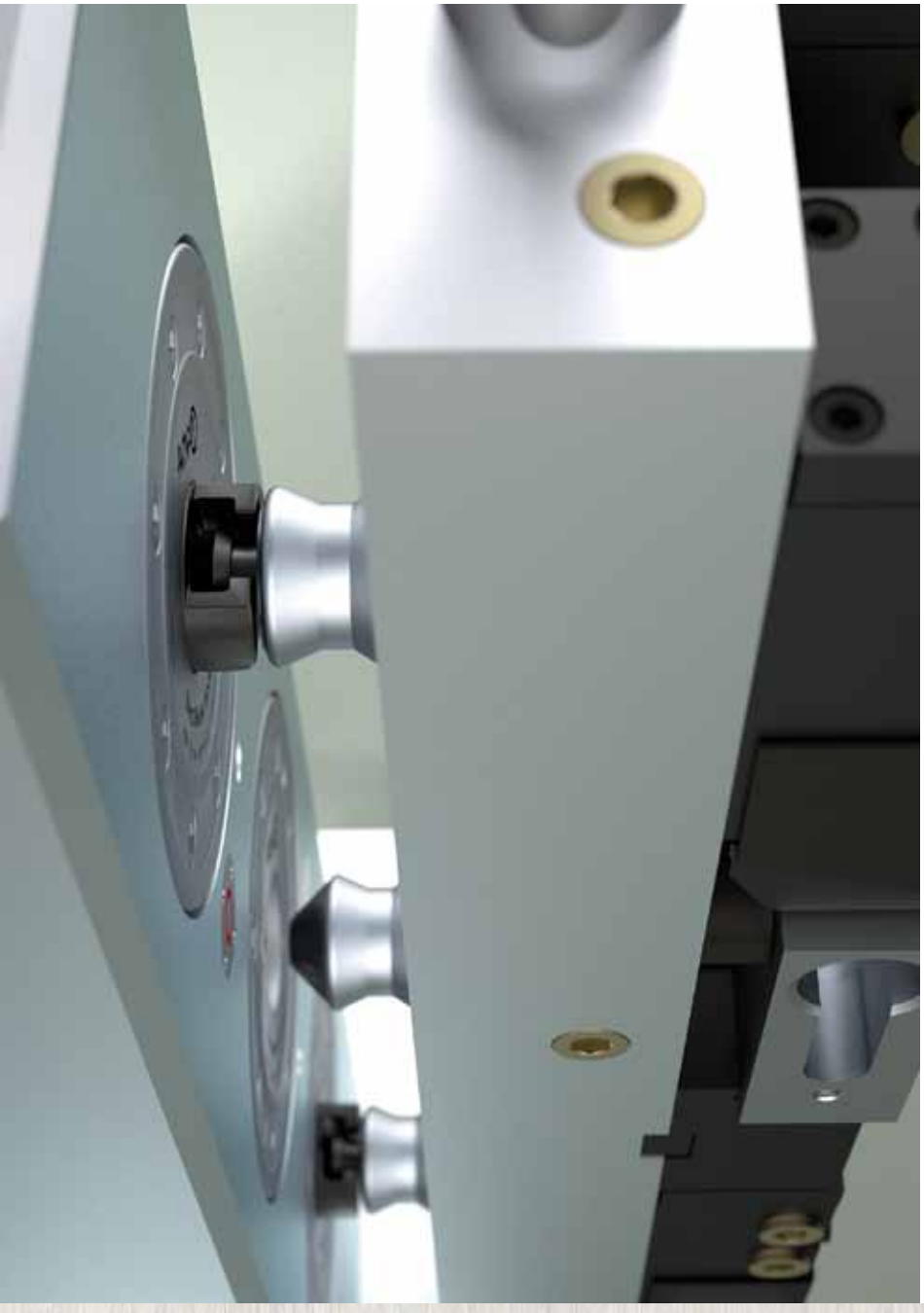
Subject to technical alterations.

HORIZONTAL RAPID-CLAMPING CYLINDER

This is how to make vertical palletization quick and uncomplicated:

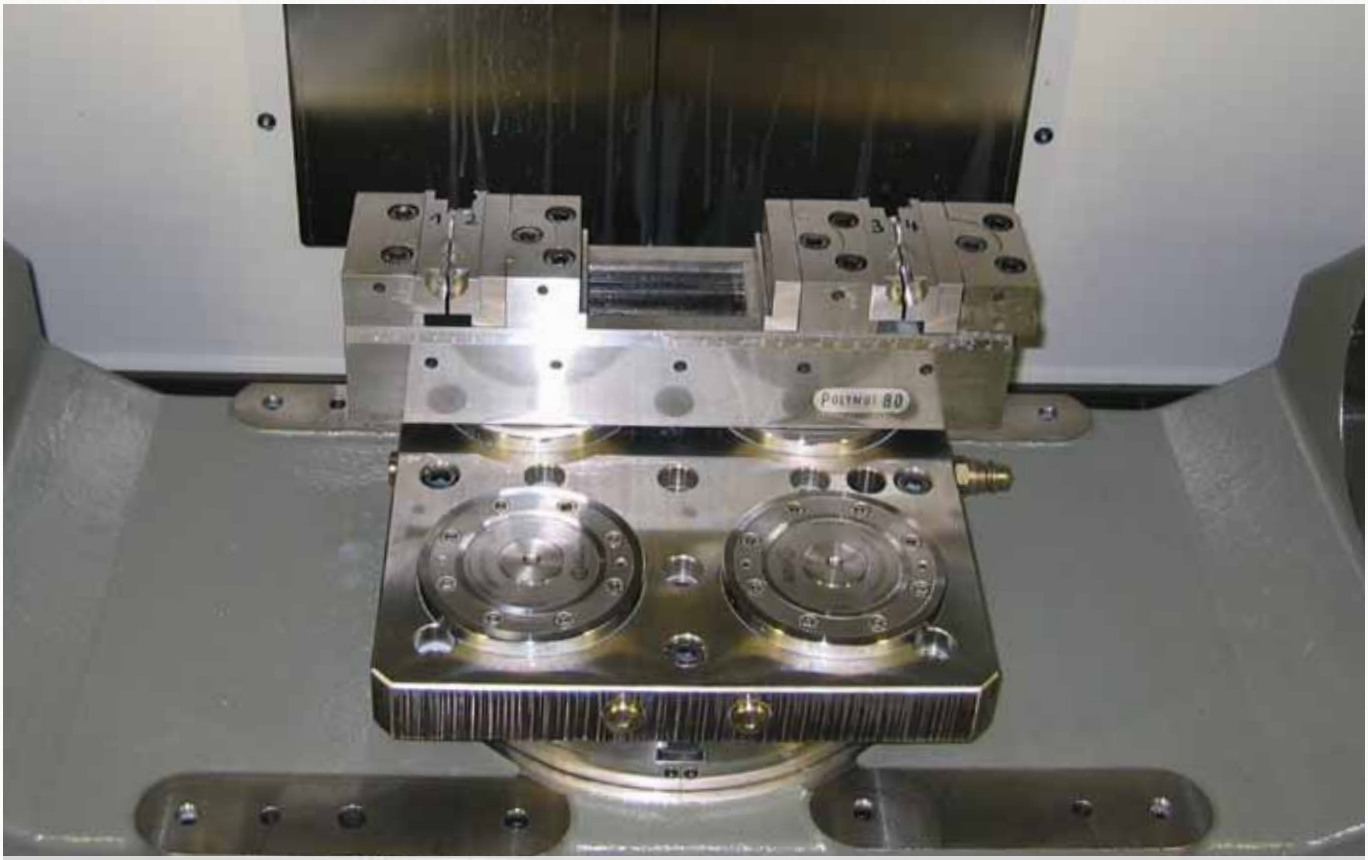
> No searching for the holes
> No hydraulic or pneumatic pre-tensioning
> No damage from zero-point hole and nipplel
> No risk of injury
> Reduced set-up times and thus cost savings

Flexibly usable in clamping towers, clamping brackets, automated handling devices or in general machine building.



> Whether by hand, with crane, handling device or robot: Horizontal rapid-clamping cylinders offer maximum protection and comfort.

> After the pallet has been mounted, it can easily be pushed in and out. This process can be automated, if desired.



4-way clamping pallet mounted on round table for fast fixture changeover

In injection moulding, the tools are successfully changed in a way that optimizes set-up time through the use of the AMF Zero-Point System.
With friendly recommendation of Robert Bosch GmbH, Waiblingen

Subject to technical alterations.

No. 6370KARH

Compact cylinder

Hydraulic opening.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei
STAINLESS STEEL

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
303503	K10	1,3	25	2,5

Application:

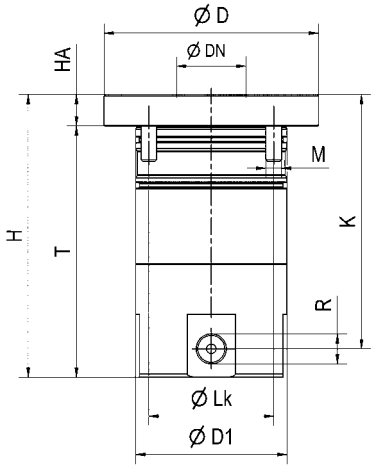
For retrofitting to modular profiles, columns, tombstones and cubes. Can be used with thin wall sections.

Note:

There are 5 standard connection options. 4 connections are installed laterally on the outside surface at a 90° angle. Connection is also possible in the base of the compact cylinder.

On request:

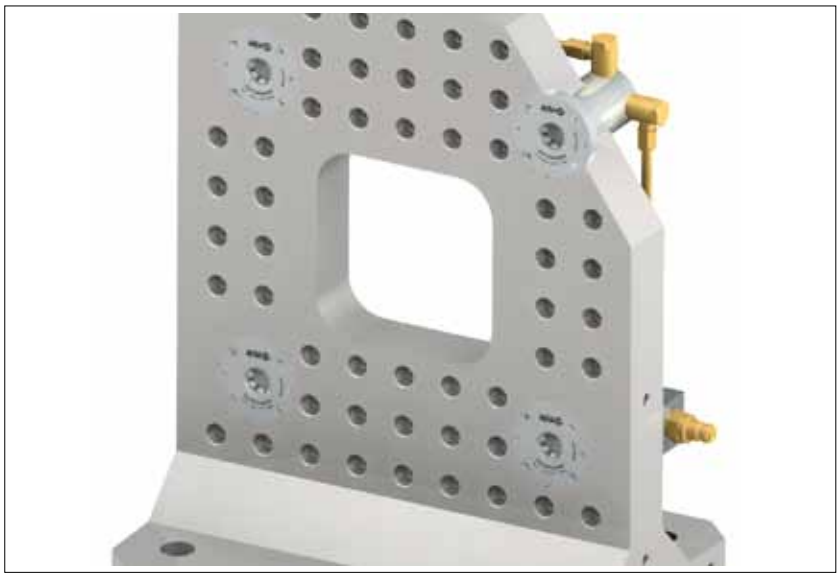
- Installation diagrams
- Automation solutions



Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	K	dia. LK	M	R	T
303503	K10	68	22	48	90	10	81	4x56	M6	G1/8	80

CAD

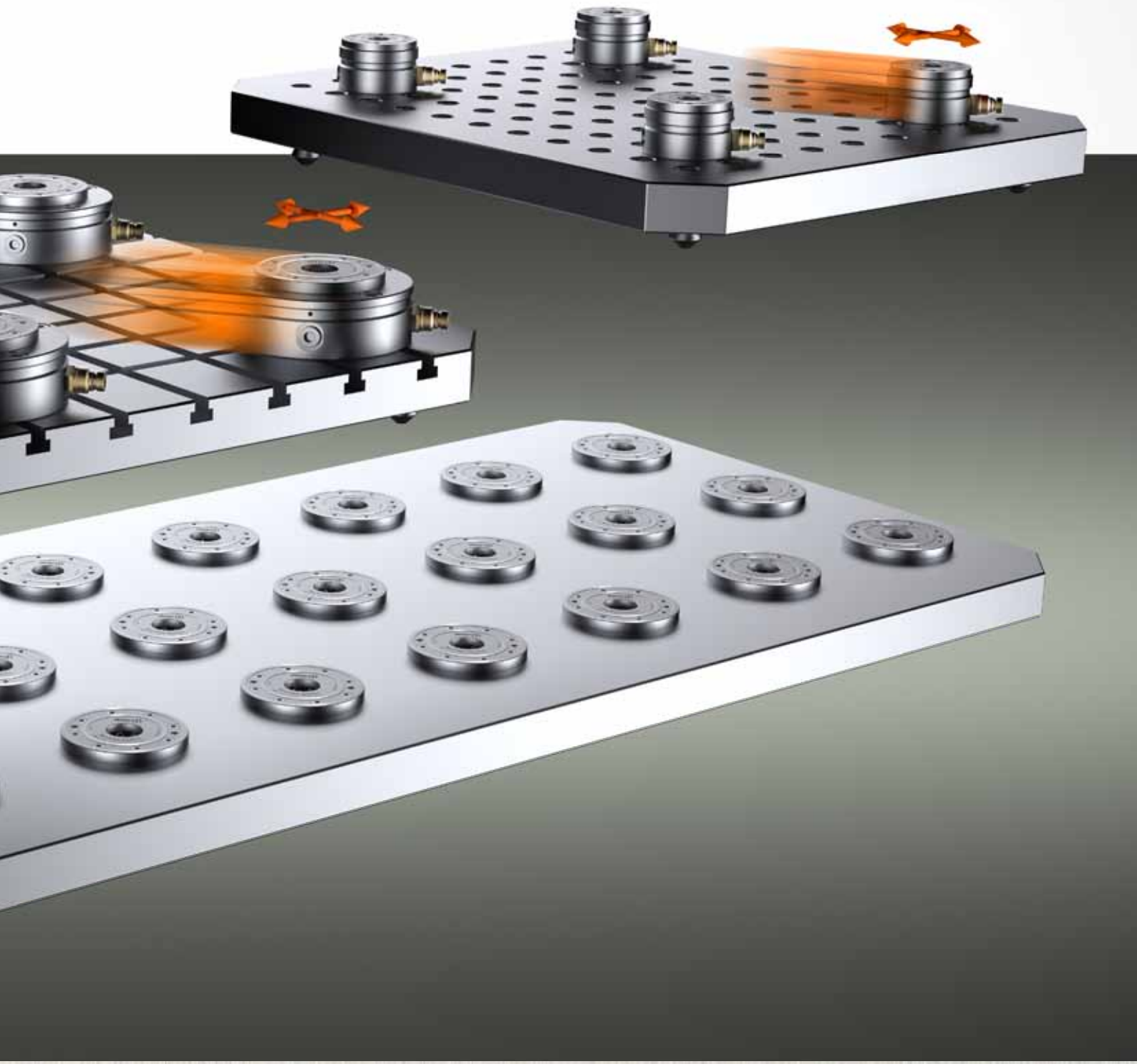


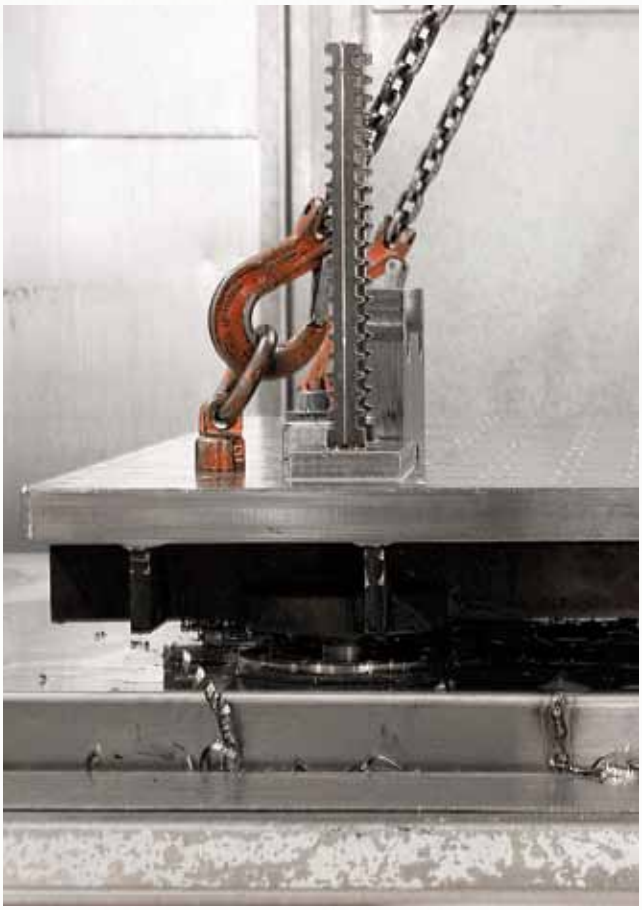
Subject to technical alterations.

VARIABLE CENTRE DISTANCE -
THE SIMPLEST SOLUTION FOR FLEXIBLE MANUFACTURING

Looking for a simple, flexible and modular clamping solution that satisfies your requirements for a modern, cost-efficient and cost-optimised manufacturing process?
This is guaranteed by the immensely varied AMF zero point clamping system „Zero-Point".
The manufacture of prototypes, small batch series and testing and measuring fixtures used to be a challenging field of application. Flexibility was to some degree limited by a fixed depth gauge.
The variable depth gauge recently developed by AMF has eliminated these boundaries. A simple displacement of the clamping modules enables the depth gauges to be quickly adapted to your specific needs.
This additional flexibility drastically cuts your tooling costs and machine downtimes, not only for medium and large batch series, but also for prototypes and small batch series, as well as test devices.

- Clamping brackets for direct workpiece clamping in simple 5-sided machining
- Variable depth gauge by easily displacing the clamping modules on a grooved or grid plate
- Easy to adapt various module sizes to suit the application at hand.
- Five standard thread sizes for the clamping nipple in the workpiece to choose from - M5, M6, M8, M12, M16
- Use of threaded adapter sleeves enables the clamping nipple to be mounted in any size of locating bores in the workpiece.
- Direct workpiece clamping can be realised by the simplest of means
- Prototypes, small batch series, test and measuring devices, installation devices can be clamped using the AMF-Zero-Point-System in a manner that fulfills your future needs.





Subject to technical alterations.

SURFACE-MOUNTED CLAMPING MODULES

The AMF surface-mounted clamping modules are installed on pallets, machine tables, clamping brackets and cubes. Usable when cutting, grinding, eroding and on plastic-processing machines as well as for fixture construction with mounting fixtures and handling systems.

The AMF clamping modules can be installed in all positions. Whether vertical or overhead - mounting works completely without assembly tools.

Surface-mounted clamping modules are available in four different sizes:

- **Clamping modules K40** - dia. 148 mm - pull-in/locking force up to 40 kN - holding force 105 kN
- **Clamping modules K20** - dia. 112 mm - pull-in/locking force up to 20 kN - holding force 55 kN
- **Clamping modules K10** - dia. 78 mm - pull-in/locking force up to 10 kN - holding force 25 kN
- **Clamping modules K5** - dia. 62 mm - pull-in/locking force up to 5 kN - holding force 13 kN

No. 6370AARH

Surface-mounted clamping module, round

Hydraulic opening.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [g]
306159	K 5	5	13	300

Application:

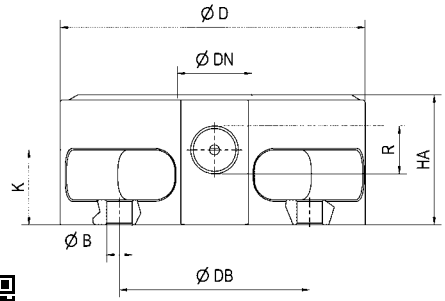
Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

The surface-mounted clamping module has high holding, pull-in and locking forces. This is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The contact surface is the upper surface of the housing.
The clamping module has one connection: 1x hydr. opening (1).

On request:

- Individual housing



CAD

Dimensions:

Order no.	Size	dia. B	dia. D	dia. DB	dia. DN	HA	K	R
306159	K 5	5,8	62	54	15	26	15	G1/8

No. 6370AARL

Surface-mounted clamping module, round

Pneumatic opening.
Opening operating pressure: min. 8 bar - max. 12 bar
Retensioning operating pressure (turbo): min. 5 bar - max. 6 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [g]
306175	K 5	1,5	13	300

Application:

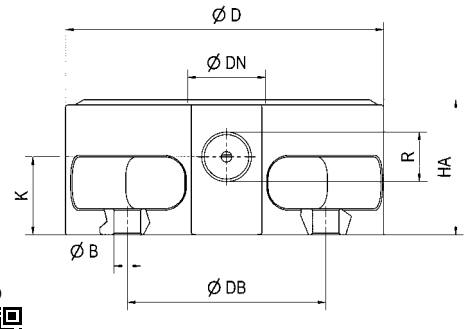
Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

The surface-mounted clamping module has high holding, pull-in and locking forces. This is opened pneumatically (1) and mechanically locked through spring force. To achieve the specified pull-in and locking forces, it must be briefly retensioned pneumatically (turbo) (2). Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The contact surface is the upper surface of the housing.
Use of the pneumatic pressure booster 6370ZVL is recommended.
The clamping module has two connections:
1x pneum. opening (1) / 1x pneum. retensioning (turbo) (2).

On request:

- Individual housing



CAD

Dimensions:

Order no.	Size	dia. B	dia. D	dia. DB	dia. DN	HA	K	R
306175	K 5	5,8	62	54	15	26	15	G1/8

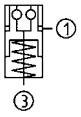
Subject to technical alterations.

No. 6370AARHA

Surface-mounted clamping module, round

Hydraulic opening.
Pneumatic blow-out.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rost frei STAINLESS STEEL



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
303545	K10	10	25	●	0,9
302836	K20	20	55	●	2,7
302877	K40	40	105	●	6,6

Application:

Zero-point clamping system in combination with clamping flanges 6370ZB for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

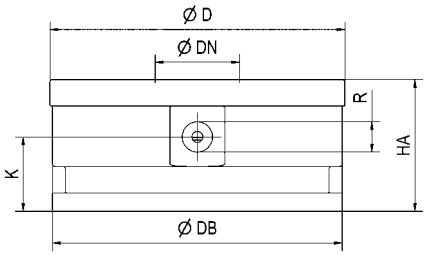
Note:

The surface-mounted clamping module has high holding, pull-in and locking forces. This is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module with blow-out and support control has two connections: 1x hydr. opening (1) / 1x pneum. blow-out and support control (3). (The pneumatic blow-out and support control can optionally be connected.)

On request:

- Individual housing
- Automation solutions

CAD



Dimensions:

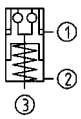
Order no.	Size	dia. D	dia. DB	dia. DN	HA	K	R
303545	K10	78	77,5	22	32	16,50	G1/8
302836	K20	112	110,0	32	50	28,25	G1/4
302877	K40	148	146,0	40	62	32,50	G1/4

No. 6370AARLA

Surface-mounted clamping module, round

Pneumatic opening.
Pneumatic blow-out.
Opening operating pressure: min. 8 bar - max. 12 bar
Retensioning operating pressure (turbo): min. 5 bar - max. 6 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rost frei STAINLESS STEEL



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
305193	K10	8	25	●	0,9
302851	K20	17	55	●	2,6
302893	K40	30	105	●	6,6

Application:

Zero-point clamping system in combination with clamping flanges 6370ZB for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

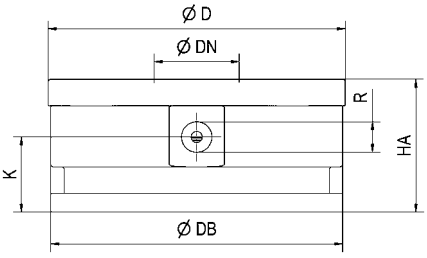
Note:

The surface-mounted clamping module has high holding, pull-in and locking forces. This is opened pneumatically (1) and mechanically locked through spring force. To achieve the specified pull-in and locking forces, it must be briefly retensioned pneumatically (turbo) (2). Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
Use of the pneumatic pressure booster 6370ZVL is recommended.
The clamping module with blow-out and support control has three connections:
1x pneum. opening (1) / 1x pneum. retensioning (turbo) (2), 1x pneum. blow-out and support control (3). (The pneumatic blow-out and support control can optionally be connected.)

On request:

- Individual housing
- Automation solutions

CAD



Dimensions:

Order no.	Size	dia. D	dia. DB	dia. DN	HA	K	R
305193	K10	78	77,5	22	32	16,50	G1/8
302851	K20	112	110,0	32	50	28,25	G1/4
302893	K40	148	146,0	40	62	32,50	G1/4

Subject to technical alterations.

No. 6370ZB

Clamping flange, Set

consisting of two single-clamp buckles, nitrided.

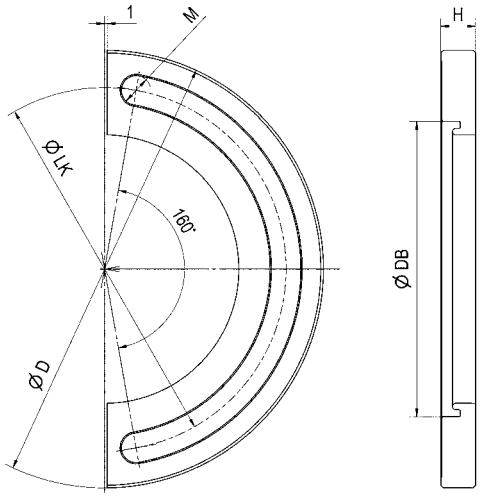
Order no.	Size	Set contents [St]	dia. D	dia. DB	H	dia. LK	M	Weight [g]
426825	K10	2	114	77,5	7,75	94	8,5	360
426833	K20	2	164	110,0	13,00	136	11,0	800
426841	K40	2	202	146,0	16,00	172	13,0	1100

Application:

Clamping flanges are used to fasten surface-mounted clamping modules on the machine table.

On request:

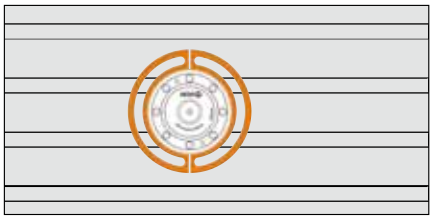
- Special clamping flanges for various T-slot tables
- Clamping flange and housing manufactured as a single piece



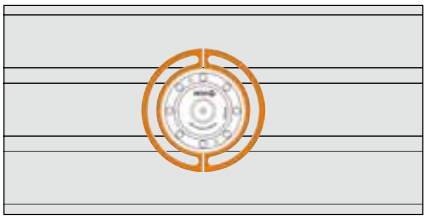
CAD

Examples of machine-table mounting:

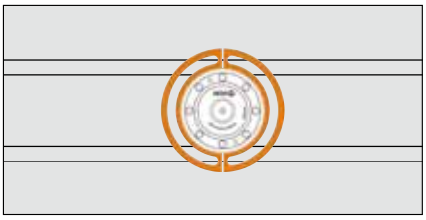
K10 - Groove distance 50 mm



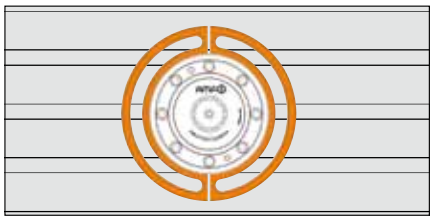
Groove distance 63 mm



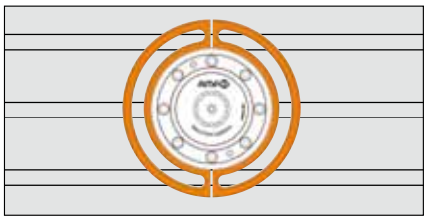
Groove distance 80 mm



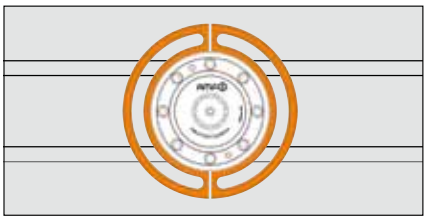
K20 - Groove distance 50 mm



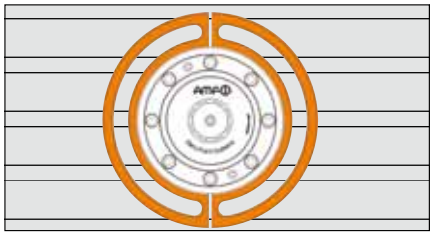
Groove distance 63 mm



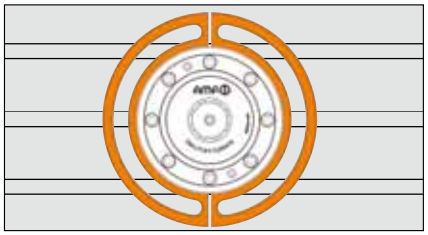
Groove distance 80 mm



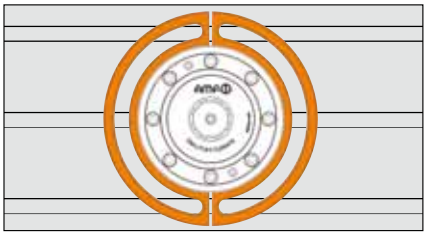
K40 - Groove distance 50 mm



Groove distance 63 mm



Groove distance 80 mm



Subject to technical alterations.

With friendly recommendation of Bäuml CNC-Fertigungs-GmbH & Co. KG, Weiden

Subject to technical alterations.

The high precision of the AMF Zero-Point System permits use in grinding

Use in the food industry

Subject to technical alterations.

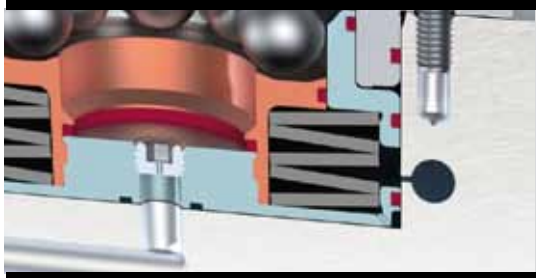
AUTOMATION SOLUTIONS FROM AMF

The enormous capability and flexibility of use of modern processing machines is undisputed. To be able to use these capabilities in reality requires more than just fast machines. An automation solution consists today of a number of multiply linked, versatile products and technologies.

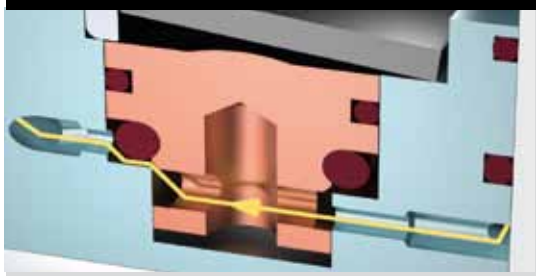
Through the possibility of a fully automatic and process-sure machine configuration, our automation solutions meet the requirements for seamless integration into the automation system. Numerous sensing options, optional media ducts and blow-out and blow-off of the modules speak for themselves!

Persuade yourself of the automation potential of the AMF zero-point clamping modules!

1A LOCKING CONTROL

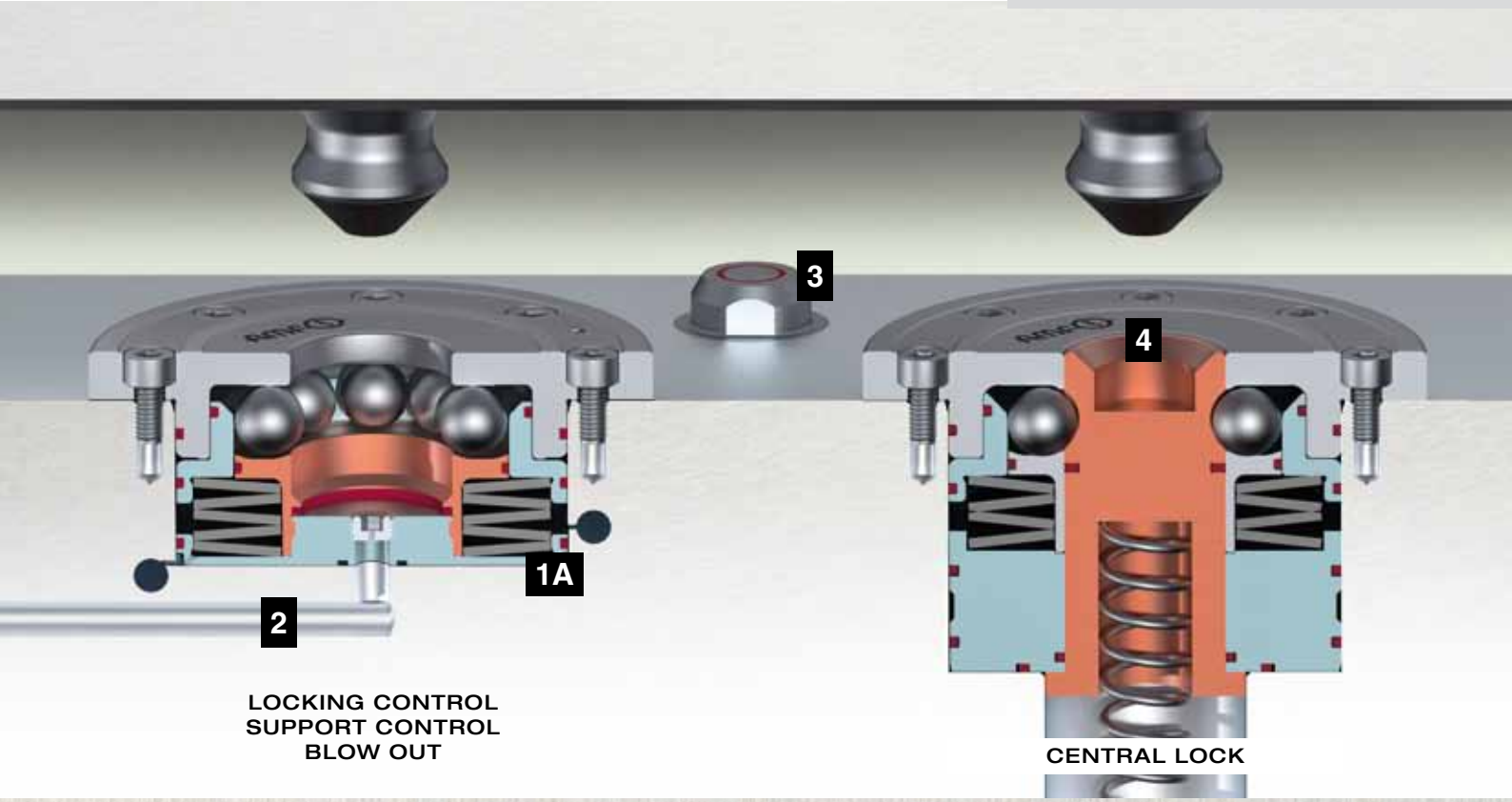


1B LOCKING CONTROL



_1A IS THE MODULE LOCKED?
Through the direct monitoring of the piston position (opened) by means of pneumatic back pressure, the position can be sensed by means of a differential pressure switch.

_1B IS THE MODULE LOCKED?
With an open module, the integrated stop valve creates a pneumatic or hydraulic static pressure, which is sensed via a differential pressure switch.



LOCKING CONTROL
SUPPORT CONTROL
BLOW OUT

CENTRAL LOCK

2 INTERNAL BLOW-OUT

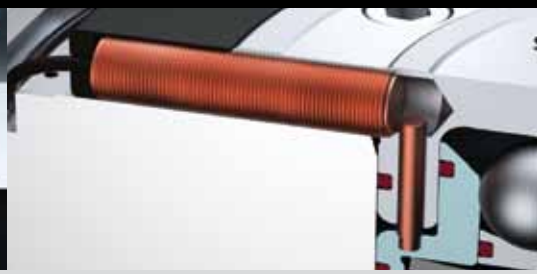
4 CENTRAL LOCK

6 NIPPLE SENSING

3 MEDIA DUCTS

5 BLOW-OFF/SUPPORT CONTROL

7 ELECTRICAL SENSING



_2 DIRT AND CHIPS IN THE CLAMPING MODULE?
Blowing out with compressed air cleans the inside from all dirt and chips and can be used simultaneously for workpiece support control by means of a differential pressure sensor.

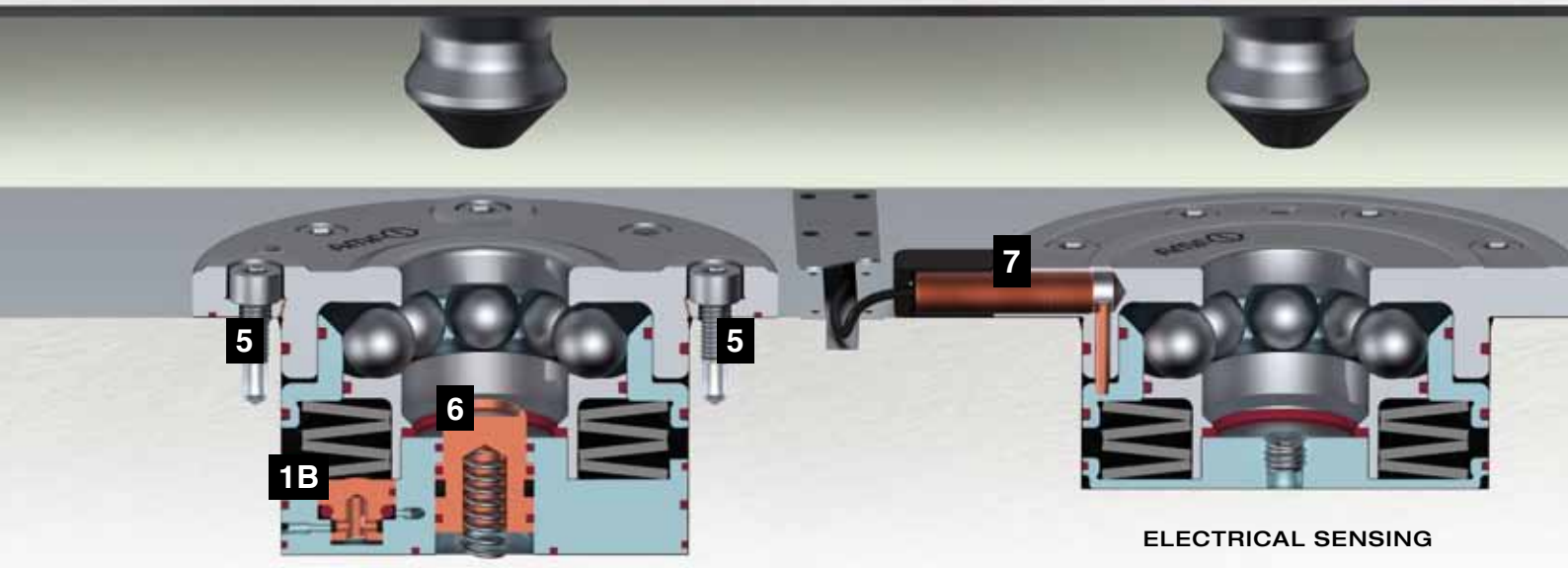
_3 ARE MEDIA DUCTS TO A FIXTURE NECESSARY?
Oil, compressed air, water, etc. can be run through our couplings without leaks.

_4 DIRT AND CHIPS UNWELCOME IN THE MODULE?
The lagging central lock prevents penetration of dirt and chips when the clamping nipple is being run out. The central lock replaces the previously required protection nipple.

_5 CHIPS AND DIRT? IS A WORKPIECE LYING WITHOUT GAP OR NOT?
The blow-out function with compressed air cleans the support surfaces and can be used simultaneously for workpiece support control by means of a differential pressure sensor.

_6 IS THE CLAMPING NIPPLE PRESENT ON THE FIXTURE?
The retracting nipple actuates a stop valve, which eliminates the pneumatic or hydraulic static pressure. This condition is sensed via a differential pressure switch.

_7 IS THE MODULE OPEN OR CLOSED?
The integrated inductive sensor can sense the piston position (open/closed) of the clamping module.



NIPPLE SENSING
LOCKING CONTROL
BLOW-OFF
SUPPORT CONTROL

ELECTRICAL SENSING

Subject to technical alterations.

OUR AUTOMATION SOLUTIONS -

THE RIGHT CLAMPING MODULE FOR EVERY APPLICATION

	K10 Order no. 424580	K10 Order no. 526632	K10.3 Order no. 426574	K10.3 Order no. 526616	K10.3 Order no. 550257	K10.3 Order no. 550259	K10.3 Order no. 550261	K20 Order no. 428409
	pneum.	pneum.	pneum.	pneum.	pneum.	pneum.	pneum.	hydr.
Support diameter max. [mm]	78	78	112	112	112	112	-	112
Support surfaces with integrated blow-out							●	
Pull-in/locking force in the system up to [kN]	8	8	10	10	10	10	10	20
Holding force [kN]	25	25	25	25	25	25	25	55
Operating pressure for pneum. opening min. - max. [bar]	8 - 12	8 - 12	**5 - 12**	**5 - 12**	**5 - 12**	**5 - 12**	**5 - 12**	
Operating pressure for pneum. re-clamping. min. - max. [bar]	5 - 6	5 - 6						
Operating pressure for hydr. opening min. - max. [bar]								60 - 70
Operating pressure for hydr. re-clamping. min. - max. [bar]								
Pneum. blow-out					●	●	●	●
Pneum. support control					●	●	●	●
Pneum. locking control					●	●	●	●
Hydr. locking control								
Pneum. clamping nipple sensing						●	●	
Hydr. clamping nipple sensing								
Sensor monitor opened	●	●	●	●				
Sensor monitor closed	●	●	●	●				
Sensor monitor clamping nipple		●		●				
Central lock with pneum. turbine blow-out								
Central lock with pneum. blow-out								

K20 Order no. 427161	K20 Order no. 550279	K20 Order no. 424192	K20.3 Order no. 526590	K20.3 Order no. 550258	K20.3 Order no. 550260	K20.3 Order no. 550262	K23 Order no. 420919	K40 Order no. 424564	
hydr.	hydr.	pneum.	pneum.	pneum.	pneum.	pneum.	hydr..	pneum.	
-	112	112	138	138	138	-	-	148	Support diameter [mm]
●						●	●		Support surfaces with integrated blow-out
20	20	17	17	17	17	17	23	30	Pull-in/locking force in the system up to [kN]
55	55	55	55	55	55	55	23	105	Holding force [kN]
		8 - 12	**4,5 - 12,0**	**4,5 - 12,0**	**4,5 - 12,0**	**4,5 - 12,0**		8 - 12	Operating pressure for pneum. opening min. - max. [bar]
		5 - 6						5 - 6	Operating pressure for pneum. re-clamping. min. - max. [bar]
50 - 60	60 - 70						25 - 50		Operating pressure for hydr. opening min. - max. [bar]
							20		Operating pressure for hydr. re-clamping. min. - max. [bar]
	●			●	●	●	●		Pneum. blow-out
●	●			●	●	●	●		Pneum. support control
●	●			●	●	●			Pneum. locking control
●							●		Hydr. locking control
●					●	●			Pneum. clamping nipple sensing
●									Hydr. clamping nipple sensing
		●	●					●	Sensor monitor opened
		●	●					●	Sensor monitor closed
									Sensor monitor clamping nipple
							●		Central lock with pneum. turbine blow-out
	●						●		Central lock with pneum. blow-out

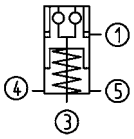
No. 6108LA-XX-08

Installation clamping module for automation solutions

Pneumatic opening.
Pneumatic blow-out.
Opening operating pressure:
K10.3 min. 5 bar
K20.3 min. 4.5 bar
Cover and piston hardened.
Repeat accuracy < 0.005 mm.
With locking control (pneum.)
and support control (pneum.).

EDELSTAHL Rostfrei
STAINLESS STEEL

NEW!



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
550257	K10.3	10	25	●	1,4
550258	K20.3	17	55	●	2,6

Design:

Centric blow-out, support control and locking control.

Application:

Zero-point clamping system for automation solutions for set-up-time-optimised clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

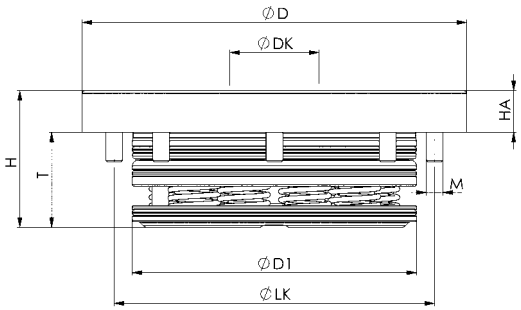
Locking control: Static pressure with opened clamping module, flow-through only with locked clamping module.
Support control via the blow-out function: Static pressure with supported interchangeable pallet.
The installation clamping module is opened pneumatically and mechanically locked through spring force. The pressure line can be subsequently decoupled at any time (module is clamped at normal pressure).
The clamping module has four connections:
1 x pneum. opening (1)
1 x pneum. blow-out and support control (3)
1 x pneum. locking control input (4)
1 x pneum. locking control output (5)

On request:

- Installation diagram
- Further automation options

K20.3

K10.3



Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	M	T
550257	K10.3	112	22	78	35	10	88	6 x M6	25
550258	K20.3	138	32	102	49	15	115	8 x M6	34

Subject to technical alterations.

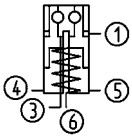
No. 6108LA-XX-08

Installation clamping module for automation solutions

Pneumatic opening.
Pneumatic blow-out.
Opening operating pressure:
K10.3 min. 5 bar
K20.3 min. 4.5 bar
Cover and piston hardened.
Repeat accuracy < 0.005 mm. With locking control (pneum.) and support control (pneum.) and clamping nipple sensing (pneum.).

EDELSTAHL Rostfrei STAINLESS STEEL

NEW!



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
550259	**K10.3**	10	25	●	1,4
550260	**K20.3**	17	55	●	2,6

Design:

Centric blow-out, support control, locking control and clamping nipple sensing.

Application:

Zero-point clamping system for automation solutions for set-up-time-optimised clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

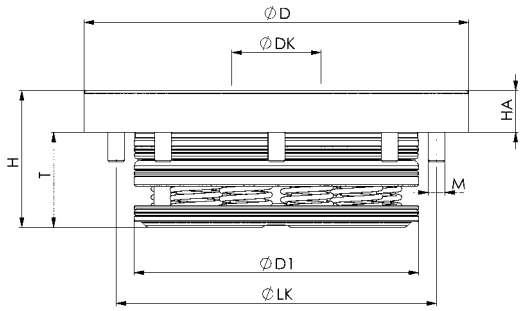
Locking control: Static pressure with opened clamping module, flow-through only with locked clamping module.
Clamping nipple sensing: Static pressure with clamping nipple present, flow-through if clamping nipple is not present.
Support control via the blow-out function: Static pressure with supported interchangeable pallet.
The installation clamping module is opened pneumatically and mechanically locked through spring force. The pressure line can be subsequently decoupled at any time (module is clamped at normal pressure).
The clamping module has five connections:
1 x pneum. opening (1)
1 x pneum. blow-out and support control (3)
1 x pneum. locking control inlet (4)
1 x pneum. locking control output (5)
1 x pneum. clamping nipple sensing input (6)
1 x pneum. clamping nipple sensing output (5)

On request:

- Installation diagram
- Further automation options

K10.3

K20.3



Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	M	T
550259	**K10.3**	112	22	78	35	10	88	6 x M6	25
550260	**K20.3**	138	32	102	49	15	115	8 x M6	34

Subject to technical alterations.

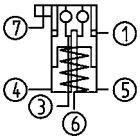
No. 6108LA-XX-10

Installation clamping module for automation solutions

Pneumatic opening.
Pneumatic blow-out.
Opening operating pressure:
K10.3 min. 5 bar
K20.3 min. 4.5 bar
Cover and piston hardened.
Repeat accuracy < 0.005 mm. With locking control (pneum.) and support control (pneum.) and clamping nipple sensing (pneum.) and isolated solution.

EDELSTAHL® Rost frei
STAINLESS STEEL

NEW!



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
550261	**K10.3**	10	25	●	1,4
550262	**K20.3**	17	55	●	2,6

Design:

Support surfaces as isolated design with integrated blow-out, centric blow-out, support control, locking control and clamping nipple sensing.

Application:

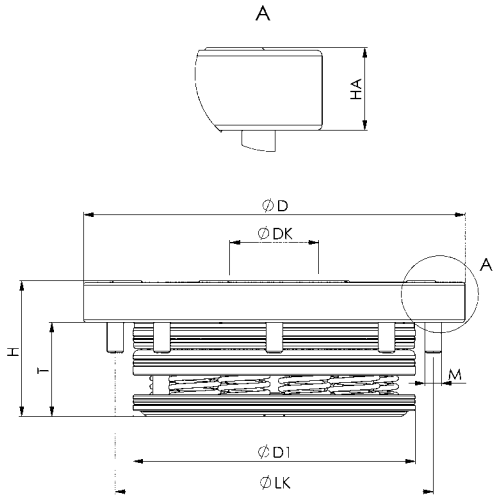
Zero-point clamping system for automation solutions for set-up-time-optimised clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

Locking control: Static pressure with opened clamping module, flow-through only with locked clamping module.
Clamping nipple sensing: Static pressure with clamping nipple present, flow-through if clamping nipple is not present.
Support control: Static pressure with supported interchangeable pallet.
The installation clamping module is opened pneumatically and mechanically locked through spring force. The pressure line can be subsequently decoupled at any time (module is clamped at normal pressure).
The clamping module has 6 connections:
1 x pneum. opening (1)
1 x pneum. blow-out (3)
1 x pneum. locking control inlet (4)
1 x pneum. locking control output (5)
1 x pneum. clamping nipple sensing input (6)
1 x pneum. clamping nipple sensing output (5)
1 x pneum. Support control (7)

On request:

- Installation diagram
- Further automation options



Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	M	T
550261	**K10.3**	112	22	78	35	10	88	6 x M6	25
550262	**K20.3**	138	32	102	49	15	115	8 x M6	34

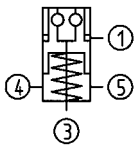
Subject to technical alterations.

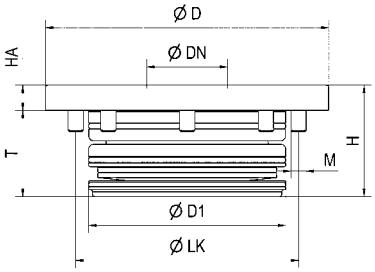
No. 6103HA-20-05

Installation clamping module for automation solutions

Hydraulic opening.
Pneumatic blow-out.
Opening operating pressure: min. 60 bar - max. 70 bar
Cover and piston hardened.
Repeatability < 0.005 mm.
With locking control (pneumatic) and support control (pneumatic).

EDELSTAHL Rostfrei STAINLESS STEEL





CAD

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
428409	K20	20	55	●	1,4

Design:

Centrical blow-out, support control and locking control.

Application:

Zero-point clamping system for automation solutions for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

Locking control: Static pressure with opened clamping module, flow-through only with locked clamping module.
Support control via the blow-out function: Static pressure with supported change pallet.
The installation clamping module is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module has four connections:
1x hydr. opening (1) / 1x pneum. blow-out and support control (3) /
1x pneum. locking control input (4) /
1x pneum. locking control output (5).

On request:

- Installation diagrams
- Additional automation options

Dimensions:

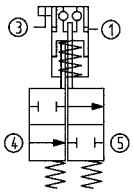
Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	M	dia. LK	T
428409	K20	112	32	78	44	10	M6	88	34

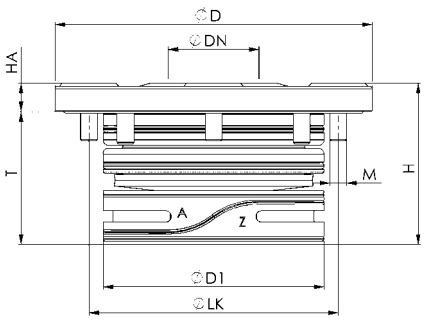
No. 6100H-20-06

Installation clamping module for automation solutions

Hydraulic opening.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.
With locking control (hydraulic or pneumatic), support control (pneumatic) and nipple sensing.

EDELSTAHL Rostfrei STAINLESS STEEL





CAD

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
427161	K20	20	55	2,8

Design:

Support surfaces as island design with integrated blow-out, locking control and nipple sensing.

Application:

Zero-point clamping system for automation solutions for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

Locking control: Static pressure with opened clamping module, flow-through only with locked clamping module and presence of clamping nipple.
Support control: Static pressure with supported change pallet.
This is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module has four connections:
1x hydr. opening (1) / 1x pneum. support control (3) /
1x hydr. or pneum. locking control and nipple sensing input (4) /
1x hydr. or pneum. locking control and nipple sensing output (5).

On request:

- Installation diagrams
- Additional automation options

Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	M	T
427161	K20	112	32	78	57	10	88	M6	47

Subject to technical alterations.

No. 6107HA-20-07

Installation clamping module with central lock for automation solutions

Hydraulic opening.
Pneumatic blow-out.
Operating pressure: 60 bar - 70 bar
Cover and piston hardened.
Repeat accuracy < 0.005 mm.
With locking control (pneum.) and support control (pneum.).

EDELSTAHL Rostfrei
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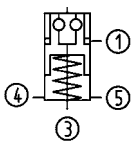


Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Blow out	Weight [Kg]
550279	K20	20	55	●	1,4

Design:

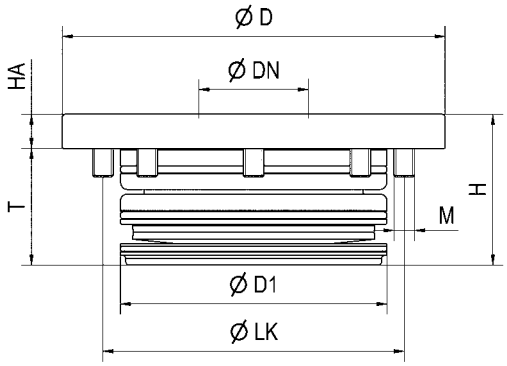
With central lock, blow-out, support control and locking control.

Application:

Zero-point clamping system for automation solutions for set-up-time-optimised clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

Central lock with pneum. cleaning function of support surfaces.
Locking control: Static pressure with opened clamping module, flow-through only with locked clamping module.
Support control via the blow-out function: Static pressure with supported interchangeable pallet.
The installation clamping module is opened hydraulically and mechanically locked through spring force. The pressure line can be subsequently decoupled at any time (module is clamped at normal pressure).
The clamping module has four connections:
1 x hydr. opening (1)
1 x pneum. blow-out and support control (3)
1 x pneum. locking control inlet (4)
1 x pneum. locking control output (5)



Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	M	T
550279	K20	112	32	78	44	10	88	M6	34

Subject to technical alterations.

Automation solution (order no. 427161) with lock and support control as well as nipple sensing in use in a fully automated production process with robot loading.

„Turbine“ high-end clamping module (order no. 420919) in use in a fully automated production process with robot loading.

Subject to technical alterations.

No. 6102H

„Turbine“ high-end clamping module for full automation

Hydraulic opening.
Opening operating pressure: 25-50 bar
Retensioning operating pressure: 20 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

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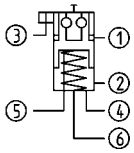


Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
420919	K23	23	23	4,8

Application:

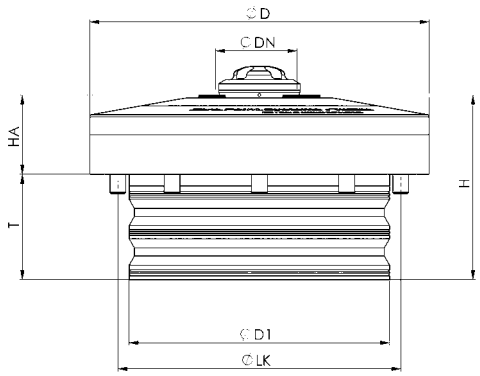
For fully automatic clamping solutions for use as machine table support in processing centres with automatic pallet changing system or robot loading and for installation in pallets, machine tables, clamping brackets and cubes. Many possible versatile uses in automation.

Note:

Hardened support surfaces as island design with integrated support control. Additional blowing off of the support surfaces by centrically running-out turbine spindles and blowing out of the sphere space
Additional hydraulic 6 mm lift-out of the pallet to be changed for easier pallet removal.
Sensing options:
- Support control (pneumatic)
- Locking control (hydraulic)
Turbine has six connections:
1x hydr. opening (1) / 1x hydr. retensioning (2) / 1x pneum. support control (3) / 1x blow-off, blow-out and pneum. turbine blow-off (4) / 1x hydr. locking control (5) / 1x run out short stroke piston (6).

On request:

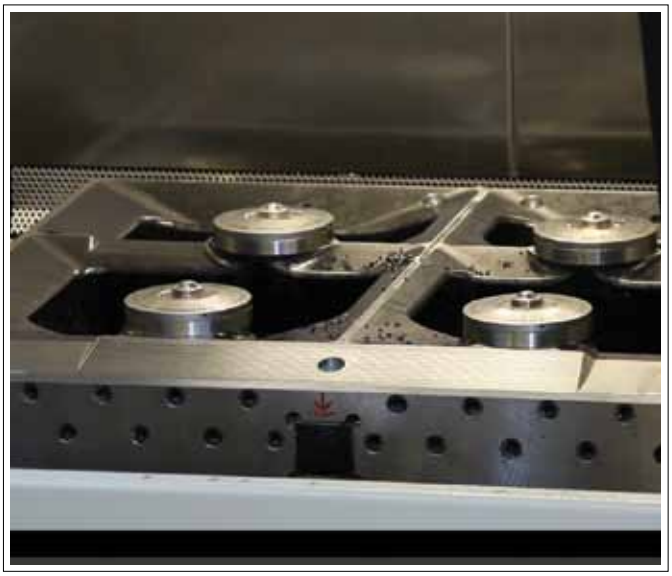
- Installation diagrams



CAD

Dimensions:

Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	T
420919	K23	129	32	99	70	30	115	40



Subject to technical alterations.

„TURBINE“ HIGH-END CLAMPING MODULE FOR FULL AUTOMATION

This high-end clamping module is used for optimised tool clamping times in fully automatic processing centres with pallet changing systems or robot loading.

- Turbine blow-off of the hardened support and housing surface
- Pneumatic support control
- Hydraulic unlocking control
- Hydraulic lifting of the pallet (6 mm) after opening of the clamping module
- Material: stainless steel
- Hardened support surface on the connection fitting with defined, measurable height

No. 6104L

Clamping module with sensor monitor and mounting flange

Pneumatic opening.
Opening operating pressure: min. 5 bar - max. 12 bar
Cover and piston hardened.
Flange housing: Aluminium
Repeat accuracy < 0.005 mm.

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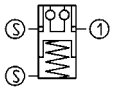


Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
526574	**K10.3**	10	25	2,6
526590	**K20.3**	17	55	5,0

Application:

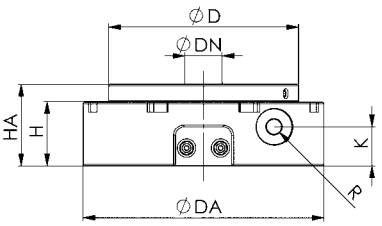
Zero point clamping system for automation solutions for time-optimised clamping during cutting and non-cutting machining in all sectors, as well as in the food, pharmaceutical and chemical industries.

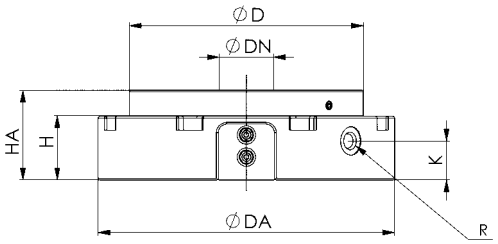
Note:

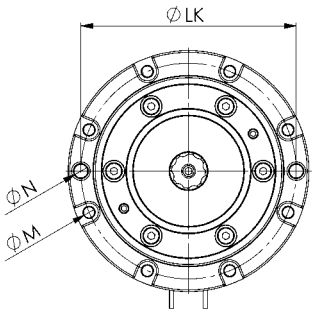
The clamping module has two inductive sensors (connection type: connector S8, cable length 150 mm) for the status check (opened / locked). This is opened pneumatically (1) and mechanically locked through spring force. The pressure line can be subsequently decoupled at any time (module is clamped depressurised).
The clamping module has one connection: 1 x pneum. opening (1).

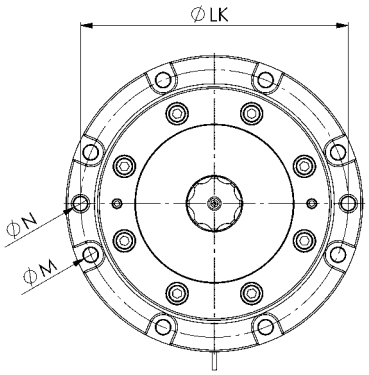
On request:

- Installation diagrams
- Further automation solutions.









Dimensions:

Order no.	Size	dia. DA	dia. D	dia. DN	H	HA	K	dia. LK	dia. M	dia. N H7	R
526574	**K10.3**	142	112	22	38	48	23	127	6,6	8	G1/8
526590	**K20.3**	175	138	32	38	53	23	158	8,4	8	G1/8

CAD

Subject to technical alterations.

No. 6105L

Clamping module with sensor monitor and nipple sensing

Pneumatic opening.
Opening operating pressure: min. 5 bar - max. 12 bar
Cover and piston hardened.
Flange housing: Aluminium
Repeat accuracy < 0.005 mm.

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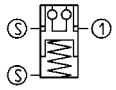
NEW!



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
526616	K10.3	10	25	2,6

Application:

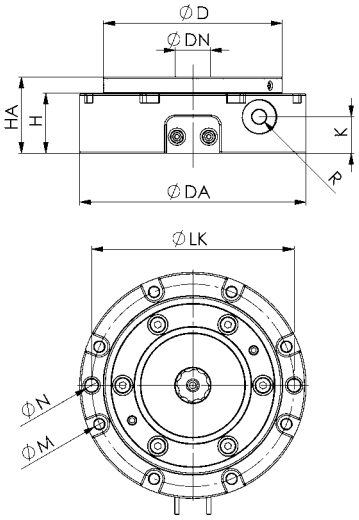
Zero point clamping system for automation solutions for time-optimised clamping during cutting and non-cutting machining in all sectors, as well as in the food, pharmaceutical and chemical industries.

Note:

The clamping module has two inductive sensors (connection type: connector S8, cable length 150 mm) for the status check for opened/locked and the presence of the clamping nipple. This is pneumatically opened (1) and mechanically locked by spring force. The pressure line can be subsequently decoupled at any time (module is clamped depressurised).
The clamping module has one connection: 1 x pneum. opening (1).

On request:

- Installation diagrams
- Further automation solutions.



Dimensions:

Order no.	Size	dia. DA	dia. D	dia. DN	H	HA	K	dia. LK	dia. M	dia. N H7	R
526616	K10.3	142	112	22	38	48	23	127	6,6	8	G1/8

CAD

Subject to technical alterations.

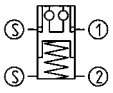
No. 6106L

Clamping module with sensor monitor and nipple sensing

Pneumatic opening.
Opening operating pressure: min. 8 bar - max. 12 bar
Re-clamping operating pressure: min. 5 bar - max. 6 bar
Cover and piston hardened.
Flange housing: Aluminium
Repeat accuracy < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL

NEW!



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
526632	K10	8	25	1,0

Application:

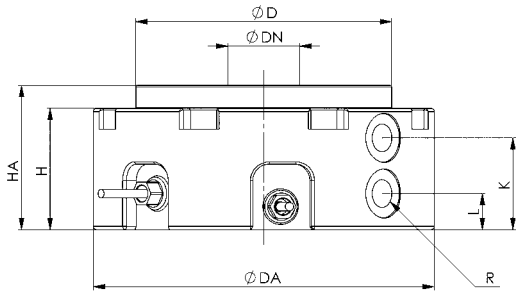
Zero point clamping system for automation solutions for time-optimised clamping during cutting and non-cutting machining in all sectors, as well as in the food, pharmaceutical and chemical industries.

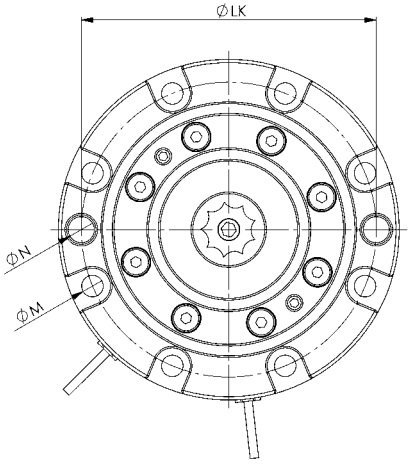
Note:

The clamping module has two inductive sensors (connection type: connector S8, cable length 150 mm) for the status check for opened/locked and the presence of the clamping nipple. This is pneumatically opened (1) and mechanically locked by spring force. The pressure line can be subsequently decoupled at any time (module is clamped depressurised).
The clamping module has two connections: 1 x pneum. opening (1) / 1 x pneum. re-clamping (turbo) (2).

On request:

- Installation diagrams
- Further automation solutions.





Dimensions:

Order no.	Size	dia. DA	dia. D	dia. DN	H	HA	K	dia. LK	dia. M	dia. N H7	R
526632	K10	104	78	22	37	44	28	90	6,6	8	G1/8

CAD

Subject to technical alterations.

No. 6101L

Clamping module with sensor monitor and mounting flange

Pneumatic opening.
Opening operating pressure: min. 8 bar - max. 12 bar
Retensioning operating pressure (turbo): min. 5 bar - max. 6 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

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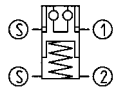
STAINLESS STEEL



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
424580	**K10**	8	25	2,4
424192	**K20**	17	55	6,9
424564	**K40**	30	105	11,0

Application:

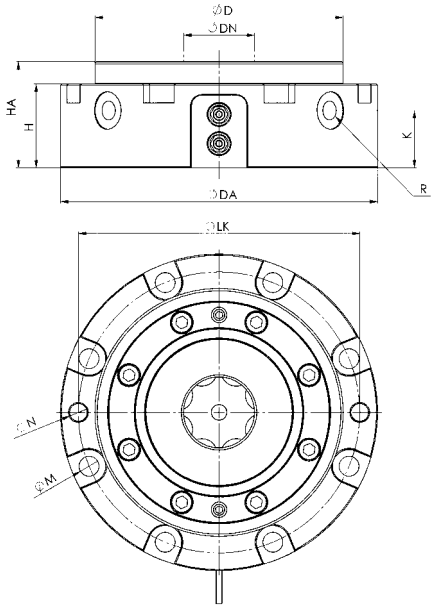
Zero-point clamping system for automation solutions for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

The installation clamping module with sensor monitor contains 2 inductive sensors (connection type: S8 plug, cable length: 150 mm) for condition control (open / locked). This is pneumatically opened (1) and mechanically locked through spring force. To achieve the specified pull-in and locking forces, it must be briefly retensioned pneumatically (turbo) (2). Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
Use of the pneumatic pressure intensifier 6370ZVL is recommended.
Clamping module has two connections: 1x pneum. opening (1) / 1x pneum. retensioning (turbo) (2).

On request:

- Installation diagrams
- Additional automation options



Dimensions:

Order no.	Size	dia. DA	dia. D	dia. DN	H	HA	K	dia. LK	dia. M	dia. N H7	R
424580	**K10**	104	78	22	37	44	12	90	6,6	8	G1/8
424192	**K20**	143	112	32	38	48	26	127	9,0	8	G1/8
424564	**K40**	188	148	40	47	62	32	168	11,0	10	G1/4

CAD

Subject to technical alterations.

No. 6206S2L

Double clamping station

Pneumatic unlocking.
Opening operating pressure:
K10.3 min. 5 bar
K20.3 min. 4.5 bar
Steel, unhardened.
Repeat accuracy <0.005 mm.

NEW!

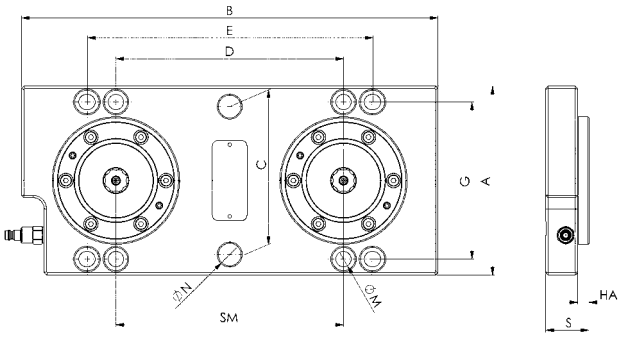
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
550249	**K10.3**	2 x 10	2 x 25	13
550254	**K20.3**	2 x 17	2 x 55	24

Design:

Pneumatic clamping station for setting time-optimised clamping on machine tables with groove spacing of 63, 100 and 125 mm. Fastening is via M12 socket head screws. At least two fitting bores are attached for alignment.
The insertion dimension of the clamping modules is 200 mm.
The pneumatic quick-coupler is premounted.

Advantage:

- Low overall height



Dimensions:

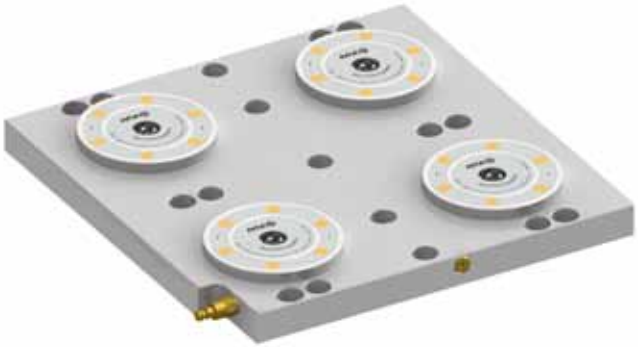
Order no.	Size	A	B	C	D	E	G	HA	dia. N	dia. M	S	SM
550249	**K10.3**	166	366	133	200	250 - 252	138	10	20	13,5	38	200
550254	**K20.3**	196	366	160	200	250 - 252	165	15	20	13,5	53	200

No. 6206S4L

Quadruple clamping station

Pneumatic unlocking.
Opening operating pressure:
K10.3 min. 5 bar
K20.3 min. 4.5 bar
Steel, unhardened.
Repeat accuracy <0.005 mm.

NEW!



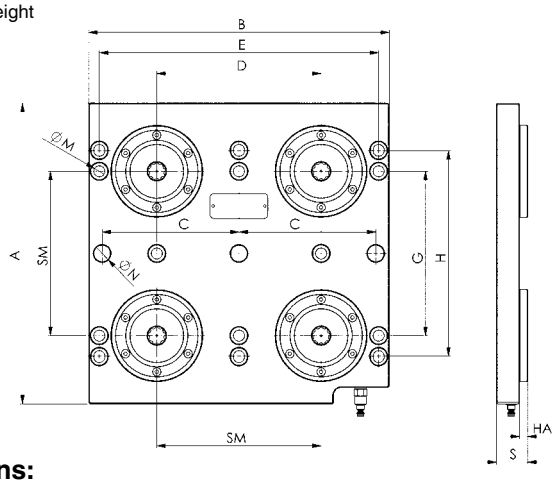
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
550251	**K10.3**	4 x 10	4 x 25	30
550255	**K20.3**	4 x 17	4 x 55	51

Design:

Pneumatic clamping station for setting time-optimised clamping on machine tables with groove spacing of 63, 100 and 125 mm. Fastening is via M12 socket head screws. At least two fitting bores are attached for alignment.
The insertion dimension of the clamping modules is 200 mm.
The pneumatic quick-coupler is premounted.

Advantage:

- Low overall height



Dimensions:

Order no.	Size	A	B	C	D	E	G	H	HA	dia. N	dia. M	S	SM
550251	**K10.3**	366	366	166,5	200	340	200	250 - 252	10	20	13,5	38	200
550255	**K20.3**	399	399	183,5	200	370	200	250 - 252	15	20	13,5	53	200

Subject to technical alterations.

No. 6206S6L

Sextuple clamping station

Pneumatic unlocking.
Opening operating pressure:
K10.3 min. 5 bar
K20.3 min. 4.5 bar
Steel, unhardened.
Repeat accuracy <0.005 mm.

NEW!

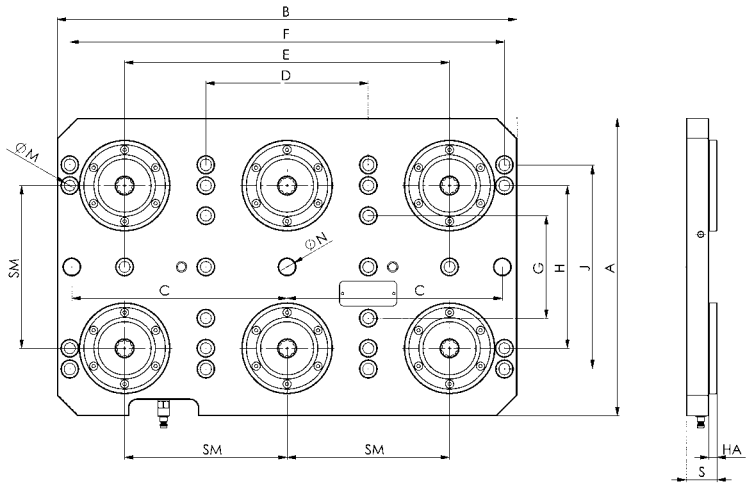
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
550252	**K10.3**	6 x 10	6 x 25	46
550256	**K20.3**	6 x 17	6 x 55	76

Design:

Pneumatic clamping station for setting time-optimised clamping on machine tables with groove spacing of 63, 100 and 125 mm. Fastening is via M12 socket head screws. At least two fitting bores are attached for alignment.
The insertion dimension of the clamping modules is 200 mm.
The pneumatic quick-coupler is premounted.

Advantage:

- Low overall height



Dimensions:

Order no.	Size	A	B	C	D	E	F	G	H	HA	J	dia. N	dia. M	S	SM
550252	**K10.3**	366	566	265	200	400	535	126	200	10	250 - 252	20	13,5	38	200
550256	**K20.3**	396	596	265	200	400	565	126	200	15	250 - 252	20	13,5	53	200

Subject to technical alterations.

No. 6370S2-001

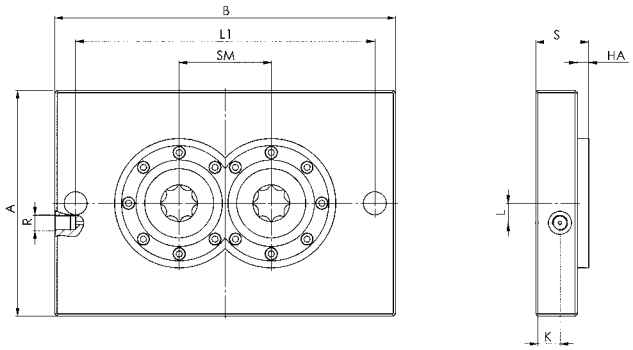
Double clamping station

Hydraulic unlocking.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
303263	K20	2 x 20	2 x 55	16,5
303271	K40	2 x 40	2 x 105	32,0

Note:

On request, we can incorporate mounting holes to your requirements in the base plate.



Dimensions:

Order no.	Size	A	B	HA	K	L	L1	dia. N	R	S	SM
303263	K20	196	296	10	21	17	260	20	G1/4	46	80
303271	K40	246	346	15	30	21	300	25	G1/4	61	110

CAD

No. 6370S2-002

Double clamping station

Hydraulic unlocking.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

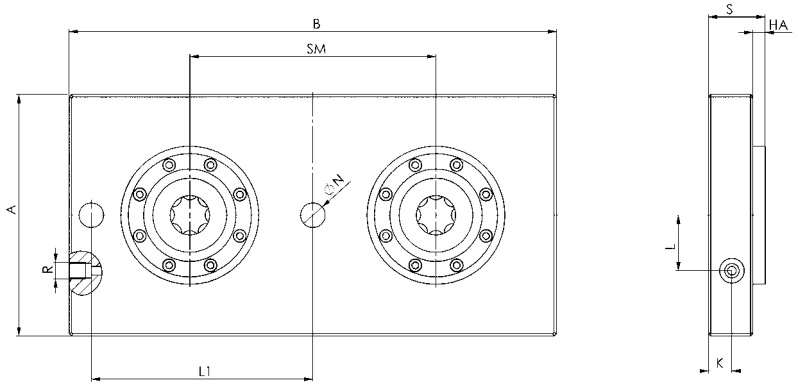
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
426726	K10	2 x 10	2 x 25	7,5
303289	K20	2 x 20	2 x 55	21,9
303297	K40	2 x 40	2 x 105	59,5

Note:

On request, we can incorporate mounting holes to your requirements in the base plate.

On request:

Other dimensions, insertion dimensions and number of clamping nipples equipped.



Dimensions:

Order no.	Size	A	B	HA	K	L	L1	dia. N	R	S	SM
426726	K10	146	240	7	14,5	35	100	20	G1/4	33	100
303289	K20	196	396	10	19,0	45	180	20	G1/4	46	200
303297	K40	296	546	15	26,0	57	250	25	G1/4	61	320

CAD

Subject to technical alterations.

No. 6370S4-001

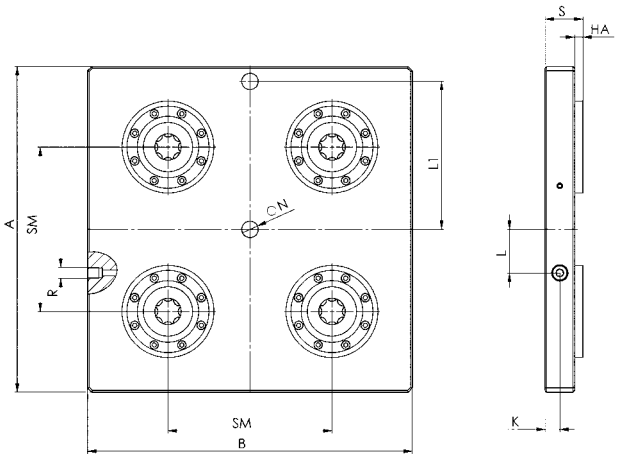
Quadruple clamping station

Hydraulic unlocking.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
426742	K10	4 x 10	4 x 25	12,5
303321	K20	4 x 20	4 x 55	44,0
303339	K40	4 x 40	4 x 105	110,0

Note:

On request, we can incorporate mounting holes to your requirements in the base plate.



Dimensions:

Order no.	Size	A	B	HA	K	L	L1	dia. N	R	S	SM
426742	K10	240	240	7	14,5	16	100	20	G1/4	33	100
303321	K20	395	395	10	19,0	50	180	20	G1/4	46	200
303339	K40	546	546	15	26,0	95	250	25	G1/4	61	320

CAD

No. 6370S6-001

Sextuple clamping station

Hydraulic unlocking.
Clamping modules' contact surface:
Steel, stainless and hardened.
Base plate: Steel, unhardened.
Repetition accuracy < 0.005 mm.

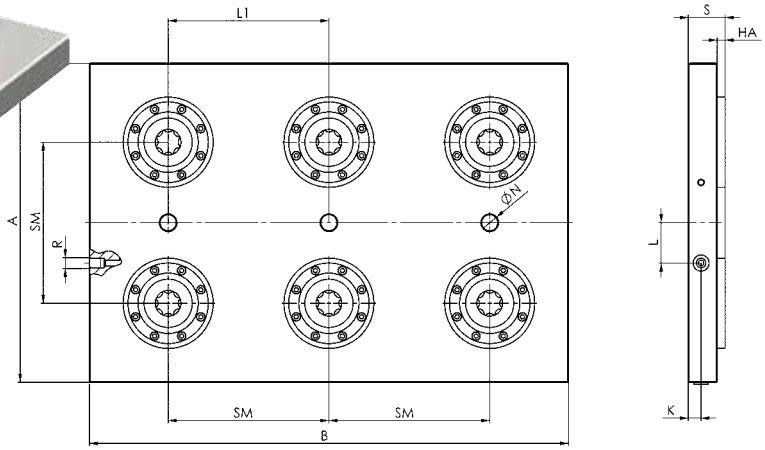
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
426734	K10	6 x 10	6 x 25	17,5
424119	K20	6 x 20	6 x 55	75,0
426759	K40	6 x 40	6 x 105	175,0

Note:

On request, we can incorporate mounting holes to your requirements in the base plate.

On request:

Other dimensions, insertion dimensions and number of clamping nipples equipped.



Dimensions:

Order no.	Size	A	B	HA	K	L	L1	dia. N	R	S	SM
426734	K10	240	340	7	14,5	84	100	20	G1/4	33	100
424119	K20	396	596	10	20,0	50	200	20	G1/4	46	200
426759	K40	546	846	15	24,0	96	320	20	G1/4	61	320

CAD

Subject to technical alterations.

No. 6370P2

Fixture plate

High-strength aluminium, suitable for double clamping station

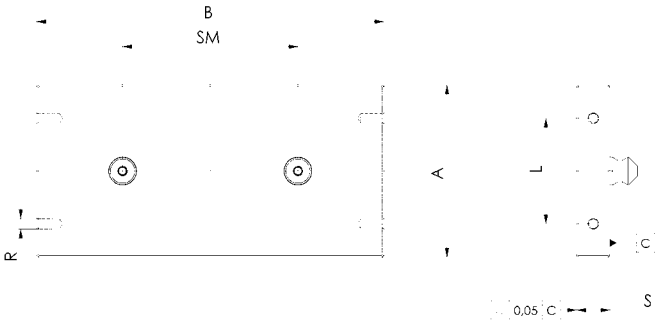
Order no.	Size	A	B	L	R	S	SM	Weight [Kg]
426700	K10	146	240	-	-	30	100	2,5
425041	K20	196	396	120	M12	40	200	6,0
426783	K40	296	546	120	M12	45	320	19,0

Note:

On request, we can incorporate mounting holes according to your specifications in the change pallet.

On request:

Other dimensions, insertion dimensions and number of clamping nipples equipped.



CAD

No. 6370P4

Fixture plate

High-strength aluminium, suitable for quadruple clamping station

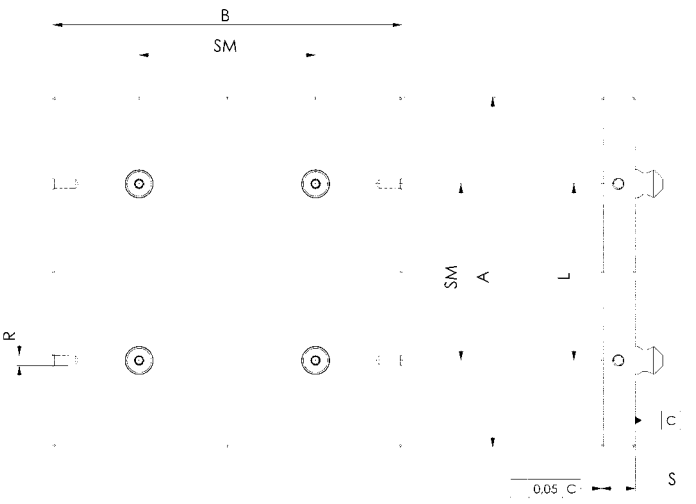
Order no.	Size	A	B	L	R	S	SM	Weight [Kg]
426767	K10	240	240	-	-	30	100	4,5
425033	K20	396	396	200	M12	40	200	16,0
426809	K40	546	546	320	M12	45	320	35,0

Note:

On request, we can incorporate mounting holes according to your specifications in the change pallet.

On request:

Other dimensions, insertion dimensions and number of clamping nipples equipped.



CAD

Subject to technical alterations.

No. 6370P6

Fixture plate

High-strength aluminium, suitable for sextuple clamping station

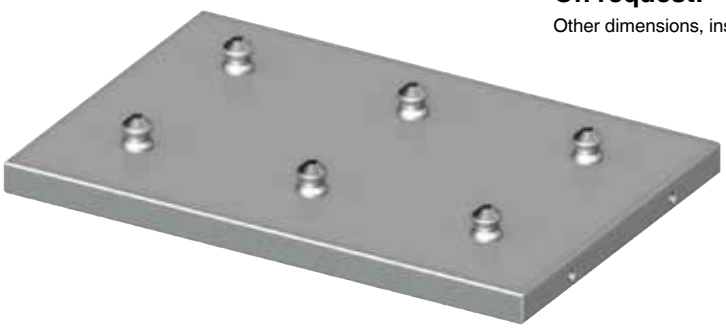
Order no.	Size	A	B	L	R	S	SM	Weight [Kg]
426775	**K10**	240	386	120	M10	30	100	7,5
426791	**K20**	396	596	200	M12	40	200	25,0
426817	**K40**	546	866	320	M12	45	320	56,0

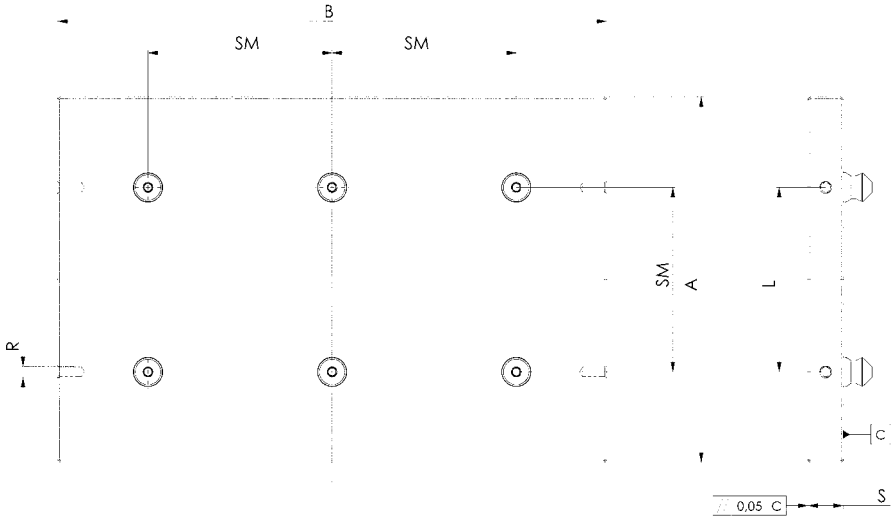
Note:

On request, we can incorporate mounting holes according to your specifications in the change pallet.

On request:

Other dimensions, insertion dimensions and number of clamping nipples equipped.





CAD

Subject to technical alterations.

No. 6211S2-20LA-03

Quadruple clamping station

Pneumatic unlocking.
Pneumatic blow-out.
Opening operating pressure: min. 5 bar
Steel, unhardened.
Repeat accuracy <0.005 mm.

NEW!

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Speed [1/min]	Weight [Kg]
550436	K20.3	4 x 17	4 x 55	2200	55

Application:

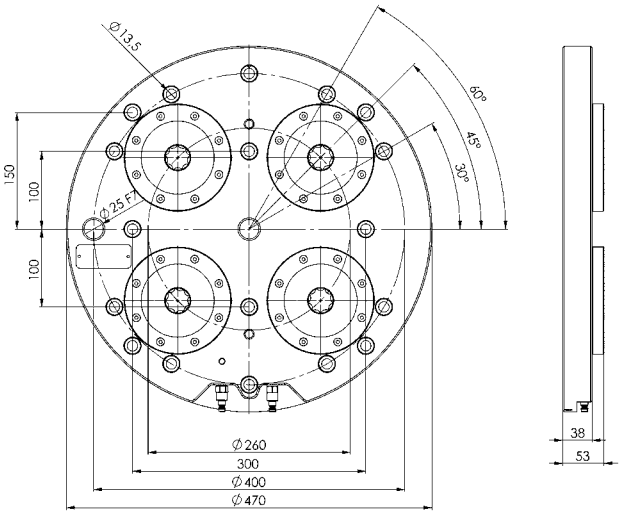
Pneumatic clamping station for setting time-optimised clamping for milling-turning machining.

Note:

Fastening to the machine table is via socket head screws.
The clamping station has two connections:
1 x pneum. opening and 1 x pneum. blow-out, which can also be used for the support control.

On request:

Further dimensions, different pitch circles and number of modules.



No. 6211P-20S4-03

Fixture plate

Steel, unhardened, suitable for 4-point clamping station

NEW!

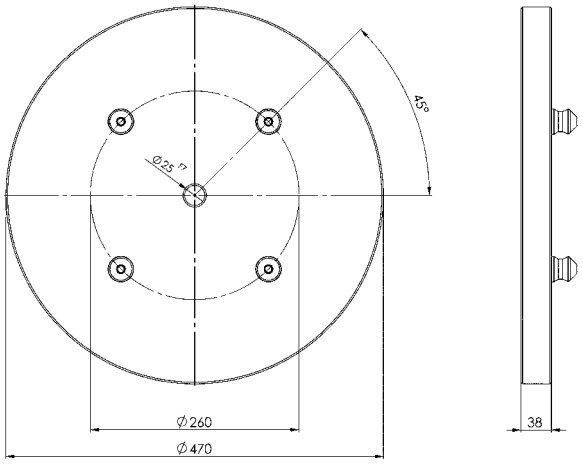
Order no.	Size	Weight [Kg]
550437	K20.3	52

Note:

The interchangeable pallet is designed for milling-turning machining and is suitable for clamping stations with 4 clamping modules K20 and K20.3, which are arranged on the 260 mm pitch circle.

On request:

Further dimensions, different pitch circles and number of clamping nipples.



Subject to technical alterations.

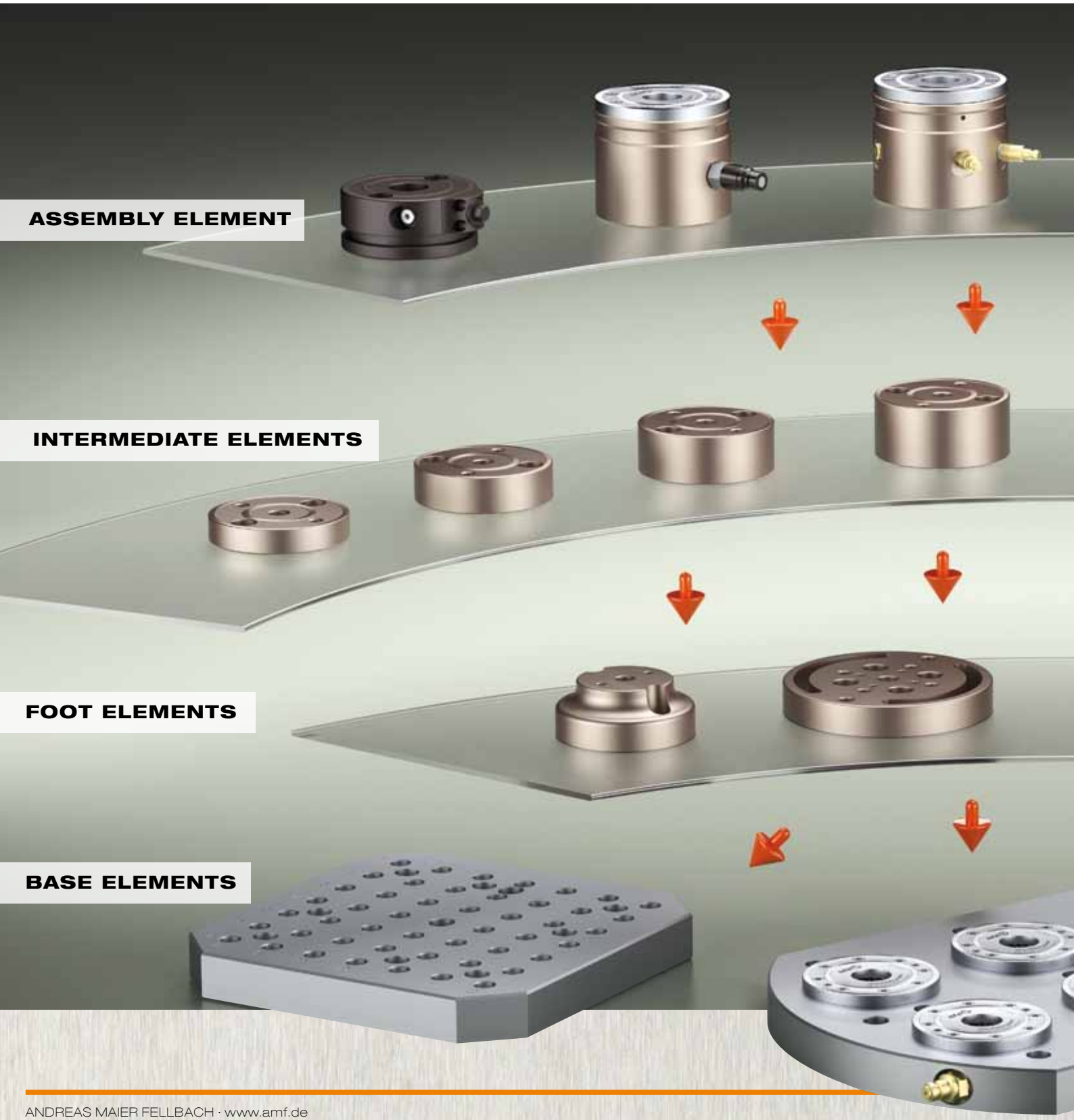
OUR ZERO-POINT SYSTEM FOR YOUR MILLING-TURNING MACHINING - QUICK, PRECISE, DURABLE, SIMPLY CONVINCING!

The benefits to you at a glance:

- Connection for opening the clamping station via the media duct in the machine table or a side connection for manual actuation.
- Opening pressure for unlocking the clamping modules just 4.5 bar.
- Only one pneumatic connection required to open the clamping modules.
- Locking via the self-locking and positive fit mechanism of the clamping modules.
- Cylindrical clamping nipple mount - hence high precision and durability.

SIMPLY CLEVER COMBINATIONS -
MODULAR HEIGHT ADAPTER FOR YOUR FLEXIBLE PRODUCTION

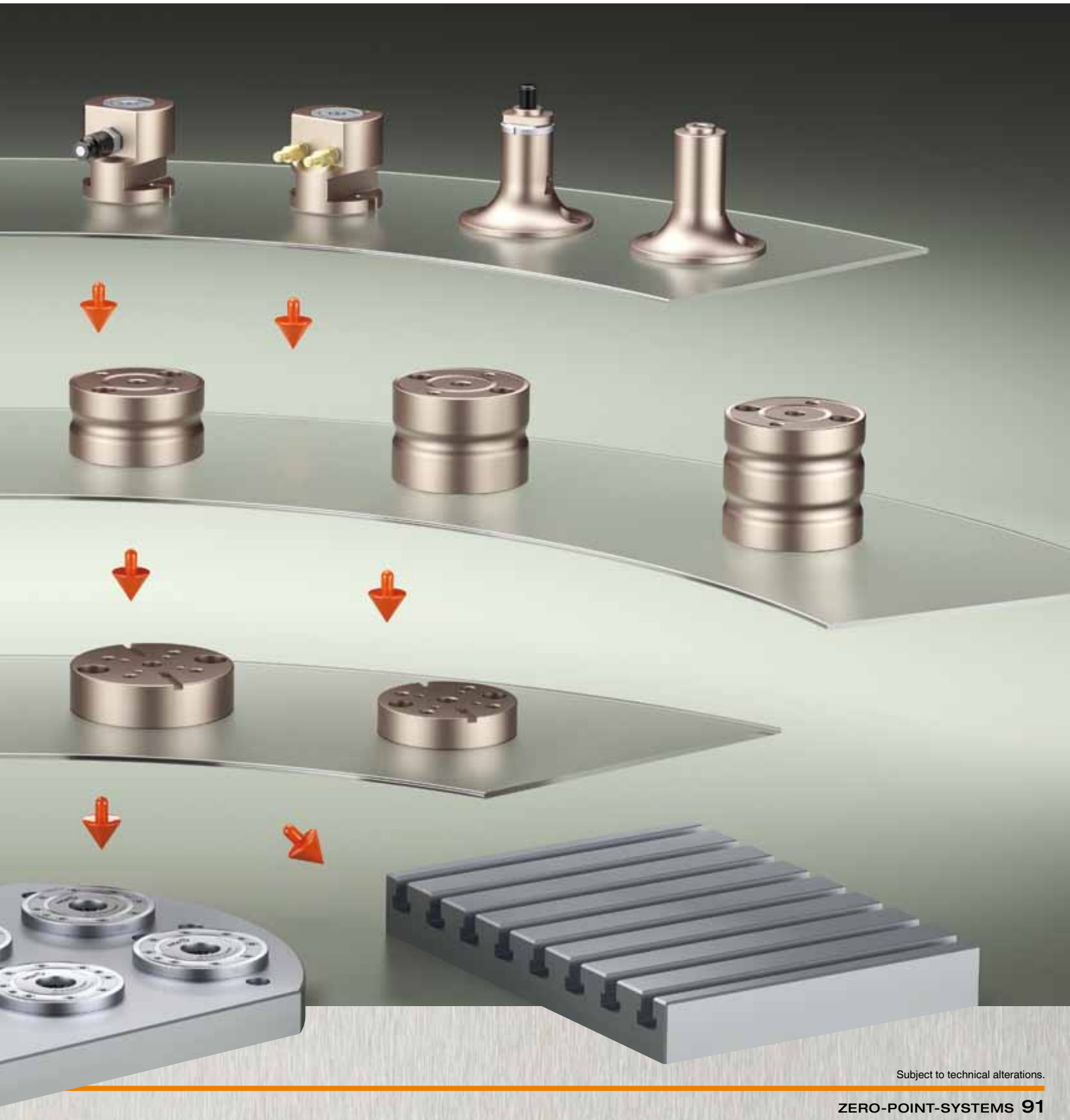
With the new modular height adapters from AMF, your production becomes even more flexible and economical.
Cleverly combined, you now have an efficient opportunity to adapt your production process more simply, flexibly and quickly to constantly changing requirements.



The modular height adapters consist of three levels. The foot elements form the interface to the existing machine table. Building on this and with the use of intermediate elements, every clamping height can be achieved and, by combining different sizes, adapted flexibly to the contour of the workpiece.
Assembly elements with integrated zero point clamping modules of the AMF Zero Point system complete the adapters. Through this, the workpiece is clamped in a process-reliable way.

THE ADVANTAGES:

> Simple direct clamping of the workpiece
> Flexibly adaptable to every workpiece size and thickness
> Convenient 5-sided processing
> Freely selectable standard dimension



Subject to technical alterations.

No. 6210Z

Intermediate element

Quenched and tempered steel, plasma-nitrated.

NEW!

Order no.	Size	H ±0.01	Weight [g]
534487	K10	20	667
534503	K10	30	1012
534529	K10	40	1353
534545	K10	50	1698
534560	K10	60	2043
534586	K10	80	2731
534602	K10	100	3443
534628	K20	20	1394
534644	K20	30	2092
534669	K20	40	2800
534685	K20	50	3508
534701	K20	60	4225
534727	K20	80	5661
534743	K20	100	7012

Application:

The intermediate elements are used as height adapters for workpieces and clamping fixtures, and are mounted to the main elements. Workpieces are clamped by means of assembly elements. This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.

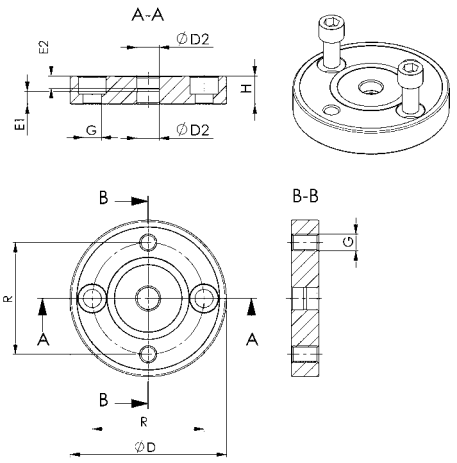
Advantage:

Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

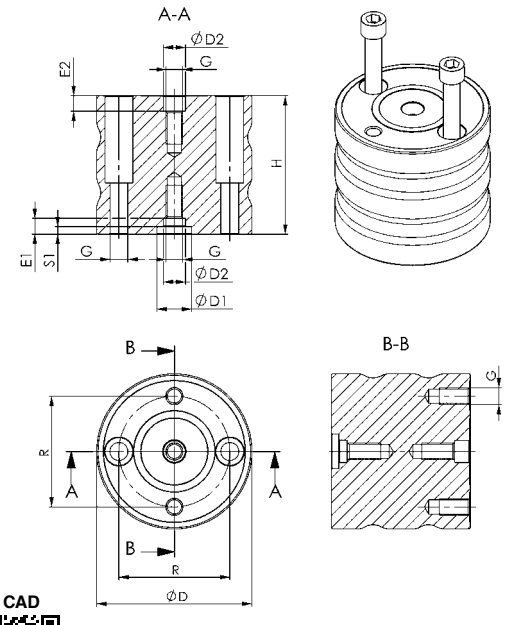
Note:

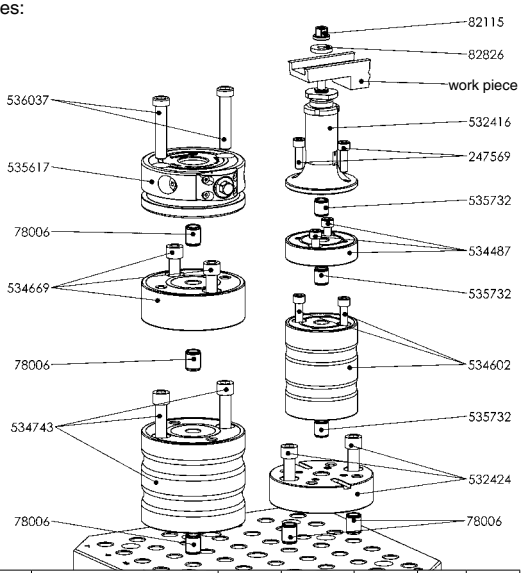
With the exception of overall heights H20 and 30, the locating bore for the clamping nipple, corresponding to size K10 and K20 is already made for the modification to zero point clamping modules.
If two or more intermediate elements are used, they can be axially aligned and then bolted using centering sleeves. The 2 screws are supplied as standard.
Order numbers for the centering sleeves:
- Size K10: Order no. 535732
- Size K20: Order no. 78006

Height 20 and 30 mm



Height from 40 mm





Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	Screw DIN84 or ISO4762	E1	E2	G	R	S1
534487	K10	78	-	15	M8x30	5,0	13,0	M8	50	-
534503	K10	78	-	15	M8x30	5,0	13,0	M8	50	-
534529	K10	78	15	15	M8x30	5,0	13,0	M8	50	3,5
534545	K10	78	15	15	M8x50	5,0	13,0	M8	50	3,5
534560	K10	78	15	15	M8x50	5,0	13,0	M8	50	3,5
534586	K10	78	15	15	M8x50	5,0	13,0	M8	50	3,5
534602	K10	78	15	15	M8x50	5,0	13,0	M8	50	3,5
534628	K20	112	-	16	M12x25	9,0	9,0	M12	80	-
534644	K20	112	-	16	M12x25	11,5	11,25	M12	80	-
534669	K20	112	25	16	M12x25	11,5	11,25	M12	80	5,5
534685	K20	112	25	16	M12x55	11,5	11,25	M12	80	5,5
534701	K20	112	25	16	M12x55	11,5	11,25	M12	80	5,5
534727	K20	112	25	16	M12x55	11,5	11,25	M12	80	5,5
534743	K20	112	25	16	M12x55	11,5	11,25	M12	80	5,5

CAD

Subject to technical alterations.

No. 6210IZ

Intermediate element, with indexing

Quenched and tempered steel, plasma-nitrated.

NEW!

Order no.	Size	H ±0.01	Weight [g]
531996	K10	20	632
532010	K10	30	987
532036	K10	40	1327
532051	K10	50	1651
532077	K10	60	2001
532093	K10	80	2713
532119	K10	100	3429
532135	K20	20	1361
532150	K20	30	2087
532176	K20	40	2788
532192	K20	50	3439
532218	K20	60	4165
532234	K20	80	5632
532242	K20	100	6980

Application:

The intermediate elements with indexing are used as height adapters for workpieces and clamping fixtures, and are mounted to the main elements. Workpieces are clamped by means of assembly elements.
This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.
Thanks to the 4-point 90° indexing option, workpieces under strong machining forces can be secured to prevent radial distortion.

Advantage:

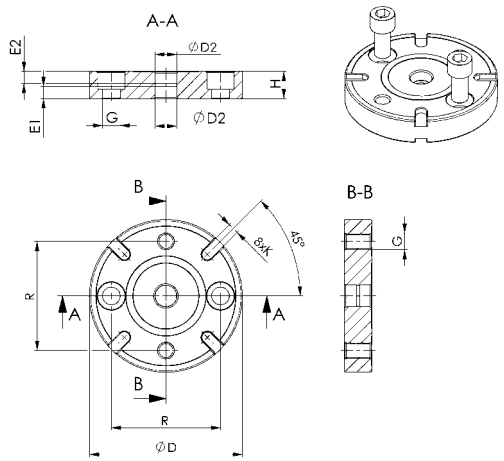
Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

Note:

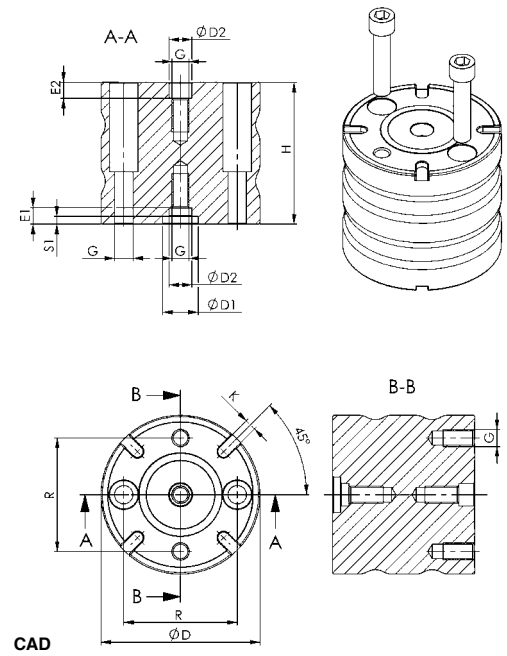
With the exception of overall heights H20 and 30, the locating bore for the clamping nipple, corresponding to size K10 and K20 is already made for the modification to zero point clamping modules.
If two or more intermediate elements are used, they can be axially aligned and then bolted using centering sleeves. The 2 screws are supplied as standard.
Order numbers for the centering sleeves:
- Size K10: Order no. 535732
- Size K20: Order no. 78006

Slot nuts: Order no. 430264.

Height 20 and 30 mm



Height from 40 mm



CAD

Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	Screw DIN84 or ISO4762	E1	E2	G	K F6	R	S1
531996	K10	78	-	15	M8x30	5,0	13,0	M8	8	50	-
532010	K10	78	-	15	M8x30	5,0	13,0	M8	8	50	-
532036	K10	78	15	15	M8x30	5,0	13,0	M8	8	50	3,5
532051	K10	78	15	15	M8x50	5,0	13,0	M8	8	50	3,5
532077	K10	78	15	15	M8x50	5,0	13,0	M8	8	50	3,5
532093	K10	78	15	15	M8x50	5,0	13,0	M8	8	50	3,5
532119	K10	78	15	15	M8x50	5,0	13,0	M8	8	50	3,5
532135	K20	112	-	16	M12x25	9,0	9,0	M12	8	80	-
532150	K20	112	-	16	M12x25	11,5	11,25	M12	8	80	-
532176	K20	112	25	16	M12x25	11,5	11,25	M12	8	80	5,5
532192	K20	112	25	16	M12x55	11,5	11,25	M12	8	80	5,5
532218	K20	112	25	16	M12x55	11,5	11,25	M12	8	80	5,5
532234	K20	112	25	16	M12x55	11,5	11,25	M12	8	80	5,5
532242	K20	112	25	16	M12x55	11,5	11,25	M12	8	80	5,5

Subject to technical alterations.

No. 6210IFR

Base element, with indexing for grid plates

NEW!

Order no.	Size	H ±0.01	Weight [g]
532424	M12	30	2018
532440	M16	40	3881

Application:

The main element with indexing is positioned on grid plates M12 and M16 via a centering sleeve and then bolted. Intermediate elements or assembly elements can be adapted.
This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.

Advantage:

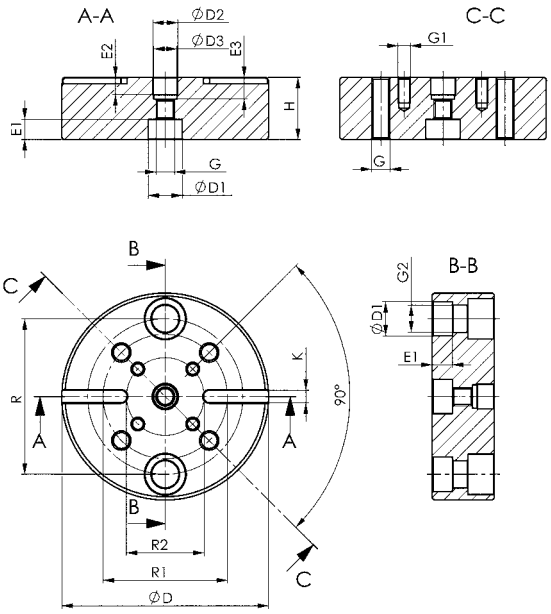
Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

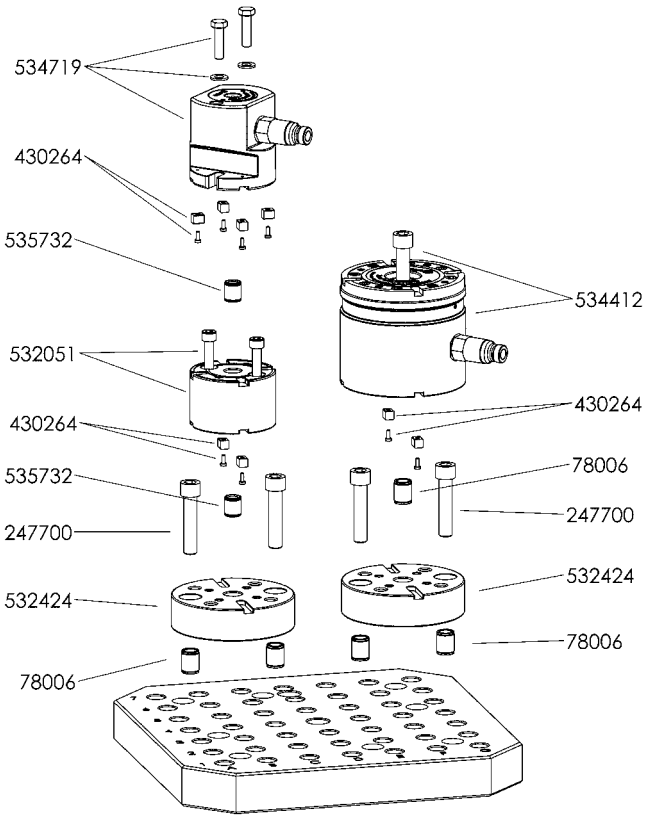
Note:

Order numbers for the centering sleeves:
- Ø15: Order no. 535732
- Ø16: Order no. 78006
- Ø22: Order no. 78238

Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	dia. D3	E1	E2	E3	G	G1	G2	K F6	R	R1	R2
532424	M12	112	16	16	15	9	11	14	M12	M8	M12	8	80	80	50
532440	M16	133	22	16	15	13	11	14	M12	M8	M16	8	100	80	50





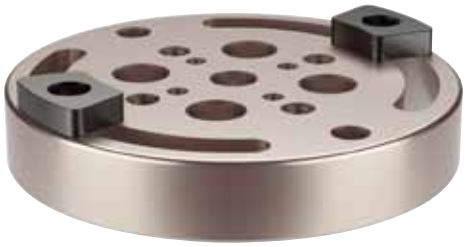
CAD

Subject to technical alterations.

No. 6210FN

Base element for T-grooved plate

NEW!



Order no.	Size	H ±0.01	Weight [g]
532465	M12	30	3681

Application:

The main element can be freely positioned and fastened on the grooved machine table at the circumferential clamping edge. Intermediate elements or assembly elements can be adapted. This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.

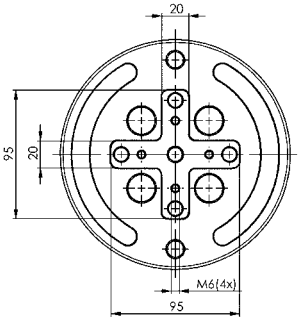
Advantage:

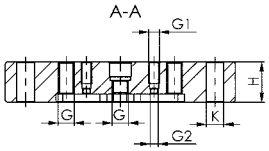
Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

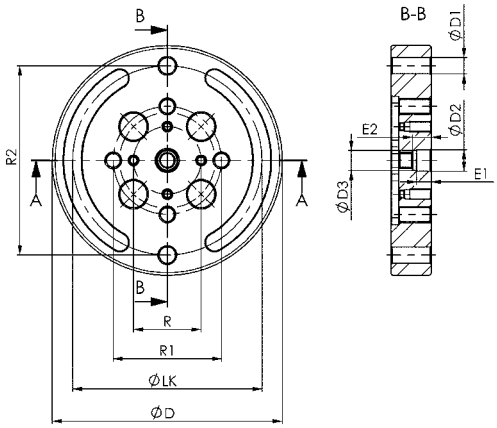
Note:

Centering sleeves:
- Ø15: Order no. 535732
- Ø16: Order no. 78006
- Ø22: Order no. 78238

Curved washer:
Order no. 535757.
T-nut no. 6322A with ISO 4762, M6x10 socket head screws can be used for positioning on a grooved plate.

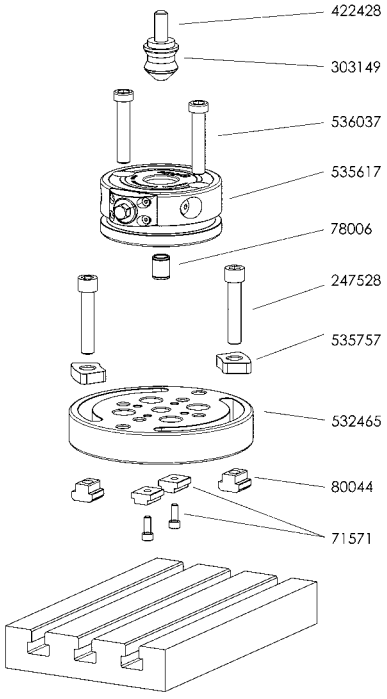






Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	dia. D3	E1	E2	G	G1	G2	K	dia. LK	R	R1	R2
532465	M12	170	12	16	15	11	14	M12	M8	M6	13	140	50	80	140



CAD

Subject to technical alterations.

No. 6210FN-M12-01

Spring washer for groove adapter

NEW!

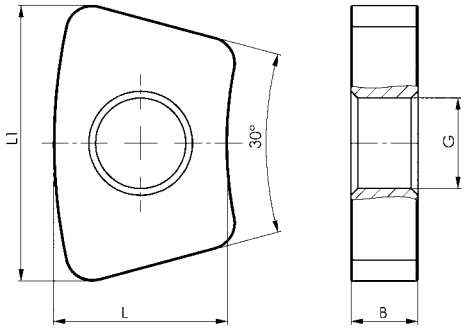
Order no.	Size	Weight [g]
535757	M12	62

Application:

The spring washer is used to securely fasten the base element for T-grooved plates with M12 cheese head screws onto the machine table.

Note:

Suitable for base element for T-grooved plate Order no. 532465



Dimensions:

Order no.	Size	B	G	L	L1
535757	**M12**	10	M12	26	41

Subject to technical alterations.

Subject to technical alterations.

No. 6210A-20-10

Adapter reduction from K20 to K10

Order no.	Size	H ±0.01	Weight [g]
534750	**K20 - K10**	50	2923

NEW!

Application:

The adapter element is used to reduce the intermediate element size K20 and K10.3 to size K10. Intermediate elements or assembly elements can be adapted.
This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.

Advantage:

Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

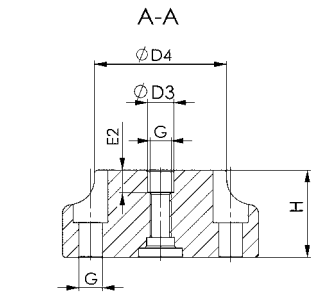
Note:

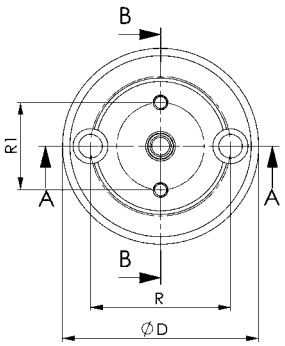
Order numbers for the centering sleeves:
- Ø15: Order no. 535732
- Ø16: Order no. 78006
- Ø22: Order no. 78238

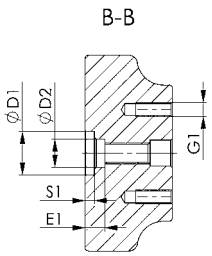
The fastening screws are supplied as standard.

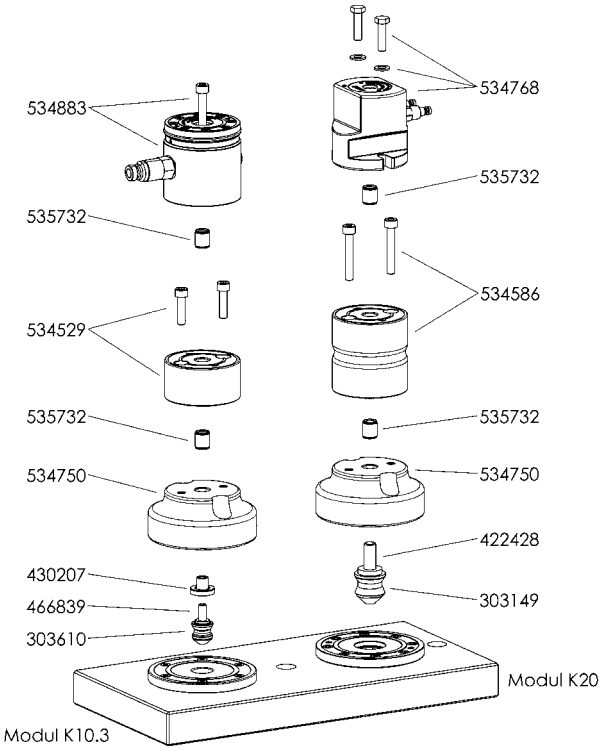
Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	dia. D3	dia. D4	Screw DIN84 or ISO4762	E1	E2	G	G1	R	R1	S1
534750	**K20 - K10**	112	25	16	15	78	M12x50	11,5	13	M12	M8	80	50	5,5









CAD

Subject to technical alterations.

No. 6210IA-20-10

Adapter reduction from K20 to K10, with indexing

NEW!

Order no.	Size	H ±0.01	Weight [g]
532499	**K20 - K10**	50	2892

Application:

The adapter element with indexing is used to reduce the intermediate element size K20 and K10.3 to size K10. Intermediate elements or assembly elements can be adapted.
This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.
Thanks to the 4-point 90° indexing option, workpieces under strong machining forces can be secured to prevent radial distortion.

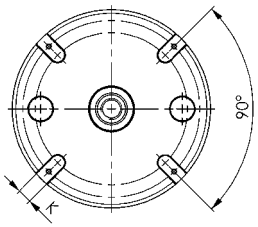
Advantage:

Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

Note:

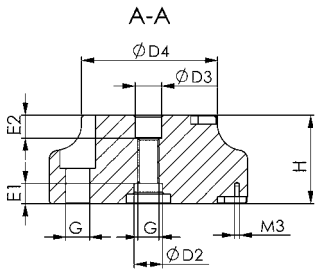
Order numbers for the centering sleeves:
- Ø15: Order no. 535732
- Ø16: Order no. 78006
- Ø22: Order no. 78238

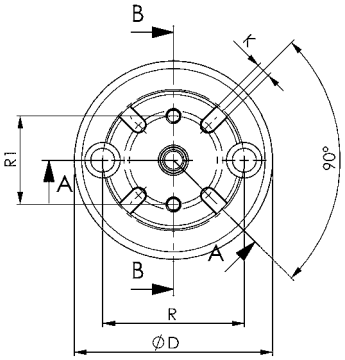
Slot nuts: Order no. 430264.

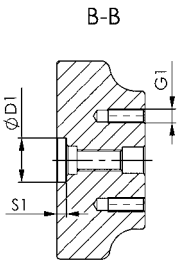


Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	dia. D3	dia. D4	Screw DIN84 or ISO4762	E1	E2	G	G1	K F6	R	R1	S1
532499	**K20 - K10**	112	25	16	15	78	M12x50	9	13	M12	M8	8	80	50	5,5







CAD

Subject to technical alterations.

No. 6210H-10-05

Adapter clamping module K5, hydr. to K10

NEW!

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [g]
534776	K05	5	13	2328

Application:

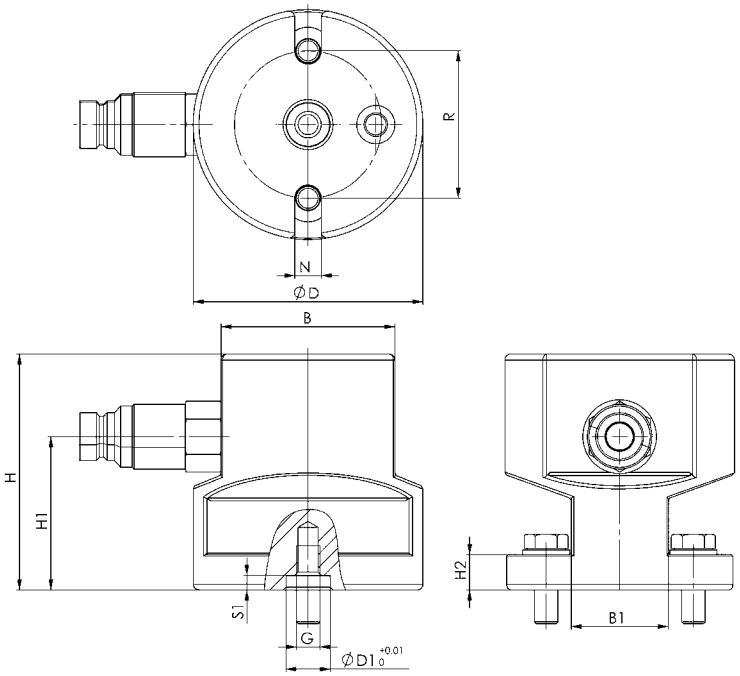
The adapter element is used to reduce the intermediate element size K10 to the hydraulic clamping module K5. Workpieces or fixtures can be clamped with repeat accuracy directly onto the hydraulic clamping module K5 via clamping nipples.
This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.

Advantage:

Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

Note:

Order no. for the centering sleeve Ø 16 mm: 78006
The hydr. quick-release coupling, connector version, and the fastening screws are supplied as standard.



Dimensions:

Order no.	Size	B	B1	dia. D	dia. D1	G	H ±0.01	H1	H2	N	R	S1
534776	K05	59	33	78	15	M8	80	52	12	8	50	5

CAD

Subject to technical alterations.

No. 6210IH-10-05

Adapter clamping module K5, hydr. to K10, with indexing

NEW!

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [g]
534719	K05	5	13	2318

Application:

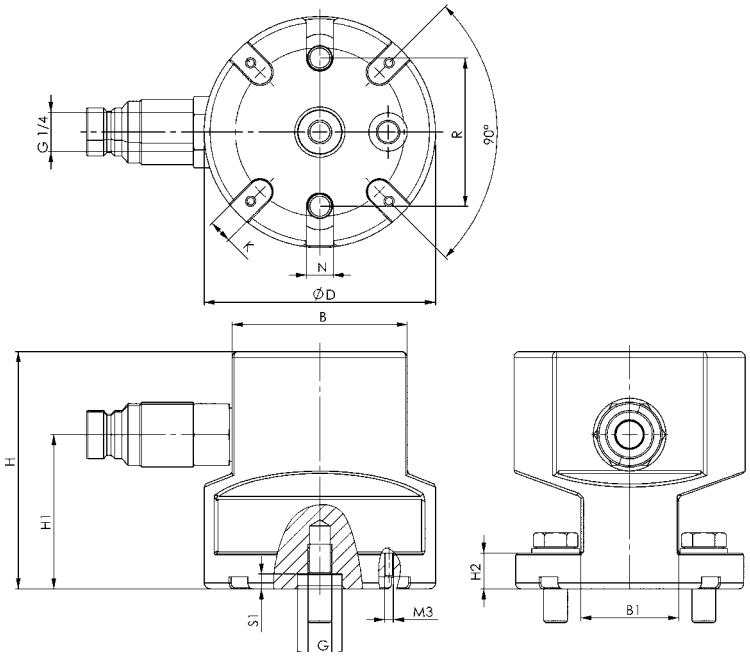
The adapter element is used to reduce the intermediate element size K10 to the hydraulic clamping module K5. Workpieces or fixtures can be clamped with repeat accuracy directly onto the hydraulic clamping module K5 via clamping nipples.
This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.
Thanks to the indexing option, workpieces under large machining forces can be secured to prevent radial distortion.

Advantage:

Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

Note:

Order no. for the centering sleeve Ø 16 mm: 78006
Order no. for the slot nuts: 430264
The hydr. quick-release coupling, connector version, and the fastening screws are supplied as standard.



Dimensions:

Order no.	Size	B	B1	dia. D	dia. D1	G	H ±0.01	H1	H2	K F6	N	R	S1
534719	K05	59	33	78	15	M8	80	52	12	8	9	50	5

CAD

Subject to technical alterations.

No. 6210L-10-05

Adapter clamping module K5, pneum. to K10

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [g]
534768	K05	1,5	13	2272

NEW!

Application:

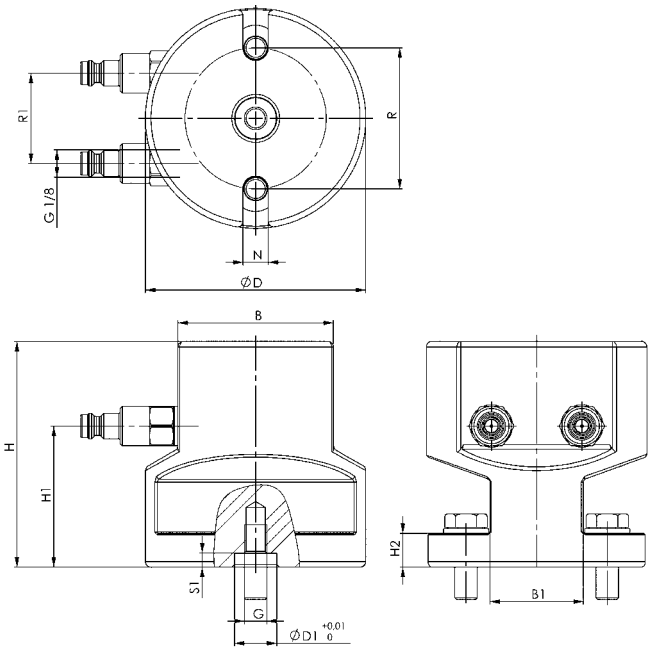
The adapter element is used to reduce the intermediate element size K10 to the pneumatic clamping module K5. Workpieces or fixtures can be clamped with repeat accuracy directly onto the pneumatic clamping module K5 via clamping nipples.
This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.

Advantage:

Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

Note:

Order no. for the centering sleeve Ø 16 mm: 78006
The pneum. quick-release coupling, connector version, and the fastening screws are supplied as standard.



Dimensions:

Order no.	Size	B	B1	dia. D	dia. D1	G	H ±0.01	H1	H2	N	R	R1	S1
534768	K05	59	33	78	15	M8	80	52	12	9	50	32	5

CAD

Subject to technical alterations.

No. 6210IL-10-05

Adapter clamping module K5, pneum. to K10, with indexing

NEW!

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [g]
532853	K05	1,5	13	2248

Application:

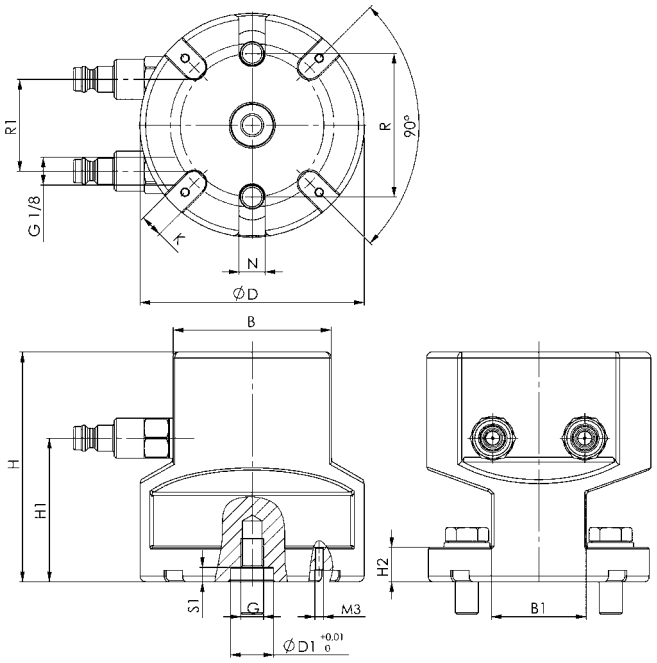
The adapter element is used to reduce the intermediate element size K10 to the pneumatic clamping module K5. Workpieces or fixtures can be clamped with repeat accuracy directly onto the pneumatic clamping module K5 via clamping nipples.
This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.
Thanks to the indexing option, workpieces under large machining forces can be secured to prevent radial distortion.

Advantage:

Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

Note:

Order no. for the centering sleeve Ø 16 mm: 78006
Order no. for the slot nuts: 430264
The pneum. quick-release coupling, connector version, and the fastening screws are supplied as standard.



Dimensions:

Order no.	Size	B	B1	dia. D	dia. D1	G	H ±0.01	H1	H2	K F6	N	R	R1	S1
532853	K05	59	33	78	15	M8	80	52	12	8	9	50	32	5

CAD

Subject to technical alterations.

No. 6210H

Assembly element K10 and K20, hydraulic

NEW!

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [g]
534883	K10	10	25	2835
534800	K20	20	55	7311

Application:

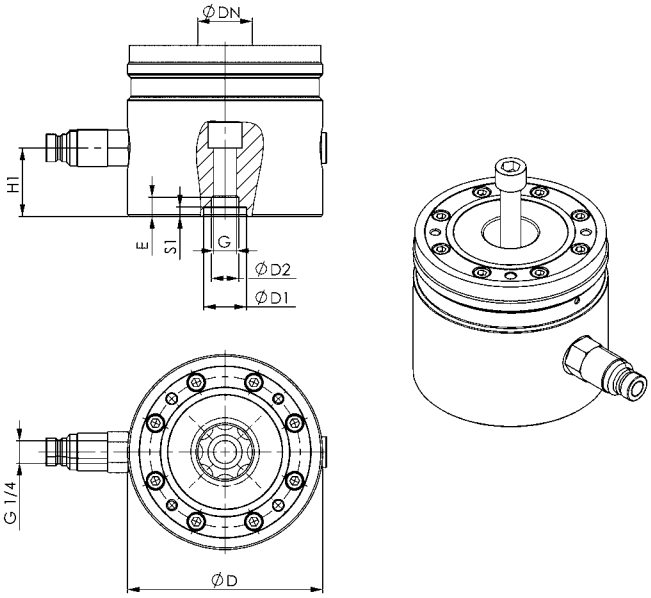
The assembly element is used to clamp with repeat accuracy workpieces or fixtures directly onto the hydraulic clamping modules K10 or K20 via clamping nipples.
This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.

Advantage:

Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

Note:

Order no. for the centering sleeve Ø 16 mm: 78006
The hydr. quick-release coupling, connector version, and the fastening screw are supplied as standard.



Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	dia. DN	E	G	H ±0.01	H1	S1
534883	K10	80	-	15	22	5,0	M8	80	35	-
534800	K20	114	25	16	32	11,25	M12	100	40	5,5

CAD

Subject to technical alterations.

No. 6210IH

Assembly element K20, hydraulic, with indexing

NEW!

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [g]
534412	K20	20	55	7154

Application:

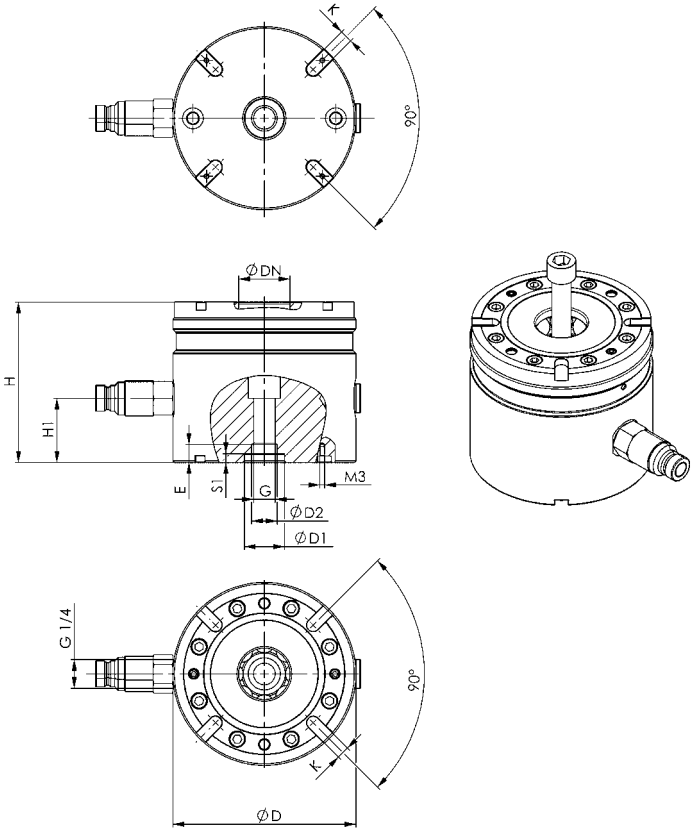
The assembly element is used to clamp with repeat accuracy workpieces or fixtures directly onto the hydraulic clamping module K20 with 4-point indexing via clamping nipples.
This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.

Advantage:

Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

Note:

Order no. for the centering sleeve Ø 16 mm: 78006
Order no. for the slot nuts: 430264
The hydr. quick-release coupling, connector version, and the fastening screw are supplied as standard.



Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	dia. DN	E	G	H ±0.01	H1	K F6	S1
534412	K20	114	25	16	32	11,25	M12	100	40	8	5,5

CAD

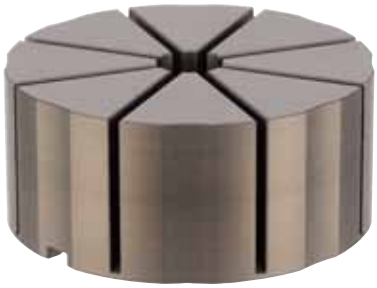
Subject to technical alterations.

No. 6370ZSZ-112

Collet attachment for clamping module K20, hydr.

NEW!

Order no.	dia. D	dia. D1	Clamping stroke Ø [mm]	H	Weight [g]
550286	112	20	0,5	50	1133

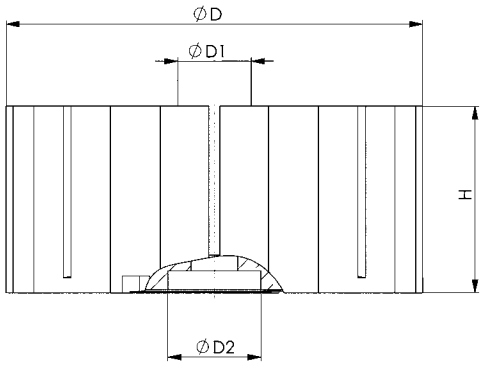


Design:

The 112 mm collet attachment is suitable for the AMF Zero Point system K20 hydraulic with indexing with order no. 428425. The collet attachment is made from anodised, high-strength aluminium.

Application:

The collet is attached to the AMF Zero Point clamping system K20 in the hydraulic version and guides the radial clamping force to the workpiece after the clamping module is closed.
The workpiece contour is milled into the collet with a minimum clamping depth of 2 mm.
The collet can be milled off to 25 mm, allowing new workpiece contours to be introduced.
The maximum workpiece diameter is 100 mm.



No. 6370ZSB

Mounting kit for collet attachment

NEW!

Order no.	Size	Weight [g]
550287	K20	190

Design:

The mounting set comprises:
- 1 pce. clamp nipple K20, version: Zero Point
- 1 pce. capture nipple screw K20
- 1 pce. counter nut M12
- 2 pce. indexing slot nut, width 8 mm

Application:

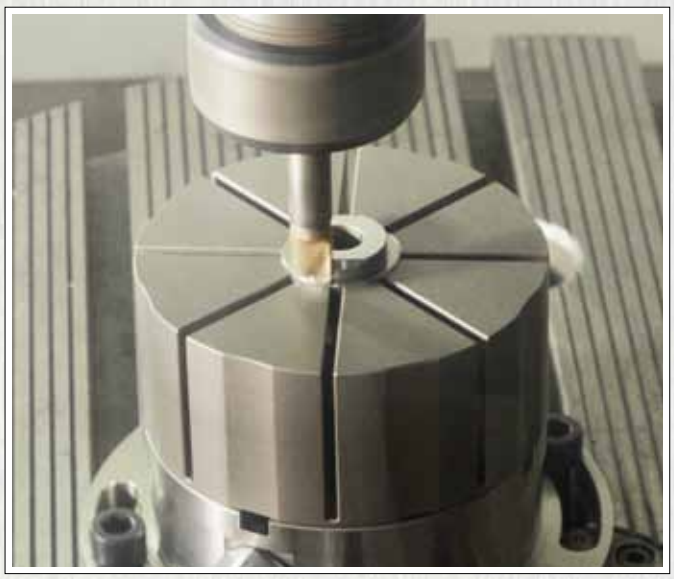
The mounting set is installed with the 112 mm collet attachment, order no. 550286.
After installation, the collet can be securely and hydraulically clamped on the AMF clamping module, size K20.

Subject to technical alterations.

Collet attachment for clamping module K20, hydr.
Code 550286

Mounting kit for collet attachment
Code 550287

Assembly element K20, hydraulic, with indexing
Code 534412



Technische Änderungen vorbehalten.

No. 6210L

Assembly element K10, K10.3 and K20, pneumatic

NEW!

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [g]
534925	K10	8	25	2720
534537	K10.3	10	25	7708
534842	K20	17	55	7185

Application:

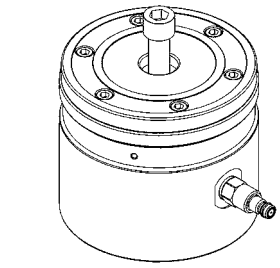
The assembly element is used to clamp with repeat accuracy workpieces or fixtures directly onto the pneumatic clamping modules K10, K10.3 and K20 via clamping nipples.
This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.

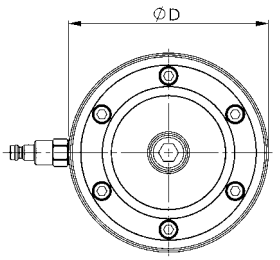
Advantage:

Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

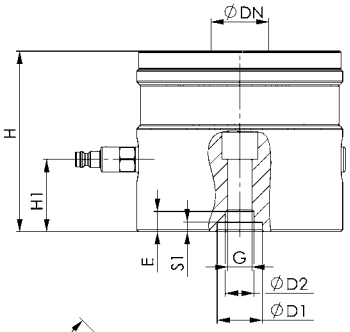
Note:

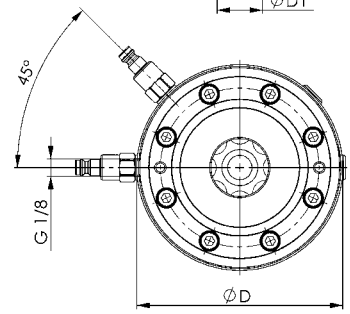
Order no. for the centering sleeve Ø 16 mm: 78006
The pneum. quick-release coupling, connector version, and the fastening screw are supplied as standard.





K10, K10.3





K20.3

Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	dia. DN	E	G	H ±0.01	H1	S1
534925	K10	80	-	15	22	5,0	M8	77	35	-
534537	K10.3	114	25	16	22	11,25	M12	100	40	5,5
534842	K20	114	25	16	32	11,25	M12	100	40	5,5

CAD

Subject to technical alterations.

No. 6210IL

Assembly element K10.3 and K20, pneumatic, with indexing

NEW!

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [g]
534495	K10.3	10	25	7668
534453	K20	17	55	7162

Application:

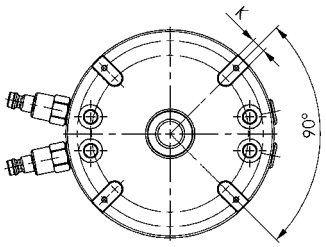
The assembly element is used to clamp with repeat accuracy workpieces or fixtures directly onto the pneumatic clamping modules K10.3 and K20 via clamping nipples.
This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.
Thanks to the 4-point 90° indexing option, workpieces under strong machining forces can be secured to prevent radial distortion.

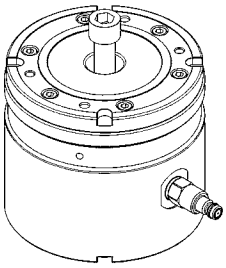
Advantage:

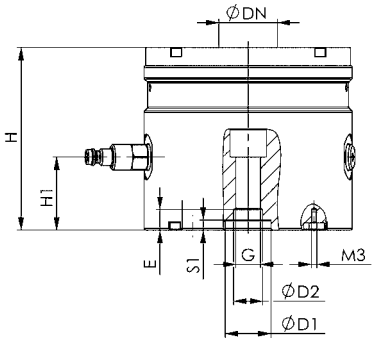
Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

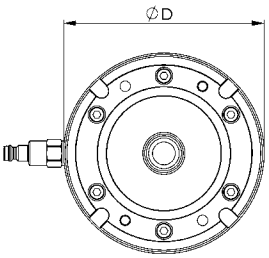
Note:

Order no. for the centering sleeve Ø 16 mm: 78006
Order no. for the slot nuts: 430264
The pneum. quick-release coupling, connector version, and the fastening screw are supplied as standard.

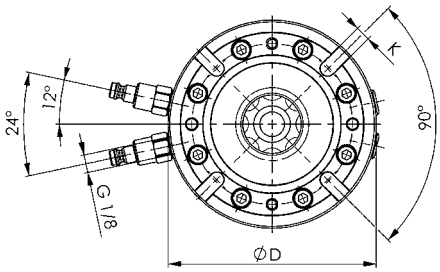








K10.3



K20.3

Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	dia. DN	E	G	H ±0.01	H1	K F6	S1
534495	K10.3	114	25	16	22	11,25	M12	100	40	8	5,5
534453	K20	114	25	16	32	11,25	M12	100	40	8	5,5

CAD

Subject to technical alterations.

No. 6210S

Support element, fixed

NEW!

Order no.	Size	H ±0.01	Weight [g]
532390	K10	100	995
532374	K20	100	1790

Application:

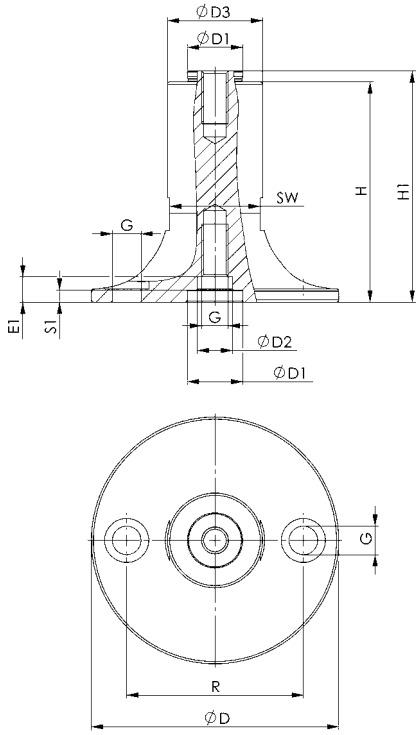
The support element allows workpieces or fixtures to be received into the bore for the clamping nipple, K10 or K20 depending on the version, and clamped to the main or intermediate elements. This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.

Advantage:

Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

Note:

Order numbers for the centering sleeves:
- Ø15: Order no. 535732
- Ø16: Order no. 78006
- Ø22: Order no. 78238



Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	dia. D3	E1	G	H1	R	S1	SW
532390	K10	78	15	15	35	4,5	M8	103	50	5	30
532374	K20	112	25	16	43	12,0	M12	105	80	6	41

Subject to technical alterations.

No. 6210S

Support element, adjustable ± 5 mm

NEW!

Order no.	Size	H ±0.01	Weight [g]
532416	K10	95-105	974
532432	K20	95-105	2020

Application:

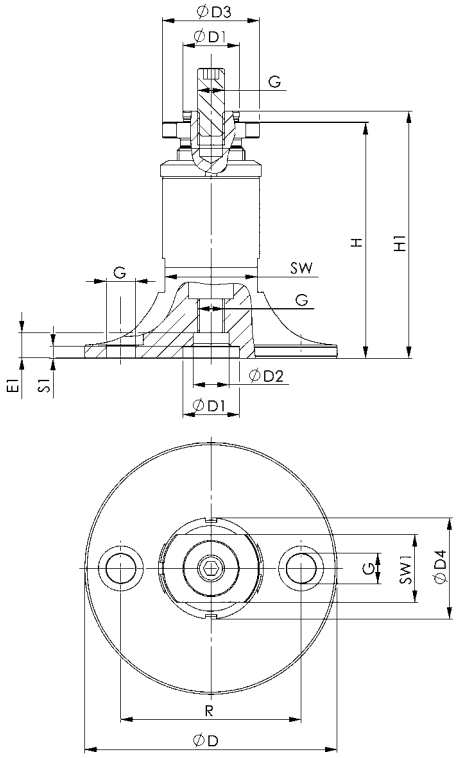
The adjustable support element allows workpieces or fixtures to be received into the bore for the clamping nipple, K10 or K20 depending on the version, and clamped to the main or intermediate elements. Thanks to the adjustment and counter option, the support element can be steplessly adapted to the workpiece contour by ± 5 mm.
This clamping system can be used to move workpieces to the required machining height in the machine for 5-sided machining, or for the safe and quick clamping of workpieces with ledges and different clamping heights on the machine table.

Advantage:

Simple, quick and flexible clamping of complex workpiece contours on the machine table. Especially suitable for levelling workpieces or clamping fixtures at the necessary machine heights in the machine tool and for the reliable clamping of same.

Note:

Order numbers for the centering sleeves:
- Ø15: Order no. 535732
- Ø16: Order no. 78006
- Ø22: Order no. 78238



Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	dia. D3	dia. D4	E1	G	H1	R	S1	SW	SW1
532416	K10	78	15	15	35	38	4,5	M8	98-108	50	4,5	30	27
532432	K20	112	25	16	43	45	11,5	M12	100-110	80	5,5	41	30

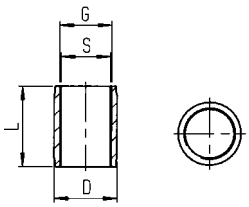
Subject to technical alterations.

No. 6363-**-005

Centring sleeve, cylindrical

Order no.	Size	dia. D	G	L -0.2	dia. S	Weight [g]
78006	12	16 +0,011/0	R1/4	20,5	12,5	9
78238	16	22 +0,015/+0,002	M18	23	16,5	25

CAD

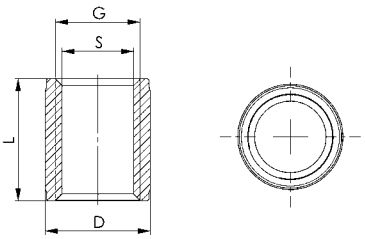


No. 6210-15-01

Centering sleeve Ø 15

Order no.	Size	ØD +0.011/0	G	L -0.2	dia. S	Weight [g]
535732	15	15	M12	17,4	10,1	12

CAD



No. 6210-XX

Centring pin

NEW!

Order no.	dia. D	dia. D1	dia. D2	L	L1	Weight [g]
550198	22	15	8,5	20	14	28
550197	32	16	12,5	18	11	44

Application:

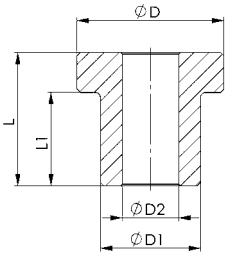
To position the double clamping modules on a clamping plate with clearance holes or a foot element from the „Modular height adapter“ AMF clamping system.

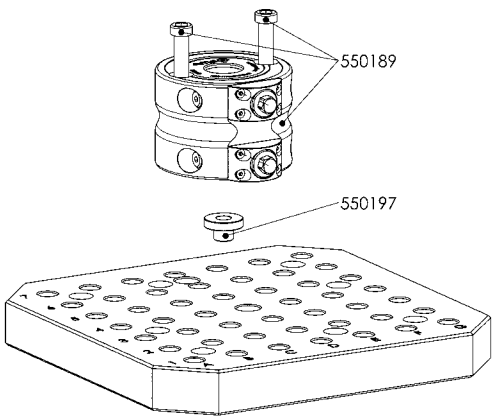
Advantage:

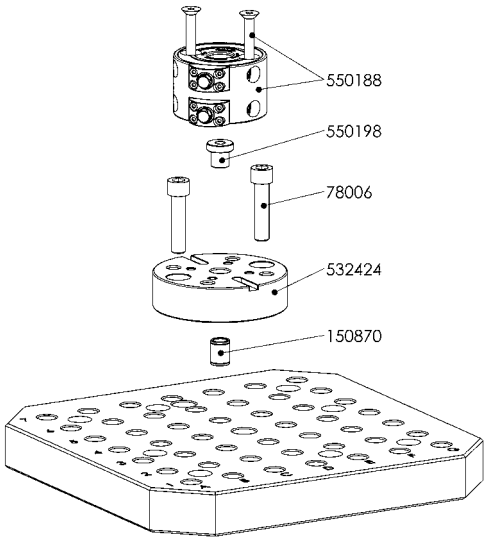
Highly-precise positioning of the double clamping module.

Note:

The centring pin is used when the double clamping module is not yet positioned with a clamping nipple for T-groove and can be clamped.







Subject to technical alterations.

The module interior is completely sealed. As a result, the system is optimally protected against liquids and dirt.

Subject to technical alterations.

No. 6208M

Clamping module, mechanical

Mechanical opening and closing.
Quenched and tempered steel, plasma-nitrated.
Repeat accuracy 0.01 mm.

NEW!

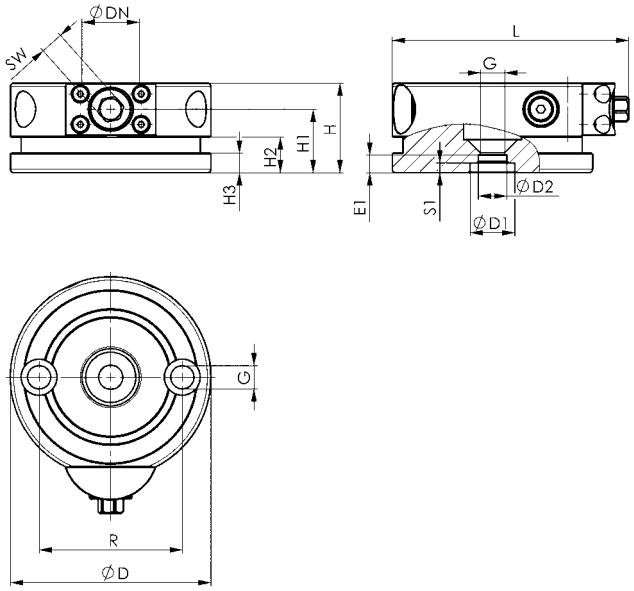
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Tightening torque [Nm]	Weight [g]
546085	K10	6	25	30	1064
535617	K20	10	55	30	3330

Application:

Mechanical zero point clamping system for time-optimised clamping during cutting and non-cutting machining. Especially suitable for the modular design of clamping solutions via zero point clamping system.

Note:

The mechanical assembly clamping module has high retention, insertion and closing forces.
The clamping module can be positioned on the machine table and fastened via mechanical clamping elements at the circumferential clamping edge.
The positioning bore for marking sleeves and a through bore for fastening via M12 countersunk screw on the grid pallets are provided on the underside. The locating bore for the K20 clamping nipple is also already made in the module.
Clamping nipple:
With this mechanical clamping module, the K10 and/or K20 versions of the clamping nipples are used. The zero point, timing or undersize nipple can be used, depending on application.
This clamping module can be used at ambient temperatures of up to max. 200°C.



Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	dia. DN	E1	G	H ±0.01	H1	H2	H3	L	R	S1	SW
546085	K10	78	15	15	22	4,5	M8	32	22	-	-	93	50	-	10
535617	K20	112	25	16	32	10	M12	50	36	20	11	132	80	5,5	13

CAD

Subject to technical alterations.

No. 6208IM

Clamping module, mechanical, with indexing

Mechanical opening and closing.
Quenched and tempered steel, plasma-nitrated.
Repeat accuracy 0.01 mm.

NEW!

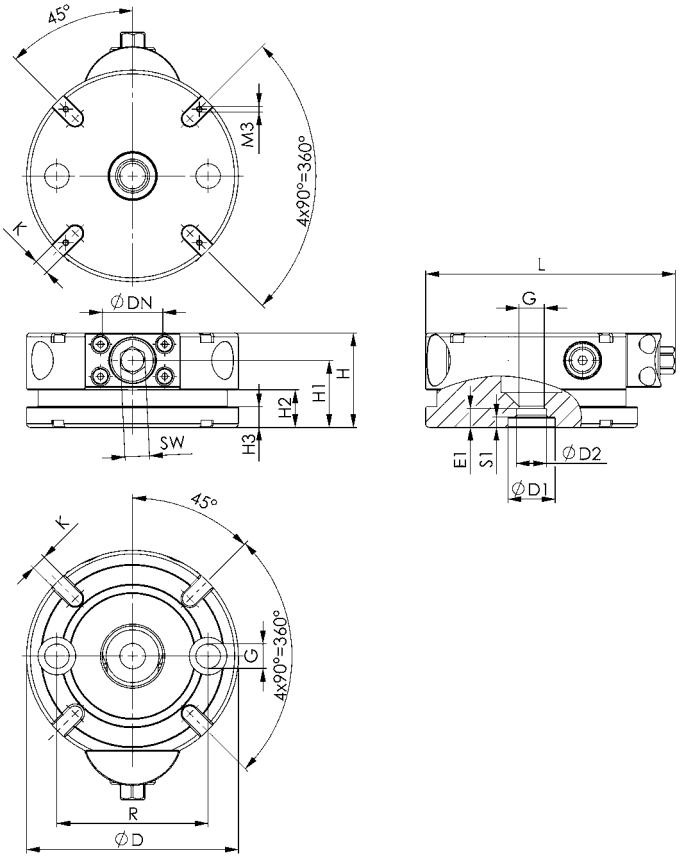
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Tightening torque [Nm]	Weight [g]
546697	K10	6	25	30	1031
535633	K20	10	55	30	3295

Application:

Mechanical zero point clamping system with indexing grooves offset by 90° for time-optimised clamping during cutting and non-cutting machining.
Especially suitable for the modular design of clamping solutions via zero point clamping system.

Note:

The mechanical assembly clamping module with indexing grooves offset by 90° has high retention, insertion and closing forces.
The clamping module can be positioned on the machine table and fastened via mechanical clamping elements at the circumferential clamping edge.
The positioning bore for marking sleeves and a through bore for fastening via M12 countersunk screw on the grid pallets are provided on the underside. The locating bore for the K20 clamping nipple is also already made in the module.
Clamping nipple:
With this mechanical clamping module, the K10 and/or K20 versions of the clamping nipples are used. The zero point, timing or undersize nipple can be used, depending on application.
This clamping module can be used at ambient temperatures of up to max. 200°C.



Dimensions:

Order no.	Size	dia. D	dia. D1	dia. D2	dia. DN	E1	G	H ±0.01	H1	H2	H3	K F6	L	R	S1	SW
546697	K10	78	15	15	22	4,5	M8	32	22	-	-	8	93	50	-	10
535633	K20	112	25	16	32	10,0	M12	50	35,5	20	11	8	132	80	5,5	13

CAD

Subject to technical alterations.

No. 6208MD

Double clamping module, mechanical

Mechanical opening and closing.
Quenched and tempered steel, plasma-nitrated.
Repeat accuracy 0.01 mm.

NEW!

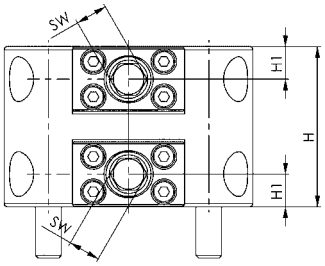
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Tightening torque [Nm]	Weight [Kg]
550188	K10	6	25	30	1,6
550189	K20	10	55	30	5,1

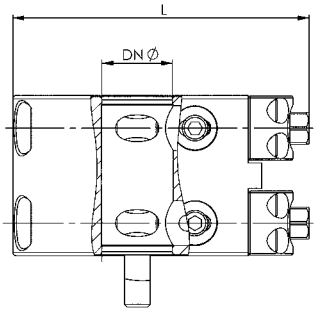
Application:

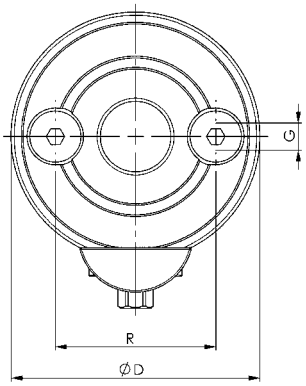
Mechanical „double clamping module“ for setting time-optimised clamping during cutting and non-cutting machining. Especially suitable for the modular design of clamping solutions via zero point clamping system.

Note:

This clamping system combines two separately operable mechanical zero point clamping systems. In conjunction with the clamping nipple for T-grooves, this clamping module is simply and quickly fastened to the machine table via clamping grooves. Further height adapters, workpieces or fixtures can be fastened to the top via clamping nipples.
Clamping nipple:
With this mechanical clamping module, the K10 and/or K20 versions of the clamping nipples are used. The zero point, timing or undersize nipple can be used, depending on application.
This clamping module can be used at ambient temperatures of up to max. 200°C.

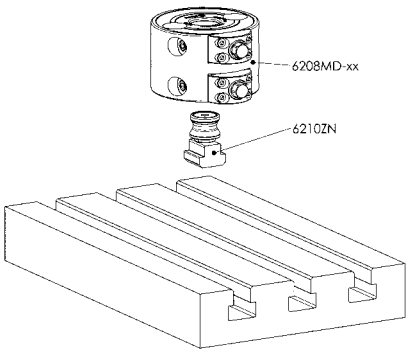


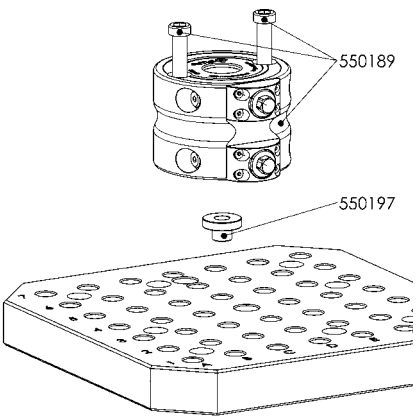


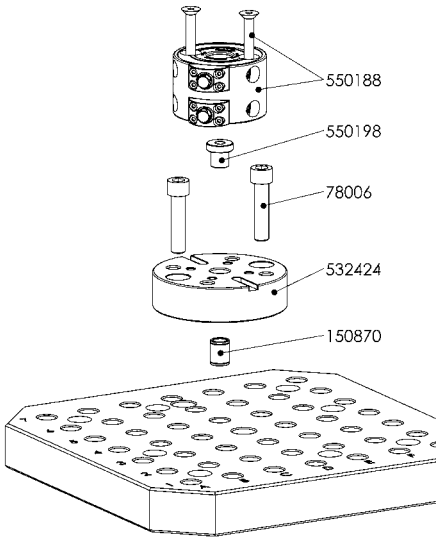


Dimensions:

Order no.	Size	dia. D	dia. DN	G	H ±0.01	H1	L	R	SW
550188	K10	77,5	22	M8	50	10,2	92	50	10
550189	K20	112,0	32	M12	80	15,0	132	80	13







Subject to technical alterations.

No. 6210ZN

Clamping nipple for T-grooves

NEW!

Order no.	Size	A	dia. DN	G	H	L	Weight [g]
550438	K10	10	22	M8	16	30	48
550439	K10	12	22	M8	16	35	51
550440	K10	14	22	M8	16	35	54
550441	K20	14	32	M12	23	45	143
550442	K20	16	32	M12	23	45	147
550443	K20	18	32	M12	23	50	157

Application:

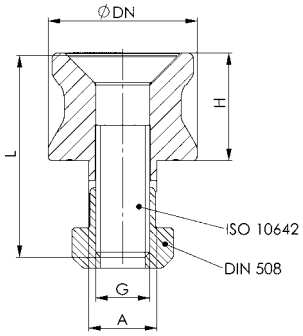
The clamping nipple for T-grooves enables the AMF zero point clamping system to be positioned and clamped directly to the machine table by means of clamping grooves.
These clamping nipples can be used for pneumatic, hydraulic and mechanical clamping modules, and also for mechanical double clamping modules.

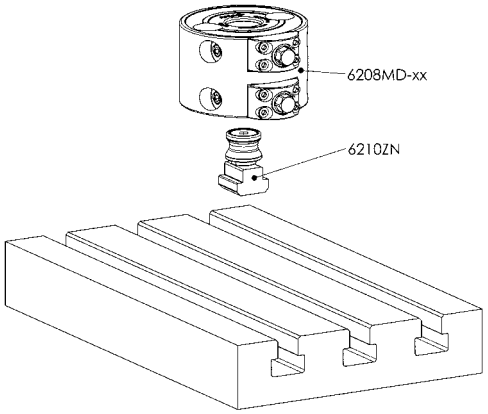
Advantage:

Simple, quick and flexible clamping of workpieces on the machine table with varying clearances of the clamping nipple bores.

Note:

The supply scope contains, as shown:
- Zero point clamping nipple with groove (dimension A)
- T-nut
- countersunk screw (resistance class 10.9)





Subject to technical alterations.

No. 6203ZN-02

Clamping nipple for clamping modules K02

Hardened, for pneumatic clamping module no. 6203L.

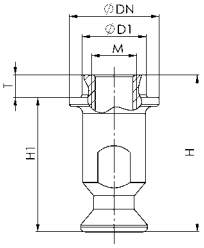
EDELSTAHL Rostfrei STAINLESS STEEL

CAD

Order no.	Size	dia. DN	dia. D1	H	H1	M	T	Weight [g]
427302	K02	10,0	7,14	17,5	15	M5	2,5	4
427328	K02	10,0	7,14	17,5	15	M5	2,5	4
427344	K02	9,95	7,14	17,5	15	M5	2,5	4

Design:

Order no. 427302: Zero point nipple
Order no. 427328: Timing nipple
Order no. 427344: Undersized nipple



No. 6370ZN-5

Clamping nipple for clamping modules K5

Hardened, for hydraulic and pneumatic clamping modules size K5.

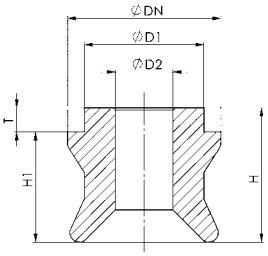
EDELSTAHL Rostfrei STAINLESS STEEL

CAD

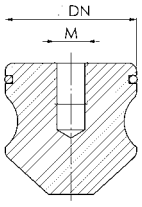
Order no.	Size	dia. DN	dia. D1	dia. D2	H	H1	M	T	Weight [g]
306019	K 5	15,0	10	6	12,7	10,2	-	2,5	15
306035	K 5	15,0	10	6	12,7	10,2	-	2,5	15
306050	K 5	14,8	10	6	12,7	10,2	-	2,5	15
306076	K 5	14,8	-	-	-	-	M 6	-	12

Design:

Order no. 306019: Zero point nipple
Order no. 306035: Timing nipple
Order no. 306050: Undersized nipple
Order no. 306076: Protection nipple



306019, 306035, 306050



306076

No. 6370ZN-10

Clamping nipple for clamping modules K10

Hardened, for hydraulic and pneumatic clamping modules size K10.

EDELSTAHL Rostfrei STAINLESS STEEL

CAD

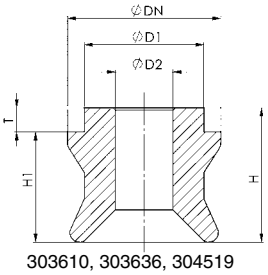
Order no.	Size	dia. DN	dia. D1	dia. D2	H	H1	M	T	Weight [g]
303610	K10	22,0	15	8	19	16	-	3	30
303636	K10	22,0	15	8	19	16	-	3	30
304519	K10	21,8	15	8	19	16	-	3	30
304535	K10	21,8	-	-	-	-	M 8	-	30

Design:

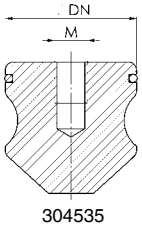
Order no. 303610: Zero point nipple
Order no. 303636: Slit nipple
Order no. 304519: Undersized nipple
Order no. 304535: Protection nipple

Note:

The slit nipple has an additional auxiliary bore, which can be optionally used for simple installation.



303610, 303636, 304519



304535

Subject to technical alterations.

No. 6370ZN-10

Clamping nipple with colour marking for clamping module K10

Hardened, for clamping modules size K10.

EDELSTAHL Rostfrei STAINLESS STEEL

NEW!

CAD

Order no.	Size	dia. DN	dia. D1	dia. D2	H	H1	T	Weight [g]
430280	K10	22,0	15	8	19	16	3	30
430306	K10	22,0	15	8	19	16	3	30

Design:

Extremely wear-resistant surface coating.
Order no. 430280: Zero point nipple „Gold“, Order no. 430306: Timing nipple „Black“.

Application:

For simple, visual differentiation of the various clamping nipple types.

Note:

The slit nipple has an additional auxiliary bore, which can be optionally used for simple installation.

No. 6370ZN-20

Clamping nipple for clamping modules K20

Hardened, for hydraulic and pneumatic clamping modules size K20.

EDELSTAHL Rostfrei STAINLESS STEEL

CAD

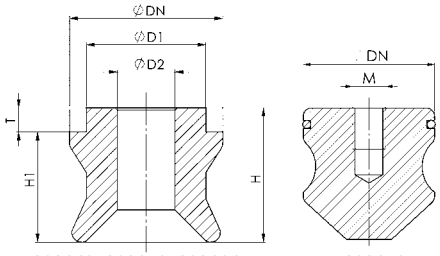
Order no.	Size	dia. DN	dia. D1	dia. D2	H	H1	M	T	Weight [g]
303149	K20	32,0	25	12	28	23	-	5	110
303156	K20	32,0	25	12	28	23	-	5	110
303164	K20	31,8	25	12	28	23	-	5	110
303172	K20	31,8	-	-	-	-	M 8	-	110

Design:

Order no. 303149: Zero point nipple
Order no. 303156: Slit nipple
Order no. 303164: Undersized nipple
Order no. 303172: Protection nipple

Note:

The slit nipple has an additional auxiliary bore, which can be optionally used for simple installation.



303149, 303156, 303164 303172

No. 6370ZN-20

Clamping nipple with colour marking for clamping module K20

Hardened, for clamping module size K20.

EDELSTAHL Rostfrei STAINLESS STEEL

NEW!

CAD

Order no.	Size	dia. DN	dia. D1	dia. D2	H	H1	T	Weight [g]
430322	K20	32,0	25	12	28	23	5	110
430348	K20	32,0	25	12	28	23	5	110

Design:

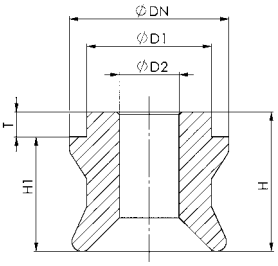
Extremely wear-resistant surface coating.
Order no. 430322: Zero point nipple „Gold“, Order no. 430348: Slit nipple „Black“

Application:

For simple, visual differentiation of the various clamping nipple types.

Note:

The slit nipple has an additional auxiliary bore, which can be optionally used for simple installation.



Subject to technical alterations.

Clamping nipple for clamping modules

No. 6370ZN-40

Clamping nipple for clamping modules K40

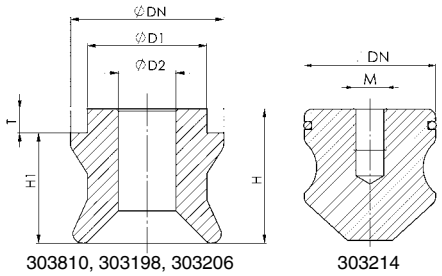
Hardened, for hydraulic and pneumatic clamping modules size K40.

EDELSTAHL Rostfrei
STAINLESS STEEL

Order no.	Size	dia. DN	dia. D1	dia. D2	H	H1	M	T	Weight [g]
303180	K40	40,0	25	16	34	29	-	5	180
303198	K40	40,0	25	16	34	29	-	5	180
303206	K40	39,8	25	16	34	29	-	5	180
303214	K40	39,8	-	-	-	-	M 8	-	180

Design:

Order no. 303180: Zero point nipple
Order no. 303198: Timing nipple
Order no. 303206: Undersized nipple
Order no. 303214: Protection nipple



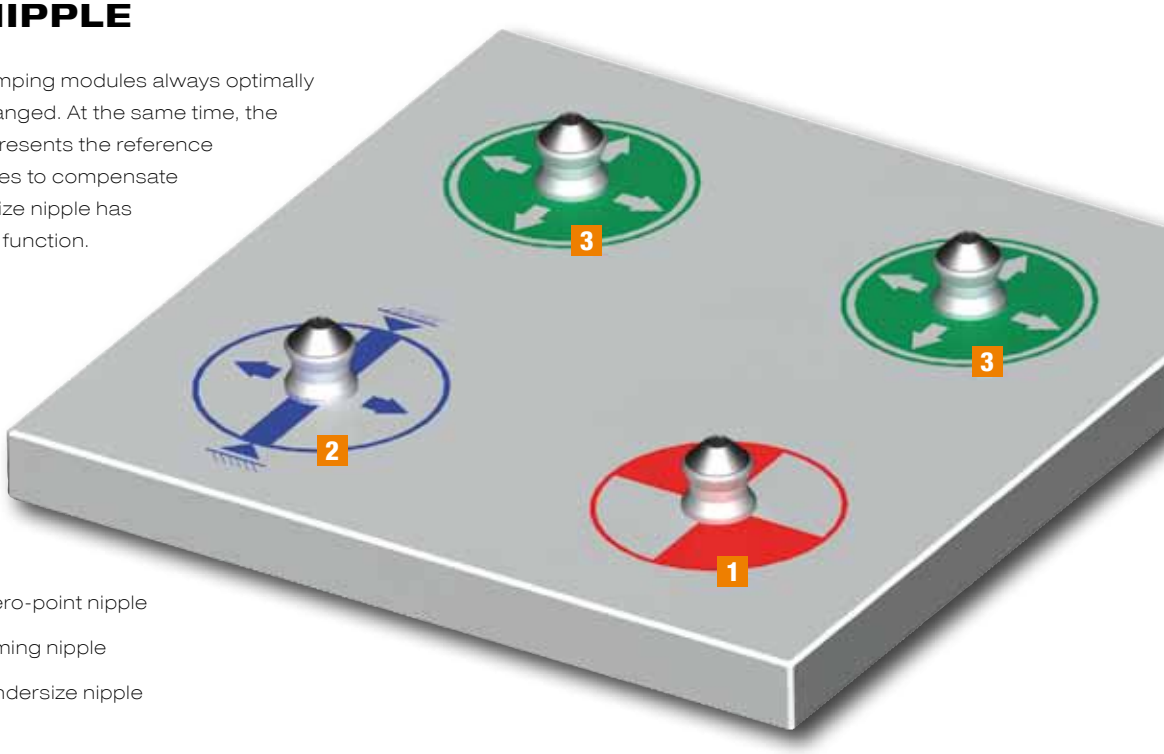
303810, 303198, 303206 303214

CAD

Subject to technical alterations.

ARRANGEMENT OF CLASSIC CLAMPING NIPPLE

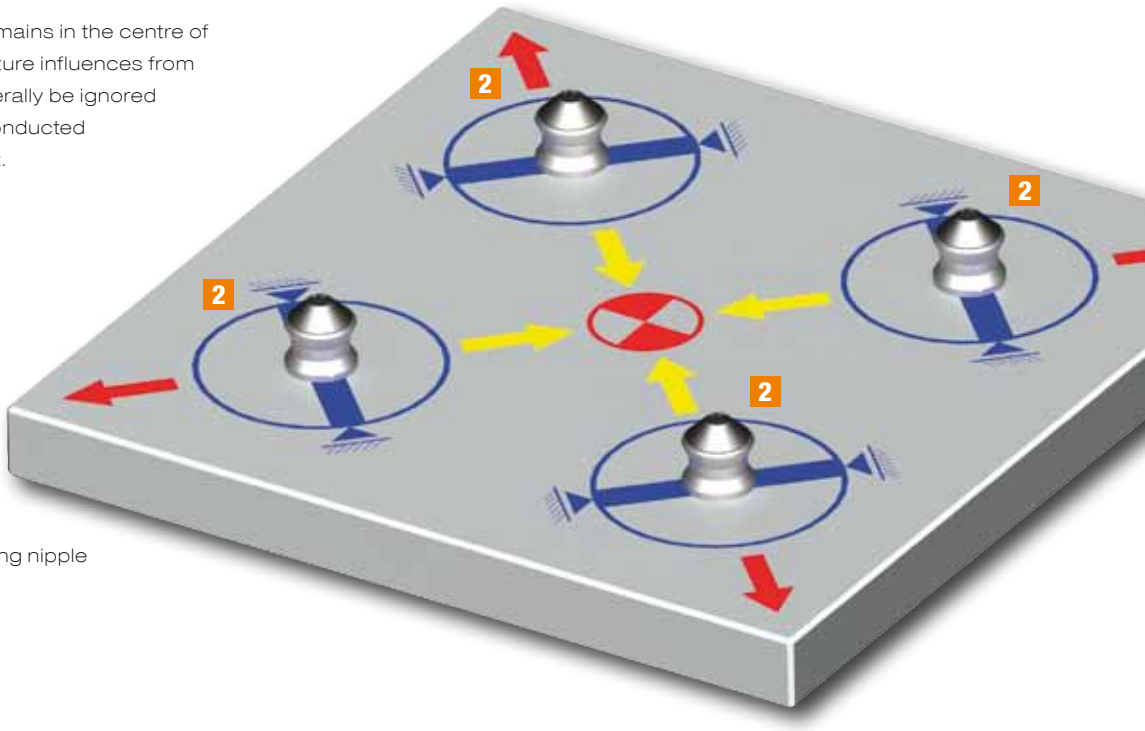
This arrangement of the clamping modules always optimally positions the pallet to be changed. At the same time, the zero-point nipple always represents the reference point. The timing nipple serves to compensate for the free axis. The undersize nipple has only a clamping and holding function.



1 zero-point nipple
2 timing nipple
3 undersize nipple

ARRANGEMENT OF OPTIONAL CLAMPING NIPPLE

The exclusive use of timing nipples compensates for stronger temperature influences.
The reference point always remains in the centre of the pallet. Of course, temperature influences from machine processing can generally be ignored since the heat generated is conducted away by the chips and coolant.



2 timing nipple

No. 6370ZNS-001

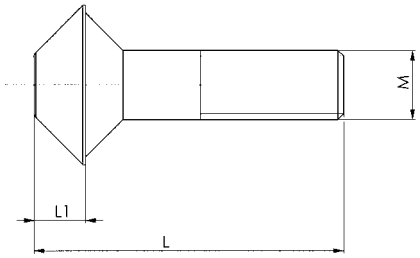
Engagement nipple screw

Strength class 10.9.
Suitable for clamping nipple, article no. 6370ZN.

Order no.	Size	M	L	L1	Weight [g]
306092	K 5	M 6	25	3,4	18
303578	K10	M 8	37	6	30
303222	K20	M12	54	9,0	70
303230	K40	M16	69	10,0	130

On request:

Engagement nipple screws in various lengths and materials (e.g. high-grade stainless steel).



CAD

No. 6370ZNS-002

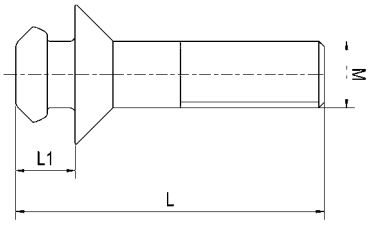
Horizontal engagement nipple screw

Strength class 10.9.
Suitable for clamping nipple, article no. 6370ZN.

Order no.	Size	M	L	L1	Weight [g]
303248	K20	M12	56	10,5	100
303255	K40	M16	73	13,0	200

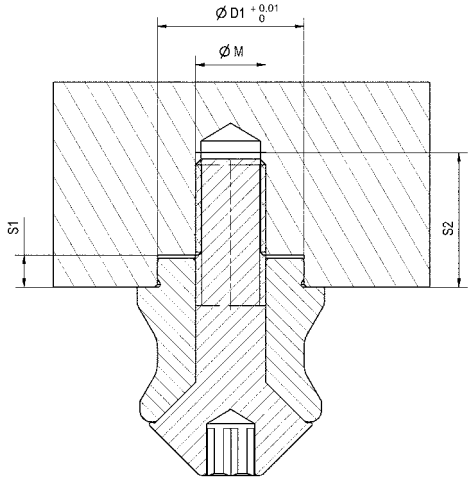
On request:

Horizontal engagement nipple screw in various lengths and materials (e.g. high-grade stainless steel).



CAD

Dimensions for machining nipple mountings.



Size	dia. D1	dia.M	S1	S2
K02	7,17	M 5	3,6	14
K5	10,00	M 6	2,8	12
K10	15,00	M 8	3,5	16
K20	25,00	M12	5,5	23
K40	25,00	M16	5,5	30

Figure:

Shown with clamping nipple and engagement nipple screw.

Subject to technical alterations.

No. 6370ZNM

Clamping female nipple

Strength class 10.
Suitable for clamping nipple No. 6370ZN

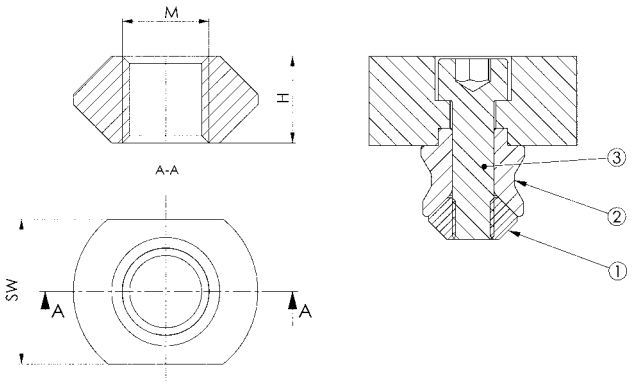
Order no.	Size	M	SW	H	Weight [g]
429969	K 5	M6	10	6	3
429985	K10	M8	14	8	8
430009	K20	M12	21	14	26
430025	K40	M16	28	17	50

Application:

Clamping female nipple for fastening the clamping nipple.

Note:

By gluing the clamping female nipple in the clamping nipple with medium adhesive it is protected against twisting when loosening the socket head screw.
1 = Clamping female nipple
2 = Clamping nipple
3 = Socket head screw



CAD

No. 6370ZNSN

Floating nipple

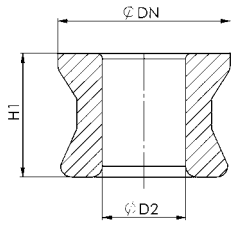
Hardened, for hydraulic and pneumatic clamping modules.

EDELSTAHL Rostfrei STAINLESS STEEL

Order no.	Size	dia. DN	dia. D2	H1	Weight [g]
340059	K10	21,8	12,0	16	25
305912	K20	31,8	15,5	23	80
426882	K40	39,8	20,0	29	160

Note:

The floating nipple is supported by bearings so that it is axially mobile and is used when large distance and angle tolerances between the nipple holes have to be compensated.
The nipple has only a holding function and does not take on any lateral load.



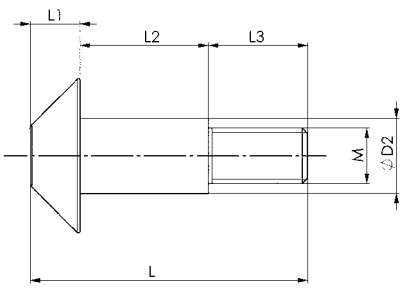
CAD

No. 6370ZNSSN

Engagement nipple screw

Strength class 10.9.
Suitable for floating nipple, article no. 6370ZNSN.

Order no.	Size	dia. D2	M	L	L1	L2	L3	Weight [g]
340034	K10	11,0	M8	35	6	16,1	12,9	24
305938	K20	13,5	M10	50	9	23,1	17,9	55
426908	K40	17,0	M12	59	10	29,1	19,9	100



CAD

Subject to technical alterations.

No. 6201ZN

Clamping nipple for clamping modules „Heavy duty“

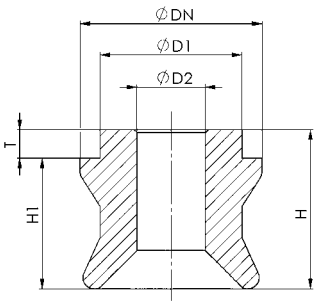
Hardened, for hydraulic clamping modules article-nos. 6201H-20.

EDELSTAHL Rostfrei STAINLESS STEEL

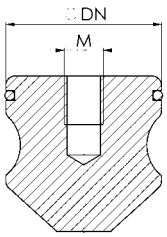
Order no.	Size	dia. DN	dia. D1	dia. D2	H	H1	M	T	Weight [g]
423970	K20	32,0	25	16	28	23	-	5	80
423996	K20	32,0	25	16	28	23	-	5	80
424010	K20	31,8	25	16	28	23	-	5	80
303172	K20	31,8	-	-	-	-	M 8	-	110

Design:

Order no. 423970: Zero point nipple
Order no. 423996: Timing nipple
Order no. 424010: Undersized nipple
Order no. 303172: Protection nipple



423970, 423996, 424010



303172

CAD

No. 6201ZS

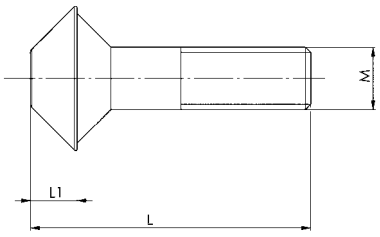
Engagement nipple screw „Heavy duty“

Strength class 10.9.
Suitable for clamping nipple article-nos. 6201ZN.

Order no.	Size	M	L	L1	Weight [g]
424036	K20	M16	70	9	120

On request:

Engagement nipple screws in various lengths and materials (e.g. high-grade stainless steel).



CAD

Subject to technical alterations.

No. 6370ZA

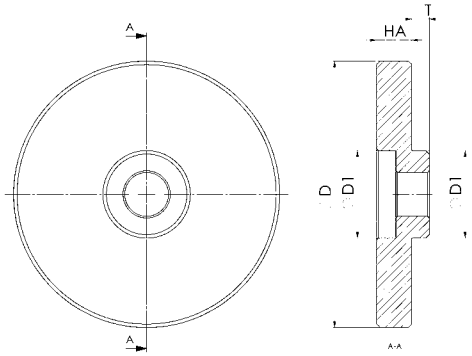
Protective shield

made of tempering steel, suitable for article-nos. 6370 A, E, S.

Order no.	Size	dia. D	dia. D1	HA	T	Weight [g]
422345	K10	50	15	7	3	100
422360	K20	76	25	10	5	340
422386	K40	112	25	15	5	1130

Application:

The protective shield is used when through-holes must be set in the area of the module cover. As a result, the module cover is protected from damage.



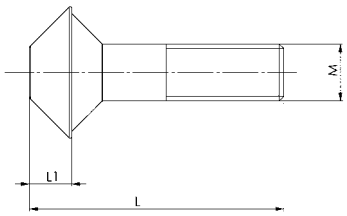
CAD

No. 6370ZNSA

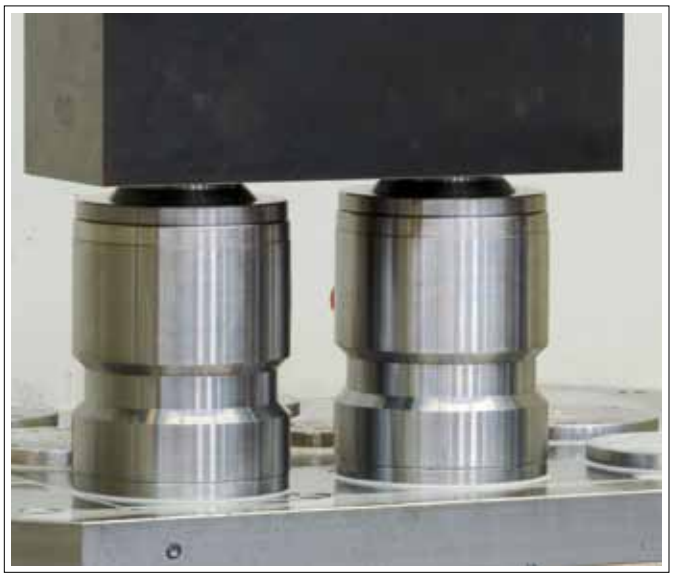
Engagement nipple screw for protective shield

Strength class 10.9.
Suitable for article-nos. 6370 A, E, S.

Order no.	Size	M	L	L1	Weight [g]
422402	K10	M8	44	6	33
422428	K20	M12	64	9	80
422444	K40	M16	84	10	145



CAD



Subject to technical alterations.

No. 6102ZN

Clamping nipple for „Turbine“ high-end clamping module

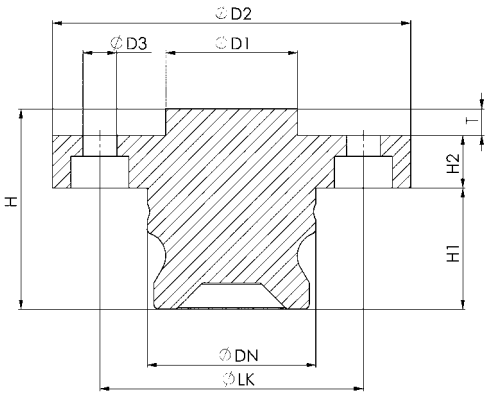
Hardened, for hydraulic high-end clamping module article no. 6102H.

EDELSTAHL Rostfrei STAINLESS STEEL

Order no.	Size	dia. DN	dia. D1	dia. D2	dia. D3	dia. LK	H	H2	H1	T	Weight [g]
426502	K23	32,0	25	68	6,4	50	38	23	10	5	370
426528	K23	32,0	25	68	6,4	50	38	23	10	5	370
426544	K23	31,8	25	68	6,4	50	38	23	10	5	370

Design:

Order no. 426502: Zero point nipple
Order no. 426528: Timing nipple
Order no. 426544: Undersized nipple



CAD

No. 6370ZZ

Positioning nipple

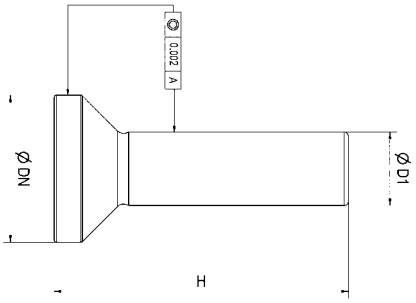
Hardened.

EDELSTAHL Rostfrei STAINLESS STEEL

Order no.	for clamping modules	dia. D1	dia. DN	H	Weight [g]
306241	K 5	8	15	48	60
306167	K10	12	22	48	85
306183	K20 / G1000	16	32	64	225
306209	K40	20	40	82	455
306225	G2000	20	47	82	550

Application:

The positioning nipple makes all of the surface-mounted modules easier to align. It can be clamped directly in the machine spindle, thus achieving the desired gauges when the machine is traversed.



No. 6370ZMSH

Mounting key for horizontal rapid-clamping cylinder

Suitable for article-nos. 6370HARH.

Order no.	Size	Weight [g]
424556	K20	520
426866	K40	940

Application:

The mounting key is needed for installation of the threaded sleeve of the horizontal rapid-clamping cylinder.

Subject to technical alterations.

No. 6370ZN-20-029

Puller

NEW!

Order no.	Size	Thread	Weight [g]
526517	**K20**	M10	150

Design:

Aluminium puller is suitable for AMF K20 clamping nipple.

Application:

Clamping nipples can be simply and quickly removed from the workpiece or fixture. For this purpose, the K20 puller is mounted on a pin puller and the clamping nipples are pulled out without damaging the locating bore.

No. 6370ZAR

Cover ring for clamping modules

EDELSTAHL Rost frei STAINLESS STEEL

NEW!

Order no.	Size	Weight [g]
550281	K10.2	4
550282	K10.3	4
550283	K10	4
550284	K20	5
550285	K40	6

CAD

Subject to technical alterations.

No. 6376Z

Adapter set for ZPS clamping nipple K10

Supply scope:
- 1 Adapter sleeve
- 1 Positioning bush

Order no.	D1	D2	S1	H	Weight [g]
430207	25	15	5,5	19	23

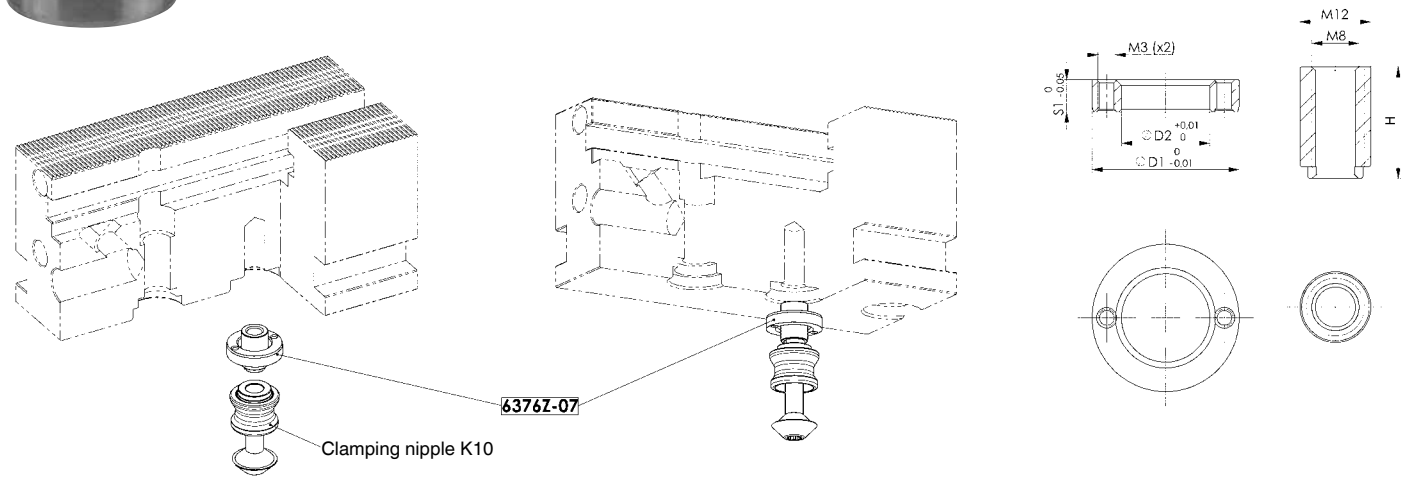
NEW!

Design:

The threaded sleeve is produced from alloyed heat-treated steel, the adapter ring from case-hardened steel.

Application:

Adapter set for reducing the locating bore from K20 to K10 ZPS clamping nipple.
For blind hole thread in the clamping rail, see Item No. 6376G.



No. 6376Z

Adapter set for ZPS clamping nipple K10

Supply scope:
- 1 Cylinder head screw
- 1 Adapter sleeve
- 1 Positioning bush

Order no.	D	D1	D2	D3	H	S1	Weight [g]
430223	17,5	25	15	12,5	30	5,5	62

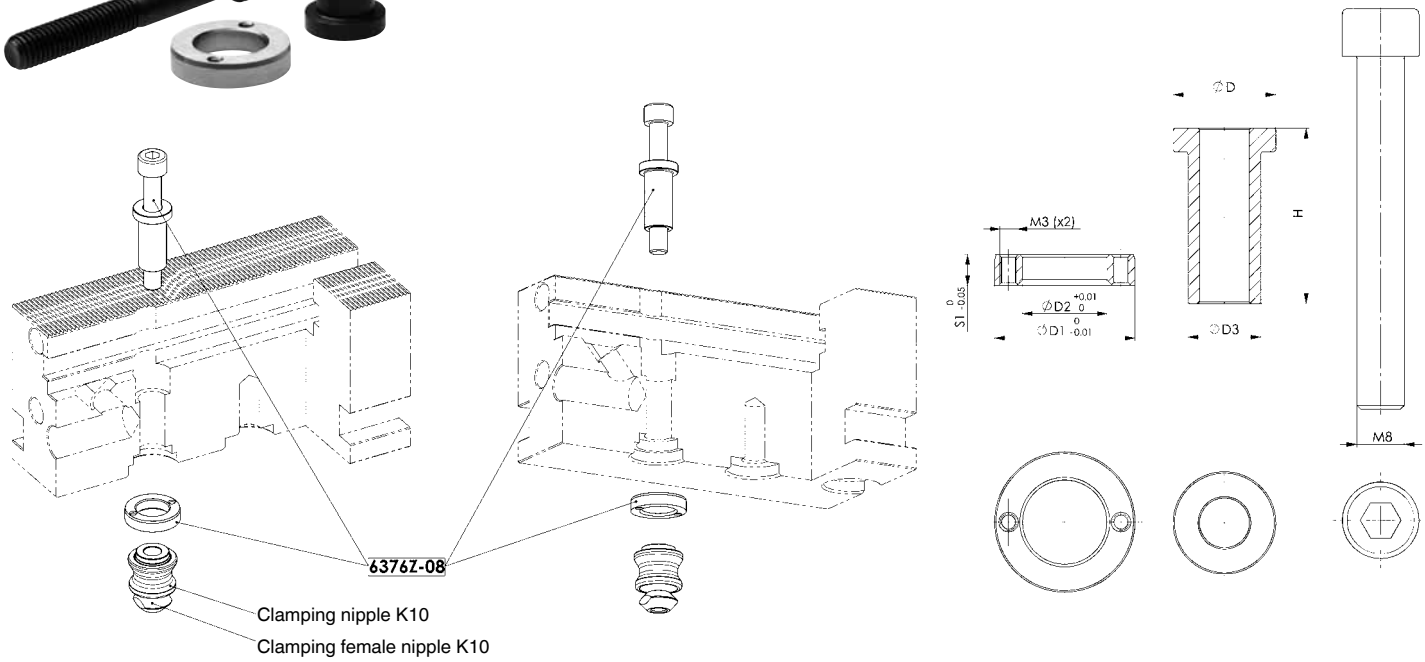
NEW!

Design:

The threaded sleeve is produced from alloyed heat-treated steel, the adapter ring from case-hardened steel.
The fastening bolt conforms to strength class 10.9.

Application:

Adapter set for reducing the locating bore from K20 to K10 ZPS clamping nipple.
For through-bores in the clamping rail, see Item No. 6376G.



Subject to technical alterations.

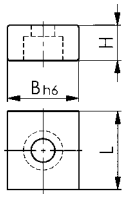
No. 6370ZI

Indexing T-nut

for clamping modules with indexing.
Case-hardened, burnished and ground, incl. fastening bolt.

Order no.	Size	B	H	L	Weight [g]
430264	K10.2, K10.3, K20	8	8	10	6
550288	K20.3	10	8	20	15

NEW!



Application:

Indexing T-nut is used for the precise positioning of workpieces or fixtures on a clamping module with indexing function.

Note:

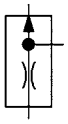
Order no. 430264 incl. M3 fastening bolt.
Order no. 550288 incl. M4 fastening bolt.

No. 6984-30

Support control, pneumatic

max. operating pressure 10 bar.

Order no.	Article no.	Stroke max. [mm]	Spring force min. [N]	Spring force max. [N]	Weight [g]
325217	6984-30	5	1,9	2,6	36



Design:

Housing from hardened and burnished steel. Pistons are tempered, nitrided and ground. Compression spring from stainless steel.

Application:

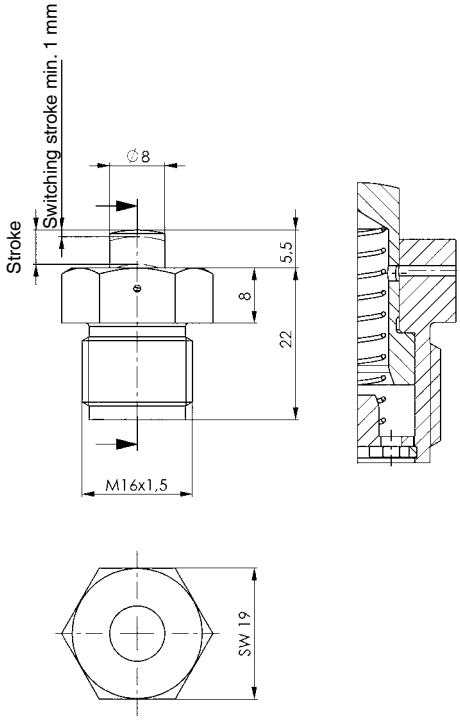
The support control is used in fixtures where a signal indicating a correctly supported workpiece is required to enable machining. Lightweight workpieces should be clamped before being pressurised with compressed air.

Features:

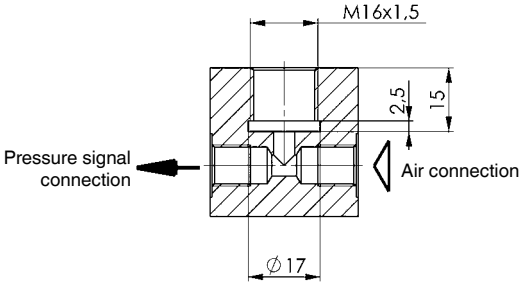
The support control works like a pneumatic back-pressure nozzle. The position is extended from its initial position by a pressure spring. Once applied, the air jet flows through the hollow piston and the radial discharge hole on the support control housing to outside. The discharge hole is sealed as soon as a workpiece is mounted and the piston is pushed downwards by min. 1 mm. The air flow backs up, the internal air pressure rises. The pressure value must be transferred to the control by an appropriate pressure signal converter. The system is relatively insensitive to fine chips.

Note:

The pressure signal converter is not included in the supply scope.
Effective piston surface with closed nozzle = 0.95 cm²
Piston force = piston surface x air pressure + spring force



Installation drawing



Subject to technical alterations.

No. 6370ZMMG

Coupling mechanism adapter

Suitable for installation clamping module nos. 6370FARH / FARL.

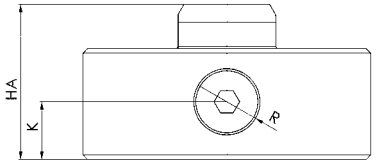
Order no.	Size	Nominal bore [NW]	A	A1	A2	B	HA	K	dia. N	dia. P	R	T	U	Weight [Kg]
424002	K20	5	56	33	18	65	35	13	6 H7	9	G1/8	12	45	0,9
424184	K40	5	56	33	18	65	45	13	6 H7	9	G1/8	12	45	1,0

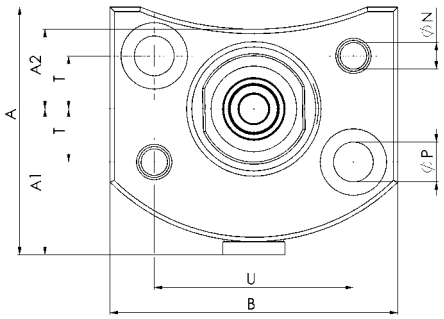
Application:

Couplings are used for loss-free transfer of liquid and gaseous media and are adjusted to the cover height of the installation clamping modules.

Note:

The coupling mechanism and nipple must be guided approx. 2-3 mm before contact with the axial sealing surfaces. The radial position tolerance (+/- 0.2mm) must not be exceeded. The couplings can only be coupled in a depressurised state.
The separating force due to hydraulic pressure between the coupling nipple and mechanism is given by the formula F [N] = 15.4 x p [bar] and must be taken into account.





CAD

No. 6370ZMM

Screw-in coupling mechanism

max. operating pressure 400 bar.

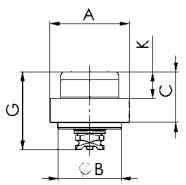
Order no.	Size	Nominal bore [NW]	A	dia. B	C	G	K	dia. P	SW	Weight [g]
424267	K10	5	M30x1,5	24	19	29,0	7	25	22	74
424200	K20	5	M30x1,5	24	19	29,0	10	25	22	65
424226	K40	5	M30x1,5	24	24	31,5	15	25	22	96

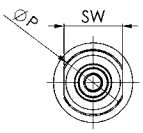
Application:

Couplings are used for loss-free transfer of liquid and gaseous media and are adjusted to the cover height of the installation clamping modules.

Note:

The coupling mechanism and nipple must be guided approx. 2-3 mm before contact with the axial sealing surfaces. The radial position tolerance (+/- 0.2 mm) must not be exceeded. The couplings can only be coupled in a depressurised state. The separating force due to hydraulic pressure between the coupling nipple and mechanism is given by the formula F [N] = 15.4 x p [bar] and must be taken into account.





CAD

Subject to technical alterations.

No. 6370ZMNG

Coupling nipple adapter

Suitable for coupling mechanism no. 6370ZMMG / ZMM

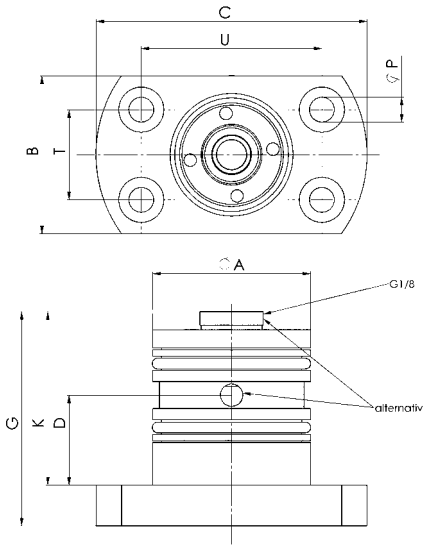
Order no.	Size	Nominal bore [NW]	dia. A	B	C	D	G	K	dia. P	T	U	Weight [g]
424242	K20/K40	5	35	35	60	20	47,5	38,5	5,5	20	40	320

Application:

The coupling nipple adapter is the counterpart to the coupling mechanicals and is used in the change pallet, in which the clamping nipples are also located. Couplings are used for loss-free transfer of liquid and gaseous media and are adjusted to the height of the installation clamping modules.

Note:

The mounting housings of the two parts must be guided approx. 2-3 mm before contact with the axial sealing surfaces. This function is taken over by the coupling nipple adapter through the centring function. The medium can be passed on at the top over the pipe connection or over the O-ring connection. The radial position tolerance (+/- 0.2 mm) must not be exceeded. The couplings can only be coupled in a depressurised state. The separating force due to hydraulic pressure between the coupling nipple and mechanism is given by the formula F [N] = 15.4 x p [bar] and must be taken into account.



CAD

No. 6370ZMN

Screw-in coupling nipple

max. operating pressure 400 bar.

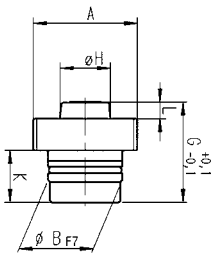
Order no.	Nominal bore [NW]	A	dia. B	G	dia. H	K	L	Weight [g]
430058	5	M24x1,5	20	27	13,5	14	4,5	56

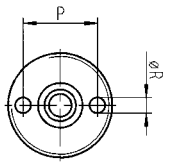
Application:

Couplings are used for the leakage-free connection of hydraulic oil supplies.

Note:

The coupling mechanism and nipple must be guided approx. 2-3 mm before contact with the axial sealing surfaces. The radial position tolerance (+/- 0.2 mm) must not be exceeded. The couplings can only be coupled in a depressurised state. The separating force due to hydraulic pressure between the coupling nipple and mechanism is given by the formula F [N] = 15.4 x p [bar] and must be taken into account.





CAD

Subject to technical alterations.

No. 6370ZD-004

Air-Hydraulic Pump

Max. operating pressure 60 bar.

Order no.	Pneum. pressure min. [bar]	Pneum. pressure max. [bar]	Oil capacity usable [cm^3]	Flow rate max. [cm^3/min]	Weight [Kg]
426569	4	6	1000	750	5,9

Design:

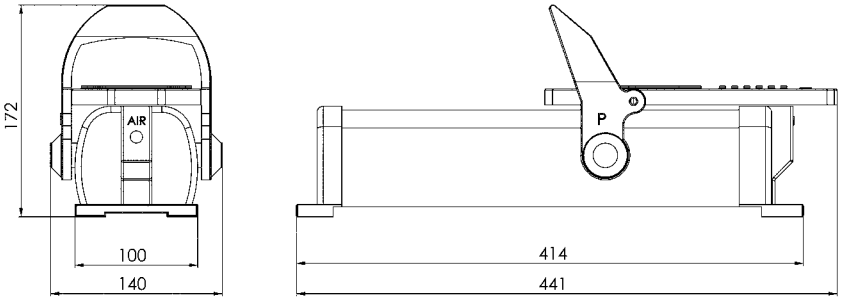
Compact, air-pressure-operated hydraulic intensification pump for single-acting circuits. The pump is fitted with an integrated safety valve that regulates the hydraulic output pressure. The safety valve is set in the factory to the max. operating pressure of 60 bar.
The extension element in the oil tank allows the pump to be adjusted horizontally and vertically.
Air connection thread: G1/4
Oil connection thread: G1/4

Application:

The air-hydraulic pump is used for opening for hydraulic clamping modules or hydraulic clamping stations.

Note:

The use of purified, lubricated compressed air is recommended for operation of the pump.



No. 6370ZD

Pressure intensifier

Max. operating pressure 60 bar.

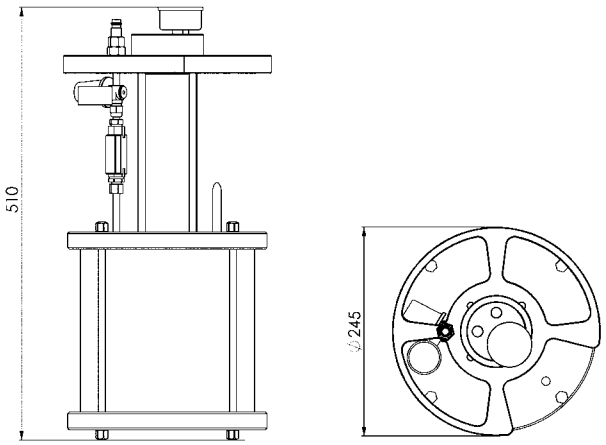
Order no.	Size	Oil capa-city [cm^3]	Flow rate [cm^3/min]	Rato	max. no. of clamping cylinders	Weight [Kg]
303354	2	653	431	1 : 8,1	36 (Typ 20), 16 (Typ 40)	9,5

Design:

Compact, air-pressure-operated hydraulic pressure intensifier for single-acting circuits. Complete with air-pressure regulator, air manometer, oil manometer and oil fill level display.

Application:

The pressure intensifier is used for opening for hydraulic clamping modules or hydraulic clamping stations.



Subject to technical alterations.

No. 6370ZVL-005

Pneumatic pressure booster

Order no.	Input pressure [bar]	Output pressure [bar]	Connection	Weight [Kg]
427088	2,5-8	4,5-10	G1/4	1,5

Design:

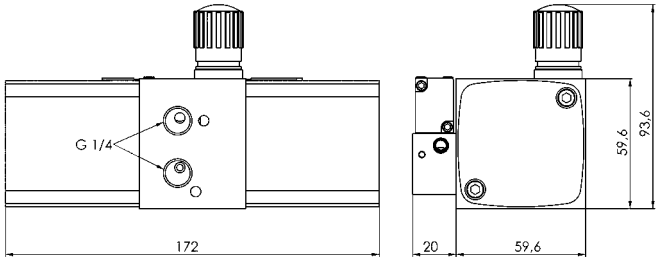
Pressure intensifier with possibility to adjust the pneumatic output pressure, incl. manometer construction kit, sound absorbers and flange mounting.

Application:

For strengthening the operating pressure with pneumatic clamping modules and compensation for pressure fluctuations in the supply line.

Note:

The pressure intensifier can be mounted in every installation position. For operation, filtered (40µm), unlubricated compressed air as per ISO 8573-1 is required. The pressure intensifier is suitable for ambient temperatures of +5 – +60 °C.



No. 6370ZVL-004

Pneumatic pressure booster set

Order no.	Input pressure [bar]	Output pressure [bar]	Connection	Weight [Kg]
421396	2,5-8	4,5-10	G1/4	2,5

Design:

Pressure intensifier group with possibility to adjust the pneumatic output pressure, incl. manometer construction kit, sound absorbers, flange mounting, pressure control valve, manual direction valve, coupling plug, connections and plastic tube.

Application:

For strengthening the operating pressure with pneumatic clamping modules and compensation for pressure fluctuations in the supply line.

Note:

The pressure intensifier can be mounted in every installation position. For operation, filtered (40µm), unlubricated compressed air as per ISO 8573-1 is required. The pressure intensifier sub-assembly is suitable for ambient temperatures of +5 – +60 °C.

No. 6370ZVL-006

Pneumatic pressure booster cabinet

Order no.	Input pressure [bar]	Output pressure [bar]	B x H x T	Connection	Weight [Kg]
427104	2,5-8	4,5-10	200 x 300 x 155	G1/4	7,0

Design:

Connection-ready pressure-intensifier cabinet with possibility to adjust the pneumatic output pressure.

Application:

For strengthening the operating pressure with pneumatic clamping modules and compensation for pressure fluctuations in the supply line.

Note:

The connection-ready pressure intensifier cabinet is shipped with wall-mounting bracket and can be mounted in every installation position. For operation, filtered (40µm), unlubricated compressed air as per ISO 8573-1 is required. The pressure cabinet is suitable for ambient temperatures of 0 – +40 °.

Subject to technical alterations.

No. 6370ZR

Pipe fittings, brass

for pipes external Ø 8 mm, internal Ø 4 mm.
Max. operating pressure 100 bar.

Application:

Fitttings for piping of surface-mounted clamping modules and flange versions.

Note:

* Article 429936:
Seamless hydraulic pipe, phosphate-coated and lubricated, ø 8x2 mm, length 2.0 m, made of steel (fully killed cast steel) in accordance with DIN 2391 C normalised, bright-annealed (NBK) cold-drawn.

Order no.	Fig. No.	Connection	Weight [g]
320986	1	G1/4	80
305409	1	G1/8	44
321000	2	G1/4	31
305417	2	G1/8	23
321026	3	G1/4	95
305425	3	G1/8	60
321042	4	-	37
321067	5	-	56
427963	6	G1/8	16
429019	6	G1/4	44
429936	7	*	475

1)

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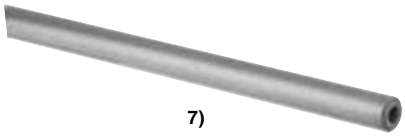
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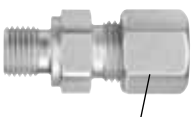
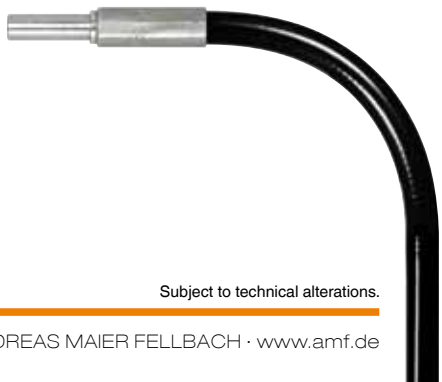
CAD

CU-seal
order no.
69823

order no.
427856

order no.
427872


order no.
321000

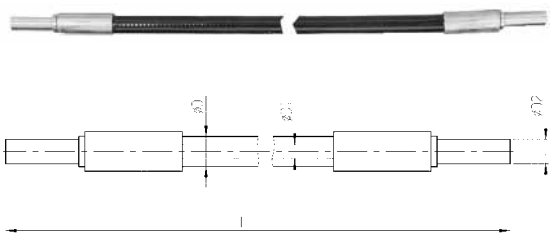


Subject to technical alterations.

No. 6985R

High Pressure Hose

Max. operating pressure dyn. at +50°C 375 bar



Order no.	Test pressure [bar]	Bending radius min. [mm]	dia. D [mm]	dia. D1 [mm]	dia. D2 [mm]	L [mm]	Weight [g]
63198	750	30	9,8	4,8	8	300	65
63206	750	30	9,8	4,8	8	500	90
63214	750	30	9,8	4,8	8	800	120
63222	750	30	9,8	4,8	8	1250	180
63230	750	30	9,8	4,8	8	2000	265
63248	750	30	9,8	4,8	8	3000	380

Design:

Steel fitting, galvanized and passivated. Hose of synthetic material with high tensile brassed steel-wire braid.

Application:

Insert hose and tighten with 1/4 turn maximum.

Note:

We recommend to use the high pressure hose of 3 m long only for double-acting elements. The period of use of a hydraulic hose, including any storage period should not exceed six years. The serviceability must be assessed to fixed inspection criteria. See DIN 20066, Part 5 for further details.

No. 6370ZSK

Quick Disconnect Coupler

zinc-plated.
Max. operating pressure 325 bar.

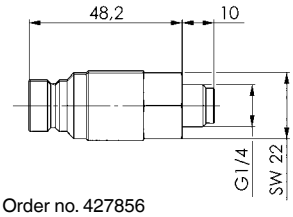
Order no.	Nominal bore [NW]	Nominal flow [l/min]	SW [mm]	Weight [g]
427856	6	12	22	100
427872	6	12	22	170

Application:

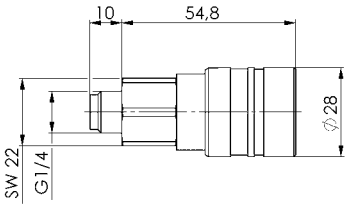
Since the clamping modules after blow-off of the opening pressure are mechanically locked, the hose is then uncoupled by means of the quick couplings. The advantage of this is that there are no interfering lines.

Note:

Flat-sealing quick coupling with G1/4 internal thread. For G1/4 external thread a threaded stud is enclosed.



Order no. 427856



Order no. 427872

CAD

No. 6370ZS-06-2000

Hose set, hydraulic

Max. operating pressure 100 bar.

Order no.	Length [m]	Weight [g]
430082	2	730

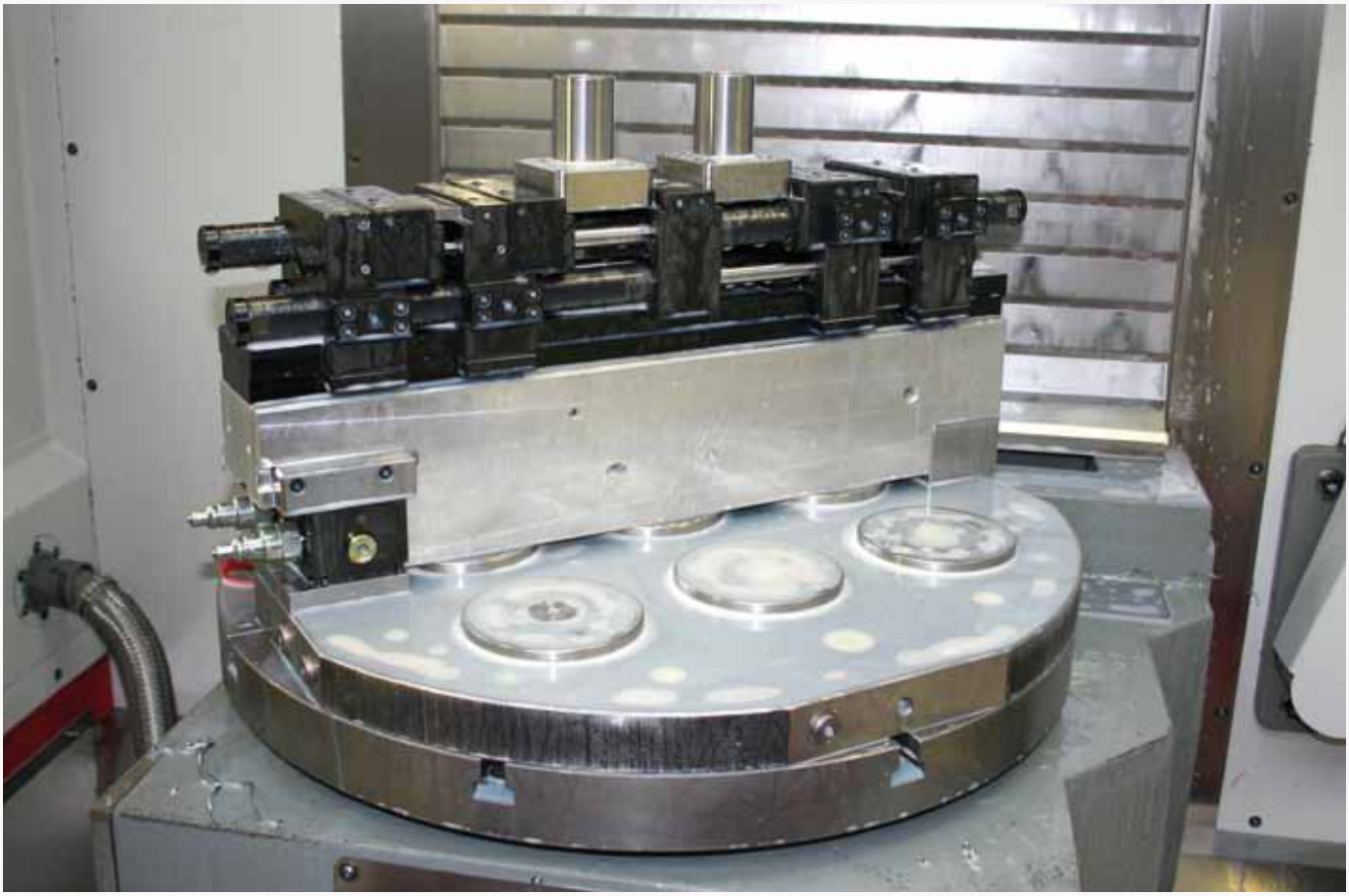
Design:

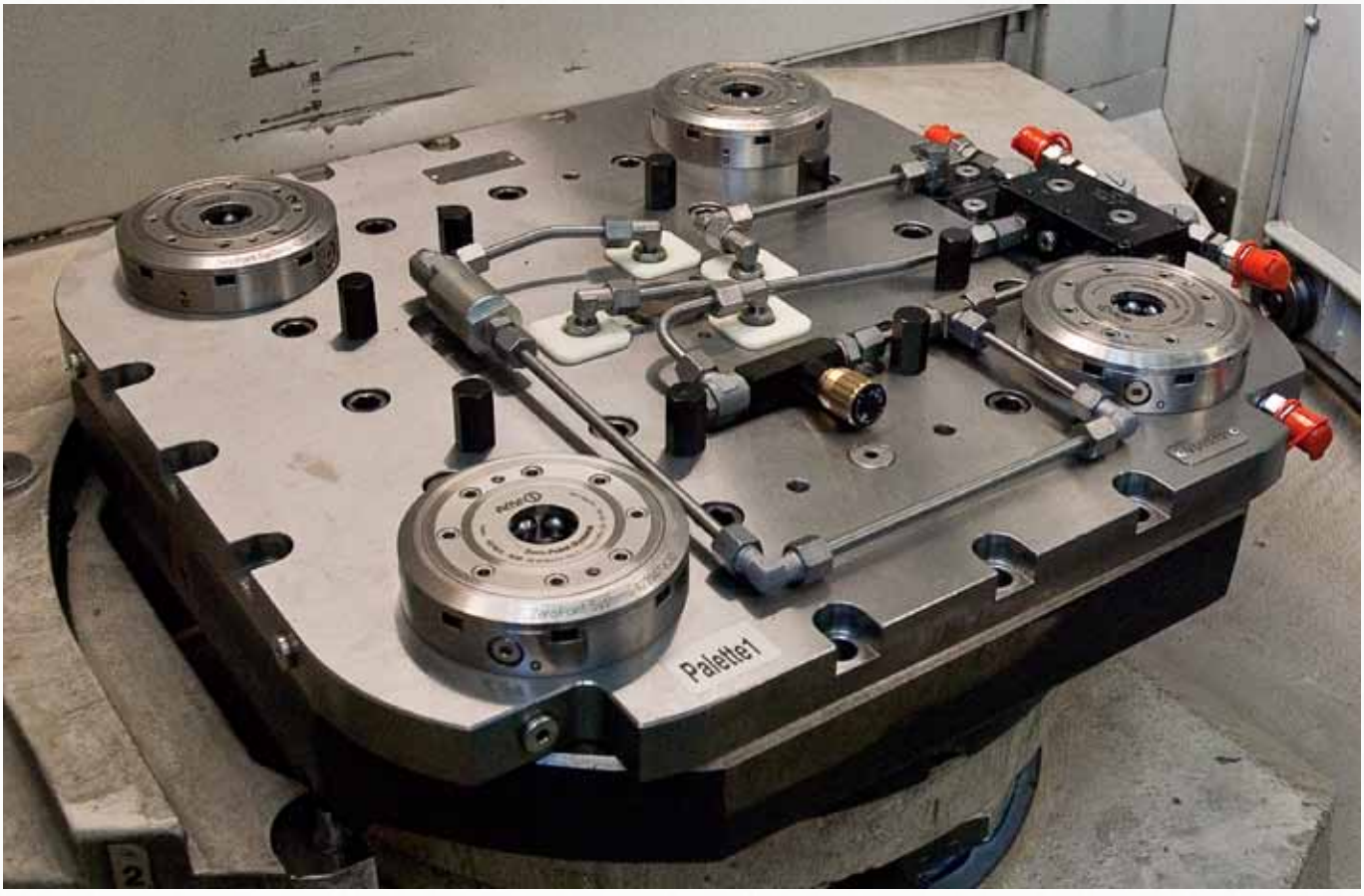
The connection set includes:
1x hydraulic connecting tube, length 2 m
2x straight screw pipe connections
2x straight screwed sockets
1x T-screw connection
1x manometer 0-100 bar
1x straight female stud coupling
2x quick fitting coupling sleeves
2x quick fitting coupling plugs
2x Cu sealing washers for G1/4

Application:

This set is used for the hydraulic connection of extension clamping modules or clamping stations for pressure generators such as pressure boosters or air-hydraulic pumps.

Subject to technical alterations.





Subject to technical alterations.

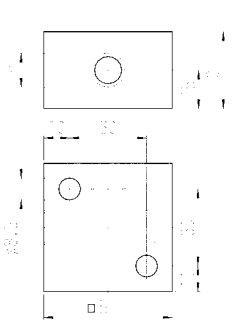
No. 6988

Manifold

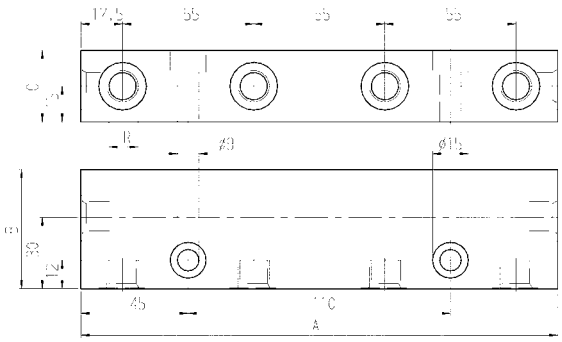
Order no.	Article no.	Operating pressure [bar]	NG	A	B	C	R	Oil connec-tions	Weight [g]
68825	6988-G1/4x4	400	6	-	50	30	G1/4	4	480
68817	6988-G1/4x6	400	6	200	50	30	G1/4	6	2025

Design:

Housing from steel, burnished.



No. 6988 G1/4x4



No. 6988 G1/4x6

No. 6370ZR-02

Push-in fittings, pneumatic

Max. operating pressure 12 bar.
For hose diameter 8 mm.

1)

2)

Order no.	Fig. No.	Connection	Weight [g]
421479	1	G1/8	14
421453	1	G1/4	16
430108	2	G1/8	19
430124	2	G1/4	27

Application:

Screwed connections are used for the pneumatic connection of extension clamping modules or clamping stations.

No. 6370ZSK

Quick fitting coupling, galvanised, pneumatic

Max. operating pressure 12 bar.

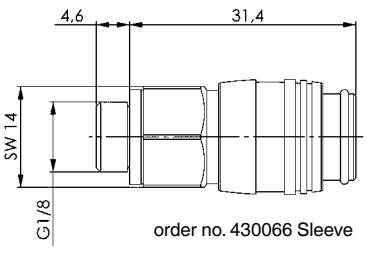
Order no.	Nominal bore [NW]	Nominal flow [l/min]	SW [mm]	Weight [g]
430041	4,2	563	14	23
430066	5,0	563	14	27

Application:

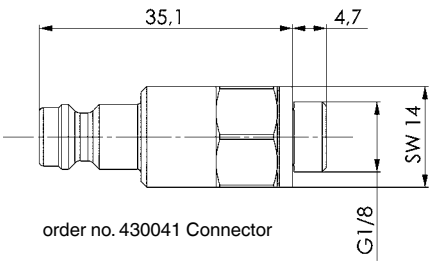
Since the clamping modules are mechanically locked after discharging the opening pressure, the hose can then be disconnected by means of the quick fitting couplings. The advantage of this is that there are no interfering lines.

Note:

Double-sided closing with external thread G1/8.



order no. 430066 Sleeve



order no. 430041 Connector

CAD

Subject to technical alterations.

No. 6370ZVL-007

Footrest valve, pneumatic

Max. operating pressure 10 bar.

Order no.	Air connection	Weight [g]
477570	G1/4	610

Application:

For controlling pneumatic clamping modules.

Note:

manual Footrest valve
valve function: 3/2 closed, monostable, latching

No. 6370ZS-07

Hose, pneumatic

Polyurethane, outside calibrated.
Max. operating pressure 10 bar.

Order no.	Hose dia. [mm]	Length [m]	Weight [g]
430140	8	3	100

Application:

Hoses are used for the pneumatic connection of extension clamping modules or clamping stations.

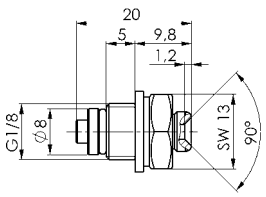
No. 6370ZSK-08

Air gun valve, pneumatic

Max. operating pressure 10 bar.

NEW!

Order no.	Nominal bore [NW]	Nominal flow [l/min]	SW	Weight [g]
533075	2,5	240	13	10



Design:

Pneumatic air gun with integrated non-return valve.

Application:

For simple and quick opening of the pneumatic zero point clamping plates. When the air gun is positioned on the valve, the air pressure is released and then held by the non-return valve. Venting is effected by briefly and manually pushing the valve, which then resets under spring force.

On request:

- Installation diagrams

Subject to technical alterations.

No. 6370ZF

Special grease for zero-point clamping modules

Order no.	Suitable for ambient temperature (°C) [°C]	Weight [g]
426494	0-80	250

Application:

Special grease for maintenance work on zero-point clamping modules.

No. 6370ZVL

Manual directional valves

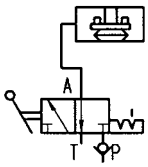
Order no.	Type	Air connection	Weight [g]
305383	4/3	G1/4	250
305391	2/2	G1/4	100

Order no. 305383

Order no. 305391

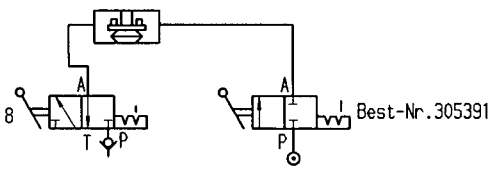
Circuit: hydraulic clamping module

order no. 114298



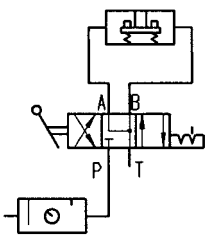
Circuit: hydraulic clamping module with blow-out

order no. 114298



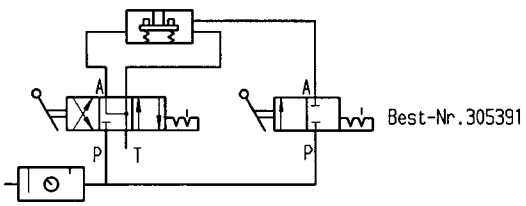
Circuit: pneumatic clamping module

order no. 305383

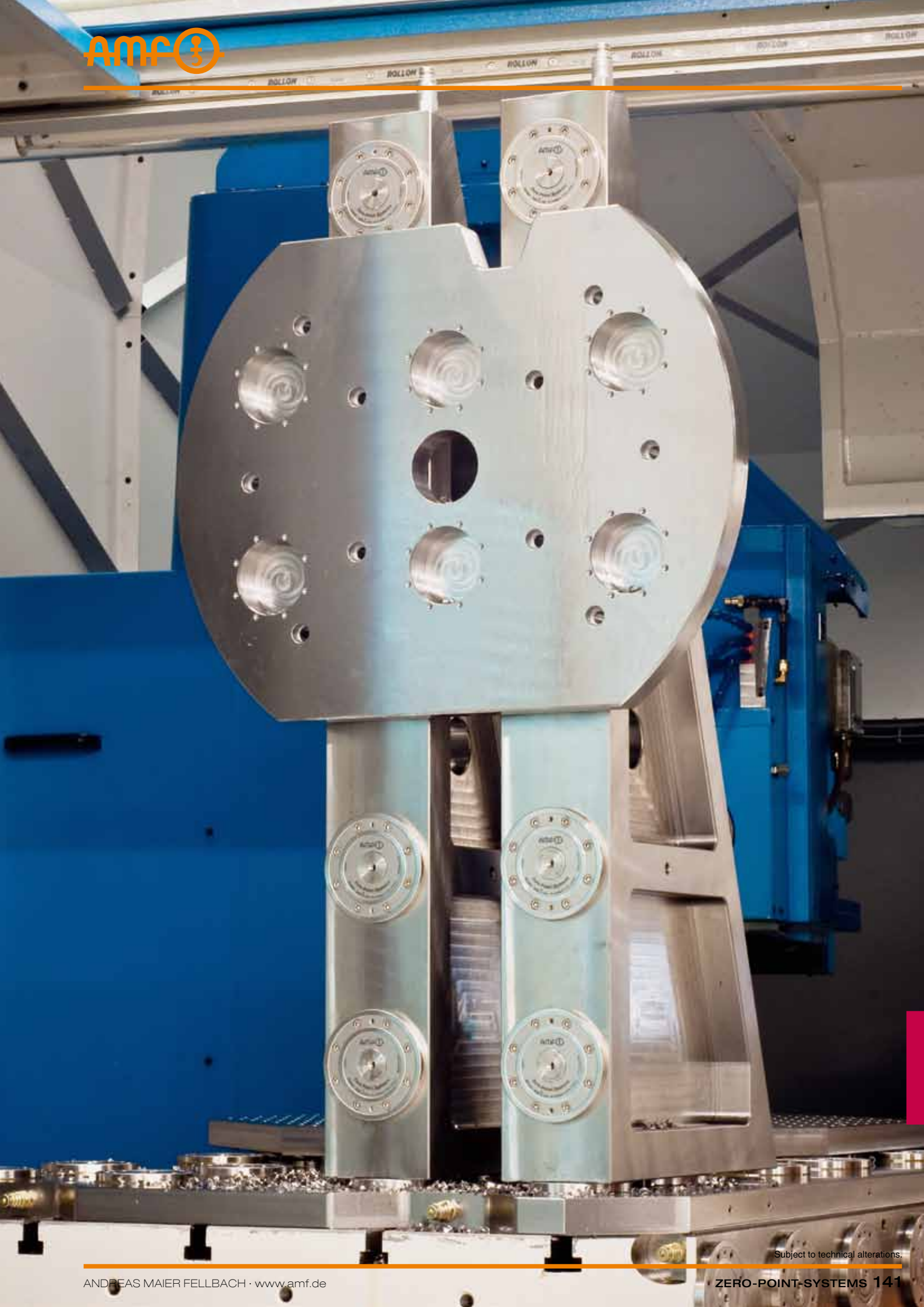


Circuit: pneumatic clamping module with turbo and blow-out

order no. 305383



Subject to technical alterations.



No. 6207S4

4-point clamping station, mechanical

Case-hardened steel, plasma-nitrided.
Repetition accuracy 0.005 mm.
Mechanical opening and closing.

NEW!

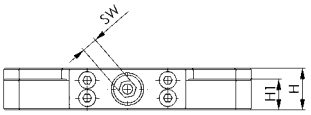
Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Tightening torque [Nm]	Weight [g]
535658	52	6	50	20	3500
546788	96	6	50	20	5890

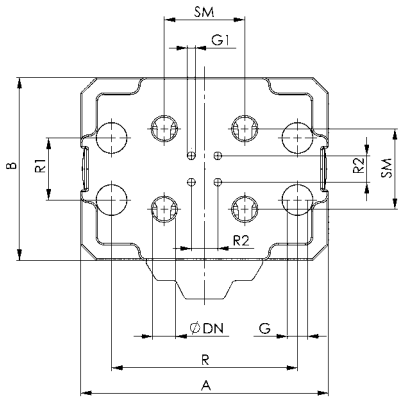
Application:

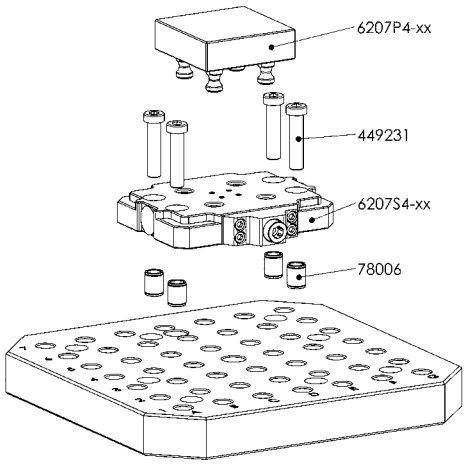
For quick, simple and time-optimised positioning and clamping of workpieces or fixtures on the machine table. Actuating the clamping screw opens or closes all four clamping points at the same time.
Extremely high retraction and retention forces are achieved thanks to the stable, high-quality design of this clamping station.

Note:

The 4-point clamping station is opened and closed using a WAF 10 hexagon wrench key. It can be fastened to the machine table either by the four M12 fastening bores or via mechanical clamping devices. A diverse range of suitable clamping devices for fastening can be found in our AMF Catalogue „Mechanical clamping elements“.



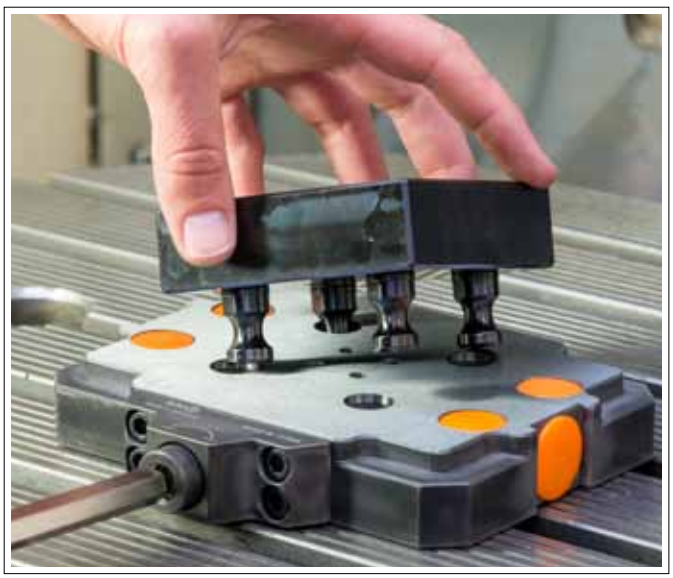




Dimensions:

Order no.	Size	A	B	dia. DN	G	G1	H ±0.01	H1	R	R1	R2	SM	SW
535658	52	160	118	15	M12	M5	27	20	120	40	17	52	10
546788	96	200	165	20	M12	M6	27	22	160	80	30	96	10

CAD



Subject to technical alterations.

No. 6207P4-52

Interchangeable pallet

Steel, burnished.
Complete with 4 clamping nipples.
Repeat accuracy 0.005 mm.

NEW!

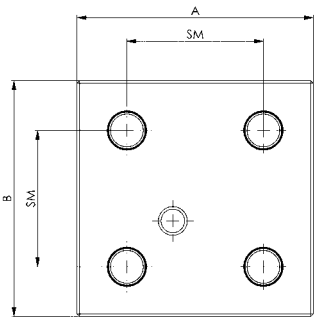
Order no.	Size	A	B	dia. DN	G	H	H1	SM	Weight [g]
535674	**52**	90	90	15	M8	27	50	52	1793
548784	**96**	150	150	20	M10	27	51	96	4845

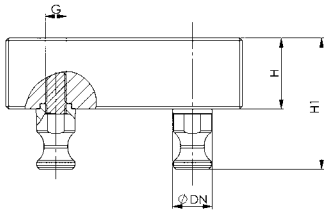
Application:

On the interchangeable plate, workpieces or fixtures are mounted and then positioned and clamped on the mechanical 4-point clamping station. The interchangeable plate is populated during machining, thus permitting longer machine operation.

Note:

On request, we can incorporate mounting holes according to your specifications in the change pallet. The 4 clamping nipples are supplied as standard.





CAD

No. 6207ZN-15

Clamping nipple

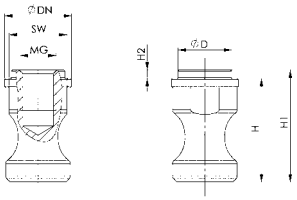
Tempered steel, burnished.

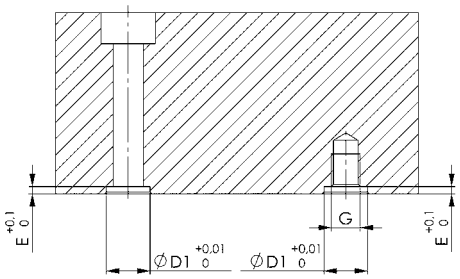
NEW!

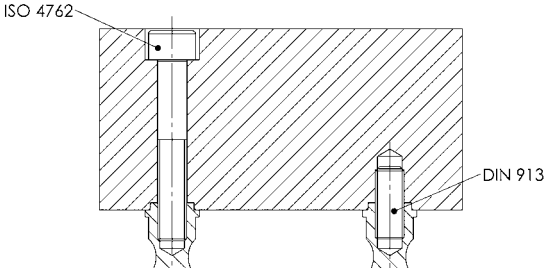
Order no.	Size	dia. D	dia. D1	dia. DN	E	G	H	H1	H2	Screw ISO 4762	Screw DIN 933	SW	Weight [g]
535690	**52**	12	12	15	2,0	M8	23	25	2	M8	M8x20	13	21
549865	**96**	16	16	20	2,5	M10	24	26	2,5	M10	M10x25	17	37

Application:

Clamping nipples suitable for mechanical 4-point clamping stations.
4 clamping nipples are required for clamping on the 4-point clamping station.
These nipples can, for example, be screwed into fixtures or into the workpieces themselves.







CAD

Subject to technical alterations.

No. 6377

Centering vice soft clamping jaws „Black-Edition“

NEW!

Order no.	Size	Clamping force F max. [kN]	Tightening torque Md max. [Nm]	Centering accuracy [mm]	Weight [g]
550656	65	14	60	+/- 0,01	3400

Design:

Base element and chuck with smooth clamping surfaces from case hardened steel, nitro-carburised and oxidised.
The spindle with trapezoidal thread is rated for extremely high clamping and retaining forces and fabricated from special steel.
For optimal force transmission onto the workpiece, the chuck is one part and the clamping force is transmitted directly onto the chuck via the drive spindle with trapezoidal thread.
The max. clamping force is 14kN. Due to these extremely high clamping forces, workpieces are not required to be pre-embossed and/or contour-embossed.
Fastening:
1) Clamping grooves on both sides for fastening directly on the machine table with mechanical clamping elements.
2) Prepared for adapting to the mechanical 4-point clamping station with insertion dimension of 52mm, see drawing. Clamping nipples under order no. 535690 are required for this purpose.
3) Two 8H7 bores are provided on the underside for precise positioning on adapter and intermediate plates.

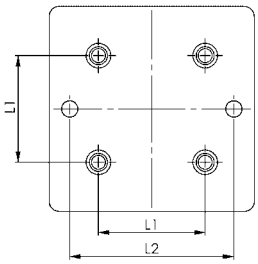
Application:

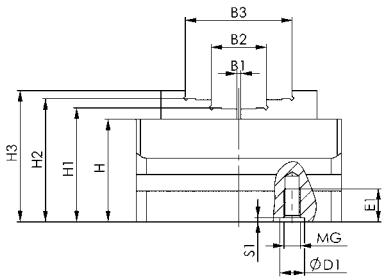
For the central clamping of workpieces.
The compact design of this centering vice makes it especially suitable for the 5-axis machining of workpieces. It is also, however, a multi-purpose tool and offers the user numerous day-to-day applications thanks to the chuck interchange option.
The chucks are easy to interchange and can, for example, be replaced by ribbed chucks, order no. 550659.

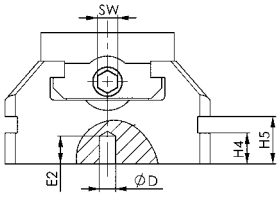
Note:

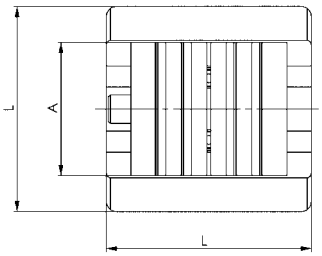
Extending the chucks beyond the max. dimension (L) of the outside contour of the main body is not recommended.
The max. clamping force is 14kN with a tightening torque of 60Nm, for further details on the clamping force, see clamping force diagram.
The clamping force is initiated on the spindle via the hexagon head with AF 10mm using either the crank handle provided or a torque wrench.

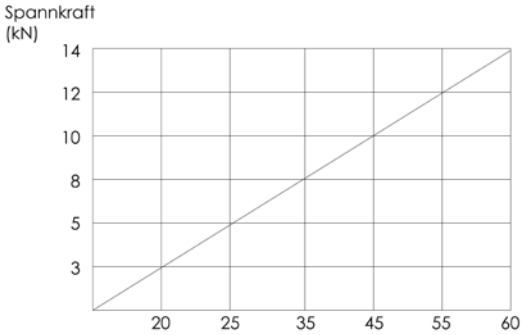
The inner hexagon on the rear of the spindle is suitable only for unscrewing and replacing the chucks. Initiating the clamping force using an inner hexagon is not permitted.











Dimensions:

Order no.	Size	A	B1	B2	B3	dia. D	dia. D1	E1	E2	G	H	H1	H2	H3	H4	H5	L	L1	L2	S1	SW
550656	65	65	2-26	27-51	52-76	8	12	16	13,5	M8	50	55,5	60	64	15	23	100	52	80	2	10

Subject to technical alterations.

No. 6377G

Centering vice ribbed clamping surfaces „Black-Edition“

NEW!

Order no.	Size	Clamping force F max. [kN]	Tightening torque Md max. [Nm]	Centering accuracy [mm]	Weight [g]
550657	65	14	60	+/- 0,01	3380

Design:

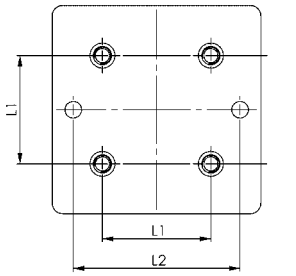
Base element and chuck with ribbed clamping surfaces from case hardened steel, nitro-carburised and oxidised.
The spindle with trapezoidal thread is rated for extremely high clamping and retaining forces and fabricated from special steel.
For optimal force transmission onto the workpiece, the chuck is one part and the clamping force is transmitted directly onto the chuck via the drive spindle with trapezoidal thread.
The max. clamping force is 14kN. Due to these extremely high clamping forces, workpieces are not required to be pre-embossed and/or contour-embossed.
Fastening:
1) Clamping grooves on both sides for fastening directly on the machine table with mechanical clamping elements.
2) Prepared for adapting to the mechanical 4-point clamping station with insertion dimension of 52mm, see drawing. Clamping nipples under order no. 535690 are required for this purpose.
3) Two 8H7 bores are provided on the underside for precise positioning on adapter and intermediate plates.

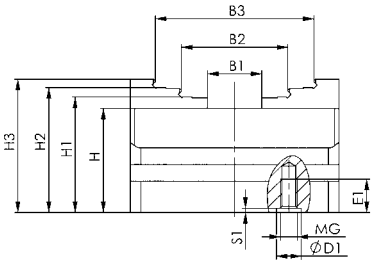
Application:

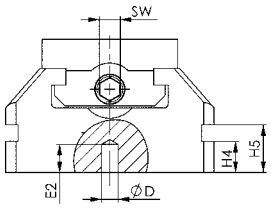
For the central clamping of workpieces.
The compact design of this centering vice makes it especially suitable for the 5-axis machining of workpieces. It is also, however, a multi-purpose tool and offers the user numerous day-to-day applications thanks to the chuck replacement option.
The chucks are easy to interchange and can, for example, be replaced by chucks with smooth clamping surface, order no. 550658.

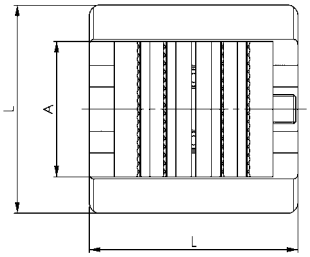
Note:

Extending the chucks beyond the max. dimension (L) of the outside contour of the main body is not recommended.
The max. clamping force is 14kN with a tightening torque of 60Nm, for further details on the clamping force, see clamping force diagram.
The clamping force is initiated on the spindle via the hexagon head with AF 10mm, either using the crank handle provided or a torque wrench.
The inner hexagon on the rear of the spindle is suitable only for unscrewing and replacing the chucks. Initiating the clamping force using an inner hexagon is not permitted.

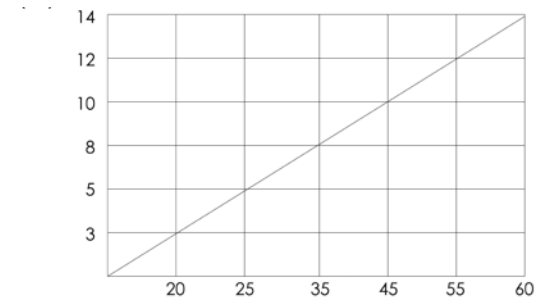








Clamping force [kN]



Tightening torque [Nm]

Dimensions:

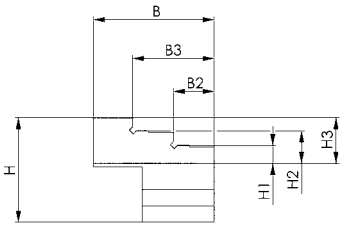
Order no.	Size	A	B1	B2	B3	dia. D	dia. D1	E1	E2	G	H	H1	H2	H3	H4	H5	L	L1	L2	S1	SW
550657	65	65	2-26	27-51	52-76	8	12	16	13,5	M8	50	55,5	60	64	15	23	100	52	80	2	10

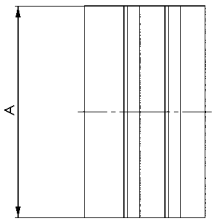
Subject to technical alterations.

No. 6377B

Clamping Jaws, soft

for centering vice, size 65.





Order no.	Size	A	B	B2	B3	H	H1	H2	H3	Weight [g]
550658	**65**	65	37	12,5	25	32	5,5	10	14	520

Design:

Base element and chuck with smooth clamping surfaces from case hardened steel, nitro-carburised and oxidised.
Suitable for „Black-Edition“ centering chuck, size 65.

Application:

The chucks can be simply and quickly interchanged and/or replaced on the „Black-Edition“ centering chuck, size 65.

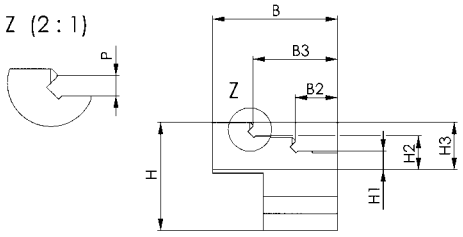
Note:

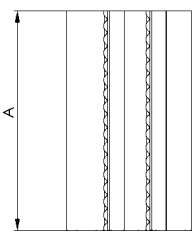
To interchange the chucks, only an AF8 inner hexagon is required.
The chucks are supplied in pairs.

No. 6377BG

Clamping Jaws, ribbed

for centering vice, size 65.





Order no.	Size	A	B	B2	B3	H	H1	H2	H3	P	Weight [g]
550659	**65**	65	37	12,5	25	32	5,5	10	14	3	510

Design:

Chuck with ribbed clamping surfaces from case hardened steel, nitro-carburised and oxidised.
Suitable for „Black-Edition“ centering chuck, size 65.

Application:

The chucks can be simply and quickly interchanged and/or replaced on the „Black-Edition“ centering chuck, size 65.

Note:

To interchange the chucks, only an AF8 inner hexagon is required.
The chucks are supplied in pairs.

Subject to technical alterations.

Centering vice
„Black-Edition“

Clamping nipple

4-point clamping station,
mechanical

Subject to technical alterations.

YOU ALREADY HAVE A CLAMPING SYSTEM?!
YOU CAN STILL TAKE ADVANTAGE OF OUR BENEFITS ...

With our „Gonzales“ and „Unitool“ clamping modules, we offer you flexibility in retrofitting and expanding your existing zero-point clamping technology. As a result, a complete replacement of the system you currently use is no longer absolutely necessary. You keep your investment as low as possible and still take advantage of the benefits of the AMF Zero-Point System.

„GONZALES“ CLAMPING MODULE (FIG. LEFT)

Your existing Speedy 1000/2000 or DockLock 1000 modules can be exchanged for our corresponding „Gonzales“ modules if you meet the following requirements:

- Unlike Speedy 1000/2000 and DockLock 1000, „Gonzales“ requires a hydraulic unclamping pressure of min. 50 bar / max. 60 bar.
- With countersunk installation, replacement is only possible if there is enough space for the larger covers of the „Gonzales“ modules (cover dia. 112 mm or 140 mm).
- Modules with media ducts cannot be exchanged
- Use „Gonzales“ modules exclusively with „Gonzales“ modules in one clamping.

With the „Gonzales“ modules, the corresponding nipples of the systems Speedy 1000/2000 and DockLock 1000 can be clamped.

„Gonzales“ nipples can be clamped with the corresponding Speedy 1000/2000 and DockLock 1000 modules.

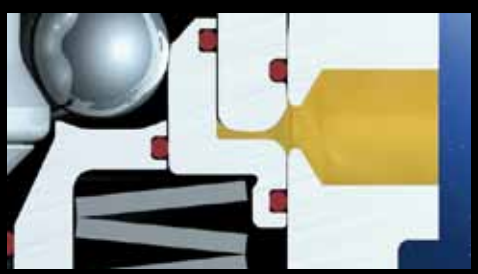
„UNITOOL“ CLAMPING MODULE (FIG. RIGHT)

Our „Unitool“ clamping module fits the nipple of the Unilock system (dia. 40 mm). The Unitool nipple also fits the Unilock system module (NSE-138).

STAINLESS STEEL

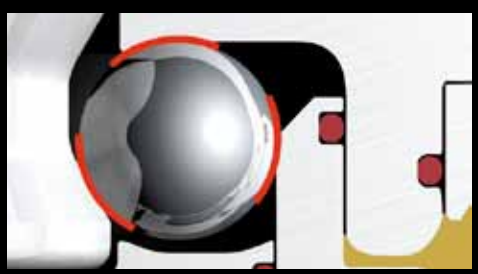
High-alloy, hardened tool steel - and so no corrosion.

SAFETY SYSTEM



Process reliability - Clamping module always opens. A piston blockade is thus impossible (only Gonzales modules).

FORM FIT



The balls are optimally encapsulated on 3 sides. As a result, the clamping nipple always remains firmly clamped in the module.

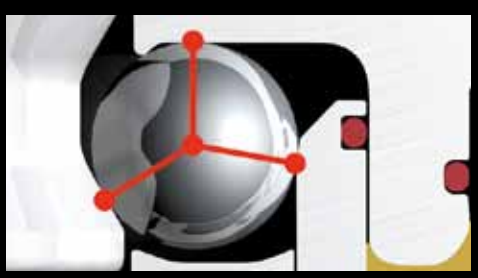
NO BALL CAGE

The balls lie freely in the ball canal. This freedom of movement enables the balls to continuously re-position themselves.

SWING-FREE

Swing-free run-in and run-out through the optimal contour of the clamping nipple (only Gonzales modules).

THREE-POINT PRINCIPLE



Power transmission by means of the three-point principle! This optimised force distribution prevents shearing load on the balls.

All depictions are model presentations of the functional principle.

Installation clamping module “Gonzales”

No. 6370EGRH

Installation clamping module “Gonzales”, round

Hydraulic opening.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Speedy	DockLock	Weight [Kg]
305201	1000	15	25	●	-	2,3
306043	1000	15	25	-	●	2,3
305219	2000	25	55	●	-	3,5

Application:

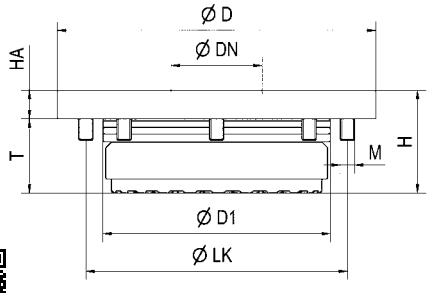
Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

Use „Gonzales“ modules exclusively with „Gonzales“ modules in one clamping. When changing systems, observe the following: Unlike Speedy 1000/2000 and DockLock 1000, „Gonzales“modules require an unclamping pressure of min. 50 bar / max. 60 bar. With recessed installation, observe the cover diameter D 112 mm / 140 mm. The installation clamping module is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module has one connection: 1x hydr. opening (1).

On request:

- Installation diagrams
- Automation solutions



CAD

Dimensions:

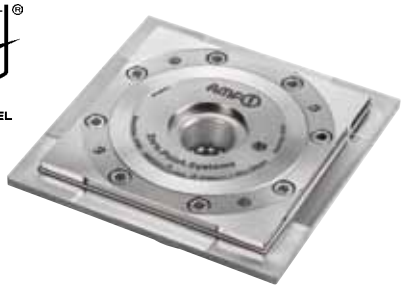
Order no.	Size	dia. D	dia. DN	dia. D1	H	HA	dia. LK	M	T
305201	1000	112	32	80	36	10	92	8 x M5	26
306043	1000	112	32	80	36	10	91	10 x M5	26
305219	2000	140	47	110	36	10	122	8 x M5	26

No. 6370EGQH

Installation clamping module “Gonzales”, square

Hydraulic opening.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL



Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
305227	1000	15	25	2,3
305235	2000	25	55	3,5

Application:

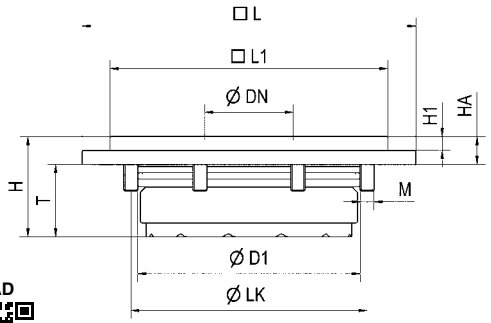
Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry. A square clamping module prevents the pallet from twisting. The indexing function enables positioning every 90°. Specially suitable for use in turning.

Note:

Use „Gonzales“ modules exclusively with „Gonzales“ modules in one clamping. When changing systems, observe the following: Unlike Speedy 1000/2000 and DockLock 1000, „Gonzales“modules require an unclamping pressure of min. 50 bar / max. 60 bar. With recessed installation, observe dimension L 120 mm / 150 mm. The clamping module is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module has one connection: 1x hydr. opening (1).

On request:

- Installation diagrams
- Automation solutions



CAD

Dimensions:

Order no.	Size	dia. DN	dia. D1	H	HA	H1	L	L1	dia. LK	M	T
305227	1000	32	80	36	10	5	120	100	92	M5	26
305235	2000	47	110	36	10	5	150	130	122	M5	26

Subject to technical alterations.

No. 6370AGRH

Suface-mounted clamping module “Gonzales”, round

Hydraulic opening.
Opening operating pressure: min. 50 bar - max. 60 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei
STAINLESS STEEL

Order no.	Size	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
303362	**1000**	15	25	2,3
303388	**2000**	25	55	3,5

Application:

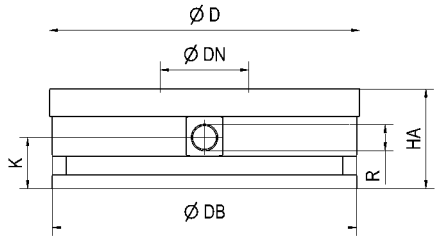
Zero-point clamping system in combination with clamping flanges 6370ZB for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

Use „Gonzales“ modules exclusively with „Gonzales“ modules in one clamping. When changing systems, observe the following: Unlike Speedy 1000/2000 and DockLock 1000, „Gonzales“modules require an unclamping pressure of min. 50 bar / max. 60 bar. The surface-mounted clamping module is opened hydraulically (1) and mechanically locked through spring force. Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free).
The clamping module has one connection: 1x hydr. opening (1).

On request:

- Automation solutions



Dimensions:

Order no.	Size	dia. D	dia. DB	dia. DN	HA	K	R
303362	**1000**	112	110	32	40	18,5	G1/8
303388	**2000**	140	139	47	40	18,5	G1/8

CAD

Subject to technical alterations.

No. 6370EURL

Installation clamping module “Unitool”, round

Pneumatic opening.
Opening operating pressure: min. 8 bar - max. 12 bar
Retensioning operating pressure (turbo): min. 5 bar - max. 6 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL

Order no.	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
303560	30	55	3,2

Application:

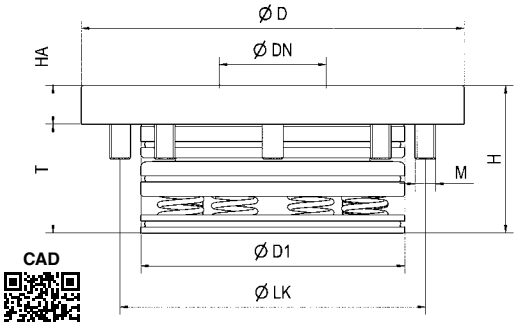
Zero-point clamping system for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

The installation clamping module has high holding, pull-in and locking forces. This is opened pneumatically (1) and mechanically locked through spring force. To achieve the specified pull-in and locking forces, it must be briefly retensioned pneumatically (turbo) (2). Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free). Use of the pneumatic pressure booster 6370ZVL-005 is recommended.
The clamping module has two connections:
1x pneum. opening (1) / 1x pneum. retensioning (turbo) (2).
Use „Unitool“ modules exclusively with „Unitool“ modules in one clamping.

On request:

- Installation diagrams
- Automation solutions



CAD

Dimensions:

Order no.	dia. D	dia. DN	dia. D1	H	HA	dia. LK	M	T
303560	148	40	102	57	15	118	M8	42

No. 6370AURL

Suface-mounted clamping module “Unitool”, round

Pneumatic opening.
Opening operating pressure: min. 8 bar - max. 12 bar
Retensioning operating pressure (turbo): min. 5 bar - max. 6 bar
Cover and piston hardened.
Repeatability < 0.005 mm.

EDELSTAHL Rostfrei STAINLESS STEEL

Order no.	Pull-in/locking force up to [kN]	Holding force [kN]	Weight [Kg]
303586	30	55	6,5

Application:

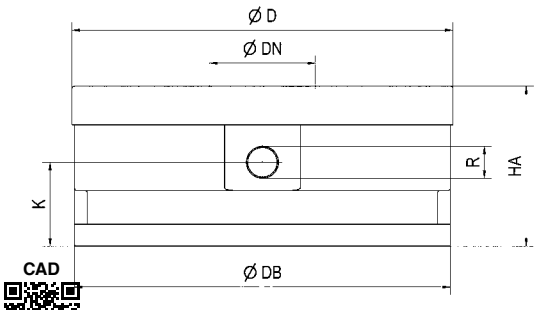
Zero-point clamping system in combination with clamping flanges 6370ZB for set-up-time-optimized clamping with cutting and non-cutting processing in all areas, also in the food, pharmaceutical and chemical industry.

Note:

The surface-mounted clamping module has high holding, pull-in and locking forces. This is opened pneumatically (1) and mechanically locked through spring force. To achieve the specified pull-in and locking forces, it must be briefly retensioned pneumatically (turbo) (2). Subsequent uncoupling of the pressure lines is possible at all times (module is tensioned pressure-free). Use of the pneumatic pressure booster 6370ZVL is recommended.
The clamping module has two connections:
1x pneum. opening (1) / 1x pneum. retensioning (turbo) (2).
Use „Unitool“ modules exclusively with „Unitool“ modules in one clamping.

On request:

- Automation solutions



CAD

Dimensions:

Order no.	dia. D	dia. DB	dia. DN	HA	K	R
303586	148	146	40	62	32,5	G1/4

Subject to technical alterations.

No. 6370ZNG-10

Clamping nipple „Gonzales 1000“

Hardened.
Clamping nipples can also be used in the modules Speedy 1000 and DockLock 1000.

EDELSTAHL Rostfrei STAINLESS STEEL

Order no.	Size	dia. DN	dia. D1	H	M	T	Weight [g]
303404	1000	32	25	34,0	M8	4,8	70
303420	1000	32	25	34,0	M8	4,8	70
303446	1000	32	25	34,0	M8	4,8	70
303461	1000	32	-	29,2	M8	12,0	55

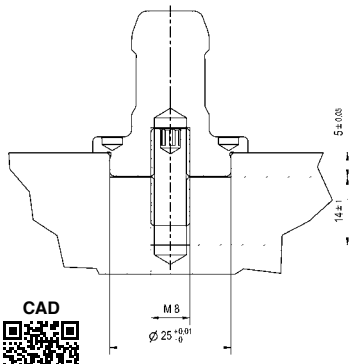
Design:

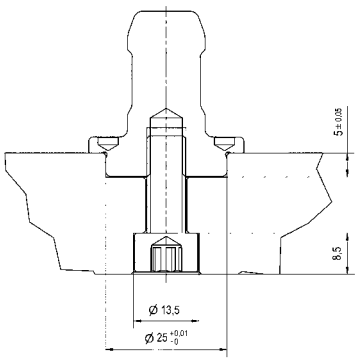
Order no. 303404: Zero point nipple
Order no. 303420: Timing nipple
Order no. 303446: Undersized nipple
Order no. 303461: Protection nipple

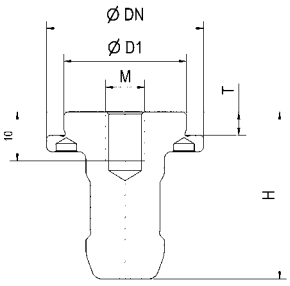
Note:

Tightening torque of the clamping nipple max. 20 Nm. Min. screw grade 8.8.

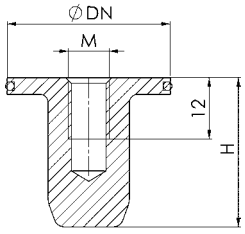
Dimensions for the nipple mounting:







303404, 303420, 303446



303461

CAD

No. 6370ZNGH-10

Clamping nipple „Gonzales 1000“

with high collar, hardened.
Clamping nipples can also be used in the modules Speedy 1000 and DockLock 1000.

EDELSTAHL Rostfrei STAINLESS STEEL

Order no.	Size	dia. DN	dia. D1	H	M	T	Weight [g]
305128	1000	32	25	49	M8	19,8	125
305144	1000	32	25	49	M8	19,8	125
305169	1000	32	25	49	M8	19,8	125
303461	1000	32	-	29,2	M8	12,0	55

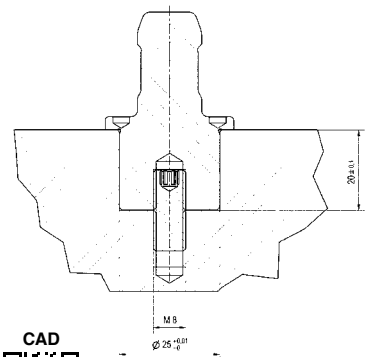
Design:

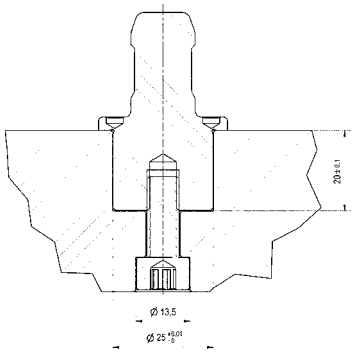
Order no. 305128: Zero point nipple
Order no. 305144: Timing nipple
Order no. 305169: Undersized nipple
Order no. 303461: Protection nipple

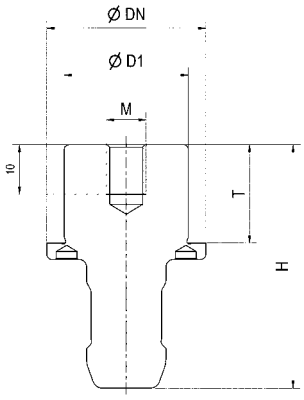
Note:

Tightening torque of the clamping nipple max. 20 Nm. Min. screw grade 8.8.

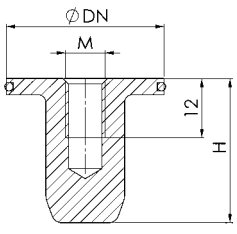
Dimensions for the nipple mounting:







305128, 305144, 305169



303461

CAD

Subject to technical alterations.

No. 6370ZNG-20

Clamping nipple „Gonzales 2000“

Hardened.
Clamping nipples can also be used in Speedy 2000.

EDELSTAHL Rostfrei
STAINLESS STEEL

Order no.	Size	dia. DN	dia. D1	dia. D2	H	M	T	Weight [g]
303412	2000	47	25	10,8	34,0	M12	4,8	170
303438	2000	47	25	10,8	34,0	M12	4,8	170
303453	2000	47	25	10,8	34,0	M12	4,8	170
303479	2000	47	-	-	29,2	M 8	12,0	180

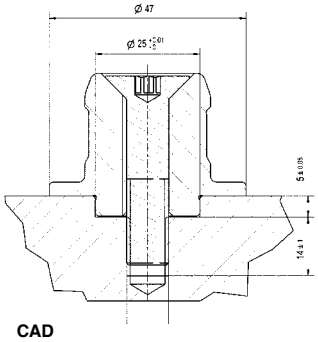
Design:

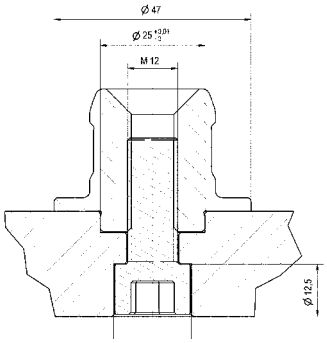
Order no. 303412: Zero point nipple
Order no. 303438: Timing nipple
Order no. 303453: Undersized nipple
Order no. 303479: Protection nipple

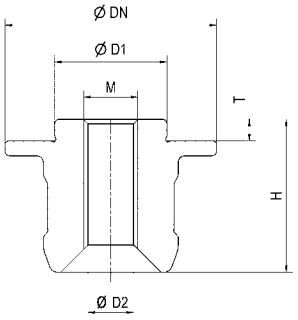
Note:

Tightening torque of the clamping nipple max. 20 Nm. Min. screw grade 8.8.

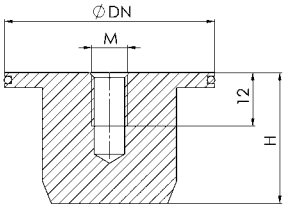
Dimensions for the nipple mounting:







303412, 303438, 303453



303479

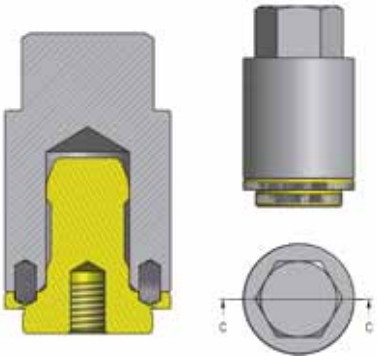
CAD

No. 6370ZNSG

Nipple key „Gonzales“

for clamping nipple no. 6370ZNG/ZNGH „Gonzales 1000“.

Order no.	SW [mm]	Weight [g]
306001	22	80



Subject to technical alterations.

No. 6370ZNU

Clamping nipple „Unitool“

Hardened.
Clamping nipples can also be used in the Unilock system (Ø 40 mm).

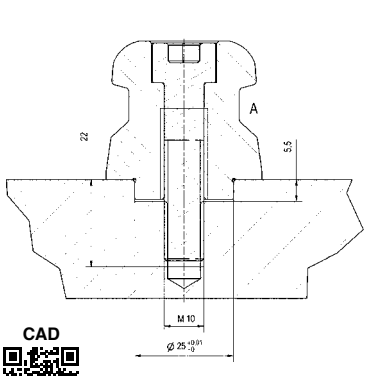
EDELSTAHL Rostfrei
STAINLESS STEEL

Order no.	dia. DN	dia. D1	dia. D2	H	M	T	Weight [g]
304352	40	25	10	40,0	M12	4,8	230
304592	40	25	10	40,0	M12	4,8	230
304618	40	25	10	40,0	M12	4,8	230
304634	40	-	-	34,7	M 8	12,0	220

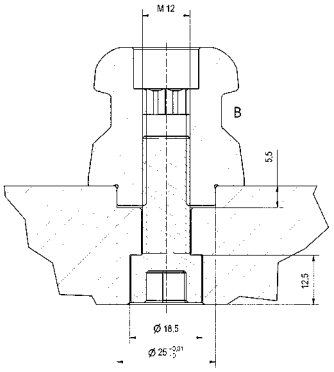
Design:

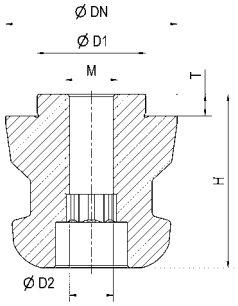
Order no. 304352: Zero point nipple
Order no. 304592: Timing nipple
Order no. 304618: Undersized nipple
Order no. 304634: Protection nipple

Dimensions for the nipple mounting:

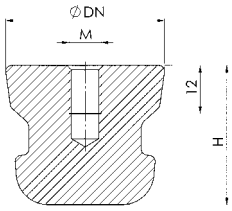


CAD

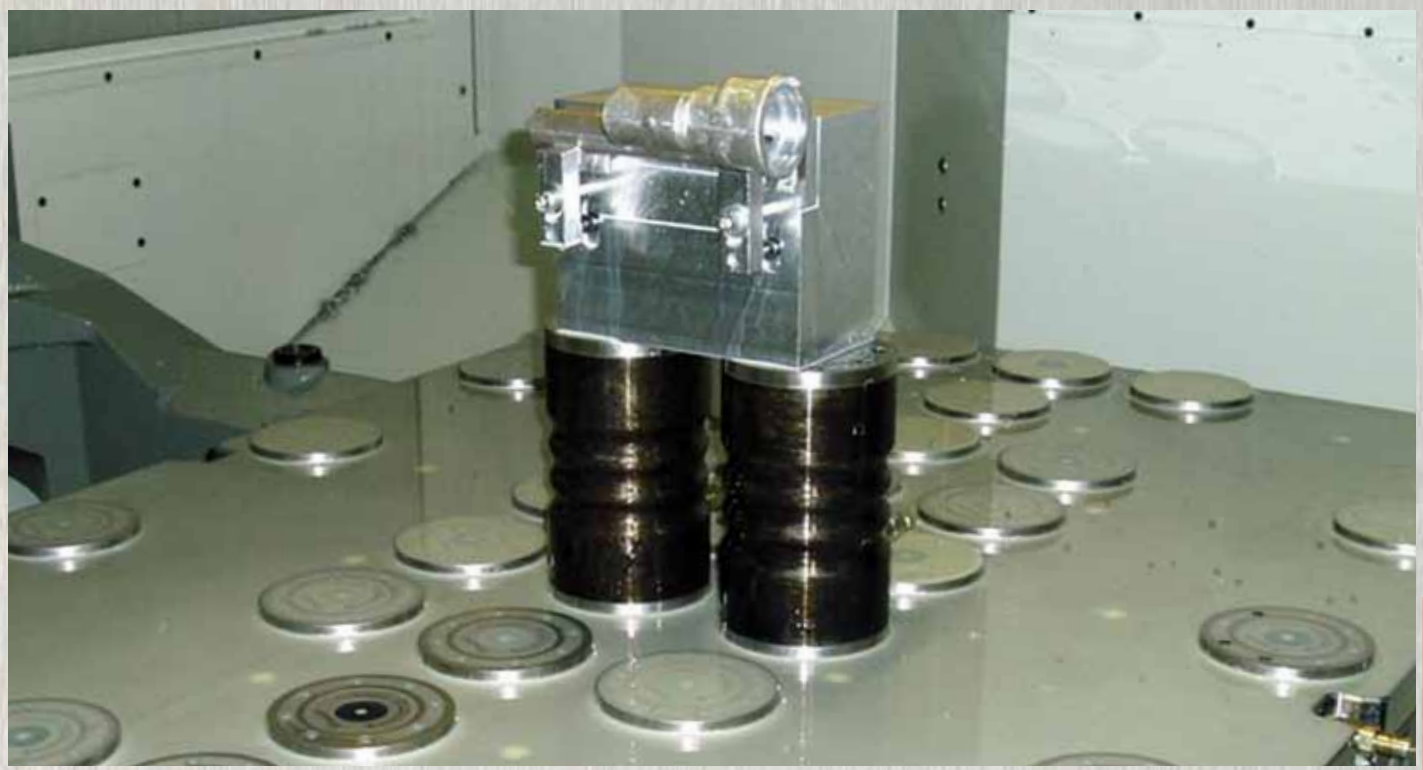




304352, 304592, 304618



304634



Subject to technical alterations.

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LOW-COST AUTOMATION FOR MACHINE TOOLS - CASSETTE BUFFER MAGAZINE AND GRIPPER FROM AMF

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Here we offer you an efficient alternative to expensive robots or automation cells. Existing shift models can be supplemented simply and flexibly by one or more worker-free shifts. This dramatically increases your machine run time and makes your entire production more economical.

THE ADVANTAGES AT A GLANCE:

- Economical and flexible automation solution
- Production of different workpieces in one loading
- Simple control by means of M-commands
- Cassette buffer magazine serves as storage and/or transport unitt
- Combined application of various gripper types

Talk to us about it!

Subject to technical alterations.

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These conditions of sale apply to business conducted with companies, legal entities in the public sector, and legal entities with special budget in the public sector. Our deliveries and services are carried out exclusively on the basis of the conditions stated below. Deviating purchasing conditions of the buyer will not become part of the contract, not even through acceptance of the order, unless we have expressly accepted them.

1. Offer and entering into a contract

The basis of our delivery contracts is the latest edition of our catalogue. Orders are not considered as accepted until they have been confirmed by us in writing. When goods are supplied from stock and, for organisational reasons, you receive no separate confirmation, the invoice has the additional function of confirming the order. Details of dimensions and weights, and illustrations, drawings and data are not binding and may be changed by us at any time. Deviations cannot be excluded.

2. Prices

Prices are quoted in EUR ex-works excluding turnover tax, packing, freight, carriage, and insurance. Unless otherwise agreed, our list prices on the day of delivery apply. In order to cover our costs, orders under EUR 50.– net value are subject to a small order surcharge of EUR 10.–.

3. Delivery

Delivery delays are quoted to the best of our knowledge but without guarantee. Agreed delivery delays begin on the day we accept the order and refer to the completion of the goods in our works.

4. Transfer of risk

Risks are transferred to you when the goods are passed to a specific person, company, or organisation that is charged with the execution of carriage of the goods. This applies also to partial deliveries and when we have accepted the costs of carriage, delivery or erection. The risks are also transferred to you when you have defaulted on acceptance.

5. Dispatch

Goods are supplied ex-works. Dispatch is at your cost and risk. Scheduled, FOB, and CIF deliveries are also at your risk. In the absence of specific instructions concerning dispatch, we will arrange same as we think fit, but without accepting any responsibility for choosing the cheapest or most suitable method of dispatch. We make a handling charge of EUR 5.– if goods are sent at your request to a third party. You accept that your order can be supplied in partial deliveries insofar as this is reasonable.

6. Reservation of proprietary rights

Goods delivered remain our property until payment of all claims has been received in full or until redemption of cheques given in payment. The cancellation of individual positions in an open invoice and the drawing of a balance and its acceptance do not affect proprietary rights. You have the right to dispose of the goods as a normal commercial transaction, but you are forbidden to pawn, mortgage, or transfer ownership of them in settlement of a debt or debts. You surrender to us herewith your right to payment for goods for which we reserve our proprietary rights. You have the right to collect these payments as long as you meet your obligations to us. If we request it, you are obliged to name the third party and we have the right to publish this information and the transfer of rights.

7. Cancellation rights due to late payment or insolvency

If you do not pay for the goods by the time payment is due, and if you have not paid after expiry of a reasonable time limit set by us, we have the right to withdraw from the contract and demand the return of goods already supplied. Rights under § 323 BGB (BGB = German civil law code) remain otherwise unaffected. Application for the opening of insolvency proceedings gives us the right to withdraw from the contract and demand the immediate return of goods supplied before the bankruptcy court orders protective measures.

8. Packaging

Packages comply with the German packaging regulations (WO). Disposable packaging is charged at cost. The packaging is not returnable.

9. Tooling costs

In the absence of any agreement to the contrary, tooling made for the execution of an order remains our property in all cases. This applies even if we have made a charge for a proportion of the tooling costs.

10. Payment

Our invoices are payable net within 30 days of the date of the invoice, or with 2% discount if paid within 10 days. Invoices below EUR 50.– are payable immediately without discount. Our credit notes and your charges on us reduce the amount subject to discount. Late payment entitles us to interest at the rate the bank charges us for a current account overdraft but at least 8 percent above the current base rate of the European Central Bank. If payment is overdue, we are entitled, after giving you notice in writing, to cease fulfilling our obligations under the contract until payment is received.

11. Offsetting exclusion

You can only offset payments with legally-established or unopposed counter claims.

12. Guarantee

If you come to an agreement with us on properties of the goods, we include this agreement in our technical specifications. If we have to supply to your drawings, specifications, samples, etc., you accept the risk associated with suitability for the intended purpose. The point in time at which risk is transferred is decisive for the contractual condition of the goods. The deterioration of parts subject to wear in the course of normal use does not constitute a defect. If the goods supplied are defective, we will – at our choice and within a reasonable time limit set by you – supply a replacement or repair the goods. If such repair or replacement is not satisfactory, you have the right to reduce the price or withdraw from the contract. Any further guarantee claims are excluded. Recognisable defects must be notified at the latest within 10 days of receipt and defects that are not recognisable must be notified as soon as they are discovered. The guarantee period is 24 months and starts with dispatch of the goods from our works.

13. Hindered or impossible performance

If we are prevented from meeting our obligation by some unforeseeable event (e.g. disruption of our plant, or delay in the delivery of important raw materials), which, in spite of taking all reasonable care appropriate to the circumstances of the case, we have been unable to avert, and it has become impossible to execute the delivery or service punctually, the delivery delay will be extended to an appropriate extent.

14. Liability

Except in the case of injury to life or limb, or damage to health caused by our breach of duty, we are only liable in the event of intent or culpable negligence on our part.

15. Customer specials

Orders for customer specials must be in writing and include binding details of execution, quantities etc. For technical reasons we reserve the right to supply 10% more or less than the quantity specified. If technical changes or cancellation are required, the costs incurred will be charged to the customer.

16. Deliveries of samples and return of goods

Samples will be charged. When goods have been sent for testing or as samples, we will credit you with the additional price against subsequent orders, as long as the net contract value is at least EUR 125.–. The return of goods is only possible with prior agreement. Customer specials may not be returned. For goods returned for reasons outside our responsibility (e.g. wrongly ordered), we charge 10% of the value of the goods but at least EUR 7.50, to cover administration costs.

17. Place of fulfilment, court of jurisdiction

The place of fulfilment for all obligations arising from this contract is D-70707 Fellbach. The court of jurisdiction for any legal dispute arising from this contract is D-71332 Waiblingen. (All disputes that arise from this contract or about its validity will be decided by a court of arbitration according to the Arbitration Rules of the German Committee for Arbitration Courts/Settlement and Arbitration Procedure of the International Chamber of Commerce. Such decisions will be final and normal legal procedures are excluded.) German law applies (BGB and HGB = civil and commercial codes). The application of UN purchasing law (CISG) is excluded.

18. Validity clause

If individual conditions should be found to be not legally valid, the remaining conditions continue to apply. The invalid conditions will be replaced by conditions which fulfil as closely as possible the commercial intent of the contract with reasonable consideration of the interests of both parties. With the publication of these Conditions for Sales, Deliveries and Payment, all previous versions become invalid. This does not apply to contracts agreed before publication.

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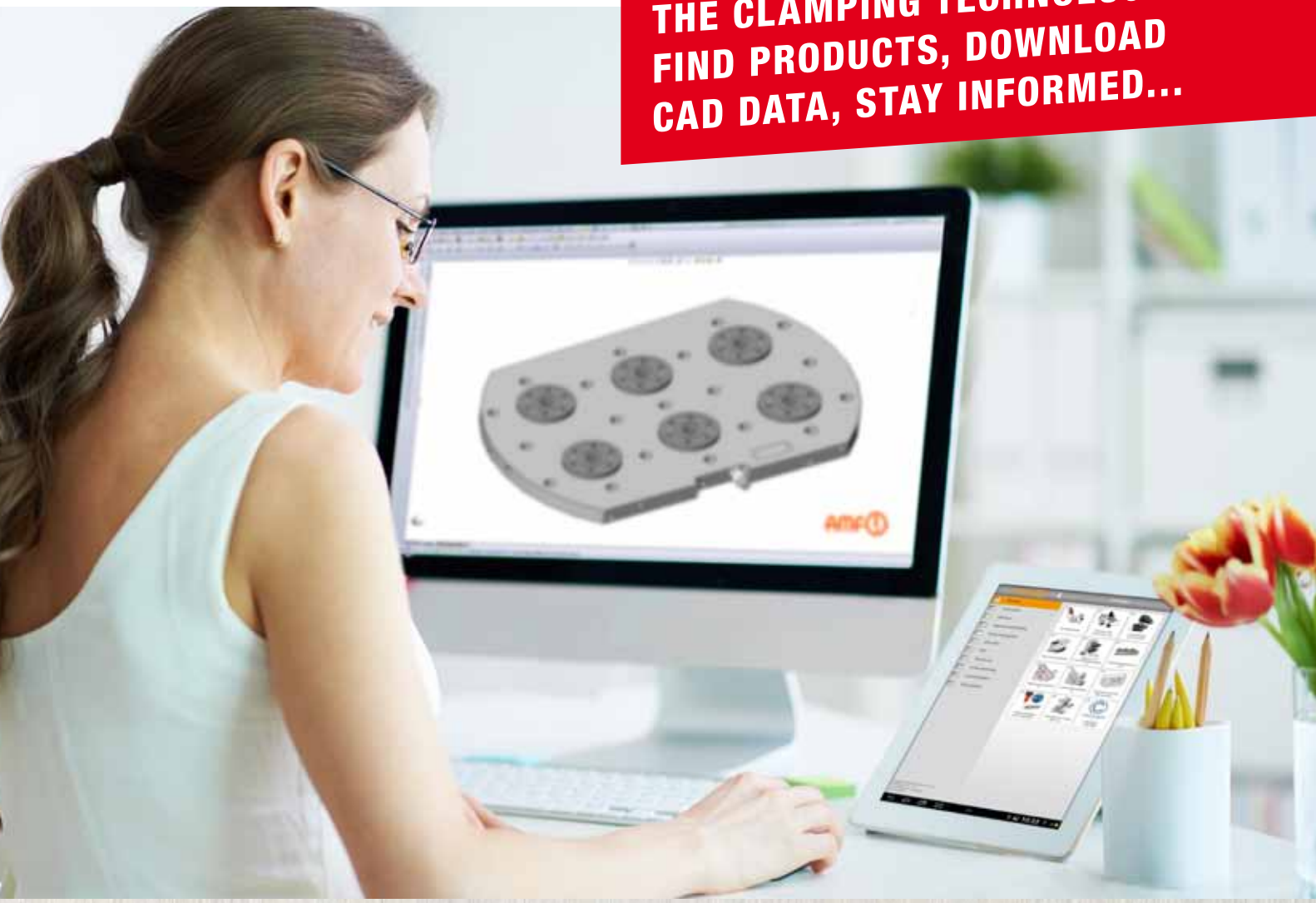

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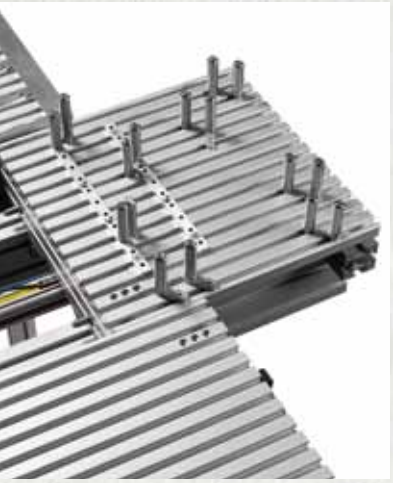

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