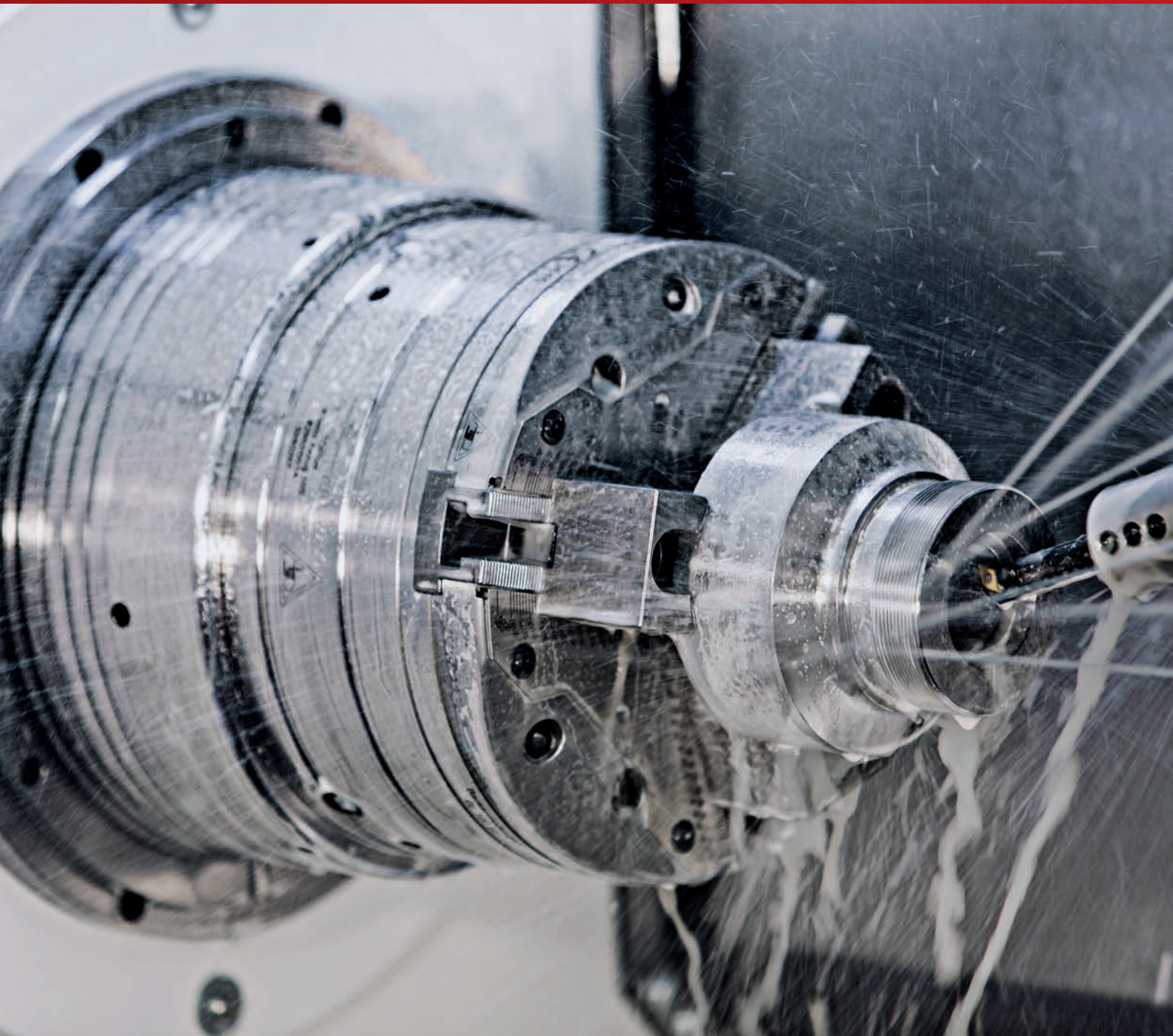


PRODUCTS









**Adaptation clamping devices**

# Overview

Find what's important fast



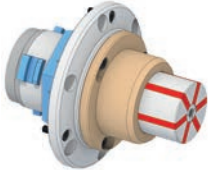





Adaptation clamping devices

	MANDO Adapt [mandrel adaptation]	 270
	Jaw modules	 316
	Face driver / morse taper adaptation	 324
	Magnet module	 332

# PRODUCTS





## Adaptation clamping devices

### Adaptation clamping devices at a glance

	<b>MANDO Adapt</b>	<b>Jaw module</b>	<b>Face driver adaptation</b>
			
Description	Adaptation for I.D. clamping	Adaptation for jaw clamping [O.D. clamping]	Adaptation for clamping between centers
Sizes	XXS, XS, S, 0, 1, 2, 3, 4, 5, 6, 7	145, 215	42, 52, 65, 80, 100
Clamping range of all sizes [mm]	8 – 190	15 – 209	–
Variant	SE [hexagonal], RD [round]	SE [hexagonal], RD [round]	SE [hexagonal], RD [round]
<b>Advantages</b>	<ul style="list-style-type: none"> <li>■ Extremely fast conversion without detachment of the basic clamping device [1 – 2 min.]</li> <li>■ Large clamping range and vibration dampening due to vulcanized clamping elements</li> <li>■ Standard segmented clamping bushings and workpiece end-stops for machining to size available</li> </ul>	<ul style="list-style-type: none"> <li>■ Jaw clamping in the HAINBUCH chuck or stationary chuck</li> <li>■ Extremely fast conversion without detachment of the base clamping device [2 min.]</li> <li>■ Self-centering on the basic clamping device</li> <li>■ Enlarges clamping range of the basic clamping device</li> <li>■ Deadlength clamping without pull-back effect</li> <li>■ Optimal lubrication and resistant to contamination thanks to the lubricating system</li> </ul>	<ul style="list-style-type: none"> <li>■ Spring-loaded center</li> <li>■ Hard metal face driver</li> <li>■ Assembly in 1 minute without alignment</li> </ul>
	 <b>Page 270</b>	 <b>Page 316</b>	 <b>Page 324</b>

# PRODUCTS

## Adaptation clamping devices

Morse taper adaptation	Magnet module
	
Adaptation to the MK4 reception	Adaptation for magnetic clamping
42, 52, 65, 80, 100	52, 65, 80, 100
-	-
SE [hexagonal], RD [round]	SE [hexagonal], RD [round]
<ul style="list-style-type: none"> <li>■ Adaptation possibility via morse taper</li> <li>■ Assembly in 1 minute without alignment</li> <li>■ Self-centering of the adaptation in the chuck without alignment</li> </ul>	<ul style="list-style-type: none"> <li>■ End face axial clamping via neodymium magnet</li> <li>■ High face-run change-over accuracy</li> <li>■ High holding power of 140 N/cm<sup>2</sup></li> <li>■ Assembly in 30 seconds without alignment</li> <li>■ Low maintenance because it is resistant to contamination</li> </ul>
 <b>Page 324</b>	 <b>Page 332</b>

Adaptation clamping devices

Measuring technology/ Automation

Quick change-over systems

Special solutions

Clamping elements/ Accessories

Services

Multi spindles





# MANDO Adapt

Mandrel-in-clamping-device





## ADAPTATION CLAMPING DEVICES **MANDO Adapt [mandrel adaptation]**

Change-over from O.D. clamping to perfect I.D. clamping, without changing the clamping device? No problem with MANDO Adapt. Place the mandrel in the mounted clamping device, tighten three screws and lock the mandrel in the clamping device. In this process the mandrel engages in the coupling of the clamping device via a sophisticated mechanism, where otherwise the clamping head engages. MANDO Adapt is attractive with extreme rigidity and precision. For rotating products, run-out of 0.005 mm between chuck taper and mandrel taper can be achieved. For stationary clamping devices repeatability of 0.003 mm is possible. And best of all, this can be accomplished without alignment.

**Ingeniously simple and effective, genuine HAINBUCH!**

### **Key advantages**

- Extremely fast conversion without detachment of the basic clamping device [1 – 2 min.]
- Large clamping range and vibration dampening due to vulcanized clamping elements
- Standard segmented clamping bushings and work-piece end-stops for machining to size available

# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt at a glance

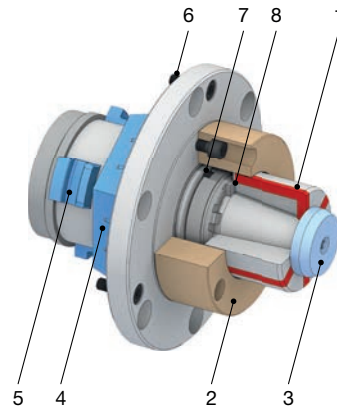
	<b>MANDO Adapt T211</b>	<b>MANDO Adapt T212</b>	<b>MANDO Adapt T812</b>
			
Description	Mandrel-in-clamping-device, with draw bolt / pull-back	Mandrel-in-clamping-device, without draw bolt / pull-back	Mandrel-in-clamping-device, without draw bolt / deadlength
Sizes	0, 1, 2, 3, 4	XXS, XS, S, 0, 1, 2, 3, 4, 5, 6, 7	XS, S, 0, 1, 2, 3, 4
Clamping range of all sizes [mm]	20 – 120	8 – 190	13 – 100
Variant	SE [hexagonal], RD [round]	SE [hexagonal], RD [round]	RD [round]
Actuation	Draw	Draw	Pressure
<b>Advantages</b>	<ul style="list-style-type: none"> <li>■ Workpiece stabilization through axial draw force applied against the workpiece end-stop</li> <li>■ Less expensive segmented clamping bushings and end-stops compared to MANDO T212</li> </ul>	<ul style="list-style-type: none"> <li>■ Workpiece stabilization through axial draw force applied against the workpiece end-stop</li> <li>■ Clamping without draw bolt, consequently ideal for blind bores</li> </ul>	<ul style="list-style-type: none"> <li>■ Radial clamping, without pull-back – ideal for pick-off the main spindle</li> <li>■ Clamping without draw bolt, consequently ideal for blind bores</li> </ul>



**MANDO Adapt T211 SE in detail**

**Designation**

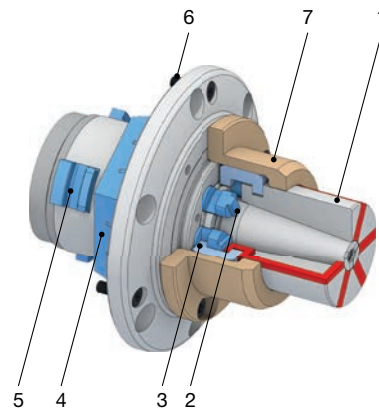
- 1 Vulcanized segmented clamping bushing made of case-hardened steel [60 HRC]
- 2 End-stop
- 3 Draw bolt
- 4 CENTREX system for  $\mu\text{m}$ -precise use without adjustment
- 5 Coupling: Mandrel locks automatically when the draw bolt is screwed in
- 6 Mounting screws for quick change-over
- 7 Integrated, and thus optimal forced release of the clamping
- 8 Torsional safety lock of segmented clamping bushing



**MANDO Adapt T212 SE in detail**

**Designation**

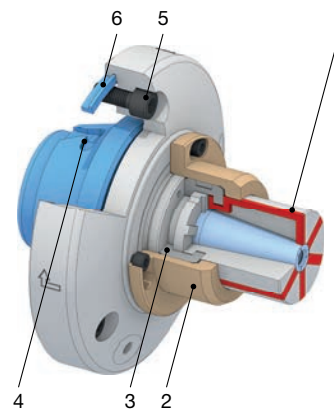
- 1 Vulcanized segmented clamping bushing made of case-hardened steel [60 HRC]
- 2 High rigidity due to one-piece crown coupling with integrated entrainment of the segmented clamping bushing
- 3 Coupling ring for fast changing of the segmented clamping bushing
- 4 CENTREX system for  $\mu\text{m}$ -precise use without adjustment
- 5 Coupling: Mandrel is locked via separate key
- 6 Mounting screws for quick change-over
- 7 End-stop



**MANDO Adapt T812 RD in detail**

**Designation**

- 1 Vulcanized segmented clamping bushing made of case-hardened steel [60 HRC]
- 2 End-stop
- 3 Coupling ring for fast changing of the segmented clamping bushing
- 4 Bayonet coupling
- 5 Mounting screws for quick change-over
- 6 CENTREX system for  $\mu\text{m}$ -precise use without adjustment



Adaptation clamping devices

Measuring technology/ Automation

Quick change-over systems

Special solutions

Clamping elements/ Accessories

Services

Multi spindles



# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T211 SE. Order overview

Size	Clamping range [mm]	Adap-tation size	Material no.	In stock	Suitable for							
					TOPlus mini pull-back Page 26	TOPlus premium pull-back Page 46	TOPlus combi pull-back Page 58	TOPlus modular Page 58	TOROK SE Page 122	HYDROK SE Page 252	MANOK plus SE Page 244	
<b>0</b>	20 – 28	52	10000999	-	✓	✓						
			10001574	✓		✓	✓	✓	✓	✓	✓	
		65	10001002	✓	✓							
			10001577	✓		✓	✓	✓	✓	✓	✓	
		80	10017061	✓	✓							
		100	10001007	✓		✓						
10001582	✓				✓	✓	✓	✓	✓	✓		
<b>1</b>	26 – 38	52	10001000	-	✓	✓						
			10001575	✓		✓	✓	✓	✓	✓		
		65	10001003	✓	✓							
			10001578	✓		✓	✓	✓	✓	✓	✓	
		80	10017067	✓	✓							
		100	10001008	✓		✓						
10001583	✓				✓	✓	✓	✓	✓			
<b>2</b>	36 – 54	52	10001001	-	✓	✓						
			10001576	✓		✓	✓	✓	✓	✓		
		65	10001004	✓	✓							
			10001579	✓		✓	✓	✓	✓	✓	✓	
		80	10017068	✓	✓							
		100	10001009	✓		✓						
10001584	✓				✓	✓	✓	✓	✓			
<b>3</b>	50 – 80	65	10001005	✓	✓							
			10001580	✓		✓	✓	✓	✓	✓		
		80	10017069	✓	✓							
		100	10001010	✓		✓						
10001585	✓				✓	✓	✓	✓	✓			
<b>4</b>	69 – 120	65	10001006	✓	✓							
			10001581	✓		✓	✓	✓	✓	✓		
		80	10017070	✓	✓							
		100	10001011	✓		✓						
			10001586	✓			✓	✓	✓	✓	✓	

Detailed technical data follows.

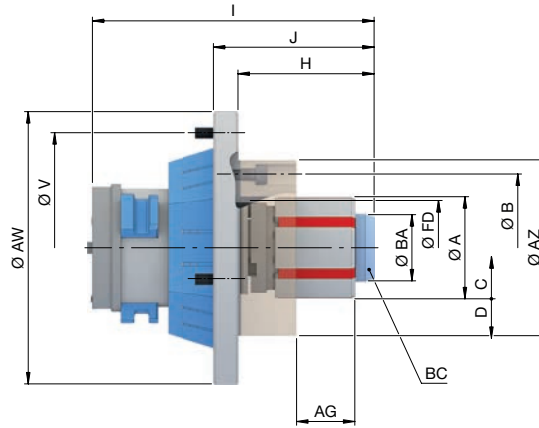
#### Scope of delivery

- Adaptation mandrel
- Draw bolt



# ADAPTATION CLAMPING DEVICES MANDO Adapt [mandrel adaptation]

## MANDO Adapt T211 SE. Technical data



Size	0							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A		20 – 28					
Run-out ≤ [mm]	0,010							
Max. radial clamping force [kN]	42							
Max. axial drawtube force [pull / push] [kN]	10							
Max. clamping length [mm]	AG		22					
Release stroke in Ø [mm]	C		0,4					
Reserve stroke in Ø [mm]	D		0,3					
Range / recommended workpiece tolerance [mm]	± 0,25							
RPM n max. [1/min.]	7000		6000		5500	5000		
Max. actuating torque [Nm]	BC		10					
Draw bolt Ø [mm]	BA		19					
Reception workpiece end-stop	FD		Ø 32 f7					
End-stop outer Ø [mm]	AZ		65					
Bolt hole circle end-stop	B		LK Ø 50 [3 x M6]					
Length [mm]	H		42,3		42			
Total length [mm]	I		109		119		129	
Height [mm]	J		55					
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	119	125	129	144	150	183	215
Weight [kg]		2,2		3,3	3,4	5	8,1	9
In stock		-	✓	✓	✓	✓	✓	✓
Material no.		10000999	10001574	10001002	10001577	10017061	10001007	10001582

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



Adaptation clamping devices

Measuring technology / Automation

Quick change-over systems

Special solutions

Clamping elements / Accessories

Services

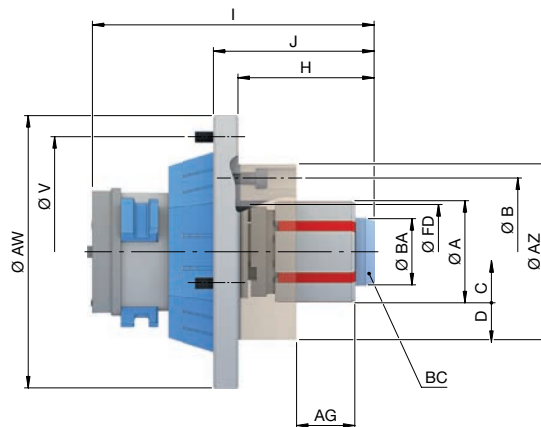
Multi spindles

# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T211 SE. Technical data



Size	1						
Adaptation size	52		65		80	100	
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium
Clamping range [mm]	A		26 – 38				
Run-out ≤ [mm]	0,010						
Max. radial clamping force [kN]	42						
Max. axial drawtube force [pull / push] [kN]	10						
Max. clamping length [mm]	AG		26				
Release stroke in Ø [mm]	C						
Reserve stroke in Ø [mm]	D						
Range / recommended workpiece tolerance [mm]	± 0,25						
RPM n max. [1/min.]	7000		6000		5500	5000	
Max. actuating torque [Nm]	BC		20				
Draw bolt Ø [mm]	BA						
Reception workpiece end-stop	FD						
End-stop outer Ø [mm]	AZ						
Bolt hole circle end-stop	B						
Length [mm]	H		52			51,5	
Total length [mm]	I		129			139	
Height [mm]	J						
Bolt hole circle	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW		69				
Weight [kg]	2,3		3,4		3,5	5	8,3
In stock	-	✓	✓	✓	✓	✓	✓
Material no.	10001000	10001575	10001003	10001578	10017067	10001008	10001583

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

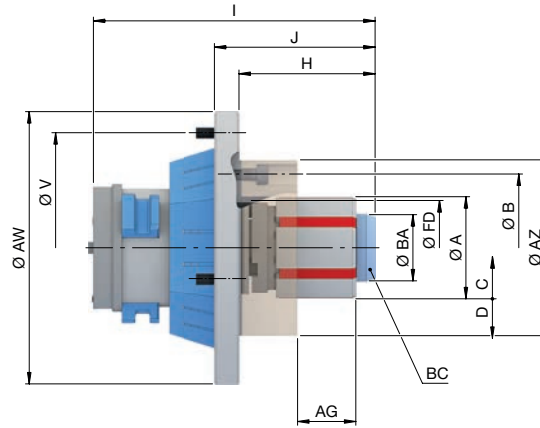
➔

Segmented clamping bushings Page 448	Accessory overview Page 478



# ADAPTATION CLAMPING DEVICES MANDO Adapt [mandrel adaptation]

## MANDO Adapt T211 SE. Technical data



Size	<b>2</b>							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A		36 – 54					
Run-out ≤ [mm]	0,010							
Max. radial clamping force [kN]	85							
Max. axial drawtube force [pull / push] [kN]	20							
Max. clamping length [mm]	AG		43					
Release stroke in Ø [mm]	C		0,4		0,5		0,3	
Reserve stroke in Ø [mm]	D		0,3		0,5		0,5	
Range / recommended workpiece tolerance [mm]	± 0,25							
RPM n max. [1/min.]	7000		6000		5500		5000	
Max. actuating torque [Nm]	BC		25					
Draw bolt Ø [mm]	BA		35					
Reception workpiece end-stop	FD		Ø 50 f7					
End-stop outer Ø [mm]	AZ		93					
Bolt hole circle end-stop	B		LK Ø 78 [3 x M6]					
Length [mm]	H		72,3		72		71,5	
Total length [mm]	I		139		149		159	
Height [mm]	J		85					
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	119	125	129	144	150	183	215
Weight [kg]		2,6	3,7	3,8	5	8,6	9,5	
In stock		-	✓	✓	✓	✓	✓	✓
Material no.		10001001	10001576	10001004	10001579	10017068	10001009	10001584

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



Adaptation clamping devices

Measuring technology / Automation

Quick change-over systems

Special solutions

Clamping elements / Accessories

Services

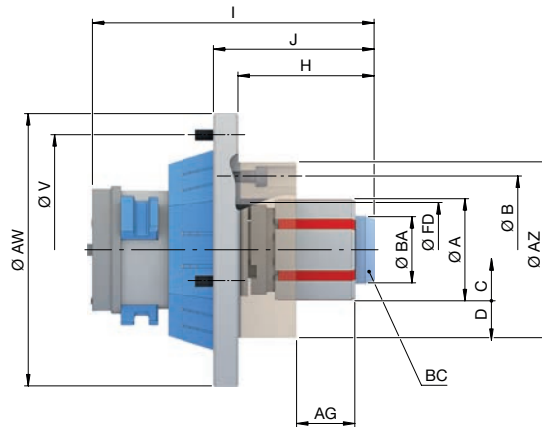
Multi spindles

# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T211 SE. Technical data



Size	<b>3</b>				
Adaptation size	<b>65</b>		<b>80</b>	<b>100</b>	
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium
Clamping range [mm]	A		50 – 80		
Run-out ≤ [mm]			0,010		
Max. radial clamping force [kN]			105		
Max. axial drawtube force [pull / push] [kN]			25		
Max. clamping length [mm]	AG		49		
Release stroke in Ø [mm]			C		
Reserve stroke in Ø [mm]			D		
Range / recommended workpiece tolerance [mm]			± 0,35		
RPM n max. [1/min.]	6000		5500	5000	
Max. actuating torque [Nm]	BC		55		
Draw bolt Ø [mm]	BA		49		
Reception workpiece end-stop	FD		Ø 65 f7		
End-stop outer Ø [mm]	AZ		96		
Bolt hole circle end-stop			B		
Length [mm]	H		LK Ø 80 [3 x M6]		
Total length [mm]	I		82		81,5
Height [mm]	J		159		169
Bolt hole circle	V		95		
Outer Ø [mm]	AW		LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]
Weight [kg]			LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]	
In stock					
Material no.	10001005	10001580	10017069	10001010	10001585

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



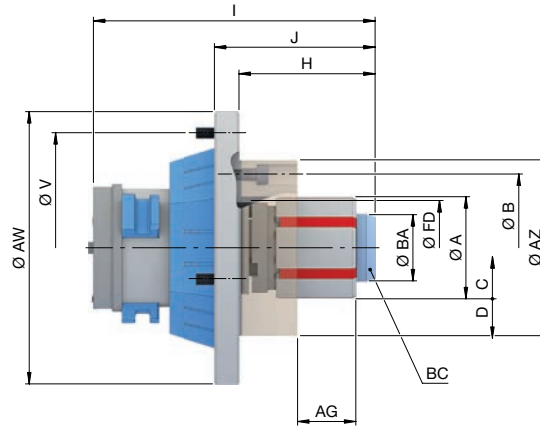




# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]

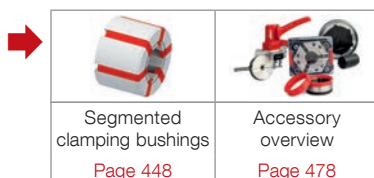
### MANDO Adapt T211 SE. Technical data



Size	4				
Adaptation size	65		80	100	
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium
Clamping range [mm]	A 69 – 120				
Run-out ≤ [mm]	0,010				
Max. radial clamping force [kN]	150				
Max. axial drawtube force [pull / push] [kN]	35				
Max. clamping length [mm]	AG 59				
Release stroke in Ø [mm]	C 0,5				
Reserve stroke in Ø [mm]	D 0,6			0,5	
Range / recommended workpiece tolerance [mm]	± 0,4				
RPM n max. [1/min.]	6000		5500	5000	
Max. actuating torque [Nm]	BC 65				
Draw bolt Ø [mm]	BA 68				
Reception workpiece end-stop	FD Ø 78 f7				
End-stop outer Ø [mm]	AZ 120				
Bolt hole circle end-stop	B LK Ø 90 [3 x M6]				
Length [mm]	H 97			96,5	
Total length [mm]	I 174			184	
Height [mm]	J 110				
Bolt hole circle	V LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW 129	144	150	183	215
Weight [kg]	5,4	5,5	7	10,2	11,1
In stock	✓	✓	✓	✓	✓
Material no.	10001006	10001581	10017070	10001011	10001586

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

For size 4, clamping range 101 – 120 mm, a max. speed of 4200 RPM applies.



# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T212 SE. Order overview

Suitable for



Size	Clamping range [mm]	Adap-tation size	Material no.	In stock	TOPlus mini pull-back Page 26	TOPlus premium pull-back Page 46	TOPlus combi pull-back Page 58	TOPlus modular Page 58	TOROK SE Page 122	HYDROK SE Page 252	MANOK plus SE Page 244	
<b>XXS</b>	8 – 13	52	10001012	-	✓	✓						
			10001648	-			✓	✓	✓	✓	✓	
		65	10001018	✓	✓	✓						
			10001656	✓			✓	✓	✓	✓	✓	
		80	10017071	-	✓	✓						
		100	10001026	-								
			10001664	-				✓	✓	✓	✓	✓
<b>XS</b>	13 – 19	52	10001013	-	✓	✓						
			10001647	✓			✓	✓	✓	✓	✓	
		65	10001019	✓	✓	✓						
			10001655	✓			✓	✓	✓	✓	✓	
		80	10017072	✓	✓	✓						
		100	10001027	✓								
			10001663	✓				✓	✓	✓	✓	✓
<b>S</b>	16 – 21	52	10001014	-	✓	✓						
			10001646	✓			✓	✓	✓	✓	✓	
		65	10001020	✓	✓	✓						
			10001654	✓			✓	✓	✓	✓	✓	
		80	10017073	✓	✓	✓						
		100	10001028	✓								
			10001662	✓				✓	✓	✓	✓	✓
<b>O</b>	20 – 28	52	10001015	-	✓	✓						
			10001645	-			✓	✓	✓	✓	✓	
		65	10001021	✓	✓	✓						
			10001653	✓			✓	✓	✓	✓	✓	
		80	10017074	✓	✓	✓						
		100	10001029	✓								
			10001661	✓				✓	✓	✓	✓	✓

Detailed technical data follows.



# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]

### MANDO Adapt T212 SE. Order overview

Size	Clamping range [mm]	Adap-tation size	Material no.	In stock	Suitable for							
					TOPlus mini pull-back Page 26	TOPlus premium pull-back Page 46	TOPlus combi pull-back Page 58	TOPlus modular Page 58	TOROK SE Page 122	HYDROK SE Page 252	MANOK plus SE Page 244	
<b>1</b>	26 – 38	52	10001016	-	✓	✓						
			10001644	✓			✓	✓	✓	✓	✓	
		65	10001022	✓	✓							
			10001652	✓			✓	✓	✓	✓	✓	
		80	10017075	✓	✓							
		100	10001030	✓								
			10001660	✓			✓	✓	✓	✓	✓	
		<b>2</b>	36 – 54	52	10001017	-	✓	✓				
10001643	✓						✓	✓	✓	✓	✓	
65	10001023			✓	✓							
	10001651			✓			✓	✓	✓	✓	✓	
80	10017076			✓	✓							
100	10001031			✓	✓							
	10001659			✓			✓	✓	✓	✓	✓	
<b>3</b>	50 – 80			65	10001024	✓	✓					
		10001650	✓				✓	✓	✓	✓		
		80	10017077	✓	✓							
		100	10001032	✓								
			10001658	✓			✓	✓	✓	✓	✓	
<b>4</b>	69 – 100	65	10001025	✓	✓							
			10001649	✓			✓	✓	✓	✓		
		80	10017078	✓	✓							
		100	10001033	✓								
			10001657	✓			✓	✓	✓	✓	✓	

Detailed technical data follows.

### Scope of delivery

- Adaptation mandrel
- Coupling ring
- Mounting aid depending on size

Adaptation clamping devices

Measuring technology/ Automation

Quick change-over systems

Special solutions

Clamping elements/ Accessories

Services

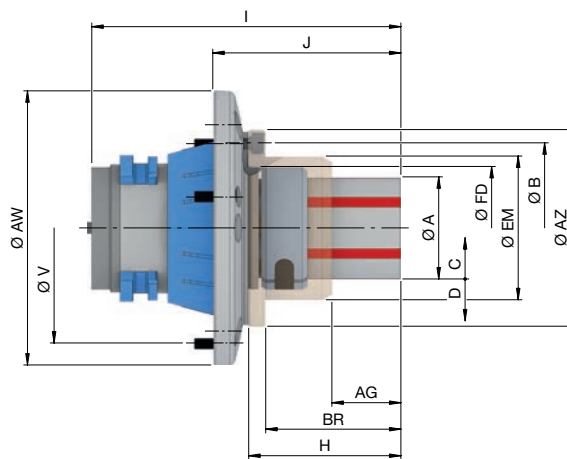
Multi spindles

# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



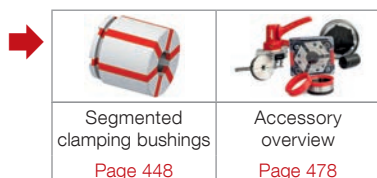
### MANDO Adapt T212 SE. Technical data



Size	XXS							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A		8 – 13					
Run-out ≤ [mm]			0,020					
Release stroke in Ø [mm]	C		0,2					
Reserve stroke in Ø [mm]	D		0,2					
Range / recommended workpiece tolerance [mm]			± 0,15					
Max. clamping length [mm]	AG		12,9					
Max. axial drawtube force [pull / push] [kN]			10					
Max. radial clamping force [kN]			42					
RPM n max. [1/min.]	7000		6000		5500	5000		
Reception workpiece end-stop	FD		Ø 34 f7					
Bolt hole circle end-stop	B		LK Ø 53 [3 x M5]					
End-stop outer Ø [mm]	AZ		65					
Depth [mm]	BR		37,5					
End-stop outer Ø 2 [mm]	EM		41					
Length [mm]	H		45,5					
Total length [mm]	I		124,3		127,5	124,5	139	
Height [mm]	J		71		64,5	61	65,5	
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	119	125	129	145	150	183	215
Weight [kg]		3	3,6	3,8	5	9	10	
In stock		-	-	✓	✓	-	-	-
Material no.		10001012	10001648	10001018	10001656	10017071	10001026	10001664

Please note: The maximum clamping length [AG] varies from 6 to 12.9 mm depending on the clamping diameter.

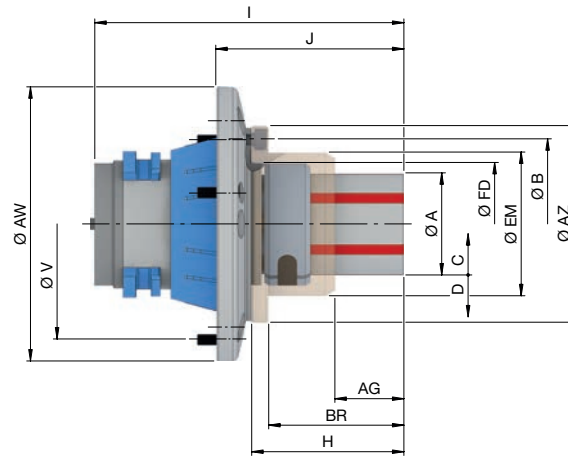
Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.





# ADAPTATION CLAMPING DEVICES MANDO Adapt [mandrel adaptation]

## MANDO Adapt T212 SE. Technical data



Size	<b>XS</b>							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A		13 – 19					
Run-out ≤ [mm]	0,020							
Release stroke in Ø [mm]	C		0,4			0,5		
Reserve stroke in Ø [mm]	D		0,3					
Range / recommended workpiece tolerance [mm]	± 0,25							
Max. clamping length [mm]	AG		14					
Max. axial drawtube force [pull / push] [kN]	10							
Max. radial clamping force [kN]	42							
RPM n max. [1/min.]	7000		6000		5500	5000		
Reception workpiece end-stop	FD		Ø 36 f7					
Bolt hole circle end-stop	B		LK Ø 53 [3 x M5]					
End-stop outer Ø [mm]	AZ		65					
Depth [mm]	BR		37,5					
End-stop outer Ø 2 [mm]	EM		42					
Length [mm]	H		45,5					
Total length [mm]	I		125		128	139,5		
Height [mm]	J		71		64,5	61		
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M6]
Outer Ø [mm]	AW	119	125	129	145	150	183	215
Weight [kg]		3		3,6	3,8	5	9	10
In stock		-	✓	✓	✓	✓	✓	✓
Material no.		10001013	10001647	10001019	10001655	10017072	10001027	10001663

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



Adaptation clamping devices

Measuring technology / Automation

Quick change-over systems

Special solutions

Clamping elements / Accessories

Services

Multi spindles

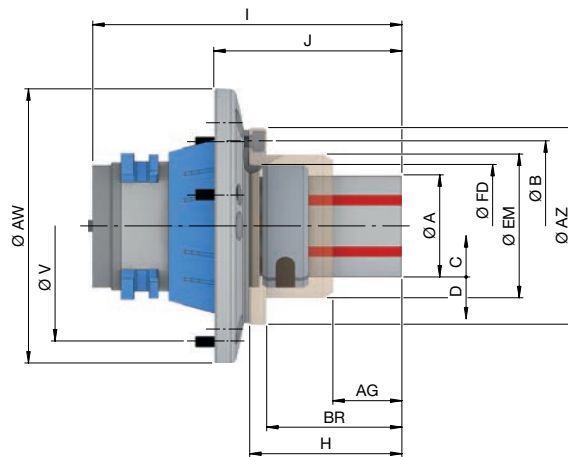


# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T212 SE. Technical data



Size	<b>S</b>							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A		16 – 21					
Run-out ≤ [mm]	0,020							
Release stroke in Ø [mm]	C		0,4			0,5		
Reserve stroke in Ø [mm]	D		0,3					
Range / recommended workpiece tolerance [mm]	± 0,25							
Max. clamping length [mm]	AG		15					
Max. axial drawtube force pull / push [kN]	10							
Max. radial clamping force [kN]	42							
RPM n max. [1/min.]	7000		6000		5500	5000		
Reception workpiece end-stop	FD		Ø 39 f7					
Bolt hole circle end-stop	B		LK Ø 57 [3 x M5]					
End-stop outer Ø [mm]	AZ		70					
Depth [mm]	BR		39,5					
End-stop outer Ø 2 [mm]	EM		45					
Length [mm]	H		47,5					
Total length [mm]	I		127		130	127	141,5	
Height [mm]	J		73		66,5	63	67,5	
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	119	125	129	145	150	183	215
Weight [kg]		3	3,7	4	5,1	9,1	10	
In stock		-	✓	✓	✓	✓	✓	
Material no.		10001014	10001646	10001020	10001654	10017073	10001028	10001662

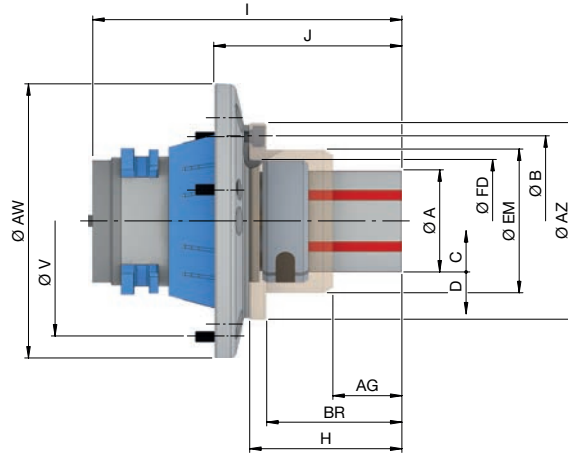
Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.





# ADAPTATION CLAMPING DEVICES MANDO Adapt [mandrel adaptation]

## MANDO Adapt T212 SE. Technical data



Size	0							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A		20 – 28					
Run-out ≤ [mm]	0,010							
Release stroke in Ø [mm]	C		0,4			0,5		
Reserve stroke in Ø [mm]	D		0,3					
Range / recommended workpiece tolerance [mm]	± 0,25							
Max. clamping length [mm]	AG		21					
Max. axial drawtube force [pull / push] [kN]	10							
Max. radial clamping force [kN]	42							
RPM n max. [1/min.]	7000		6000		5500	5000		
Reception workpiece end-stop	FD		Ø 47 f7					
Bolt hole circle end-stop	B		LK Ø 70 [3 x M6]					
End-stop outer Ø [mm]	AZ		90					
Depth [mm]	BR		49,5					
End-stop outer Ø 2 [mm]	EM		56					
Length [mm]	H		58,5					
Total length [mm]	I		138		141	138	152,5	
Height [mm]	J		84		77,5	74	78,5	
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	119	125	129	145	150	183	215
Weight [kg]		3,6	3,4	4,2	4,3	5,5	9,6	10,5
In stock		-	-	✓	✓	✓	✓	✓
Material no.		10001015	10001645	10001021	10001653	10017074	10001029	10001661

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



Adaptation clamping devices

Measuring technology / Automation

Quick change-over systems

Special solutions

Clamping elements / Accessories

Services

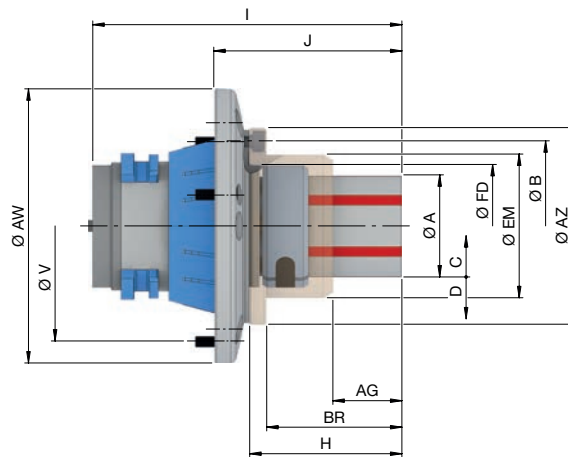
Multi spindles

# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]

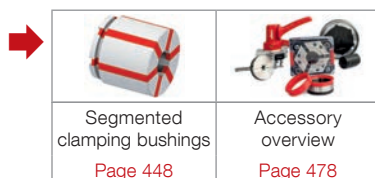


### MANDO Adapt T212 SE. Technical data



Size	1							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A		26 – 38					
Run-out ≤ [mm]	0,010							
Release stroke in Ø [mm]	C		0,4		0,5			
Reserve stroke in Ø [mm]	D		0,3					
Range / recommended workpiece tolerance [mm]	± 0,25							
Max. clamping length [mm]	AG		25					
Max. axial drawtube force [pull / push] [kN]	10							
Max. radial clamping force [kN]	42							
RPM n max. [1/min.]	7000		6000		5500	5000		
Reception workpiece end-stop	FD		Ø 55 f7					
Bolt hole circle end-stop	B		LK Ø 75 [3 x M6]					
End-stop outer Ø [mm]	AZ		90					
Depth [mm]	BR		55,5					
End-stop outer Ø 2 [mm]	EM		62					
Length [mm]	H		64,5					
Total length [mm]	I		139		147,5		158,5	
Height [mm]	J		85		83,5		84,5	
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	119	125	129	145	150	183	215
Weight [kg]		3,2		4,3	4,5	5,6	9,7	10,6
In stock		-	✓	✓	✓	✓	✓	✓
Material no.		10001016	10001644	10001022	10001652	10017075	10001030	10001660

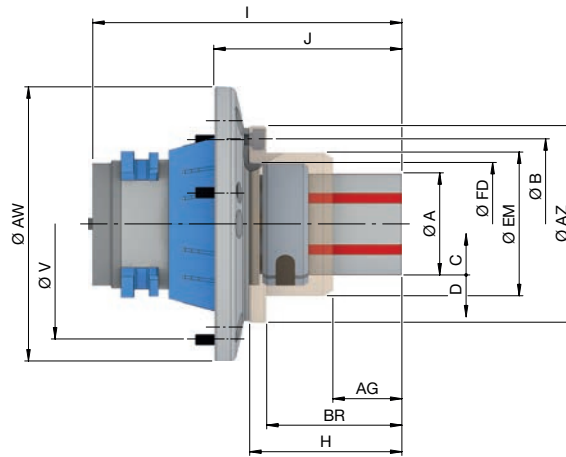
Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.





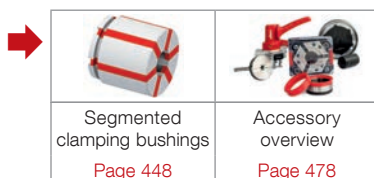
# ADAPTATION CLAMPING DEVICES MANDO Adapt [mandrel adaptation]

## MANDO Adapt T212 SE. Technical data



Size	<b>2</b>							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A		36 – 54					
Run-out ≤ [mm]	0,010							
Release stroke in Ø [mm]	C		0,4		0,5			
Reserve stroke in Ø [mm]	D		0,3					
Range / recommended workpiece tolerance [mm]	± 0,25							
Max. clamping length [mm]	AG		40					
Max. axial drawtube force [pull / push] [kN]	20							
Max. radial clamping force [kN]	85							
RPM n max. [1/min.]	7000		6000		5500	5000		
Reception workpiece end-stop	FD		Ø 65 f7					
Bolt hole circle end-stop	B		LK Ø 90 [3 x M6]					
End-stop outer Ø [mm]	AZ		104					
Depth [mm]	BR		71,5					
End-stop outer Ø 2 [mm]	EM		75					
Length [mm]	H		80,5					
Total length [mm]	I		155		163,5		158	
Height [mm]	J		101		99,5		94	
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	119	125	129	145	150	183	215
Weight [kg]		4	3,9	5	5,2	6	10,3	11,3
In stock		-	✓	✓	✓	✓	✓	✓
Material no.		10001017	10001643	10001023	10001651	10017076	10001031	10001659

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

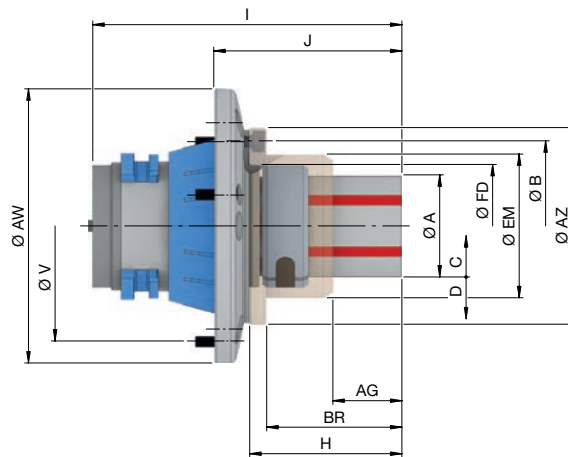


# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T212 SE. Technical data



Size	<b>3</b>				
Adaptation size	<b>65</b>		<b>80</b>	<b>100</b>	
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium
Clamping range [mm]	A		50 – 80		
Run-out ≤ [mm]			0,010		
Release stroke in Ø [mm]	C		0,5		
Reserve stroke in Ø [mm]	D		0,3		0,4
Range / recommended workpiece tolerance [mm]	0,4		± 0,35		
Max. clamping length [mm]	AG		44,5		
Max. axial drawtube force [pull / push] [kN]			25		
Max. radial clamping force [kN]			105		
RPM n max. [1/min.]	6000		5500		5000
Reception workpiece end-stop	FD		Ø 83 f7		
Bolt hole circle end-stop	B		LK Ø 104 [3 x M6]		
End-stop outer Ø [mm]	AZ		120		
Depth [mm]	BR		78		
End-stop outer Ø 2 [mm]	EM		92,5		
Length [mm]	H		87,5		
Total length [mm]	I		170,5		181,5
Height [mm]	J		106,5		107,5
Bolt hole circle	V	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8] LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	129	145	150	183 215
Weight [kg]		5,9	6	6,7	11,2 12
In stock		✓	✓	✓	✓
Material no.		10001024	10001650	10017077	10001032 10001658

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

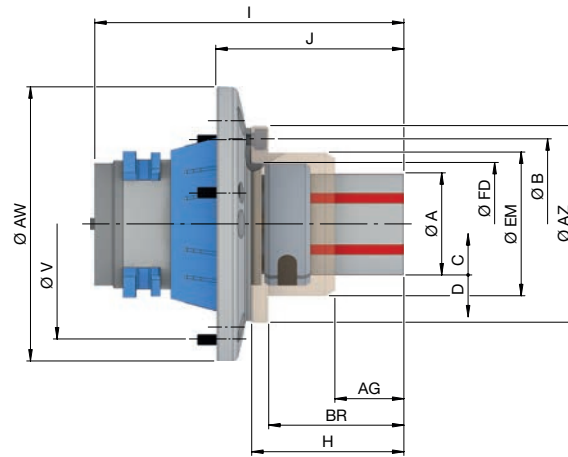






# ADAPTATION CLAMPING DEVICES MANDO Adapt [mandrel adaptation]

## MANDO Adapt T212 SE. Technical data



Size	4				
Adaptation size	65		80	100	
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium
Clamping range [mm]	A 69 – 100				
Run-out ≤ [mm]	0,010				
Release stroke in Ø [mm]	C 0,5				
Reserve stroke in Ø [mm]	D 0,4		0,6	0,5	
Range / recommended workpiece tolerance [mm]	± 0,4				
Max. clamping length [mm]	AG 52,5				
Max. axial drawtube force [pull / push] [kN]	35				
Max. radial clamping force [kN]	150				
RPM n max. [1/min.]	6000		5500	5000	
Reception workpiece end-stop	FD Ø 103 f7				
Bolt hole circle end-stop	B LK Ø 124 [3 x M6]				
End-stop outer Ø [mm]	AZ 138				
Depth [mm]	BR 87,5				
End-stop outer Ø 2 [mm]	EM 113				
Length [mm]	H 97,5				
Total length [mm]	I 180,5		176	191,5	
Height [mm]	J 116,5		112	117,5	
Bolt hole circle	V LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW 138	145	150	183	215
Weight [kg]	7,5	7,4	8,2	12,6	13,5
In stock	✓				
Material no.	10001025	10001649	10017078	10001033	10001657

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T211 RD. Order overview

Size	Clamping range [mm]	Adaptation size	Material no.	In stock	Suitable for					
					SPANNTOP mini pull-back Page 72	SPANNTOP combi pull-back Page 92	SPANNTOP modular Page 92	TOROK RD Page 122	HYDROK RD Page 252	MANOK plus RD Page 244
<b>0</b>	20 – 28	42	10001561	✓						
		52	10001558	✓						
		65	10001550	✓	✓	✓	✓	✓	✓	✓
		80	10001540	✓						
		100	10001549	✓						
<b>1</b>	26 – 38	42	10001563	-						
		52	10001559	✓						
		65	10001551	✓	✓	✓	✓	✓	✓	✓
		80	10001541	✓						
		100	10001545	✓						
<b>2</b>	36 – 54	42	10001562	-						
		52	10001560	✓						
		65	10001552	✓	✓	✓	✓	✓	✓	✓
		80	10001542	✓						
		100	10001546	✓						
<b>3</b>	50 – 80	65	10001553	✓						
		80	10001543	✓	✓	✓	✓	✓	✓	
		100	10001547	✓						
<b>4</b>	69 – 120	65	10001554	✓						
		80	10001544	✓	✓	✓	✓	✓	✓	
		100	10001548	✓						

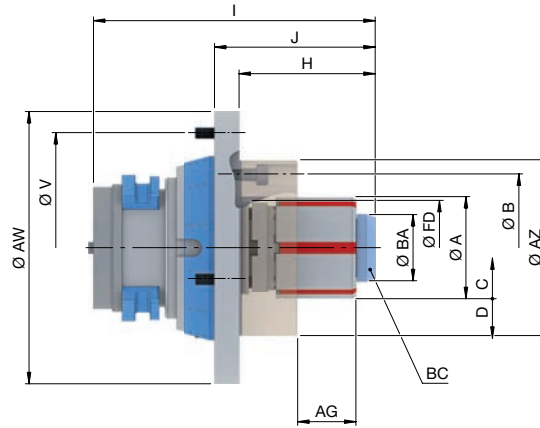
Detailed technical data follows.

### Scope of delivery

- Adaptation mandrel
- Draw bolt



### MANDO Adapt T211 RD. Technical data



Size	<b>0</b>				
Adaptation size	<b>42</b>	<b>52</b>	<b>65</b>	<b>80</b>	<b>100</b>
Clamping range [mm]	A 20 – 28				
Run-out ≤ [mm]	0,010				
Max. radial clamping force [kN]	42				
Max. axial drawtube force [pull / push] [kN]	10				
Max. clamping length [mm]	AG 22				
Release stroke in Ø [mm]	C 0,4				
Reserve stroke in Ø [mm]	D 0,3				
Range / recommended workpiece tolerance [mm]	± 0,25				
RPM n max. [1/min.]	7000		6000	5500	5000
Max. actuating torque [Nm]	BC 10				
Draw bolt Ø [mm]	BA 19				
Reception workpiece end-stop	FD Ø 32 f7				
End-stop outer Ø [mm]	AZ 65				
Bolt hole circle end-stop	B LK Ø 50 [3 x M6]				
Length [mm]	H 42,3		42		41,5
Total length [mm]	I 106	109	119		129
Height [mm]	J 55				
Bolt hole circle	V LK Ø 107 [3 x M6]		LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW 125		144	160	215
Weight [kg]	2,1	2,2	3,7	4,9	9,2
In stock	✓	✓	✓	✓	✓
Material no.	10001561	10001558	10001550	10001540	10001549

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

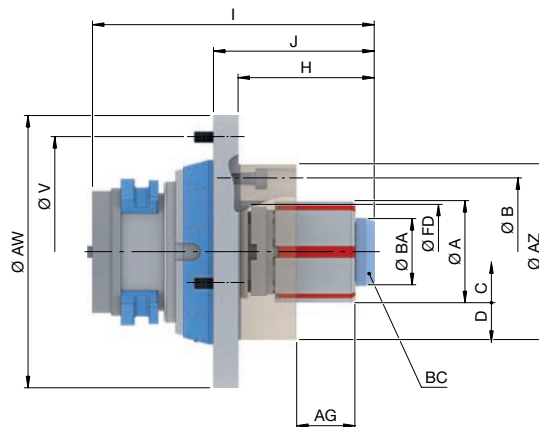


# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T211 RD. Technical data



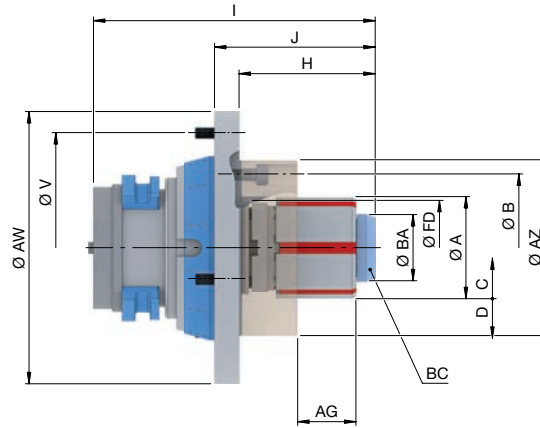
Size	<b>1</b>				
Adaptation size	<b>42</b>	<b>52</b>	<b>65</b>	<b>80</b>	<b>100</b>
Clamping range [mm]	A 26 – 38				
Run-out ≤ [mm]	0,010				
Max. radial clamping force [kN]	42				
Max. axial drawtube force [pull / push] [kN]	10				
Max. clamping length [mm]	AG 25,4				26
Release stroke in Ø [mm]	C 0,4				
Reserve stroke in Ø [mm]	D 0,3				
Range / recommended workpiece tolerance [mm]	± 0,25				
RPM n max. [1/min.]	7000		6000	5500	5000
Max. actuating torque [Nm]	BC 20				
Draw bolt Ø [mm]	BA 25				
Reception workpiece end-stop	FD Ø 41 f7				
End-stop outer Ø [mm]	AZ 69				
Bolt hole circle end-stop	B LK Ø 55 [3 x M6]				
Length [mm]	H 52,3		52		51,5
Total length [mm]	I 116	119	129		139
Height [mm]	J 65				
Bolt hole circle	V LK Ø 107 [3 x M6]		LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW 125		144	160	215
Weight [kg]	2,2	2,4	3,7	5	9,3
In stock	-	✓	✓	✓	✓
Material no.	10001563	10001559	10001551	10001541	10001545

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.





### MANDO Adapt T211 RD. Technical data



Size	<b>2</b>				
Adaptation size	<b>42</b>	<b>52</b>	<b>65</b>	<b>80</b>	<b>100</b>
Clamping range [mm]	A 36 – 54				
Run-out ≤ [mm]	0,010				
Max. radial clamping force [kN]	85				
Max. axial drawtube force [pull / push] [kN]	20				
Max. clamping length [mm]	AG 43	42,4	43		
Release stroke in Ø [mm]	C 0,4		0,5		
Reserve stroke in Ø [mm]	D 0,3				
Range / recommended workpiece tolerance [mm]	± 0,25				
RPM n max. [1/min.]	7000		6000	5500	5000
Max. actuating torque [Nm]	BC 25				
Draw bolt Ø [mm]	BA 35				
Reception workpiece end-stop	FD Ø 50 f7				
End-stop outer Ø [mm]	AZ 93				
Bolt hole circle end-stop	B LK Ø 78 [3 x M6]				
Length [mm]	H 72,3		72		71,5
Total length [mm]	I 136	139	149		159
Height [mm]	J 85				
Bolt hole circle	V LK Ø 107 [3 x M6]		LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW 125		144	160	215
Weight [kg]	2,5	2,7	4	5,3	9,6
In stock	-	✓	✓	✓	✓
Material no.	10001562	10001560	10001552	10001542	10001546

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Segmented clamping bushings Page 442	Adaptation ring Page 508	Accessory overview Page 478

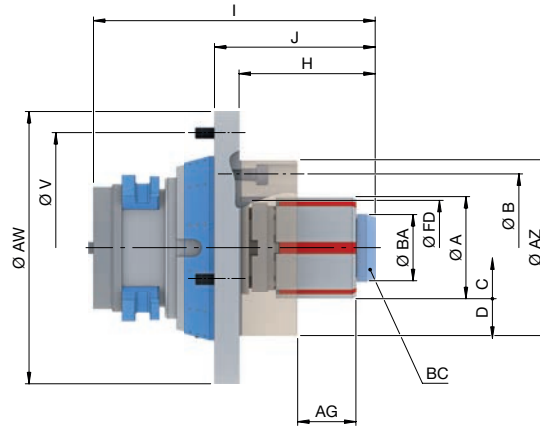


# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T211 RD. Technical data



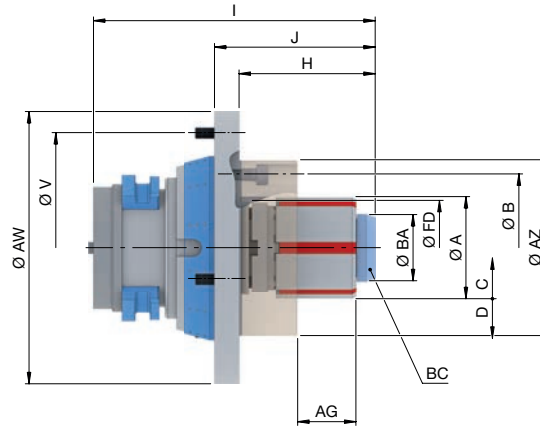
Size	<b>3</b>		
Adaptation size	<b>65</b>	<b>80</b>	<b>100</b>
Clamping range [mm]	A	50 – 80	
Run-out ≤ [mm]		0,010	
Max. radial clamping force [kN]		105	
Max. axial drawtube force [pull / push] [kN]		25	
Max. clamping length [mm]	AG	49	
Release stroke in Ø [mm]	C	0,5	
Reserve stroke in Ø [mm]	D	0,4	
Range / recommended workpiece tolerance [mm]		± 0,35	
RPM n max. [1/min.]	6000	5500	5000
Max. actuating torque [Nm]	BC	55	
Draw bolt Ø [mm]	BA	49	
Reception workpiece end-stop	FD	Ø 65 f7	
End-stop outer Ø [mm]	AZ	96	
Bolt hole circle end-stop	B	LK Ø 80 [3 x M6]	
Length [mm]	H	82	81,5
Total length [mm]	I	159	169
Height [mm]	J	95	
Bolt hole circle	V	LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]
Outer Ø [mm]	AW	144	160
Weight [kg]		4,7	6
In stock		✓	✓
Material no.		10001553	10001543
			10001547

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.





### MANDO Adapt T211 RD. Technical data



Size	4		
Adaptation size	65	80	100
Clamping range [mm]	A	69 – 120	
Run-out ≤ [mm]		0,010	
Max. radial clamping force [kN]		150	
Max. axial drawtube force [pull / push] [kN]		35	
Max. clamping length [mm]	AG	59	
Release stroke in Ø [mm]	C	0,5	
Reserve stroke in Ø [mm]	D	0,6	
Range / recommended workpiece tolerance [mm]		± 0,4	
RPM n max. [1/min.]	6000	5500	5000
Max. actuating torque [Nm]	BC	65	
Draw bolt Ø [mm]	BA	68	
Reception workpiece end-stop	FD	Ø 78 f7	
End-stop outer Ø [mm]	AZ	120	
Bolt hole circle end-stop	B	LK Ø 90 [3 x M6]	
Length [mm]	H	97	96,5
Total length [mm]	I	174	184
Height [mm]	J	110	
Bolt hole circle	V	LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]
Outer Ø [mm]	AW	144	215
Weight [kg]		5,7	11,2
In stock		✓	✓
Material no.		10001554	10001548

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

For size 4, clamping range 101 – 120 mm, a max. speed of 4200 RPM applies.



# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T212 RD. Order overview

					Suitable for						
Size	Clamping range [mm]	Adaptation size	Material no.	In stock	SPANNTOP mini pull-back Page 72	SPANNTOP combi pull-back Page 92	SPANNTOP modular Page 92	TOROK RD Page 122	HYDROK RD Page 252	MANOK plus RD Page 244	
<b>XXS</b>	8 – 13	42	10001619	-							
		52	10001620	-							
		65	10001621	✓	✓	✓	✓	✓	✓	✓	
		80	10001622	-							
		100	10001623	-							
<b>XS</b>	13 – 19	42	10001618	✓							
		52	10001588	✓							
		65	10001593	✓	✓	✓	✓	✓	✓	✓	
		80	10001600	✓							
		100	10001607	✓							
<b>S</b>	16 – 21	42	10001614	✓							
		52	10001589	✓							
		65	10001594	✓	✓	✓	✓	✓	✓	✓	
		80	10001601	✓							
		100	10001608	✓							
<b>0</b>	20 – 28	42	10001615	✓							
		52	10001590	✓							
		65	10001595	✓	✓	✓	✓	✓	✓	✓	
		80	10001602	✓							
		100	10001609	✓							
<b>1</b>	26 – 38	42	10001617	✓							
		52	10001591	✓							
		65	10001596	✓	✓	✓	✓	✓	✓	✓	
		80	10001603	✓							
		100	10001610	✓							
<b>2</b>	36 – 54	42	10001616	✓							
		52	10001592	✓							
		65	10001597	✓	✓	✓	✓	✓	✓	✓	
		80	10001604	✓							
		100	10001611	✓							
<b>3</b>	50 – 80	65	10001598	✓							
		80	10001605	✓	✓	✓	✓	✓	✓	✓	
		100	10001612	✓							
		125	10001624	-							
<b>4</b>	69 – 100	65	10001599	✓							
		80	10001606	✓	✓	✓	✓	✓	✓	✓	
		100	10001613	✓							
		125	10001625	-							
<b>5</b>	100 – 130	125	10001626	✓		✓	✓				
<b>6</b>	130 – 160	125	10001627	-		✓	✓				
<b>7</b>	160 – 190	125	10001628	✓		✓	✓				

Detailed technical data below.

Please note: SPANNTOP nova 125 is only compatible with MANDO Adapt manufactured in 2015 or later.

#### Scope of delivery

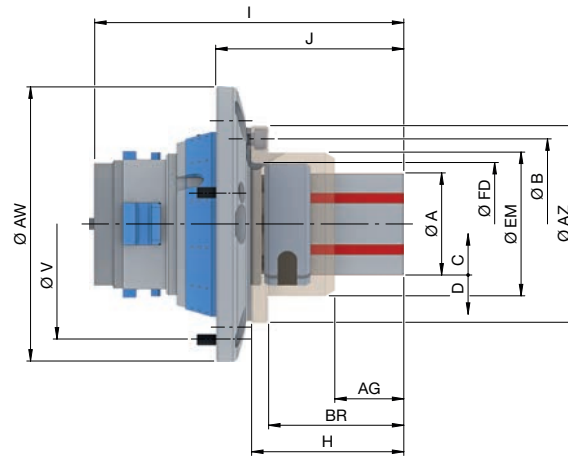
- Adaptation mandrel
- Coupling ring
- Mounting aid depending on size



# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]

### MANDO Adapt T212 RD. Technical data



Size	<b>XXS</b>					
Adaptation size	<b>42</b>	<b>52</b>	<b>65</b>	<b>80</b>	<b>100</b>	
Clamping range [mm]	A		8 – 13			
Run-out ≤ [mm]	0,020					
Release stroke in Ø [mm]	C		0,2			
Reserve stroke in Ø [mm]	D		0,2			
Range / recommended workpiece tolerance [mm]	± 0,15					
Max. clamping length [mm]	AG		12,9			
Max. axial drawtube force [pull / push] [kN]	10					
Max. radial clamping force [kN]	42					
RPM n max. [1/min.]	7000		6000	5500	5000	
Reception workpiece end-stop	FD		Ø 34 f7			
Bolt hole circle end-stop	B		LK Ø 53 [3 x M5]			
End-stop outer Ø [mm]	AZ		65			
Depth [mm]	BR		37,5			
End-stop outer Ø 2 [mm]	EM		41			
Length [mm]	H		45,5			
Total length [mm]	I	124,5	124,3	127,5	124,5	139
Height [mm]	J	71		64,5	61	65,5
Bolt hole circle	V	LK Ø 107 [3 x M6]		LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	125		145	160	215
Weight [kg]		2,8	2,9	4,1	5	10,1
In stock		-	-	✓	-	-
Material no.		10001619	10001620	10001621	10001622	10001623

Please note: The maximum clamping length [AG] varies from 6 to 12.9 mm depending on the clamping diameter.

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

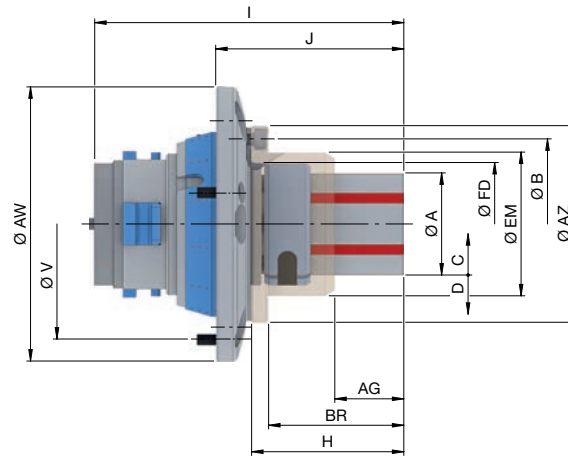


# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T212 RD. Technical data



Size	<b>XS</b>				
Adaptation size	<b>42</b>	<b>52</b>	<b>65</b>	<b>80</b>	<b>100</b>
Clamping range [mm]	A				
Run-out ≤ [mm]	13 – 19				
Release stroke in Ø [mm]	0,020				
Reserve stroke in Ø [mm]	0,4				
Range / recommended workpiece tolerance [mm]	0,3				
Max. clamping length [mm]	AG				
Max. axial drawtube force [pull / push] [kN]	± 0,25				
Max. radial clamping force [kN]	14				
RPM n max. [1/min.]	10				
Reception workpiece end-stop	42				
Bolt hole circle end-stop	FD				
End-stop outer Ø [mm]	7000				
Depth [mm]	6000				
End-stop outer Ø 2 [mm]	5500				
Length [mm]	5000				
Total length [mm]	Ø 36 f7				
Height [mm]	LK Ø 53 [3 x M5]				
Bolt hole circle	65				
Outer Ø [mm]	37,5				
Weight [kg]	42				
In stock	H				
Material no.	I				
	125				
	128				
	125				
	139,5				
	71				
	64,5				
	61				
	65,5				
	LK Ø 107 [3 x M6]				
	LK Ø 126 [3 x M6]				
	LK Ø 139 [3 x M6]				
	LK Ø 180 [3 x M8]				
	125				
	145				
	160				
	215				
	2,8				
	3				
	4				
	5				
	10,1				
	✓				
	✓				
	✓				
	✓				
	✓				
	10001618				
	10001588				
	10001593				
	10001600				
	10001607				

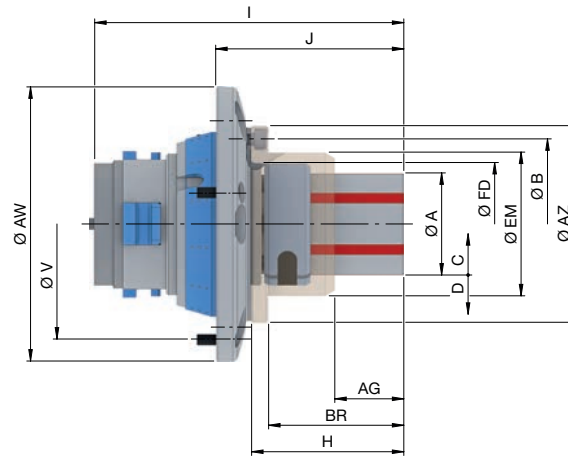
Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.





# ADAPTATION CLAMPING DEVICES MANDO Adapt [mandrel adaptation]

## MANDO Adapt T212 RD. Technical data



Size	<b>S</b>				
Adaptation size	42	52	65	80	100
Clamping range [mm]	A 16 – 21				
Run-out ≤ [mm]	0,020				
Release stroke in Ø [mm]	C 0,4				
Reserve stroke in Ø [mm]	D 0,3				
Range / recommended workpiece tolerance [mm]	± 0,25				
Max. clamping length [mm]	AG 15				
Max. axial drawtube force [pull / push] [kN]	10				
Max. radial clamping force [kN]	42				
RPM n max. [1/min.]	7000		6000	5500	5000
Reception workpiece end-stop	FD Ø 39 f7				
Bolt hole circle end-stop	B LK Ø 57 [3 x M5]				
End-stop outer Ø [mm]	AZ 70				
Depth [mm]	BR 39,5				
End-stop outer Ø 2 [mm]	EM 45				
Length [mm]	H 47,5				
Total length [mm]	I 124	127	130	127	141,5
Height [mm]	J 73				
Bolt hole circle	V LK Ø 107 [3 x M6]		LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW 125		145	160	215
Weight [kg]	3	3,1	4,1	5	10,2
In stock	✓	✓	✓	✓	✓
Material no.	10001614	10001589	10001594	10001601	10001608

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

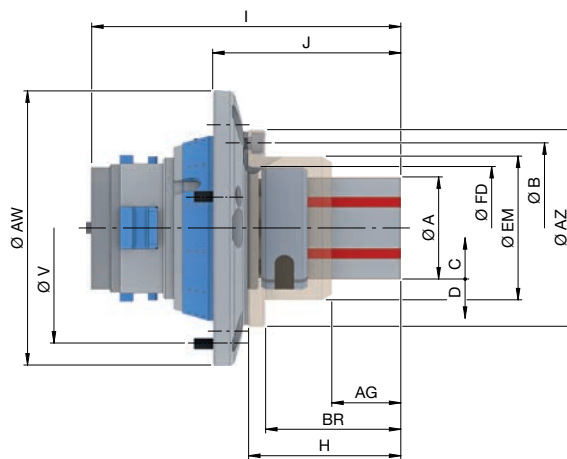


# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]

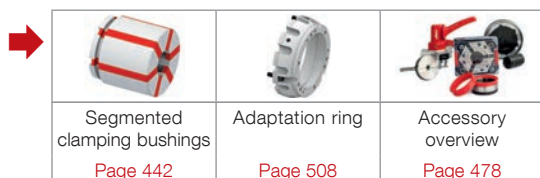


### MANDO Adapt T212 RD. Technical data



Size	0				
Adaptation size	42	52	65	80	100
Clamping range [mm]	A				
Run-out ≤ [mm]	20 – 28				
Release stroke in Ø [mm]	0,010				
Reserve stroke in Ø [mm]	C				
Range / recommended workpiece tolerance [mm]	0,4				
Max. clamping length [mm]	AG				
Max. axial drawtube force [pull / push] [kN]	0,3				
Max. radial clamping force [kN]	± 0,25				
RPM n max. [1/min.]	7000				
Reception workpiece end-stop	FD				
Bolt hole circle end-stop	B				
End-stop outer Ø [mm]	AZ				
Depth [mm]	BR				
End-stop outer Ø 2 [mm]	EM				
Length [mm]	H				
Total length [mm]	I				
Height [mm]	J				
Bolt hole circle	V				
Outer Ø [mm]	AW				
Weight [kg]	3,4				
In stock	✓				
Material no.	10001615				
	10001590				
	10001595				
	10001602				
	10001609				

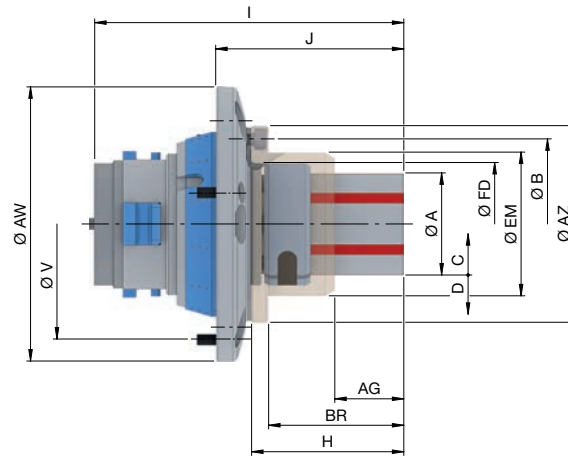
Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.







### MANDO Adapt T212 RD. Technical data



Size	<b>1</b>					
Adaptation size	<b>42</b>	<b>52</b>	<b>65</b>	<b>80</b>	<b>100</b>	
Clamping range [mm]	A		26 – 38			
Run-out ≤ [mm]			0,010			
Release stroke in Ø [mm]	C		0,5			
Reserve stroke in Ø [mm]	D		0,3			
Range / recommended workpiece tolerance [mm]			± 0,25			
Max. clamping length [mm]	AG		25			
Max. axial drawtube force [pull / push] [kN]			10			
Max. radial clamping force [kN]			42			
RPM n max. [1/min.]	7000		6000	5500	5000	
Reception workpiece end-stop	FD		Ø 55 f7			
Bolt hole circle end-stop	B		LK Ø 75 [3 x M6]			
End-stop outer Ø [mm]	AZ		90			
Depth [mm]	BR		55,5			
End-stop outer Ø 2 [mm]	EM		62			
Length [mm]	H		64,5			
Total length [mm]	I	136	139	147,5	146,5	158,5
Height [mm]	J	85		83,5	80	84,5
Bolt hole circle	V	LK Ø 107 [3 x M6]		LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	125		145	160	215
Weight [kg]		3,2	3,4	4,6	5,6	10,7
In stock		✓	✓	✓	✓	✓
Material no.		10001617	10001591	10001596	10001603	10001610

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

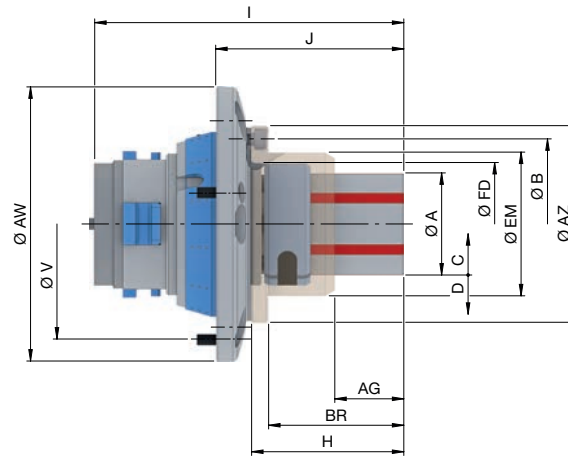


# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T212 RD. Technical data



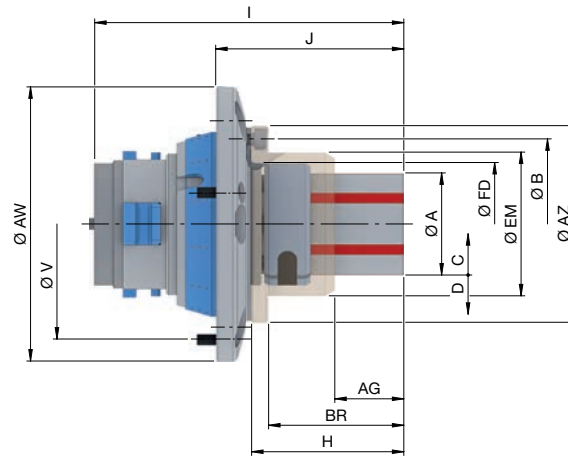
Size	<b>2</b>				
Adaptation size	<b>42</b>	<b>52</b>	<b>65</b>	<b>80</b>	<b>100</b>
Clamping range [mm]	A 36 – 54				
Run-out ≤ [mm]	0,010				
Release stroke in Ø [mm]	C 0,4		0,5		
Reserve stroke in Ø [mm]	D 0,3				
Range / recommended workpiece tolerance [mm]	± 0,25				
Max. clamping length [mm]	AG 40				
Max. axial drawtube force [pull / push] [kN]	20				
Max. radial clamping force [kN]	85				
RPM n max. [1/min.]	7000		6000	5500	5000
Reception workpiece end-stop	FD Ø 65 f7				
Bolt hole circle end-stop	B LK Ø 90 [3 x M6]				
End-stop outer Ø [mm]	AZ 104				
Depth [mm]	BR 71,5				
End-stop outer Ø 2 [mm]	EM 75				
Length [mm]	H 80,5				
Total length [mm]	I 152	155	163,5	160,5	174,5
Height [mm]	101		99,5	94	100,5
Bolt hole circle	V LK Ø 107 [3 x M6]		LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW 125		145	160	215
Weight [kg]	3,9	4	5,4	6	11,3
In stock	✓	✓	✓	✓	✓
Material no.	10001616	10001592	10001597	10001604	10001611

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



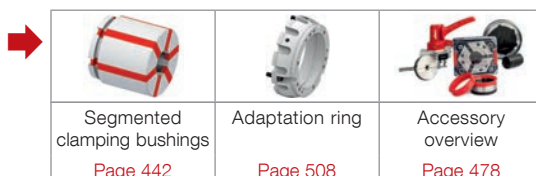


### MANDO Adapt T212 RD. Technical data



Size	<b>3</b>			
Adaptation size	<b>65</b>	<b>80</b>	<b>100</b>	<b>125</b>
Clamping range [mm]	A 50 – 80			
Run-out ≤ [mm]	0,010			
Release stroke in Ø [mm]	C 0,5			
Reserve stroke in Ø [mm]	D 0,4	0,3	0,4	
Range / recommended workpiece tolerance [mm]	± 0,35			
Max. clamping length [mm]	AG 44,5			
Max. axial drawtube force [pull / push] [kN]	25			
Max. radial clamping force [kN]	105			
RPM n max. [1/min.]	6000	5500	5000	3200
Reception workpiece end-stop	FD Ø 83 f7			
Bolt hole circle end-stop	B LK Ø 104 [3 x M6]			
End-stop outer Ø [mm]	AZ 120			
Depth [mm]	BR 78			
End-stop outer Ø 2 [mm]	EM 92,5			
Length [mm]	H 87,5			
Total length [mm]	I 170,5	168,5	181,5	200,5
Height [mm]	J 106,5	102	107,5	122,5
Bolt hole circle	V LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]	LK Ø 208,5 [6 x M8]
Outer Ø [mm]	AW 145	160	215	226
Weight [kg]	6,2	7	12,2	24,3
In stock	✓	✓	✓	-
Material no.	10001598	10001605	10001612	10001624

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

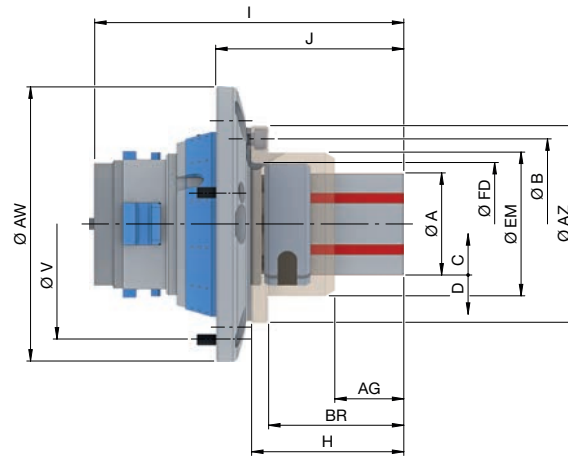


# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T212 RD. Technical data



Size	4			
Adaptation size	65	80	100	125
Clamping range [mm]	A 69 – 100			
Run-out ≤ [mm]	0,010			
Release stroke in Ø [mm]	C 0,5	0,6	0,7	0,6
Reserve stroke in Ø [mm]	D 0,5			
Range / recommended workpiece tolerance [mm]	± 0,35		± 0,4	
Max. clamping length [mm]	AG 52,5			
Max. axial drawtube force [pull / push] [kN]	35			
Max. radial clamping force [kN]	150			
RPM n max. [1/min.]	6000	5500	5000	3200
Reception workpiece end-stop	FD Ø 103 f7			
Bolt hole circle end-stop	B LK Ø 124 [3 x M6]			
End-stop outer Ø [mm]	AZ 138	138,5	138	
Depth [mm]	BR 87,5		82,5	
End-stop outer Ø 2 [mm]	EM 113			
Length [mm]	H 97,5			
Total length [mm]	I 180,5	176	191,5	210
Height [mm]	J 116,5		117,5	
Bolt hole circle	V LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]	LK Ø 208,5 [6 x M8]
Outer Ø [mm]	AW 145	160	215	221,5
Weight [kg]	7,6	8,3	13,6	25
In stock	✓	✓	✓	-
Material no.	10001599	10001606	10001613	10001625

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Please note: SPANNTOP nova 125 is only compatible with MANDO Adapt manufactured in 2015 or later.

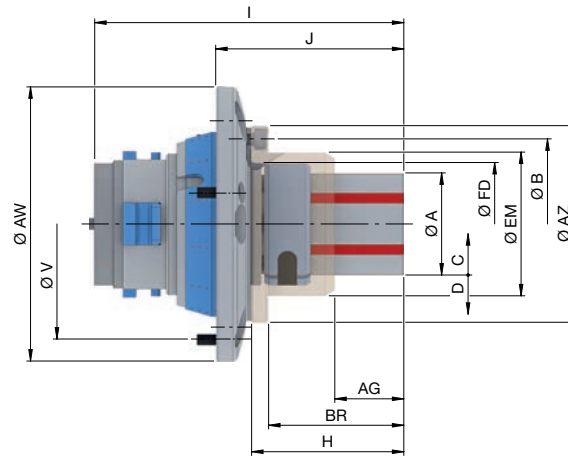




# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]

### MANDO Adapt T212 RD. Technical data



<b>Size</b>		<b>5</b>
<b>Adaptation size</b>		<b>125</b>
Clamping range [mm]	A	100 – 130
Run-out ≤ [mm]		0,010
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	0,6
Range / recommended workpiece tolerance [mm]		± 0,45
Max. clamping length [mm]	AG	53
Max. axial drawtube force [pull / push] [kN]		40
Max. radial clamping force [kN]		170
RPM n max. [1/min.]		3200
Reception workpiece end-stop	FD	Ø 140 f7
Bolt hole circle end-stop	B	LK Ø 176 [3 x M8]
End-stop outer Ø [mm]	AZ	195
Depth [mm]	BR	99
End-stop outer Ø 2 [mm]	EM	160
Length [mm]	H	112
Total length [mm]	I	218
Height [mm]	J	140
Bolt hole circle	V	LK Ø 208,5 [6 x M8]
Outer Ø [mm]	AW	228
Weight [kg]		24,3
In stock		✓
Material no.		10001626

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Please note: SPANNTOP nova 125 is only compatible with MANDO Adapt manufactured in 2015 or later.

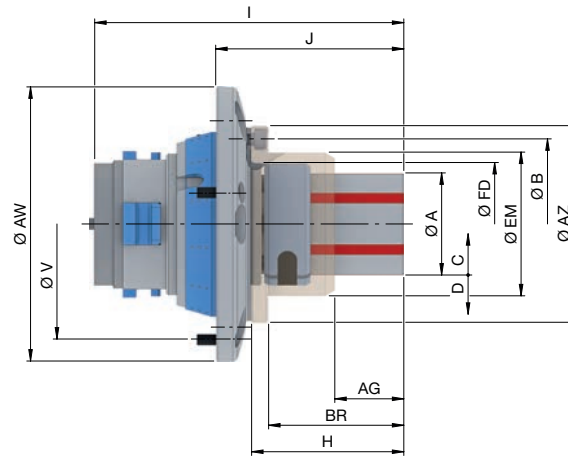


# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T212 RD. Technical data



<b>Size</b>		<b>6</b>
<b>Adaptation size</b>		<b>125</b>
Clamping range [mm]	A	130 – 160
Run-out ≤ [mm]		0,010
Release stroke in Ø [mm]	C	0,6
Reserve stroke in Ø [mm]	D	0,6
Range / recommended workpiece tolerance [mm]		± 0,5
Max. clamping length [mm]	AG	61
Max. axial drawtube force [pull / push] [kN]		40
Max. radial clamping force [kN]		170
RPM n max. [1/min.]		3200
Reception workpiece end-stop	FD	Ø 164 f7
Bolt hole circle end-stop	B	LK Ø 200 [3 x M8]
End-stop outer Ø [mm]	AZ	226
Depth [mm]	BR	107,5
End-stop outer Ø 2 [mm]	EM	184
Length [mm]	H	121,5
Total length [mm]	I	227,5
Height [mm]	J	149,5
Bolt hole circle	V	LK Ø 208,5 [6 x M8]
Outer Ø [mm]	AW	231
Weight [kg]		24,3
In stock		-
Material no.		10001627

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Please note: SPANNTOP nova 125 is only compatible with MANDO Adapt manufactured in 2015 or later.

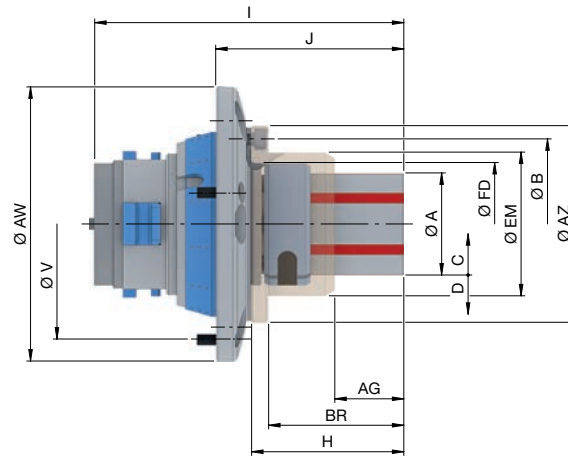




# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]

### MANDO Adapt T212 RD. Technical data



<b>Size</b>		<b>7</b>
<b>Adaptation size</b>		<b>125</b>
Clamping range [mm]	A	160 – 190
Run-out ≤ [mm]		0,010
Release stroke in Ø [mm]	C	0,8
Reserve stroke in Ø [mm]	D	0,6
Range / recommended workpiece tolerance [mm]		± 0,5
Max. clamping length [mm]	AG	73
Max. axial drawtube force [pull / push] [kN]		40
Max. radial clamping force [kN]		170
RPM n max. [1/min.]		3200
Reception workpiece end-stop	FD	Ø 192 f7
Bolt hole circle end-stop	B	LK Ø 216 [3 x M8]
End-stop outer Ø [mm]	AZ	234
Depth [mm]	BR	101
End-stop outer Ø 2 [mm]	EM	212
Length [mm]	H	115
Total length [mm]	I	223
Height [mm]	J	145
Bolt hole circle	V	LK Ø 208,5 [6 x M8]
Outer Ø [mm]	AW	234
Weight [kg]		24,3
In stock		✓
Material no.		10001628

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Please note: SPANNTOP nova 125 is only compatible with MANDO Adapt manufactured in 2015 or later.



Adaptation clamping devices

Measuring technology / Automation

Quick change-over systems

Special solutions

Clamping elements / Accessories

Services

Multi spindles

# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T812 RD. Order overview

Suitable for



Size	Clamping range [mm]	Adaptation size	Material no.	In stock	SPANNTOP mini deadlength	SPANNTOP nova combi deadlength
					Page 72	Page 92
<b>XS</b>	13 – 19	42/52	10000469	-		
		65	10000470	-	✓	✓
		80	10000465	-		
<b>S</b>	16 – 21	42/52	10000461	-		
		65	10000471	-	✓	✓
		80	10000466	-		
<b>0</b>	20 – 28	42/52	10000472	-		
		65	10000473	✓	✓	✓
		80	10000467	-		
<b>1</b>	26 – 38	42/52	10000474	-		
		65	10000475	✓	✓	✓
		80	10000476	-		
<b>2</b>	36 – 54	42/52	10000462	-		
		65	10000477	✓	✓	✓
		80	10000478	-		
<b>3</b>	50 – 80	42/52	10000463	-		
		65	10000479	✓	✓	✓
		80	10000480	-		
<b>4</b>	69 – 100	65	10000481	-		
		80	10000468	-	✓	✓

Detailed technical data follows. Adaptation size 100 upon request.

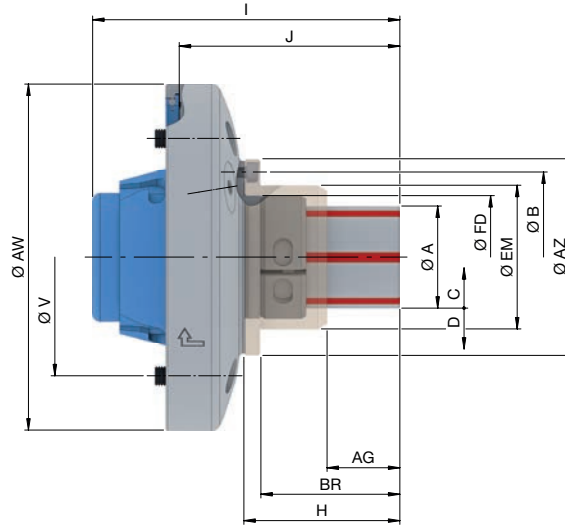
#### Scope of delivery

- Adaptation mandrel
- Support sleeve for SAD segmented clamping bushings
- Assembly wrench





### MANDO Adapt T812 RD. Technical data



Size	<b>XS</b>		
Adaptation size	42/52	65	80
Clamping range [mm]	A	13 – 19	
Run-out ≤ [mm]		0,025	
Release stroke in Ø [mm]	C	0,4	
Reserve stroke in Ø [mm]	D	0,3	
Range / recommended workpiece tolerance [mm]		± 0,25	
Max. clamping length [mm]	AG	14	
Max. axial compression force [kN]		10	
Max. radial clamping force [kN]		42	
RPM n max. [1/min.]		7000	
Reception workpiece end-stop	FD	Ø 36 f7	
Bolt hole circle end-stop	B	LK Ø 53 [3 x M5]	
End-stop outer Ø [mm]	AZ	65	
Depth [mm]	BR	39,5	
End-stop outer Ø 2 [mm]	EM	42	
Length [mm]	H	47,5	
Total length [mm]	I	124,5	129,5
Height [mm]	J	83,7	
Bolt hole circle	V	LK Ø 125 [3 x M10]	LK Ø 145 [3 x M10]
Outer Ø [mm]	AW	166	183
Weight [kg]		7	10
In stock		-	-
Material no.	10000469	10000470	10000465

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

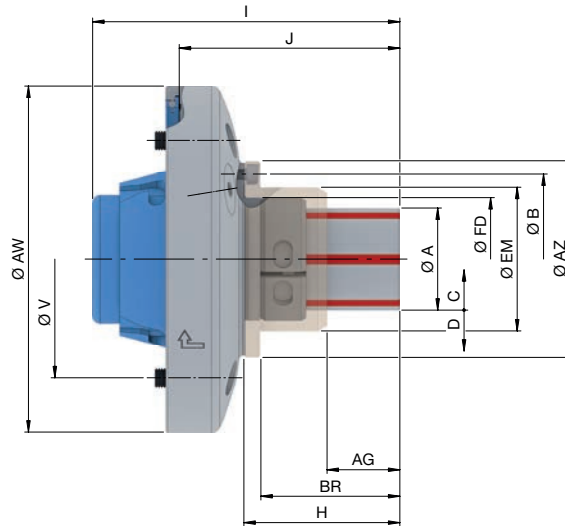


# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T812 RD. Technical data



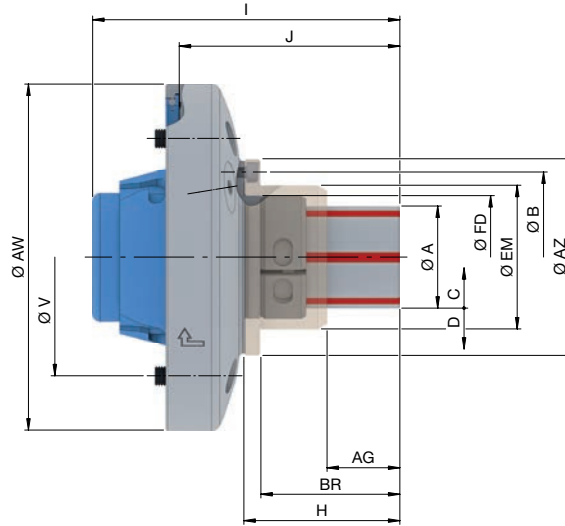
Size	<b>S</b>		
Adaptation size	42/52	65	80
Clamping range [mm] A		16 – 21	
Run-out ≤ [mm]		0,025	
Release stroke in Ø [mm] C		0,4	
Reserve stroke in Ø [mm] D		0,3	
Range / recommended workpiece tolerance [mm]		± 0,25	
Max. clamping length [mm] AG		15	
Max. axial compression force [kN]		10	
Max. radial clamping force [kN]		42	
RPM n max. [1/min.]	7000	6000	7000
Reception workpiece end-stop FD		Ø 39 f7	
Bolt hole circle end-stop B		LK Ø 57 [3 x M5]	
End-stop outer Ø [mm] AZ		70	
Depth [mm] BR		41,5	
End-stop outer Ø 2 [mm] EM		45	
Length [mm] H		49,5	
Total length [mm] I	126,5		131,5
Height [mm] J		85,7	
Bolt hole circle	LK Ø 125 [3 x M10]	LK Ø 145 [3 x M10]	LK Ø 160 [3 x M10]
Outer Ø [mm] AW	166	183	202
Weight [kg]	7	8	10
In stock	-	-	-
Material no.	10000461	10000471	10000466

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.





### MANDO Adapt T812 RD. Technical data



Size	0		
Adaptation size	42/52	65	80
Clamping range [mm]	A	20 – 28	
Run-out ≤ [mm]		0,015	
Release stroke in Ø [mm]	C	0,4	
Reserve stroke in Ø [mm]	D	0,3	
Range / recommended workpiece tolerance [mm]		± 0,25	
Max. clamping length [mm]	AG	21	
Max. axial compression force [kN]		10	
Max. radial clamping force [kN]		42	
RPM n max. [1/min.]	7000	6000	7000
Reception workpiece end-stop	FD	Ø 47 f7	
Bolt hole circle end-stop	B	LK Ø 70 [3 x M6]	
End-stop outer Ø [mm]	AZ	90	
Depth [mm]	BR	51,5	
End-stop outer Ø 2 [mm]	EM	54	
Length [mm]	H	60,5	
Total length [mm]	I	135,5	140,5
Height [mm]	J	94,7	
Bolt hole circle	V	LK Ø 125 [3 x M10]	LK Ø 145 [3 x M10]
Outer Ø [mm]	AW	166	183
Weight [kg]		8	11
In stock		-	-
Material no.	10000472	10000473	10000467

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

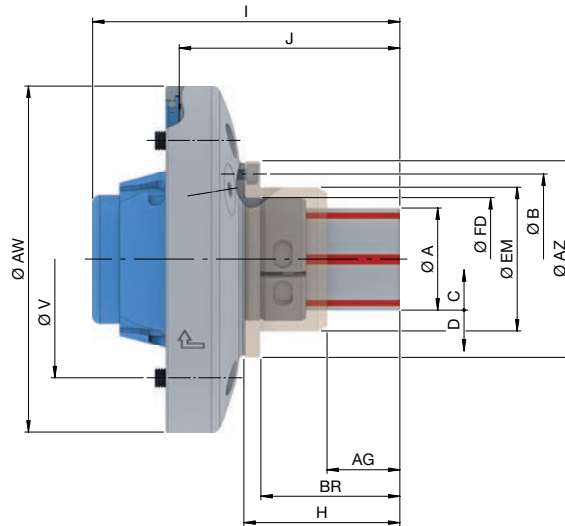


# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]



### MANDO Adapt T812 RD. Technical data



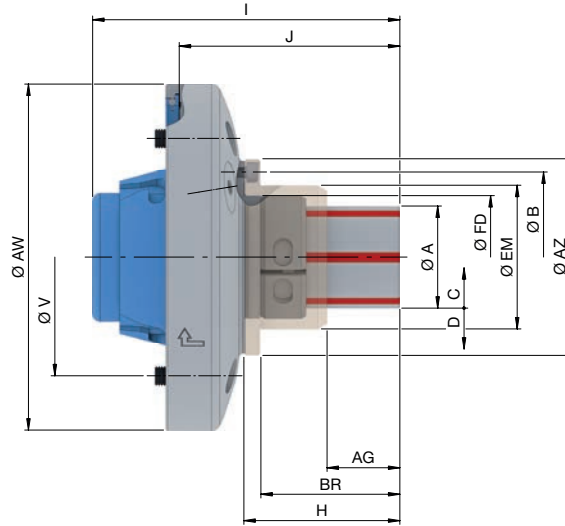
Size	<b>1</b>		
Adaptation size	<b>42/52</b>	<b>65</b>	<b>80</b>
Clamping range [mm]	A		
Run-out ≤ [mm]	0,015		
Release stroke in Ø [mm]	C		
Reserve stroke in Ø [mm]	D		
Range / recommended workpiece tolerance [mm]	± 0,25		
Max. clamping length [mm]	AG		
Max. axial compression force [kN]	10		
Max. radial clamping force [kN]	42		
RPM n max. [1/min.]	7000		
Reception workpiece end-stop	FD		
Bolt hole circle end-stop	B		
End-stop outer Ø [mm]	AZ		
Depth [mm]	BR		
End-stop outer Ø 2 [mm]	EM		
Length [mm]	H		
Total length [mm]	I		
Height [mm]	J		
Bolt hole circle	V		
Outer Ø [mm]	AW		
Weight [kg]	8		
In stock	-		
Material no.	10000474		

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Segmented clamping bushings Page 442	Adaptation ring Page 508	Accessory overview Page 478



### MANDO Adapt T812 RD. Technical data



Size	<b>2</b>		
Adaptation size	<b>42/52</b>	<b>65</b>	<b>80</b>
Clamping range [mm]	A		
Run-out ≤ [mm]	0,015		
Release stroke in Ø [mm]	C	0,4	0,5
Reserve stroke in Ø [mm]	D	0,3	0,4
Range / recommended workpiece tolerance [mm]	± 0,25		± 0,3
Max. clamping length [mm]	AG	40	
Max. axial compression force [kN]	20		
Max. radial clamping force [kN]	85		
RPM n max. [1/min.]	7000		
Reception workpiece end-stop	FD	Ø 65 f7	
Bolt hole circle end-stop	B	LK Ø 90 [3 x M6]	
End-stop outer Ø [mm]	AZ	104	
Depth [mm]	BR	73,5	
End-stop outer Ø 2 [mm]	EM	76	
Length [mm]	H	82,5	
Total length [mm]	I	157,5	162,5
Height [mm]	J	116,7	
Bolt hole circle	V	LK Ø 125 [3 x M10]	LK Ø 145 [3 x M10]
Outer Ø [mm]	AW	166	183
Weight [kg]		9	11
In stock		-	-
Material no.	10000462	10000477	10000478

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

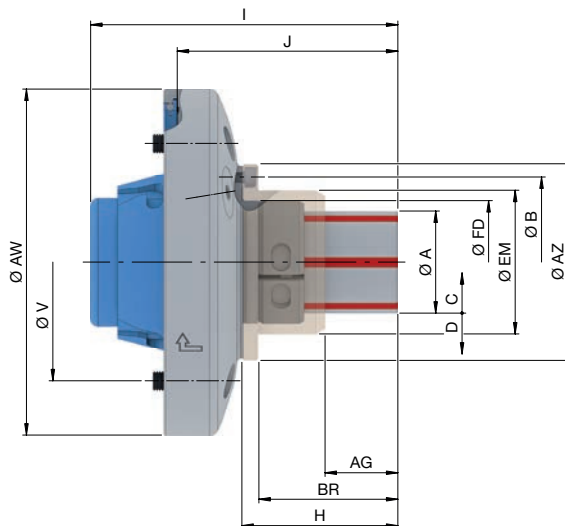
Segmented clamping bushings Page 442	Adaptation ring Page 508	Accessory overview Page 478

# ADAPTATION CLAMPING DEVICES

## MANDO Adapt [mandrel adaptation]

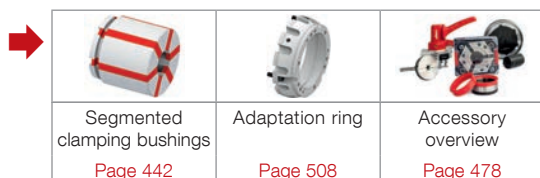


### MANDO Adapt T812 RD. Technical data



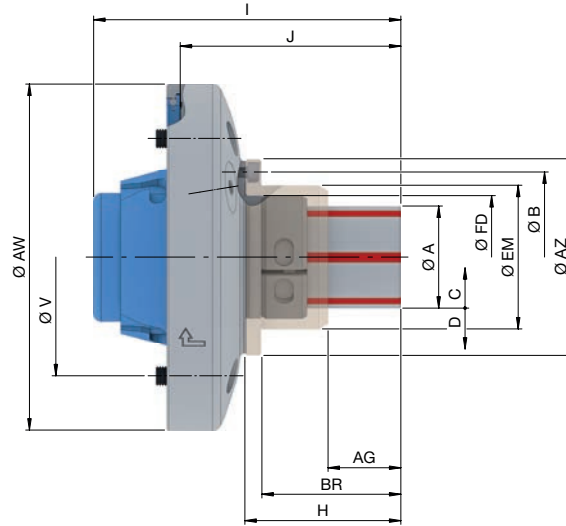
Size	<b>3</b>		
Adaptation size	42/52	65	80
Clamping range [mm]	A	50 – 80	
Run-out ≤ [mm]		0,015	
Release stroke in Ø [mm]	C	0,5	
Reserve stroke in Ø [mm]	D	0,4	
Range / recommended workpiece tolerance [mm]		± 0,35	
Max. clamping length [mm]	AG	44,5	
Max. axial compression force [kN]		25	
Max. radial clamping force [kN]		105	
RPM n max. [1/min.]	6000		5500
Reception workpiece end-stop	FD	Ø 83 f7	
Bolt hole circle end-stop	B	LK Ø 104 [3 x M6]	
End-stop outer Ø [mm]	AZ	120	
Depth [mm]	BR	80,0	
End-stop outer Ø 2 [mm]	EM	105	
Length [mm]	H	89,5	
Total length [mm]	I	164,5	169,5
Height [mm]	J	123,7	
Bolt hole circle	V	LK Ø 125 [3 x M10]	LK Ø 145 [3 x M10]
Outer Ø [mm]	AW	166	183
Weight [kg]		9	12
In stock		-	-
Material no.	10000463	10000479	10000480

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.





### MANDO Adapt T812 RD. Technical data



Size	4	
Adaptation size	65	80
Clamping range [mm]	A	69 – 100
Run-out ≤ [mm]		0,015
Release stroke in Ø [mm]	C	0,5
Reserve stroke in Ø [mm]	D	0,4
Range / recommended workpiece tolerance [mm]		± 0,35
Max. clamping length [mm]	AG	52,5
Max. axial compression force [kN]		35
Max. radial clamping force [kN]		150
RPM n max. [1/min.]		6000
Reception workpiece end-stop	FD	Ø 103 f7
Bolt hole circle end-stop	B	LK Ø 124 [3 x M6]
End-stop outer Ø [mm]	AZ	138
Depth [mm]	BR	90,5
End-stop outer Ø 2 [mm]	EM	124
Length [mm]	H	100
Total length [mm]		179,5
Height [mm]	J	133,7
Bolt hole circle	V	LK Ø 145 [3 x M10]
Outer Ø [mm]	AW	183
Weight [kg]		14
In stock		-
Material no.	10000481	10000468

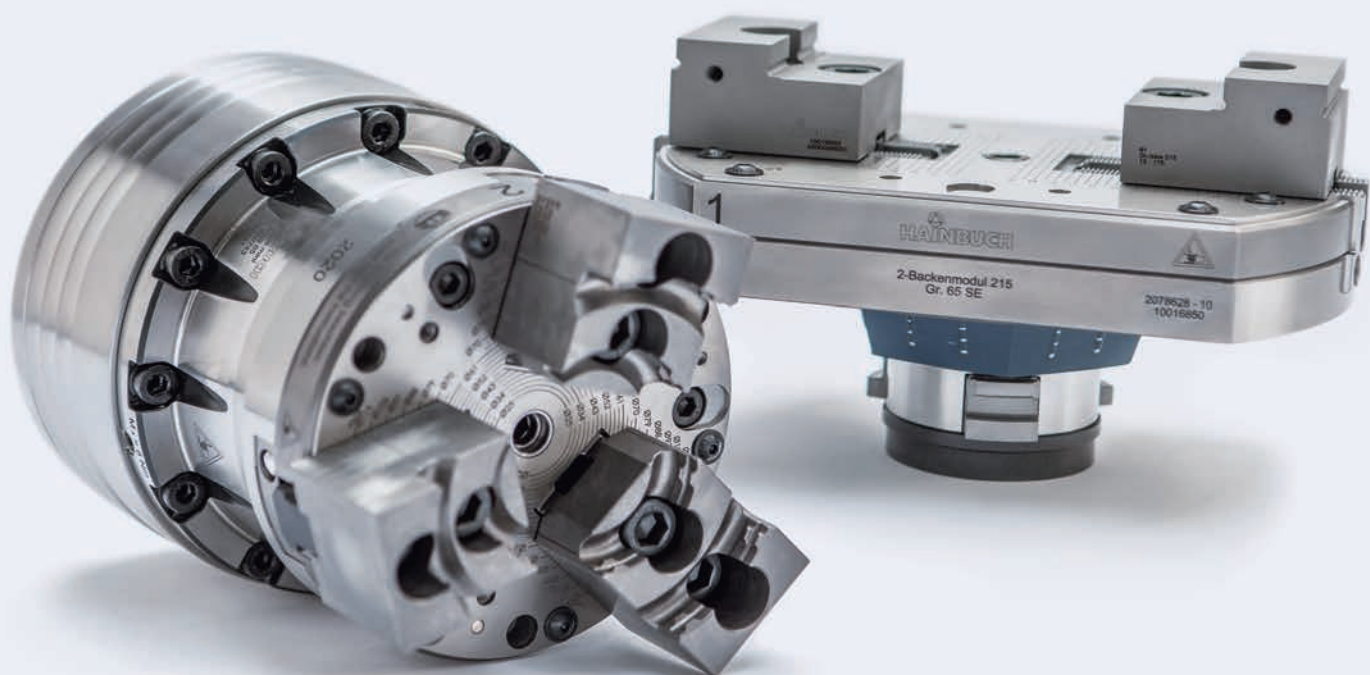
Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.





# Jaw modules

Perfect for a large parts spectrum







Change over from O.D. clamping to jaw clamping or centric clamping in 2 minutes – without clamping device change-over and without having to align? No problem, with the jaw modules. The basic unit, into which the jaw module is inserted, is a HAINBUCH chuck or stationary chuck. If at times the clamping head reaches its limits because it must clamp a larger area, then use one of the jaw modules.



The 3-jaw module is best suited for round workpieces, and if you have cubic workpieces, then rely on the 2-jaw module. This means that for a large parts spectrum you are completely flexible and always have the solution that is ideally suited for the respective clamping situation.

Both are small, lightweight, and can be quickly changed over – an ingenious solution for small-series production.

#### Key advantages

- Jaw clamping in the HAINBUCH chuck or stationary chuck
- Extremely fast conversion without detachment of the base clamping device [2 min.]
- Self-centering on the basic clamping device
- Enlarges clamping range of the basic clamping device
- Deadlength clamping without pull-back effect
- Optimal lubrication and resistant to contamination thanks to the lubricating system

**Jaw modules****Jaw modules at a glance**

	<b>3-jaw module</b>	<b>2-jaw module</b>
		
Description	Adaptation for jaw clamping [O.D. clamping]	Adaptation for centric clamping [O.D. clamping]
Sizes	145, 215	215
Clamping range of all sizes [mm]	25 – 209	15 – 209
Variant	SE [hexagonal], RD [round]	SE [hexagonal], RD [round]
<b>Advantages</b>	<ul style="list-style-type: none"> <li>■ Machining between the jaws is possible [milling or drilling]</li> <li>■ Handy and lightweight compared to 3-jaw chucks</li> <li>■ Run-out <math>\leq 0.020</math> mm for re-machined soft jaws</li> </ul>	<ul style="list-style-type: none"> <li>■ Can also be used rotating up to 1,500 rpm</li> <li>■ Handy and lightweight compared to centric clamping vises</li> <li>■ Clamping repeatability <math>\leq 0.010</math> for hard reversible stepped jaws</li> </ul>



**2-jaw module SE in detail**

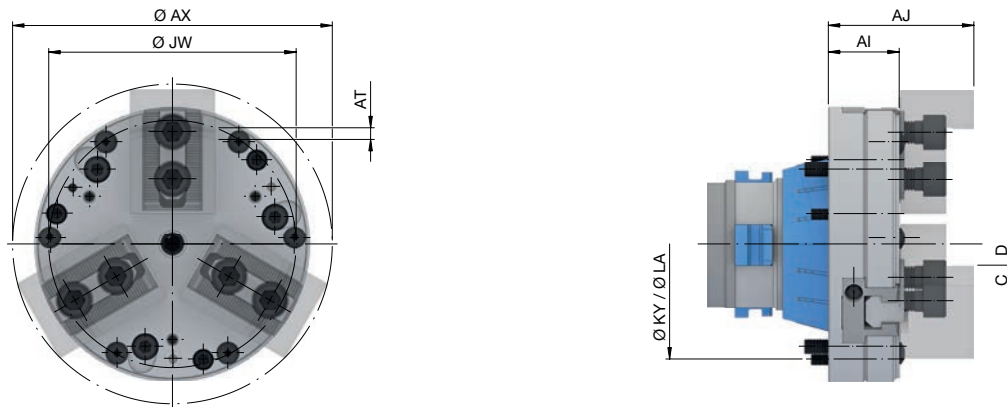
Designation	
<ul style="list-style-type: none"> <li>1 Adjustable top jaws with fine serration</li> <li>2 Assembly and locking mechanism</li> <li>3 Coupling</li> <li>4 CENTREX system for <math>\mu\text{m}</math>-precise use without adjustment</li> <li>5 Master jaw</li> <li>6 Grease nipple</li> <li>7 T-slot nut</li> <li>8 Indicator for the clamping reserve</li> </ul>	

**3-jaw module SE in detail**

Designation	
<ul style="list-style-type: none"> <li>1 Adjustable top jaws with fine serration</li> <li>2 Assembly and locking mechanism</li> <li>3 Coupling</li> <li>4 CENTREX system for <math>\mu\text{m}</math>-precise use without adjustment</li> <li>5 Master jaw</li> <li>6 Grease nipple</li> <li>7 T-slot nut</li> <li>8 Indicator for the clamping reserve</li> </ul>	



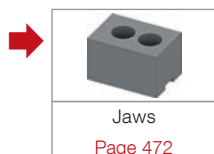
**3-jaw module SE.** Technical data and order overview



Product line	<b>SE</b>		
Adaptation size	<b>65</b>		<b>100</b>
Size	145	215	
Run-out ≤ [mm]	0,020		
Clamping range [mm]	JW	see overview top jaws	
RPM n max. [1/min.]	5000		3000
Max. actuating force when boring the jaws [kN]	45		
Max. axial drawtube force [pull / push] [kN]	45		
Max. radial clamping force [kN]	60		
Release stroke in Ø [mm]	C	2,2	5
Reserve stroke in Ø [mm]	D	1,6	2,5
Stroke per jaw [mm]	AT	1,9	3,8
Gear cutting type	1,5 x 60° [serration]		
Swing Ø	AX	~149	~220
Length without jaws [mm]	AI	37,5	
Length with jaws [mm]	AJ	77	
Bolt hole circle TOPlus mini / premium	KY	LK Ø 112 [3 x M8]	LK Ø 160 [3 x M8]
Bolt hole circle all except TOPlus mini / premium	LA	LK Ø 126 [3 x M6]	LK Ø 180 [3 x M8]
Weight [kg]	6,3	11,3	14,5
In stock	✓	✓	✓
Material no.	10000711	10000712	10000713

Run-out of ≤ 0.020 mm is only ensured with re-machined soft jaws.

Mounting precision for rotating clamping devices: Run-out of 0.005 mm can be achieved between chuck and the adaptation clamping device. Run-out errors on the chuck must be taken into consideration. Mounting repeatability of stationary clamping devices is 0.003 mm on the adaptation clamping device.

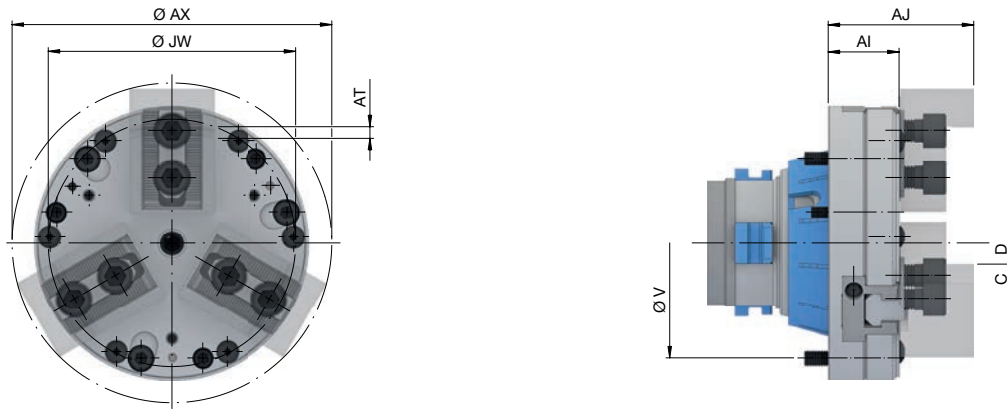


**Scope of delivery**

- 3-jaw module
- T-slot nuts
- Storage box



**3-jaw module RD.** Technical data and order overview



Product line	<b>RD</b>				
Adaptation size	<b>65</b>		<b>80</b>		<b>100</b>
Size	145		215		
Run-out ≤ [mm]	0,020				
Clamping range [mm]	JW	see overview top jaws			
RPM n max. [1/min.]	5000		3000		
Max. actuating force when boring the jaws [kN]	45				
Max. axial drawtube force [pull / push] [kN]	45				
Max. radial clamping force [kN]	60				
Release stroke in Ø [mm]	C	2,2		5	
Reserve stroke in Ø [mm]	D	1,6		2,5	
Stroke per jaw [mm]	AT	1,9		3,8	
Gear cutting type	1,5 x 60° [serration]				
Swing Ø	AX	~149		~220	
Length without jaws [mm]	AI	37,5		40	
Length with jaws [mm]	AJ	77		80	
Bolt hole circle	V	LK Ø 126 [3 x M8]		LK Ø 139 [3 x M8]	
Weight [kg]		6,3		11,3	
In stock		✓		✓	
Material no.		10000718		10000719	
				10000720	
				10000721	

Run-out ≤ 0.020 mm only applies for re-machined soft jaws.

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Please note: The adaptation ring is required for use of the jaw module on a SPANNTOP mini chuck.



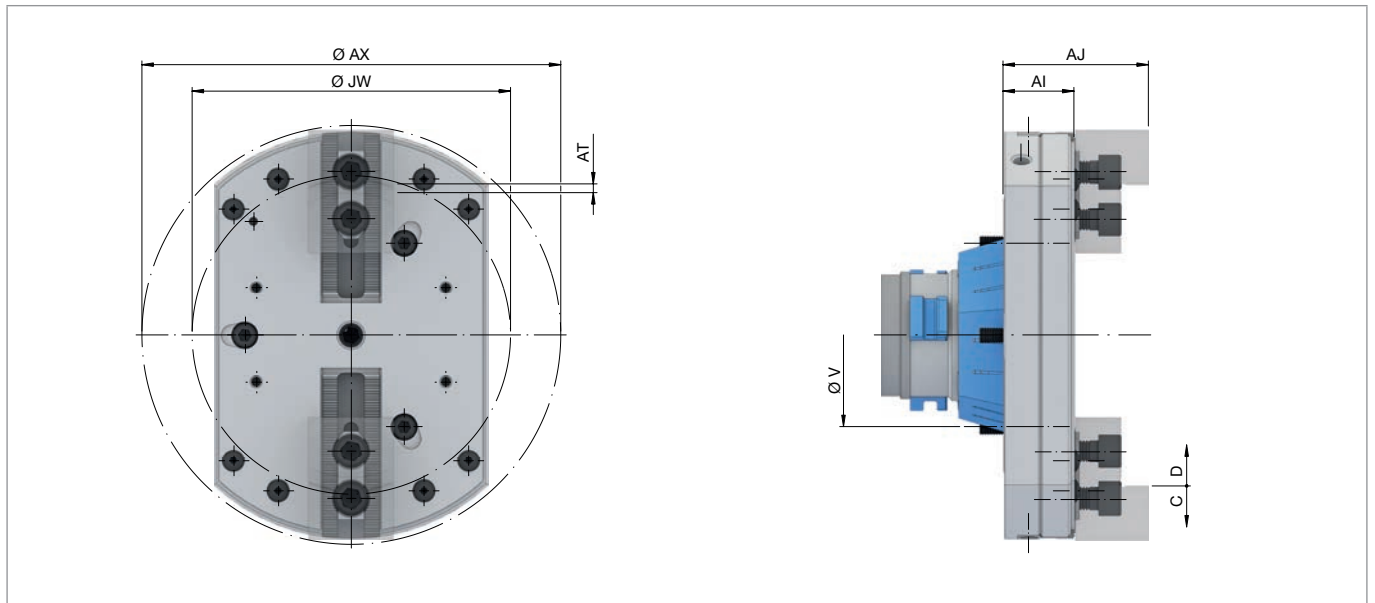
**Scope of delivery**

- 3-jaw module
- T-slot nuts
- Storage box

**Jaw modules**



**2-jaw module SE.** Technical data and order overview

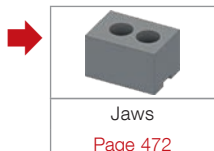


Product line	<b>SE</b>			
Adaptation size	<b>65</b>		<b>100</b>	
Size	<b>215</b>			
Suitable for	TOPlus mini / premium		all except TOPlus mini / premium	
Run-out ≤ [mm]	0,020			
Repeatability ≤ [mm]	0,010			
Clamping range [mm]	JW see overview top jaws			
RPM n max. [1/min.]	1500			
Max. actuating force when boring the jaws [kN]	40			
Max. axial drawtube force [pull / push] [kN]	40			
Max. radial clamping force [kN]	50			
Release stroke in Ø [mm]	C	2,2	5	
Reserve stroke in Ø [mm]	D	1,6	2,5	
Stroke per jaw [mm]	AT	1,9	3,75	
Gear cutting type	1,5 x 60° [serration]			
Swing Ø	AX	220		
Length without jaws [mm]	AI	37,5		
Length with jaws [mm]	AJ	77		
Bolt hole circle	V	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 180 [3 x M8] / LK Ø 160 [3 x M8]
Weight [kg]		10,1	10,2	15,5
In stock		✓	✓	✓ / ✓
Material no.		10016842	10016850	10016847 / 10016848

Run-out ≤ 0.020 mm only applies for re-machined and re-milled jaws.

Clamping repeatability ≤ 0.010 mm for hard reversible stepped jaws:

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

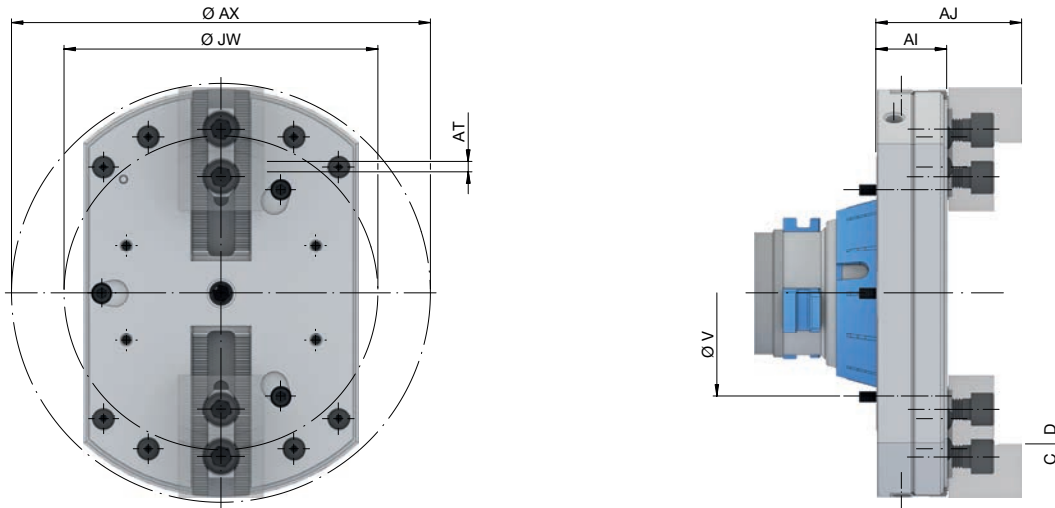


**Scope of delivery**

- 2-jaw module
- T-slot nuts
- Storage box



**2-jaw module RD.** Technical data and order overview



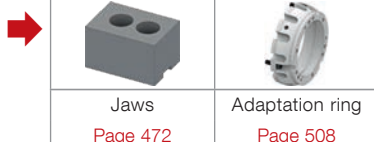
Product line	<b>RD</b>		
Adaptation size	<b>65</b>	<b>80</b>	<b>100</b>
Size		<b>215</b>	
Run-out ≤ [mm]		0,020	
Repeatability ≤ [mm]		0,010	
Clamping range [mm]	JW	see overview top jaws	
RPM n max. [1/min.]		1500	
Max. actuating force when boring the jaws [kN]		40	
Max. axial drawtube force [pull / push] [kN]		40	
Max. radial clamping force [kN]		50	
Release stroke in Ø [mm]	C	2,2	5
Reserve stroke in Ø [mm]	D	1,6	2,5
Stroke per jaw [mm]	AT	1,9	3,75
Gear cutting type		1,5 x 60° [serration]	
Swing Ø	AX	220	
Length without jaws [mm]	AI	37,5	
Length with jaws [mm]	AJ	77	
Bolt hole circle	V	LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]
Weight [kg]		10,2	11,5
In stock		✓	✓
Material no.		<b>10016849</b>	<b>10016843</b>
			<b>10016846</b>

Run-out ≤ 0.020 mm only applies for re-machined and re-milled jaws.

Clamping repeatability ≤ 0.010 mm for hard reversible stepped jaws:

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Please note: The adaptation ring is required for use of the jaw module on a SPANNTOP mini chuck.

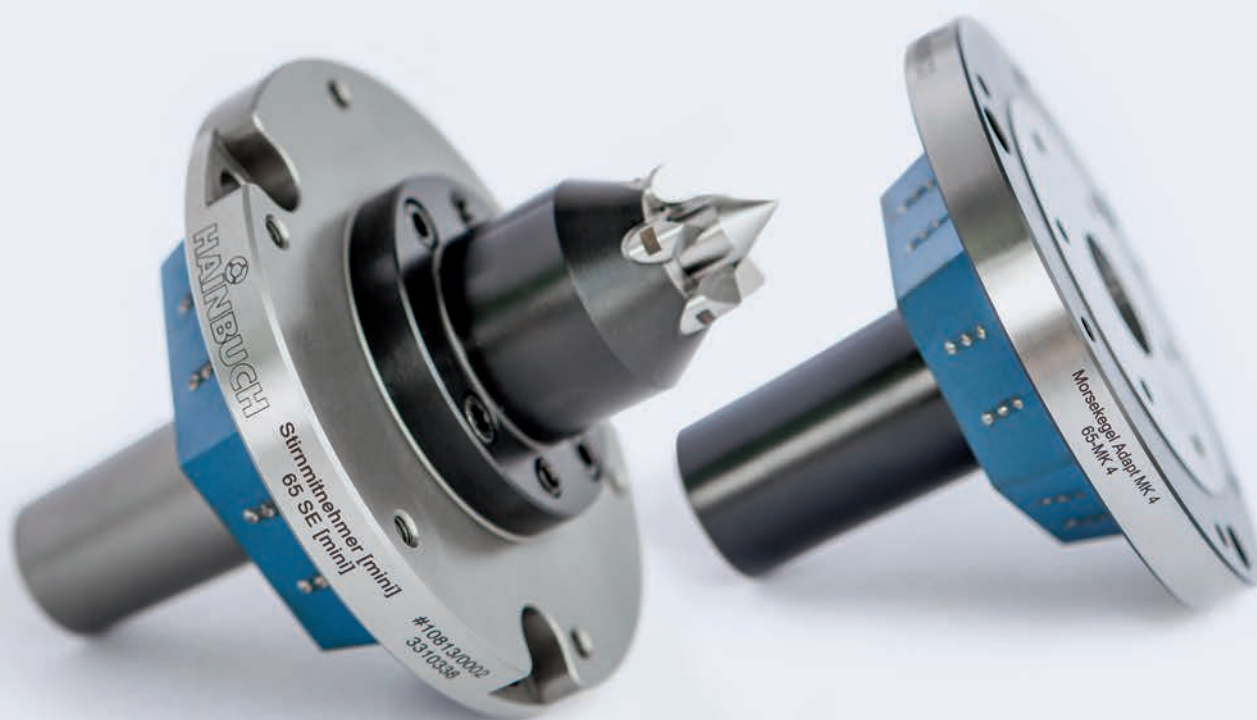


**Scope of delivery**

- 2-jaw module
- T-slot nuts
- Storage box



# Face driver / morse taper adaptation







Be flexible and machine your workpiece over its entire length between centers with the face driver adaptation. First, this increases run-out precision. Secondly, it shapes and positions tolerances better, and thirdly, it speeds up mounting of the face driver adaptation.

The morse taper adaptation gives you even more flexibility. Whether face driver, fixed center, a manually activated mandrel, or even tools – with this adaptation you can use anything that you can adapt with the morse taper connection. Therefore, you have the possibility of extending your chuck with many additional functions within seconds.

This is made possible by the CENTREX quick change-over interface integrated in both adaptations. This enables mounting of the adaptation without the need for alignment.

### Key advantages



- Tremendous flexibility
- Self-centering of the adaptation in the chuck without alignment
- Extremely fast conversion without disassembling the chuck [1 min.]



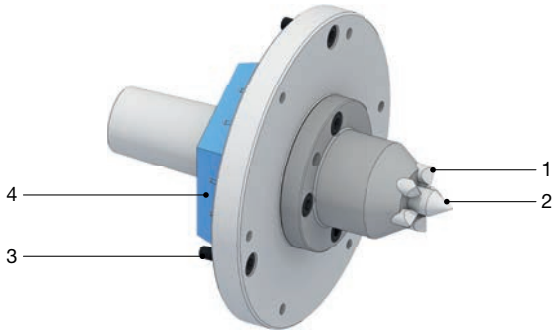
Face driver adaptation on the machine



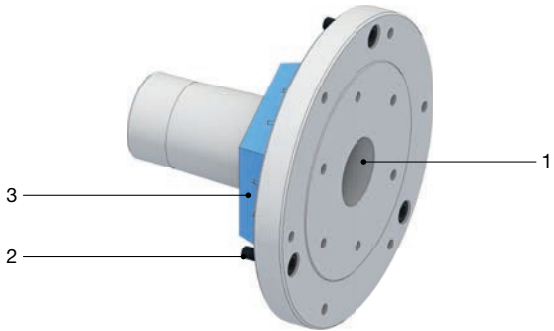
**Face driver / morse taper**

	<b>Face driver adaptation</b>	<b>Morse taper adaptation</b>
		
Description	Adaptation for clamping between centers	Adaptation to the MK4 reception
Sizes	42, 52, 65, 80, 100	42, 52, 65, 80, 100
Clamping range of all sizes [mm]	-	-
Variant	SE [hexagonal], RD [round]	SE [hexagonal], RD [round]
<b>Advantages</b>	<ul style="list-style-type: none"> <li>■ Spring-loaded center</li> <li>■ Hard metal face driver</li> <li>■ Assembly in 1 minute without alignment</li> </ul>	<ul style="list-style-type: none"> <li>■ Adaptation possibility via morse taper</li> <li>■ Assembly in 1 minute without alignment</li> <li>■ Self-centering of the adaptation in the chuck without alignment</li> </ul>

**Face driver SE in detail**

<b>Designation</b>	
<ol style="list-style-type: none"> <li>1 Hard metal face driver</li> <li>2 Spring-loaded center</li> <li>3 Mounting screws</li> <li>4 CENTREX system for <math>\mu\text{m}</math>-precise use without adjustment</li> </ol>	

**Morse taper adaptation SE in detail**

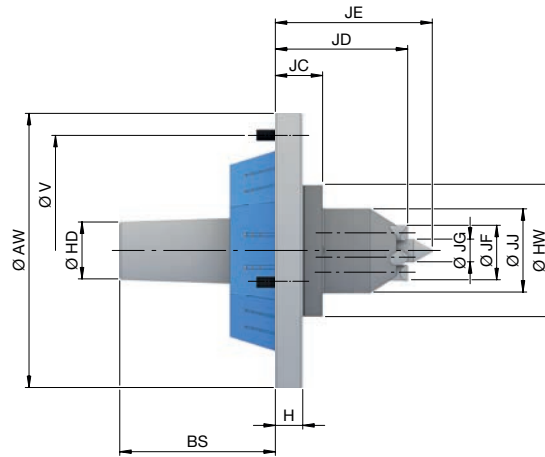
<b>Designation</b>	
<ol style="list-style-type: none"> <li>1 Morse taper size 4</li> <li>2 Mounting screws</li> <li>3 CENTREX system for <math>\mu\text{m}</math>-precise use without adjustment</li> </ol>	



# ADAPTATION CLAMPING DEVICES

## Face driver / morse taper adaptation

### Face driver adaptation SE. Technical data and order overview



Product line	SE											
Size	52		65		100							
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium						
Run-out ≤ [mm]			0,010									
RPM n max. [1/min.]	7000		6000		5000							
Length [mm]	H		14,5									
Length 2 [mm]	BS		82,3		83,3							
Length 3 [mm]	JC		25									
Length 4 [mm]	JD		70		81,5							
Length 5 [mm]	JE		83		101							
Outer Ø [mm]	AW	119	125	129	145	183	215					
Outer Ø 2 [mm]	HD			30								
Outer Ø 3 [mm]	HW	52		70		86						
Outer Ø 4 [mm]	JJ	29		44		60						
Driving pin-Ø	JF	20		31		45						
Center-Ø	JG	6		12		20						
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]					
Weight [kg]	2,3		3,6		7,7							
In stock	-		✓		-		✓					
Material no.	10000993		10000603		10000994		10000604		10000995		10000605	

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Adaptation clamping devices

Measuring technology / Automation

Quick change-over systems

Special solutions

Clamping elements / Accessories

Services

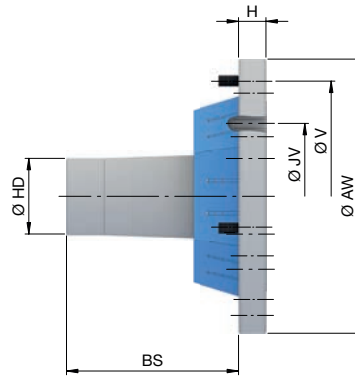
Multi spindles

# ADAPTATION CLAMPING DEVICES

## Face driver / morse taper adaptation



### Morse taper adaptation [MK4] SE. Technical data and order overview



Product line	SE						
Size	52		65		100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Run-out ≤ [mm]	0,010						
RPM n max. [1/min.]	7000		6000		5000		
Length [mm]	H		14,5				
Length 2 [mm]	BS		91				
Outer Ø [mm]	AW	119	125	129	145	183	215
Outer Ø 2 [mm]	HD	40					
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Bolt hole circle 2	JV	LK Ø 60 [6 x M6]		LK Ø 77 [6 x M6]		LK Ø 80 [6 x M6]	
Weight [kg]	2		2,8		6		
In stock	-	✓	✓	✓	-	✓	
Material no.	10000996	10000614	10000997	10000615	10000998	10000616	

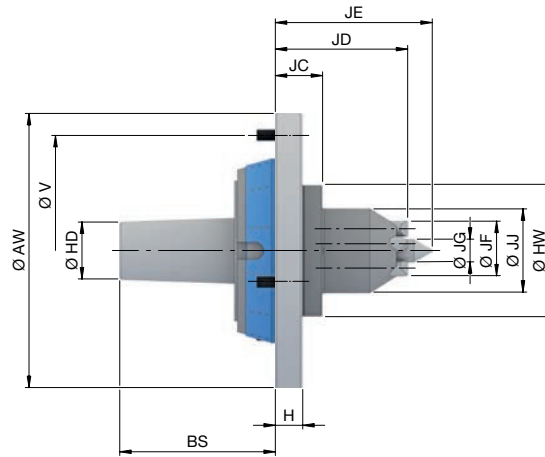
Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



# ADAPTATION CLAMPING DEVICES

## Face driver / morse taper adaptation

### Face driver adaptation RD. Technical data and order overview



Product line	<b>RD</b>				
Size	<b>42/52</b>	<b>65</b>	<b>80</b>	<b>100</b>	
Run-out ≤ [mm]	0,010				
RPM n max. [1/min.]	7000	6000	5500	5000	
Length [mm]	14,5				
Length 2 [mm]	BS	82,3	83,3		
Length 3 [mm]	JC	25			
Length 4 [mm]	JD	56	81,5		
Length 5 [mm]	JE	63,5	101		
Outer Ø [mm]	AW	125	160	215	
Outer Ø 2 [mm]	HD	30			
Outer Ø 3 [mm]	HW	52	70	86	
Outer Ø 4 [mm]	JJ	29	44	60	
Driving pin-Ø	JF	20	31	45	
Center-Ø	JG	6	12	20	
Bolt hole circle	V	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Weight [kg]	2,4	3,4	4,6	6	
In stock	✓	✓	✓	✓	
Material no.	10000606	10000608	10000609	10000610	

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



Adaptation clamping devices

Measuring technology/ Automation

Quick change-over systems

Special solutions

Clamping elements/ Accessories

Services

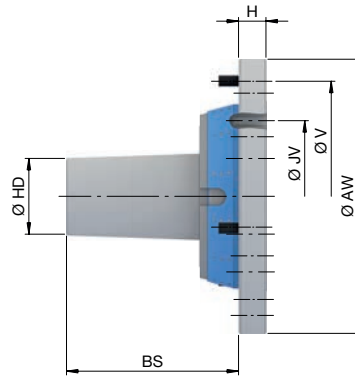
Multi spindles

# ADAPTATION CLAMPING DEVICES

## Face driver / morse taper adaptation



### Morse taper adaptation [MK4] RD. Technical data and order overview



Product line	RD			
Size	42/52	65	80	100
Run-out ≤ [mm]	0,010			
RPM n max. [1/min.]	7000	6000	5500	5000
Length [mm]	14,5			
Length 2 [mm]	91			
Outer Ø [mm]	40			
Outer Ø 2 [mm]	40			
Bolt hole circle	V LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Bolt hole circle 2	JV LK Ø 60 [6 x M6]	LK Ø 80 [6 x M6]		
Weight [kg]	2	2,7	3,5	5,7
In stock	✓	✓	✓	✓
Material no.	10000617	10000618	10000619	10000620

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



# ADAPTATION CLAMPING DEVICES

## Magnet module

Adaptation  
clamping devices

Measuring tech-  
nology/ Automation

Quick change-  
over systems

Special solutions

Clamping elements/  
Accessories

Services

Multi spindles



# Magnet module

Adaptation for magnetic clamping







In daily use you are optimally equipped with the TOPlus or SPANNTOP chucks. However, there are always components that are difficult to clamp due to the contour, or that will be deformed through radial clamping. So what is required is an axial chuck, which in addition can also be set up very fast.

The answer: the HAINBUCH magnet module. With the magnet module you can clamp components axially on a neodymium magnet. The HAINBUCH magnet module is set up in only 30 seconds. Your basic clamping device is already mounted. You exchange the clamping head that is included in the scope of delivery. When clamping, the magnetic clamping device is pulled onto the flat contact area of your basic clamping device. If, after initial installation, the magnet module is planed flat and the install position is marked, a face change-over accuracy of 2 µm can be achieved. The workpiece itself is clamped by hand on the magnet.

#### Key advantages

- End face axial clamping via neodymium magnet
- High face-run change-over accuracy
- High holding power of 140 N/cm<sup>2</sup>
- Assembly in 30 seconds without alignment
- Low maintenance because it is resistant to contamination



Magnet module in use

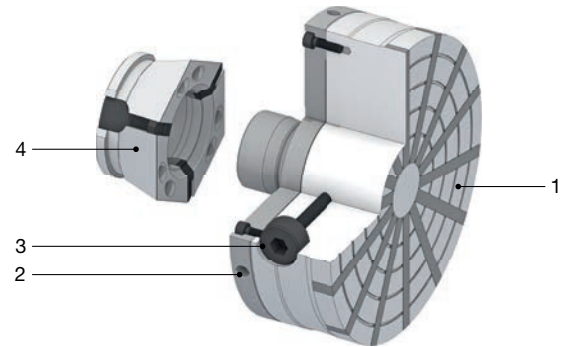
## Magnet module



### Magnet module in detail

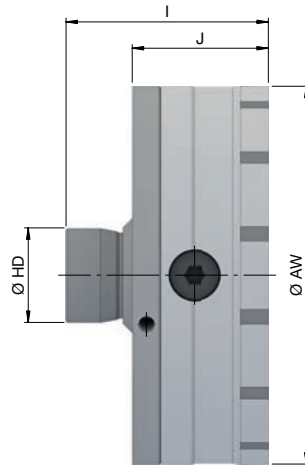
#### Designation

- 1 Magnet module
- 2 Thread for transport lug
- 3 Actuating screw for the magnet
- 4 Magnet module clamping head





**Magnet module starter-set.** Technical data and order overview



Product line	SE			RD			
Size	52	65	100	52	65	80	100
Size – magnet module				200			
Clamping force [N/cm <sup>2</sup> ]				140			
RPM n max. [1/min.]				2500			
Min. draw force axial [kN]				10			
Total length [mm]	I			107			
Height [mm]	J			72			
Outer Ø [mm]	AW			200			
Outer Ø 2 [mm]	HD			50			
Weight [kg]				18			
In stock	✓	✓	✓	✓	✓	✓	✓
Material no.	10001034	10001035	10001036	10001040	10001041	10001042	10001043

Please note: The magnet module is only suitable for modular and pull-back clamping devices.

**Scope of delivery**

- Magnet module
- Clamping head for magnet module
- Storage box

**Clamping head for magnet module.** For use of an existing magnet module on a different chuck size.

Product line	Size	In stock	Material no.
SE	52	✓	10001037
	65	✓	10001038
	100	✓	10001039
RD	52	✓	10001044
	65	✓	10001045
	80	✓	10001046
	100	✓	10001047