Overview

Find what's important fast

Stationary clamping devices

Stationary clamping devices

Stationary standard clamping devices in overview

	MANOK	MANOK plus	HYDROK
			
Description	Manual stationary chuck	Manual stationary chuck with adaptation possibility	Hydraulic stationary chuck with adaptation possibility
Sizes	42, 52, 65, 80, 100	52, 65	SE 40, 65, 80, 100 / RD 32, 42, 52, 65, 80, 100
Clamping range of all sizes [mm]	3 – 100	3 – 65	3 – 100
Variant	RD [round]	SE [hexagonal], RD [round]	SE [hexagonal], RD [round]
Advantages	■ Easy set-up ■ Sensitive manual clamping is possible ■ Ideal for 5-sided machining ■ Clamping is possible with work-piece end-stop or front end-stop	■ Also available in a CFRP light-weight design ■ Sensitive manual clamping is possible ■ Workpiece stabilization through axial draw force applied against the workpiece end-stop ■ Ideal for 5-sided machining	■ Ideal for automated clamping ■ Angular contour requires less space ■ Multiple clamping made possible in the smallest space ■ Ideal for 5-sided machining
Clamping elements	 Clamping head RD	 Clamping head SE  Clamping head RD	 Clamping head SE  Clamping head RD
Adaptations	 Magnet module RD [Adaptation for magnetic clamping]	 MANDO Adapt T211 SE / RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE / RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE / RD [Adaptation for jaw clamping]  Magnet module SE / RD [Adaptation for magnetic clamping]	 MANDO Adapt T211 SE / RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE / RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE / RD [Adaptation for jaw clamping]  Magnet module SE / RD [Adaptation for magnetic clamping]
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InoFlex VF

Manual stationary chuck

160, 260

8 – 291

- 4-sided clamping [2x2] with compensation of the opposing jaws
- Ideal for clamping workpieces that are susceptible to deformation
- Large stroke and compensating stroke for each jaw
- For I.D. and O.D. clamping

Jaws

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MANOK

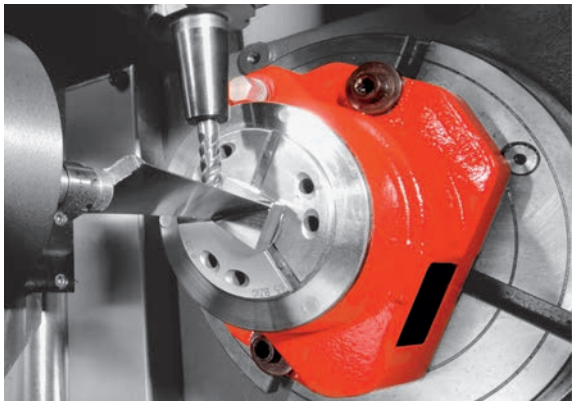
Small but powerful

It isn't just the price-performance ratio of MANOK that is impressive. With its incredible holding power, precision and rigidity, MANOK has already surprised many users who never would have imagined that this kind of quality could be found in a manual clamping device. In addition, you can also mount an end-stop to the MANOK in no time at all: Simply fasten the inside end-stop directly onto your machine tool table or mount a front end-stop on the face of the clamping taper. That's it!

MANOK is not only practical and economical, but it is also extremely versatile. For instance, the integrated actuation lever makes this possible by functioning as an additional force accumulator and acts as an anti-vibration device during milling.

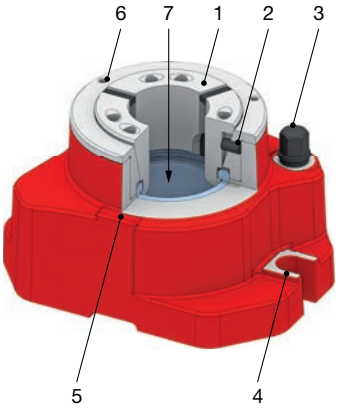
Key advantages

- Easy set-up
- Sensitive manual clamping is possible
- Ideal for 5-sided machining
- Clamping is possible with workpiece end-stop or front end-stop
- Absolute versatile implementation on machining centers, measuring machines, slotters, broaching machines, drilling machines, laser marking machines etc.
- Workpiece stabilization through axial draw force applied against the workpiece end-stop

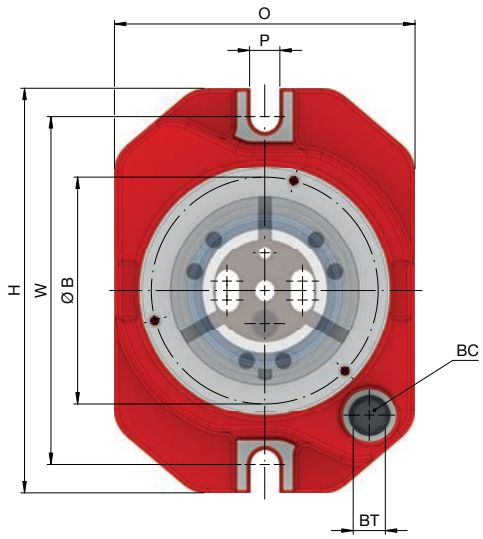


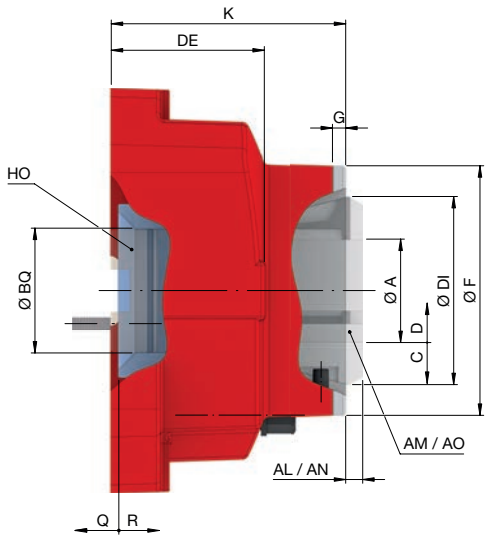
MANOK manual stationary chuck in use.
Photo: OEM Berthold Hermle

Manual stationary chuck MANOK in detail

Designation	
1 Clamping head with hardened steel segments joined in a vulcanization process 2 Torsional safety lock of the clamping head 3 Manual actuation via hexagonal nut 4 Mounting groove 5 Supporting surface for additional holding clamps 6 Reception for front end-stop 7 Full passage available	

Manual stationary chuck MANOK. Technical data and order overview





Size		42	52	65	80	100
Clamping range [mm]	A	**3 – 42**	**3 – 52**	**3 – 65**	**4 – 80**	**15 – 100**
Repeatability ≤ [mm]		0,010				
Max. radial clamping force [kN]		80	94	105	115	150
Max. axial drawtube force [pull / push] [kN]		35	40	45	50	65
Max. actuating torque [Nm]	BC	50	60	70	60	80
Bolt hole distance [mm]	W	184			236	
Release stroke in Ø [mm]	C	0,6				2
RPM n max. [1/min.]		60				
Reserve stroke in Ø [mm]	D	1				1,5
Reserve stroke axial [mm]	Q	2				3
Release stroke axial [mm]	R	2,5			5	
Location front end-stop	F	Ø 132 f7			Ø 178 f7	
Centering length [mm]	G	7			11,5	
Bolt hole circle end-stop	B	LK Ø 120 [3 x M6]			LK Ø 165 [3 x M6]	
Ø Capacity [mm]	BQ	56		66	80,5	102
Length [mm]	H	214			264	
Overall height [mm]	K	124			140	
Width [mm]	O	159			210	
Screw connection width [mm]	P	16			16,6	
Clamping edge height [mm]	DE	81			93	
Wrench size [SW]	BT	17				
Head Ø [mm]	DI	80		99,5	115	144,5
Clamping head serrated	AM	SK 42 BZI	SK 52 BZI	SK 65 BZI	SK 80 BZI	SK 100 BZ
Clamping head protrusion length serrated [mm]	AL	9	4	9	4	0
Clamping head smooth	AO	SK 42 BZIG	SK 52 BZIG	SK 65 BZIG	SK 80 BZIG	SK 100 BZG
Clamping head protrusion length smooth [mm]	AN	4				0
Workpiece end-stop	HO	available as accessory				
Weight [kg]		14,3	14,1	12,9	22,3	21,6
In stock		✔	✔	✔	✔	✔
Material no.		10001427	10001426	10001425	10001430	10001424

			
Clamping heads Page 430	Magnet module Page 332	Clamping head adapter Page 513	Accessory overview Page 478

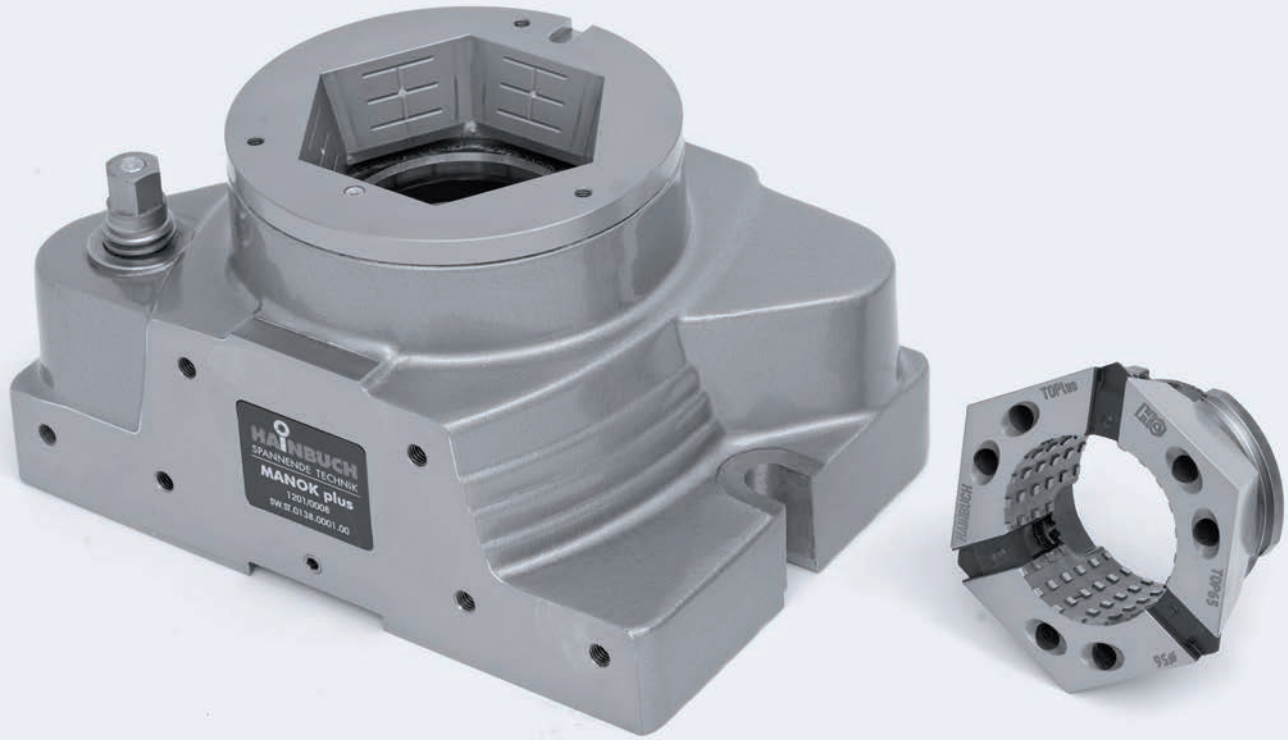
Scope of delivery

- Stationary chuck
- Actuation tool

MANOK plus

Incredibly versatile

HAINBUCH SYSTEM



Manual stationary chuck MANOK plus

MANOK plus, the extended variant of our manual MANOK stationary chuck differs through use of adaptation elements. For example, many more clamping possibilities are available to you in combination with the MANDO Adapt mandrel-in-chuck or the jaw module for even larger clamping diameters.

And most recent: Due to the optional lightweight CFRP design, with the MANOK plus CFK you can save half of the weight. The lightweights are easy to set-up and particularly well-suited for milling machines and machining centers with small load weights. Plus they protect machine components, which ultimately helps the machine accuracy. When loading manually or with a handling system, often the only possible solution is a lightweight stationary chuck.

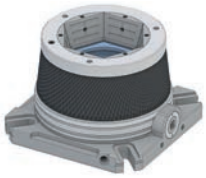
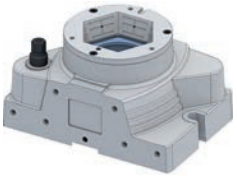
Key advantages

- Also available in a CFRP lightweight design
- Sensitive manual clamping is possible
- Workpiece stabilization through axial draw force applied against the workpiece end-stop
- Ideal for 5-sided machining
- Adaptation devices possible [HAINBUCH SYSTEM]

MANOK plus manual stationary chuck in use

Manual stationary chuck MANOK plus

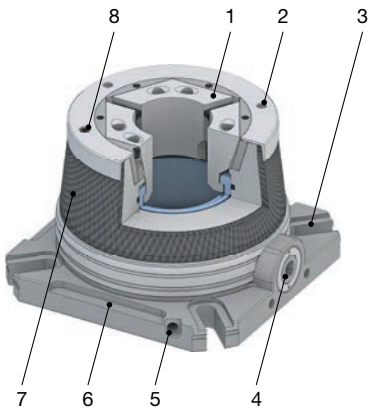
MANOK plus at a glance

	MANOK plus CFK	MANOK plus
		
Description	Hand-actuated lightweight clamping device	Manual stationary chuck
Variant	SE [hexagonal] / RD [round]	SE [hexagonal] / RD [round]
Advantages	■ Made of carbon fiber ■ As much as 60 % lighter than the standard model	■ Lateral set-up on optional baseplate is possible
Clamping elements	 Clamping head SE  Clamping head RD	 Clamping head SE  Clamping head RD
Adaptations	 MANDO Adapt T211 SE / RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE / RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE / RD [Adaptation for jaw clamping]  Magnet module SE / RD [Adaptation for magnetic clamping]	 MANDO Adapt T211 SE / RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE / RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE / RD [Adaptation for jaw clamping]  Magnet module SE / RD [Adaptation for magnetic clamping

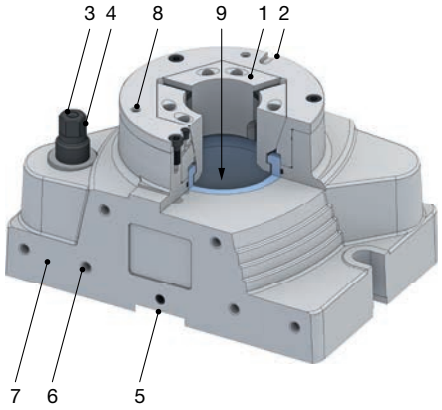
Manual stationary chuck MANOK plus CFK SE in detail

Designation

1 Clamping head with hexagonal geometry for optimal chuck seal and greater clamping force
2 Reception for front end-stop
3 Mounting groove
4 Manual actuation
5 Clamping screw for base end-stop
6 Supporting surface for additional holding clamps
7 Chuck body made of carbon fiber
8 Grease nipple



Manual stationary chuck MANOK plus SE in detail

Designation	
1 Clamping head with hexagonal geometry for optimal chuck seal and greater clamping force 2 Reception for front end-stop with guide groove for radial alignment 3 Central grease nipple, optimal draw-in force due to perfect lubrication 4 Manual actuation via hexagonal nut 5 Guide groove for table alignment 6 Thread for mounting end-stops or for horizontal clamping set-up 7 Ground surface for horizontal set-up 8 Reception for front end-stop 9 Full passage after removal of the base end-stop that is accessible from the outside	

Order overview.
Manual stationary chuck MANOK plus CFK SE / RD

				Clamping elements and adaptations				
								
Product line	Size	Material no.	In stock	Clamping head SE Page 422	MANDO Adapt T211 SE Page 274	MANDO Adapt T212 SE Page 280	Jaw module SE Page 316	Magnet module SE Page 332
SE	52	10000484	-	✔	✔	✔		✔
	65	10000485	-	✔	✔	✔	✔	✔
Product line	Size	Material no.	In stock	Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	Jaw module RD Page 316	Magnet module RD Page 332
RD	52	10000482	-	✔	✔	✔		✔
	65	10000483	-	✔	✔	✔	✔	✔

Detailed technical data follows.

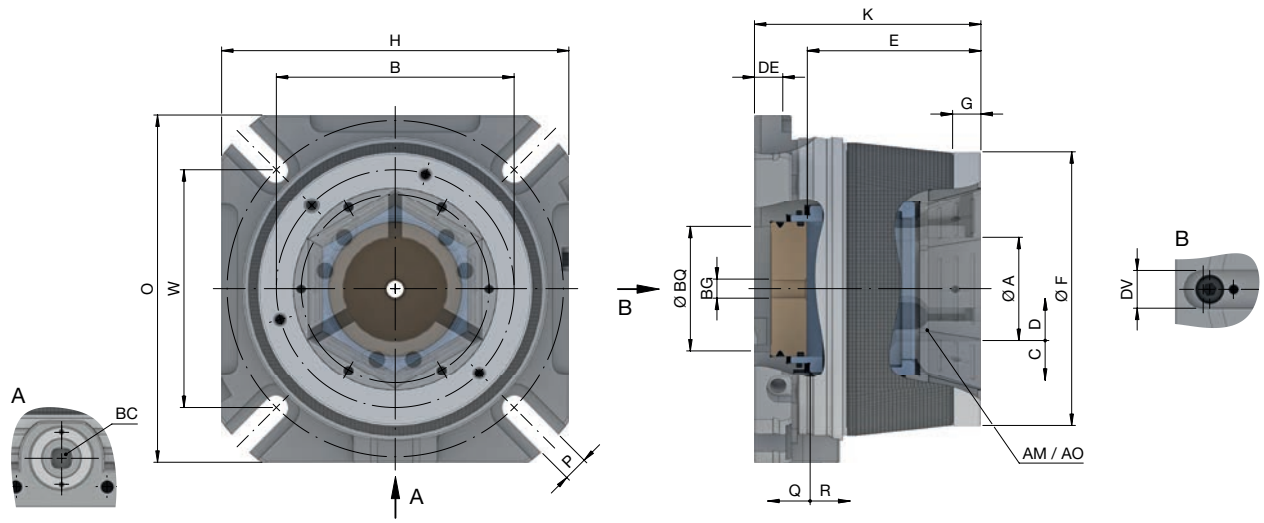
Order overview.
Manual stationary chuck MANOK plus SE / RD

				Clamping elements and adaptations				
								
Product line	Size	Material no.	In stock	Clamping head SE Page 422	MANDO Adapt T211 SE Page 274	MANDO Adapt T212 SE Page 280	Jaw module SE Page 316	Magnet module SE Page 332
SE	65	10001429	✔	✔	✔	✔	✔	✔
Product line	Size	Material no.	In stock	Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	Jaw module RD Page 316	Magnet module RD Page 332
RD	65	10001428	✔	✔	✔	✔	✔	✔

Detailed technical data follows.

Manual stationary chuck MANOK plus

Manual stationary chuck MANOK plus CFK SE. Technical data



Product line		SE	
Size		**52**	**65**
Clamping range [mm]	A	3 – 52	3 – 65
Repeatability ≤ [mm]		0,010	
Max. radial clamping force [kN]		108	120
Max. axial drawtube force [pull / push] [kN]		40	45
Max. actuating torque [Nm]	BC	75	90
Release stroke in Ø [mm]	C	0,6	
RPM n max. [1/min.]		60	
Reserve stroke in Ø [mm]	D	1	
Reserve stroke axial [mm]	Q	2	
Release stroke axial [mm]	R	2,5	
Location front end-stop	F	Ø 125 f7	Ø 145 f7
Centering length [mm]	G	15	
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]
End-stop depth [mm]	E	90	92
End-stop thread size [M]	BG	10	12
Ø Capacity [mm]	BQ	53	66
Length [mm]	H	161	184
Overall height [mm]	K	115	120
Width [mm]	O	161	184
Screw connection width [mm]	P	13	
Clamping edge height [mm]	DE	15	
Bolt hole distance [mm]	W	120	126
Groove seat	DV	14 H7	20 H7
Clamping head serrated	AM	TOP 52	TOP 65
Clamping head smooth	AO	TOP 52 G	TOP 65 G
Weight [kg]		7	10,3
In stock		-	-
Material no.		10000484	10000485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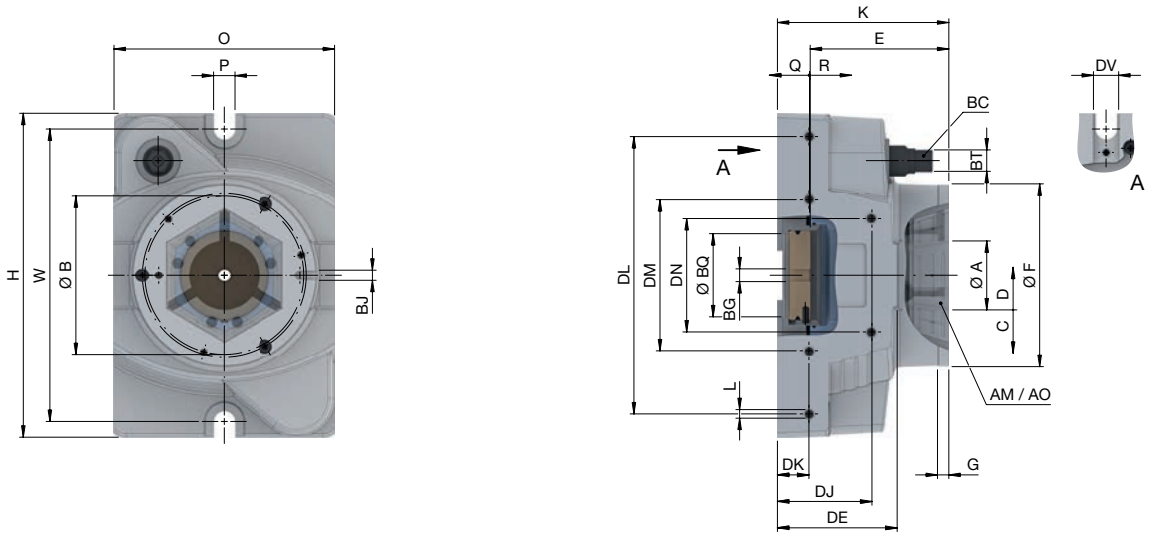
Scope of delivery

- Stationary chuck
- Base end-stop
- Actuation tool

Manual stationary chuck MANOK plus SE. Technical data



Product line		SE
Size		**65**
Clamping range [mm]	A	3 – 65
Repeatability ≤ [mm]		0,010
Max. radial clamping force [kN]		120
Max. axial drawtube force [pull / push] [kN]		45
Max. actuating torque [Nm]	BC	100
Release stroke in Ø [mm]	C	0,6
RPM n max. [1/min.]		60
Reserve stroke in Ø [mm]	D	1
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5
Location front end-stop	F	Ø 145 f7
Centering length [mm]	G	9
Bolt hole circle end-stop	B	LK Ø 126 [3 x M6]
Groove width [mm]	BJ	8 H7
End-stop depth [mm]	E	110
End-stop thread size [M]	BG	12
Ø Capacity [mm]	BQ	66
Length [mm]	H	257
Overall height [mm]	K	136
Width [mm]	O	175
Screw connection width [mm]	P	17
Clamping edge height [mm]	DE	95
Thread size [M]	L	8
Screw-on height 1 [mm]	DJ	75
Screw-on height 2 [mm]	DK	25
Screw connection spacing 1 [mm]	DL	220
Screw connection spacing 2 [mm]	DM	120
Screw connection spacing 3 [mm]	DN	90
Bolt hole distance [mm]	W	232
Groove seat	DV	20 H7
Wrench size [SW]	BT	17
Clamping head serrated	AM	TOP 65
Clamping head smooth	AO	TOP 65 G
Weight [kg]		23,5
In stock		✔
Material no.		10001429


Clamping heads
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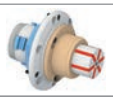
Adaptations I.D. clamping
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Adaptations jaw clamping
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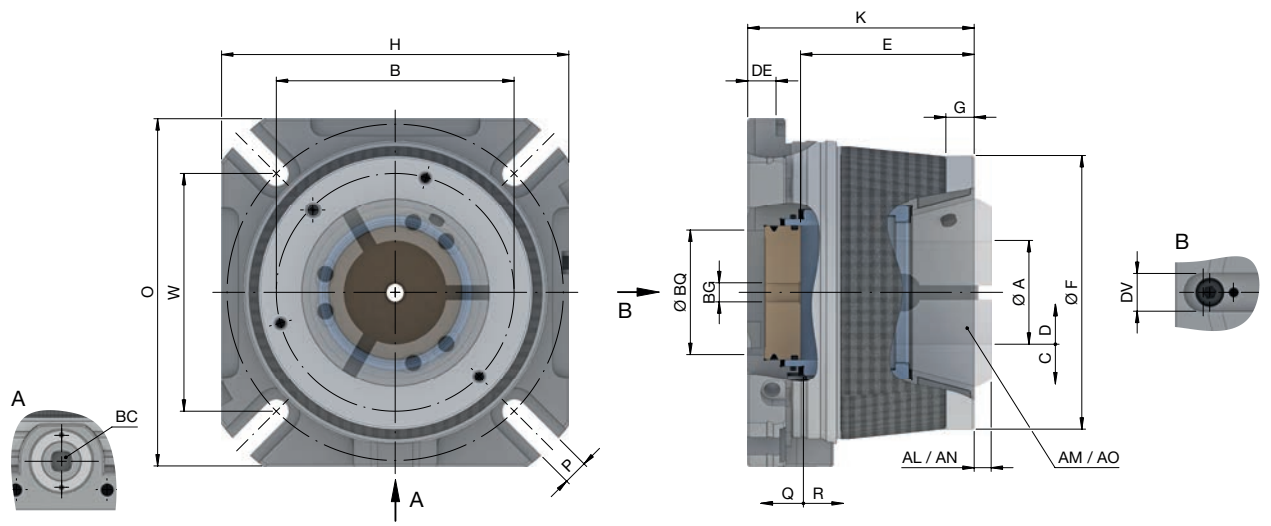
Scope of delivery

- Stationary chuck
- Base end-stop
- Actuation tool

Manual stationary chuck MANOK plus CFK RD. Technical data



Product line		RD	
Size		**52**	**65**
Clamping range [mm]	A	3 – 52	3 – 65
Repeatability ≤ [mm]		0,010	
Max. radial clamping force [kN]		94	105
Max. axial drawtube force [pull / push] [kN]		40	45
Max. actuating torque [Nm]	BC	75	90
Release stroke in Ø [mm]	C	0,6	
RPM n max. [1/min.]		60	
Reserve stroke in Ø [mm]	D	1	
Reserve stroke axial [mm]	Q	2	
Release stroke axial [mm]	R	2,5	
Location front end-stop	F	Ø 125 f7	Ø 145 f7
Centering length [mm]	G	15	
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]
End-stop depth [mm]	E	90	92
End-stop thread size [M]	BG	10	12
Ø Capacity [mm]	BQ	53	66
Length [mm]	H	161	184
Overall height [mm]	K	115	120
Width [mm]	O	161	184
Screw connection width [mm]	P	13	
Clamping edge height [mm]	DE	15	
Bolt hole distance [mm]	W	120	126
Groove seat	DV	14 H7	20 H7
Clamping head serrated	AM	SK 52 BZI	
Clamping head protrusion length serrated [mm]	AL	4	9
Clamping head smooth	AO	SK 52 BZIG	SK 65 BZIG
Clamping head protrusion length smooth [mm]	AN	4	
Weight [kg]		7	10,3
In stock		-	-
Material no.		10000482	10000483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Adaptations I.D. clamping
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Adaptations jaw clamping
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Magnet module
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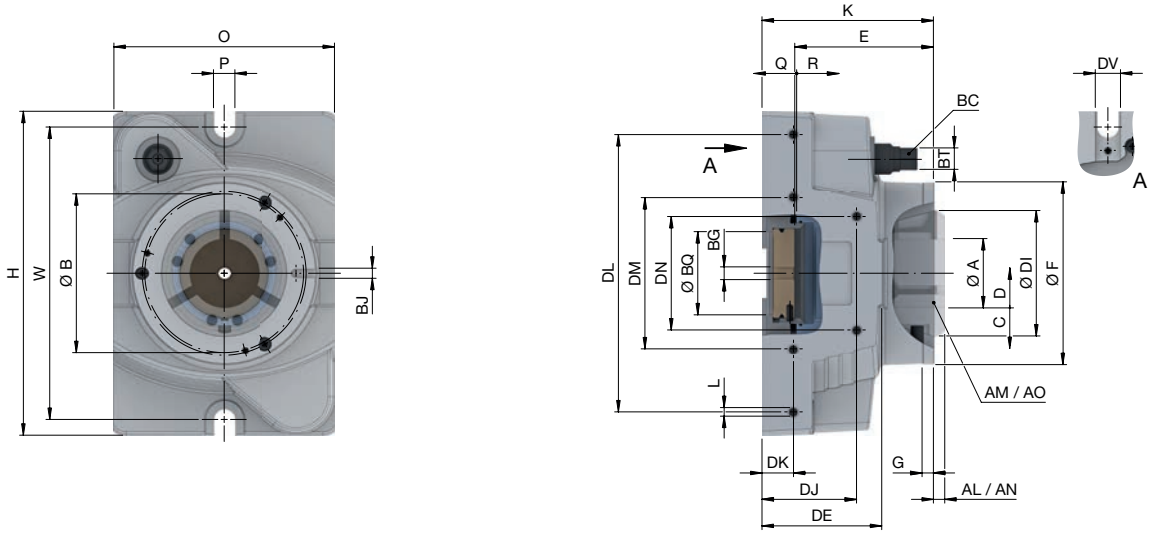
Scope of delivery

- Stationary chuck
- Base end-stop
- Actuation tool

Manual stationary chuck MANOK plus RD. Technical data



Product line		RD
Size		**65**
Clamping range [mm]	A	3 – 65
Repeatability ≤ [mm]		0,010
Max. radial clamping force [kN]		105
Max. axial drawtube force [pull / push] [kN]		45
Max. actuating torque [Nm]	BC	100
Release stroke in Ø [mm]	C	0,6
RPM n max. [1/min.]		60
Reserve stroke in Ø [mm]	D	1
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5
Location front end-stop	F	Ø 145 f7
Centering length [mm]	G	9
Bolt hole circle end-stop	B	LK Ø 126 [3 x M6]
Groove width [mm]	BJ	8 H7
End-stop depth [mm]	E	110
End-stop thread size [M]	BG	12
Ø Capacity [mm]	BQ	66
Length [mm]	H	257
Overall height [mm]	K	136
Width [mm]	O	175
Screw connection width [mm]	P	17
Clamping edge height [mm]	DE	95
Thread size [M]	L	8
Screw-on height 1 [mm]	DJ	75
Screw-on height 2 [mm]	DK	25
Screw connection spacing 1 [mm]	DL	220
Screw connection spacing 2 [mm]	DM	120
Screw connection spacing 3 [mm]	DN	90
Bolt hole distance [mm]	W	232
Groove seat	DV	20 H7
Wrench size [SW]	BT	17
Head Ø [mm]	DI	99,5
Clamping head serrated	AM	SK 65 BZI
Clamping head protrusion length serrated [mm]	AL	9
Clamping head smooth	AO	SK 65 BZIG
Clamping head protrusion length smooth [mm]	AN	4
Weight [kg]		23,5
In stock		✔
Material no.		10001428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Adaptations jaw clamping
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Accessory overview
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Scope of delivery

- Stationary chuck
- Base end-stop
- Actuation tool

HYDROK

Convincing in performance

HAINBUCH SYSTEM

Hydraulic stationary chuck HYDROK

5-axis machining or efficient multiple clamping – with the HYDROK we offer a hydraulically actuated stationary chuck that provides even more implementation possibilities. Depending on the size, you can use it with all clamping device adaptations, such as the MANDO Adapt mandrel-in-clamping device or the jaw module. In the future you can also rely completely on the intelligent HAINBUCH SYSTEM, also for your stationary clamping device.

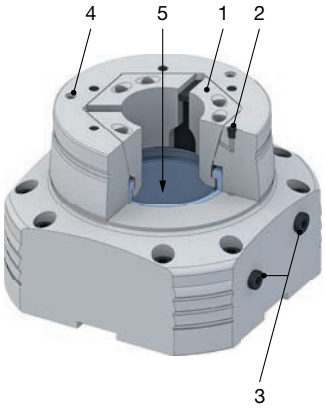
Our smallest modules: HYDROK 40 SE and 32 RD. Their modular base plates can be easily fitted together and enable multiple clamping setups with incredible holding forces in the most confined spaces. And with an additional tandem cylinder you can even generate the full clamping force with a weaker hydraulic unit.

Key advantages

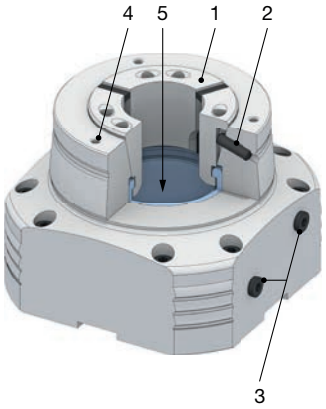
- Ideal for automated clamping
- Angular contour requires less space
- Multiple clamping made possible in the smallest space
- Ideal for 5-sided machining
- Clamping is possible with workpiece end-stop or front end-stop
- Adaptation devices possible [HAINBUCH SYSTEM]

HYDROK hydraulic stationary chuck in use

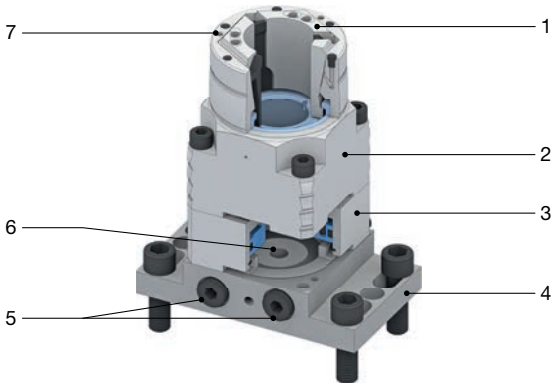
HYDROK SE in detail

Designation	
1 Clamping head with hexagonal geometry for optimal chuck seal and greater clamping force 2 Central grease nipple, optimum tool life and holding power due to perfect lubrication 3 Side and/or bottom hydraulic connections available 4 Reception for front end-stop 5 Full passage available	

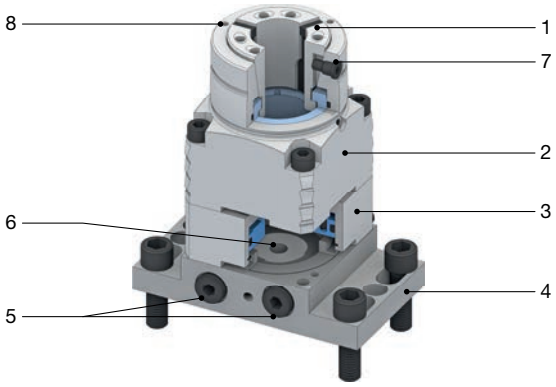
HYDROK RD in detail

Designation	
1 Clamping head with hardened steel segments joined in a vulcanization process 2 Torsional safety lock of the clamping head 3 Side and/or bottom hydraulic connections available 4 Reception for front end-stop 5 Full passage available	

HYDROK SE size 40 in detail

Designation	
1 Clamping head with hexagonal geometry for optimal chuck seal and greater clamping force 2 HYDROK SE 40 3 Tandem cylinder, insert at low actuation pressure [optional] 4 Modular base plate, several adaptation possibilities for multiple clamping [optional] 5 Hydraulic connections 6 Location for depth end-stop 7 Reception for front end-stop	

HYDROK RD size 32 in detail

Designation	
1 Clamping head with hardened steel segments joined in a vulcanization process 2 HYDROK RD 32 3 Tandem cylinder, insert at low actuation pressure [optional] 4 Modular base plate, several adaptation possibilities for multiple clamping [optional] 5 Hydraulic connections 6 Location for depth end-stop 7 Torsional safety lock of the clamping head 8 Reception for front end-stop	

Order overview.
Hydraulic stationary chuck HYDROK SE

Product line	Size	Material no.	In stock	Clamping elements and adaptations: Clamping head SE Page 422	MANDO Adapt T211 SE Page 274	MANDO Adapt T212 SE Page 280	Jaw module SE Page 316	Magnet module SE Page 332
SE	40	10001416	✔	✔				
	52	10001415	✔	✔	✔	✔		✔
	65	10001407	✔	✔	✔	✔	✔	✔
	100	10001412	✔	✔	✔	✔	✔	✔

Detailed technical data follows.

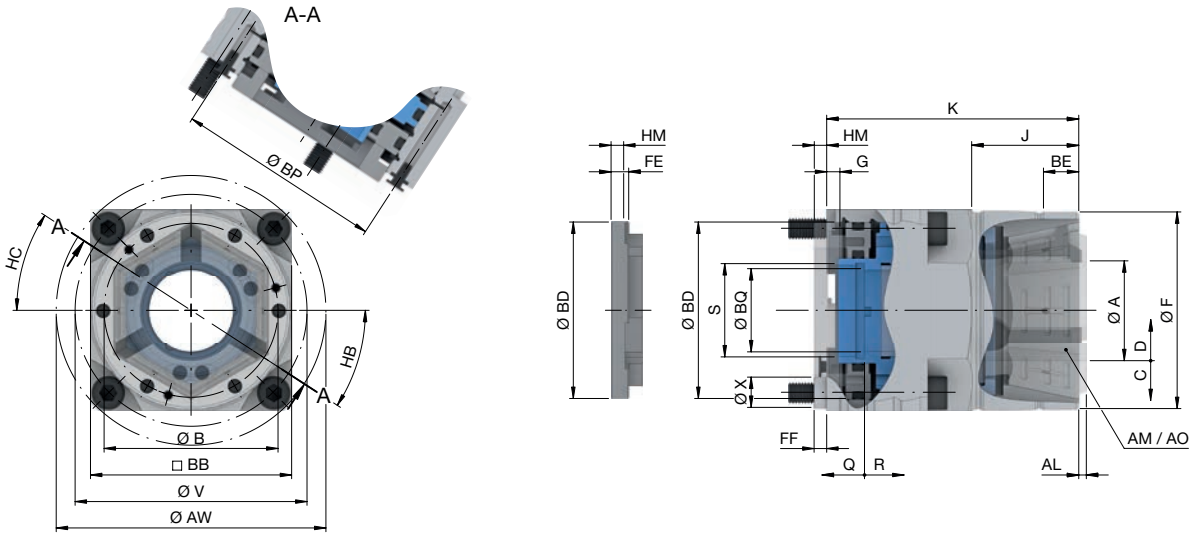
Order overview.
Hydraulic stationary chuck HYDROK RD

Product line	Size	Material no.	In stock	Clamping elements and adaptations: Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	Jaw module RD Page 316	Magnet module RD Page 332
RD	32	10001414	✔	✔				
	42	10001408	✔	✔	✔	✔		
	52	10001409	✔	✔	✔	✔		✔
	65	10001406	✔	✔	✔	✔	✔	✔
	80	10001410	✔	✔	✔	✔	✔	✔
	100	10001411	✔	✔	✔	✔	✔	✔

Detailed technical data follows.

Scope of delivery
- Stationary chuck

HYDROK SE size 40. Technical data



Product line		SE
Size		**40**
Clamping range [mm]	A	3 – 40
Repeatability ≤ [mm]		0,010
Max. axial drawtube force [pull / push] [kN]		27
Max. radial clamping force [kN]		75
Max. actuating pressure [bar]		110
Release stroke in Ø [mm]	C	0,5
RPM n max. [1/min.]		60
Reserve stroke in Ø [mm]	D	0,8
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2
Location front end-stop	F	Ø 78 f7
Length flange location [mm]	BE	14
Bolt hole circle end-stop	B	LK Ø 69 [3 x M4]
Ø Capacity [mm]	BQ	33
Height [mm]	J	42,5
Overall height [mm]	K	100
Outer variant [mm]	BB	79,8
Connecting position [mm]	BP	82
Outer Ø [mm]	AW	106 h7
Bolt hole circle	V	LK Ø 92 [4 x M8]
Clamping via base plate [°]	HB	33
Release via base plate [°]	HC	33
Clamping head serrated	AM	TOP 40
Clamping head protrusion length serrated [mm]	AL	3
Clamping head smooth	AO	TOP 40 G
Centering height 1 [mm]	FE	7
Centering height 2 [mm]	FF	5
Interface	X	Ø 12 H7
Flange location	BD	Ø 70 H7/g7
Connecting thread inside	S	M38 x 1
Centering length [mm]	G	5
Installation depth [mm]	HM	5 +0,05
Weight [kg]		2,79
In stock		✔
Material no.		10001416

Through adaptation of the tandem cylinder to HYDROK 40 SE, the maximum clamping force of 75 kN can be achieved, even at 43 bar.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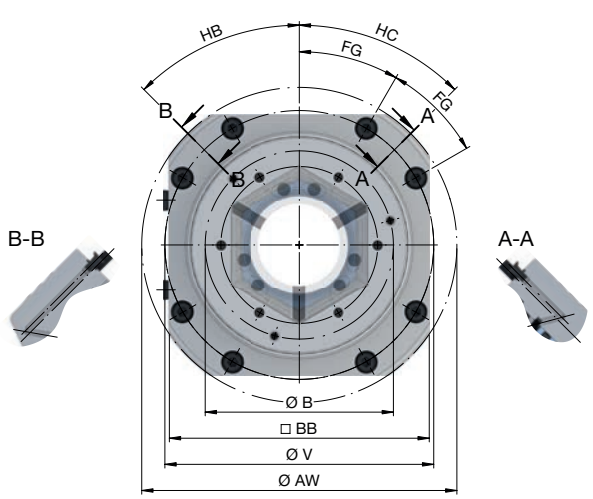
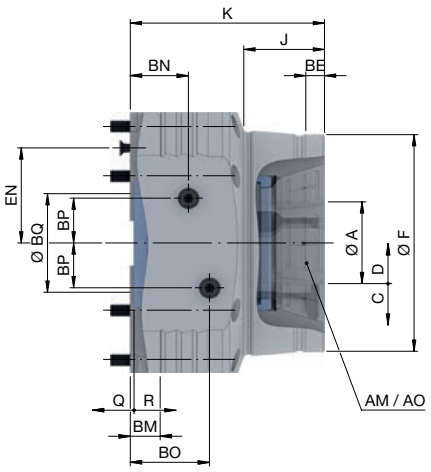
HYDROK SE size 52 - 100. Technical data





Product line		SE		
Size		**52**	**65**	**100**
Clamping range [mm]	A	3 – 52	3 – 65	15 – 100
Repeatability ≤ [mm]		0,010		
Max. axial drawtube force [pull / push] [kN]		35	45	65
Max. radial clamping force [kN]		91	120	172
Max. actuating pressure [bar]		40		
Release stroke in Ø [mm]	C	0,6		2
RPM n max. [1/min.]		1000		
Reserve stroke in Ø [mm]	D	1		1,5
Reserve stroke axial [mm]	Q	2	2,15	3
Release stroke axial [mm]	R	2,5		5
Location front end-stop	F	Ø 125 f7	Ø 145 f5	Ø 215 f7
Length flange location [mm]	BE	9,5	12,5	15,5
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]	LK Ø 180 [3 x M8]
Ø Capacity [mm]	BQ	53	66	108
Height [mm]	J	39,6	54	55
Overall height [mm]	K	120	130	140
Outer variant [mm]	BB	154	174	230
Release	BN	38,1 [1/8"]	38,9 [1/8"]	
Clamping	BO	57,2 [1/8"]	53 [1/8"]	63 [1/8"]
Connecting position [mm]	BP	25	30	
Fluid connection 1 [mm]	EN	55,5	63,6	84,9
Outer Ø [mm]	AW	175 f6	210 f6	270 f6
Bolt hole circle	V	LK Ø 157 [8 x M8]	LK Ø 180 [8 x M8]	LK Ø 240 [8 x M8]
Mounting seat fit length [mm]	BM	20		
Angle position [°]	FG	30		
Clamping via base plate [°]	HB	45		
Release via base plate [°]	HC	45		
Clamping head serrated	AM	TOP 52	TOP 65	TOP 100
Clamping head smooth	AO	TOP 52 G	TOP 65 G	TOP 100 G
Weight [kg]		12	14,5	26
In stock		✔	✔	✔
Material no.		10001415	10001407	10001412

Please note: At adaptation size 52 the adaptation for jaw clamping cannot be used.
Size 100 is also available in lightweight design [14 kg].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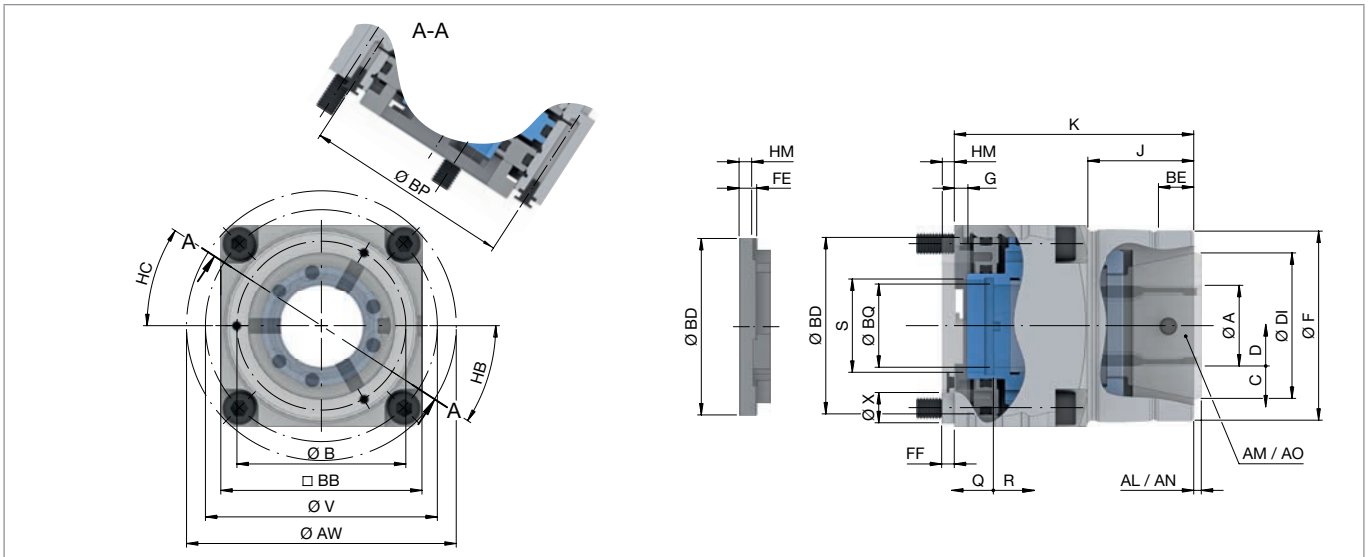
HYDROK RD size 32. Technical data



Product line		RD
Size		**32**
Clamping range [mm]	A	3 – 32
Repeatability ≤ [mm]		0,010
Max. axial drawtube force [pull / push] [kN]		25
Max. radial clamping force [kN]		70
Max. actuating pressure [bar]		100
Release stroke in Ø [mm]	C	0,6
RPM n max. [1/min.]		60
Reserve stroke in Ø [mm]	D	1
Reserve stroke axial [mm]	Q	2,5
Release stroke axial [mm]	R	3
Location front end-stop	F	Ø 75 f7
Length flange location [mm]	BE	15
Bolt hole circle end-stop	B	LK Ø 67 [3 x M4]
Ø Capacity [mm]	BQ	33
Height [mm]	J	42
Overall height [mm]	K	95
Outer variant [mm]	BB	79,8
Connecting position [mm]	BP	82
Outer Ø [mm]	AW	106 h7
Bolt hole circle	V	LK Ø 92 [4 x M8]
Clamping via base plate [°]	HB	33
Release via base plate [°]	HC	33
Head Ø [mm]	DI	58
Clamping head serrated	AM	SK 32 BZI
Clamping head protrusion length serrated [mm]	AL	6
Clamping head smooth	AO	SK 32 BZIG
Clamping head protrusion length smooth [mm]	AN	3
Centering height 1 [mm]	FE	7
Centering height 2 [mm]	FF	5
Interface	X	Ø 12 H7
Flange location	BD	Ø 70 H7/g7
Connecting thread inside	S	M38 x 1
Centering length [mm]	G	5
Installation depth [mm]	HM	5 +0,05
Weight [kg]		2,69
In stock		✔
Material no.		10001414

By adapting the tandem cylinder on the HYDROK 32 the maximum clamping force of 70 kN can be reached already at 50 bar.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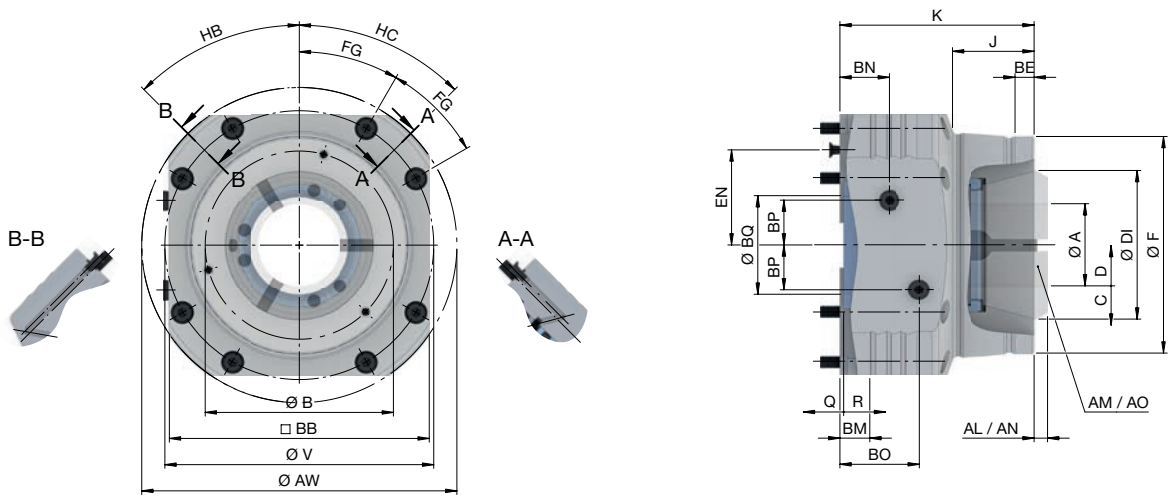
HYDROK RD size 42 - 100. Technical data



Product line		RD				
Size		**42**	**52**	**65**	**80**	**100**
Clamping range [mm]	A	3 – 42	3 – 52	3 – 65	5 – 80	15 – 100
Repeatability ≤ [mm]		0,010				
Max. axial drawtube force [pull / push] [kN]		35		45	50	65
Max. radial clamping force [kN]		80		105	115	150
Max. actuating pressure [bar]		40				
Release stroke in Ø [mm]	C	0,6				2
RPM n max. [1/min.]		1000				
Reserve stroke in Ø [mm]	D	1				1,5
Reserve stroke axial [mm]	Q	2				3
Release stroke axial [mm]	R	2,5				5
Location front end-stop	F	Ø 125 f7		Ø 145 f5	Ø 160 f7	Ø 215 f7
Length flange location [mm]	BE	7,4		12,5	17,5	15,5
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]		LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Ø Capacity [mm]	BQ	47	53	66	81	108
Height [mm]	J	39		54		
Overall height [mm]	K	120		130		140
Outer variant [mm]	BB	154		174	186	229
Release	BN	38,1 [1/8"]		33,15 [1/8"]	33 [1/8"]	38,9 [1/8"]
Clamping	BO	57,2 [1/8"]		53,15 [1/8"]	53,5 [1/8"]	63 [1/8"]
Connecting position [mm]	BP	25	30			
Fluid connection 1 [mm]	EN	55,5		63,6	68,6	84,85
Outer Ø [mm]	AW	175 f6		210 f6	215 f6	270 f6
Bolt hole circle	V	LK Ø 157 [8 x M8]		LK Ø 180 [8 x M8]	LK Ø 194 [8 x M8]	LK Ø 240 [8 x M8]
Mounting seat fit length [mm]	BM	20				
Angle position [°]	FG	30				
Clamping via base plate [°]	HB	45				
Release via base plate [°]	HC	45				
Head Ø [mm]	DI	80		99,5	115	144,5
Clamping head serrated	AM	SK 42 BZI	SK 52 BZI	SK 65 BZI	SK 80 BZI	SK 100 BZ
Clamping head protrusion length serrated [mm]	AL	9	4	9	4	
Clamping head smooth	AO	SK 42 BZIG	SK 52 BZIG	SK 65 BZIG	SK 80 BZIG	SK 100 BZG
Clamping head protrusion length smooth [mm]	AN	4				
Weight [kg]		12		15	17,5	29
In stock		✔	✔	✔	✔	✔
Material no.		10001408	10001409	10001406	10001410	10001411

Please note: At adaptation size 42 and 52 the jaw module cannot be used. Size 100 is also available in Lightweight design [14 kg].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InoFlex

Compensating 4-jaw clamping device

InoFlex centric clamping vise

The new InoFlex 4-jaw compensating chucks enable optimal clamping of round, rectangular, and geometrically irregular workpieces or workpieces that are susceptible to deformation in milling operations.

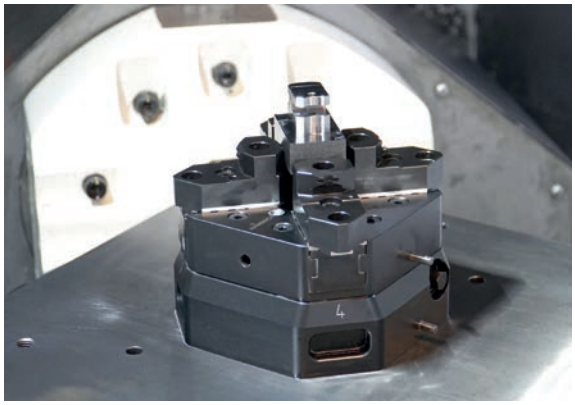
Thanks to the 4-jaw workholding technology, with which the jaw pairs enclose the center in a manner that provides compensation, the workpiece is always clamped centered – no matter how asymmetric it is. Compensation is achieved by connecting the sliding carriages located in the circle by means of levers.

This ensures substantially safer and more stable clamping than with conventional 3-jaw chucks or non-compensating concentric clamping vises. You can therefore switch between workpieces with different geometries, without the need for additional clamping devices.

They are suitable for clamping of blanks and finished parts; they compensate in the case of blanks and provide for excellent repeatability of finished parts.

Key advantages

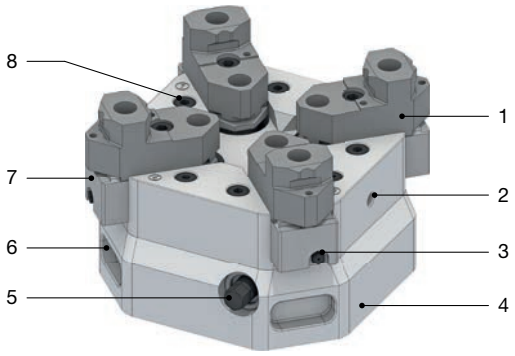
- 4-sided clamping [2x2] with compensation of the opposing jaws
- Ideal for clamping workpieces that are susceptible to deformation
- Large stroke and compensating stroke for each jaw
- For I.D. and O.D. clamping
- Flexible implementation [4-jaw and 2-jaw clamping]
- High repeatability
- Flat and compact size
- Easy handling



InoFlex in use

InoFlex centric clamping vise

InoFlex VF [centric clamping vise] in detail

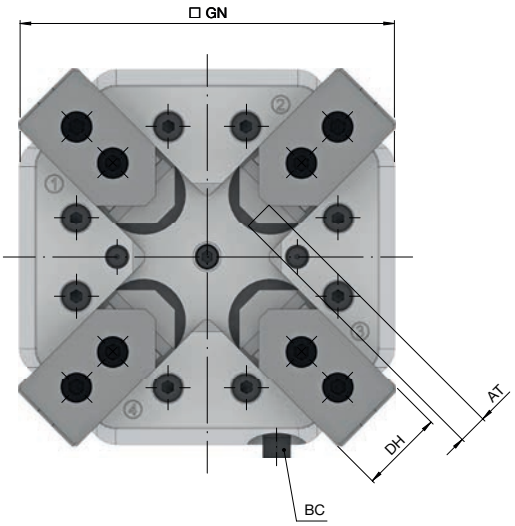
Designation	
1 Adjustable top jaw with wedge profile toothing 2 Thread for transport lug 3 Grease nipple, for each jaw guide for optimal lubrication 4 Stable base body 5 Manual actuation via socket wrench 6 Groove for fastening on machine table 7 Master jaw with wedge profile toothing for use with different top jaws 8 Mounting thread for positive stop jaws	

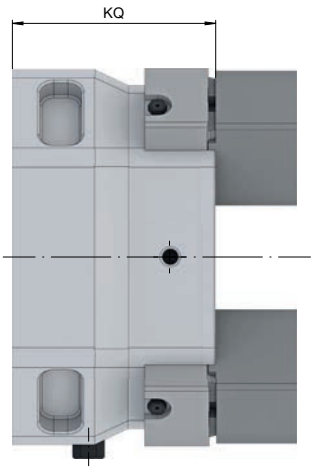
Applications

Technical suitability	Vise	3-jaw chuck	InoFlex
Clamping of asymmetrical workpieces	✘	✘	✔
Clamping of round workpieces	✘	✔	✔
Clamping of cubic workpieces	✔	✘	✔
Clamping workpieces that are susceptible to deformation	✘	✘	✔
I.D. clamping	✘	✔	✔
Centric compensating clamping	✘	✘	✔

✔ = suitable ✘ = unsuitable

InoFlex VF centric clamping vise. Technical data





Size		160	260
Variant		VF	
Repeatability ≤ [mm]		0,020	
Max. radial clamping force [kN]		40	70
Max. actuating torque [Nm]	BC	100	180
RPM n max. [1/min.]		400	
Stroke per jaw [mm]	AT	12,6	14
Compensating stroke for each jaw [mm]		11,6	13,0
Height without jaws [mm]	KQ	88,0	125,5
Jaw width [mm]	DH	36	48
Outer dimension [mm]	GN	162	235
Weight [kg]		13	44,5
In stock		✔	✔
Material no.		10015010	10015012

The run-out is based on soft, milled top jaws.

Jaws

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Accessory overview

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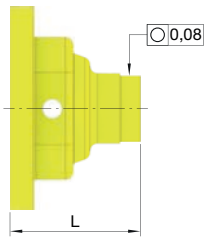
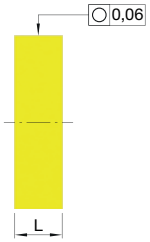
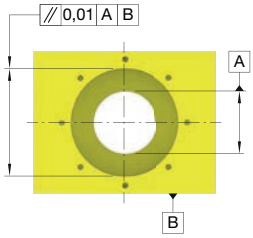
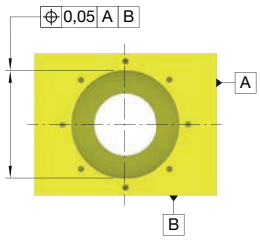
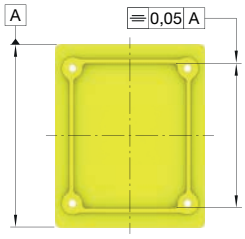
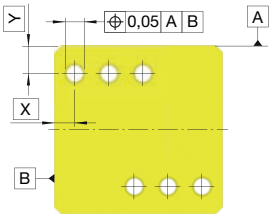
Scope of delivery

- Centric clamping vise
- Top jaws, soft
- Grease cartridge
- Actuation wrench

InoFlex centric clamping vise

Clamping possibilities

	Chuck O.D. clamping	Chuck I.D. clamping	Concentric clamping
			
Symbol			
Description	Clamping with four identical jaws. The workpiece is clamped from the outside.	Clamping with four identical jaws. The workpiece is clamped from the inside.	Clamping with two movable jaws. Two jaw seats are not equipped.
Application	Machining with centric zero point. Machining on the top side and between the jaws.	Machining with centric zero point. Easy access from five sides i.e. from the shell surface.	Classic concentric clamping.
Workpiece examples			
Advantages	■ Centric zero point ■ Powerful, four-sided clamping ■ Enclosed clamping	■ Centric zero point ■ Powerful, four-sided clamping ■ Minimal interference contour	■ Workpiece machining on both sides in one clamping set-up
Jaws	 VP10, VP12  VR10, VR12  VCB016, VCB026  VCB018, VCB028  VCG016, VCG026	 VP10, VP12  VR10, VR12  VCB016, VCB026  VCB018, VCB028  VCG016, VCG026	 VCB016, VCB026  VCB018, VCB028  VCG016, VCG026

Vise clamping	Centric vise clamping	Double vise clamping
		
		
Clamping with one fixed and one movable jaw. Two jaw seats are not equipped.	Clamping with one fixed and three movable jaws.	Clamping with two fixed jaws and two movable jaws.
Classic vise clamping.	Machining with one zero edge and one centric center axis.	Machining with end-stop on two zero edges.
		
■ Workpiece machining on both sides in one clamping set-up	■ Vise clamping and centering in a center axis ■ Powerful, four-sided clamping ■ Enclosed clamping	■ Clamping in the corner ■ Powerful, four-sided clamping ■ Enclosed clamping
 VCF016, VCF026  VCB016, VCB026  VCB018, VCB028  VCG016, VCG026	 VCF016, VCF026  VCB016, VCB026  VCB018, VCB028  VCG016, VCG026	 VCF016, VCF026  VCB016, VCB026  VCB018, VCB028  VCG016, VCG026