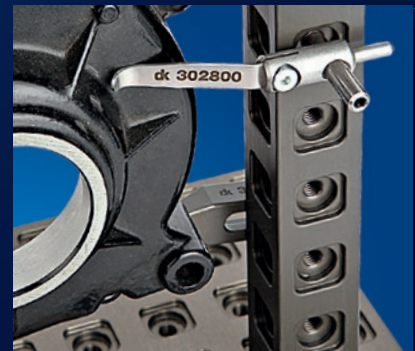
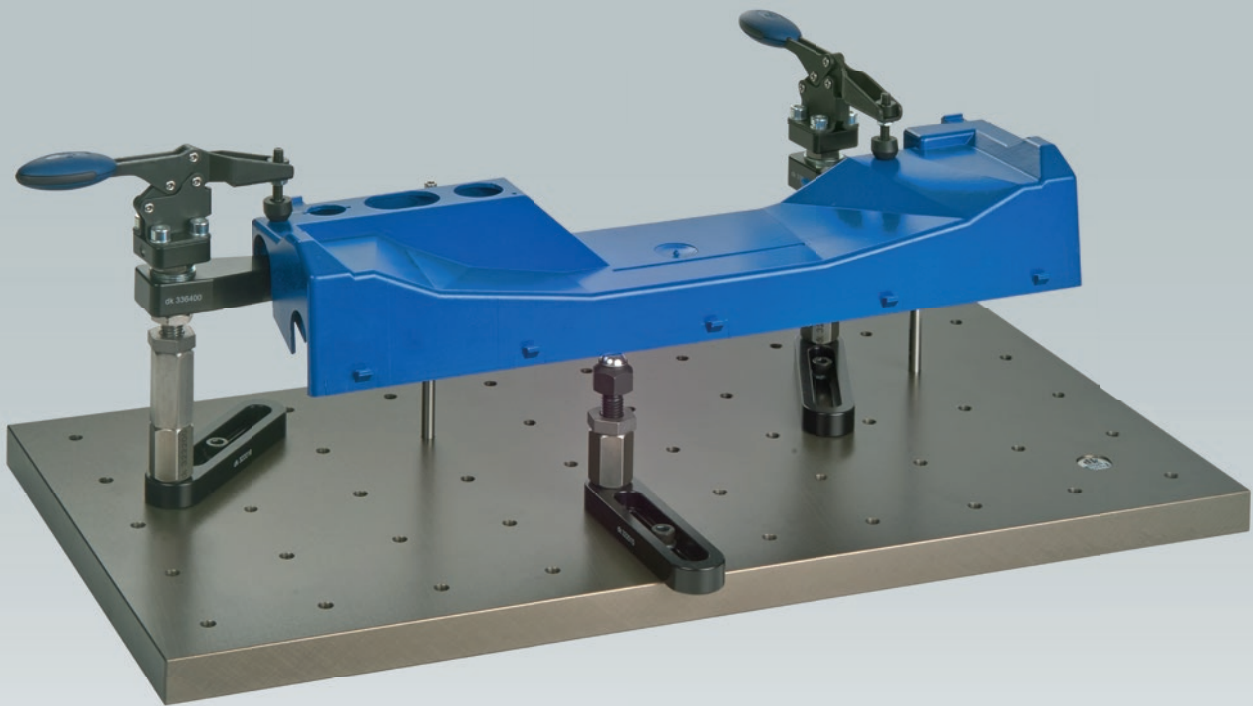


Fixturing systems

*Fixturing systems
for measurement technology
Innovations and new additions to range*





Spannfix Eco complete set

Description

The set contains different supports, extension elements and stop units. Workpieces are clamped using spring clamps or toggle-clamps. The base is formed by a base plate with mounting holes, which allows module elements to be fitted quickly and flexibly.

Complete set "1" contains a base plate with dimensions of 500 x 250 mm, while complete set "2" has a large base plate with dimensions of 600 x 300 mm. The complete set makes it possible to clamp an extremely wide variety of different sheet metal parts and plastic parts, including even milled and turned parts.

Set versions

Order number	Designation
285160	Spannfix Eco "1" complete set
285170	Spannfix Eco "2" complete set

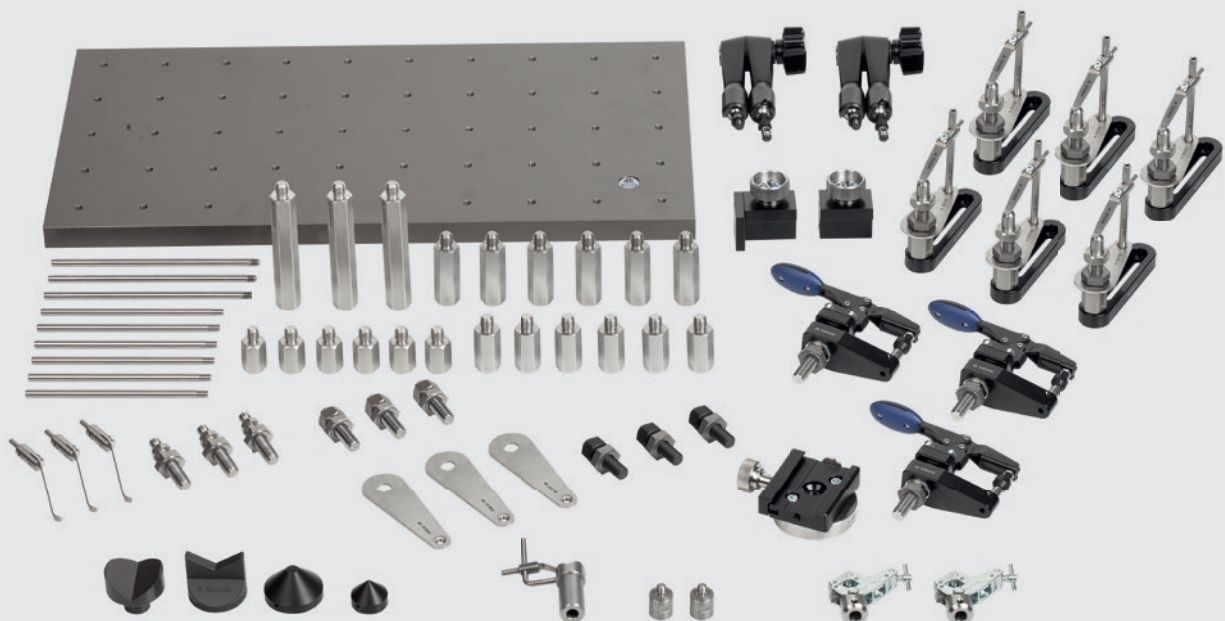
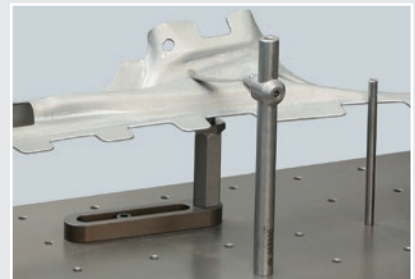
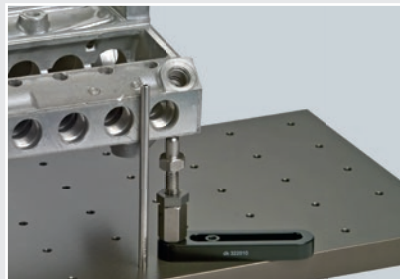
Set contents

Order number	Designation	Set "1"	Set "2"
395030	Base plate with tapped holes, 500 x 250 mm	1	
395040	Base plate with tapped holes, 600 x 300 mm		1
281436	Base plate anchoring claws (1 set)	1	1
285206	Quick-action clamp	1	1
322005	Screw frame sets with spring clamp	6	6
322600	Formed support with 90° point	3	3
323000	Self-aligning supports	3	3
368500	125 mm columns, for spring clamp or as stop unit	6	6

Spannfix Eco complete set (continued)

Set contents

Order number	Designation	Set "1"	Set "2"
368505	150 mm columns, for spring clamp or as stop unit	3	3
353800	Retaining plates for columns	3	3
302900	75 mm spring clamp	3	3
322200	25 mm extension elements	6	6
322300	35 mm extension elements	6	6
322400	50 mm extension elements	6	6
304400	100 mm extension elements	3	3
336400	Horizontal clamp with support dome	3	3
329500	Quick-change mounts	3	3
323500	8 mm V-support, 120°	1	1
323400	40 mm V-support, 120°	1	1
303700	25 mm centre point, 90°	1	1
303800	40 mm centre point, 90°	1	1
275000	Thread adapter, M6/M8	2	2
296700	Articulated clamping arms, model SU	2	2
334900	0 - 25 mm toggle-clamps	2	2
285810	V-support 120° with spring clamp	1	1



Clamp set "A" New variant

Description

The "A3" set with quick-action clamp, swivel unit and vice can be used for clamping milled and turned parts, for example. The swivel unit allows the vice and the workpiece to be tilted to the desired position. The clamping elements are mounted using the quick-action clamp, which is screwed directly either on the measuring table or on a base plate. The "A4" set additionally contains a three-jaw chuck, which can be used to ideally accommodate turned parts or workpieces with bores. The three-jaw chuck can equally be positioned in any angled position using the swivel unit.

Ordering information

When ordering, select the appropriate quick-action clamp or tell us at the time of order the size of the mounting hole or T-slot on your measuring table.



+



Set versions

Order number	Designation
340530	Clamp set "A3"
340540	Clamp set "A4"

Set contents

Order number	Designation	Set "A3"	Set "A4"
308200	80 mm precision vice	1	1
307800	Cylindrical pins for vice jaws with straight support surface (4 pcs)	1	1
326600	Cylindrical pins for vice jaws with inclined support surface (4 pcs)	1	1
283200	110 mm precision three-jaw chuck		1
314010	Quick-action clamp swivel unit	1	1
see right	Quick-action clamp	1	1
	Order number		
	285206		
	285208		
	285210		
	285212		
	285300		
	Connection		
	M6		
	M8		
	M10		
	M12		
	T-slot		

Horizontal clamp

Description

Horizontal clamp with M10 thread.
Available in two size classes.

Material

Steel.

Scope of delivery

With lock nut.



M10

Order number	Overhang	Clamp adjustment range	M10 bolt adjustment range	Height
288400	18-32	0-8	0-15	70
288500	30-50	0-14	0-15	85

Horizontal clamp with support

Description

Horizontal clamp with support and M10 thread.
Available in two size classes.

Material

Steel.

Scope of delivery

With lock nut.



M10

Order number	Overhang	Clamping range	Height
336300	32	0-20	100
336400	51	0-27	115

Universal clamping set

Description

Clamping set for optical measuring instruments for quick and flexible clamping of round and cuboid workpieces, such as plastic, punched and turned parts.

The clamping elements can be placed directly onto the measuring table or, if the quick-change adapter SWA39 is fitted, they can be positioned using the swivel unit.



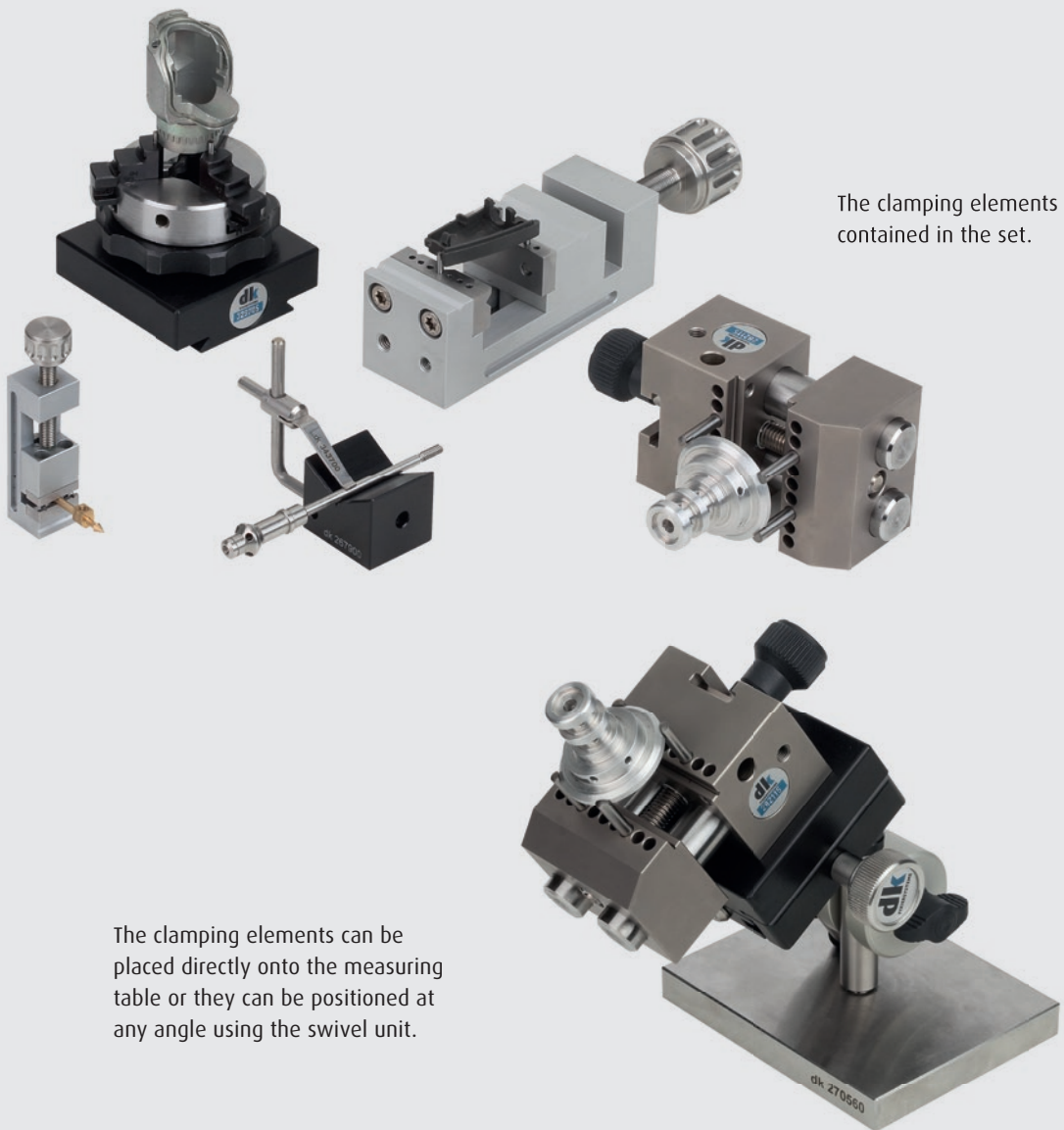
Set versions

Order number	Designation
269855	"Universal" clamping set incl. case
269850	"Universal with swivel unit" clamping set incl. case

Universal clamping set (continued)

Set contents

Order number	Designation	"Universal" set	"Universal with swivel unit" set
270920	15 mm precision vice	1	1
270860	35 mm precision vice	1	1
282115	50 mm precision vice	1	1
282300	Cylindrical pins with stepped profile, 4 pcs, for vice	1	1
267900	V-block with spring clamp	1	1
270560	Swivel unit with attachment plate and quick-action clamp		1
397020	Adapter plate SWA39 for 35 mm and 50 mm vices		1
314100	Adapter plate SWA39 for 15 mm vice or V-block		1
329705	50 mm precision three-jaw chuck with quick-change adapter SWA39		1



Clamping component set

New variant

Description

For optical measuring instruments and microscopes. For clamping plastic, punched or turned parts, for example. The base is a high-quality articulated clamping arm, on which clamping elements such as a mini chuck, spring clamp or toggle clamp can be mounted. The new clamping component sets contain a precision vice.

Ordering information

When ordering, please tell us the mounting thread or T-slot size of your measuring table.

**Set versions**

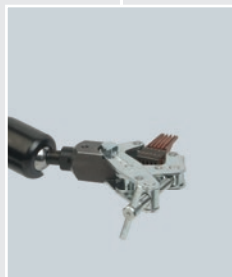
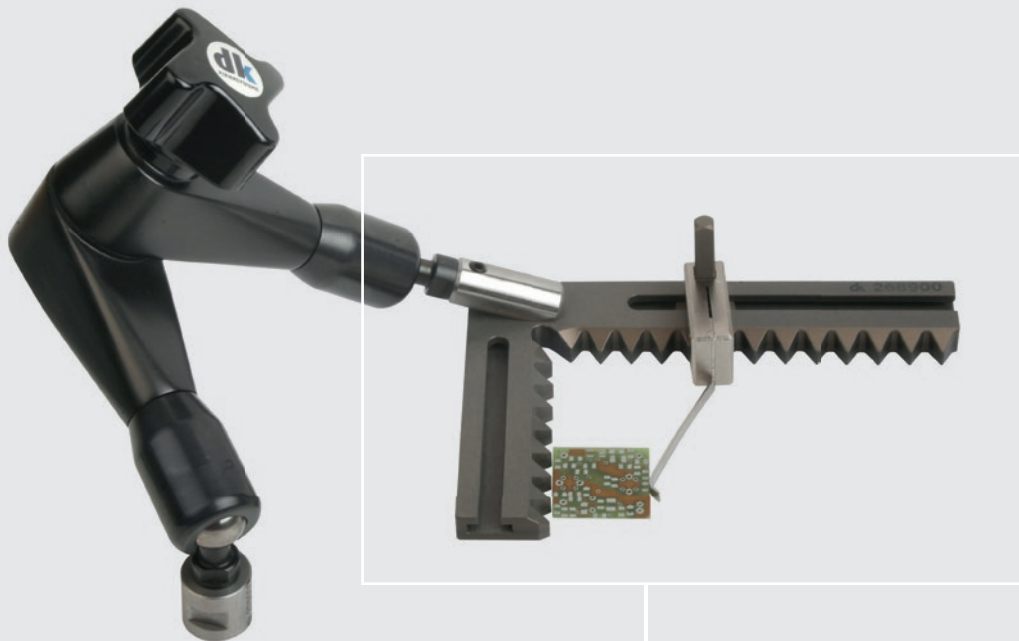
Order number	Designation
269805	"Standard model II" clamping component set with storage box
269815	"Small model II" clamping component set with storage box

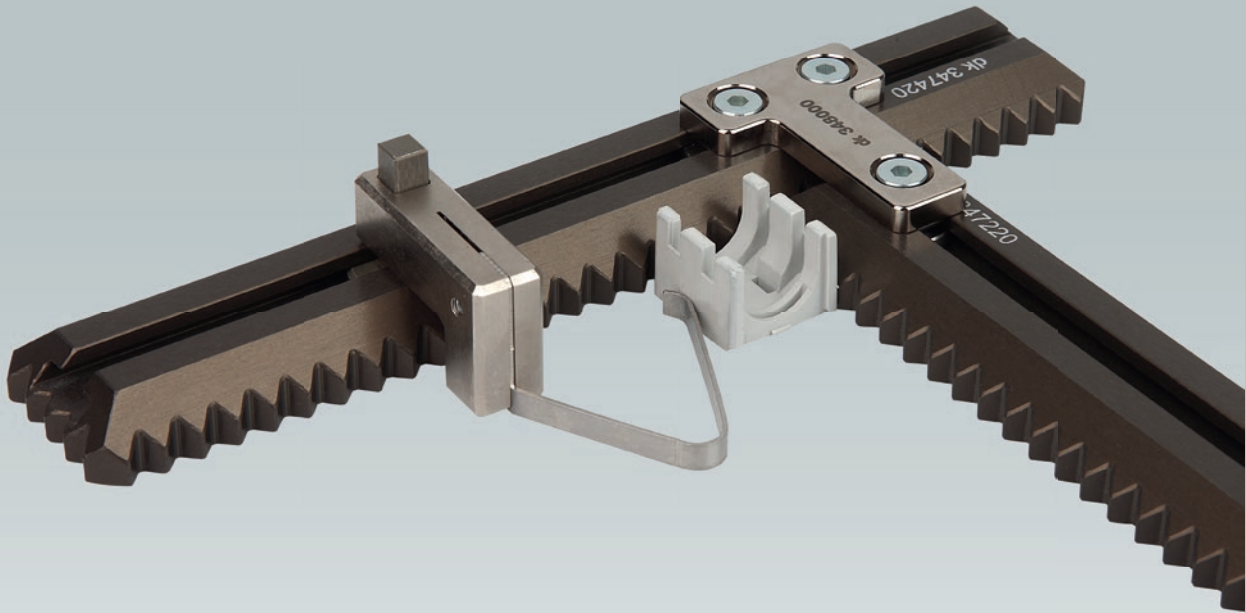
Clamping component set (continued)

New variant

Set contents

Order number	Designation	"Standard model II" set	"Small model II" set
296800	Articulated clamping arm, model SU	1	1
268900	Try square with spring clamp Contains: Try square 120 x 80 mm, 2 columns for spring clamp (268600), left-hand spring clamp for horizontal clamping (269200), 35 mm spring clamp for vertical clamping (269100)	1	1
268200	Right-hand spring clamp for horizontal clamping	1	
268100	50 mm spring clamp for vertical clamping	1	
283600	Precision mini chuck	1	
267900	V-block with spring clamp	1	1
266100	Small-parts clamp with stepped profile	1	
278800	Toggle clamp	1	1
269300	Spring clamp with SWA5	1	
269600	Rotary unit	1	
269700	Satellite mount, horizontal	1	
270900	15 mm precision vice	1	1
333000	Four-way hexagon socket spanner	1	1
Customer specification	Adapter or T-slot block (see ordering information)	1	1





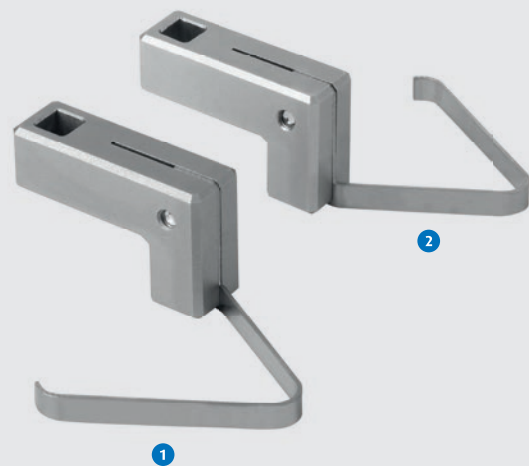
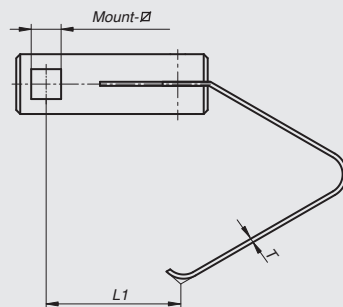
Spring clamp for horizontal clamping

Description

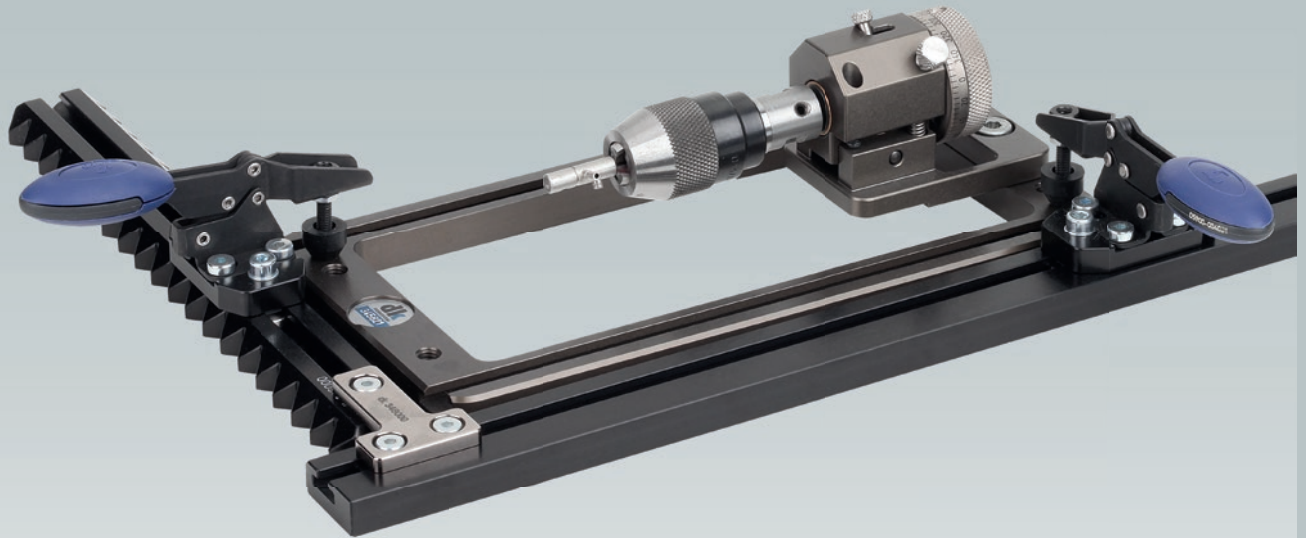
Spring clamp for clamping workpieces on toothed rails horizontally. Because of the curved design of the spring, small parts can be easily clamped into the corner of the angle. Clamping point length 23 mm to the slot centre.

Material

Brass/stainless steel.



Order number	Mount ∅	Clamping direction	T	L1
349150	5	Left ①	0.6	23
349250	5	Right ②	0.6	23



Horizontal clamp for toothed rails

Description

Horizontal clamp for mounting on toothed rails.

Material

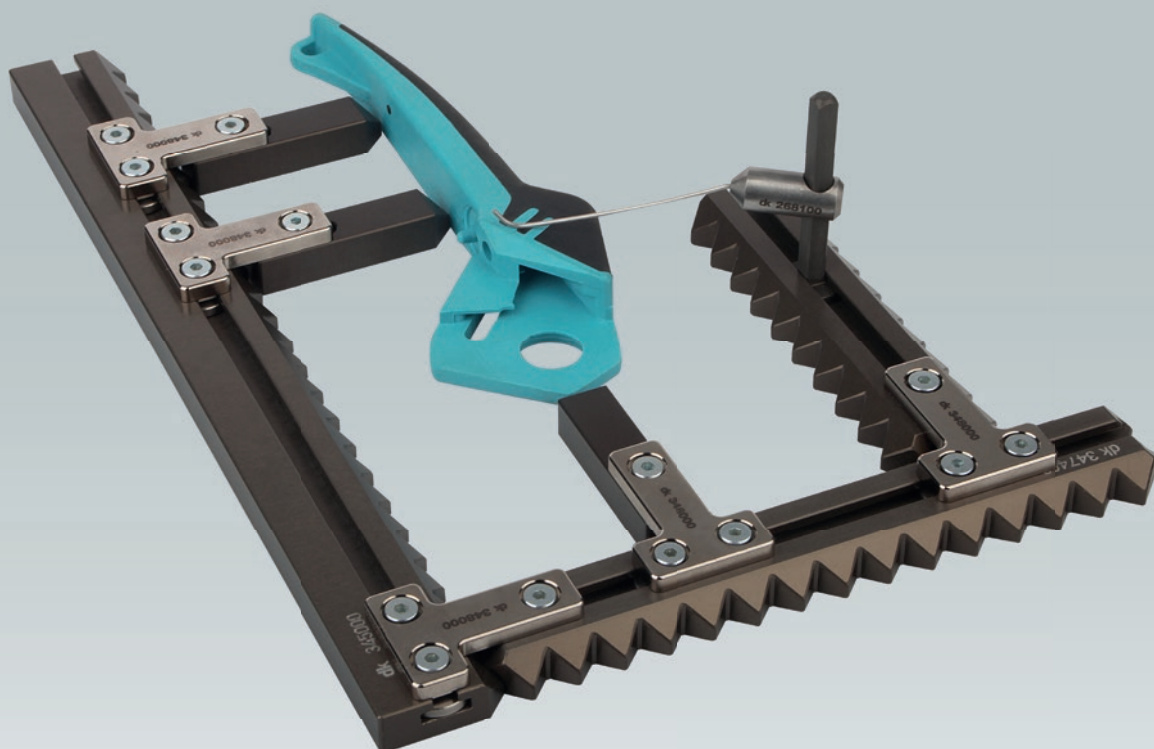
Steel/hard-coated aluminium.

↪ *Spacers can be used to increase the clamping range (main catalogue, page 165)*



T-slot 5

Order number	Overhang	Clamping range	Height
336900	18-32	0-16	35



Stop unit set

Description

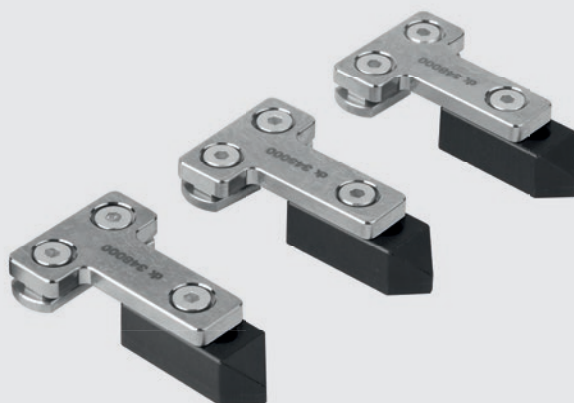
The stop unit teeth are fastened to the toothed rails and can be positioned anywhere along the T-slot. Complex parts can be positioned securely and reproducibly with three points of contact. The stop unit teeth are available in lengths of 30 and 50 mm.

Material

Hard-coated aluminium/steel.

Scope of delivery

3 x stop unit teeth and 3 x T-connector.



Order number	Designation	Tooth length
347500	30 mm stop unit set	30 mm
347510	50 mm stop unit set	50 mm



3-point support set

Description

3-point support for sheet metal parts, angled parts and formed parts. Flexible adjustment of the supports in x-, y- and z-direction. Simple and secure fixturing of the workpiece by spring clamp. The adjustable base rails can be flexibly fixtured along the T-slot on the toothed rails. The supports are height-adjustable. Extension elements can be used to compensate for further height differences.

Material

Hard-coated aluminium/steel.

Scope of delivery

3 x screw frame with spring clamp (322006), 3 x 25 mm extension element (322350), 3 x 50 mm extension element (322450), 2 x steel self-aligning support (323050), 3 x column for 30 mm spring clamp (269042)



Order number	Designation
269965	3-point support set

+ Accessories for 3-point support set

Screw frame with spring clamp

Description

Adjustable base rail with height-adjustable support. With spring clamp for fixturing the workpiece.

Order number	Scope of delivery
322006	1 x base rail (322050), 1 x 15 mm extension element (322250), 1 x formed support (322750), 1 x 30 mm retaining plate (353750), 1 x column for 50 mm spring clamp (269043), 1 x spring clamp (343700)



Screw frame

Description

Adjustable base rail with height-adjustable support.

Order number	Scope of delivery
322001	1 x base rail (322050), 1 x 15 mm extension element (322250), 1 x formed support (322750)



Supports

Description

Height-adjustable supports for supporting test parts. With M6 thread and an adjustment range of 15 mm.

Order number	Version	Total length
322750	Formed support with 3 mm dome radius	40
323050	Self-aligning support, steel, +/- 10°	35
323060	Self-aligning support, plastic, +/- 10°	35
323070	Magnetic support, dia. 6 mm, 5 N	42



Extension elements

Description

Extension pieces with M6 male and female thread. Width across flats 17 mm.

Order number	Male thread	Female thread	Length
322250	M6	M6	15
322350	M6	M6	25
322450	M6	M6	50



+ Accessories for 3-point support set (continued)

Base rail

Description

Adjustable base rail with slot and M6 mounting thread.

Scope of delivery

Incl. fastening screw and T-slot block

Order number	Adjustment range	Total length
322050	50	81



Retaining plates

Description

Mounting plates for spring clamp columns with M4 or M6 thread. For mounting on extension pieces or directly on base rail.

Order number	Thread for columns	Retaining bore	Overhang
353750	M4	6	30
353850	M6	6	50



Columns for spring clamps

Description

Columns for mounting spring clamps.

Order number	Column dia.	Length	Thread
269042	4	30	M4
269043	4	50	M4
269044	4	75	M4
368100	6	30	M6
368200	6	50	M6
368300	6	75	M6

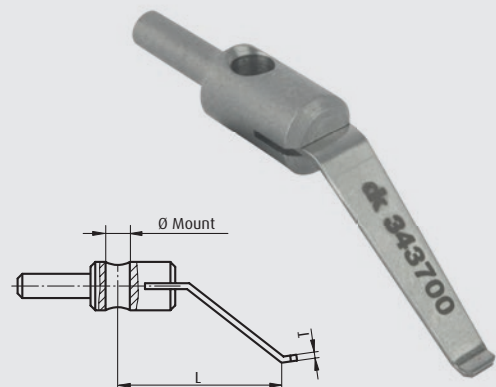


Spring clamp

Description

Simple and quick clamping of workpieces.
Spring clamp 343710 with narrow spring design.

Order number	T	L	Mount Ø
269037	0.4	30	4
343700	0.8	30	4
343710	0.8	30	4
302800	1.0	50	6



Symbol legend

M10

Connection with an M10 metric thread.

T-slot 5

Connection via T-slot. Width 5/10 mm, height 2.5/2.5 mm.
For use predominantly in the Schienenfix fixturing system.

↪ *The symbols are intended to make it easier for you to combine the individual base, structural and clamping elements to form complete fixturing systems. For individual products, it is the connection concerned that is illustrated, while in the case of adapters, both interfaces are shown.*

Imprint

Publisher

dk Fixiersysteme GmbH & Co. KG
Ferdinand-Lassalle-Straße 35
72770 Reutlingen, Germany
www.dk-gmbh.de
info@dk-gmbh.de

Catalogue number

Z200100-514-DE, issue 3

Edition

May 2014

Note

Dimensions and other data conform to the latest technical standards at the time of publication. We reserve the right to introduce technical modifications at any time. We can accept no responsibility for printing errors. Reprinting or duplication – even in part – is not permitted without our consent.

dk Fixiersysteme GmbH & Co. KG
Ferdinand-Lassalle-Straße 35
72770 Reutlingen, Germany

Tel. +49 (0) 7121 90 97 10
Fax +49 (0) 7121 90 97 120
www.dk-gmbh.de
info@dk-gmbh.de

dk
FIXIERSYSTEME