ALLMATIC Spannsysteme JAKOB

GENERAL CATALOGUE 2014

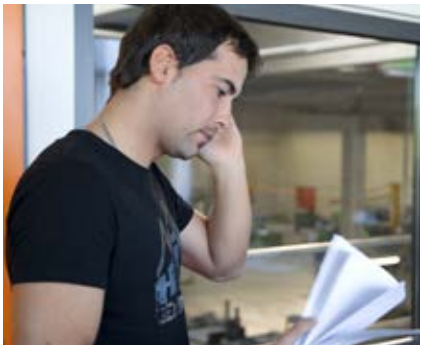
QUALITY CREATES TRUST

ALLMATIC GENERAL CATALOGUE 2014

Stand 18.08.2014

CUSTOMER SERVICE –
OUR SPECIALISTS AT YOUR DISPOSAL

Mr Guggenmoos, Sales



Mr Orban, Production Control

Ms Guggenmoos, In-house Sales

Telephone enquiries
+49(0)8377 929-0

Ordering by fax
+49(0)8377 929-380

Ordering by e-mail
order@allmatic.de

Our repair service
+49(0)8377 929-358

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

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

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

Minimum order value
Our minimum order value is €20.

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

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

Further information
We also offer 3D data, brochures and operator instructions, which you can download at **www.allmatic.de**.

THE ALLMATIC PICTOGRAPHS AND THEIR MEANING

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

THE ALLMATIC PICTOGRAPHS

Threaded spindle
Spindle without power intensification

Mechanical power intensification
Purely mechanical power intensifier

Gripper spindle
Spindle with mechanical power intensification for clamping and machining unmachined workpieces

Hydraulic power intensification
Single-acting cylinder

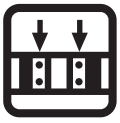
Fully enclosed spindle
Scraper provides protection against dirt – enhanced functional reliability, optimal chip protection and minimal cleaning. Nitrated spindle!

Spindle chamber cover
Sheet metal cover for dirt protection

Power preset
Spindle power can be preset in increments

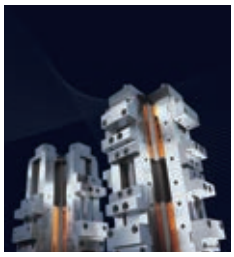
Horizontal installation
Suitable for vertical machining centres

Vertical installation
Suitable for horizontal machining centres



Lateral installation
Lateral surfaces additionally ground and polished

Click system
Quick-change system for false jaws and parallels



About us

Company management 2
Our philosophy 4
Process optimisation 8

ALLMATIC basic – mechanical

Product information, technical data, accessories 10

ALLMATIC HD – mechanical

Product information, technical data, accessories 20

ALLMATIC NC series – mechanical

LC version
Product information, technical data, accessories 28

TC version
Product information, technical data, accessories 44

NC 70 version
Product information, technical data, accessories 62

DUO 90 version
Product information, technical data, accessories 66

ALLMATIC GRIPP series – mechanical

T-REX version
Product information, technical data, accessories 72

TITAN 2 version
Product information, technical data, accessories 90

DUO Plus 125 version
Product information, technical data, accessories 122

CENTRO GRIPP version
Product information, technical data, accessories 138

ALLMATIC tombstones

3 x 120° Single Monobloc
Product information, technical data 160

4 x 90° Single Monobloc
Product information, technical data 162

4 x 90° DUO 90 Monobloc
Product information, technical data 164

3 x 120° DUO Plus 125 Monobloc
Product information, technical data 166

4 x 90° DUO Plus 125 Monobloc
Product information, technical data 168

Back-to-back set-up
Product information, technical data 170

Customised solutions
Application examples 172

Automatable workholding

LCH version
Product information, technical data, accessories 174

basic – HYDRAULIC
Product information, technical data, accessories 192

Zero-point clamping systems – important information 200
Standard terms and conditions 201

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

1973

Company directors: Ludwig Jakob and Bernhard Rösch (left to right)

We are specialists.

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

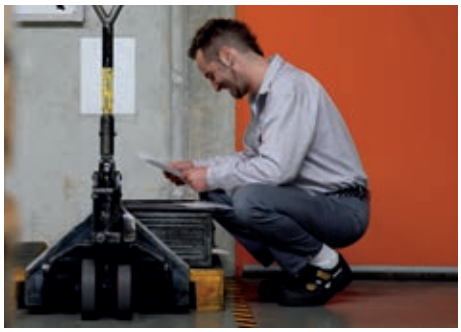
We pursue perfection.

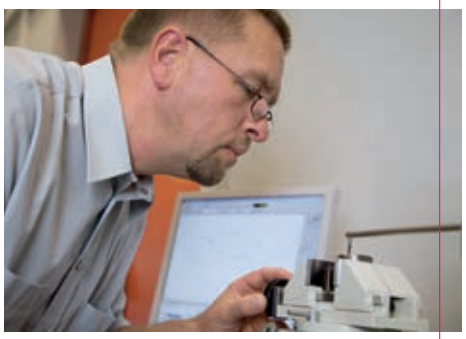
The core features of our brand are innovative strength and a passion for precision. The motivation to achieve top quality and reliability comes from the yardstick of perfection we set ourselves and from our enthusiasm for new technologies.
Reliable products, expert advice, first-class service and the candid and lasting relationships with our customers, business partners and staff are what characterise ALLMATIC.

We motivate.

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

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





Our philosophy:

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

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

“WE MANUFACTURE TO OUR CUSTOMERS’ SPECIFICATIONS.”

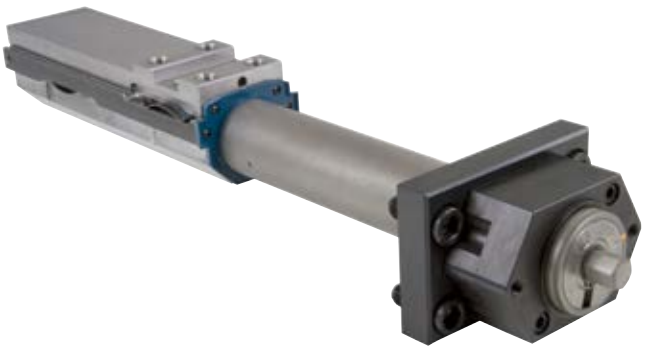
Product range.

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

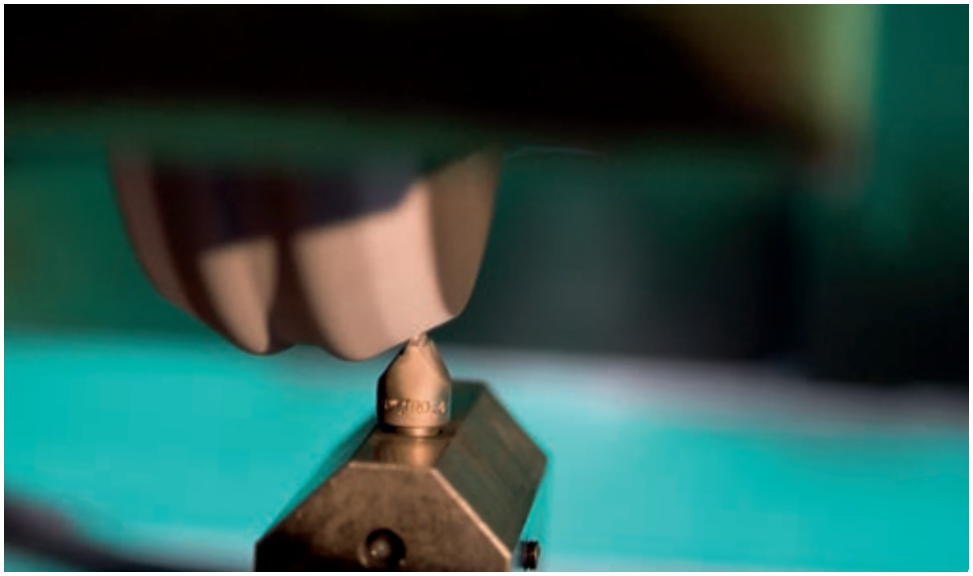
Quality.

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

Fully enclosed spindle



Mechanical power intensifier

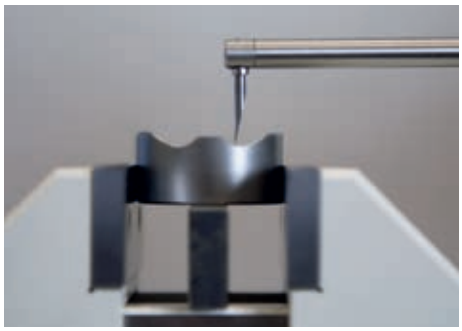


1. After hardening, pre-machined blanks are placed on the magnets for profile grinding and polishing.

2. Grinding wheel during profile dressing

3. Fully automatic process for profile grinding and polishing

4. Finished profile



5. Checking the process

6. Finished part with test certificate

Process optimisation

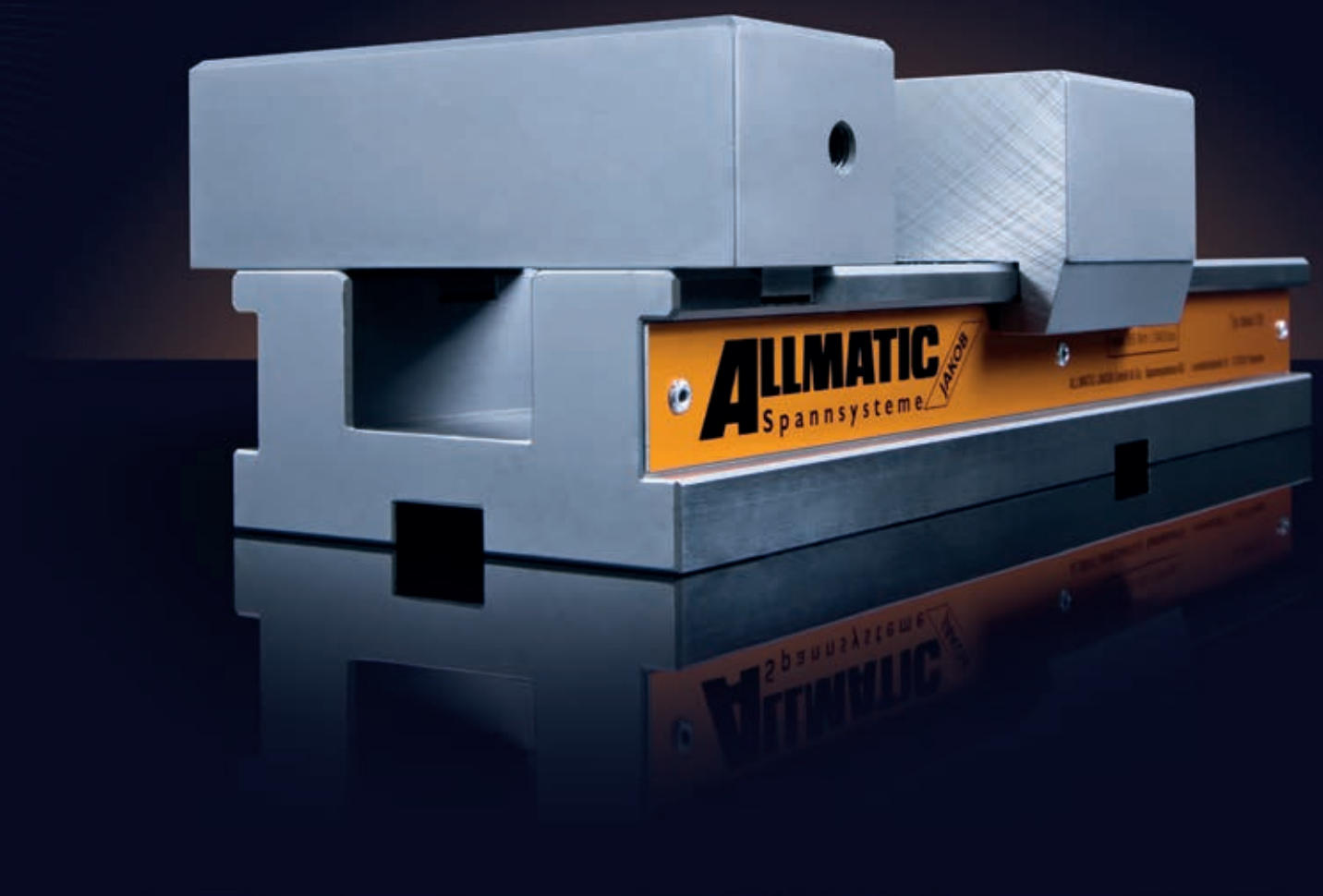
Finish-machining a power transmission housing: the priority in the manufacture of this housing is the durable high quality of the surface finish. Allmatic ensures that this is achieved by means of high process reliability. The profile is produced via profile grinding wheels, and the contour is checked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

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

TODAY

ALLMATIC basic – SIMPLE AND RELIABLE!

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



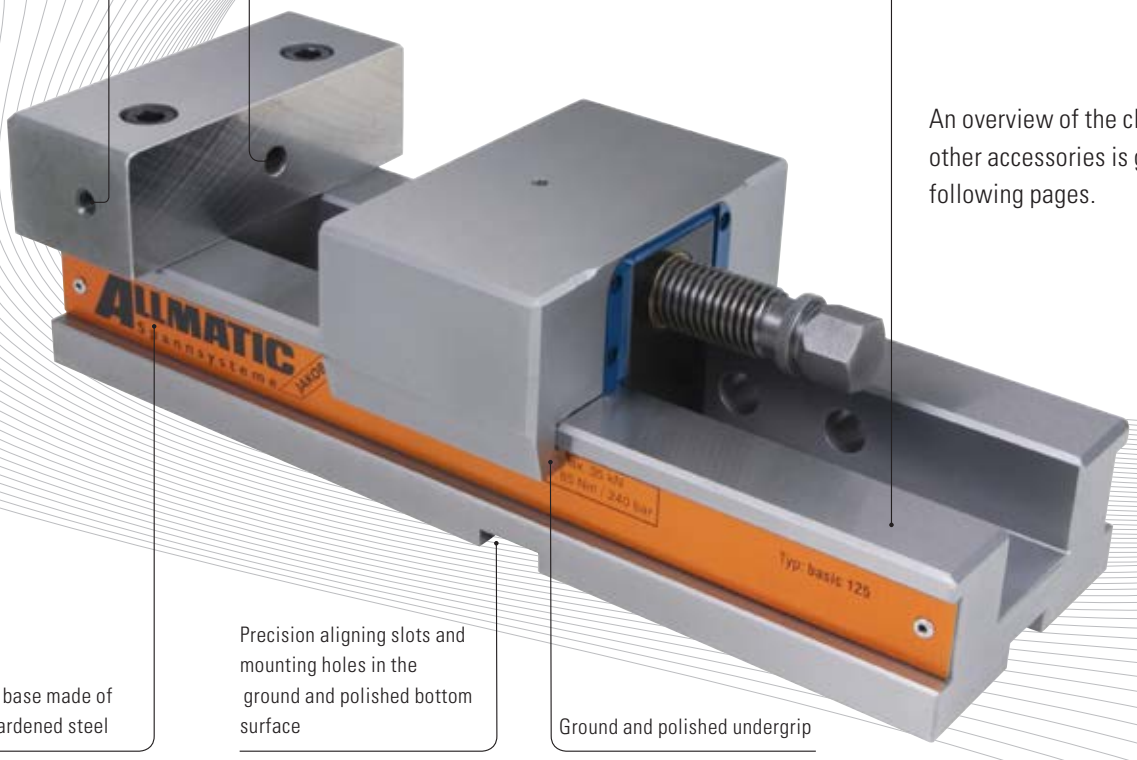
ALLMATIC basic – MECHANICAL

Scope of application:

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

Product features:

- Excellent ease of operation guarantees optimal handling for every application
- Fast adjustment for clamping range presetting
- Operation with the ring wrench supplied
- Reproducible clamping forces are achieved using a torque wrench
- Integrated scrapers ensure functional reliability and minimise cleaning
- Fixing on the machine table by means of mounting holes in the vice base. Additional holes can be made in the soft middle section of the vice base
- Optional centre jaw allows two or more workpieces to be clamped

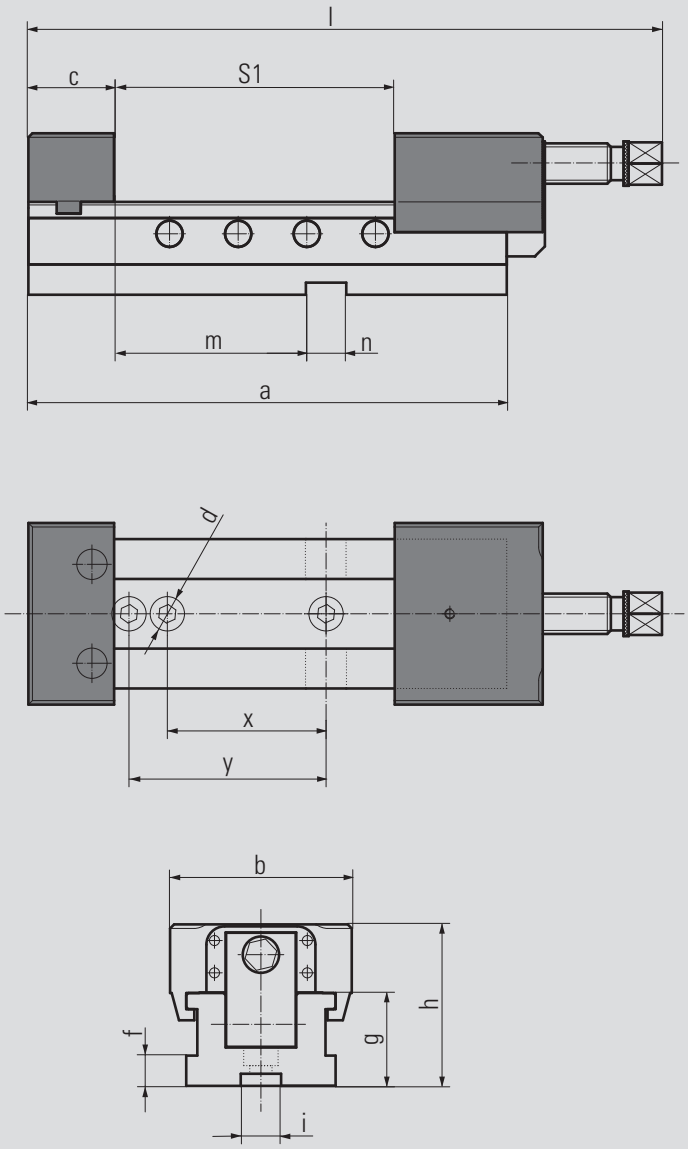


An overview of the clamping jaws and other accessories is given on the following pages.

Scope of supply:

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

Order no. jaw width 125: 6921188000055
160: 6921208000055



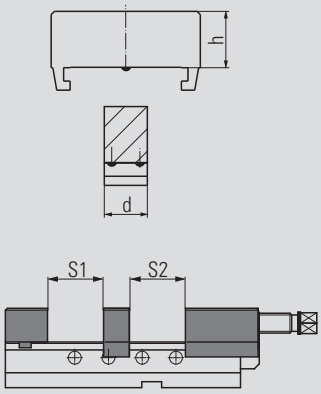
Technical data

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

Jaw width	125	160
Clamping range S1 in mm	0 – 208	0 – 283
Torque in Nm	85	120
Max. clamping force in kN	35	50
Weight in kg	13.5	26

ALLMATIC basic – mechanical (accessories)

Intermediate jaw

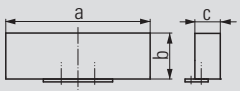


Order no. jaw width 125: 6921185024040
160: 6921205024040

Jaw width		125	160
Dimensions in mm	h	39.5	49.5
	d	33	41
Clamping range S1		0 – 87	0 – 121
Clamping range S2		0 – 87	0 – 121

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

Soft jaw

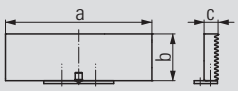


Order no. jaw width 125: 6921684023042

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

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

Jaw with cross grooving



Order no. jaw width 125: 6921684032040

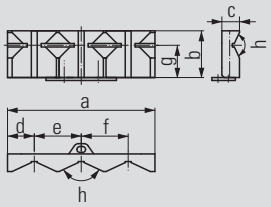
Jaw width		125
Dimensions in mm	a	125.6
	b	40.1
	c	12

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

ALLMATIC basic – mechanical (accessories)

Prismatic jaws (pair)

Order no. jaw width 125: 6921684024042

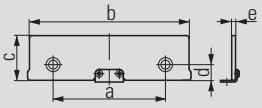


Jaw width		125
Dimensions in mm	a	125.6
	b	39.8
	c	15
	d	22.8
	e	40
	f	40
	g	27.5
	h	130°

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

Click parallels (pair)

Order no. jaw width 125: 6921185035042
160: 6921205044042

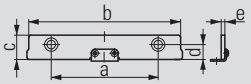


Jaw width		125	160
Dimensions in mm	a	88	88
	b	125	160
	c -0.01	35	44
	d	12.25	12.25
	e	3	3

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

Click parallels (pair)

Order no. jaw width 125: 6921185020042
160: 6921205025042



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

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

ALLMATIC basic – mechanical (accessories)

Smooth jaws (pair)

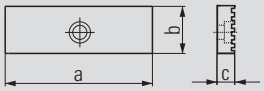
Order no. jaw width 125: 6921024022031
160: 6921034022031

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

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

Serrated jaws (pair)

Order no. jaw width 125: 6921021005031
160: 6921031005031

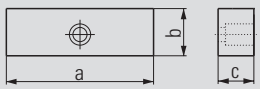


Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

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

Soft basic jaws (pair)

Order no. jaw width 125: 6921024023031
160: 6921034023031



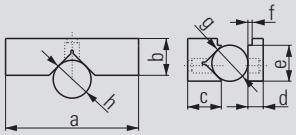
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	25	30

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

ALLMATIC basic – mechanical (accessories)

Prismatic jaws (set)

Order no. jaw width 125: 6921024024031
160: 6921034024031

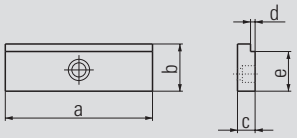


Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	35	45
	d	15	20
	e	35	45
	f	3	3
	g	Ø 12 – 28	Ø 15 – 40
	h	Ø 18 – 55	Ø 22 – 65

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

Step jaws (pair)

Order no. jaw width 125: 6921024025031
160: 6921034025031

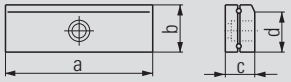


Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20
	d	3	3
	e	35	45

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

Roller pull-down jaws (pair)

Order no. jaw width 125: 6921024005131
160: 6921034005131



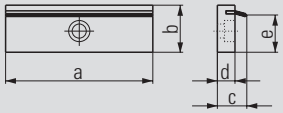
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	26	35.5
	d	35	45

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

ALLMATIC basic – mechanical (accessories)

Spring leaf pull-down jaws (pair)

Order no. jaw width 125: 6921024001042
160: 6921034001042



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

- Material: hardened steel
- For parts with rough clamping surfaces
- Spring leaves press the workpiece onto the support surface
- Spring leaves are interchangeable, see order no. 6921021005031 and 6921031005031 (see below)
- Please order fastening bolts separately (order no. 6921011023000)

Spring leaves (pair)

Order no. jaw width
125: 6921021005031
160: 6921031005031

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

Jaw fixing bolt

Order no. 6921011023000

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

Mechanical spindle kit

Order no. jaw width
125: 6922180000055
160: 6922200000055

- As spare spindle for basic mechanical

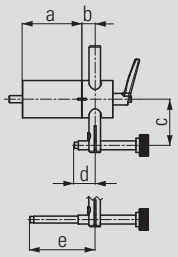
Hydraulic spindle kit

Order no. jaw width
125: 6922180000655
160: 6922200000655

- For retrofitting to hydraulic clamping system

Workpiece stop

Order no. 6921285650144

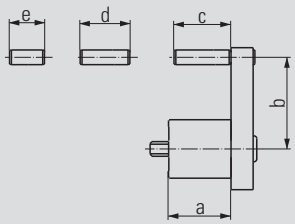


Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

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

ALLMATIC basic – mechanical (accessories)

Workpiece stop



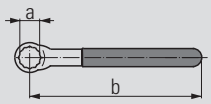
Order no. 6921685670042

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

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

Ring wrench

Order no. 0651110811210

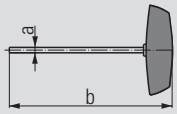


Dimensions in mm	a	SW 19
	b	192

- With grip sleeve made of soft plastic

T-wrench

Order no. 0651112010536



Dimensions in mm	a	SW 6
	b	182

- For adjusting the clamping range

Side clamps (pair)

Order no. 6921025000031

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

Suitable for the Series 125 mm up to 200 mm

Aligning and fixing set

Order no. – see table

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

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

Aligning and fixing set

Order no. – see table

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

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

ALLMATIC HD – EXTREMELY ROBUST AND RELIABLE

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

ALLMATIC

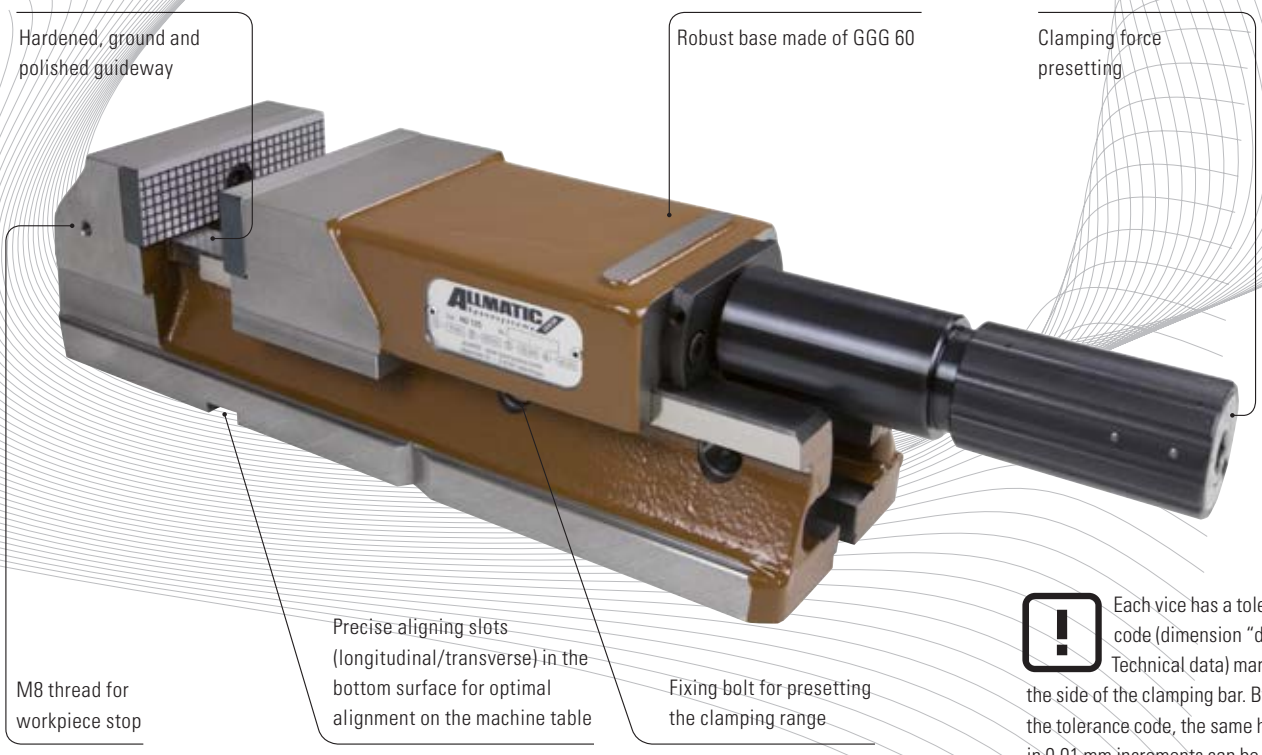
ALLMATIC HD – MECHANICAL

Scope of application:

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

Product features:

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



Each vice has a tolerance code (dimension "d" – Technical data) marked on the side of the clamping bar. By quoting the tolerance code, the same heights in 0.01 mm increments can be repeat-purchased at no extra charge.

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

Scope of supply:

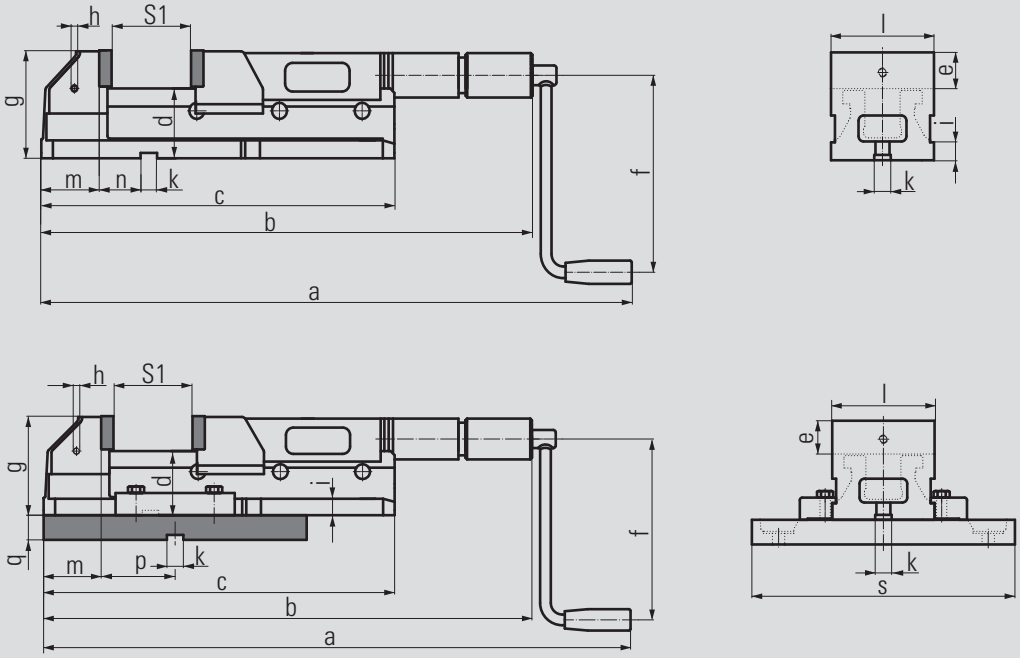
- 1 high-pressure vice
- 1 pair of serrated clamping jaws (1501)
- 4 side clamps
- 1 hand crank

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

<u>with swivel base</u>: order no. jaw width 100: 6921011000455
125: 6921021000455

Scope of supply:

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

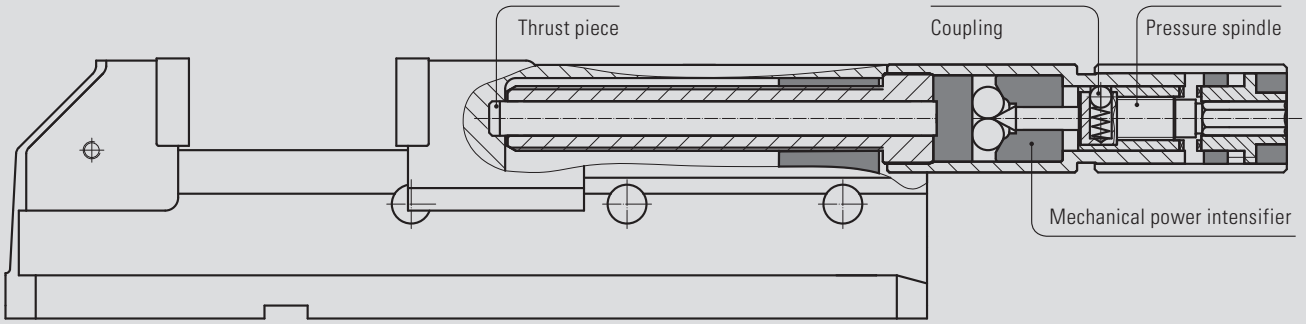


Technical data

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

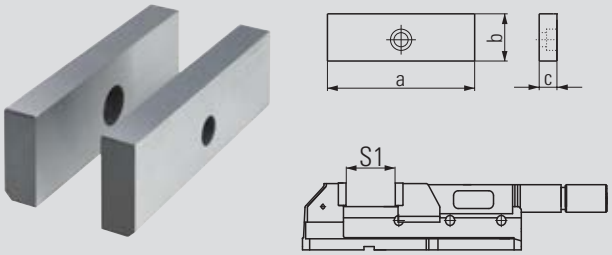
Jaw width	100	125	160
Clamping range S1 in mm	0 – 82	0 – 102	0 – 152
Clamping range S2 in mm (can be changed by means of fixing bolt)	78 – 162	98 – 202	147 – 302
Clamping force increments	2	4	4
Max. clamping force in kN	30	40	60
Weight in kg (1020)	13.5	26	52
Weight in kg (1001)	20	37	–

Spindle cross-section



ALLMATIC HD – mechanical (accessories)

Smooth jaws (pair)

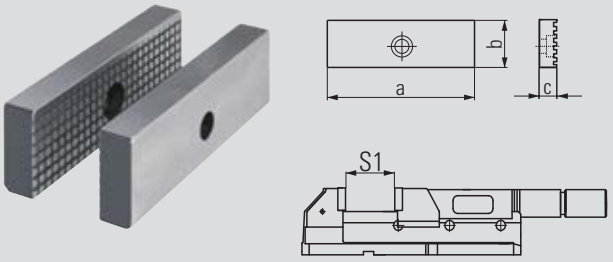


- Material: hardened steel
- For parts with delicate clamping surfaces
- Please order fastening bolts separately (order no. 6921011023000)

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

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	12	15	20
Clamping range S1		0 – 82	0 – 102	0 – 152
Can be changed by means of fixing bolt		78 – 162	98 – 202	147 – 302

Serrated jaws (pair)

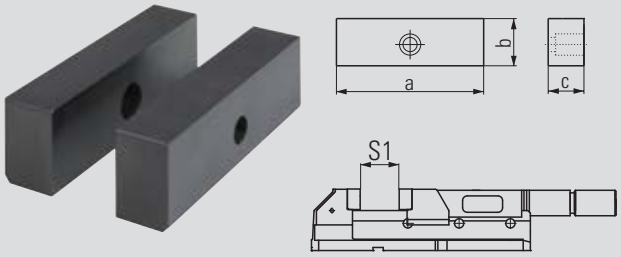


- Material: hardened steel
- Standard jaws with small surface area
- To increase the specific contact pressure per unit area
- Please order fastening bolts separately (order no. 6921011023000)

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

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	12	15	20
Clamping range S1		0 – 82	0 – 102	0 – 152
Can be changed by means of fixing bolt		78 – 162	98 – 202	147 – 302

Soft jaws (pair)



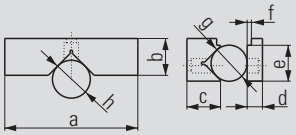
- Material: 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Please order fastening bolts separately (order no. 6921011023000)

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

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	20	25	30
Clamping range S1		0 – 66	0 – 84	0 – 132
Can be changed by means of fixing bolt		62 – 146	80 – 184	127 – 282

ALLMATIC HD – mechanical (accessories)

Prismatic jaws (set)

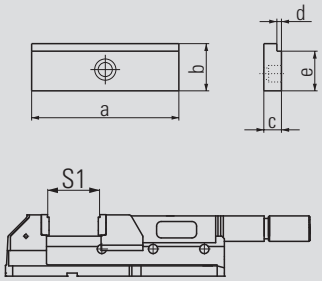


- Material: hardened steel
- For horizontal and vertical clamping of round and flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

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

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

Step jaws (pair)

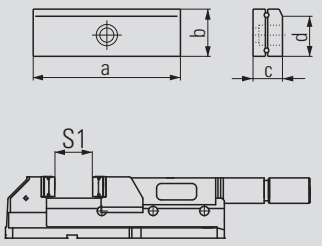


- Material: hardened steel
- For horizontal clamping of flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

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

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	12	15	20
	d	3	3	3
	e	28	35	45
Clamping range S1		7 – 88	7 – 108	7 – 158
Can be changed by means of fixing bolt		84 – 168	104 – 208	153 – 308

Roller pull-down jaws (pair)



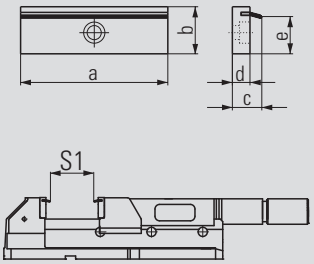
- Material: hardened steel
- For parts with delicate clamping surfaces
- Jaw parts in contact with the workpiece press the workpiece onto the support surface
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 125: 6921024005131
160: 6921034005131

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	26	35.5
	d	35	45
Clamping range S1		0 – 80	0 – 115
Can be changed by means of fixing bolt		76 – 180	110 – 265

ALLMATIC HD – mechanical (accessories)

Spring leaf pull-down jaws (pair)



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

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

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

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

Spring leaves (pair)

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

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

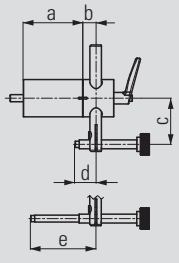
Jaw fixing bolt

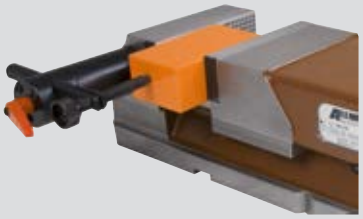
Order no. 6921011023000

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

Workpiece stop

Order no. 6921285650144



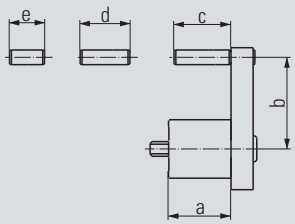


Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

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

ALLMATIC HD – mechanical (accessories)

Workpiece stop

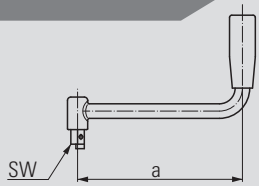


Order no. 6921685670042

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

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

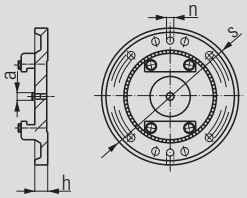
Hand crank



Order no. jaw width 100: 6923015000142
125 & 160: 6923025000142

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

Swivel base



Order no. jaw width 100: 6921013000044
125: 6921023000044

Jaw width		100	125
Dimensions in mm	a	Ø 20	Ø 20
	h	26	30
	n	20	20
	s	Ø 260	Ø 320

- Particularly suitable for single-piece production if you wish to make your vice rotatable
- Can be removed at any time
- Swivel base supporting edge larger than the vice's maximum clamping range
- Swivels 360° without indexing
- Alignment on the machine with T-keys in slots in the swivel base
- Clamping slots arranged in the form of a ring for machines with different slot spacings

Side clamps (pair)

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

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

Aligning and fixing set

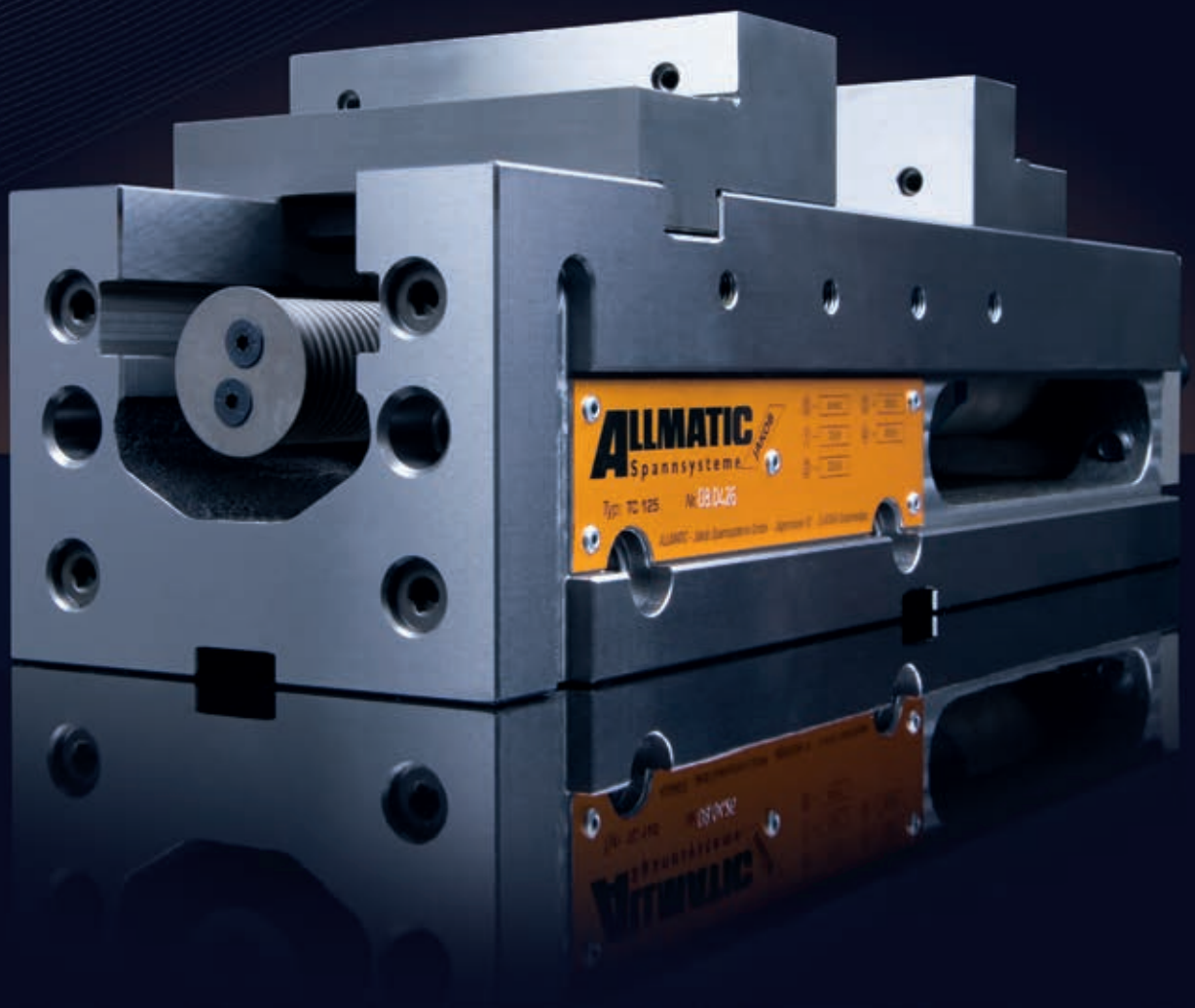
Order no. – see table

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

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

ALLMATIC NC SERIES – HIGH PRECISION AND POWER

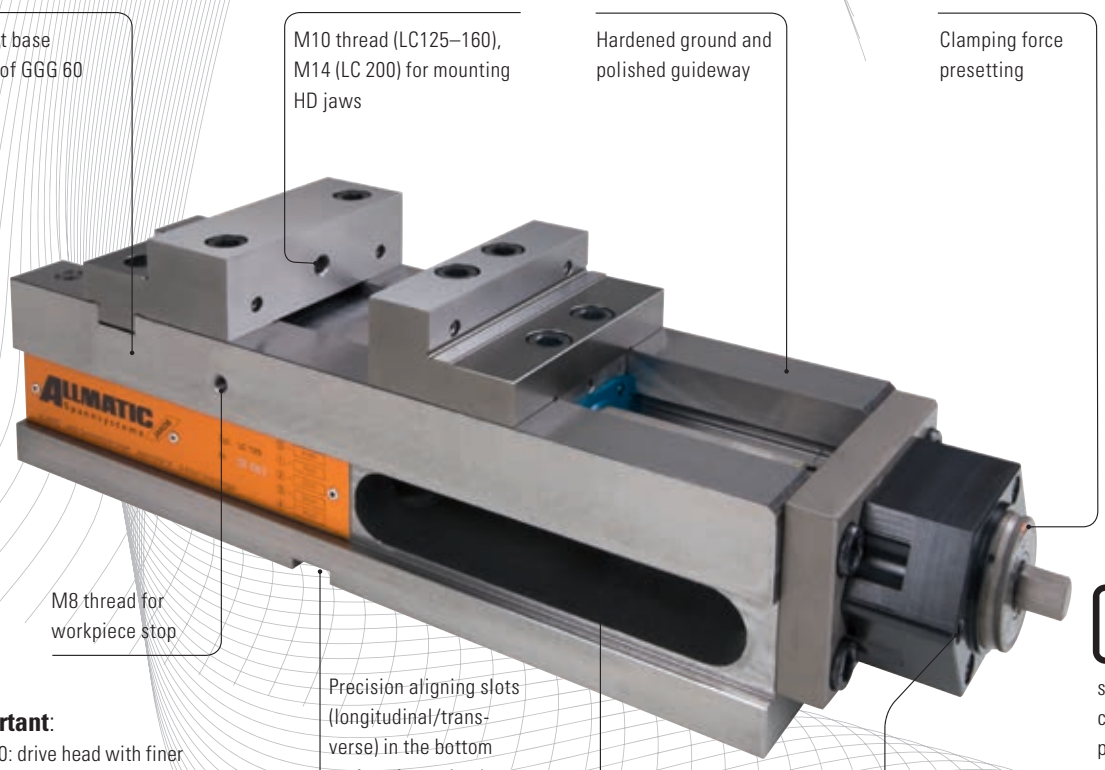
The ALLMATIC NC series of vices offers outstanding flexibility.


ALLMATIC
Spannsysteme

ALLMATIC NC – MECHANICAL
LC VERSION

Scope of application:
- Horizontal installation – suitable for vertical CNC-controlled milling machines

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



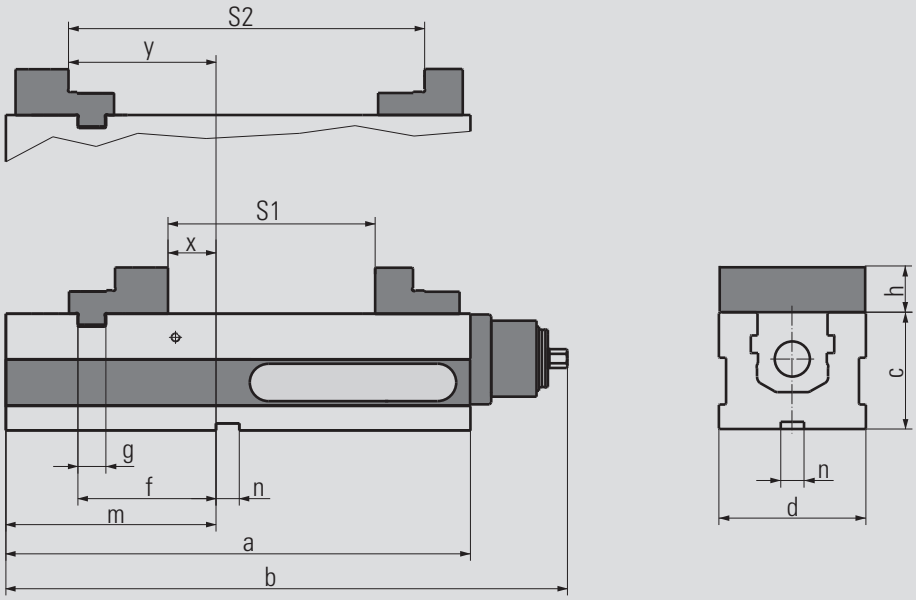
Important:
- LC 90: drive head with finer clamping force preselection for sensitive workpieces (11 increments)
- LC 200: jaw width 200 mm, width of vice base 164 mm

Order no. jaw width

90:	6921678000955
125:	6921688000955
160:	6921708000955
200:	6921698000955

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

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

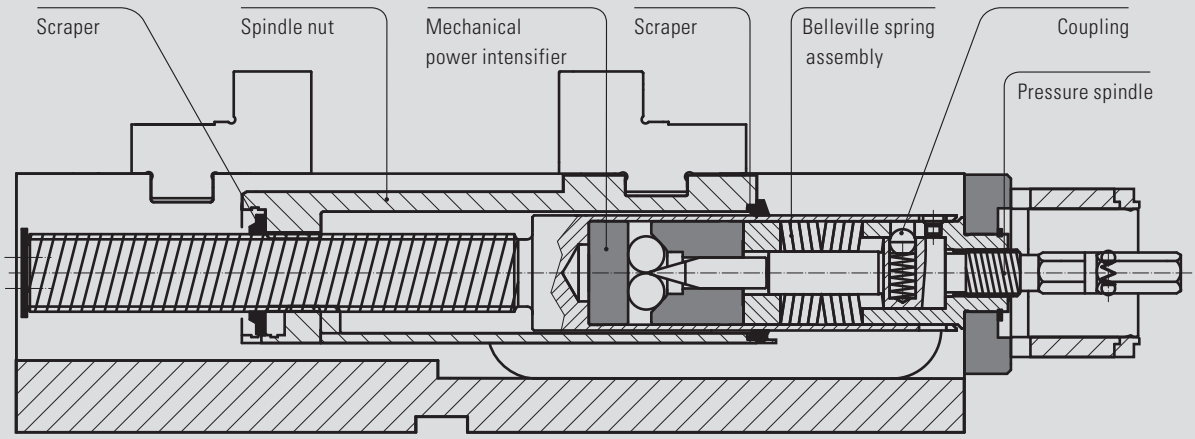


Technical data

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

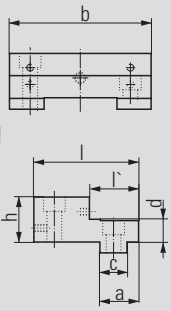
Jaw width	90	125	160	200
Clamping range S1 in mm	0 – 126	0 – 182	(0) 17 – 263	(0) 17 – 263
Clamping range S2 in mm	91 – 217	131 – 313	187 – 433	187 – 433
Clamping force increments	11	4	4	4
Max. clamping force in kN	28	40	60	60
Weight in kg	15	35	56	60

Spindle cross-section

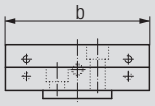


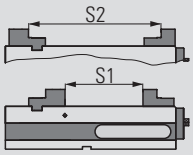
ALLMATIC NC – mechanical / LC version (accessories)

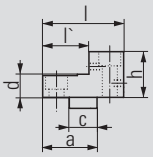
Step jaws



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





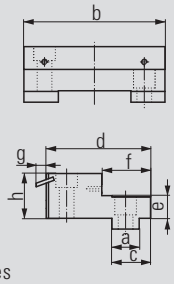


Jaw width	90	125	160	200
Clamping range S1	0 – 126	0 – 182	17 – 263	17 – 263
Clamping range S2	91 – 217	131 – 313	187 – 433	187 – 433

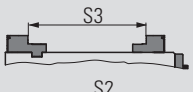
Jaw width					
fixed		90	125	160	200
Ord. no.:		6921674006731	6921684006731	6921704006731	6921694006031
In mm	a	30	34	40	40
	b	89,5	124,4	160,4	200,4
	c	20	24	30	30
	d	16	20	25	25
	h	34	39,5	49,8	60
	l	68	92	104	104
	l`	32	43	54	54

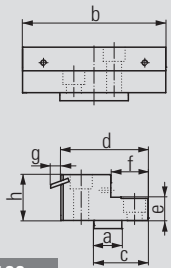
Jaw width					
movable		90	125	160	200
Ord. no.:		6921474002731	6921484002731	6921304002731	6921294002231
In mm	a	38	47	63	65
	b	89,5	124,4	160,4	200,4
	c	20	24	30	30
	d	16	20	25	25
	h	34	39,5	49,8	60
	l	56	70	96	100
	l`	31	40	64	65

Pull-down jaws



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





Jaw width	90	125	160
Clamping range S1	0 – 100	0 – 157	0 – 238
Clamping range S2	0 – 117	0 – 175	17 – 256
Clamping range S3	87 – 209	125 – 303	178 – 420

Jaw width				
fixed		90	125	160
Ord. no.:		6921674106031	6921684106031	6921704109031
In mm	a	20	24	30
	b	89,5	124,4	160,4
	c	30	34	40
	d	69	92	104
	e	16	20	25
	f	37	43	54
	g	8,8	8,8	8,8
	h	34	39,5	49,8

Jaw width				
movable		90	125	160
Ord. no.:		6921674102031	6921684102031	6921704102031
In mm	a	20	24	30
	b	89,5	124,4	160,4
	c	48	46,5	63
	d	62	75	101
	e	16	20	25
	f	24,5	32	51
	g	8,8	8,8	8,8
	h	34	39,5	49,8

ALLMATIC NC – mechanical / LC version (accessories)

Spring leaves (pair)

Order no. jaw width 90: 6921884103031

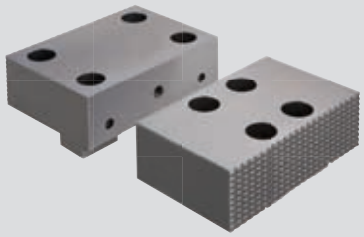
- Hardened spring leaves
- Spring leaves (spare) for pull-down jaws Type 90 (see left)

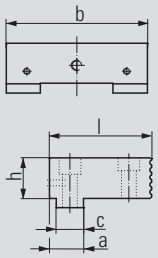
Spring leaves (pair)

Order no. jaw width 125: 6921684103031
160: 6921704103031

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

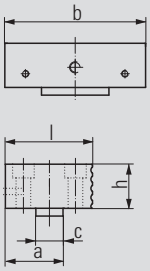
Hard basic jaws



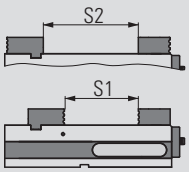


- Material: hardened steel
- One side smooth, ground and polished; one side serrated
- Additional thread for parallels and for mounting HD jaws on the smooth side
- Mounts for Click system on both sides of the jaw

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



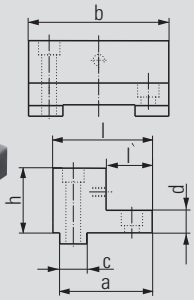
Jaw width				
movable		**90**	**125**	**160**
Ord. no.:		**6921674004731**	**6921684004731**	**6921704004731**
In mm	a	40	50	65
	b	89,5	124,4	160,4
	c	20	24	30
	h	34	39,5	49,8
	l	60	76	100



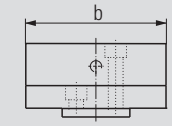
Clamping range S1	0 – 120	0 – 173	20 – 256
Clamping range S2	32 –150	50 – 225	70 – 310

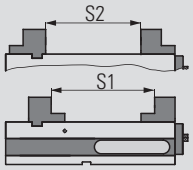
ALLMATIC NC – mechanical / LC version (accessories)

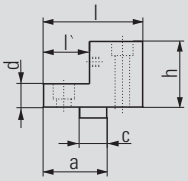
Master jaw adapters



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





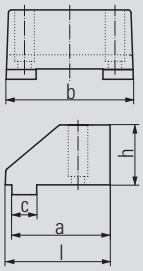


Jaw width	90	125	160	200
Clamping range S1	67 – 183	71 – 243	90 – 330	90 – 330
Clamping range S2	28 – 149	47 – 224	70 – 310	70 – 310

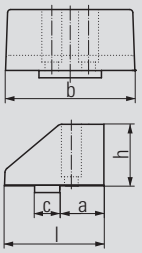
Jaw width					
fixed		90	125	160	200
Ord. no.:		6921674012231	6921684012231	6921704012231	6921694012231
In mm	a	56	77	89	89
	b	90	126	164	202
	c	20	24	30	30
	d	16	20	24	24
	h	46	58	73	85
	l	66	85	100	100
	l`	30	32	34	34

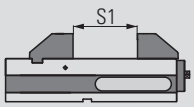
Jaw width					
movable		90	125	160	200
Ord. no.:		6921274011231	6921284011231	6921304011231	6921294011231
In mm	a	40	52	65	45
	b	90	126	164	202
	c	20	24	30	30
	d	16	20	24	24
	h	46	58	73	85
	l	60	80	100	100
	l`	30	32	34	38

Soft jaws



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





Order no. fixed: 6921684088031

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

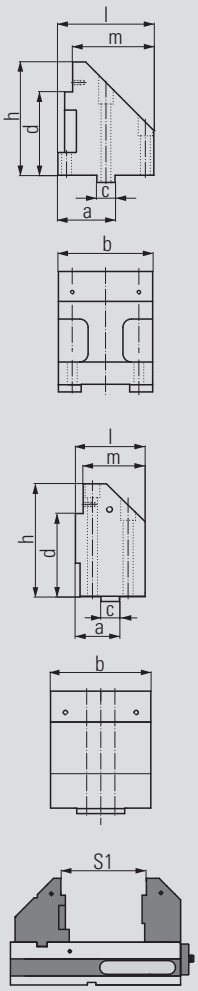
Order no. movable: 6921484087031

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

Clamping range S1	0 – 150

ALLMATIC NC – mechanical / LC version (accessories)

High jaws



- Material: hardened steel
- Particularly suitable for 5-sided machining
- Better accessibility for tools
- Ground and polished clamping surfaces
- Additional thread for parallels

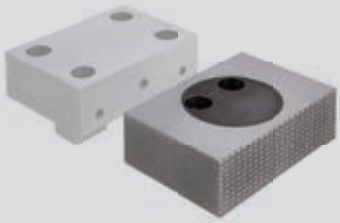
Order no. fixed: 6921684047031

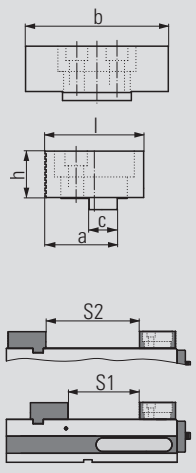
Jaw width		125
Dimensions in mm	a	75.5
	b	124.4
	c	24
	d	110
	h	149.5
	l	126.7
	m	107.2

Order no. movable: 6921684048031

Jaw width		125
Dimensions in mm	a	57
	b	124.4
	c	24
	d	110
	h	149.5
	l	90
	m	80
Clamping range S1		26 – 208

Pivot jaw, movable





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

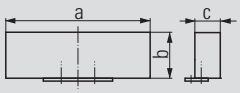
Order no. jaw width 90: 6921674020142
125: 6921684020042
160: 6921704020042

Jaw width		90	125	160
Dimensions in mm	a	49.5	62	86
	b	90	124.4	160.4
	c	20	24	30
	h	34	39.5	49.8
	l	68	84	118
Clamping range S1		0 – 110	0 – 161	0 – 235
Clamping range S2		22 – 140	38 – 213	50 – 290

ALLMATIC NC – mechanical / LC version (accessories)

Soft jaw

Order no. 6921684023042

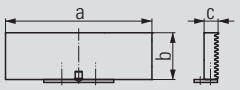


Jaw width		125
Dimensions in mm	a	125
	b	39.8
	c	22

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

Jaw with cross grooving

Order no. 6921684032040

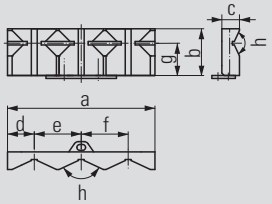


Jaw width		125
Dimensions in mm	a	125.6
	b	40.1
	c	12

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

Prismatic jaws (pair)

Order no. 6921684024042

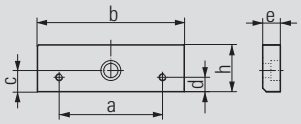


c		125
Dimensions in mm	a	125.6
	b	39.8
	c	15
	d	22.8
	e	40
	f	40
	g	27.5
	h	130°

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

ALLMATIC NC – mechanical / LC version (accessories)

Compensation jaw

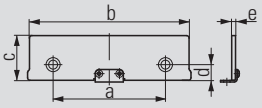


Order no. jaw width 160: 6921704022031
200: 6921694022031

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

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

Click parallels (pair)

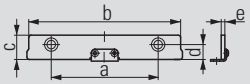


Order no. jaw width 90: 6921175029042
125: 6921185035042
160: 6921205044042

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

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

Click parallels (pair)



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

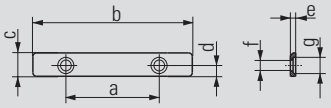
Jaw width		90	125	160
Dimensions in mm	a	48	88	88
	b	90	125	160
	c -0.01	16	20	25
	d	8.75	12.25	12.25
	e	3	3	3

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

ALLMATIC NC – mechanical / LC version (accessories)

Parallels (pair)

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

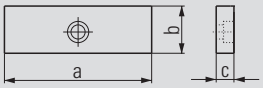


Jaw width		90	125	160
Dimensions in mm	a	52	88	88
	b	89	124	160
	c	13	15	19
	d	6	6	6
	e	3	3	3
	f	Ø 6	Ø 6	Ø 6
	g	Ø 9	Ø 9	Ø 9

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

Smooth jaws (pair)

Order no. jaw width 125: 6921024022031
160: 6921034022031

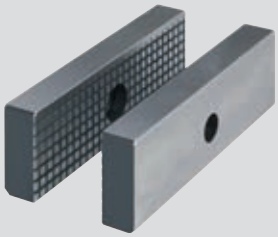


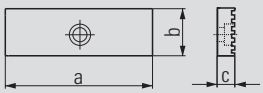
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

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

Serrated jaws (pair)

Order no. jaw width 125: 6921021005031
160: 6921031005031





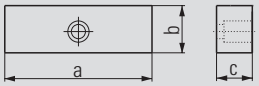
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

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

ALLMATIC NC – mechanical / LC version (accessories)

Soft jaws (pair)

Order no. jaw width 125: 6921024023031
160: 6921034023031

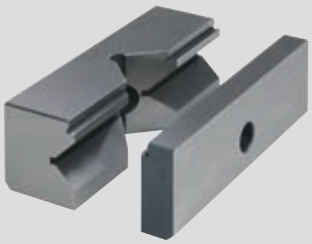


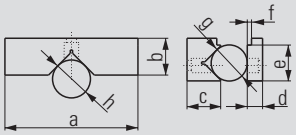
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	25	30

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

Prismatic jaws (set)

Order no. jaw width 125: 6921024024031
160: 6921034024031



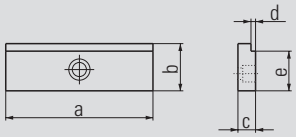


Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	35	45
	d	15	20
	e	35	45
	f	3	3
	g	Ø 12 – 28	Ø 15 – 40
	h	Ø 18 – 55	Ø 22 – 65

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

Step jaws (pair)

Order no. jaw width 125: 6921024025031
160: 6921034025031



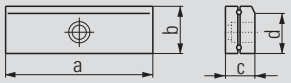
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20
	d	3	3
	e	35	45

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

ALLMATIC NC – mechanical / LC version (accessories)

Roller pull-down jaws (pair)

Order no. jaw width 125: 6921024005131
160: 6921034005131

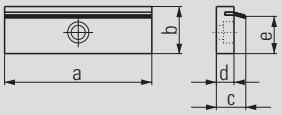


Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	26	35.5
	d	35	45

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

Spring leaf pull-down jaws (pair)

Order no. jaw width 125: 6921024001042
160: 6921034001042



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

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

Spring leaves (pair)

Order no. jaw width
125: 6921024001131
160: 6921034001131

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

Jaw fixing bolt

Order no. 6921011023000

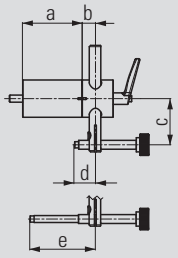
Bolt with shoulder – M10 x 23

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

ALLMATIC NC – mechanical / LC version (accessories)

Workpiece stop

Order no. 6921285650144

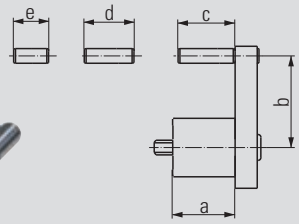


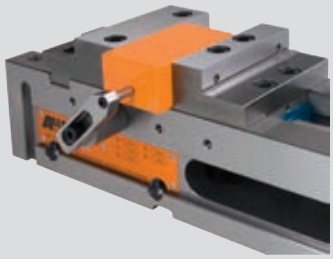
Dimensions in mm		
	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

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

Workpiece stop

Order no. 6921685670042



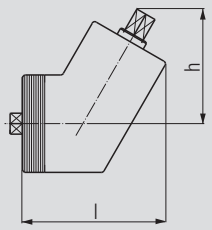


Dimensions in mm		
	a	34
	b	27 – 59
	c	31
	d	27
	e	19

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

Angular drive

Order no. jaw width 125 to 200: 6921285700143



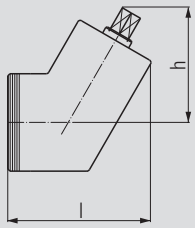
Jaw width		125	160	200
Dimensions in mm	l	97	97	97
	h	75	75	75

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

ALLMATIC NC – mechanical / LC version (accessories)

Angular drive

Order no. jaw width 90: 6921675700043

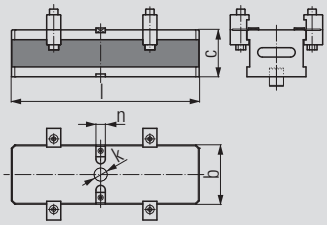


Jaw width		90
Dimensions in mm	l	87
	h	75

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

XL console

Order no. 6921885010042

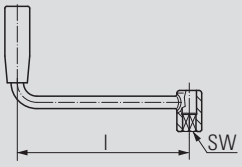


Jaw width		125
Dimensions in mm	b	126
	c	100
	k	Ø 30
	l	400
	n	20

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

Hand crank

Order no. jaw width 90: 6921675508042
125 - 200: 6921685508042

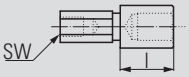


Jaw width		90	125
Dimensions in mm	l	150	180
	SW	12	14

- Suitable for jaw width 125 – 200 mm

Hexagonal extension

Order no. 6921685512040



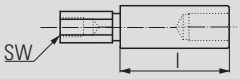
Jaw width		125
Dimensions in mm	l	30
	SW	14

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

- Suitable for jaw width 125 – 200 mm

ALLMATIC NC – mechanical / LC version (accessories)

Hexagonal extension



Order no. 6921685512140

Jaw width		125
Dimensions in mm	l	60
	SW	14

- Improves access for the hand crank
- Is secured to the hand crank with a bolt
- Suitable for jaw width 125 – 200 mm

Side clamps (pair)

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

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

DUO side clamps

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

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

Aligning and fixing set

Order no. – see table

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

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

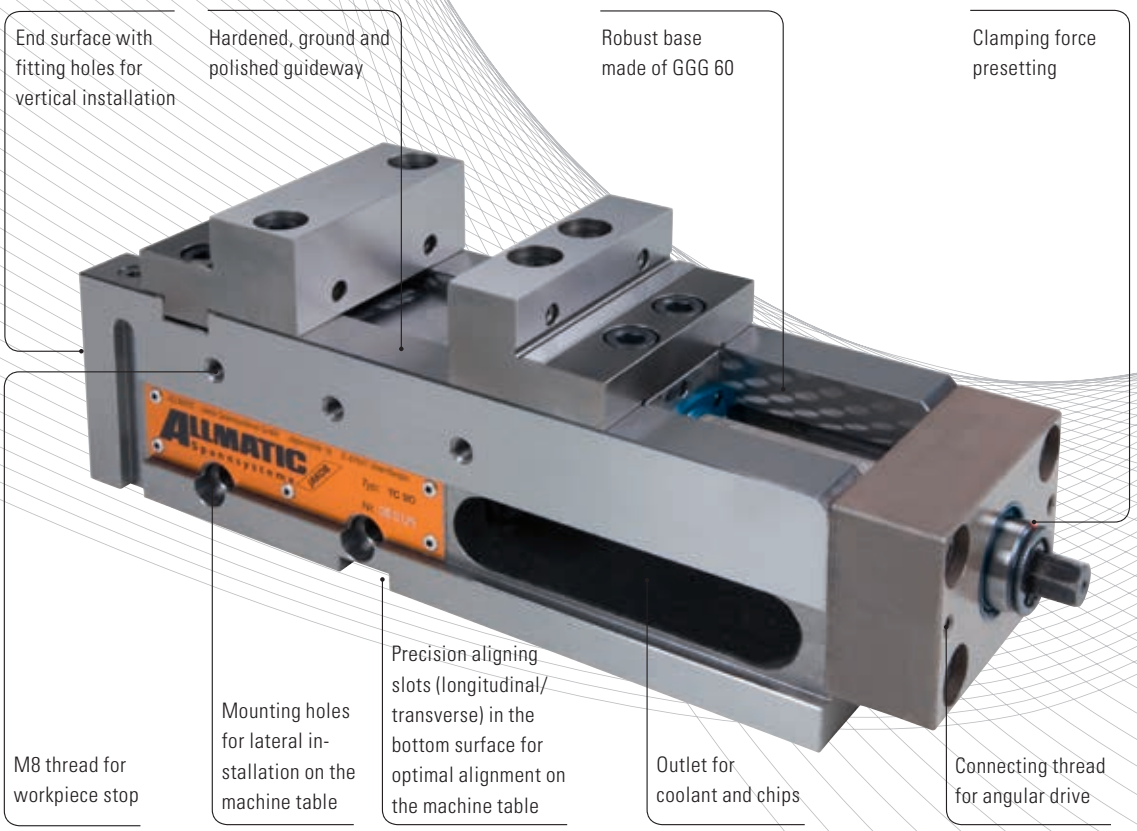
ALLMATIC NC – MECHANICAL TC VERSION, TYPE 90

Scope of application:

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

Product features:

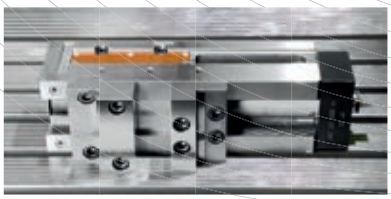
- Extreme accuracy for your machining
- The TC vice is ground and polished on all sides
- Clamping force can be preset in 11 increments – fine gradations for delicate workpieces. At most, one revolution is required to reach the max. clamping force
- Preselectable and reproducible clamping forces enable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



Order no. jaw width 90: 6921678000055

Scope of supply:

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



Vice in lateral clamping position

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

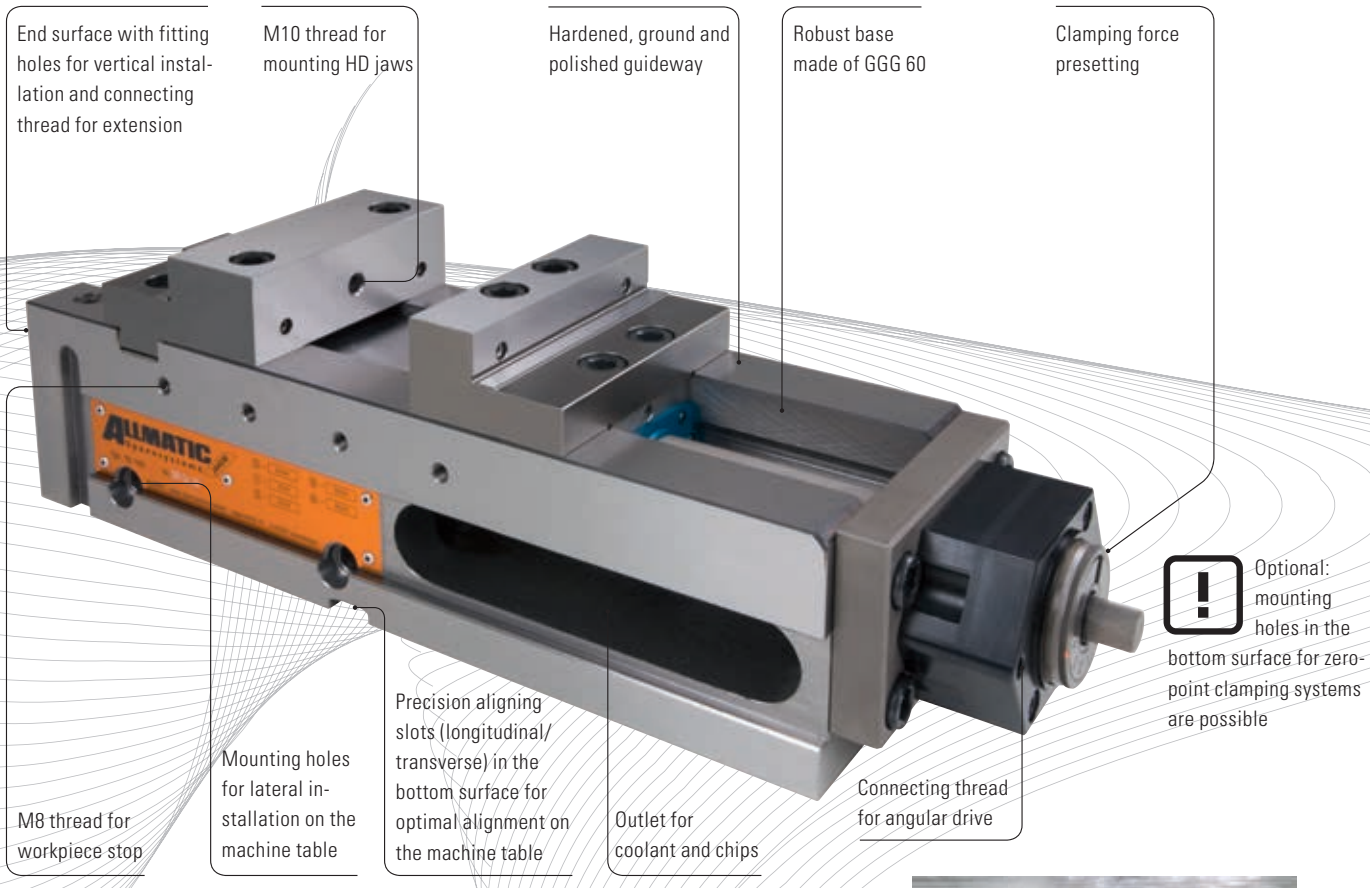
ALLMATIC NC – MECHANICAL TC VERSION, TYPE 125

Scope of application:

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

Product features:

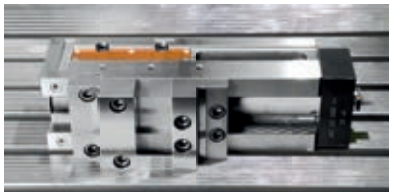
- Extreme accuracy for your machining
- The TC vice is ground and polished on all sides
- Clamping force can be preset in 4 increments. At most, 2 revolutions are required to reach the max. clamping force
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within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



Order no. jaw width 125: 6921688000055

Scope of supply:

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



Vice in lateral clamping position

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

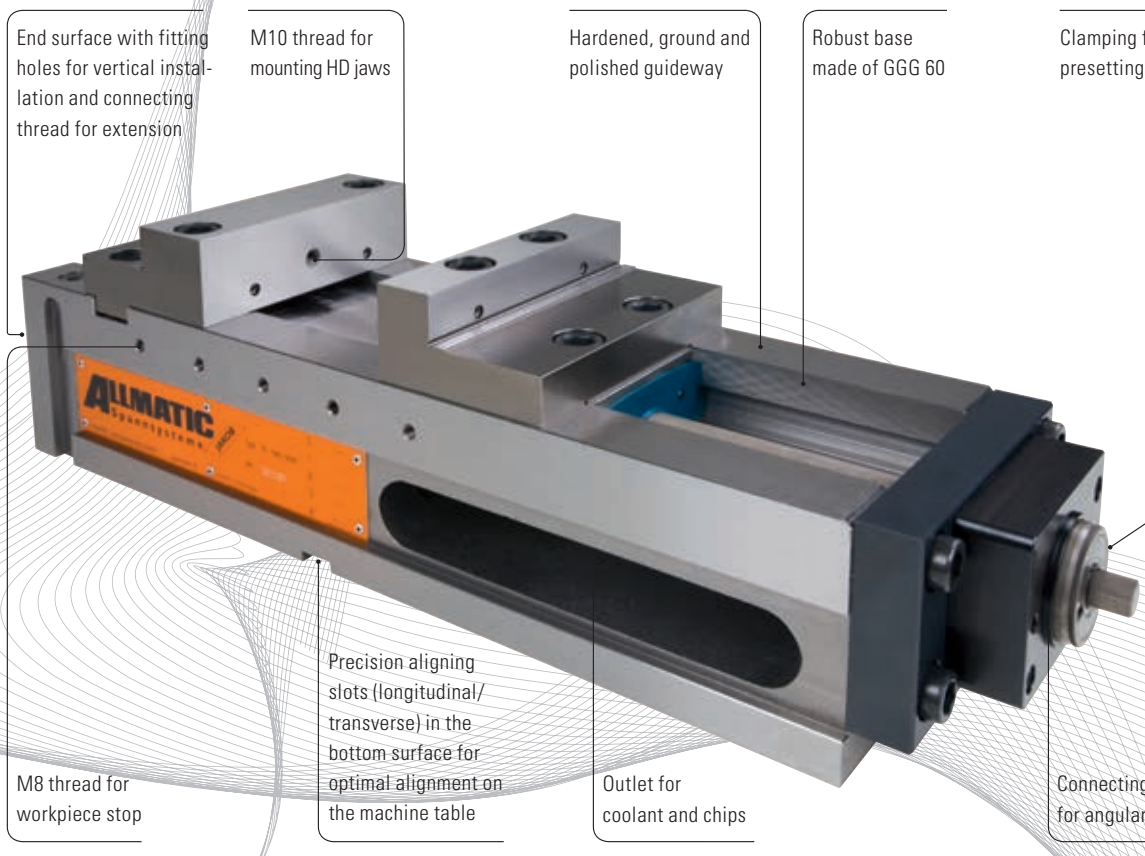
ALLMATIC NC – MECHANICAL TC VERSION, TYPE 160

Scope of application:

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

Product features:

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

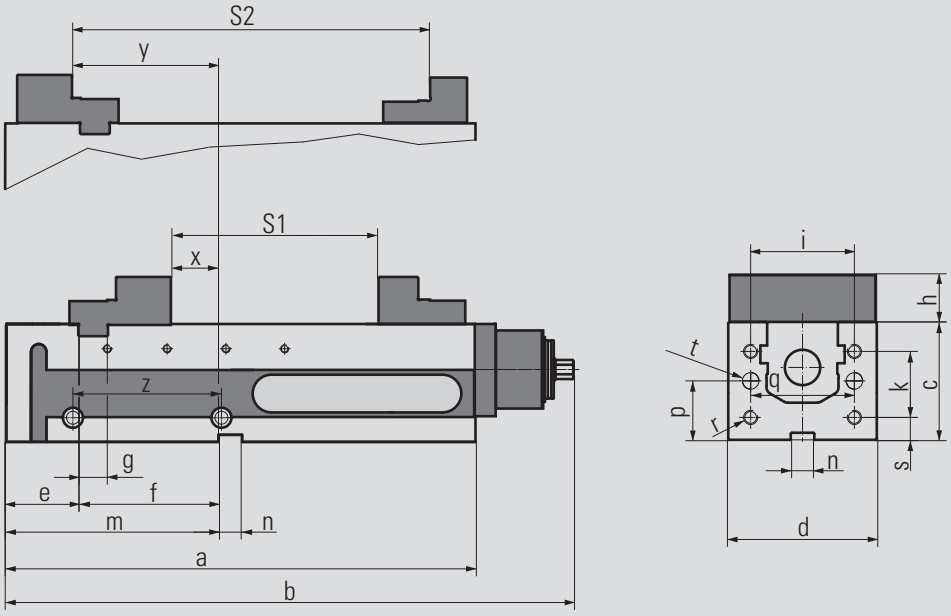


Order no. jaw width 160: 6921708000055

Scope of supply:

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

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



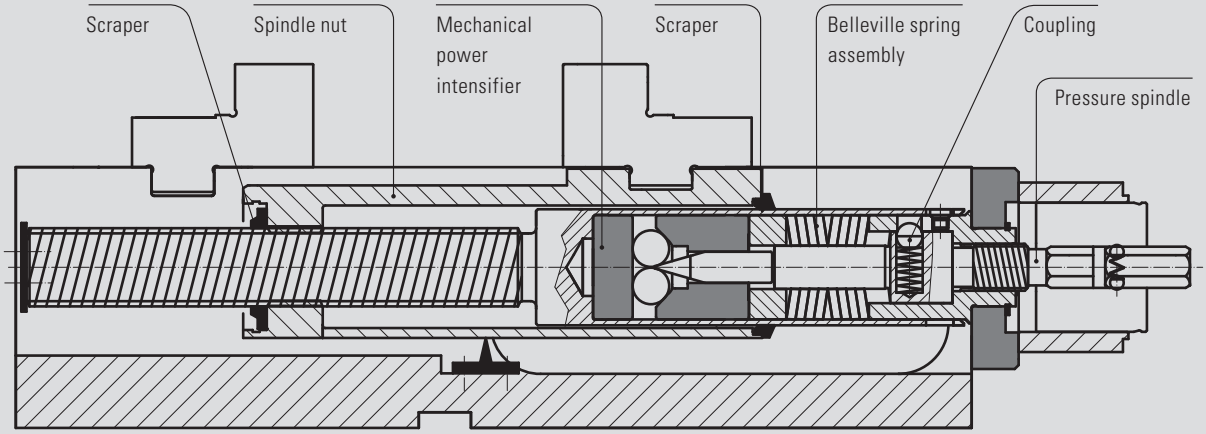
Technical Data

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

Jaw width	90	125	160
Clamping width S1 in mm	0 – 126	0 – 182	(0) 17 – 263
Clamping width S2 in mm	91 – 217	131 – 313	187 – 433
Clamping force increments	11	4	4
Max. clamping force in kN	28	40	60
Weight in kg	15	35	56

• Clamping width 0 can be reached using the compensation jaw

Spindle cross-section



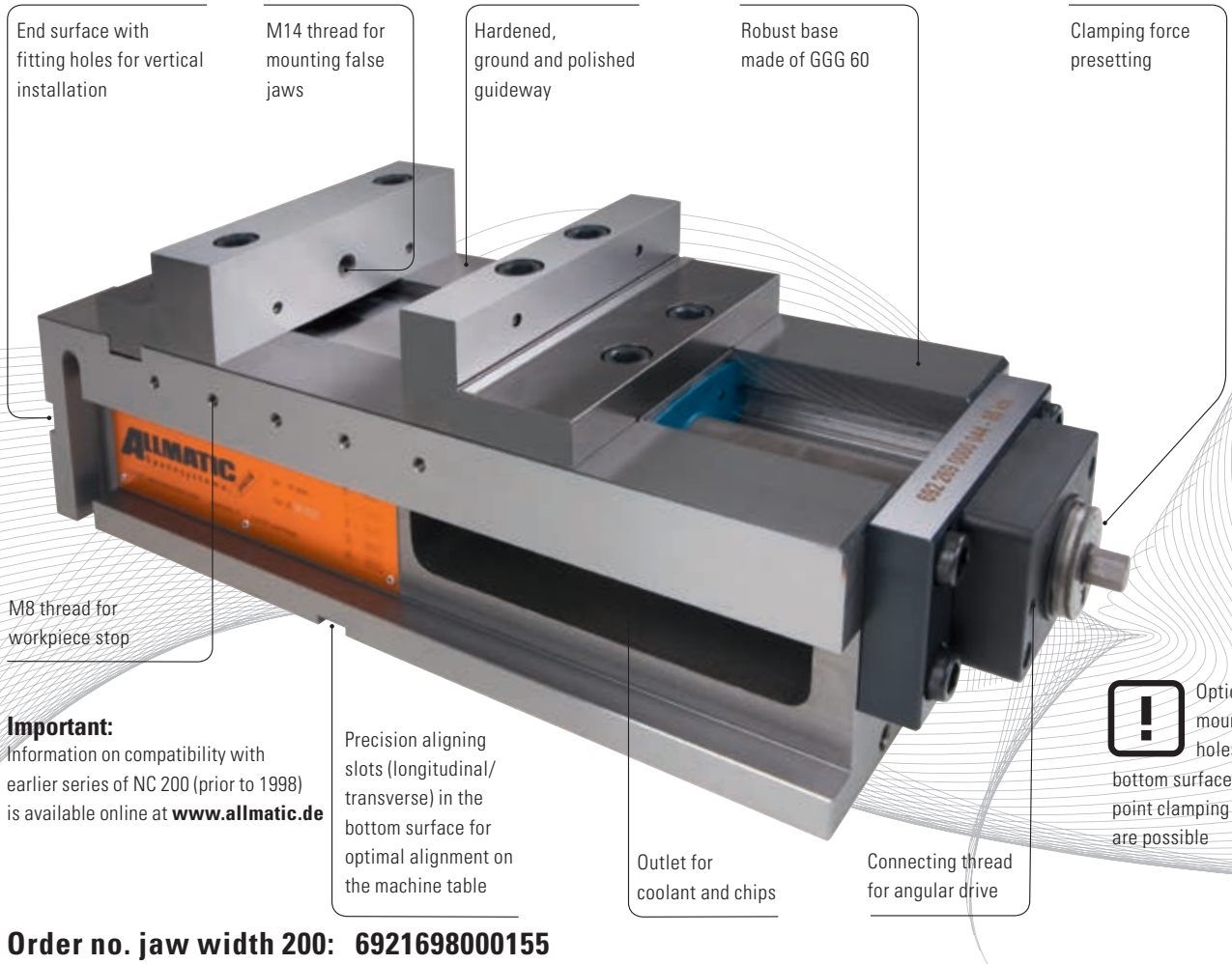
ALLMATIC NC – MECHANICAL TC VERSION, TYPE 200

Scope of application:

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

Product features:

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



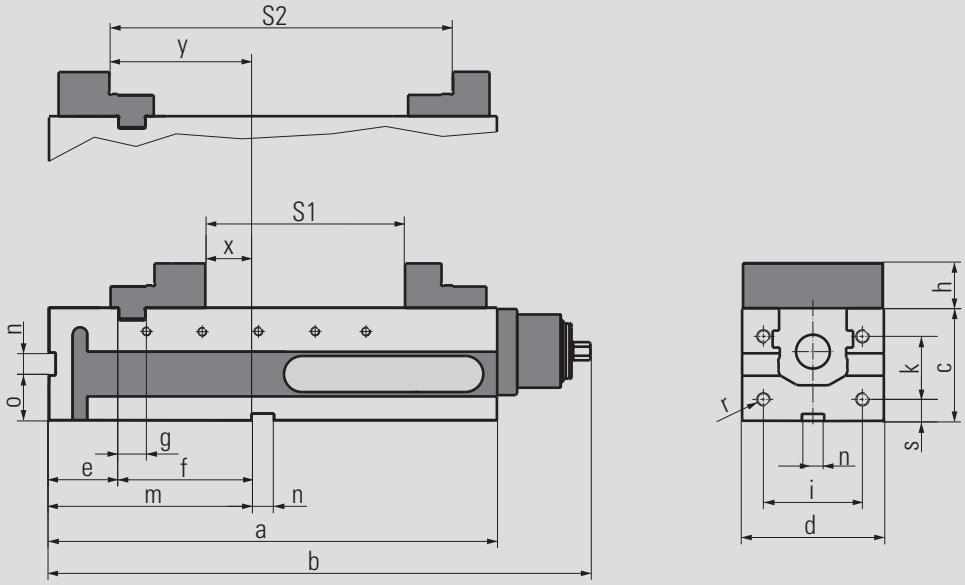
Important:
Information on compatibility with earlier series of NC 200 (prior to 1998) is available online at **www.allmatic.de**

Order no. jaw width 200: 6921698000155

Scope of supply:

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

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



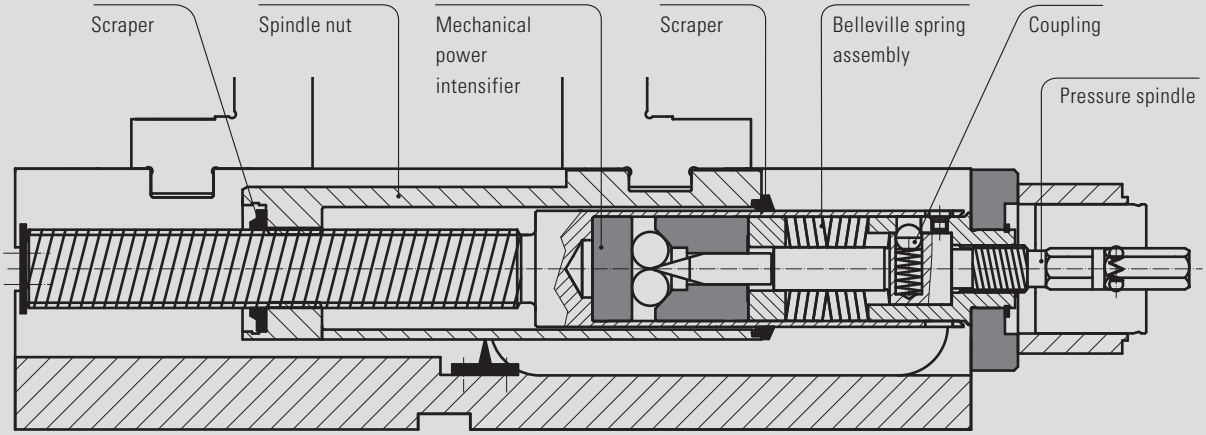
Technical data

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

Jaw width	200
Clamping range S1 in mm	(0) 17 – 263
Clamping range S2 in mm	187 – 433
Clamping force increments	4
Max. clamping force in kN	80
Weight in kg	85

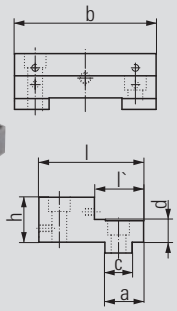
• Clamping width 0 can be reached using the compensation jaw

Spindle cross-section

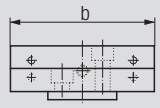


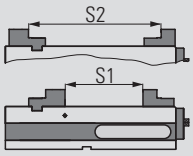
ALLMATIC NC –mechanical / TC version (accessories)

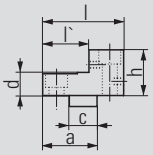
Step jaws



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





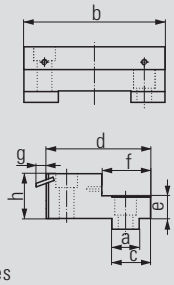


Jaw width	90	125	160	200
Clamping range S1	0 – 126	0 – 182	17 – 263	17 – 263
Clamping range S2	91 – 217	131 – 313	187 – 433	187 – 433

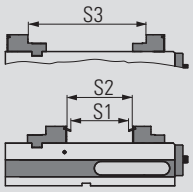
Jaw width					
fixed		90	125	160	200
Ord. no.:		6921674006731	6921684006731	6921704006731	6921694006031
In mm	a	30	34	40	40
	b	89,5	124,4	160,4	200,4
	c	20	24	30	30
	d	16	20	25	25
	h	34	39,5	49,8	60
	l	68	92	104	104
	l`	32	43	54	54

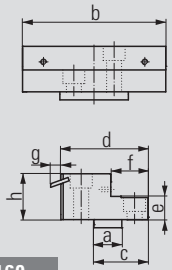
Jaw width					
movable		90	125	160	200
Ord. no.:		6921474002731	6921484002731	6921304002731	6921294002231
In mm	a	38	47	63	65
	b	89,5	124,4	160,4	200,4
	c	20	24	30	30
	d	16	20	25	25
	h	34	39,5	49,8	60
	l	56	70	96	100
	l`	31	40	64	65

Pull-down jaws



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





Jaw width	90	125	160
Clamping range S1	0 – 100	0 – 157	0 – 238
Clamping range S2	0 – 117	0 – 175	17 – 256
Clamping range S3	87 – 209	125 – 303	178 – 420

Jaw width				
fixed		90	125	160
Ord. no.:		6921674106031	6921684106031	6921704109031
In mm	a	20	24	30
	b	89,5	124,4	160,4
	c	30	34	40
	d	69	92	104
	e	16	20	25
	f	37	43	54
	g	8,8	8,8	8,8
	h	34	39,5	49,8

Jaw width				
movable		90	125	160
Ord. no.:		6921674102031	6921684102031	6921704102031
In mm	a	20	24	30
	b	89,5	124,4	160,4
	c	48	46,5	63
	d	62	75	101
	e	16	20	25
	f	24,5	32	51
	g	8,8	8,8	8,8
	h	34	39,5	49,8

ALLMATIC NC – mechanical / TC version (accessories)

Spring leaves (pair)

Order no. jaw width 90: 6921884103031

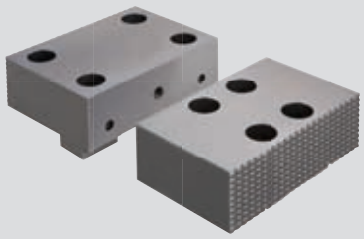
- Hardened spring leaves
- Spring leaves (spare) for pull-down jaws Type 90 (see left)

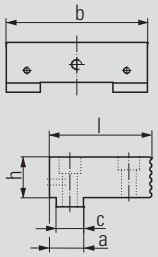
Spring leaves (pair)

Order no. jaw width 125: 6921684103031
160: 6921704103031

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

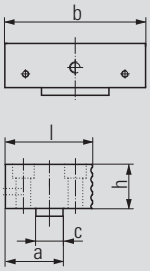
Hard basic jaws



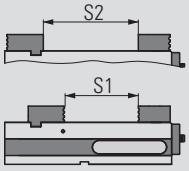


- Material: hardened steel
- One side smooth, ground and polished; one side serrated
- Additional thread for parallels and for mounting HD jaws on the smooth side
- Mounts for Click system on both sides of the jaw

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



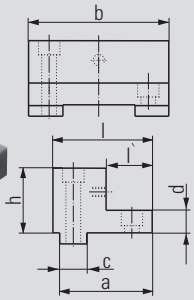
Jaw width				
movable		**90**	**125**	**160**
Ord. no.:		**6921674004731**	**6921684004731**	**6921704004731**
In mm	a	40	50	65
	b	89,5	124,4	160,4
	c	20	24	30
	h	34	39,5	49,8
	l	60	76	100



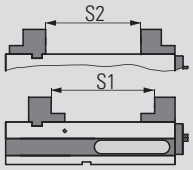
Clamping range S1	0 – 120	0 – 173	20 – 256
Clamping range S2	32 –150	50 – 225	70 – 310

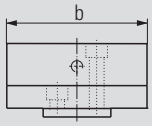
ALLMATIC NC – mechanical / TC version (accessories)

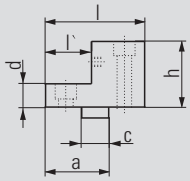
Master jaw adapters



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





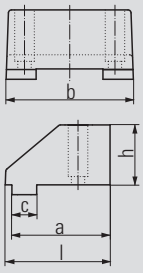


Jaw width	90	125	160	200
Clamping range S1	67 – 183	71 – 243	90 – 330	90 – 330
Clamping range S2	28 – 149	47 – 224	70 – 310	70 – 310

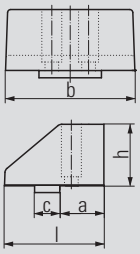
Jaw width					
fixed		90	125	160	200
Ord. no.:		6921674012231	6921684012231	6921704012231	6921694012231
In mm	a	56	77	89	89
	b	90	126	164	202
	c	20	24	30	30
	d	16	20	24	24
	h	46	58	73	85
	l	66	85	100	100
	l`	30	32	34	34

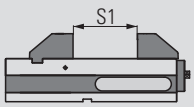
Jaw width					
movable		90	125	160	200
Ord. no.:		6921274011231	6921284011231	6921304011231	6921294011231
In mm	a	40	52	65	45
	b	90	126	164	202
	c	20	24	30	30
	d	16	20	24	24
	h	46	58	73	85
	l	60	80	100	100
	l`	30	32	34	38

Soft jaws



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





Order no. fixed: 6921684088031

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

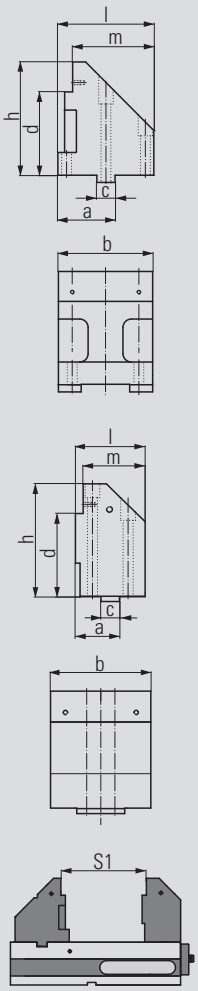
Order no. movable: 6921484087031

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

Clamping range S1	0 – 150

ALLMATIC NC – mechanical / TC version (accessories)

High jaws



- Material: hardened steel
- Particularly suitable for 5-sided machining
- Better accessibility for tools
- Ground and polished clamping surfaces
- Additional thread for parallels

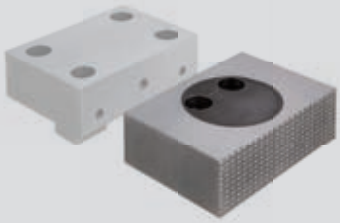
Order no. fixed: 6921684047031

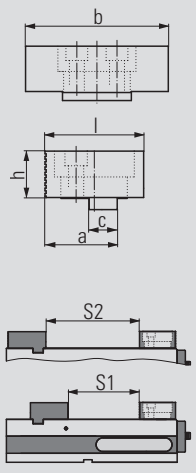
Jaw width		125
Dimensions in mm	a	75.5
	b	124.4
	c	24
	d	110
	h	149.5
	l	126.7
	m	107.2

Order no. movable: 6921684048031

Jaw width		125
Dimensions in mm	a	57
	b	124.4
	c	24
	d	110
	h	149.5
	l	90
	m	80
Clamping range S1		26 – 208

Pivot jaw, movable





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

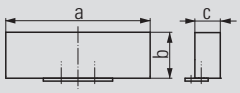
Order no. jaw width 90: 6921674020142
125: 6921684020042
160: 6921704020042

Jaw width		90	125	160
Dimensions in mm	a	49.5	62	86
	b	90	124.4	160.4
	c	20	24	30
	h	34	39.5	49.8
	l	68	84	118
Clamping range S1		0 – 110	0 – 161	0 – 235
Clamping range S2		22 – 140	38 – 213	50 – 290

ALLMATIC NC – mechanical / TC version (accessories)

Soft jaw

Order no. 6921684023042

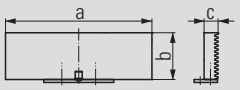


Jaw width		125
Dimensions in mm	a	125
	b	39.8
	c	22

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

Jaw with cross grooving

Order no. 6921684032040

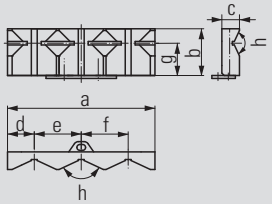


Jaw width		125
Dimensions in mm	a	125.6
	b	40.1
	c	12

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

Prismatic jaws (pair)

Order no. 6921684024042

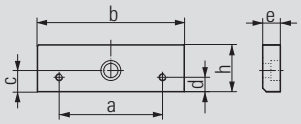


c		125
Dimensions in mm	a	125.6
	b	39.8
	c	15
	d	22.8
	e	40
	f	40
	g	27.5
	h	130°

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

ALLMATIC NC – mechanical / TC version (accessories)

Compensation jaw

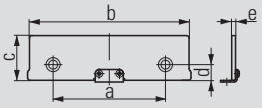


Order no. jaw width 160: 6921704022031
200: 6921694022031

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

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

Click parallels (pair)

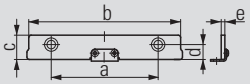


Order no. jaw width 90: 6921175029042
125: 6921185035042
160: 6921205044042

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

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

Click parallels (pair)



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

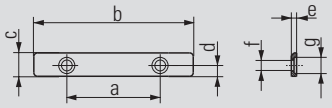
Jaw width		90	125	160
Dimensions in mm	a	48	88	88
	b	90	125	160
	c -0.01	16	20	25
	d	8.75	12.25	12.25
	e	3	3	3

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

ALLMATIC NC – mechanical / TC version (accessories)

Parallels (pair)

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

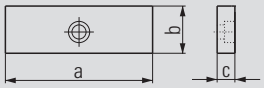


Jaw width		90	125	160
Dimensions in mm	a	52	88	88
	b	89	124	160
	c	13	15	19
	d	6	6	6
	e	3	3	3
	f	Ø 6	Ø 6	Ø 6
	g	Ø 9	Ø 9	Ø 9

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

Smooth jaws (pair)

Order no. jaw width 125: 6921024022031
160: 6921034022031

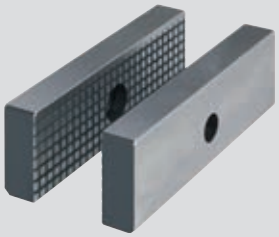


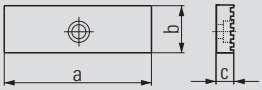
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

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

Serrated jaws (pair)

Order no. jaw width 125: 6921021005031
160: 6921031005031





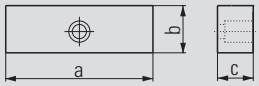
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

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

ALLMATIC NC – mechanical / TC version (accessories)

Soft jaws (pair)

Order no. jaw width 125: 6921024023031
160: 6921034023031

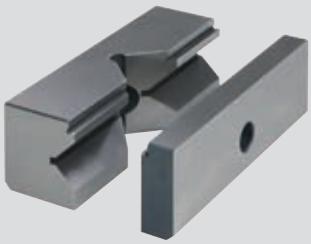


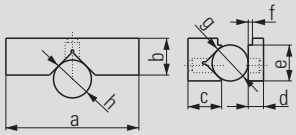
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	25	30

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

Prismatic jaws (set)

Order no. jaw width 125: 6921024024031
160: 6921034024031



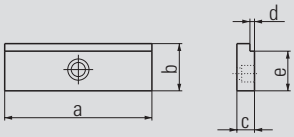


Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	35	45
	d	15	20
	e	35	45
	f	3	3
	g	Ø 12 – 28	Ø 15 – 40
	h	Ø 18 – 55	Ø 22 – 65

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

Step jaws (pair)

Order no. jaw width 125: 6921024025031
160: 6921034025031



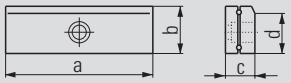
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20
	d	3	3
	e	35	45

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

ALLMATIC NC – mechanical / TC version (accessories)

Roller pull-down jaws (pair)

Order no. jaw width 125: 6921024005131
160: 6921034005131

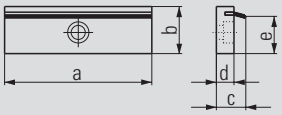


Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	26	35.5
	d	35	45

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

Spring leaf pull-down jaws (pair)

Order no. jaw width 125: 6921024001042
160: 6921034001042



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

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

Spring leaves (pair)

Order no. jaw width
125: 6921024001131
160: 6921034001131

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

Jaw fixing bolt

Order no. 6921011023000

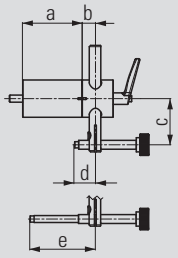
Bolt with shoulder – M10 x 23

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

ALLMATIC NC – mechanical / TC version (accessories)

Workpiece stop

Order no. 6921285650144

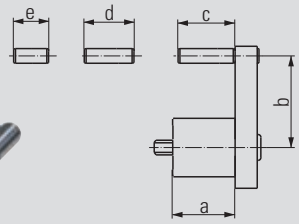


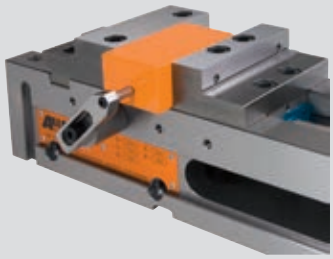
Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

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

Workpiece stop

Order no. 6921685670042



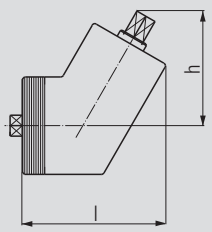


Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

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

Angular drive

Order no. jaw width 125 to 200: 6921285700143

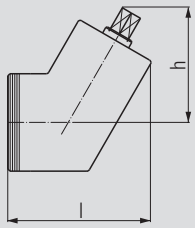


Jaw width		125	160	200
Dimensions in mm	l	97	97	97
	h	75	75	75

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

ALLMATIC NC – mechanical / TC version (accessories)

Angular drive

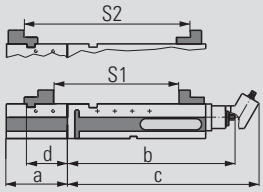


- For type 90
- Wrench size 12
- Can be bolted to the end of the spindle if access is difficult
- Step-down ratio 2 : 1

Order no. 6921675700043

Jaw width		90
Dimensions in mm	l	87
	h	75

Clamping range enlargement



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

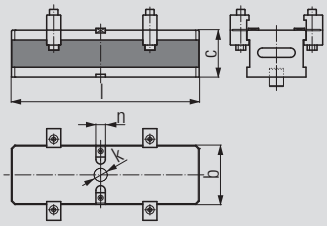
Order no. jaw width 125: 6921685008055
160: 6921705008055

Jaw width		125	160
Dimensions in mm	a	176	237
	b	483	620
	c	552	683
	d	117	172
Clamping range S1		179 – 361	259 – 505
Clamping range S2		310 – 492	431 – 675

XL console

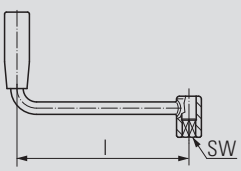
- Material: GG30
- For raising the vice
- Improvement of access for 5-sided machining
- Optional preparation for zero-point clamping systems
- Scope of supply: console incl. fixing bolt for positioning the vice, 4 pairs of Duo side clamps, 2 socket screw wrenches

Order no. 6921885010042



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

Hand crank



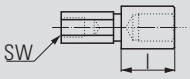
Order no. jaw width 90: 6921675508042
125 - 200: 6921685508042

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

- Suitable for jaw width 125 – 200 mm

ALLMATIC NC – mechanical / TC version (accessories)

Hexagonal extension

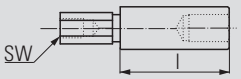


Order no. 6921685512040

Jaw width		125
Dimensions in mm	l	30
	SW	14

- Improves access for the hand crank
- Is secured to the hand crank with a bolt
- Suitable for jaw width 125 – 200 mm

Hexagonal extension



Order no. 6921685512140

Jaw width		125
Dimensions in mm	l	60
	SW	14

- Improves access for the hand crank
- Is secured to the hand crank with a bolt
- Suitable for jaw width 125 – 200 mm

Side clamps (pair)

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

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

DUO side clamps

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

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

Aligning and fixing set

Order no. – see table

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

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

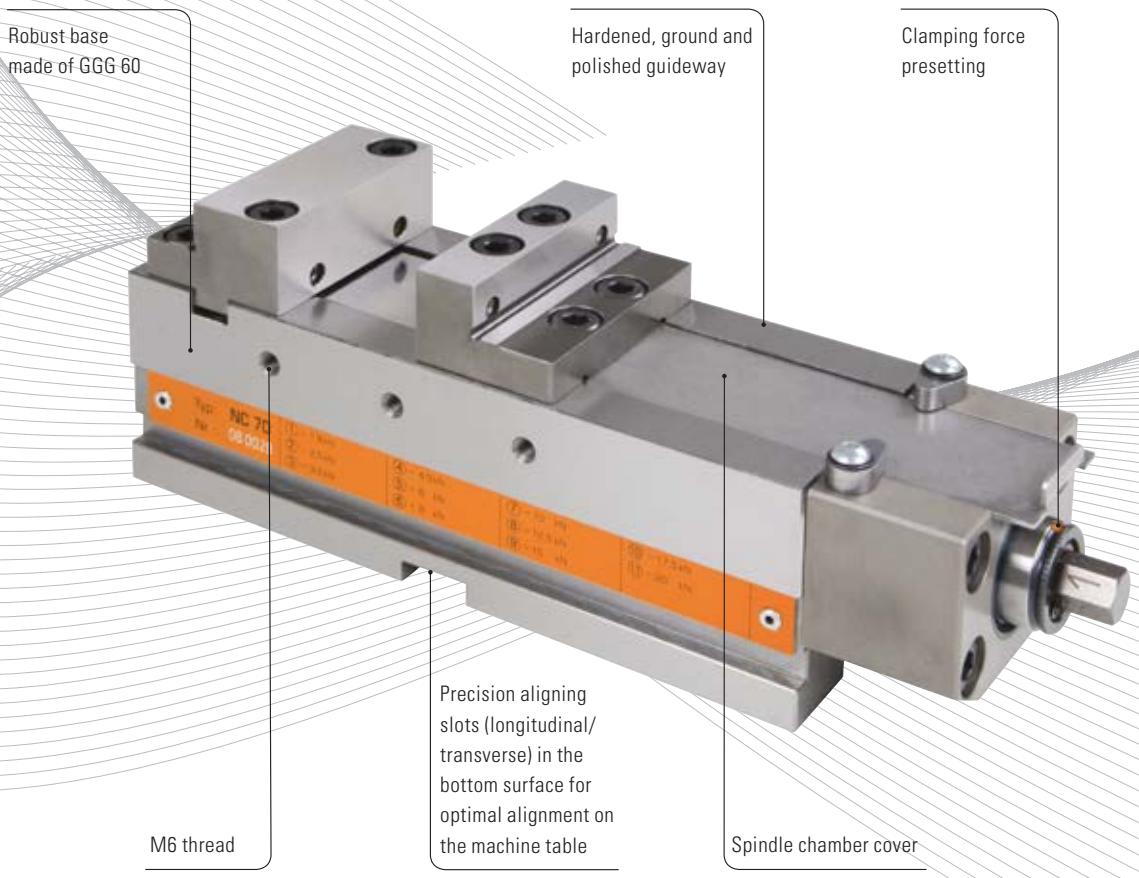
ALLMATIC NC – MECHANICAL
NC 70 VERSION

Scope of application:

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

Product features:

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

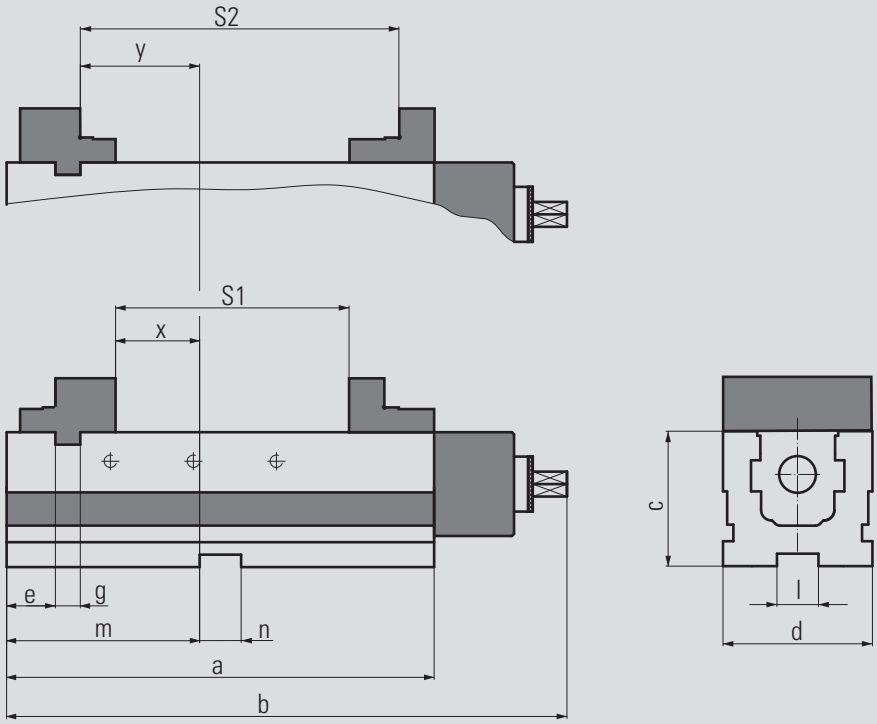


Order no. jaw width 70: 6921268000055

Scope of supply:

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

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

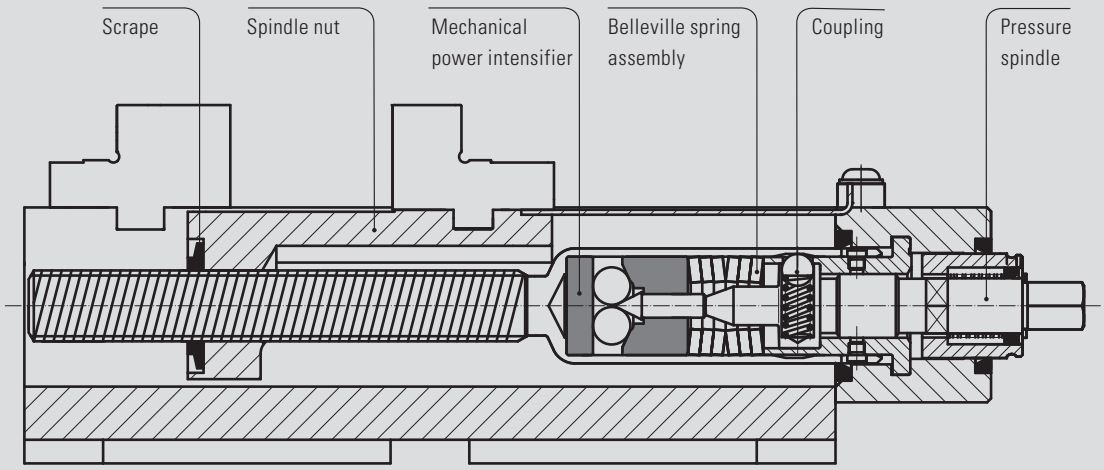


Technical data

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

Jaw width	70
Clamping range S1 in mm	0 – 112
Clamping range S2 in mm	40 – 152
Clamping force increments	11
Max. clamping force in kN	20
Weight in kg	7

Spindle cross-section

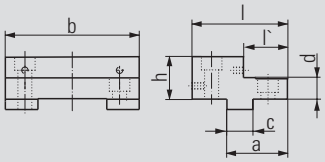


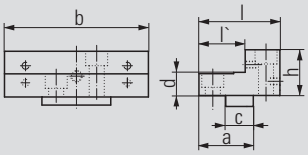
ALLMATIC NC – mechanical / NC 70 version (accessories)

Step jaws

Order no. fixed:
6921264006031

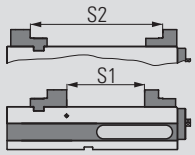
Order no. movable:
6921264002031





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

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

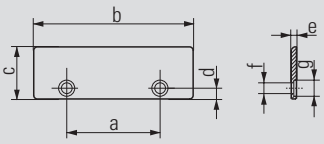


- Material: hardened steel
- Ground and polished clamping surfaces
- High and step sides with M5 thread for parallels

Clamping range S1	0 – 112
Clamping range S2	40 – 152

Parallels (pair)

Order no. 6921265022031

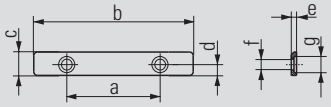


Jaw width		70
Dimensions in mm	a	37
	b	69.6
	c	22
	d	6
	e	2.5
	f	Ø 6
	g	Ø 9

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

Parallels (pair)

Order no. 6921265010031



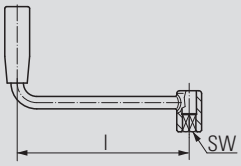
Jaw width		70
Dimensions in mm	a	52
	b	69.6
	c	10
	d	4.5
	e	2.5
	f	Ø 6
	g	Ø 9

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

ALLMATIC NC – mechanical / NC 70 version (accessories)

Hand crank

Order no. 6921675508042



Jaw width		70
Dimensions in mm	l	150
	SW	12

Aligning and fixing set

Order no. – see table

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

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

ALLMATIC NC – MECHANICAL
DUO 90 VERSION

Scope of application:
- Horizontal installation – suitable for vertical CNC-controlled milling machines
- Lateral installation is also possible

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

Robust base made of GGG 60

Hardened, ground and polished guideway

Clamping force presetting

M8 thread for workpiece stop

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

Outlet for coolant and chips

Connecting thread for angular drive

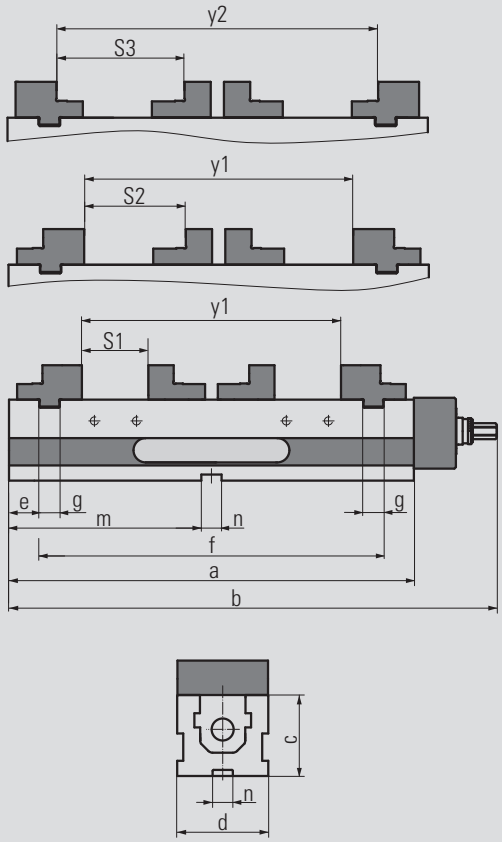
Optional: mounting holes in the bottom surface for zero-point clamping system are possible

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

Order no. jaw width 90: 6921478000955

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

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



Technical data

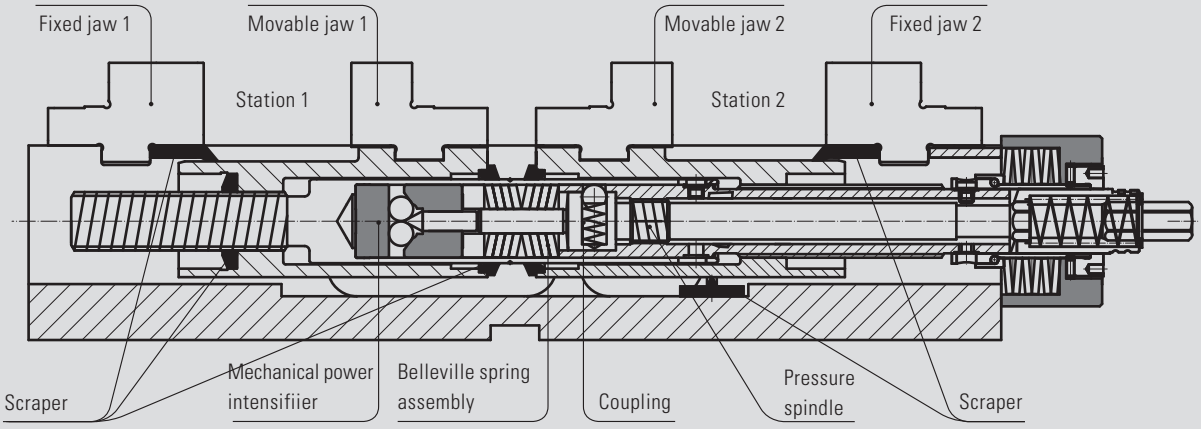
Jaw width		90
Dimensions / tolerances in mm	a	400
	b	482
	c	80
	d	90
	e	30
	f	340
	g	20
	m	190
	n	20
	y1	256
	y2	306

Jaw width	90
Clamping range S1 in mm	0 – 64
Clamping range S2 in mm	31 – 95
Clamping range S3 in mm	56 – 120
Clamping force increments	6
Max. clamping force in kN	28
Weight in kg	19.5

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

Workpieces must be placed in both stations before clamping begins. Dimensional differences between workpiece one and workpiece two are compensated for:
NC DUO 90 ± 3 mm

Spindle cross-section

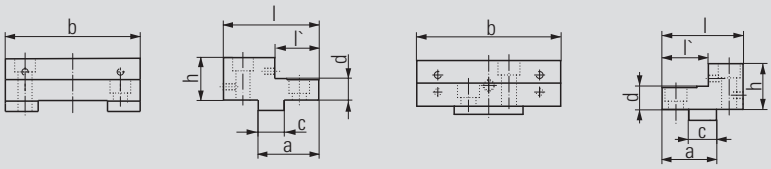


ALLMATIC NC – mechnical / DUO 90 version (accessories)

Step jaws

Order no. fixed:
6921474006731

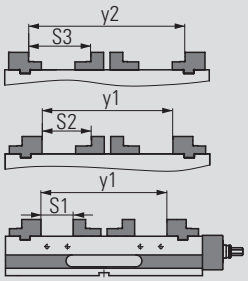
Order no. movable:
6921474002731



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

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

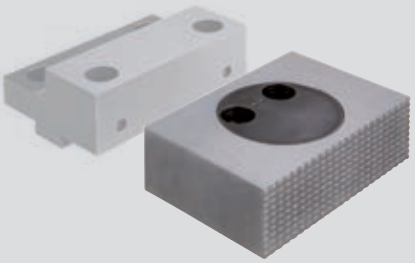
Jaw width		90
Dimensions in mm	a	38
	b	89.5
	c	20
	d	16
	h	34
	l	56
	l`	31

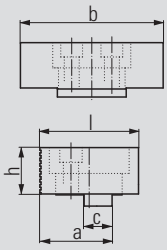


y1	256
y2	306
Clamping range S1	0 – 64
Clamping range S2	31 – 95
Clamping range S3	56 – 120

Pivot jaw, movable

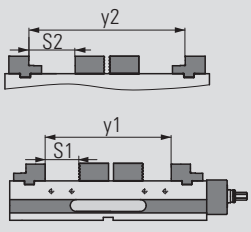
Order no. movable: 6921674020142





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

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

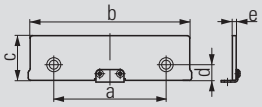


y1	256
y2	306
Clamping range S1	0 – 64
Clamping range S2	31 – 95

ALLMATIC NC – mechnical / DUO 90 version (accessories)

Click parallels (pair)

Order no. 6921175029042

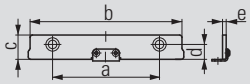


Jaw width		90
Dimensions in mm	a	48
	b	90
	c -0.01	29
	d	8.75
	e	3

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

Click parallels (pair)

Order no. 6921175016042

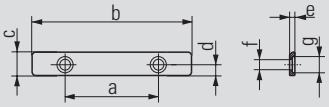


Jaw width		90
Dimensions in mm	a	48
	b	90
	c -0.01	16
	d	8.75
	e	3

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

Parallels (pair)

Order no. 6921475013031



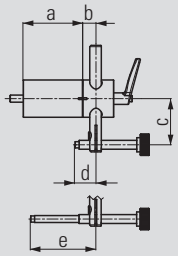
Jaw width		90
Dimensions in mm	a	52
	b	89
	c	13
	d	6
	e	3
	f	Ø 6
	g	Ø 9

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

ALLMATIC NC – mechnical / DUO 90 version (accessories)

Workpiece stop

Order no. 6921285650144

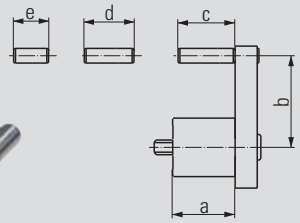


Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

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

Workpiece stop

Order no. 6921685670042

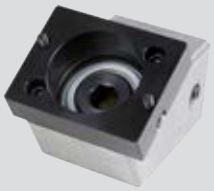


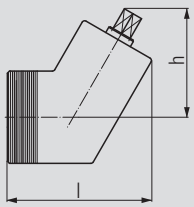
Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

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

Angular drive

Order no. 6921485700043



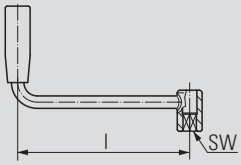


Jaw width		90
Dimensions in mm	h	75
	l	102

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

ALLMATIC NC – mechnical / DUO 90 version (accessories)

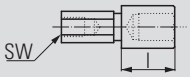
Hand crank



Order no. 6921685508042

Jaw width		90
Dimensions in mm	l	180
	SW	14

Hexagonal extension

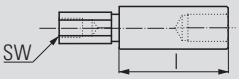


Order no. 6921685512040

Jaw width		90
Dimensions in mm	l	30
	SW	14

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

Hexagonal extension



Order no. 6921685512140

Jaw width		90
Dimensions in mm	l	60
	SW	14

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

Side clamps (pair)

Order no. 6921015000231

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

DUO side clamps

Order no. 6921675000031

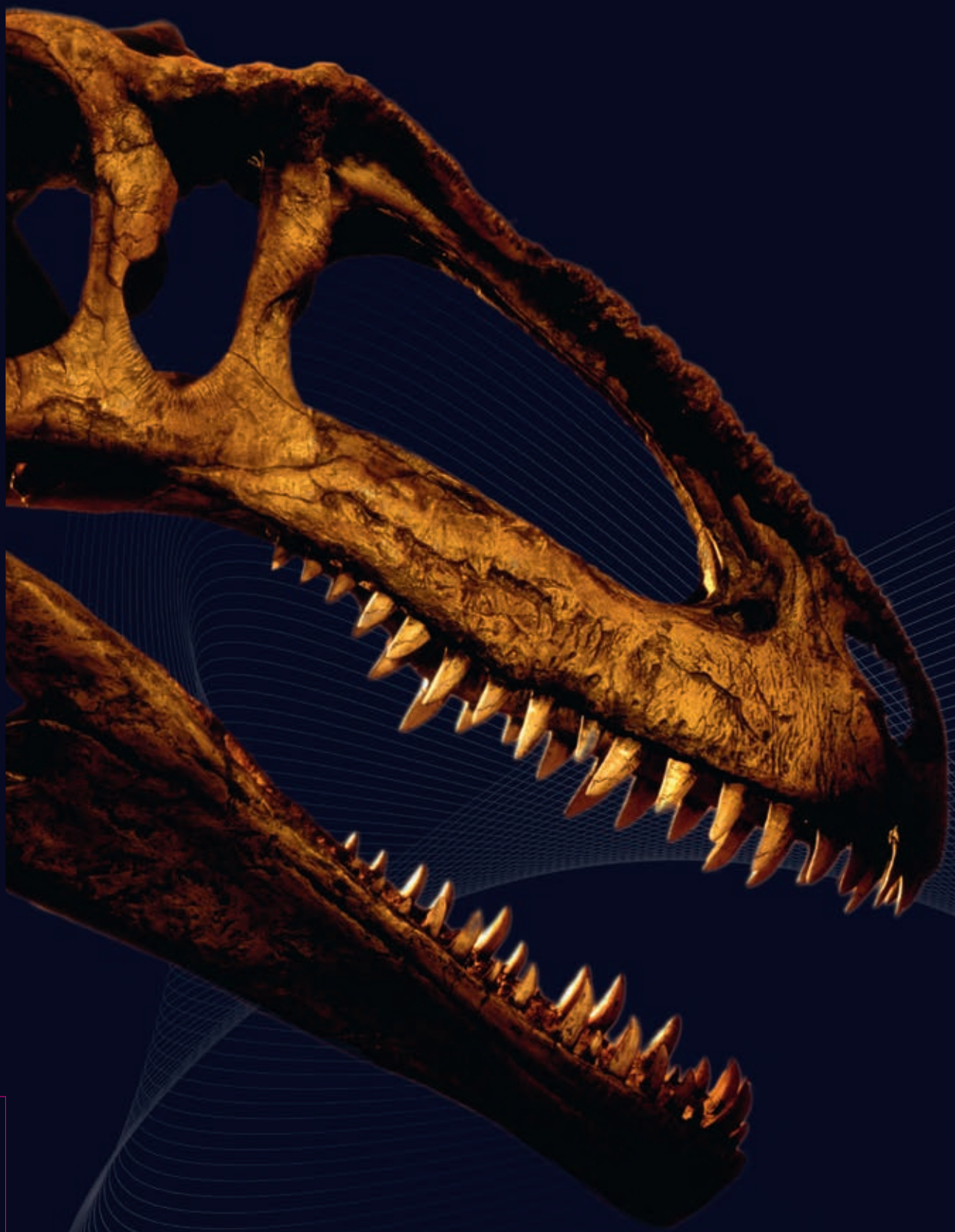
- For securing the vice on the machine table
- 1 set consists of 2 pairs of side clamps incl. screw connections

Aligning and fixing set

Order no. – see table

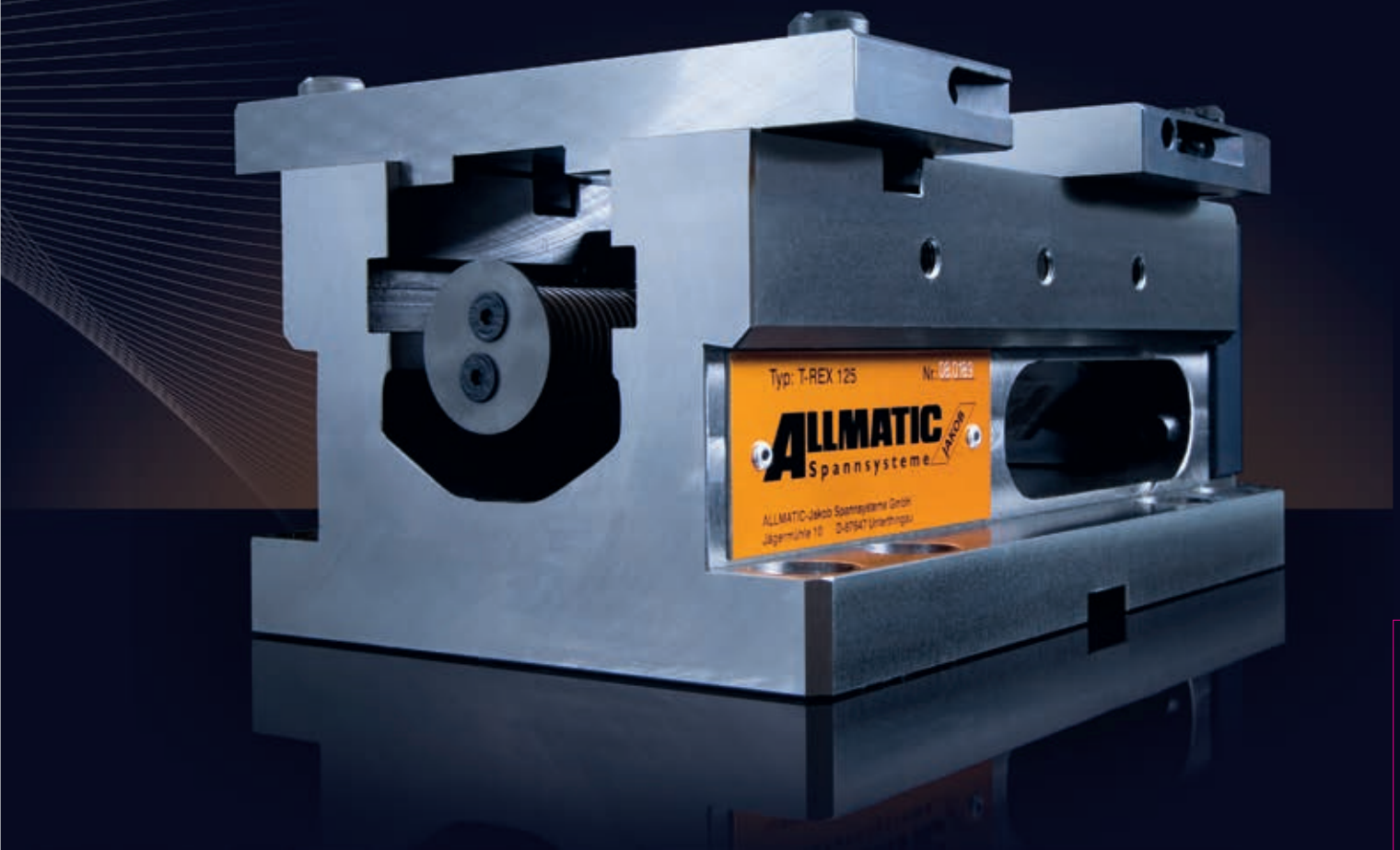
T-slot/ thread	Order no.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

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



ALLMATIC T-REX – MIND THE JAWS!

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



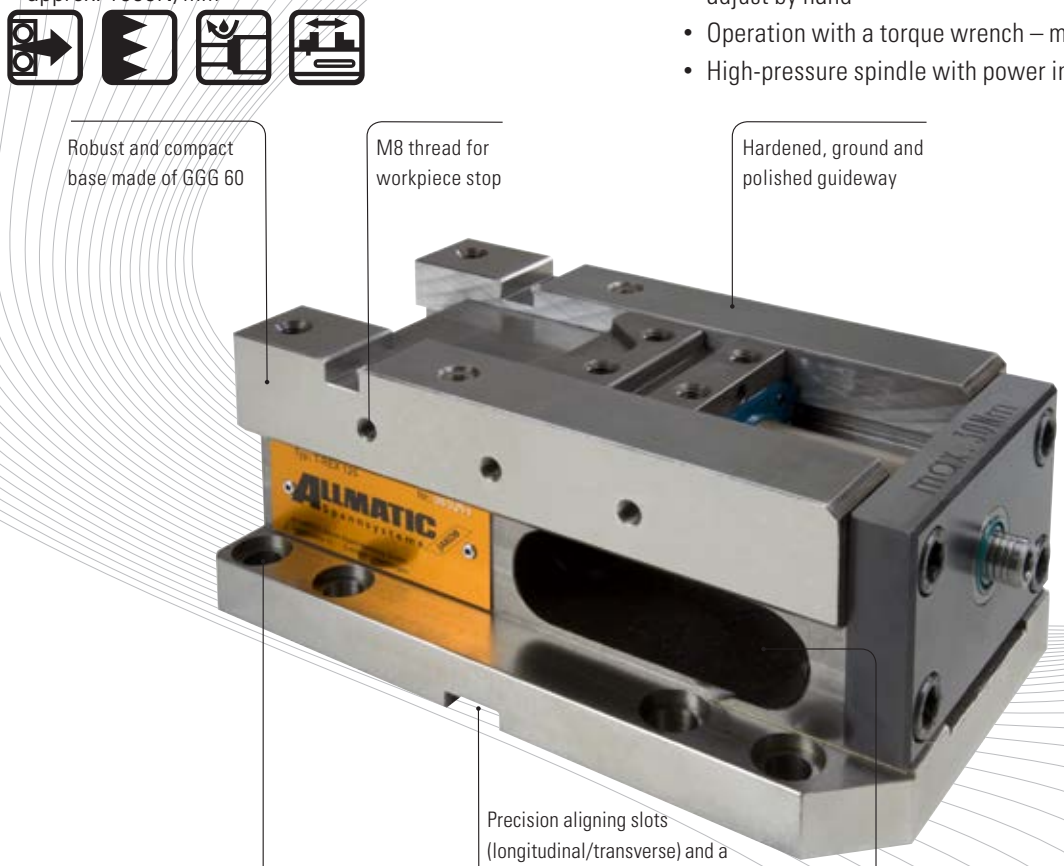
ALLMATIC GRIPP – MECHANICAL T-REX VERSION

Scope of application:

- Horizontal installation – suitable for vertical CNC-controlled milling machines
- Ideal for use on 5-axis machining centres
- Reliable and fast clamping of unmachined parts, flame-cut and sawn materials with gripper jaws
- Clamping of parallel pre-machined workpieces with optional step jaws
- Gripper studs suitable for materials with a strength of up to approx. 1000N/mm²

Product features:

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



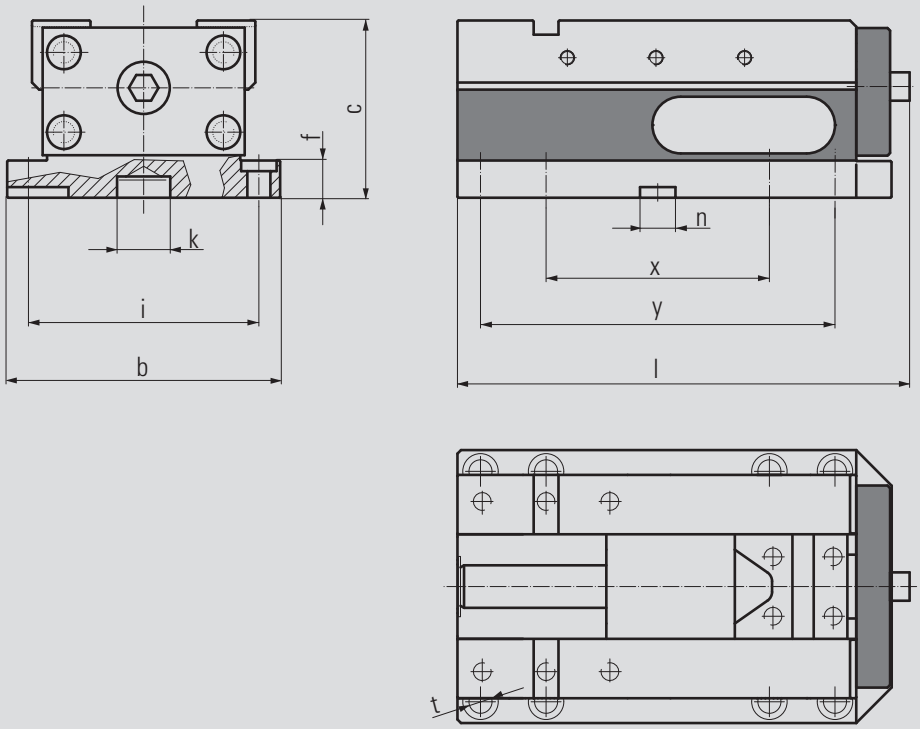
Order no. jaw width 125: 6921888000155

Scope of supply:

- 1 high-pressure vice without jaws
- 4 fastening bolts M12 x 35 mm
- 3 socket screw wrenches

(Please order clamping jaws separately)

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

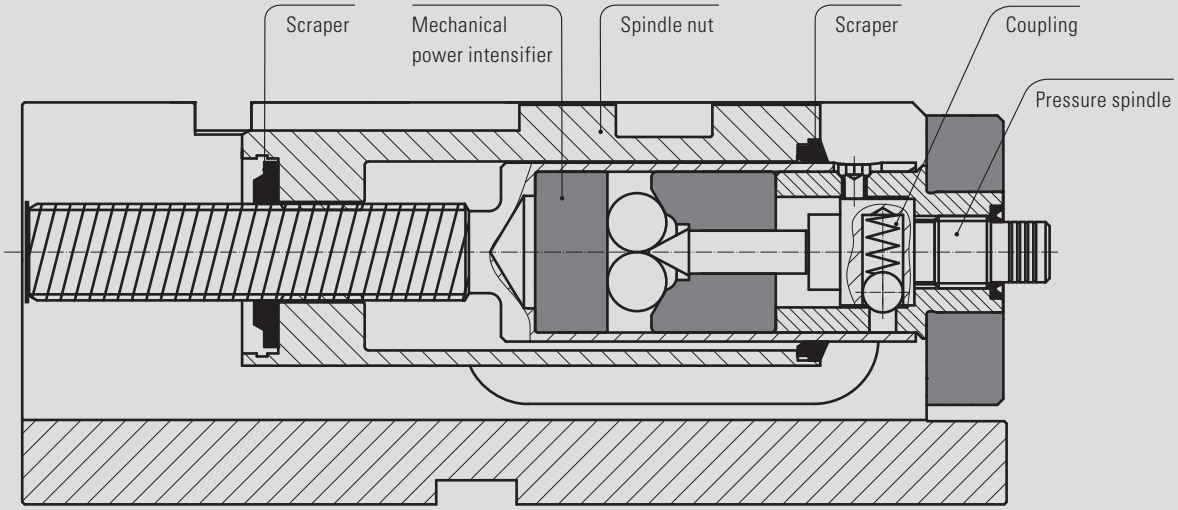


Technical data

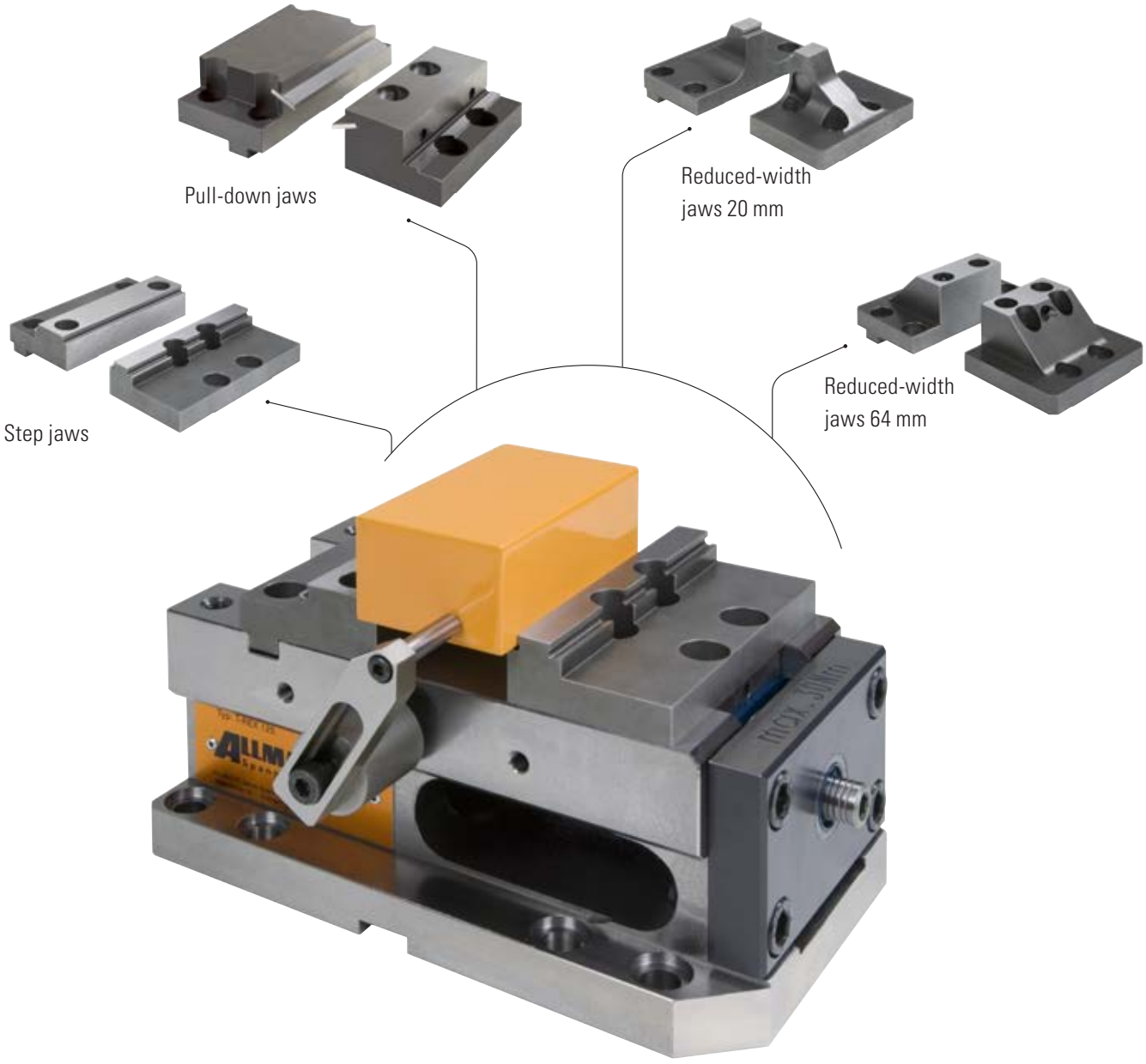
Jaw width		125
Dimensions / tolerances in mm	b	154
	c	100
	f	21
	i	130
	k	Ø 30 H8
	l	256
	n	20 H7
	t	Ø 13
	x	127
	y	200

Jaw width	125
Max. torque in Nm	30
Max. clamping force in kN	40
Weight in kg	17

Spindle cross-section



ALLMATIC GRIPP – MECHANICAL/T-REX



For conventional clamping of workpieces

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

For clamping complex unmachined parts

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

Gripper clamping:

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

CLAMPING RANGES – T-REX

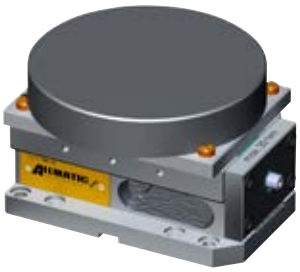
Support jaws with gripper studs

min. clamping range	26 mm
min. clamping width	70 mm

min. clamping range	Ø 80 mm

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

max. clamping range	184 mm
max. clamping width	at least 150 mm or larger



max. clamping range	Ø 226 mm

Support jaws with universal gripper set

min. clamping range	0 mm
min. clamping width	90 mm

min. clamping range	Ø 60 mm

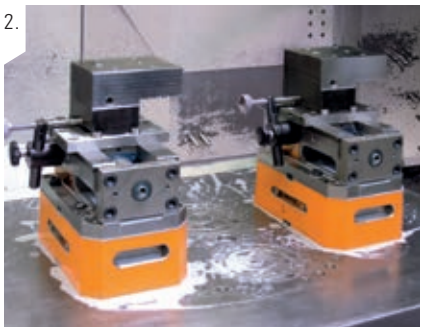
max. clamping range	125 mm
max. clamping width	at least 165 mm or larger

max. clamping range	Ø 170 mm

APPLICATION EXAMPLES – T-REX

1.

2.

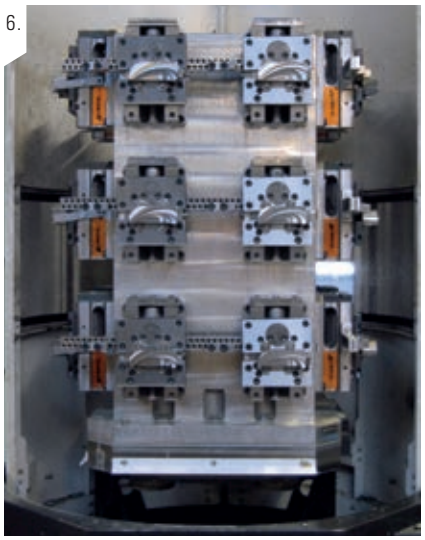


3.

4.

5.

6.



Application examples

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

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

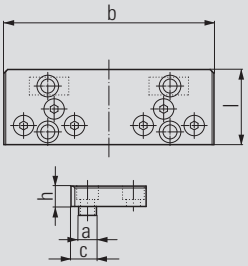
Support jaws for gripper studs

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

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

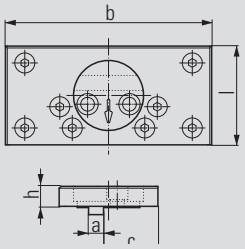
Dimensions of the individual items of the gripper set can be found at www.allmatic.de

Order no. fixed:
6921884005042



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

Order no. movable, pivot:
6921884072042



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

Please order gripper studs separately.

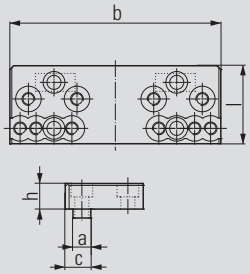
Support jaws for universal gripper set

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

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

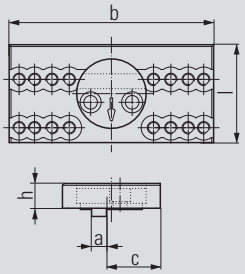
Dimensions of the individual items of the gripper set can be found at www.allmatic.de

Order no. fixed:
6921884005242



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

Order no. movable, pivot:
6921884072242

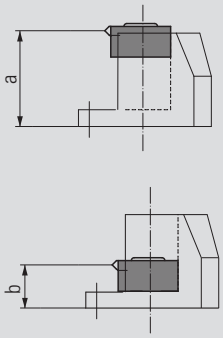


Jaw width		125
Dimensions in mm	a	12
	b	165
	c	35.5
	h	20
	l	79

Please order universal gripper set separately.

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

Universal gripper set



Order no. 6921884027031

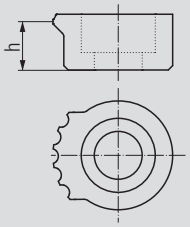
Jaw width		125
Dimensions in mm	a	40
	b	18

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

Comprising:

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

Gripper stud

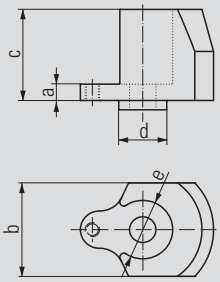


Order no. 6921884026000

Dimensions in mm	h	11

- Gripper stud for universal gripper set

Gripper stud mount

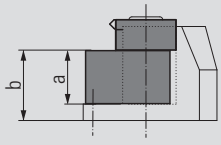


Order no. 6921884072000

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

- Mount for gripper stud 2306/001

Support



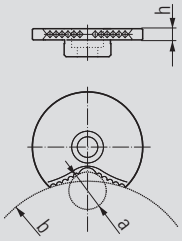
Order no. 6921884028000

Dimensions in mm	a	22
	b	29

- Support for universal gripper set

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

Prismatic gripper

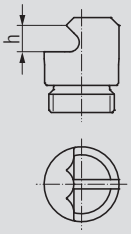


Order no. 6921884029031

Dimensions in mm	a	Ø 20
	b	Ø 120
	h	6

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

Gripper stud, pointed

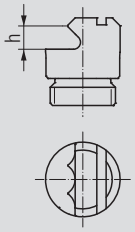


Order no. 6921884036000

Dimensions in mm	h	5.5

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

Gripper stud, low-level

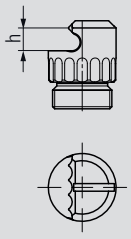


Order no. 6921884036100

Dimensions in mm	h	5

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

Gripper stud, four-point

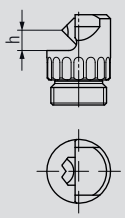


Order no. 6921884036500

Dimensions in mm	h	5,4

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

Gripper stud, carbide coated



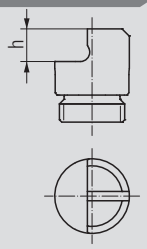
Order no. 6921884036841

Dimensions in mm	h	5,1

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

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

Clamping insert, smooth

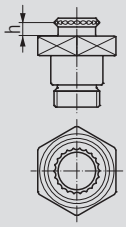


Order no. 6921884037000

Dimensions in mm	h	7

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

Gripper stud, round



Order no. 6921884038000

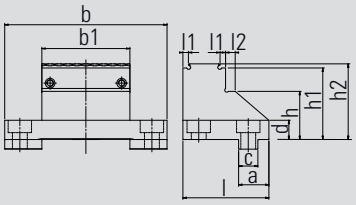
Dimensions in mm	h	4

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

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

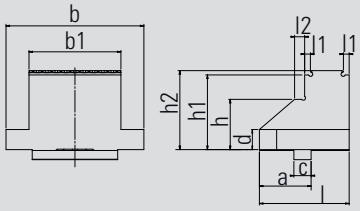
Jaw 64 mm, with integrated gripper row

Order no. fixed:
6921884034031



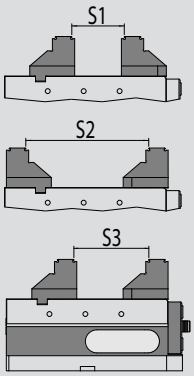
Jaw width		125
Dimensions in mm	a	22
	b	118
	b1	64
	c	14
	d	14
	h	35
	h1	52
	h2	55
	l	62,5
	l1	4
	l2	7

Order no. movable:
6921534036031



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

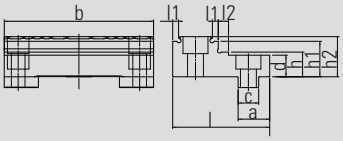
- For rectangular workpieces (sawn material) ≤ 0.5 mm
- Rigid design to prevent vibrations when parts are clamped upright
- Additional clamping surfaces, ground on both sides
- For five-sided machining, ensuring best possible accessibility to the workpiece
- Positive locking through penetration of the centres into the material
- Minimal lost clamping margin of approx. 3 mm.
- Suitable for material strength of up to 1000 N/mm²



Clamping range S1	11 - 72
Clamping range S2	93 - 170
Clamping range S3	51 - 106

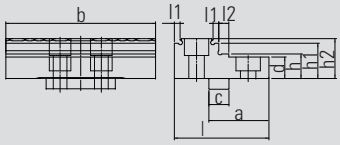
Gripper jaw with integrated gripper row

Order no. fixed:
6921884034931



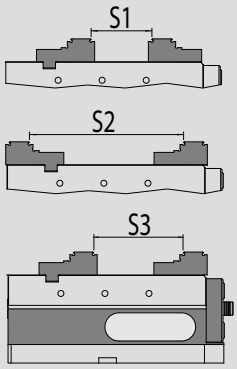
Jaw width		125
Dimensions in mm	a	21,5
	b	118
	c	14
	d	14
	h	16
	h1	23
	h2	26
	l	66
	l1	4
	l2	7

Order no. movable:
6921534036931



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

- For rectangular workpieces (sawn material) ≤ 0.5 mm
- Rigid design to prevent vibrations when parts are clamped upright
- Additional clamping surfaces, ground on both sides
- For five-sided machining, ensuring best possible accessibility to the workpiece
- Positive locking through penetration of the centres into the material
- Minimal lost clamping margin of approx. 4 mm.
- Suitable for material strength of up to 1000 N/mm²



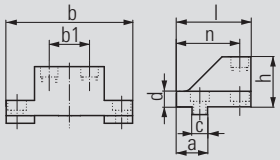
Clamping range S1	11 - 68
Clamping range S2	95 - 172
Clamping range S3	44 - 102

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

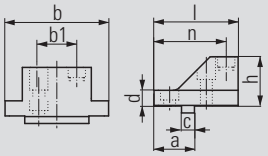
Reduced-width jaws, 64 mm

Please order gripper studs separately.

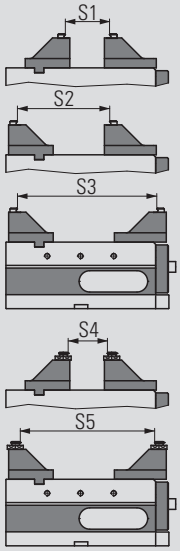
Order no. fixed:
6921884040140



Order no. movable:
6921884040040



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



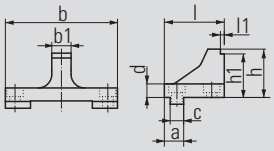
Jaw width		125
Dimensions in mm	a	28
	b	116
	b1	37
	c	14
	d	14
	h	45
	l	67
	n	56

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

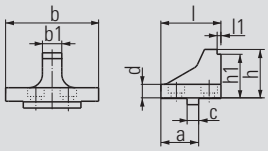
Clamping range S1	19 – 67
Clamping range S2	61 – 137
Clamping range S3	128 – 208
Clamping range S4	15 – 59
Clamping range S5	120 – 200

Reduced-width jaws, 20 mm

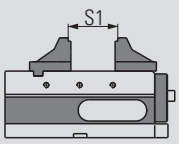
Order no. fixed:
6921884041141



Order no. movable:
6921884041041



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



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

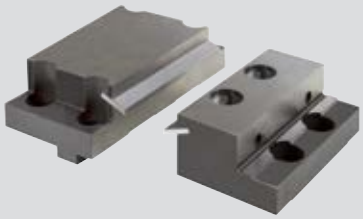
Jaw width		125
Dimensions in mm	a	39
	b	96
	b1	20
	c	12
	d	14
	h	50
	h1	45
	l	62
	l1	4

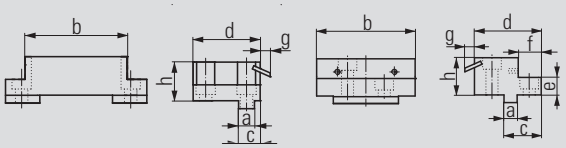
Clamping range S1	9 – 74

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

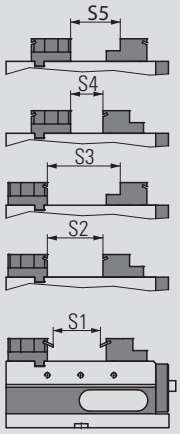
Universal pull-down jaws

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





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



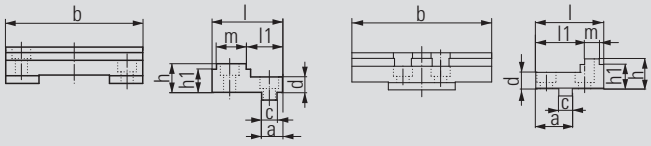
Jaw width		125
Dimensions in mm	a	14
	b	90
	c	19
	d	59
	g	8,8
	h	34

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

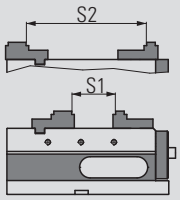
Clamping range S1	0 – 82
Clamping range S2	18 – 100
Clamping range S3	45 – 127
Clamping range S4	0 – 61
Clamping range S5	23 – 88

Step jaws HM - coated

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



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



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

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

Clamping range S1	8 – 66
Clamping range S2	68 – 182

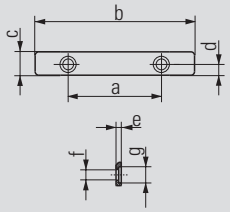
ALLMATIC GRIPP – mechanical / T-REX version (accessories)

Spring leaves (pair)

Order no. 6921884103031

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

Parallels (pair)



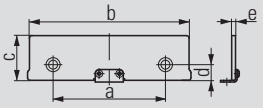
Order no. 6921475013031

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

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

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

Click parallels (pair)



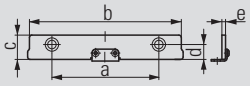
Order no. 6921175029042

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

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

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

Click parallels (pair)



Order no. 6921175016042

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

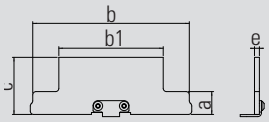
- For parallel raising of workpieces
- Hardened, ground and polished parallels

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

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

Click parallels (pair)

Order no. 6921535035042

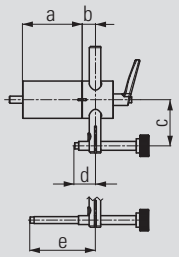


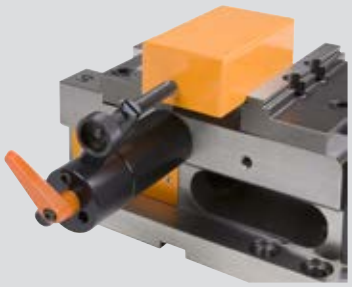
Jaw width		90
Dimensions in mm	a	14
	b	96
	b1	64
	c	35
	e	3

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

Workpiece stop

Order no. 6921285650144



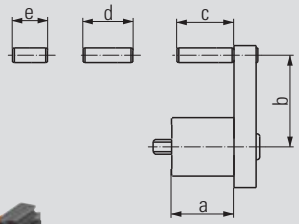


Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63,5
	e	53,5 – 113,5

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

Workpiece stop

Order no. 6921685670042

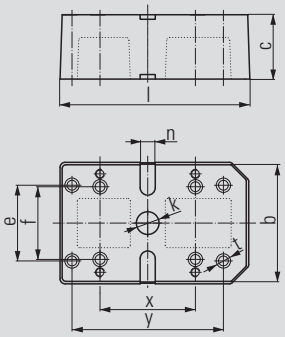


Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

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

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

Console



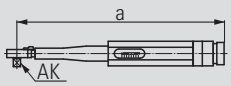
Order no. 6921885009042

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

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

Scope of supply:
- Console incl. fixing bolt
- 2 socket screw wrenches
- 4 bolts

Torque wrench



Order no. 0651114113188

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

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

Aligning and fixing set

Order no. – see table

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

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

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

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

ALLMATIC
Spannsysteme
Typ TITAN 2 - K

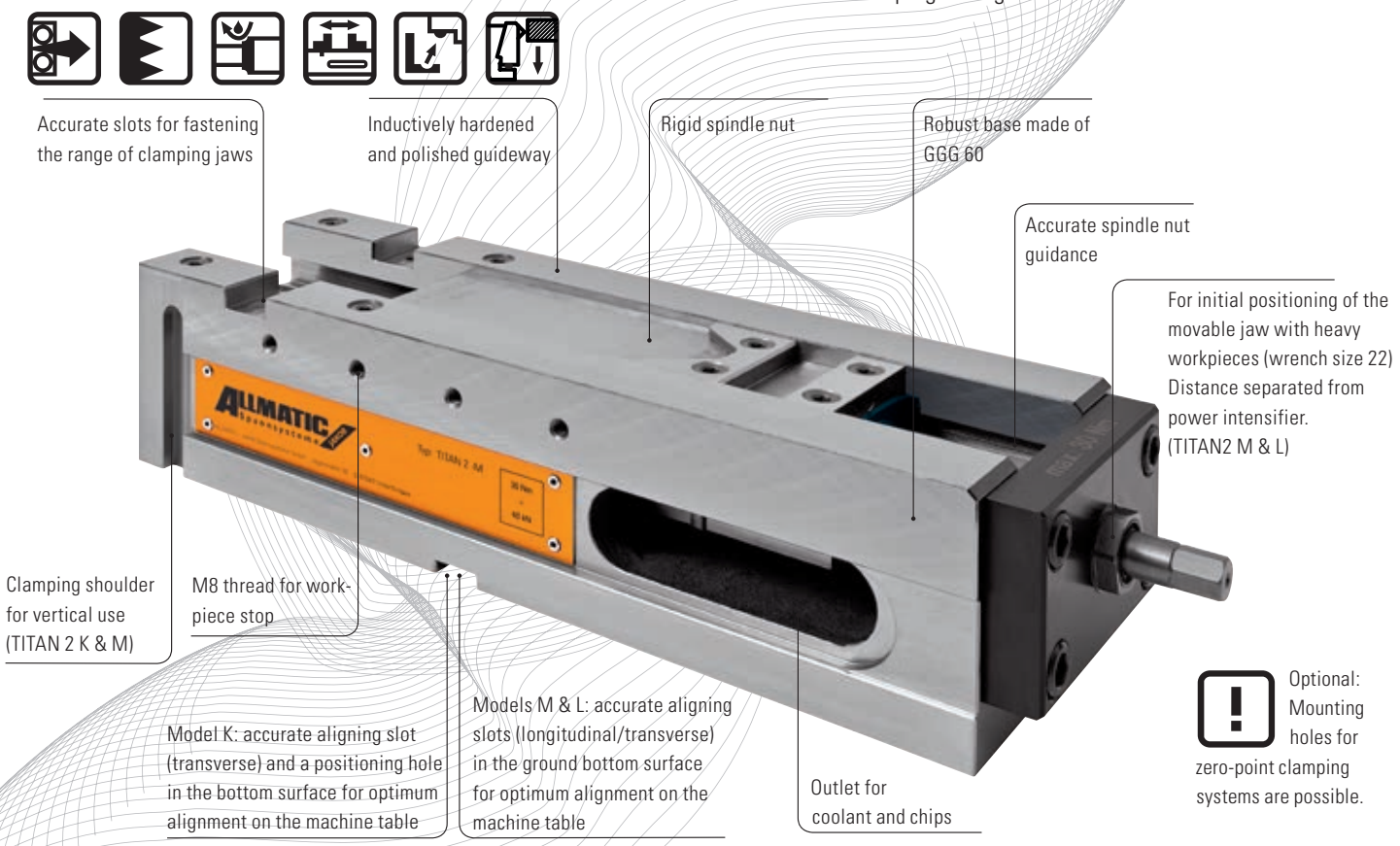
ALLMATIC GRIPP – MECHANICAL VERSION TITAN 2 K/M/L

Scope of application:

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

Product features:

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

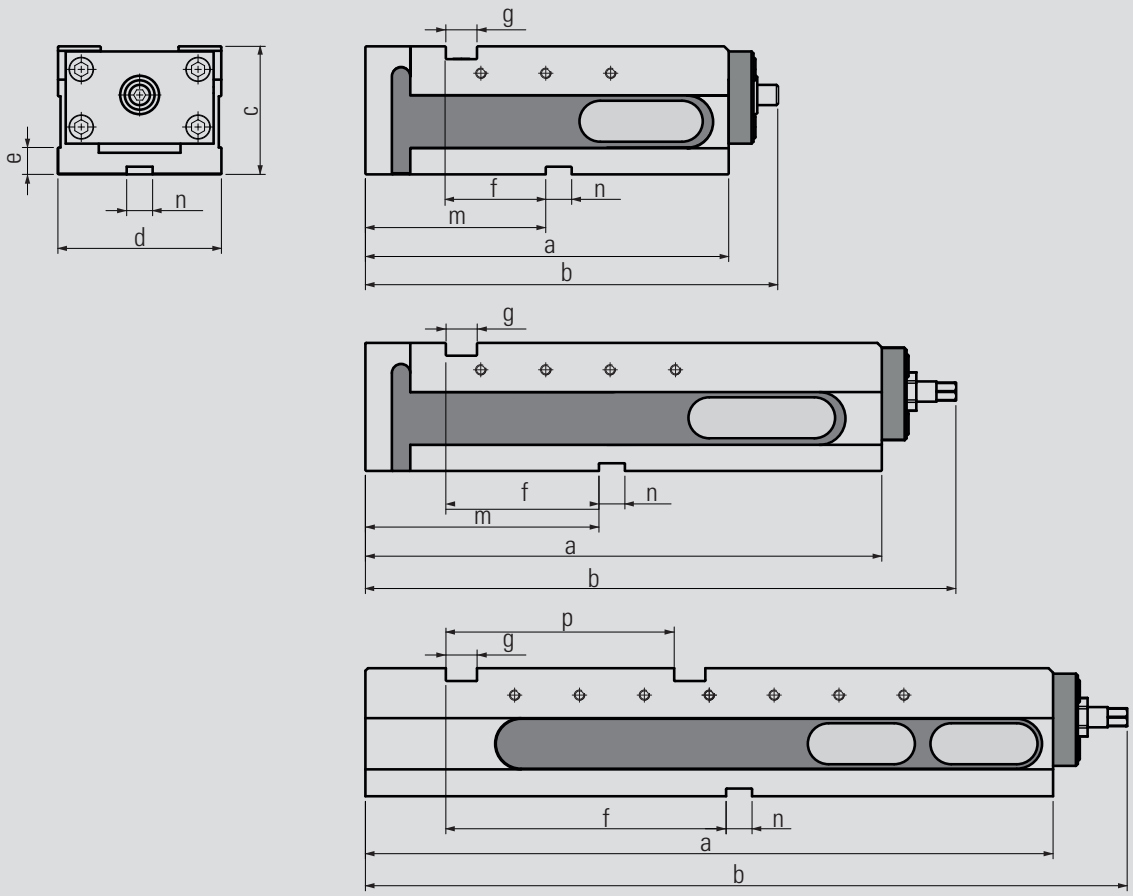


Order no. jaw width 125:
TITAN 2 K: 6921738000055
TITAN 2 M: 6921838000755
TITAN 2 L: 6921838000055

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

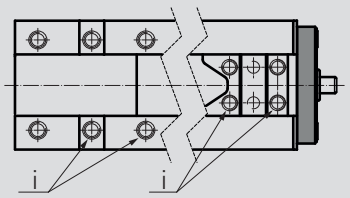
Scope of supply:

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



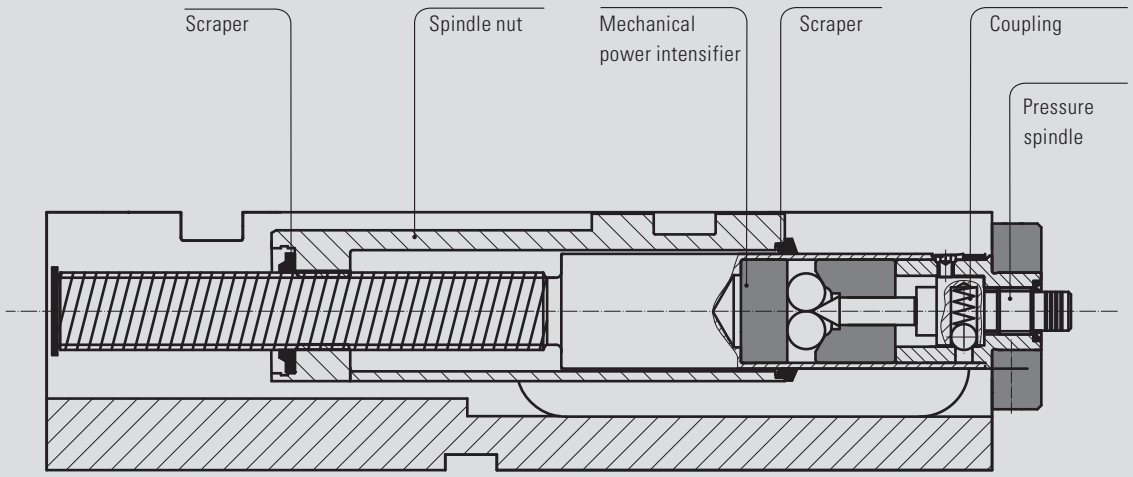
Technical data

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

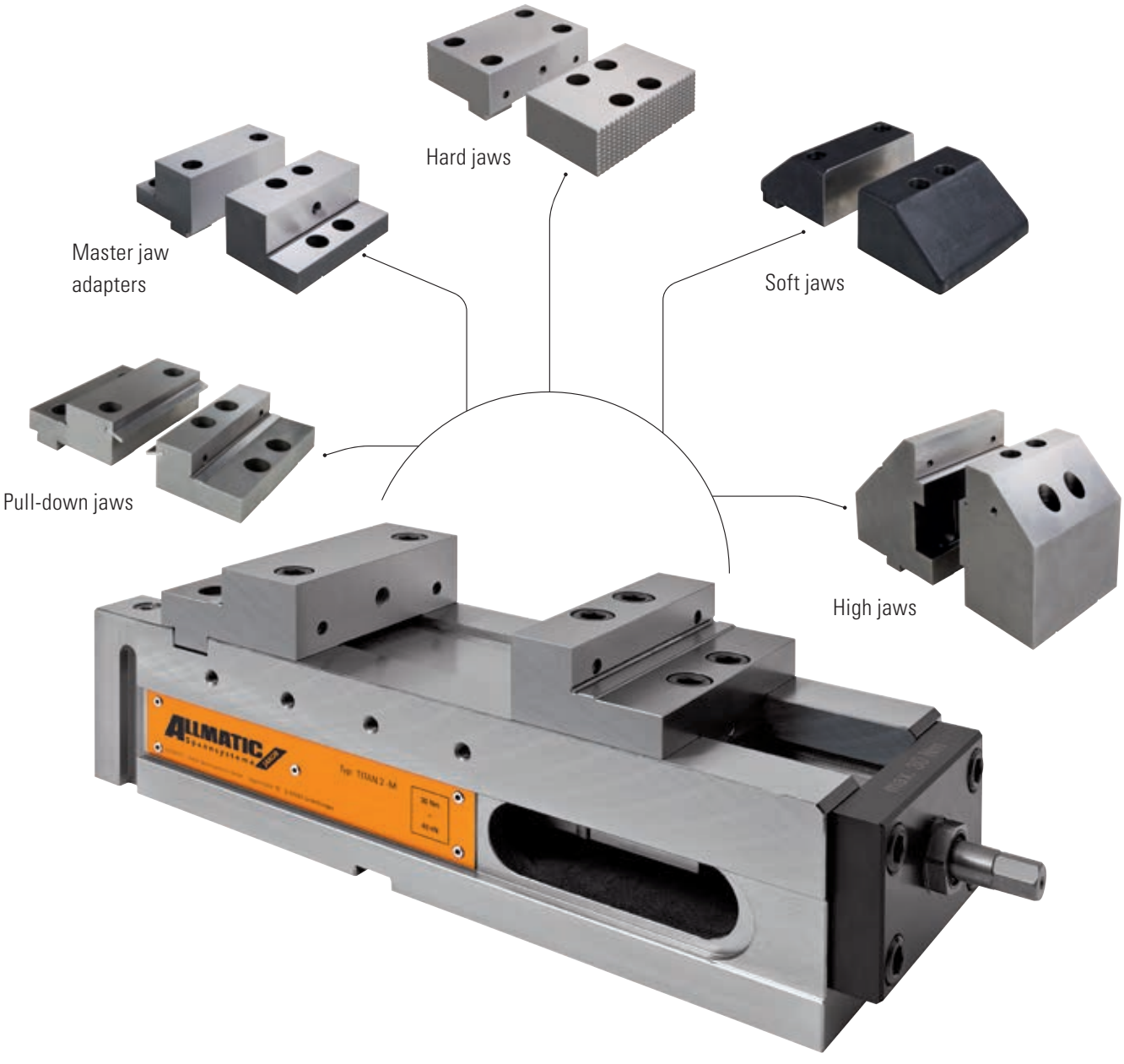


Jaw width	125
Max. torque in Nm	30
Max. clamping force in kN	40
Weight in kg TITAN 2 K	18
Weight in kg TITAN 2 M	30
Weight in kg TITAN 2 L	38

Spindle cross-section



TITAN 2 K/M/L
CONVENTIONAL CLAMPING



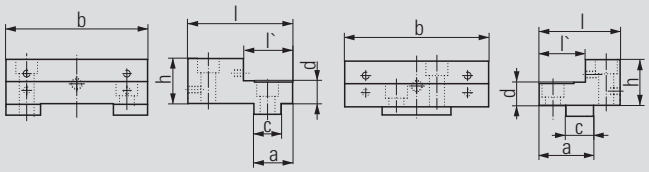
For conventional clamping of workpieces

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

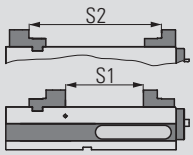
ALLMATIC GRIPP – mechanical / version TITAN 2 (conventional clamping accessories)

Step jaws

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



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



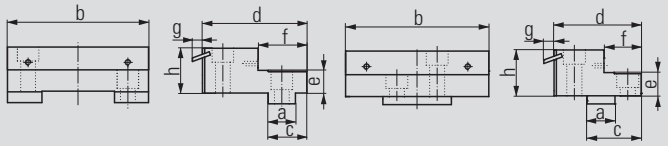
Jaw width		125
Dimensions in mm	a	34
	b	124,4
	c	24
	d	20
	h	39,5
	l	92
	l`	43

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

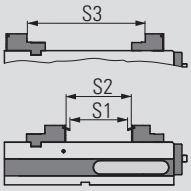
	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	0 – 62	0 – 182	0 – 312
Clamping width S2	85 – 193	131 – 313	88 – 443

Pull-down jaws

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



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



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

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

	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	0 – 42	0 – 157	0 – 291
Clamping width S2	0 – 56,5	0 – 175	0 – 306
Clamping width S3	77 – 185,5	125 – 303	77 – 435

Spring leaves (pair)

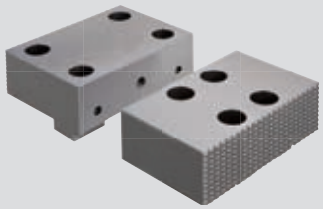
Order no. 6921684103031

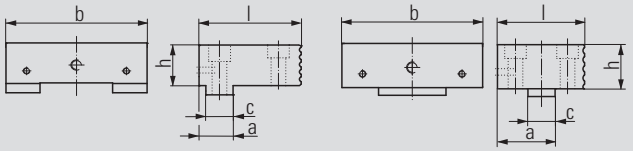
- Hardened spring leaves
- Spring leaves (replacement) for the pull-down jaws Order no.: 6921684106031 and 6921684102031

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

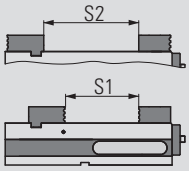
Hard base jaws

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





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



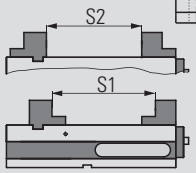
Jaw width		125
Dimensions in mm	a	30
	b	124.4
	c	24
	h	39.5
	l	88

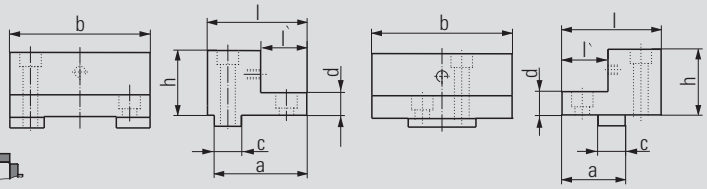
Jaw width		125
Dimensions in mm	a	50
	b	124.4
	c	24
	h	39.5
	l	76

	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	0 – 58	0 – 173	0 – 308
Clamping width S2	0 – 111	50 – 225	4 – 361

Master jaw adapters

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





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

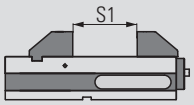
	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	66 – 126	71 – 243	66 – 376
Clamping width S2	0 – 107	47 – 224	0 – 357

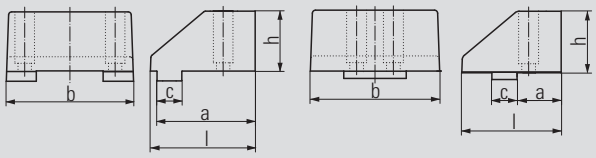
Jaw width		125
Dimensions in mm	a	77
	b	126
	c	24
	d	20
	h	58
	l	85
	l`	32

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

Soft jaws

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





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

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

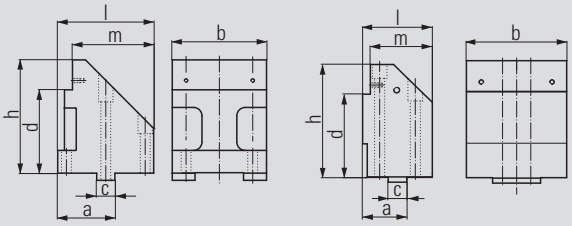
Jaw width		125
Dimensions in mm	a	42
	b	124
	c	24
	h	58
	l	94.5

	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	0 – 30	0 – 150	0 – 280

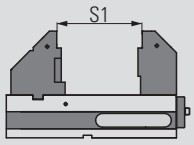
ALLMATIC GRIPP – mechanical / version TITAN 2 (conventional clamping accessories)

High jaws

Order no. fixed: 6921684047031 Order no. movable: 6921684048031



- Material: hardened steel
- Particularly suitable for five-side machining
- Better accessibility for tools
- Ground clamping surfaces
- Additional thread for parallels



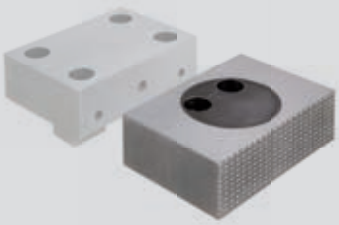
Jaw width		125
Dimensions in mm	a	75.5
	b	124.4
	c	24
	d	110
	h	149.5
	l	126.7
	m	107.2

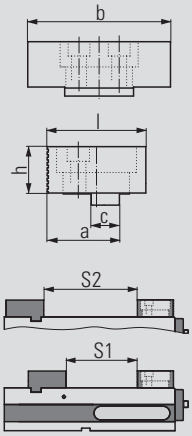
Jaw width		125
Dimensions in mm	a	57
	b	124.4
	c	24
	d	110
	h	149.5
	l	90
	m	80

	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	26 – 88	26 – 208	26 – 338

Pivot jaw, movable

Order no. 6921684020042





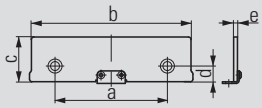
- Material: Hardened steel
- With click system
- One side smooth and ground, one side serrated
- 360° rotatable
- Picture with hard base jaw (see order no.: 6921684005731)

Jaw width		125
Dimensions in mm	a	62
	b	124.4
	c	24
	h	39.5
	l	84

	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	0 – 45	0 – 161	0 – 296
Clamping width S2	0 – 99	38 – 213	0 – 349

Click parallels (pair)

Order no. 6921185035042



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

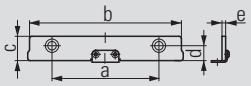
- For parallel raising of workpieces
- Hardened and ground parallels

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

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

Click parallels (pair)

Order no. 6921185020042

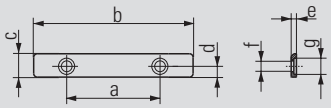


Jaw width		125
Dimensions in mm	a	88
	b	125
	c -0.01	20
	d	12.25
	e	3

- For parallel raising of workpieces
- Hardened and ground parallels
- Parallels with click system or screw-on
- For the high side of the jaws

Parallels (pair)

Order no. 6921485015031

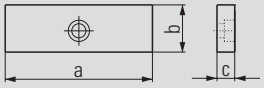


Jaw width		125
Dimensions in mm	a	88
	b	124
	c	15
	d	6
	e	3
	f	dia. 6
	g	dia. 9

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

Smooth jaws (pair)

Order no. 6921024022031



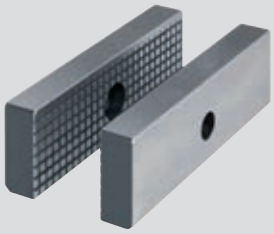
Jaw width		125
Dimensions in mm	a	125
	b	40
	c	15

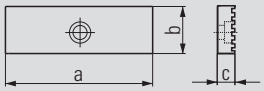
- Material: hardened steel
- For parts with delicate clamping surfaces
- Please order fastening bolts separately (order no. 6921011023000)

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

Serrated jaws (pair)

Order no. 6921021005031



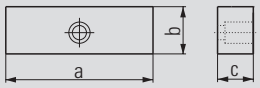


Jaw width		125
Dimensions in mm	a	125
	b	40
	c	15

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

Soft jaws (pair)

Order no. 6921024023031

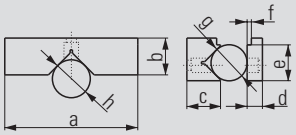


Jaw width		125
Dimensions in mm	a	125
	b	40
	c	25

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

Prismatic jaws (set)

Order no. 6921024024031

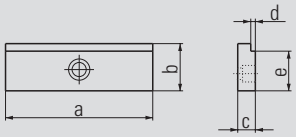


Jaw width		125
Dimensions in mm	a	125
	b	40
	c	35
	d	15
	e	35
	f	3
	g	dia. 12–28
	h	dia. 18–55

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

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

Step jaws (pair)

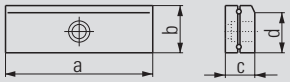


Order no. 6921024025031

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

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

Roller pull-down jaws (pair)

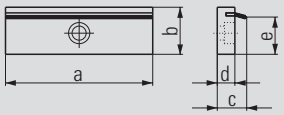


Order no. 6921024005131

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

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

Spring leaf pull-down jaws (pair)



Order no. 6921024001042

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

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

Spring leaves (pair)

Order no. 6921024002131

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

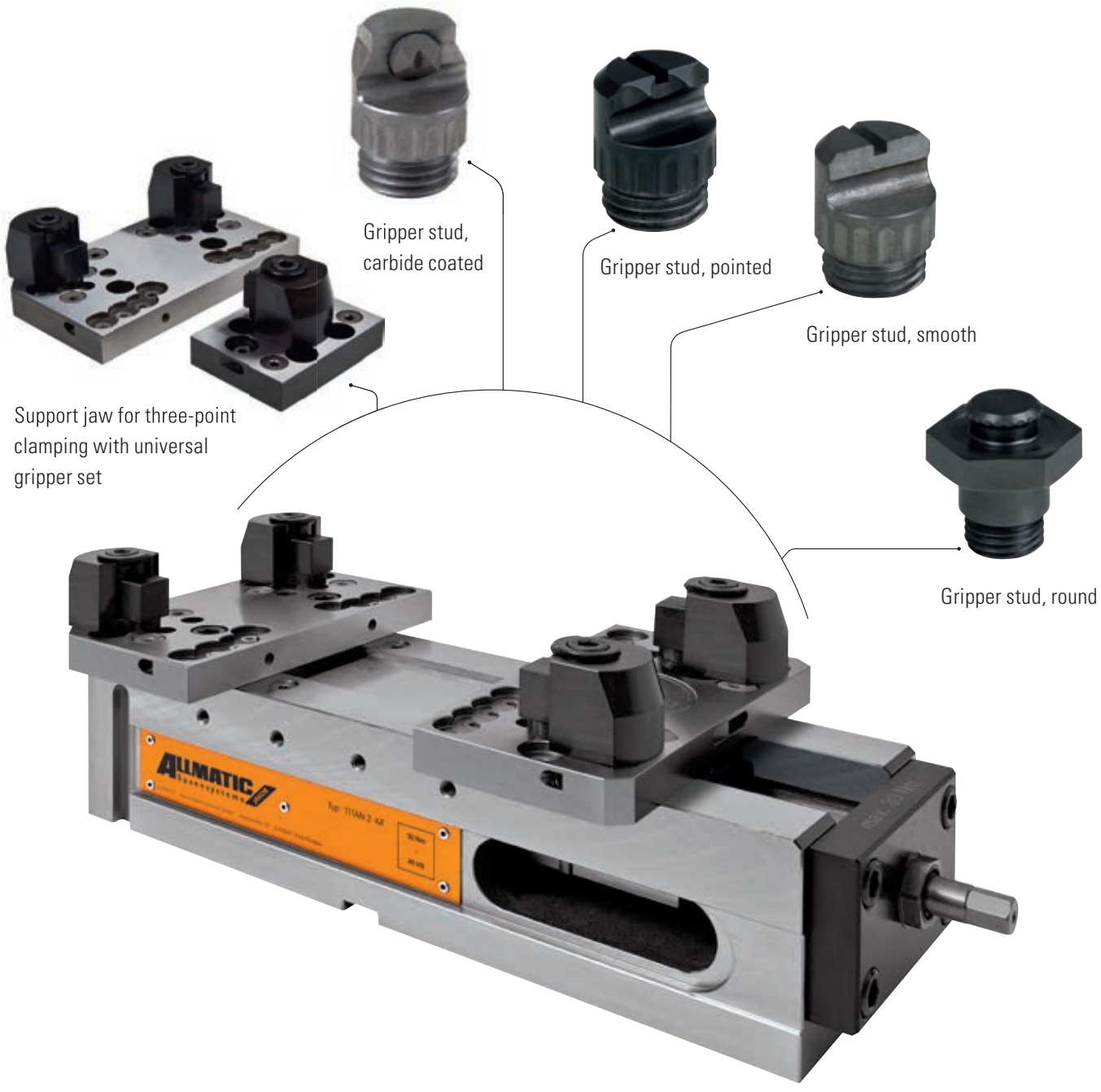
Jaw fixing screw

Order no. 6921011023000

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

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

TITAN 2 K/M/L
GRIPP CLAMPING



For clamping complex unmachined parts

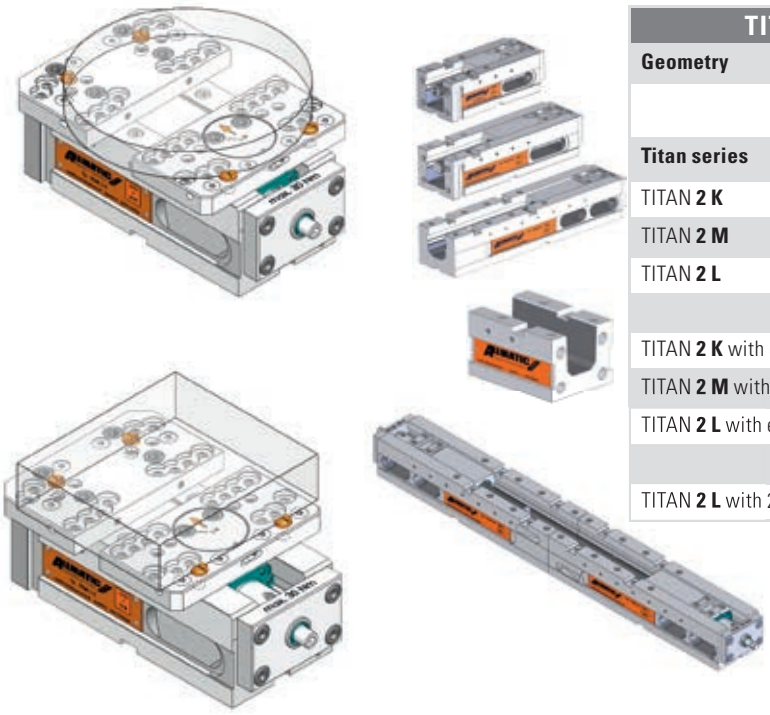
The support jaws enable you to clamp different unmachined parts quickly and securely. You will find jaws for gripper clamping on the following pages.

GRIPP clamping

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

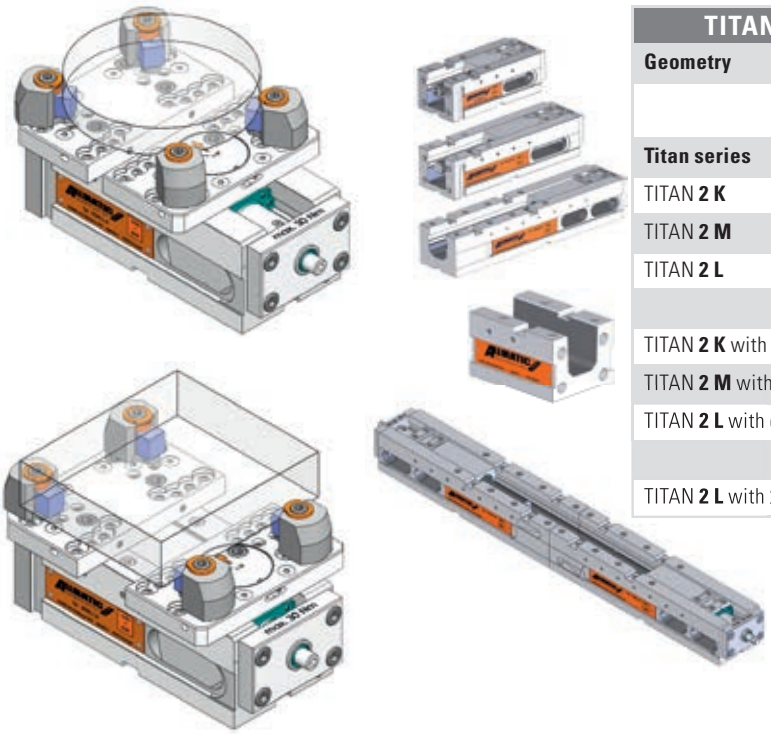
CLAMPING WIDTHS – GRIPP CLAMPING

Support jaws with gripper studs



TITAN 2 – Support jaws with gripper studs					
Geometry	**Rectangular workpiece**			**Round workpiece**	
	Clamping range (in mm)		**Clamping width (in mm)**	**Clamping range (in mm)**	
Titan series	**min.**	**max.**	**min.**	**min.**	**max.**
TITAN **2 K**	28	202	70	dia. 70	dia. 240
TITAN **2 M**	28	320	70	dia. 70	dia. 330
TITAN **2 L**	28	452	70	dia. 70	dia. 330
TITAN **2 K** with extension	-	417	70	-	dia. 330
TITAN **2 M** with extension	-	535	70	-	dia. 330
TITAN **2 L** with extension	-	667	70	-	dia. 330
TITAN **2 L** with 2nd vice base	-	1037	70	-	-

Support jaws with universal gripper set



TITAN 2 – Support jaw with universal gripper set					
Geometry	**Square workpiece**			**Round workpiece**	
	Clamping range (in mm)		**Clamping width (in mm)**	**Clamping range (in mm)**	
Titan series	**min.**	**max.**	**min.**	**min.**	**max.**
TITAN **2 K**	25	192	80	dia. 70	dia. 230
TITAN **2 M**	25	310	80	dia. 70	dia. 330
TITAN **2 L**	25	442	80	dia. 70	dia. 330
TITAN **2 K** with extension	-	371	80	-	dia. 330
TITAN **2 M** with extension	-	489	80	-	dia. 330
TITAN **2 L** with extension	-	621	80	-	dia. 330
TITAN **2 L** with 2nd vice base	-	976	80	-	-

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

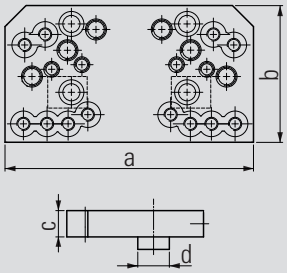
Support jaws

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

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

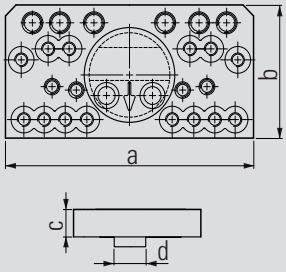
You will find dimensions of the individual gripper items and the gripper studs at www.allmatic.de

Order no. fixed:
6921734005842



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

Order no. movable, pivoting:
6921734072842



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

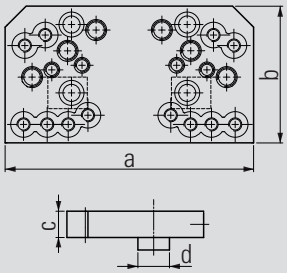
Please order universal gripper set or gripper studs separately

Support jaws

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

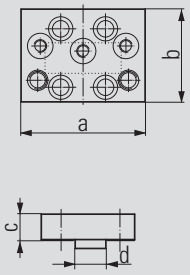
You will find dimensions of the individual gripper items and the gripper studs at www.allmatic.de

Order no. fixed:
6921734005842



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

Order no. movable, rigid:
6921884004842



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

Please order universal gripper set or gripper studs separately

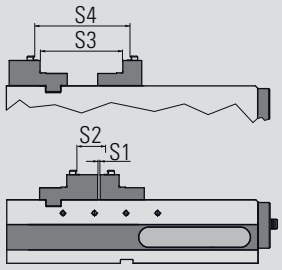
ALLMATIC GRIPP – mechanical / version TITAN 2 (GRIPP clamping accessories)

Step jaws for gripper studs

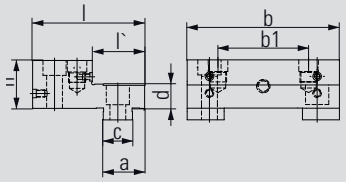
- Material: Hardened steel
- High and stepped sides with thread for parallels
- Ground clamping surfaces
- Additional thread on the high side for mounting the HD jaws (Typ 125 – 200)
- Suitable for screw-in gripper studs
- First and second clamping steps are possible without changing jaws
- Click system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

Note: because the jaws have no pendulum,they are only suitable for rectangular workpieces (Saw cuts) // <= 0,5 (Parallelism less than equal 0.5 mm) respectively cylindrical workpieces O <= 0,5 (unitless than equal 0.5)

Please order gripper studs separately

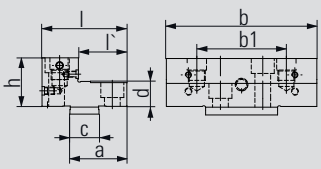


Order no. fixed:
6921884051031



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

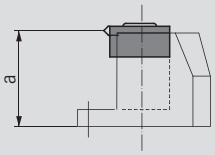
Order no. movable :
6921884050031

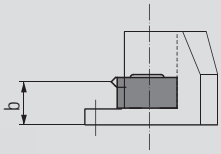


Jaw width		125
Dimensions in mm	a	47
	b	124,4
	b1	74
	c	24
	d	20
	h	39,5
	l	70
	l`	40

	TITAN 2 K	TITAN 2 M	TITAN 2 L
Clamping width S1	0 – 64	0 – 182	0 – 314
Clamping width S2	52 - 106	52 - 224	52 - 356
Clamping width S2 round workpiece	Ø 88-220	Ø 88-220	Ø 88-220
Clamping width S3	78 - 106	131 - 313	131 - 445
Clamping width S4	107 - 214	160 - 332	160 - 464

Universal gripper set





Order no. 6921884027031

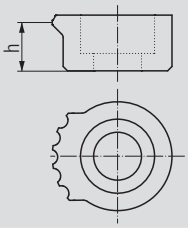
Jaw width		125
Dimensions in mm	a	40
	b	18

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

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

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

Gripper stud

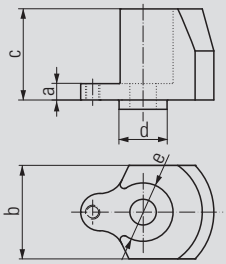


Order no. 6921884026000

Dimensions in mm	h	11

- Gripper stud for universal gripper set

Gripper stud mount

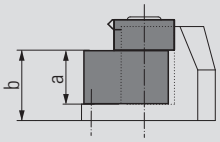


Order no. 6921884027000

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

- Mounting for gripper stud 2306/001

Support

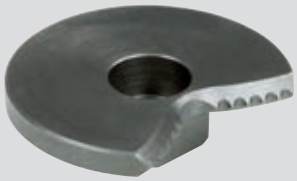


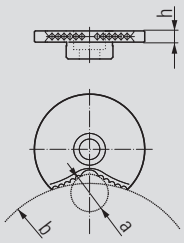
Order no. 6921884028000

Dimensions in mm	a	22
	b	29

- Support for universal gripper set

Prismatic gripper



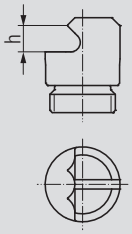


Order no. 6921884029031

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

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

Gripper stud, pointed



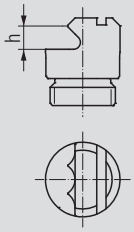
Order no. 6921884036000

Dimensions in mm	h	5.5

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

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

Gripper stud, low

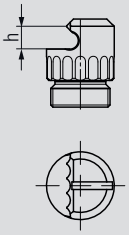


Order no. 6921884036100

Dimensions in mm	h	5

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

Clamping insert, four-point

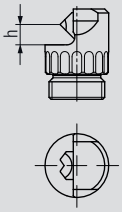


Order no. 6921884036500

Dimensions in mm	h	5.4

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

Gripper stud, carbide coated

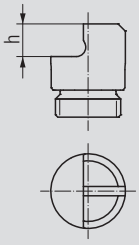


Order no. 6921884036841

Dimensions in mm	h	5.1

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

Clamping insert, smooth

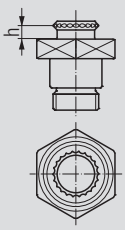


Order no. 6921884037000

Dimensions in mm	h	7

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

Gripper stud, round

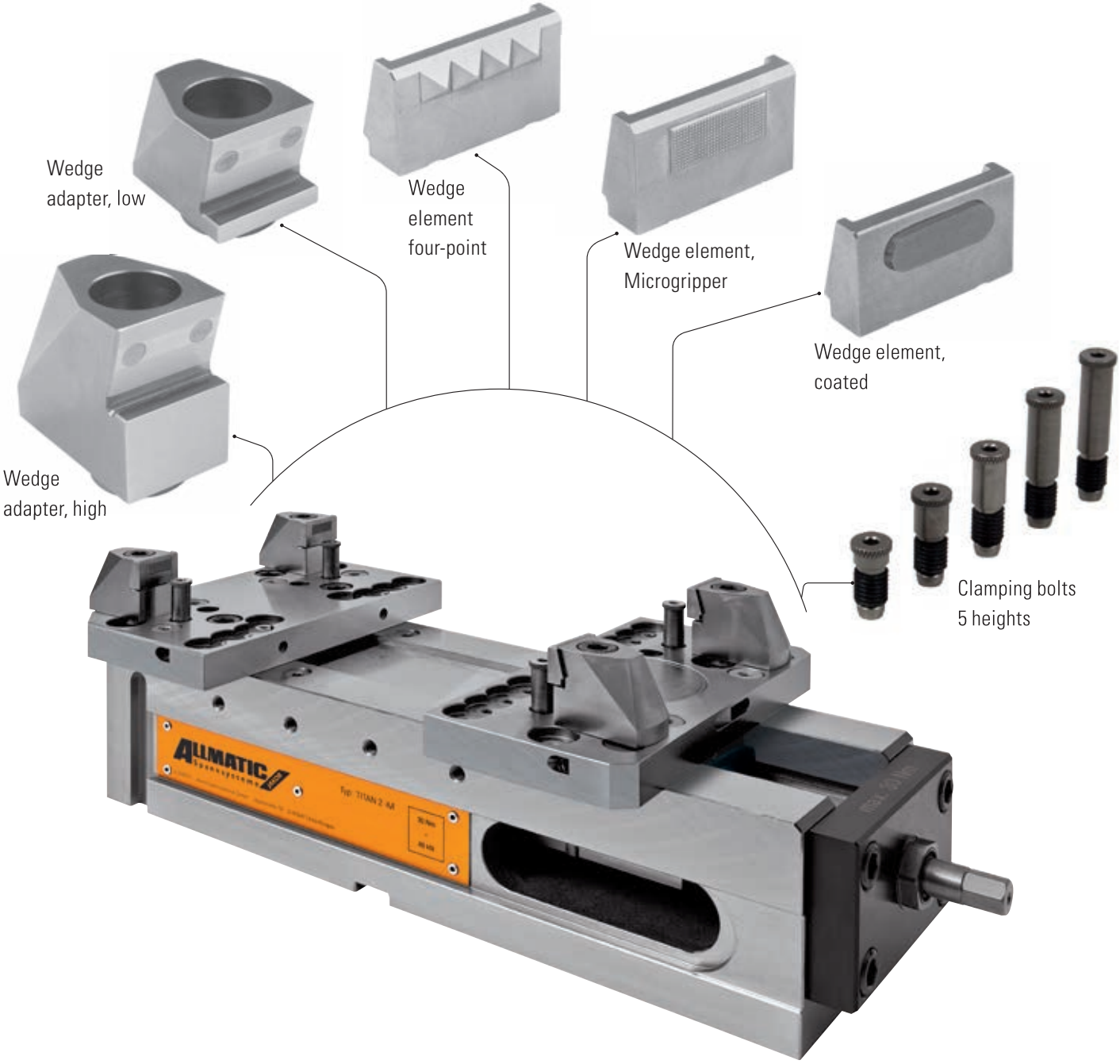


Order no. 6921884038000

Dimensions in mm	h	4

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

TITAN 2 K/M/L
PULL-DOWN CLAMPING



Accuracy through pull-down

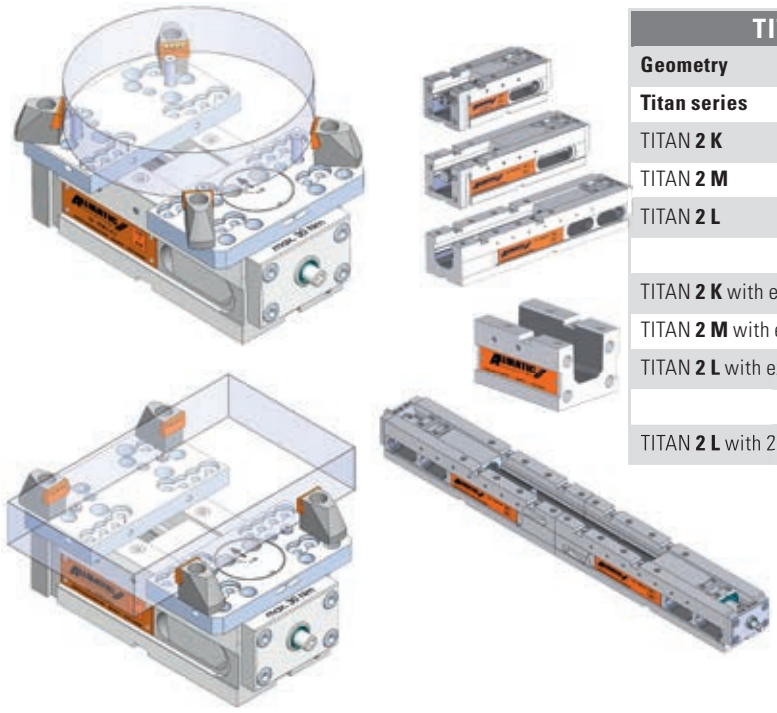
The support jaws and the pull-down system ensure accurate, versatile and secure clamping of the unmachined parts. The workpiece is positioned on ground clamping bolts which make the connection to the guideway. In this way, the parallelism of the guideway or of the machine table is transferred to the workpiece, thus achieving even greater clamping accuracy. Vibrations in the workpiece during machining are to a large extent avoided. The pull-down system can be found on the following pages.

Pull-down clamping:

- Support jaws are used to mount various wedge adapters and clamping bolts
- Wedge adapters can be bolted in various positions on the grid plate
- The various wedge elements can be changed quickly on the wedge adapters
- Additional pivot function of the support jaws compensates for non-parallel clamping surfaces and is required to clamp uneven workpieces
- Accuracy through pull-down
- Clamping in the neutral filament can be optimised using the 5 different heights of the clamping bolts

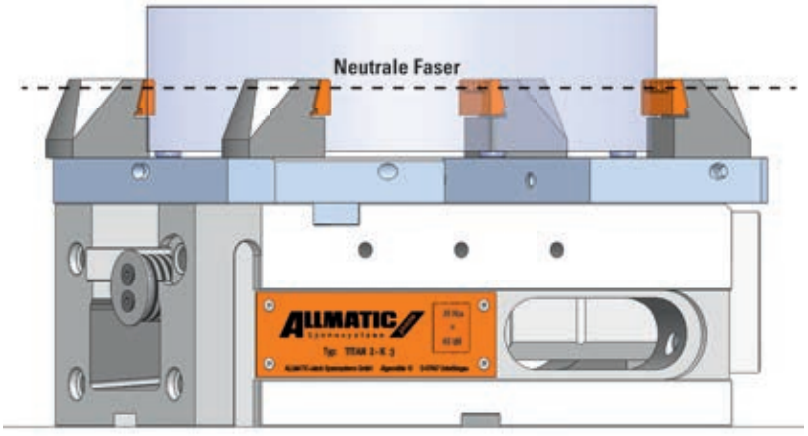
CLAMPING WIDTHS – PULL-DOWN CLAMPING

Support jaws with pull-down



TITAN 2 - Support jaws with pull-down				
Geometry	**Square workpiece**		**Round workpiece**	
Titan series	**min. [mm]**	**min. [mm]**	**min.**	**max.**
TITAN **2 K**	18	185	dia. 65	dia. 226
TITAN **2 M**	18	305	dia. 65	dia. 330
TITAN **2 L**	18	435	dia. 65	dia. 330
TITAN **2 K** with extension	-	365	-	dia. 330
TITAN **2 M** with extension	-	485	-	dia. 330
TITAN **2 L** with extension	-	615	-	dia. 330
TITAN **2 L** with 2nd vice base	-	970	-	-

Clamping in the neutral filament



ALLMATIC GRIPP – mechanical / version TITAN 2 (pull-down clamping accessories)

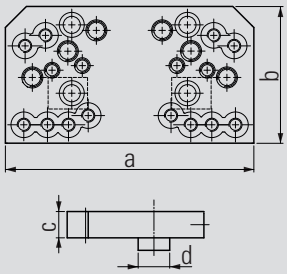
Support jaws

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

Pivot jaw:
- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- Supplied **without** clamping elements

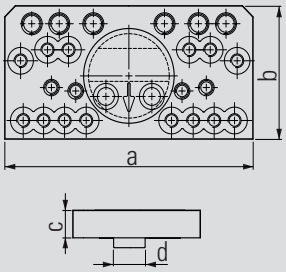
You will find dimensions of the individual gripper items and the gripper studs at www.allmatic.de

Order no. fixed:
6921734005842



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

Order no. movable, pivoting:
6921734072842

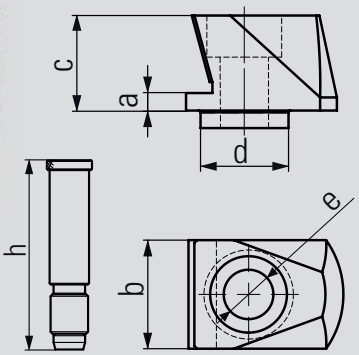


Jaw width		125
Dimensions in mm	a	189
	b	97
	c	20
	d	24

Please order universal gripper set, pull-down studs, or gripper studs separately

Pull-down set case, low

Order no. 6921734027031



Jaw width		125
Dimensions in mm	a	4
	b	24
	c	21.7
	d	dia. 20
	e	dia. 11
	h	23 / 34

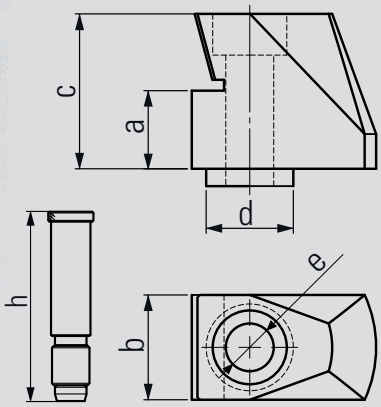
- Pull-down elements suitable for clamping and pulling down clamping surfaces that are unmachined or pre-machined onto the guideway or onto the supplied clamping bolts
- In this way, workpieces can be clamped almost exactly parallel to the guideway for machining
- The direct contact to the clamping bolts largely avoids vibrations in the workpiece

Pull-down set consisting of:

- 1 x foamed case
- 4 x wedge adapter, low
- 4 x bolts, M10 x 30 mm
- 4 x wedge element, 4 point
- 4 x wedge element Microgripper
- 4 x clamping bolts 23 mm
- 4 x clamping bolts 34 mm

ALLMATIC GRIPP – mechanical / version TITAN 2 (pull-down clamping accessories)

Pull-down set case, high



Order no. 6921734027131

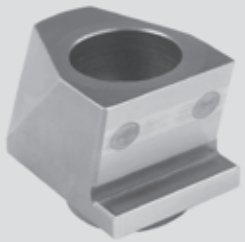
Jaw width		125
Dimensions in mm	a	18
	b	24
	c	35.7
	d	dia. 20
	e	dia. 11
	h	34 / 48

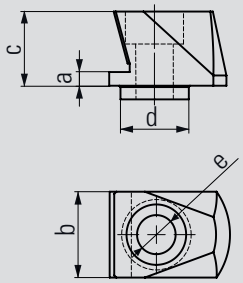
- Pull-down elements suitable for clamping and pulling down clamping surfaces that are unmachined or pre-machined onto the guideway or onto the supplied clamping bolts
- In this way workpieces can be clamped almost exactly parallel to the guideway for machining
- The direct contact to the clamping bolts largely avoids vibrations in the workpiece

Pull-down set consisting of:

- 1 x foamed case
- 4 x wedge adapter, high
- 4 x bolts, M10 x 45 mm
- 4 x wedge element, 4 point
- 4 x wedge element Microgripper
- 4 x clamping bolts 48 mm
- 4 x clamping bolts 34 mm

Wedge adapter, low



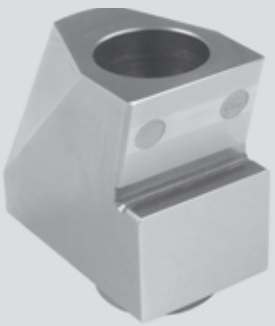


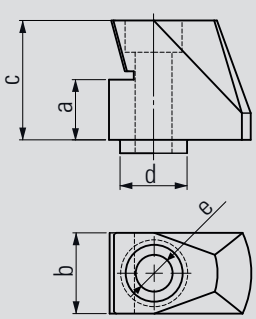
Order no. 6921834027041

Dimensions in mm	a	4
	b	24
	c	21.7
	d	dia. 20
	e	dia. 11

- Wedge adapter, low, for use on support jaws. For mounting the four-point, Microgripper, round and coated wedge elements supplied **without** M10 x 30 mm fastening bolt (see next page)

Wedge adapter, high





Order no. 6921834027141

Dimensions in mm	a	18
	b	24
	c	35.7
	d	dia. 20
	e	dia. 11

- Wedge adapter, high, for use on support jaws. For mounting the four-point, Microgripper, round and coated wedge elements supplied **without** M10 x 45 mm fastening bolt (see next page)

ALLMATIC GRIPP – mechanical / version TITAN 2 (pull-down clamping accessories)

Fastening bolt, low

Order no. 8006101030050

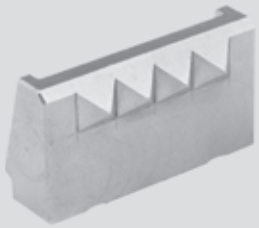
- For fastening the wedge adapter, low, on the support jaws
- M 10 X 30 mm

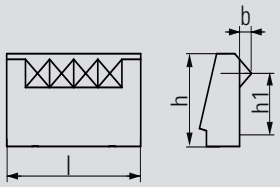
Fastening bolt, high

Order no. 8006101045050

- For fastening the wedge adapter, high, on the support jaws
- M 10 X 45 mm

Wedge element, four-point



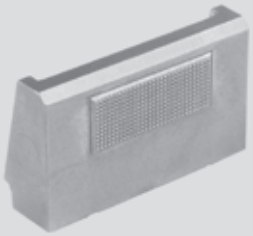


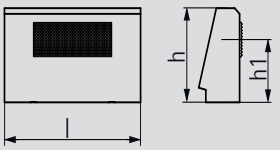
Order no. 6921834025040

Dimensions in mm		
	b	2.4
	h	16.5
	h1	13
	l	27.8

- Wedge elements for various shapes, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm

Wedge element, Microgripper



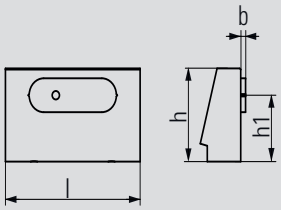


Order no. 6921834025140

Dimensions in mm		
	h	16.5
	h1	11
	l	27.8

- Wedge elements for various shapes, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm

Wedge element, coated



Order no. 6921834025240

Dimensions in mm		
	b	1
	h	16.5
	h1	11.75
	l	27.8

- Wedge elements for pre-machined, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm
- Please order the pads separately (see below)

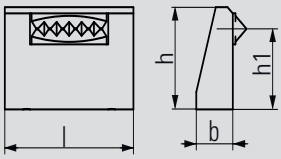
Blister-pads, diamond-coated

Order no. 6921834028141

- Diamond-coated pads for secure clamping of machined surfaces without a visible impression
- Blister contents: 20 pads

ALLMATIC GRIPP – mechanical / version TITAN 2 (pull-down clamping accessories)

Wedge element, round



Order no. 6921834026340

Dimensions in mm		
	b	2.4
	h	16.5
	h1	13
	l	27.8

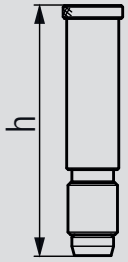
- Wedge elements for round shapes or radii, irrespective of surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm

Clamping bolts

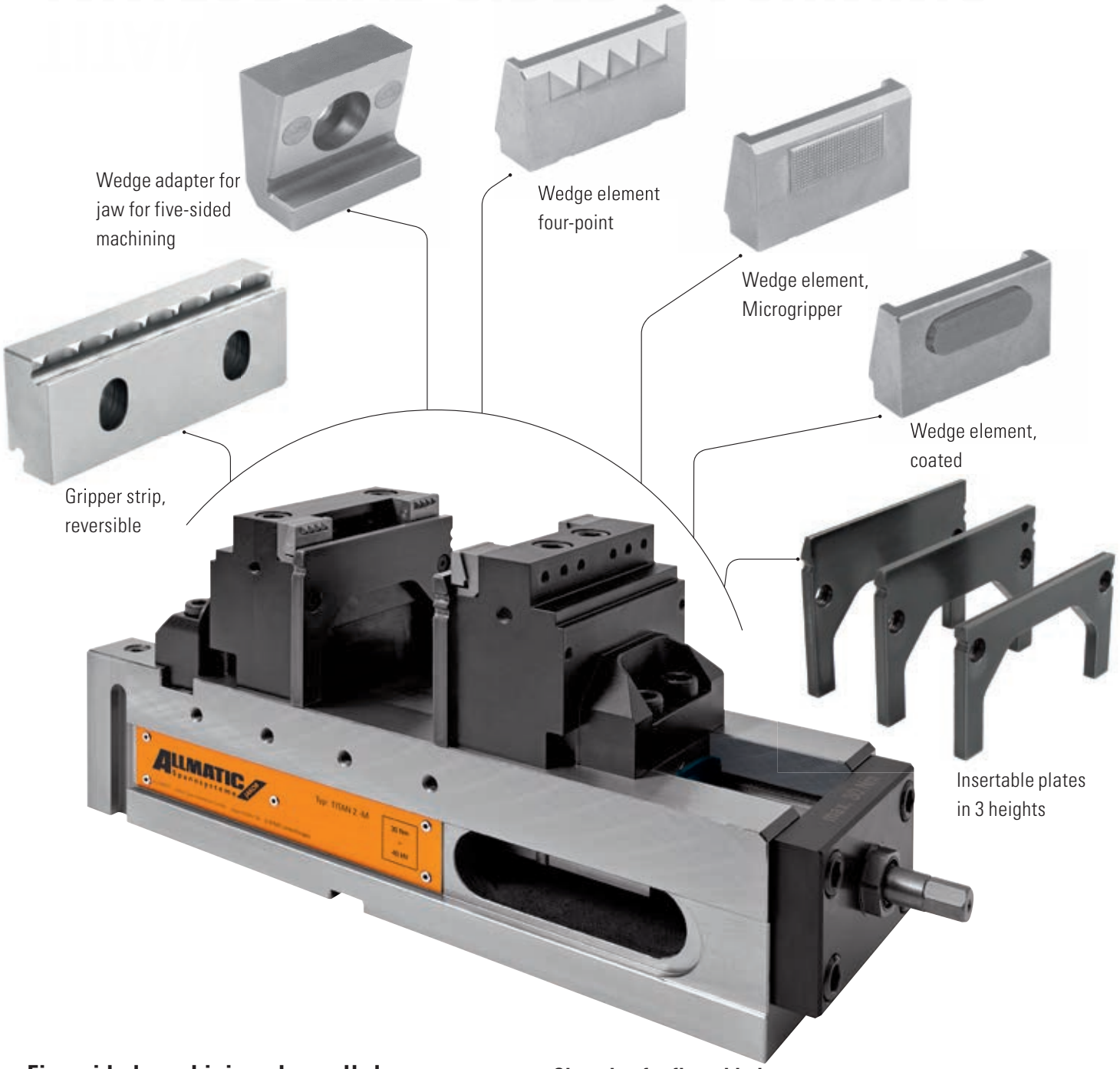
See table for order nos.

6921735048040	
h	48
6921735043040	
h	43
6921735034040	
h	34
6921735029040	
h	29
6921735023040	
h	23

- Five support heights
- For levelling the workpiece on the guideway
- Material: hardened steel
- Ground to high accuracy



TITAN 2 K/M/L
JAW FOR FIVE-SIDED MACHINING



Five-sided machining plus pull-down

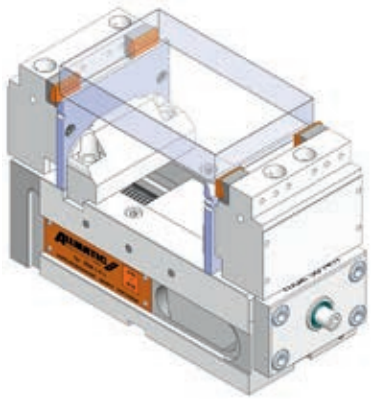
The five-sided machining jaw with pull-down can clamp workpieces up to a height of 90 mm onto the guideway of the TITAN 2. The insertable plates are pressed onto the guideway using the pull-down effect, thus establishing an accurate parallel workpiece position. This largely avoids any vibration of the workpiece during machining. Accessibility with short tools is a particular advantage of the five-sided machining jaw. You will find jaws for five-sided machining on the following pages.

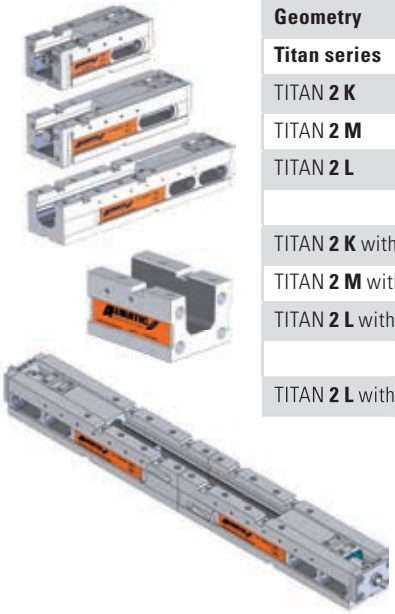
Clamping for five-sided machining:

- Five-sided machining jaws are used to mount the wedge adapters and the insertable plates
- Wedge adapters can be bolted in various positions on the grid plate
- The various wedge elements can be quickly changed on the wedge adapters
- Suitable for five-sided machining with short tools
- Accuracy through pull-down
- Stability through form-locking
- Clamping in the neutral filament can be optimised using the three support heights of the insertable plates

CLAMPING WIDTHS – JAW FOR FIVE-SIDED MACHINING

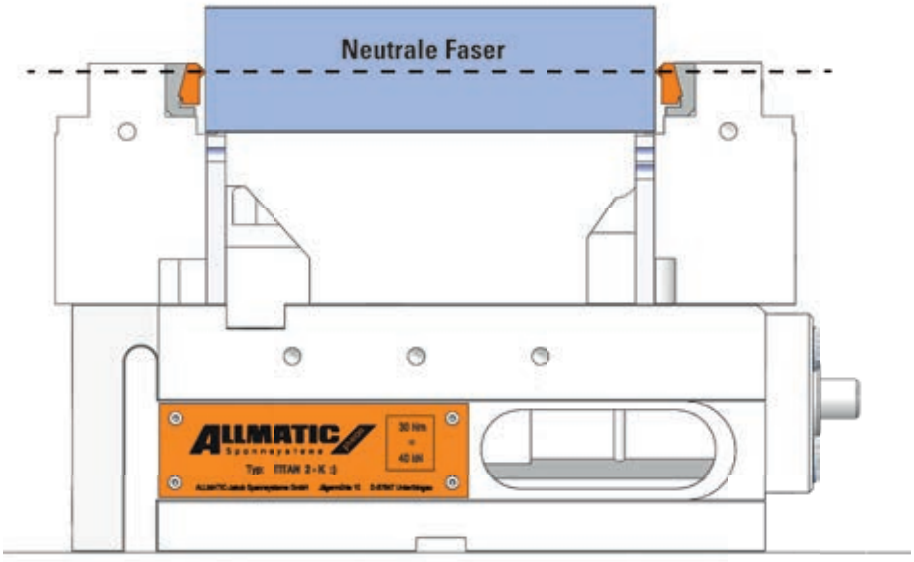
90-mm jaw for five-sided machining with pull-down





TITAN 2 – Jaw for five-sided machining with pull-down		
Geometry	**Square workpiece**	
Titan series	**min. [mm]**	**max. [mm]**
TITAN **2 K**	18	180
TITAN **2 M**	18	300
TITAN **2 L**	18	430
TITAN **2 K** with extension	-	380
TITAN **2 M** with extension	-	480
TITAN **2 L** with extension	-	610
TITAN **2 L** with 2nd vice base	-	970

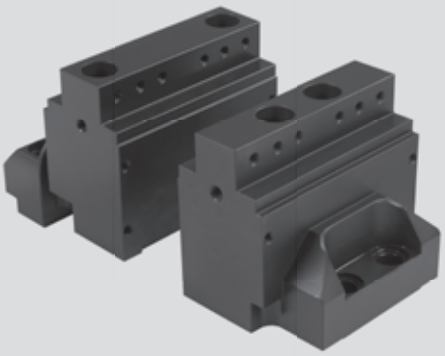
Clamping in the neutral filament



ALLMATIC GRIPP – mechanical / version TITAN 2 (five-sided machining jaws)

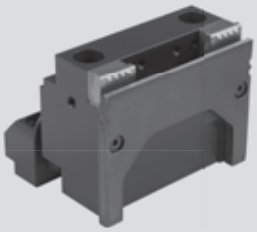
Jaws for five-sided machining

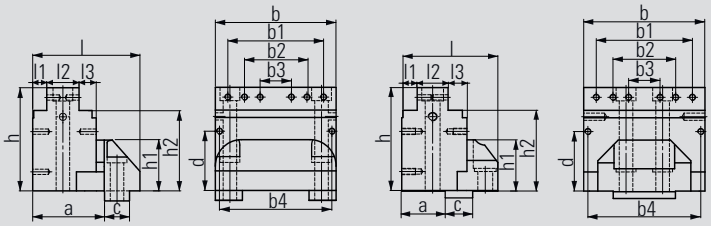
Order no. fixed: 6921734047031 Order no. movable: 6921734048031



- Material: plasma-nitrided steel
- Particularly suitable for five-side machining
- Better accessibility for tools
- Ground clamping surfaces
- Additional thread for parallels
- Accuracy through pull-down
- Stability through form-locking

Please order wedge elements and insertable plates separately





Jaw width		125
Dimensions in mm	a	69
	b	116
	b1	90
	b2	60
	b3	30
	b4	108
	c	24
	d	56
	h	97.5
	h1	48
	h2	76
	l	103
	l1	13.5
	l2	31
	l3	16.5

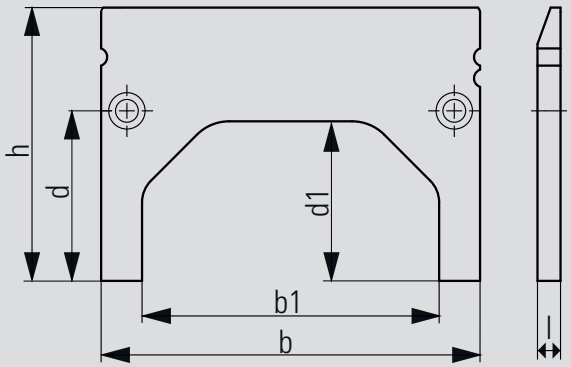
Jaw width		125
Dimensions in mm	a	38
	b	116
	b1	92
	b2	60
	b3	30
	b4	108
	c	24
	d	56
	h	97.5
	h1	48
	h2	76
	l	84
	l1	13.5
	l2	27
	l3	16.5

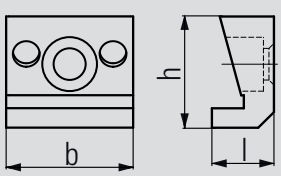
Case set for five-sided machining jaw

Order no. 6921734027531

Jaw width 125		Insertable plate	Wedge adapter
Dimensions in mm	b	125	24.15
	b1	98	-
	d	56	-
	d1	53	-
	h	**90**	21.45
	l	7.6	11.8

- Pull-down elements suitable for clamping and pulling unmachined clamping surfaces down onto the guideway or onto the 90-mm support plates supplied
- In this way workpieces can be clamped almost exactly parallel to the guideway for machining
- The direct contact to the support plates largely avoids vibrations in the workpiece



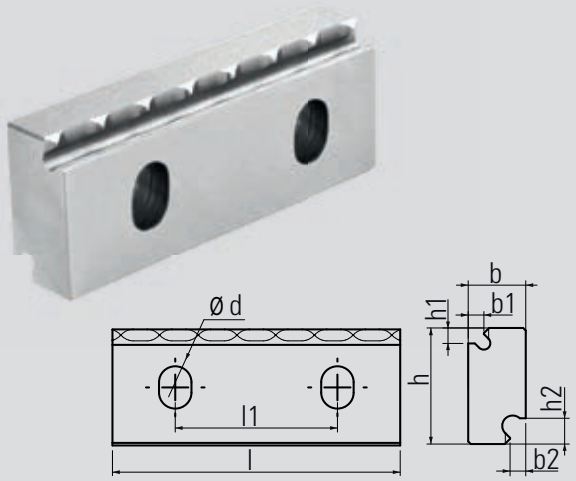


Pull-down set consisting of:

- 1 x foamed case
- 4 x wedge adapters
- 4 x wedge element, four-point
- 4 x wedge element, Microgripper
- 2 x insertable plates (H=90 mm)
- 20 x cheese-head screws M 6 x 8

ALLMATIC GRIPP – mechanical / version TITAN 2 (five-sided machining jaws)

Gripper strip, reversible

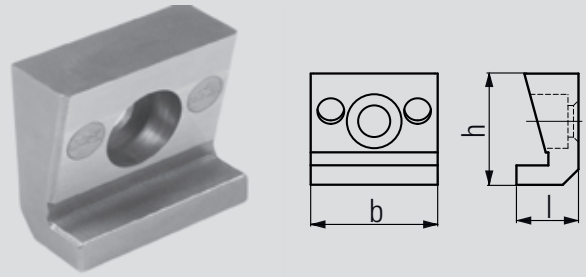


Order no. 6921734036031

Dimensions in mm	b	11
	b1	3
	b2	3
	d	6.2
	h	22.5
	h1	3
	h2	5
	l	55
	l1	311

- Gripper strip can be reversed for mounting on the five-sided machining jaw (4 of them are required)
- For clamping unmachined parts close to the edge, 3 or 5 mm
- Incl. 2 bolts M 6 x 16 each

Wedge adapter for jaw for five-sided machining

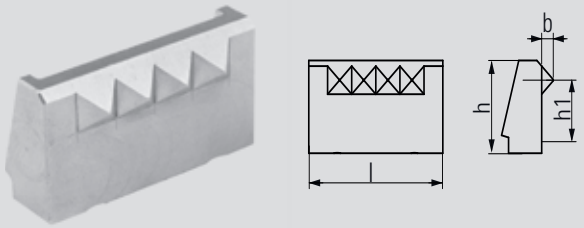


Order no. 6921834027540

Dimensions in mm	b	24.15
	h	21.45
	l	11.8

- Wedge adapter for use five-sided machining jaws. For mounting the 4-point, Microgripper, round and coated wedge elements
- Supplied **without** M6 x 8 mm fastening bolt (see next page)

Wedge element, four-point

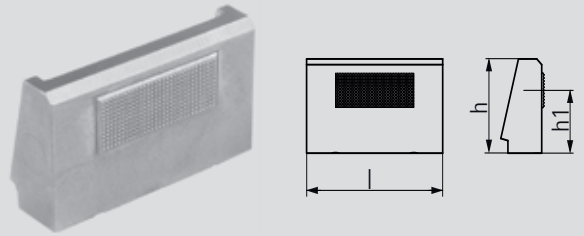


Order no. 6921834025040

Dimensions in mm	b	2.4
	h	16.5
	h1	13
	l	27.8

- Wedge elements for various shapes, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm

Wedge element, Microgripper



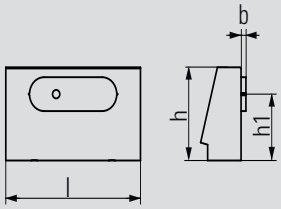
Order no. 6921834025140

Dimensions in mm	h	16.5
	h1	11
	l	27.8

- Wedge elements for various shapes, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm

ALLMATIC GRIPP – mechanical / version TITAN 2 (five-sided machining jaws)

Wedge element, coated



Order no. 6921834025240

Dimensions in mm		
	b	1
	h	16.5
	h1	11.75
	l	27.8

- Wedge elements for pre-machined, surface conditions and materials
- Quick to exchange
- Minimum clamping depth 8 mm
- Please order the pads separately (see below)

Pads, diamond-coated, in blister pack

Order no. 6921834028141

- Diamond-coated pads for secure clamping of machined surfaces without a visible impression
- Blister contents: 20 pads

Insertable plates

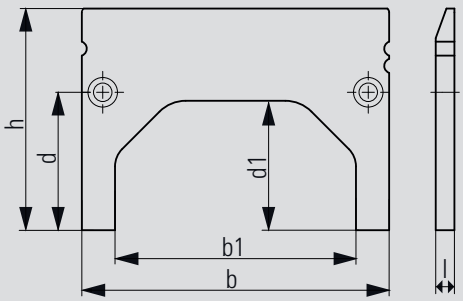
6921735655041	
h	**90**

6921735655141	
h	**85**

6921735655241	
h	**70**

See table for order nos.

Insertable plate height		90	85	70
Dimensions in mm	b	125		
	b1	98		
	d	56		
	d1	53		
	l	7.6		



- Three support heights
- For levelling the workpiece on the five-sided machining jaws
- Material: hardened steel
- Ground to high accuracy
- Supplied **without** M6 x 8 mm fastening bolt (see next page)

Fastening bolt for five-sided machining

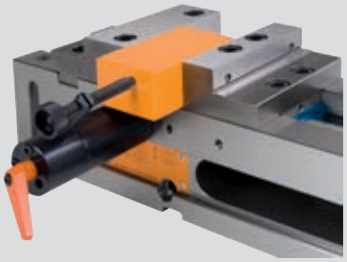
Order no. 8006300068800

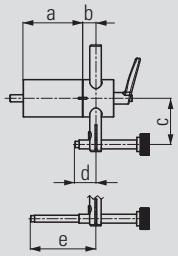
- For fastening the wedge adapters on the five-sided machining jaws
- For fastening the insertable plates on the five-sided machining jaws
- M 6 x 8 mm

ALLMATIC GRIPP – mechanical / version TITAN 2 (five-sided machining jaws)

ALLMATIC GRIPP – mechanical / version TITAN 2 (accessories)

Workpiece stop



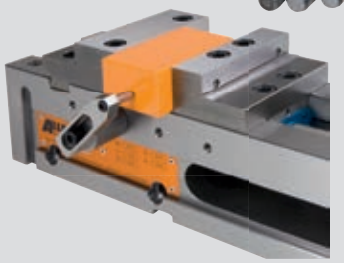


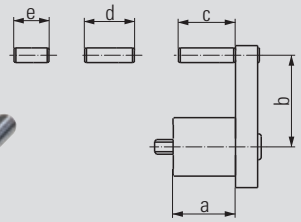
Order no. 6921285650144

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

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

Workpiece stop





Order no. 6921685670042

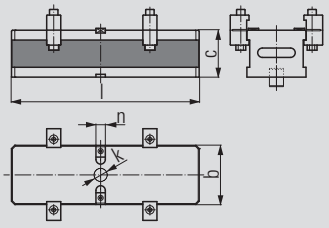
Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

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

XL console

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

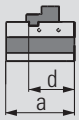
Order no. 6921885010042



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

ALLMATIC GRIPP – mechanical / version TITAN 2 (accessories)

Clamping width enlargement

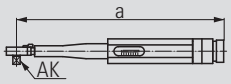


Order no. jaw width 125: 6921685008055

Jaw width		125
Dimensions in mm	a	176
	d	117

- For increasing the clamping width of the TITAN 2 K & M (optional L)
- Is attached to the end face of the TITAN 2 vice
- Clamping forces are not transmitted to the machine table
- Included: 1 pair of side clamps

Torque wrench



Order no. 0651114113188

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

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

Side clamps (pair)

Order no. 6921025000031

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

DUO side clamps

Order no. 6921285000031

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

Aligning and fixing set

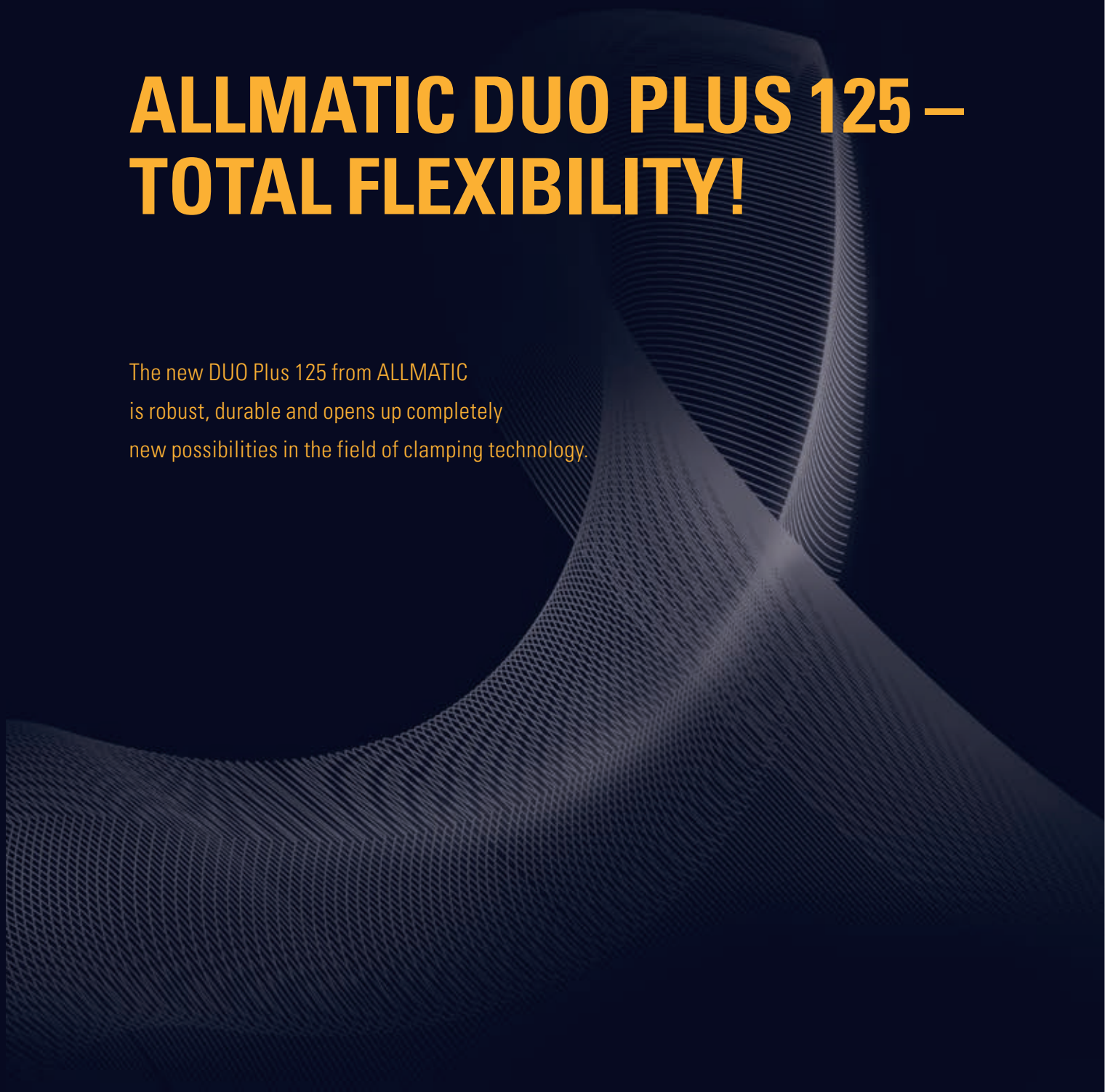
Order no. – see table

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

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

ALLMATIC DUO PLUS 125 – TOTAL FLEXIBILITY!

The new DUO Plus 125 from ALLMATIC
is robust, durable and opens up completely
new possibilities in the field of clamping technology.



ALLMATIC
JAKOB
Spannsysteme

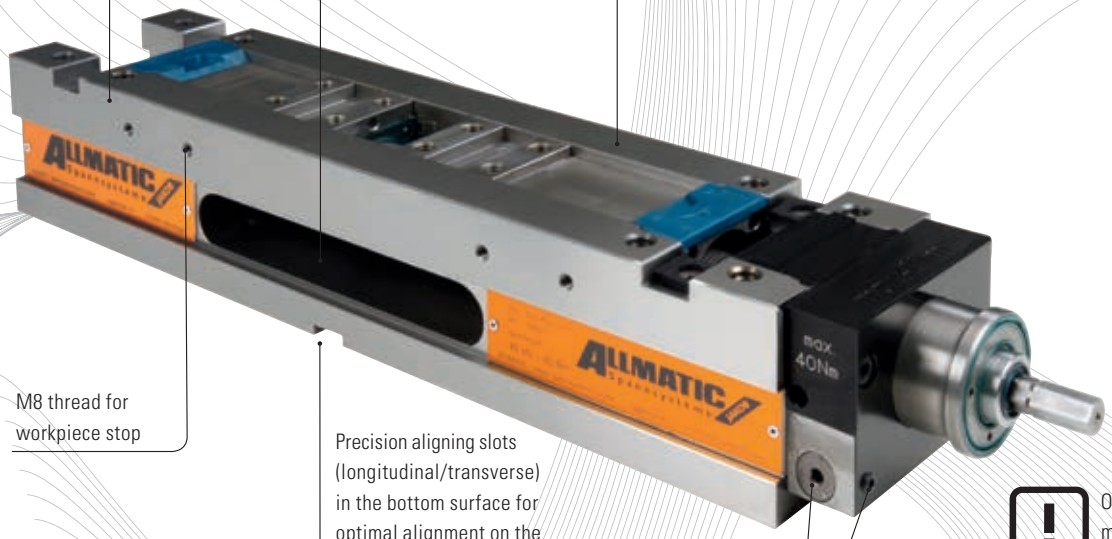
ALLMATIC GRIPP – MECHANICAL DUO PLUS 125 VERSION

Scope of application:

- Horizontal installation
- Suitable for conventional clamping and for gripper clamping or a combination of both
- The support jaws enable a wide range of unmachined parts from flame-cut and sawn materials through to complex castings to be clamped securely and economically. Gripper studs suitable for materials with a strength of up to approx. 1,000 N/mm²

Product features:

- Clamping range adjustment for clamping two workpieces of different sizes
- Reproducible clamping forces enable excellent repeating accuracy of the workpiece position
- Mechanical power-transfer device
- Fully enclosed and maintenance-free high-pressure spindle – high chip protection, minimum cleaning requirements, constant clamping forces up to 40 kN
- Use with a torque wrench – max. 40 Nm



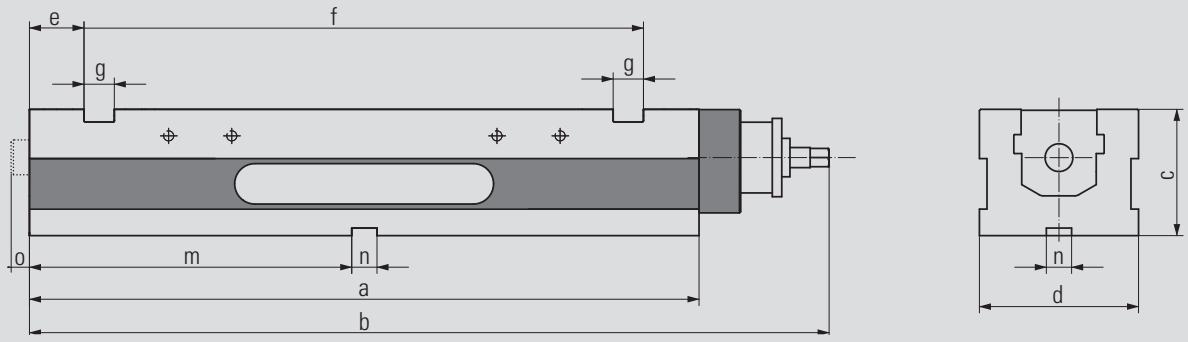
Order No. jaw width 125: 6921438000055

Scope of supply:

- 1 high-pressure vice without jaws
- 4 side clamps
- 3 socket screw wrenches
- 1 wrench socket WS 14
  (Please order clamping jaws separately)

Note:
Delivery does not include a torque wrench (see accessories).

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



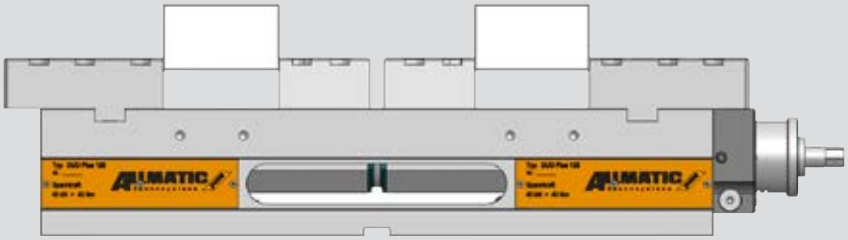
Technical data

Jaw width		125
Dimensions / tolerances in mm	a	530
	b	633
	c	100
	d	126
	e	43.2
	f	443
	g	24
	m	255.2
	n	20
	o	0 – 15

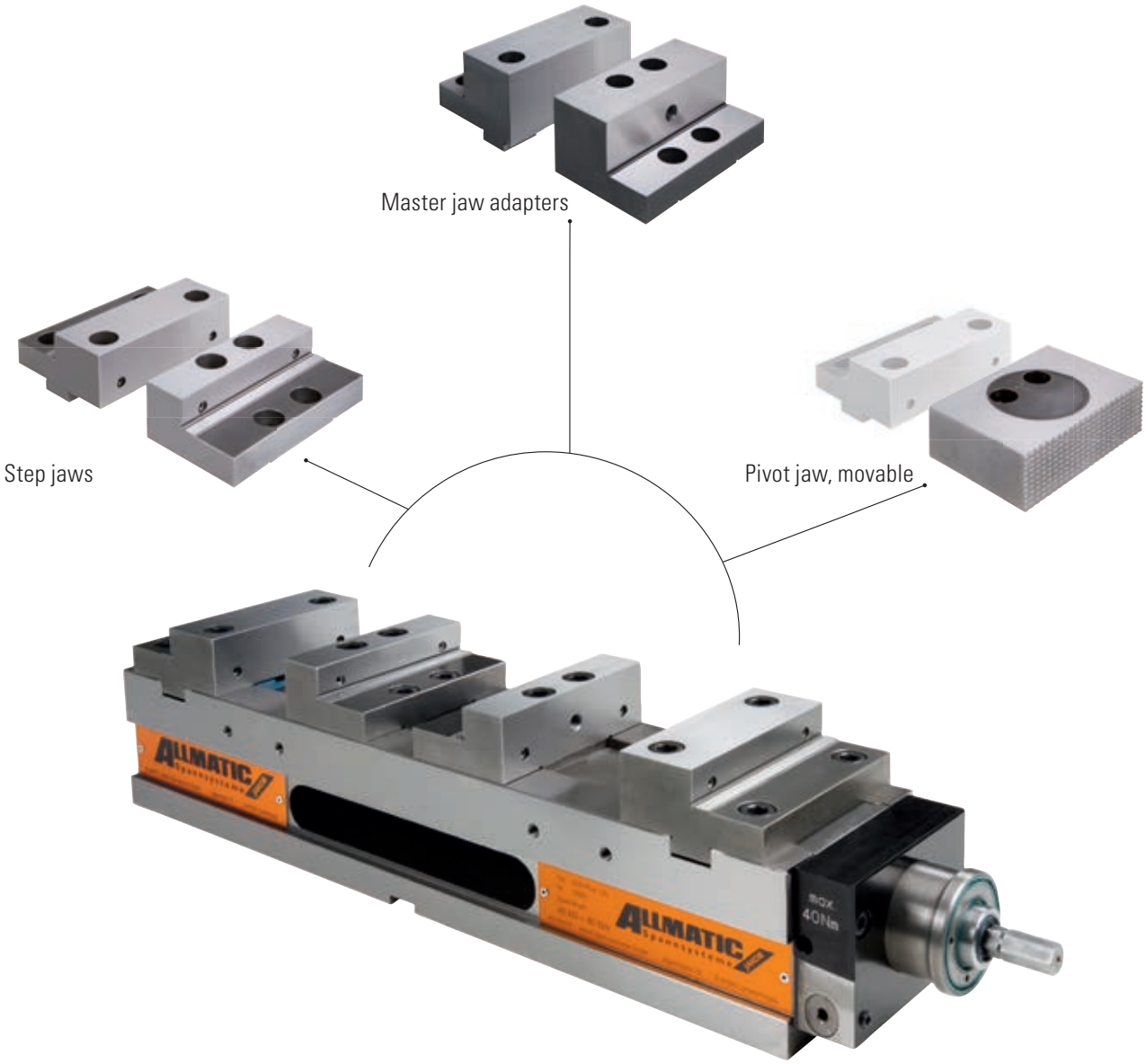
Jaw width	125
Max. torque in Nm	40
Max. clamping force in kN	40
Weight in kg	37

With the spindle in a symmetrical postition, turn the torque wrench clockwise to bring movable jaw 1 up against the workpiece in station 1 (see page 6). The workpiece is fixed with a force of approx. 1000 N. Turn the torque wrench further to bring movable jaw 2 up against the workpiece in station 2 and fix it there. If you continue turning beyond the “locking point”, the coupling will disengage. The pressure spindle activates the mechanical power intensifier.

Turning as far as the preset torque level (max. 40 Nm) produces a controlled clamping force build-up. Workpieces must be placed in both stations before clamping begins. Tolerances of ± 2.5 mm between workpiece 1 and workpiece 2 are compensated for. The new function of the clamping range adjustment enables the clamping of two differently sized workpieces.



ALLMATIC GRIPP – MECHANICAL/DUO PLUS 125

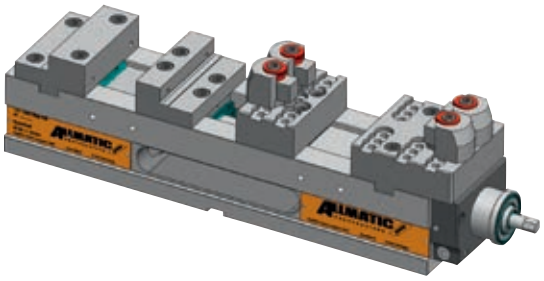


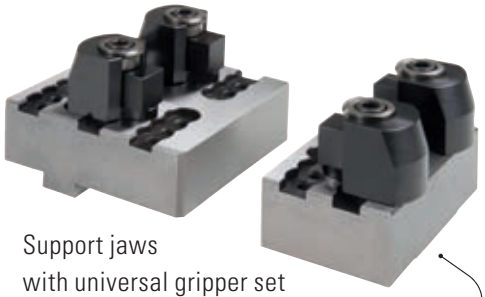
For conventional clamping of workpieces

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

IMPORTANT

A combination of both clamping options is possible!





Support jaws
with universal gripper set

Prismatic gripper

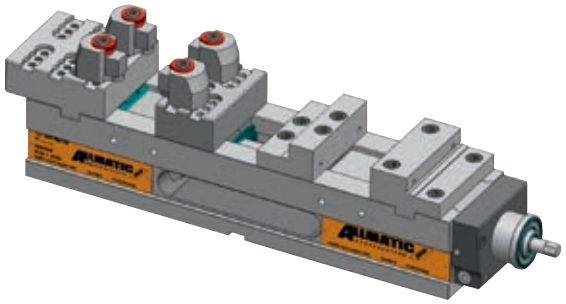
For clamping complex unmachined parts

The support jaws and gripper studs enable you to clamp different unmachined parts quickly and securely.

IMPORTANT
A combination of both clamping options is possible!

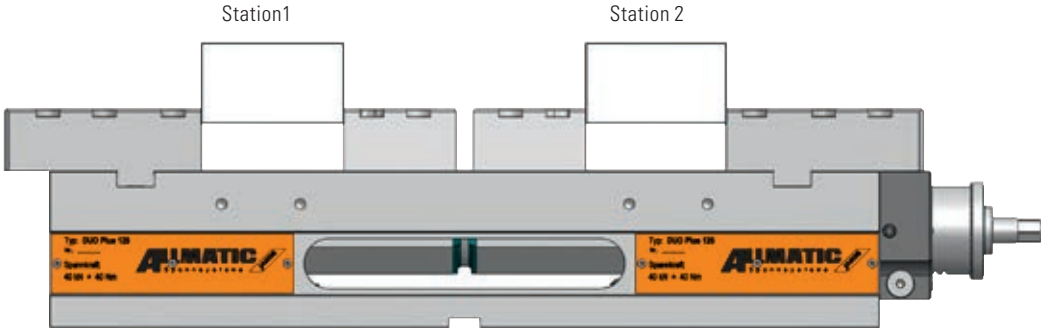
Gripper clamping

- Support jaws are used to mount the universal gripper set
- Gripper studs can be screwed onto grid plates in variable positions, to clamp unmachined workpieces of different sizes

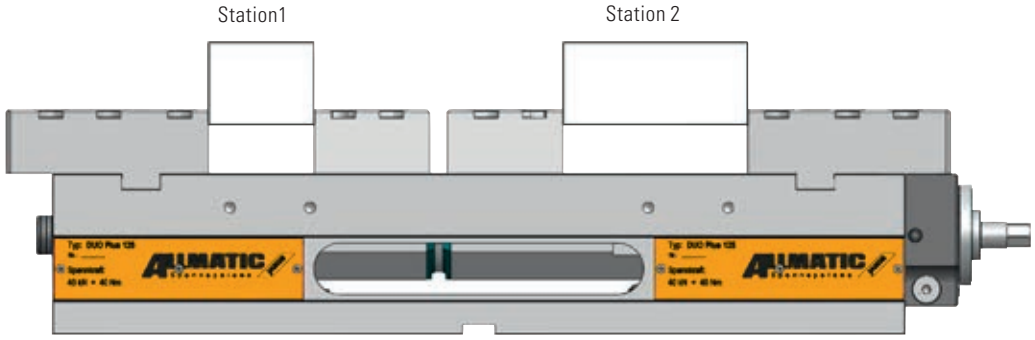


CLAMPING RANGES – DUO PLUS 125

With symmetrical spindle position



With loaded spindle position



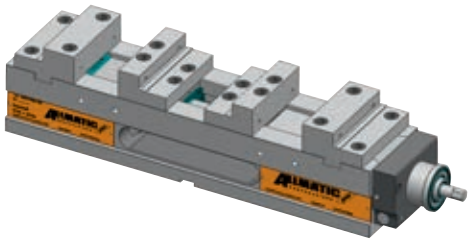
Clamping range adjustment

For the first time, the new DUO Plus 125 enables you to adjust the clamping range by changing the spindle position. This makes it possible to clamp workpieces of different sizes. The greatest workpiece differences are reached when using the support jaws in combination with the universal gripper set.

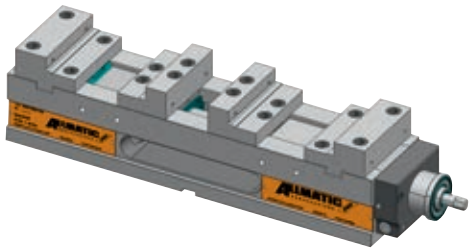
In view of the endless clamping combination possibilities, we have developed a **clamping width calculator** for you. All you need to do is enter the type and size of the workpiece. The program then suggests a complete range of clamping possibilities. This includes the recommendation for jaws with grippers, the requirement to adjust the spindle, and a detailed description of the clamping set-up. Visit us at:

www.allmatic.de

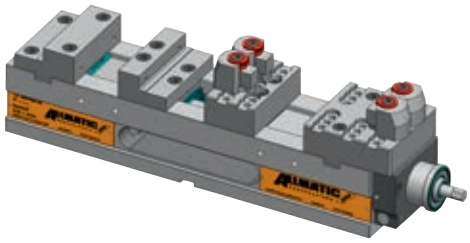
CLAMPING RANGES – DUO PLUS 125



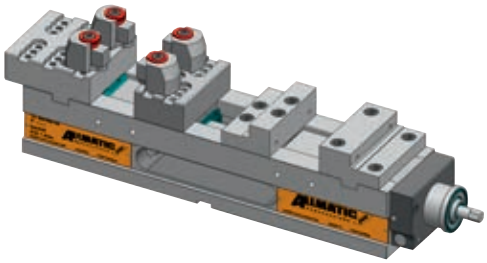
	Station 1	Station 2
Clamping ranges	0 – 89 mm	0 – 89 mm
Clamping ranges with spindle adjustment	0 – 64 mm	50 – 114 mm



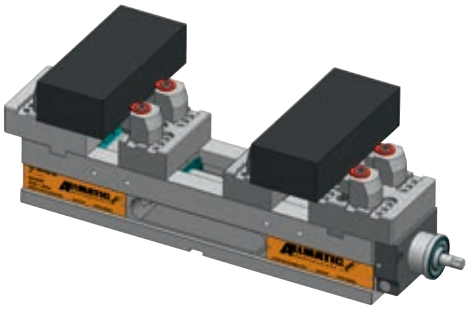
	Station 1	Station 2
Clamping ranges	43 – 172 mm	43 – 172 mm
Clamping ranges with spindle adjustment	43 – 147 mm	93 – 197 mm



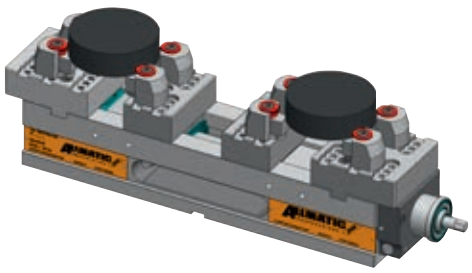
	Station 1	Station 2
Clamping ranges	0 – 89 mm	10 – 200 mm
Clamping ranges with spindle adjustment	0 – 64 mm	60 – 225 mm



	Station 1	Station 2
Clamping ranges	10 – 200 mm	0 – 89 mm
Clamping ranges with spindle adjustment	10 – 175 mm	93 – 197 mm



	Station 1	Station 2
Clamping ranges	10 – 200 mm	10 – 200 mm
Clamping ranges with spindle adjustment	10 – 175 mm	60 – 225 mm



	Station 1	Station 2
Clamping ranges	Ø 60 – 220 mm	60 – 220 mm
Clamping ranges with spindle adjustment	Ø 60 – 190 mm	80 – 240 mm

IMPORTANT
Combining the clamping ranges at Station one and Station two is not always possible when the spindle is adjusted!
Use our clamping range calculator at: **www.allmatic.de**

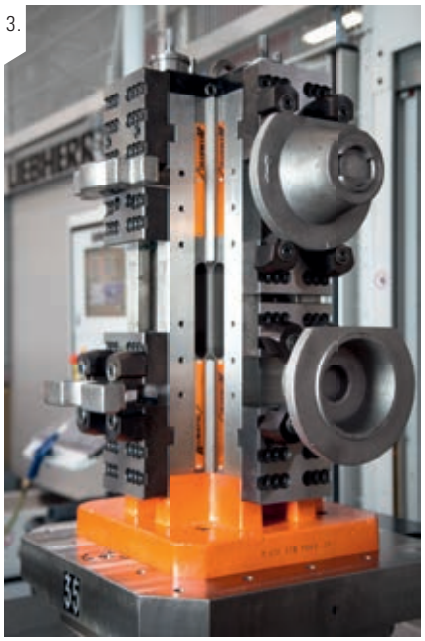
APPLICATION EXAMPLES – DUO PLUS 125

1.

2.

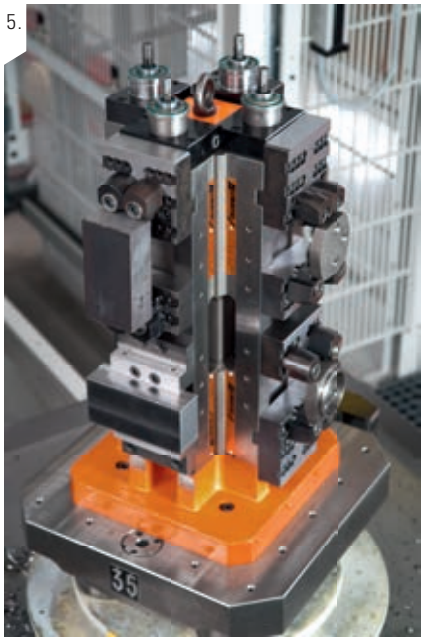
APPLICATION EXAMPLES – DUO PLUS 125

3.



4.

5.



Application examples

1. First and second clamping of a round casting with different diameters on support jaws and using the universal gripper set.
2. Complete machining of a workpiece in a second clamping by combining the clamping of unmachined parts and conventional clamping.

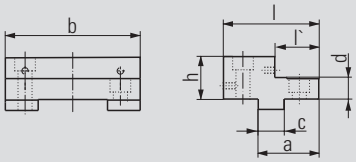
3.– 5. Wide variety of clamping possibilities with the DUO Plus 125 as a monobloc with step jaws, support jaws with the universal gripper set, and soft inserts.

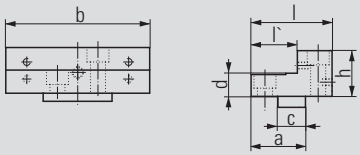
ALLMATIC GRIPP – mechanical / DUO Plus 125 version (accessories)

Step jaws

Order no. fixed:
6921484006731

Order no. movable:
6921484002731

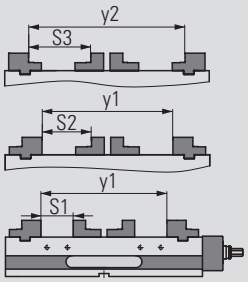




Jaw width		125
Dimensions in mm	a	55
	b	124.4
	c	24
	d	20
	h	39.5
	l	87
	l`	42

Jaw width		125
Dimensions in mm	a	47
	b	124.4
	c	24
	d	20
	h	39.5
	l	70
	l`	40

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

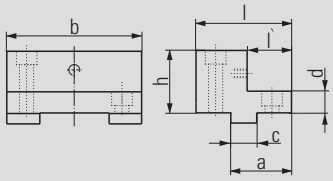


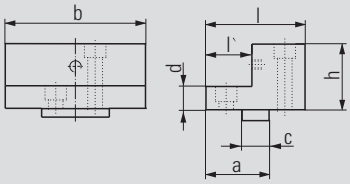
y1	331
y2	417
Clamping range S1	0 – 89
Clamping range S2	40 – 129
Clamping range S3	43 – 172

Master jaw adapters

Order no. fixed:
6921284012131

Order no. movable:
6921284011231

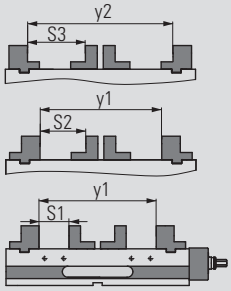




Jaw width		125
Dimensions in mm	a	77
	b	126
	c	24
	d	20
	h	58
	l	85
	l`	32

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

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

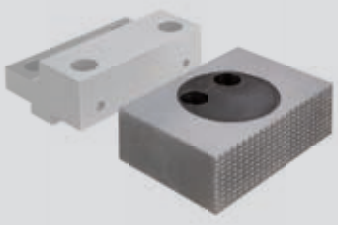


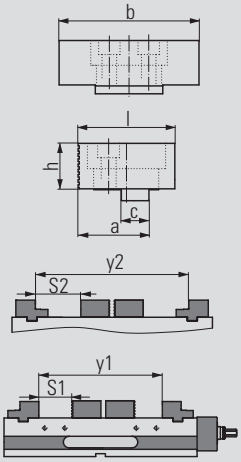
y1	331
y2	401
Clamping range S1	0 – 84
Clamping range S2	28 – 117
Clamping range S3	77 – 166

ALLMATIC GRIPP – mechanical / DUO Plus 125 version (accessories)

Pivot jaw, movable

Order no. 6921684020042



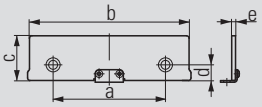


- Material: hardened steel
- With Click-System
- One side smooth, ground and polished; one side serrated
- Rotatable through 360°
- Picture with step jaw (see order no. 2530)

Jaw width		125
Dimensions in mm	a	62
	b	124.4
	c	24
	h	39.5
	l	84
y1		331
y2		417
Clamping range S1		0 – 89
Clamping range S2		40 – 129

Click parallels (pair)

Order no. 6921185035042

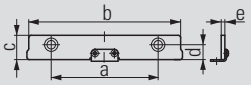


- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels with Click system
- For the high side of the jaws

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

Click parallels (pair)

Order no. 6921185020042

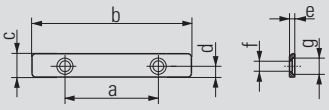


- For parallel raising of workpieces
- Hardened, ground and polished parallels
- Bolt-on parallels with Click system
- For the high side of the jaws

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

Parallels (pair)

Order no. 6921485015031



- For parallel raising of workpieces
- Hardened and ground parallels
- Screw-fastened parallels
- For the step side of the jaws

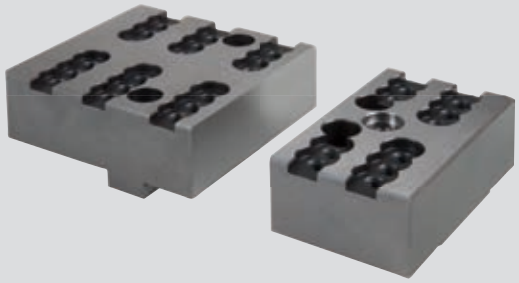
Jaw width		125
Dimensions in mm	a	88
	b	124
	c	15
	d	6
	e	3
	f	Ø 6
	g	Ø 9

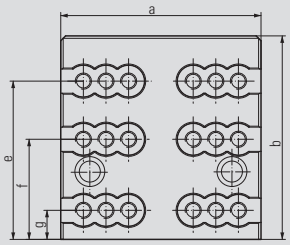
ALLMATIC GRIPP – mechanical / DUO Plus 125 version (accessories)

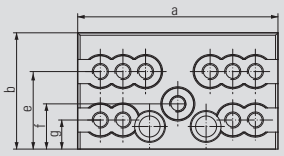
Support jaws for universal gripper set

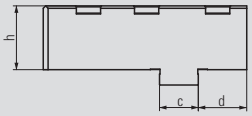
Order no. fixed:
6921484005042

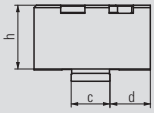
Order no. movable:
6921484004042







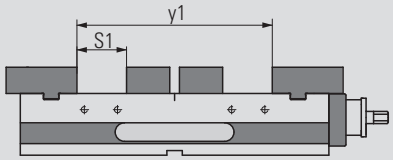




- Material: hardened steel
- For mounting the universal gripper set and the prismatic gripper
- For clamping unmachined parts
- For clamping pre-machined workpieces
- Front surface can be used as clamping surface
- Use of the Click system
- Universal gripper set **not** included

Jaw width		125
Dimensions in mm	a	124
	b	126
	c	24
	d	30
	e	98
	f	62
	g	18
	h	39.5

Jaw width		125
Dimensions in mm	a	124
	b	72
	c	24
	d	25
	e	48
	f	28
	g	18
	h	39.5



y1	335
Clamping range S1	0 – 89

The clamping range dimensions change due to spindle adjustment!

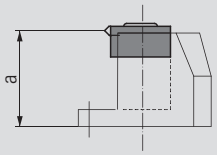
Soft jaws

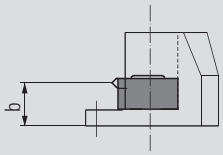
Order no. available on request

- For mounting onto the support jaws

ALLMATIC GRIPP – mechanical / DUO Plus 125 version (accessories)

Universal gripper set





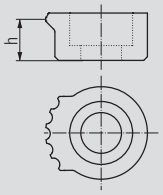
Order no. 6921884027031

Jaw width		125
Dimensions in mm	a	40
	b	18

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

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

Gripper stud

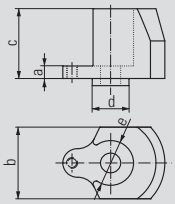


Order no. 6921884026000

Dimensions in mm	h	11

- Gripper stud for universal gripper set

Gripper stud mount

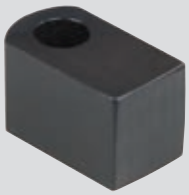


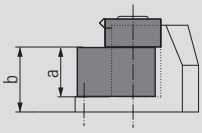
Order no. 6921884027000

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

- Mount for gripper stud 6921884026000

Support





Order no. 6921884028000

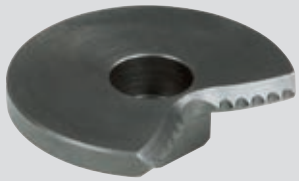
Dimensions in mm	a	22
	b	29

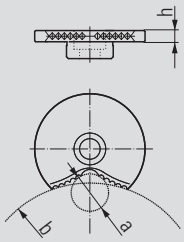
- Support for universal gripper set

ALLMATIC GRIPP – mechanical / DUO Plus 125 version (accessories)

Prismatic gripper

Order no. 6921884029031



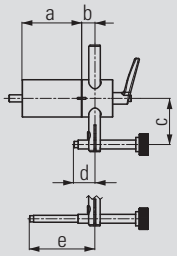


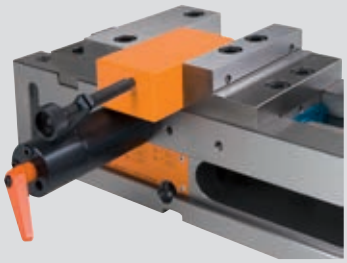
Dimensions in mm		
	a	Ø 20
	b	Ø 120
	h	6

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

Workpiece stop

Order no. 6921285650144



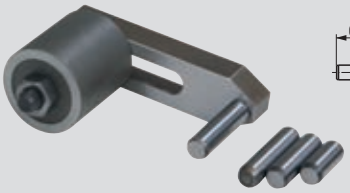


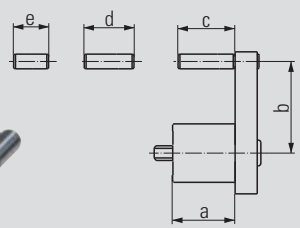
Dimensions in mm		
	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

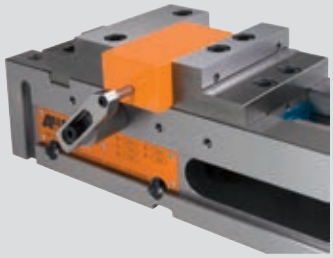
- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Position of the third workpiece axis can be preset and clamped Workpiece stop can be swivelled away once the workpiece has been clamped
- This allows the stop side of the workpiece to also be machined (repeating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

Workpiece stop

Order no. 6921685670042







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

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

ALLMATIC GRIPP – mechanical / DUO Plus 125 version (accessories)

Torque wrench

Order no. 0651114113188

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

- Can be preset to 10 – 60 Nm
- For use on the high-pressure gripper spindle DUO Plus 125

Side clamps (pair)

Order no. 6921025000031

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

Aligning and fixing set

Order no. – see table

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

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

ALLMATIC CENTRO GRIPP – FOR CENTRAL GRIPPING

Our „all-rounder" stands out for its superb precision and durability. Central clamping of workpiece – for conventional clamping and clamping of unmachined parts. Ideal for five-sided machining.

Typ: CENTRO Gripp 125
Nr. 0001
ALLMATIC
Spannsysteme
Spannkraft: 40 kN
ALLMATIC

ALLMATIC GRIPP – MECHANICAL CENTRO GRIPP VERSION

Scope of application:

- Horizontal installation – suitable for vertical CNC milling machines
- Ideal for use on five-axis machining centres due to its compact design
- Depending on the clamping jaws, both pre-machined workpieces and unmachined parts can be clamped
- With support jaws, unmachined parts with varying types of flame-cut and sawn materials and even complex castings can be clamped safely and economically. Gripper studs suitable for materials of mechanical strength of up to approx. 1000 N/mm².

Product features:

- The centre is adjustable. The position of the workpiece stays within set boundaries.
- Repeating accuracy ± 1/100 mm for angled workpieces
- Guides ground, polished and paired
- Clamping range presetting via adjustment of clamping jaws along transverse slots of spindle nuts
- Moulding and clamping in a single step, directly in the work area – no auxiliary aids required
- Use with a torque wrench – max. 70 Nm
- Fully enclosed and maintenance-free high-pressure spindle – high chip protection, minimum cleaning requirements, constant clamping forces up to 40 kN

Order No.
jaw width 125: 6921538000055

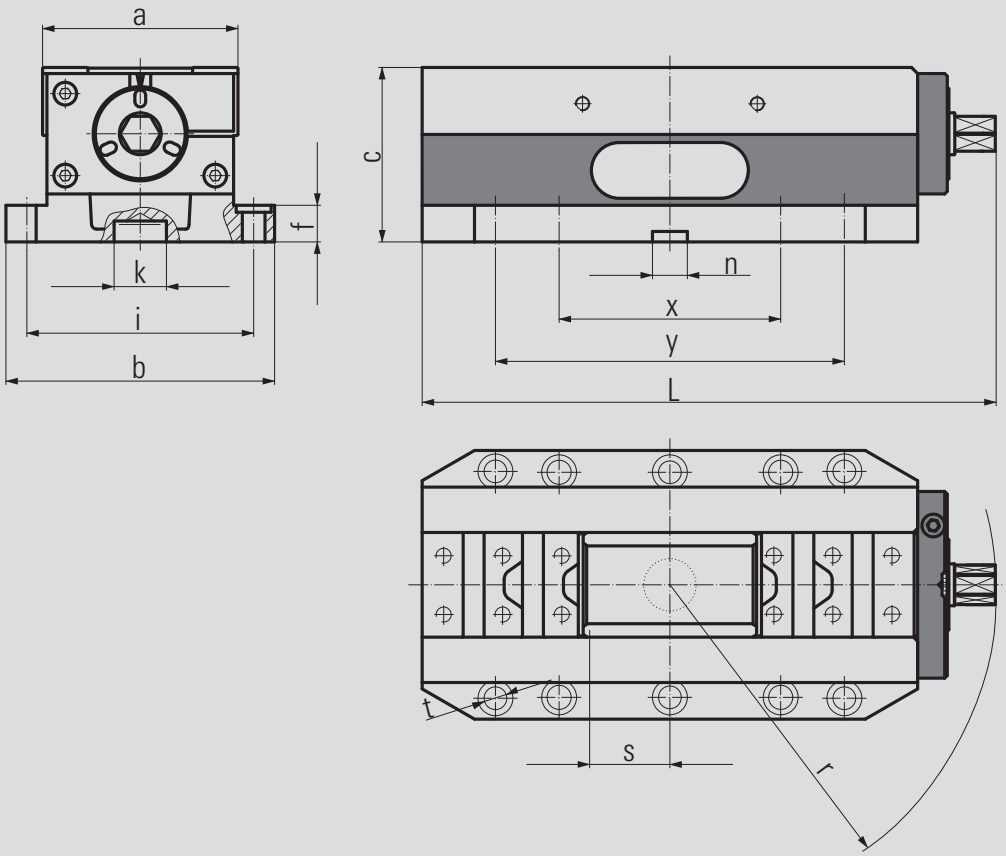
Scope of delivery:

- 1 high-pressure vice without jaws
- 2 combination wrenches
- 6 fastening screws, M12 x 35 mm
- 2 socket screw wrenches
- 1 wrench socket

(Please order clamping jaws separately)

Note:

Delivery does not include a torque wrench (see accessories).
An overview of the clamping jaws and other accessories is given on the following pages.

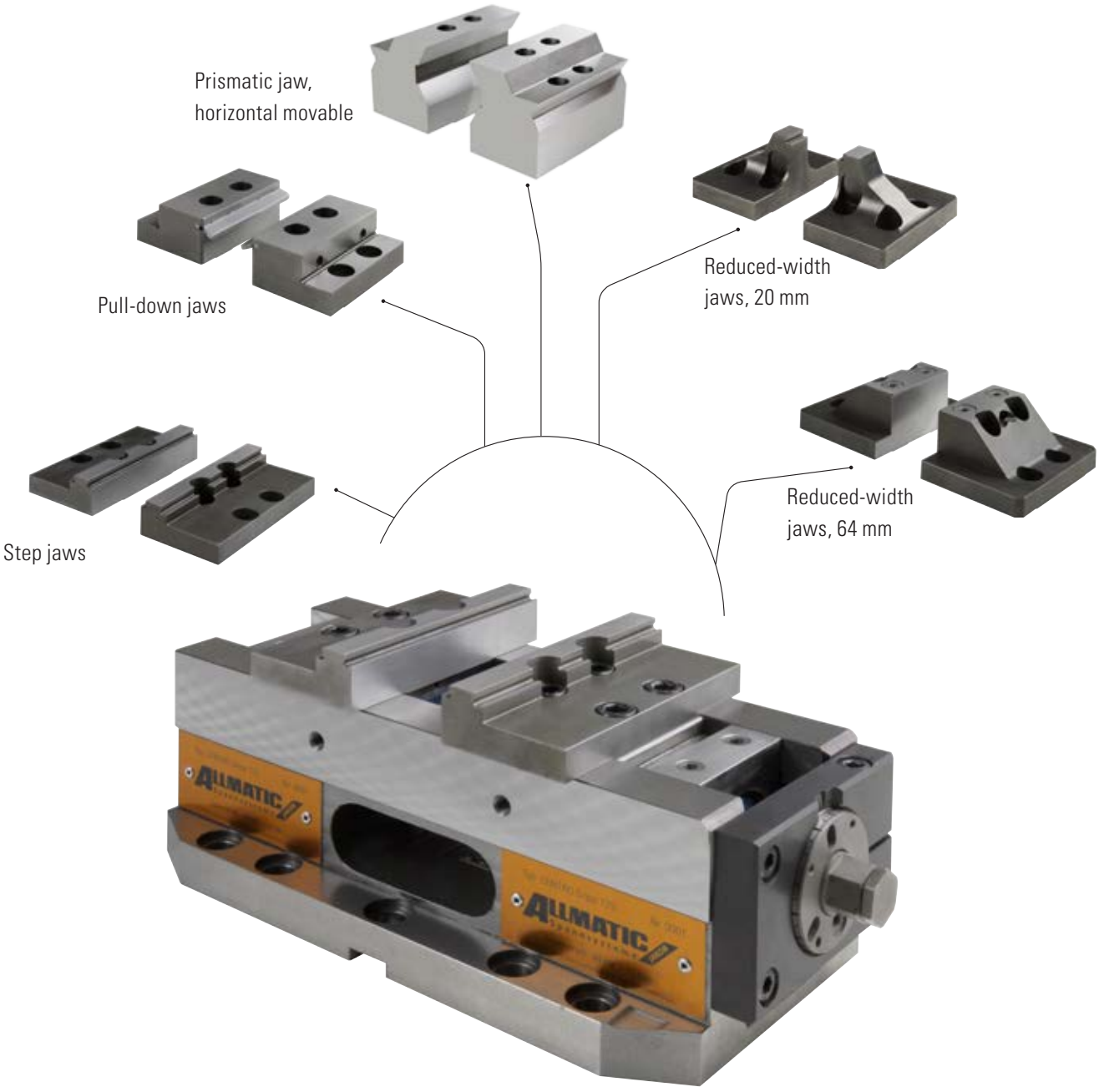


Technical data

Jaw width		125
Dimensions / tolerances in mm	a	112
	b	154
	c	100
	f	21
	i	129/130
	k	Ø 30 H8
	L	329
	n	20 H7
	r	182
	s (traverse)	46
	t	Ø 13
	x	127
	y	200

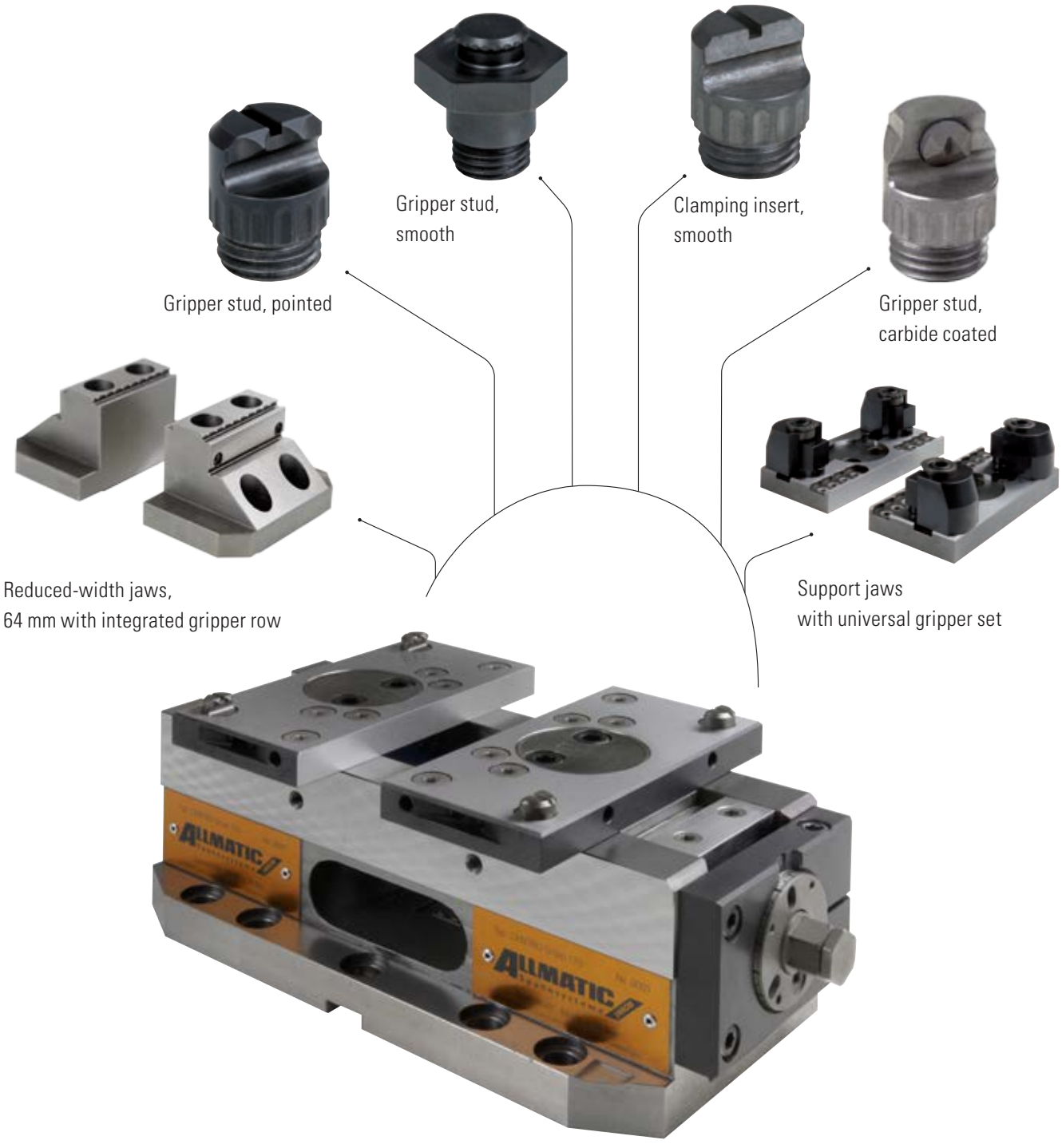
Jaw width	125
Max. torque in Nm	70
Max. clamping force in kN	40
Weight in kg	19.5

ALLMATIC GRIPP – MECHANICAL/CENTRO GRIPP



For conventional clamping of workpieces

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



For clamping complex unmachined parts

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

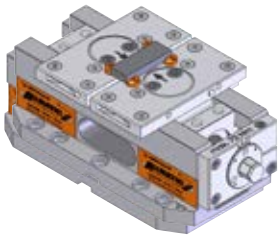
Gripper clamping:

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

CLAMPING RANGES – CENTRO GRIPP

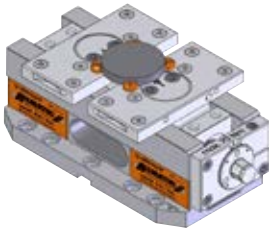
You can find the clamping ranges of the other jaws for conventional clamping on the following pages of accessories.

Support jaws with gripper studs

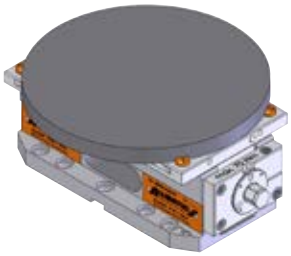


Min. clamping range	27 mm
Min. clamping width	70 mm

Max. clamping range	242 mm
Max. clamping width	at least 150 mm or larger

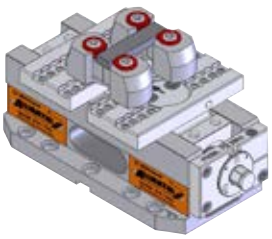


Min. clamping range	Ø 65 mm

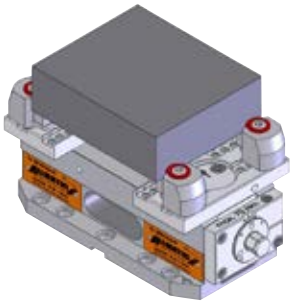


Max. clamping range	Ø 274 mm

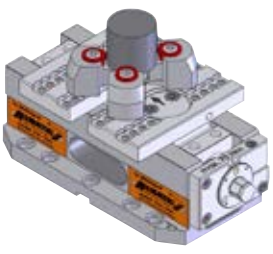
Support jaws with universal gripper set



Min. clamping range	10 mm
Min. clamping width	90 mm



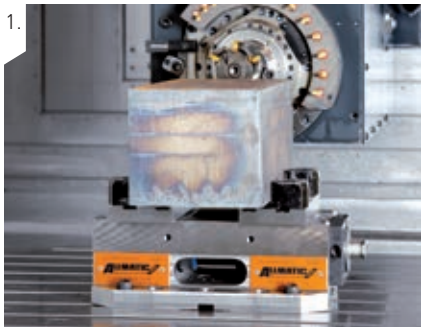
Max. clamping range	192 mm
Max. clamping width	at least 165 mm or larger



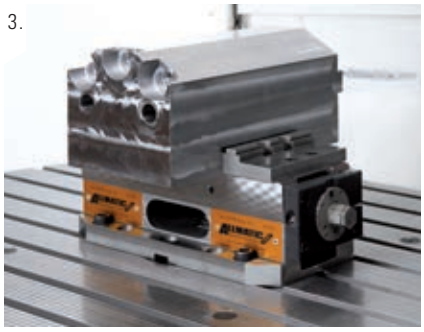
Min. clamping range	Ø 55 mm

Max. clamping range	Ø 240 mm

APPLICATION EXAMPLES – CENTRO GRIPP

1. 

2.

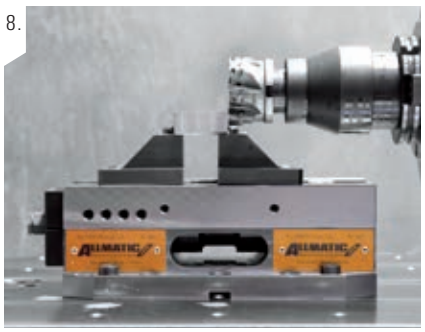
3. 

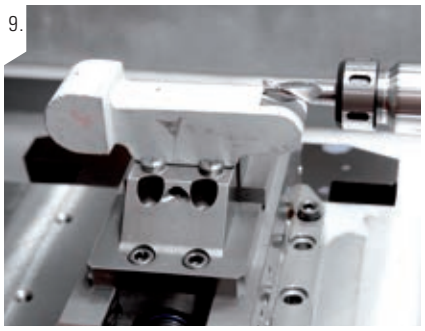
4.

5.

6.

7.

8. 

9. 

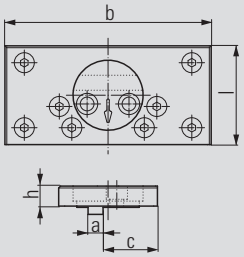
Application examples

1. – 3. Flexible – from the unmachined part through to the finished product
   Supports complete machining – from the reliable positive-locking clamping of unmachined parts by means of our tried and tested gripper technology through to the clamping of the machined part in smooth jaws or studs on modern CNC machines with just a single clamping device. Reliable clamping of large workpieces (even for heavy-duty machining work) thanks to the power spindle
4. Flexible gripper studs combined with pivot jaws enable reliable clamping of unmachined parts of very diverse geometries and materials
5. The concentric function enables clamping of unmachined parts of small dimensions. The clamping of unmachined parts is fast, simple and, above all, reliable thanks to the use of tried and tested components
6. – 7. Reliable positive-locking clamping with defined clamping force on clamping edge loss for five-sided machining, irrespective of whether the part is round or angular
8. – 9. Optimum accessibility to the workpiece from all five sides with standard tools

ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

Support jaws for gripper studs

Order No. movable, pivot (1 piece): 6921884072042



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

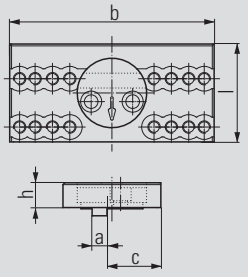
- Material: hardened steel
- For mounting various studs (pointed/smooth)
- Front surface can be used as clamping surface (hardened, ground and polished)
- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- If using 2 pivot jaws, one pivot jaw must be manually aligned and blocked
- Studs (pointed/smooth) **not** included

Dimensions of the individual items of the gripper set can be found at www.allmatic.de

Please order gripper studs separately.

Support jaws for universal gripper set

Order No. movable, pivot (1 piece): 6921884072242



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

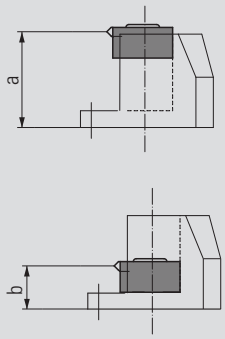
- Material: hardened steel
- For mounting the universal gripper set
- Front surface can be used as clamping surface (hardened, ground and polished)
- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- If using 2 pivot jaws, one pivot jaw must be manually aligned and blocked
- Studs (pointed/smooth) **not** included

Dimensions of the individual items of the gripper set can be found at www.allmatic.de

Please order universal gripper set separately.

ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

Universal gripper set



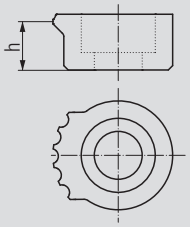
Order no. 6921884027031

Jaw width		125
Dimensions in mm	a	40
	b	18

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

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

Gripper stud

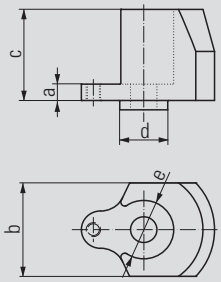


Order no. 6921884026000

Dimensions in mm	h	11

- Gripper stud for universal gripper set

Gripper stud mount

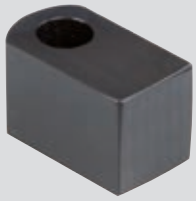


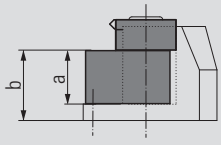
Order no. 6921884027000

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

- Mount for gripper stud 6921884026000

Support





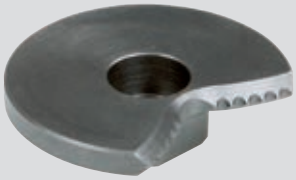
Order no. 6921884028000

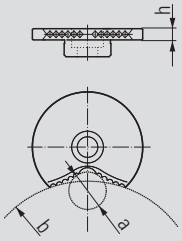
Dimensions in mm	a	22
	b	29

- Support for universal gripper set

ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

Prismatic gripper



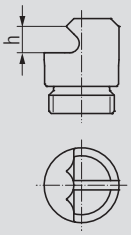


Order no.6921884029031

Dimensions in mm	a	Ø 20
	b	Ø 120
	h	6

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

Gripper stud, pointed

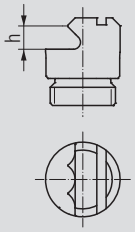


Order no. 6921884036000

Dimensions in mm	h	5.5

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

Gripper stud, low-level

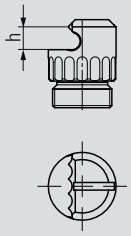


Order no. 6921884036100

Dimensions in mm	h	5

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

Gripper stud, four-point

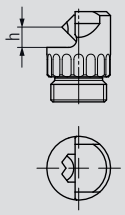


Order no. 6921884036500

Dimensions in mm	h	5,4

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

Gripper stud, carbide coated



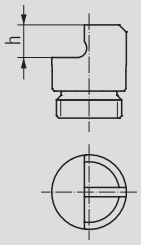
Order no. 6921884036841

Dimensions in mm	h	5,1

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

ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

Clamping insert, smooth

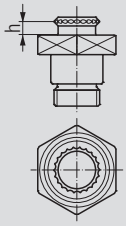


Order no. 6921884037000

Dimensions in mm	h	7

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

Gripper stud, round



Order no. 6921884038000

Dimensions in mm	h	4

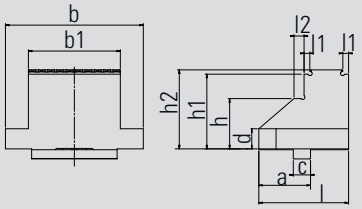
- For clamping unmachined parts
- For through-drilling close to the edge
- Offers 6 mm space below workpiece

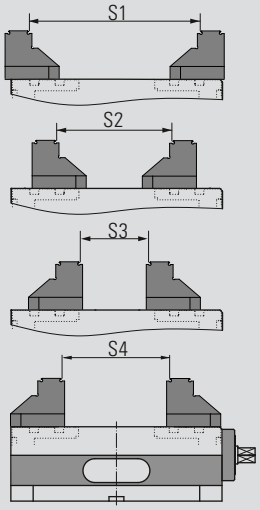
ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

Jaw 64 mm, with integrated gripper row

Order no. movable: 6921534036031

- For rectangular workpieces (sawn material) ≤ 0.5 mm
- Rigid design to prevent vibrations when parts are clamped upright
- Additional clamping surfaces, ground on both sides
- For five-sided machining, ensuring best possible accessibility to the workpiece
- Positive locking through penetration of the centres into the material
- Minimal lost clamping margin of approx. 3 mm.
- Suitable for material strength of up to 1000 N/mm²





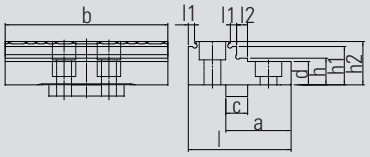
Jaw width		125
Dimensions in mm	a	36
	b	96
	b1	64
	c	12
	d	14
	h	35
	h1	52
	h2	55
	l	62,5
	l1	4
	l2	7

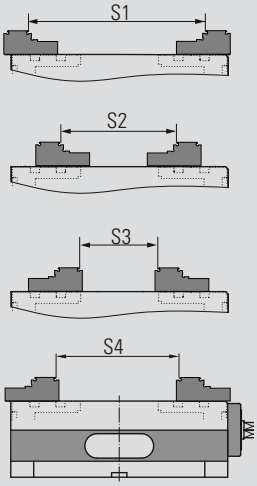
Clamping range S1	150 - 226
Clamping range S2	80 - 158
Clamping range S3	15 - 92
Clamping range S4	80 - 160

Jaw with integrated gripper row

Order no. movable: 6921534036931

- For rectangular workpieces (sawn material) ≤ 0.5 mm
- Rigid design to prevent vibrations when parts are clamped upright
- Additional clamping surfaces, ground on both sides
- For five-sided machining, ensuring best possible accessibility to the workpiece
- Positive locking through penetration of the centres into the material
- Minimal lost clamping margin of approx. 4 mm.
- Suitable for material strength of up to 1000 N/mm²





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

Clamping range S1	148 - 226
Clamping range S2	80 - 158
Clamping range S3	15 - 90
Clamping range S4	80 - 158

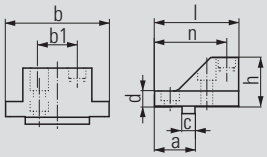
ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

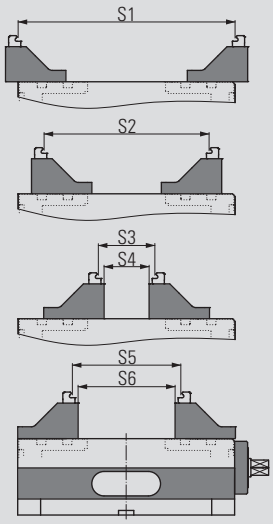
Reduced-width jaws 64 mm

Order no. movable:6921884040040

Please order gripper studs separately

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





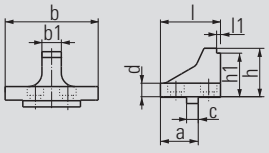
Jaw width		125
Dimensions in mm	a	37.5
	b	96
	b1	37
	c	12
	d	14
	h	45
	l	79
	n	67

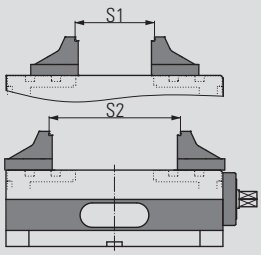
Clamping range S1	196 – 284
Clamping range S2	128 – 216
Clamping range S3	21 – 74
Clamping range S4	0 – 59
Clamping range S5	54 – 142
Clamping range S6	35 – 127

Reduced-width jaws 20 mm

Order no. movable: 6921884041041

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





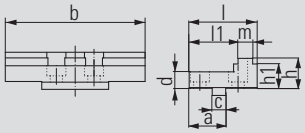
Jaw width		125
Dimensions in mm	a	39
	b	96
	b1	20
	c	12
	d	14
	h	50
	h1	45
	l	62
	l1	4

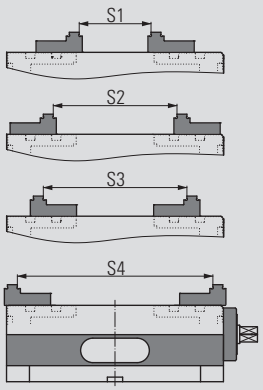
Clamping range S1	12 – 104
Clamping range S2	80 – 172

ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

Step jaws, carbide–coated

Order no. movable: 6921884002041





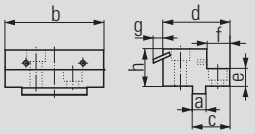
- Material: hardened steel
- For clamping parallel pre-machined workpieces
- Clamping surfaces (step) additionally carbide – coated to ensure secure clamping – this increases the holding force by a factor of at least 2 compared to smooth clamping surface

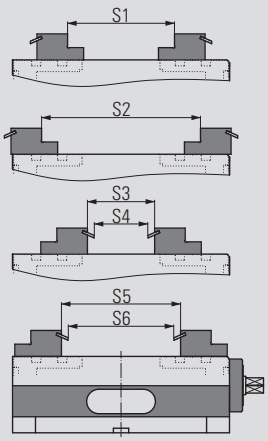
Jaw width		125
Dimensions in mm	a	32.5
	b	124.4
	c	12
	d	14
	h	26
	h1	21
	l	60.5
	l1	43.5
	m	13

Clamping range S1	9 – 94
Clamping range S2	99 – 162
Clamping range S3	95 – 188
Clamping range S4	163 – 256

Universal pull-down jaws

Order no. movable:6921884102031





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

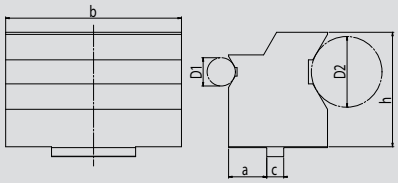
Jaw width		125
Dimensions in mm	a	12
	b	90
	c	34
	d	61
	e	16
	f	21
	g	8.8
	h	34

Clamping range S1	47 – 139
Clamping range S2	115 – 207
Clamping range S3	0 – 88
Clamping range S4	0 – 70
Clamping range S5	64 – 156
Clamping range S6	46 – 138

ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

Prismatic jaw, horizontal movable

Order no. movable: 6921534001031

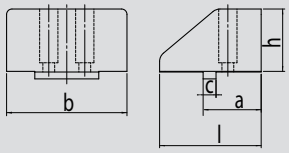


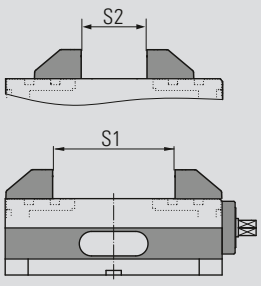
Jaw width		125
Dimensions in mm	a	27
	b	124,4
	c	12
	h	81
	D1	ø 17 - 42
	D2	ø 38 - 104

- Prism angle 120° - shaft height 53 mm on both sides
- Hardened and ground
- Jaws open far enough to allow the workpiece to be removed from above – even at maximum diameter
- Ideally suited for machining keyways on stepped shafts, for example, using two vices side-by-side

Soft jaw movable

Order no. movable: 6921534087031





Jaw width		125
Dimen-sions in mm	a	54
	b	112
	c	12
	h	58
	l	94,5

Clamping range S1	33 – 125
Clamping range S2	0 – 57

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

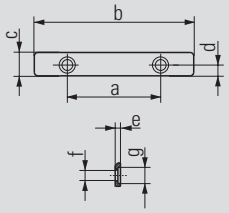
ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

Spring leaves (pair)

Order no. 6921884103031

- Hardened spring leaves
- Spring leaves (spare) for the pull-down jaws (see page 140 below)

Parallels (pair)



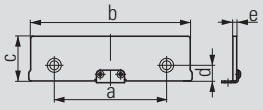
Order no. 6921475013031

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

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

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

Click parallels (pair)



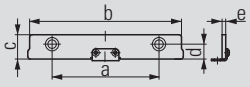
Order no. 6921175029042

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

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

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

Click parallels (pair)



Order no. 6921175016042

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

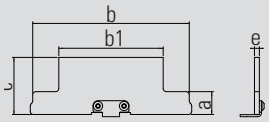
- For parallel raising of workpieces
- Hardened, ground and polished parallels

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

ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

Click parallels (pair)

Order no. 6921535035042

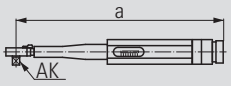


Jaw width		90
Dimensions in mm	a	14
	b	96
	b1	64
	c	35
	e	3

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

Torque wrench

Order no. 0651114113153

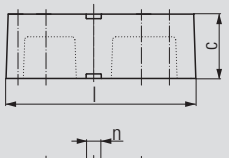


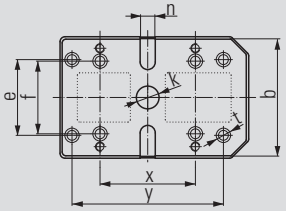
Dimensions in mm	a	410
	AK (Drive square)	1/2“

- Can be preset to 20 – 120 Nm
- Only for use on the CENTRO Gripp high-pressure gripper spindle
- Use a smaller torque wrench for more precise presetting of the spindle power

Console

Order no. 6921885009042





Jaw width		125
Dimensions in mm	b	154
	c	85
	e	100
	f	96
	l	250
	n	20 H7
	k	Ø 30 H7
	t	13
	x	125,5
	y	200

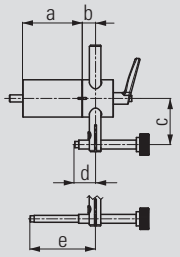
- Material: GG30
- For raising the CENTRO Gripp 125
- Improved access for five-sided machining
- The mounting hole pattern of CENTRO Gripp and console is offset slightly in order to enable mounting in tables with parallel T-slots as well as in tables with cross slots.

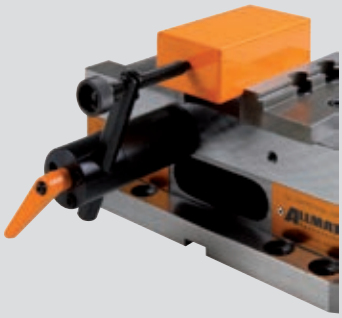
Scope of supply:
- Console incl. fixing bolt
- 2 socket screw wrenches
- 4 bolts

ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

Workpiece stop

Order no. 6921285650144



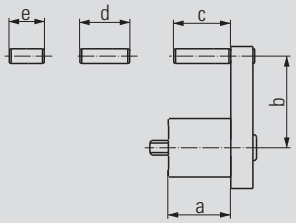


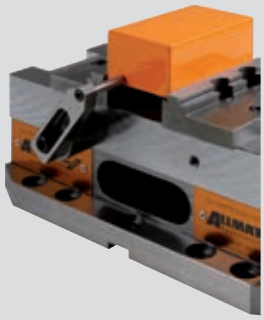
Dimensions in mm		
	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

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

Workpiece stop

Order no. 6921685670042





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

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

ALLMATIC GRIPP – mechanical / CENTRO Gripp version (accessories)

Aligning and fixing set

Order no. – see table

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

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

ALLMATIC

TOMBSTONES FOR HORIZONTAL MACHINING

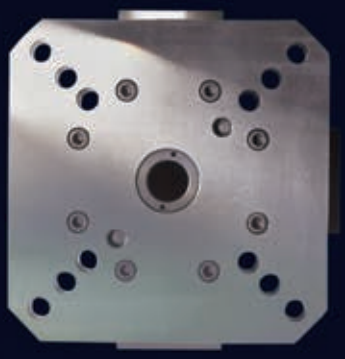
In addition to our standard products, ALLMATIC offers a wide range of customised solutions, each of which can be individually tailored to your machine, workpiece and machining techniques.

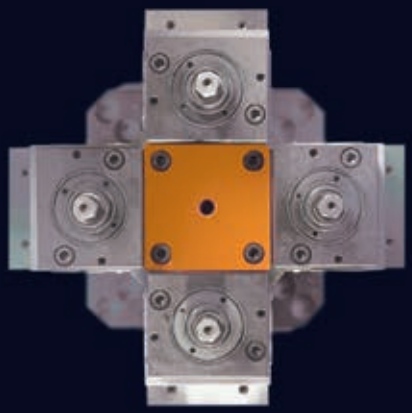
The majority of these solutions are monoblocs and set-ups.

- Monoblocs are made from a single piece, are long-time gas nitrated and ground and polished on all sides. This ensures a very high stability and produces optimal machining results.
- Set-ups are tombstones comprising several standard vices.

The base plates are suitably adapted to ensure exact positioning on the machine table or on a pallet. According to your requirements, we can manufacture base plates with an elevation, with a different spacing of the mounting holes, with a centering mechanism (possibly with a second index) or with a JIS stop system.

To give you even greater flexibility, we will manufacture special clamping jaws adapted to the geometry of your workpieces. Similarly, in customised solutions, the clamping force of the spindles can be adapted to suit your machining requirements. In addition to the set-ups for conventional clamping, we can also offer you solutions for clamping unmachined parts. For this, we employ the functions of our tried and tested T-REX, TITAN and DUO Plus 125 vices.





The set-ups described on the following pages are just a few examples of already realised clamping solutions. We shall be pleased to provide you with a customised solution – let us know your requirements!

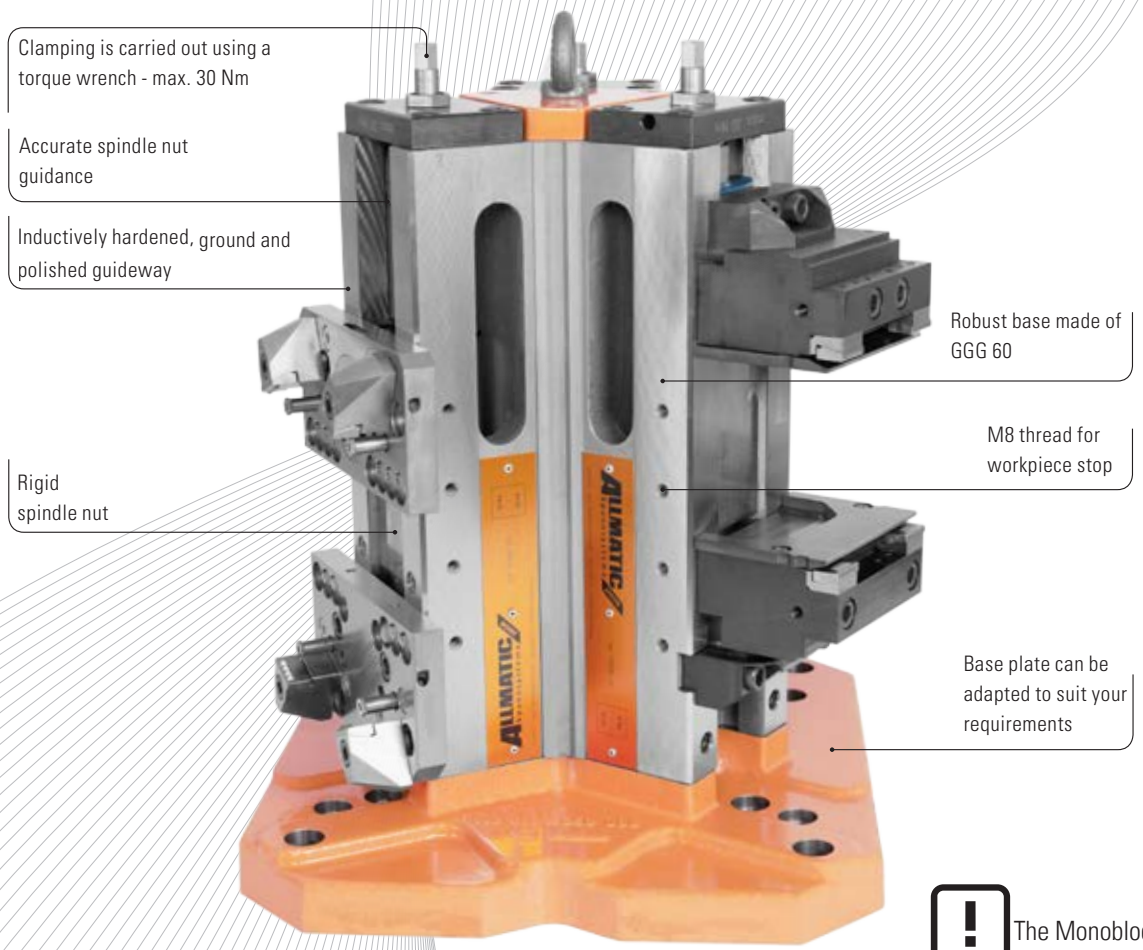
MONOBLOC – 3 x 120° SINGLE TITAN 2

Scope of application:

- Modular clamping system for horizontal machining centres

Product features:

- High stability from base cast as one piece-maximum precision or workpiece machining
- Very good accessibility, even with large workpieces
- Conventional clamping, gripper clamping or pull-down clamping are all possible (see TITAN 2)
- High-pressure spindle with mechanical power-transfer device
- Stepless adjustment of the clamping force with torque wrench
- Individual adaptation to your machine (pallet, traverses and workpieces) is possible
- Three clamping points permit three-sided machining



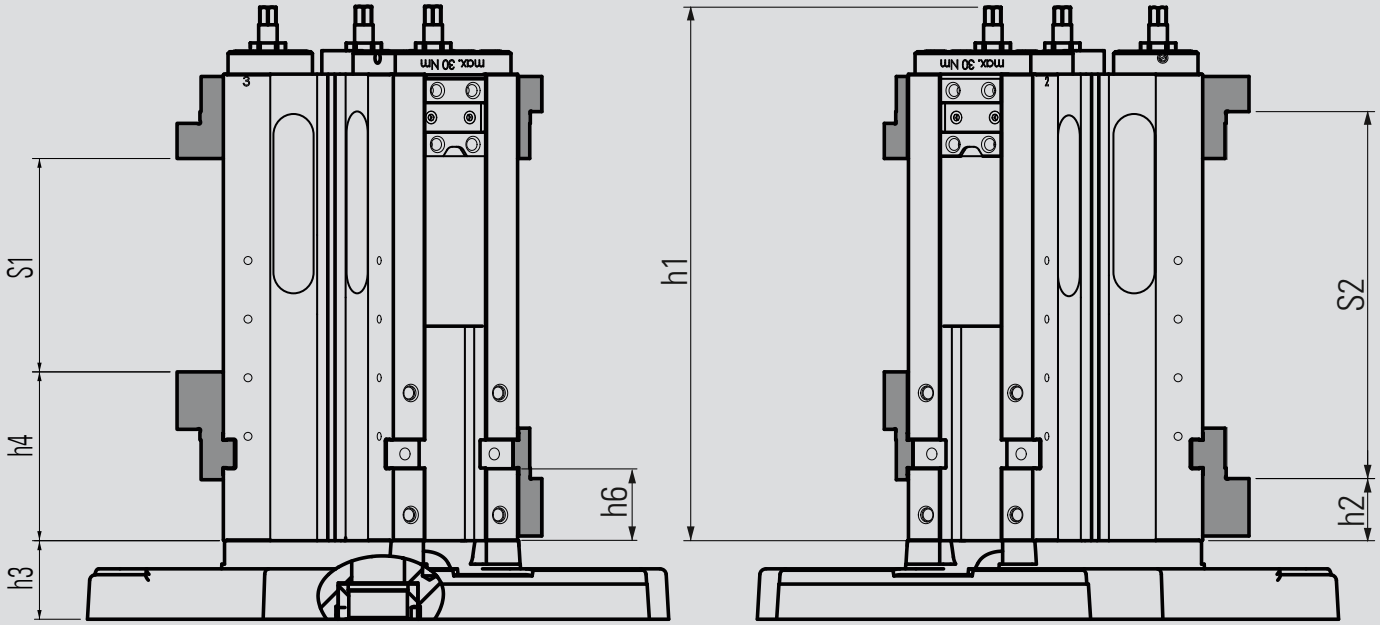
Order no.: available on request

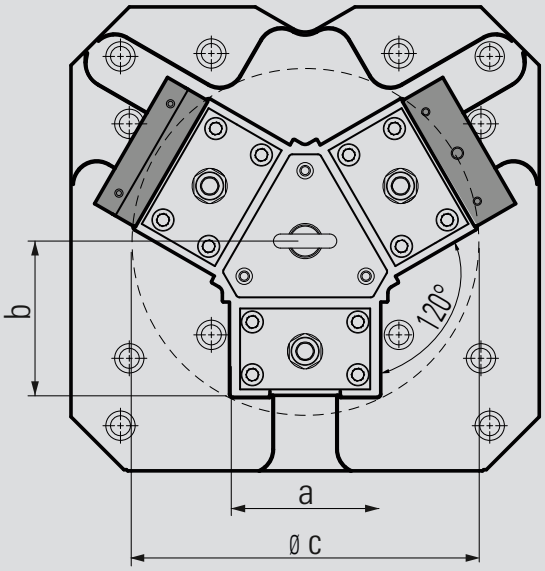
Scope of supply:

- Monobloc without jaws
- 3 socket screw wrench
- Hexagonal insert for torque wrench, 3/8"

The Monoblock, type TITAN 2, is also available with the LC/TC spindle (see version LC/TC, photos on page 28)

An overview of the clamping jaws and other accessories is given in the section: Accessories for the ALLMATIC TITAN 2 K-M-L.





Technical data

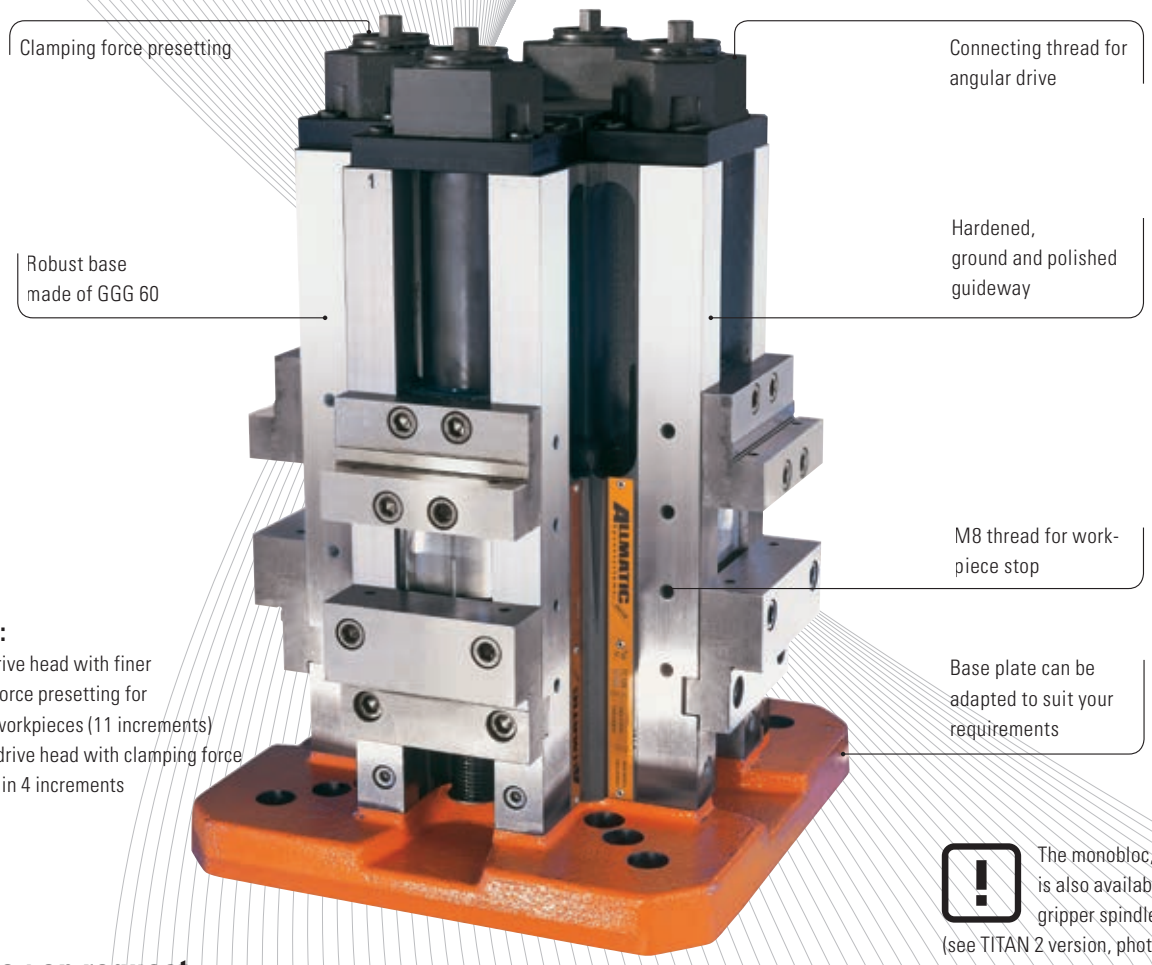
Jaw width TITAN 2 M		125
Dimensions in mm	a	126
	b	132
	c (swing circle)	dia. 300
	h1	456
	h2	53
	h3	67
	h4	144
	h5	62

Jaw width with step jaws	125
Clamping width S1 in mm	0 – 182
Clamping width S2 in mm	131 – 313
Max. torque in Nm	30
Max. clamping force in kN	40

MONOBLOC – 4 x 90° SINGLE

Scope of application:
- Modular clamping system for horizontal machining centres

Product features:
- Base gives high stability and extreme accuracy for your machining
- Clamping force can be preset in 4 to 11 increments. At most, two revolutions are required to reach the max. clamping force
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within a tolerance of less than 0.01 mm
- Individual adaptation to your machine (pallet, traverses and workpieces) is possible
- Four clamping points permit three-sided machining



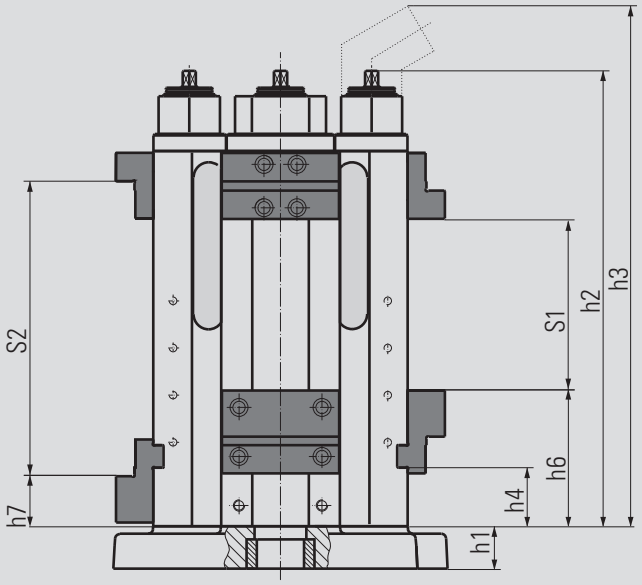
Important:
- Type 90: drive head with finer clamping force presetting for sensitive workpieces (11 increments)
- Type 125: drive head with clamping force presetting in 4 increments

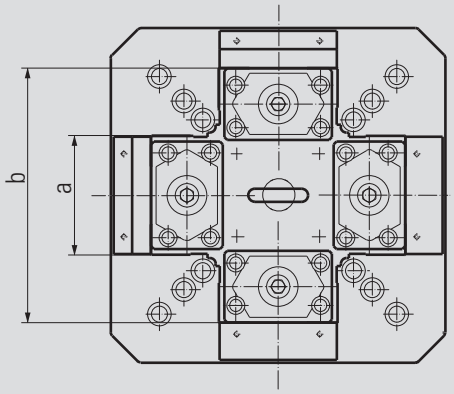
The monobloc, type 125, is also available with gripper spindle
(see TITAN 2 version, photos on p.90)

Order no.: on request

Scope of supply:
- Monobloc with step jaws
- 1 hand crank
- Socket screw wrench

An overview of the clamping jaws and other accessories is given in the section: Accessories ALLMATIC NC – mechanical / TC.





Technical data

Jaw width		90	125
Dimensions in mm	a	90	126
	b	220	270
	h1	min. 45	min. 45
	h2	340	483
	h3	403	452
	h4	39	62
	h6	97	144
	h7	37	53

Jaw width	90	125
Clamping range S1 in mm	0 – 126	0 – 182
Clamping range S2 in mm	91 – 217	131 – 313
Clamping force levels	11	4
Max. clamping force in kN	28	40

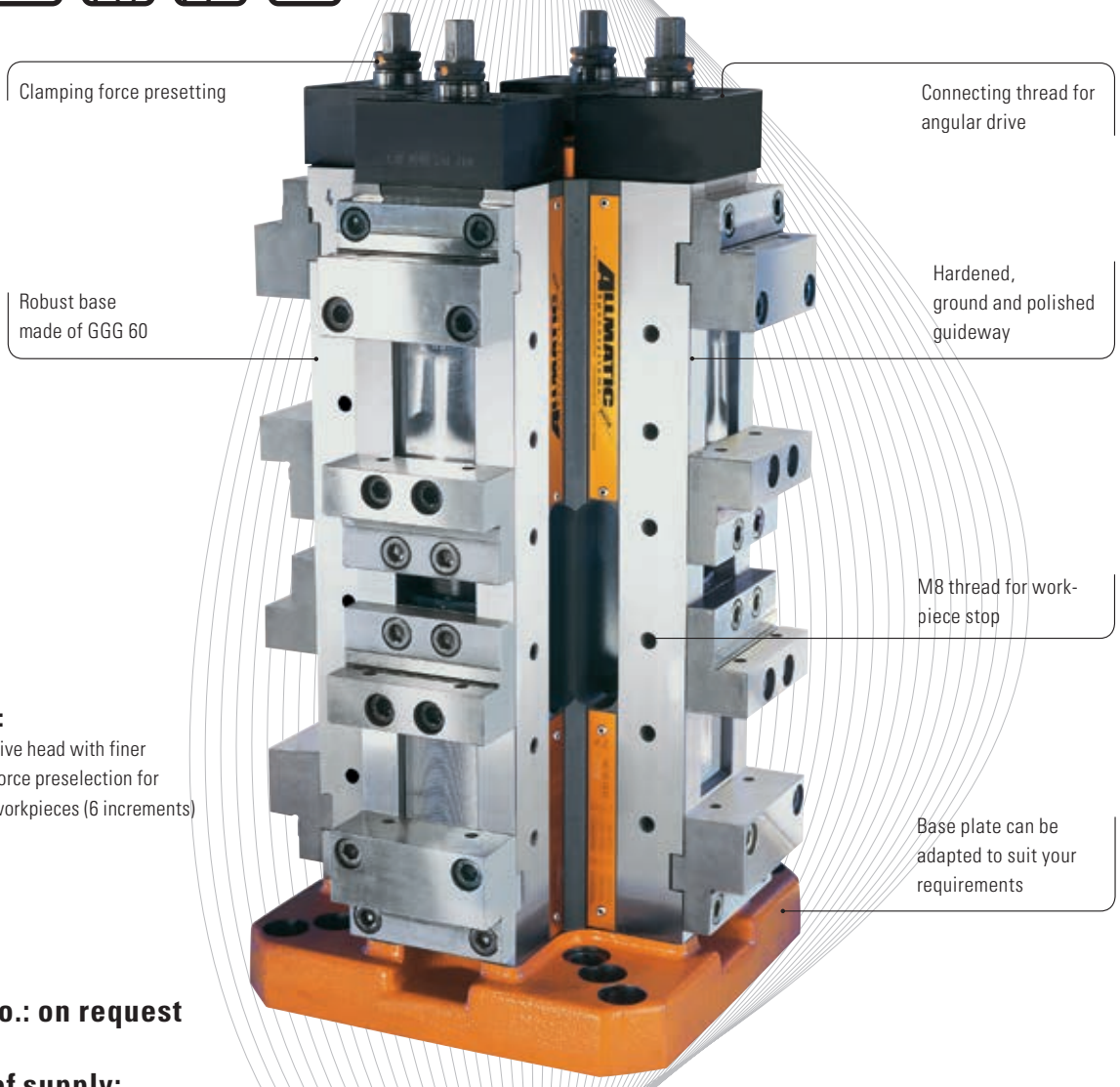
MONOBLOC – 4 x 90° DUO 90

Scope of application:

- Modular clamping system for horizontal machining centres

Product features:

- Base gives high stability and extreme accuracy for your machining
- Clamping force can be preset in 4 to 6 increments At most, two revolutions are required to reach the max. clamping force
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within a tolerance of less than 0.01 mm
- Individual adaptation to your machine (pallet, traverses and workpieces) is possible
- Eight clamping points permit Three-sided machining



Important:

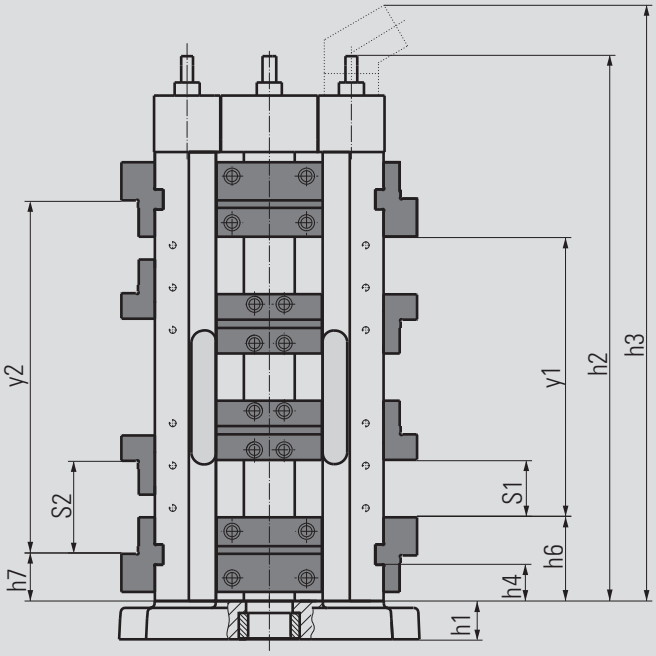
- Type 90: drive head with finer clamping force preselection for sensitive workpieces (6 increments)

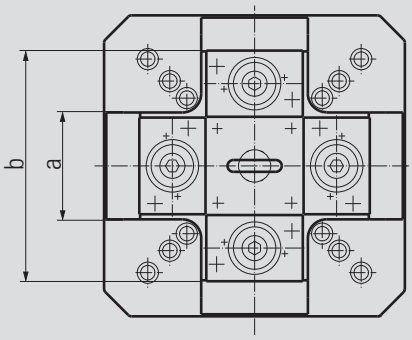
Order no.: on request

Scope of supply:

- Monobloc with step jaws
- 1 hand crank
- Socket screw wrench

An overview of the clamping jaws and other accessories is given in the section: Accessories ALLMATIC NC – mechanical / DUO.





As an alternative to the star set-ups (see customised solutions), we offer the monobloc 4 x 90° DUO with a larger square dimension:

Technical data

Jaw width		90
Dimensions in mm	a	90
	b (square dimension)	**220**
	h1	min. 45
	h2	482
	h3	547
	h4	30
	h6	72
	h7	47
	y1	256
	y2	306

Jaw width	90
Clamping range S1 in mm	0 – 64
Clamping range S2 in mm	56 – 120
Clamping force increments	6
Max. clamping force in kN	28

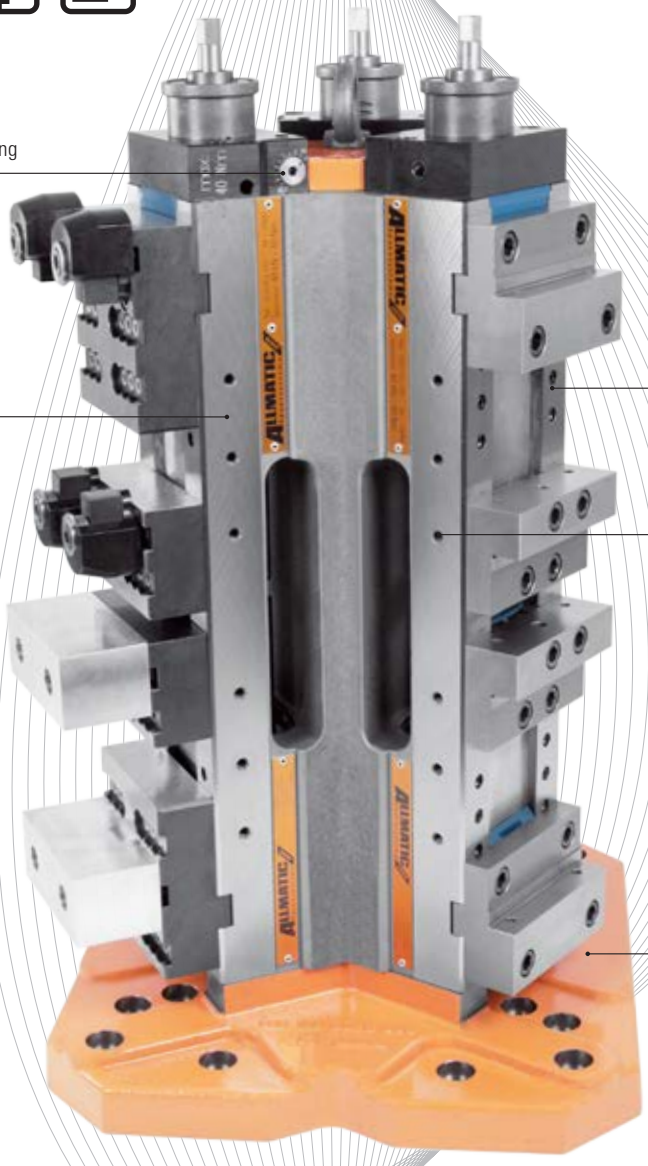
Jaw width		90
Dimensions in mm	a	90
	b (square dimension)	**326**
	h1	min. 45
	h2	482
	h3	547
	h4	30
	h6	72
	h7	47
	y1	256
	y2	306

Jaw width	90
Clamping range S1 in mm	0 – 64
Clamping range S2 in mm	56 – 120
Clamping force increments	6
Max. clamping force in kN	28

MONOBLOC –
3 x 120° DUO PLUS 125

Scope of application:
- Modular clamping system for horizontal machining centres

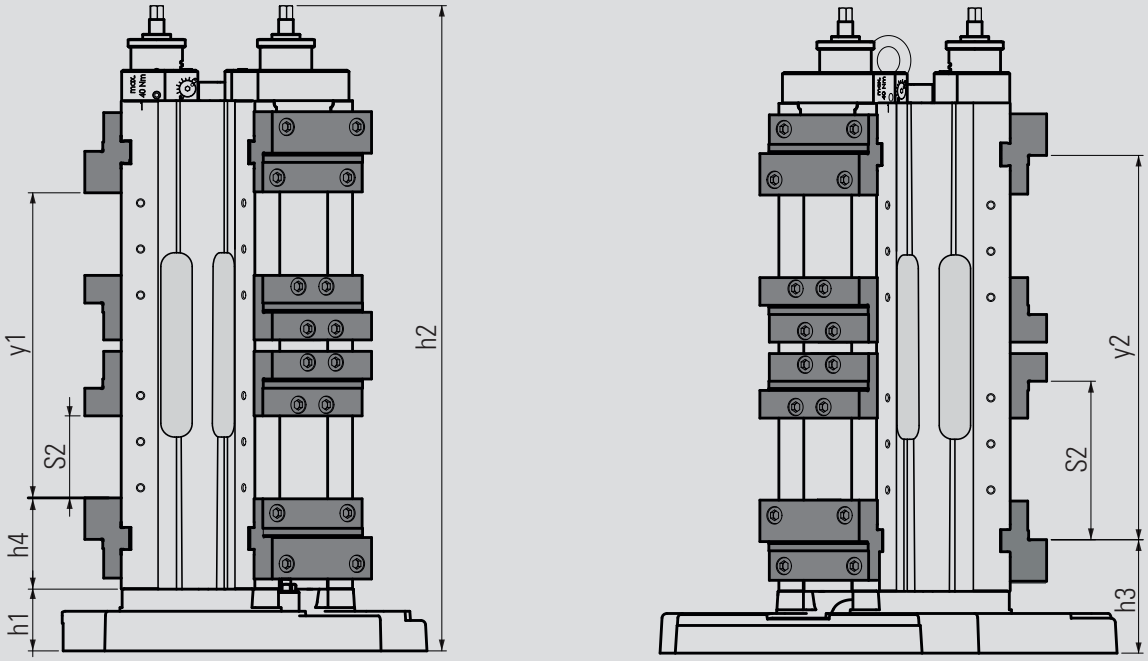
Product features:
- Base gives high stability and extreme accuracy for your machining
- Clamping width adjustment for clamping two workpieces of different sizes
- Reproducible clamping forces enable excellent repeating accuracy of the workpiece position
- Individual adaptation to your machine (pallet, traverses and workpieces) is possible
- Six clamping points

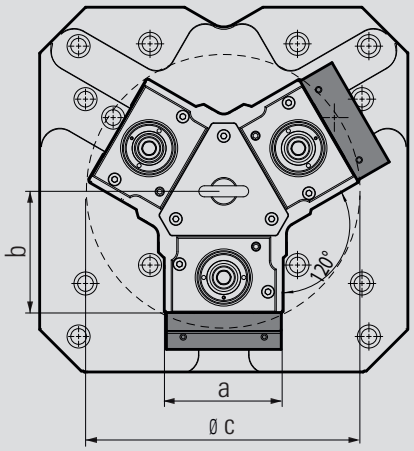


Order no.: on request

Scope of supply:
- Monobloc without jaws
- 1 hand crank
- Socket screw wrench

Note:
Delivery does not include a torque wrench. An overview of the clamping jaws and other accessories is given in the section: Accessories ALLMATIC NC – mechanical / DUO Plus.





Technical data

Jaw witdh		125
Dimensions in mm	a	126
	b	132
	c (swing circle)	dia. 300
	h1	67
	h2	700
	h3	123
	h4	99
	y1	331
	y2	417

Jaw width with step jaws	125
Clamping range S1 in mm	0 – 89*
Clamping range S2 in mm	43 – 172*
Max. clamping force in kN	28

* When using step jaws without clamping width adjustment

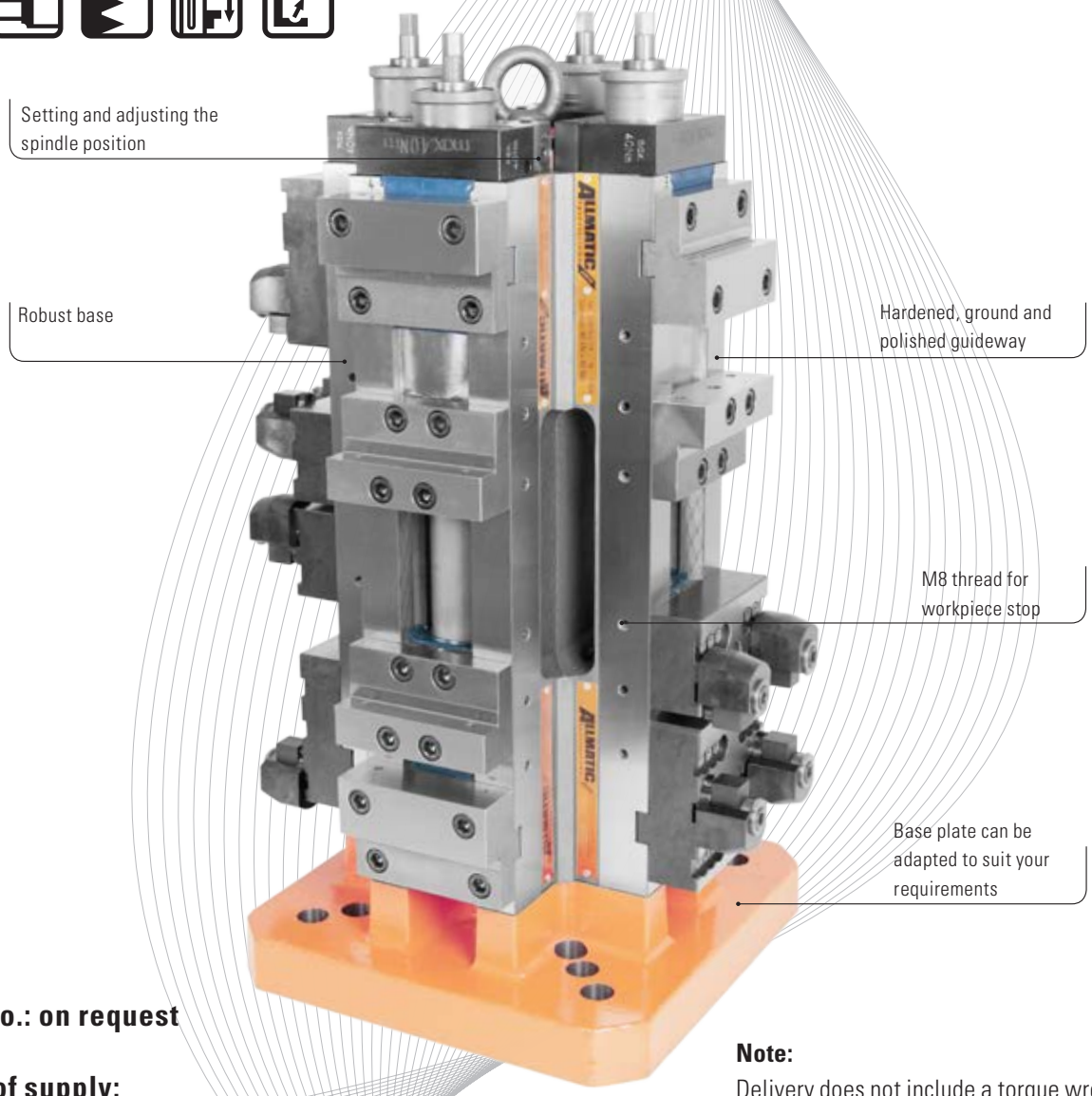
MONOBLOC – 4 x 90° DUO PLUS 125

Scope of application:

- Modular clamping system for horizontal machining centres

Product features:

- Base gives high stability and extreme accuracy for your machining
- Clamping width adjustment for clamping two workpieces of different sizes
- Reproducible clamping forces enable excellent repeating accuracy of the workpiece position
- Individual adaptation to your machine (pallet, traverses and workpieces) is possible
- Eight clamping points



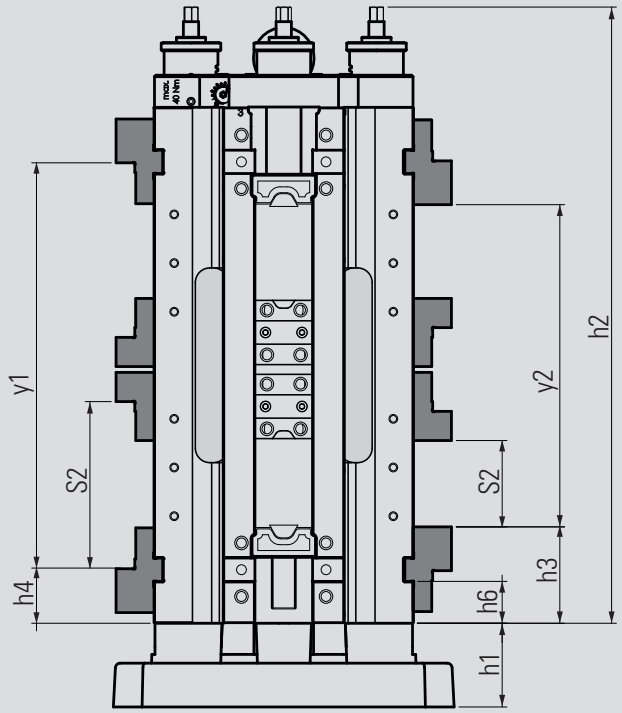
Order no.: on request

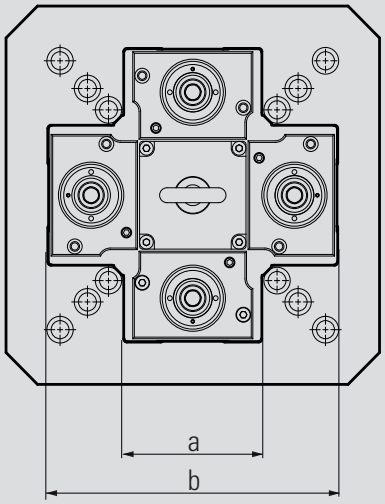
Scope of supply:

- Monobloc without jaws
- 1 wrench socket WS 14
- 3 socket screw wrenches

Note:

Delivery does not include a torque wrench.
An overview of the clamping jaws and other accessories is given in the section:
Accessories ALLMATIC NC – mechanical /DUO Plus.





As an alternative to the star set-ups (see customised solutions), we offer the monobloc 4 x 90° DUO Plus with a larger square dimension:

Technical data

Jaw width		125
Dimensions in mm	a	126
	b (square dimension)	**270**
	h1	min. 86
	h2	633
	h3	99
	h4	56
	h6	43
	y1	417
	y2	331

Jaw width with step jaws	125
Clamping range S1 in mm	0 – 89 *
Clamping range S2 in mm	43-172 *
Max. clamping force in kN	40

Jaw width		125
Dimensions in mm	a	126
	b (square dimension)	**360**
	h1	min. 86
	h2	633
	h3	99
	h4	56
	h6	43
	y1	417
	y2	331

Jaw width with step jaws	125
Clamping range S1 in mm	0 – 89 *
Clamping range S2 in mm	43-172 *
Max. clamping force in kN	40

* When using step jaws without clamping width adjustment

The DUO Plus 125 monobloc offers a huge number of clamping possibilities (see DUO Plus p. 122).
For exact details on the resulting clamping widths, see our clamping width calculator at:

www.allmatic.de

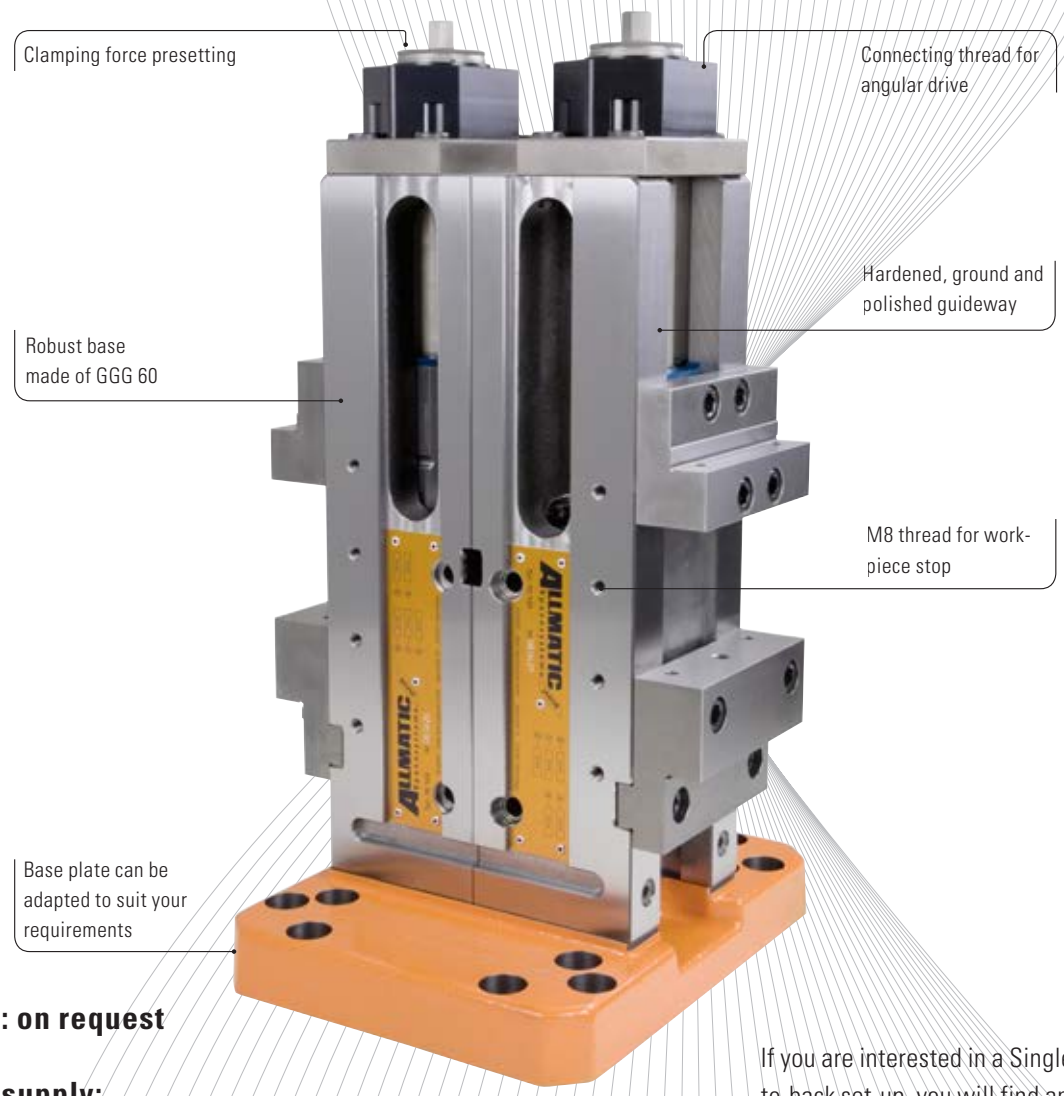
BACK-TO-BACK SET-UP

Scope of application:

- Modular clamping system for horizontal machining centres

Product features:

- Comprises standard Single (TC series) or DUO vices
- Clamping force increments can be preset. At most, two revolutions are required to reach the max. clamping force
- Preselectable and reproducible clamping forces enable the workpiece position to be repeated within a tolerance of less than 0.01 mm
- Individual adaptation to your machine (pallet, traverses and workpieces) is possible
- Two or four clamping points permit 3-sided machining



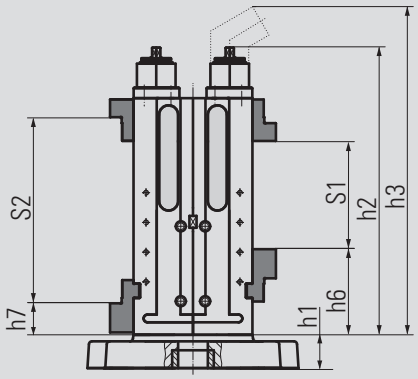
Order no.: on request

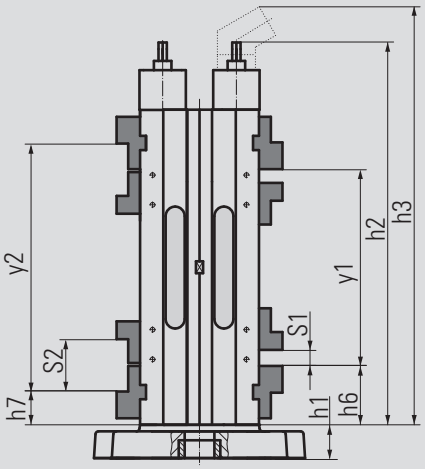
Scope of supply:

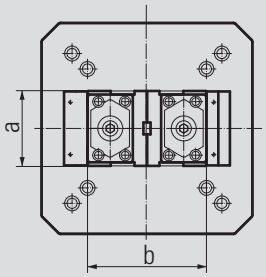
Back-to-back set-up Single / DUO

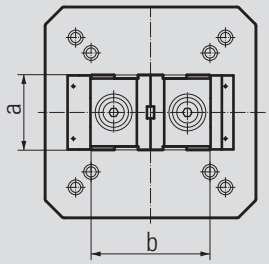
- 1 back-to-back set-up Single / DUO
- 1 hand crank
- Socket screw wrench

If you are interested in a Single or DUO back-to-back set-up, you will find an overview of the clamping jaws and other accessories in the respective section: Accessories ALLMATIC NC – mechanical / TC or DUO.









Technical data

Jaw width Single		90	125	160	200
Dimensions in mm	a	90	125	160	200
	b	160	200	230	280
	h1	min. 45	min. 45	min. 45	min. 74
	h2	340	483	615	615
	h3	403	552	683	683
	h6	97	144	164	164
	h7	37	53	56	56

Jaw width		DUO 90	DUO Plus 125
Dimensions in mm	a	90	125
	b	160	200
	h1	min. 45	min. 86
	h2	482	633
	h3	547	–
	h6	72	99
	h7	47	56
	y1	256	331
	y2	306	417

Type	90	125	160	200
Clamping range S1 in mm	0 – 126	0 – 182	17 – 263	17 – 263
Clamping range S2 in mm	91 – 217	131 – 313	189 – 435	189 – 435
Clamping force increments	11	4	4	4
Max. clamping force in kN	28	40	60	80

Type	DUO 90	DUO Plus 125
Clamping range S1 in mm	0 – 64	0 – 89 *
Clamping range S2 in mm	56 – 120	43-172 *
Clamping force increments	6	–
Max. clamping force in kN	28	40

* When using step jaws without clamping width adjustment

The DUO Plus 125 back-to-back set-up offers a huge number of clamping possibilities.
For exact details on the resulting clamping ranges, see our clamping range calculator at:

www.allmatic.de

CUSTOMISED SOLUTIONS – APPLICATION EXAMPLES

1.

2.

3.

4.

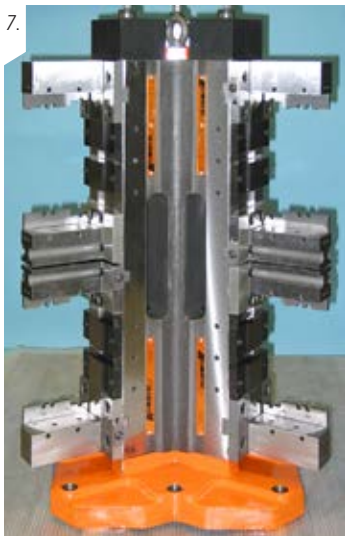
5.

6.

Application examples

1. Monobloc DUO 125 4 x 90° with reduced-width special jaws and floating centre jaw (sixteenfold clamping)
2. Monobloc DUO 125 4 x 90° special version: stacked mounting of 40 workpieces
3. Monobloc Single 90 4 x 90° with reduced-width special jaws for manufacturing small workpieces
4. Monobloc DUO 125 4 x 90° special version for machining complex castings
5. Monobloc DUO 125 4 x 90° with special jaws
6. 6-fold set-up DUO 125 on double-angle tower

7.



8.

9.

10.

11.

12.

Application examples

7. Monobloc DUO 125 3 x 120° with special clamping jaws for machining valve housings
8. 4-fold set-up TC 160 with extension on the double-angle for machining very large workpieces
9. Monobloc DUO 125 4 x 90° with reduced-width special jaws for 1st and 2nd clamping
10. Star set-up Single 160 4 x 90° on grid body with extended vice base, special jaws with positioning bolt
11. Wide variety of clamping possibilities with the DUO Plus 125 as a monobloc with step jaws, support jaws with the universal gripper set and soft inserts.
12. Monobloc Single TITAN 2 125 3 x 120° with pull-down jaw system and workpiece (pump case)

AUTOMATABLE WORKHOLDING

Flexible, precise and very easy to operate –
hydraulic vices from ALLMATIC.
Ideal for batch production.

ALLMATIC
Spannsysteme

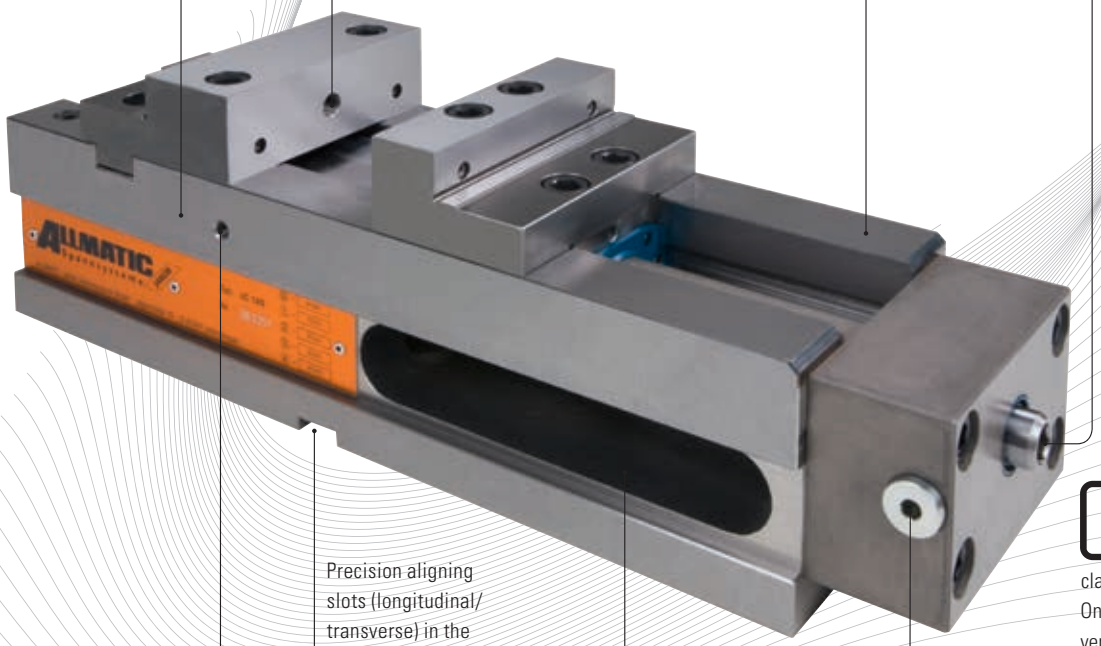
ALLMATIC NC – HYDRAULIC LCH VERSION

Scope of application:

- Horizontal installation – suitable for vertical CNC-controlled milling machines
- For automation of machining centres – particularly suitable for batch production
- The hydraulic spindle also enables the use of support jaws with which a wide range of unmachined parts, from flame-cut and sawn materials through to complex castings, can be clamped securely and economically. Suitable for materials with a strength of up to approx. 1000 N/mm².

Product features:

- Extreme accuracy for your machining
- The clamping force is generated via the pressure from a hydraulic unit with a hydraulic clamping stroke of up to 4.5 mm
- The clamping force is steplessly adjusted by regulating the hydraulic pressure on the hydraulic unit. A hand crank is provided for coarse adjustment of the clamping range
- The spindle contains a single-acting hydraulic piston and an additional Belleville spring assembly



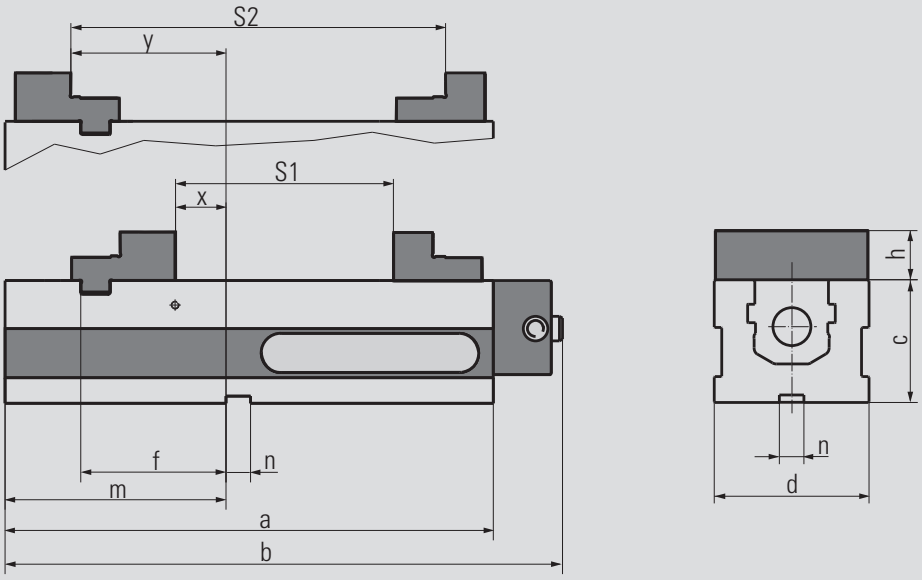
Order no. jaw width

90:	6921678000655
125:	6921688000655
160:	6921708000655

Scope of supply:

- 1 high-pressure vice with step jaws
- 1 hand crank
- 4 side clamps
- 1 socket screw wrench
- 1 compensation jaw for clamping range from 0 mm – only LCH 160

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



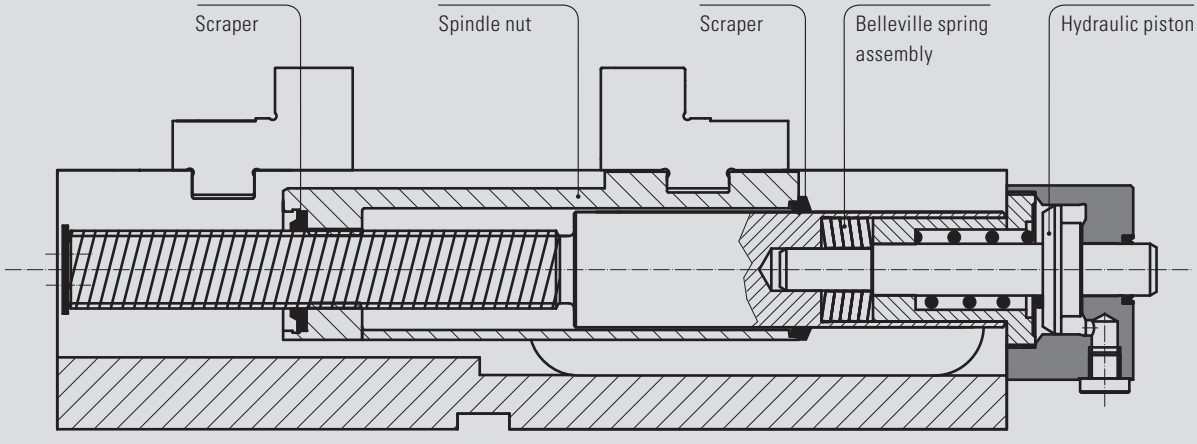
Technical data

Jaw width		90	125	160
Dimensions in mm	a	283	398	530
	b	340	456	596
	c	80	100	115
	d	90	126	164
	f	73	118	164
	h	34	39.5	49.8
	m	112	180	234
	n	20	20	20
	x	15	36	70
	y	75	127	178

Jaw width	90	125	160
Clamping range S1 in mm	0 – 126	0 – 182	(0) 17 – 263
Clamping range S2 in mm	91 – 217	131 – 313	187 – 433
Hydraulic movement in mm	4.5	4.5	4.5
Max. clamping force in kN	24	40	60
At hydr. pressure in bar	240	240	240
Weight in kg	15	35	56

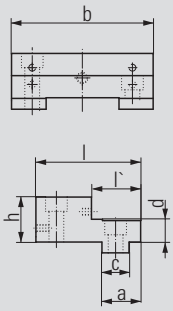
• Clamping width 0 can be reached using the compensation jaw

Spindle cross-section

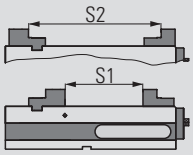


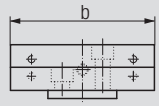
ALLMATIC NC – hydraulic / LCH version (accessories)

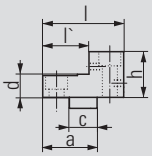
Step jaws



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





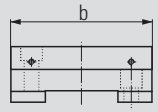


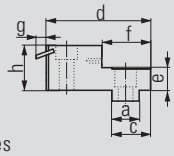
Jaw width	90	125	160
Clamping range S1	0 – 126	0 – 182	17 – 263
Clamping range S2	91 – 217	131 – 313	187 – 433

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

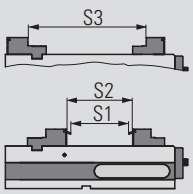
Jaw width				
movable		90	125	160
Ord. no.:		6921474002731	6921484002731	6921304002731
Dimensions in mm	a	38	47	63
	b	89,5	124,4	160,4
	c	20	24	30
	d	16	20	25
	h	34	39,5	49,8
	l	56	70	96
	l`	31	40	64

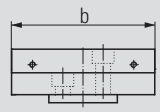
Pull-down jaws

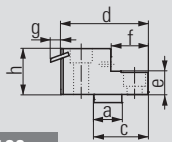




- Material: hardened steel
- Pull-down with ground and polished spring leaves for machined and unmachined clamping surfaces
- Ground and polished clamping surfaces
- High clamping accuracy for parallel and accurate angle machining
- Click system on the high side







Jaw width	90	125	160
Clamping range S1	0 – 100	0 – 157	0 – 238
Clamping range S2	0 – 117	0 – 175	17 – 256
Clamping range S3	87 – 209	125 – 303	178 – 420

Jaw width				
fixed		90	125	160
Ord. no.:		6921674106031	6921684106031	6921704109031
Dimensions in mm	a	20	24	30
	b	89,5	124,4	160,4
	c	30	34	40
	d	69	92	104
	e	16	20	25
	f	37	43	54
	g	8,8	8,8	8,8
	h	34	39,5	49,8

Jaw width				
movable		90	125	160
Ord. no.:		6921674102031	6921684102031	6921704102031
Dimensions in mm	a	20	24	30
	b	89,5	124,4	160,4
	c	48	46,5	63
	d	62	75	101
	e	16	20	25
	f	24,5	32	51
	g	8,8	8,8	8,8
	h	34	39,5	49,8

ALLMATIC NC – hydraulic / LCH version (accessories)

Spring leaves (pair)

Order no. jaw width 90: 6921884103031

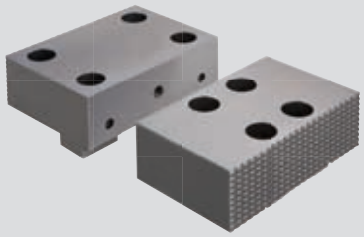
- Hardened spring leaves
- Spring leaves (spare) for pull-down jaws Type 90 (see left)

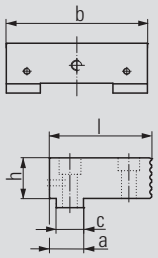
Spring leaves (pair)

Order no. jaw width 125: 6921684103031
160: 6921704103031

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

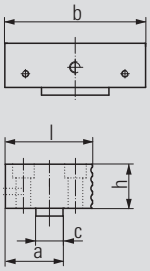
Hard basic jaws



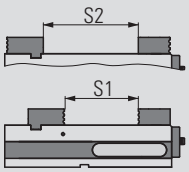


- Material: hardened steel
- One side smooth, ground and polished; one side serrated
- Additional thread for parallels and for mounting HD jaws on the smooth side
- Mounts for Click system on both sides of the jaw

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



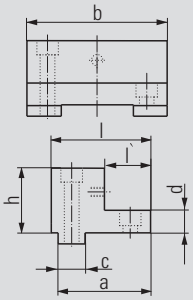
Jaw width				
movable		**90**	**125**	**160**
Ord. no.:		**6921674004731**	**6921684004731**	**6921704004731**
Dimensions in mm	a	40	50	65
	b	89,5	124,4	160,4
	c	20	24	30
	h	34	39,5	49,8
	l	60	76	100



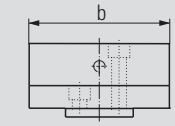
Clamping range S1	0 – 120	0 – 173	20 – 256
Clamping range S2	32 –150	50 – 225	70 – 310

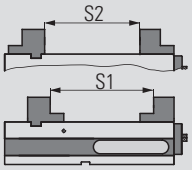
ALLMATIC NC – hydraulic / LCH version (accessories)

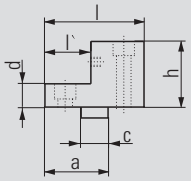
Master jaw adapters



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





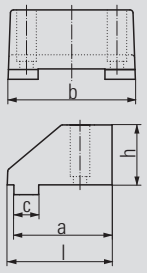


Jaw width	90	125	160
Clamping range S1	67 – 183	71 – 243	90 – 330
Clamping range S2	28 – 149	47 – 224	70 – 310

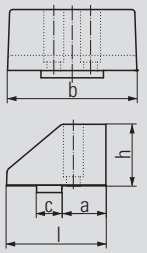
Jaw width				
fixed		90	125	160
Ord. no.:		6921674012231	6921684012231	6921704012231
Dimensions in mm	a	56	77	89
	b	90	126	164
	c	20	24	30
	d	16	20	24
	h	46	58	73
	l	66	85	100
	l`	30	32	34

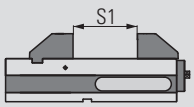
Jaw width				
movable		90	125	160
Ord. no.:		6921274011231	6921284011231	6921304011231
Dimensions in mm	a	40	52	65
	b	90	126	164
	c	20	24	30
	d	16	20	24
	h	46	58	73
	l	60	80	100
	l`	30	32	34

Soft jaws



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





Order no. fixed: 6921684088031

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

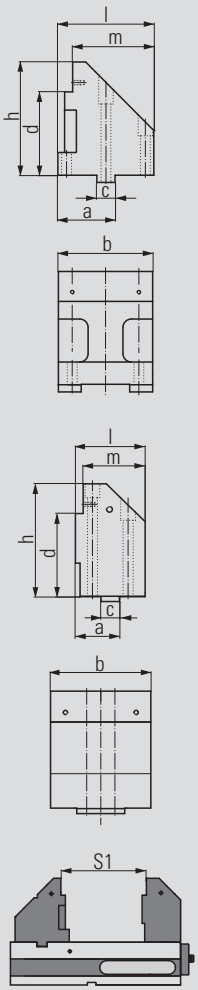
Order no. movable: 6921484087031

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

Clamping range S1	0 – 150

ALLMATIC NC – hydraulic / LCH version (accessories)

High jaws



- Material: hardened steel
- Particularly suitable for 5-sided machining
- Better accessibility for tools
- Ground and polished clamping surfaces
- Additional thread for parallels

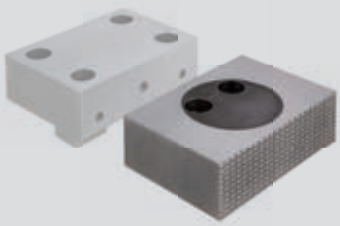
Order no. fixed: 6921684047031

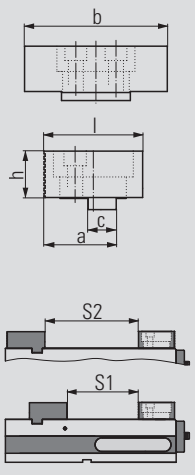
Jaw width		125
Dimensions in mm	a	75.5
	b	124.4
	c	24
	d	110
	h	149.5
	l	126.7
	m	107.2

Order no. movable: 6921684048031

Jaw width		125
Dimensions in mm	a	57
	b	124.4
	c	24
	d	110
	h	149.5
	l	90
	m	80
Clamping range S1		26 – 208

Pivot jaw, movable





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

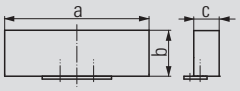
Order no. jaw width 90: 6921674020142
125: 6921684020042
160: 6921704020042

Jaw width		90	125	160
Dimensions in mm	a	49.5	62	86
	b	90	124.4	160.4
	c	20	24	30
	h	34	39.5	49.8
	l	68	84	118
Clamping range S1		0 – 110	0 – 161	0 – 235
Clamping range S2		22 – 140	38 – 213	50 – 290

ALLMATIC NC – hydraulic / LCH version (accessories)

Soft jaw

Order no. 6921684023042

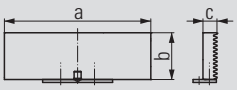


Jaw width		125
Dimensions in mm	a	125
	b	39.8
	c	22

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

Jaw with cross grooving

Order no. 6921684032040

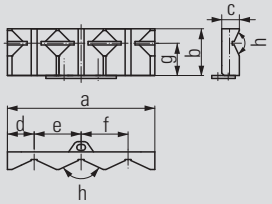


Jaw width		125
Dimensions in mm	a	125.6
	b	40.1
	c	12

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

Prismatic jaws (pair)

Order no. 6921684024042



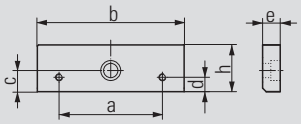
Jaw width		125
Dimensions in mm	a	125.6
	b	39.8
	c	15
	d	22.8
	e	40
	f	40
	g	27.5
	h	130°

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

ALLMATIC NC – hydraulic / LCH version (accessories)

Compensation jaw

Order no. jaw width 160: 6921704022031

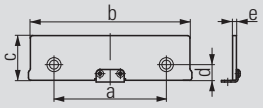


Jaw width		160
Dimensions in mm	a	88
	b	160.4
	c	20
	d	12.25
	e	18
	h	49.8

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

Click parallels (pair)

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

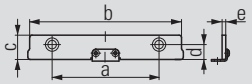


Jaw width		90	125	160
Dimensions in mm	a	48	88	88
	b	90	125	160
	c -0.01	29	35	44
	d	8.75	12.25	12.25
	e	3	3	3

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

Click parallels (pair)

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



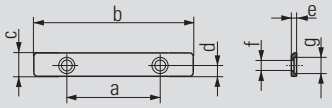
Jaw width		90	125	160
Dimensions in mm	a	48	88	88
	b	90	125	160
	c -0.01	16	20	25
	d	8.75	12.25	12.25
	e	3	3	3

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

ALLMATIC NC – hydraulic / LCH version (accessories)

Parallels (pair)

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

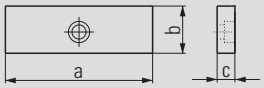


Jaw width		90	125	160
Dimensions in mm	a	52	88	88
	b	89	124	160
	c	13	15	19
	d	6	6	6
	e	3	3	3
	f	Ø 6	Ø 6	Ø 6
	g	Ø 9	Ø 9	Ø 9

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

Smooth jaws (pair)

Order no. jaw width 125: 6921024022031
160: 6921034022031

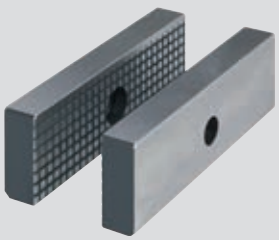


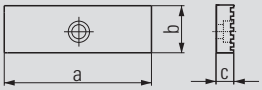
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

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

Serrated jaws (pair)

Order no. jaw width 125: 6921021005031
160: 6921031005031





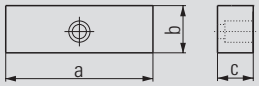
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

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

ALLMATIC NC – hydraulic / LCH version (accessories)

Soft jaws (pair)

Order no. jaw width 125: 6921024023031
160: 6921034023031

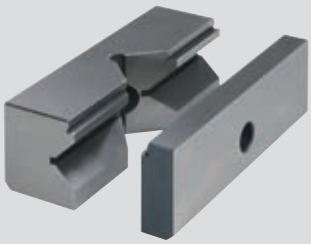


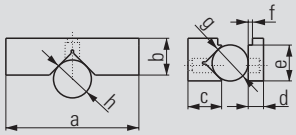
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	25	30

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

Prismatic jaws (set)

Order no. jaw width 125: 6921024024031
160: 6921034024031



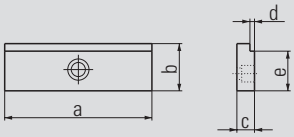


Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	35	45
	d	15	20
	e	35	45
	f	3	3
	g	Ø 12 – 28	Ø 15 – 40
	h	Ø 18 – 55	Ø 22 – 65

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

Step jaws (pair)

Order no. jaw width 125: 6921024025031
160: 6921034025031



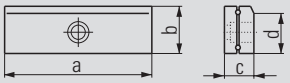
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20
	d	3	3
	e	35	45

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

ALLMATIC NC – hydraulic / LCH version (accessories)

Roller pull-down jaws (pair)

Order no. jaw width 125: 6921024005131
160: 6921034005131

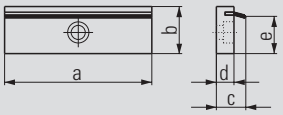


Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	26	35.5
	d	35	45

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

Spring leaf pull-down jaws (pair)

Order no. jaw width 125: 6921024001042
160: 6921034001042



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

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

Spring leaves (pair)

Order no. jaw width
125: 6921024002131
160: 6921034002131

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

Jaw fixing bolt

Order no. 6921011023000

Bolt with shoulder – M10 x 23

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

ALLMATIC NC – hydraulic / LCH version (GRIPP clamping accessories)

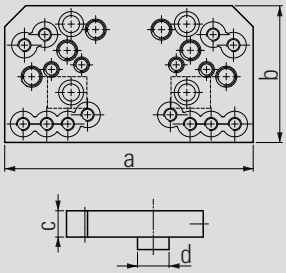
Support jaws

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

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

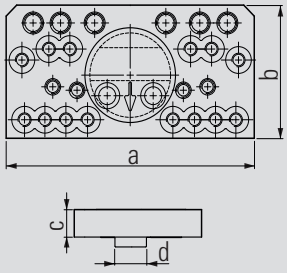
You will find dimensions of the individual gripper items and the gripper studs at www.allmatic.de

Order no. fixed:
6921734005842



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

Order no. movable, pivoting:
6921734072842



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

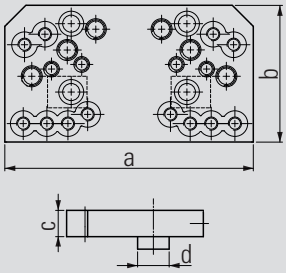
Please order universal gripper set or gripper studs separately

Support jaws

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

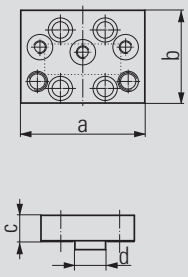
You will find dimensions of the individual gripper items and the gripper studs at www.allmatic.de

Order no. fixed:
6921734005842



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

Order no. movable, rigid:
6921884004842

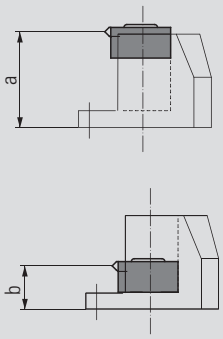


Jaw width		125
Dimensions in mm	a	97
	b	73
	c	20
	d	24

Please order universal gripper set or gripper studs separately

ALLMATIC NC – hydraulic / LCH version (GRIPP clamping accessories)

Universal gripper set



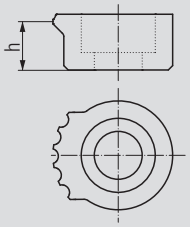
Order no. 6921884027031

Jaw width		125
Dimensions in mm	a	40
	b	18

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

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

Gripper stud

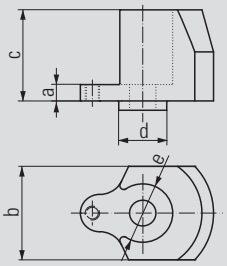


Order no. 6921884026000

Dimensions in mm	h	11

- Gripper stud for universal gripper set

Gripper stud mount

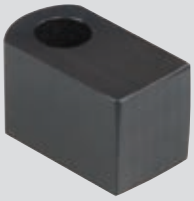


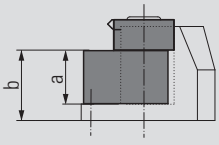
Order no. 6921884027000

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

- Mount for gripper stud 2306/001

Support





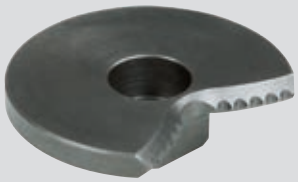
Order no. 6921884028000

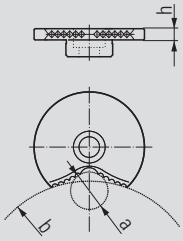
Dimensions in mm	a	22
	b	29

- Support for universal gripper set

ALLMATIC NC – hydraulic / LCH version (GRIPP clamping accessories)

Prismatic gripper



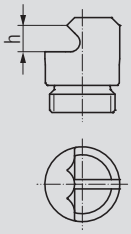


Order no. 6921884029031

Dimensions in mm	a	Ø 20
	b	Ø 120
	h	6

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

Gripper stud, pointed

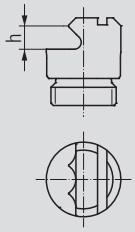


Order no. 6921884036000

Dimensions in mm	h	5.5

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

Gripper stud, low-level

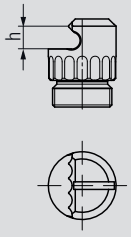


Order no. 6921884036100

Dimensions in mm	h	5

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

Gripper stud, four-point

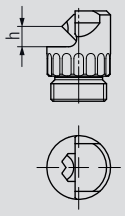


Order no. 6921884036500

Dimensions in mm	h	5,4

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

Gripper stud, carbide coated



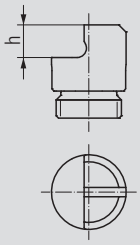
Order no. 6921884036841

Dimensions in mm	h	5,1

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

ALLMATIC NC – hydraulic / LCH version (GRIPP clamping accessories)

Clamping insert, smooth

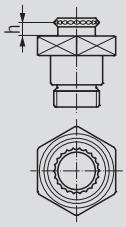


Order no. 6921884037000

Dimensions in mm	h	7

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

Gripper stud, round

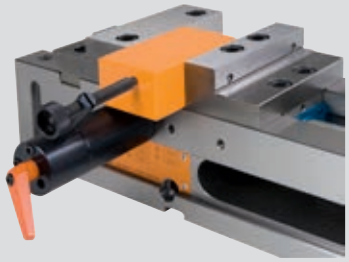


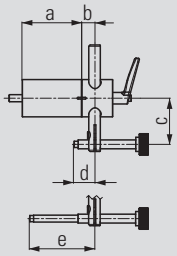
Order no. 6921884038000

Dimensions in mm	h	4

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

Workpiece stop



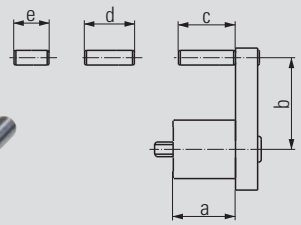


Order no. 6921285650144

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

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

Workpiece stop



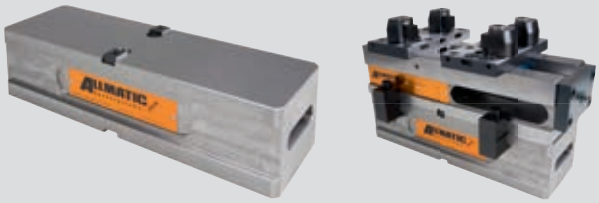
Order no. 6921685670042

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

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

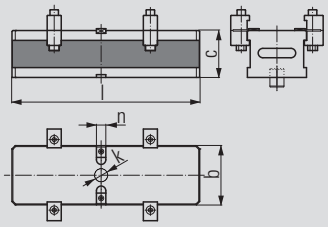
ALLMATIC NC – hydraulic / LCH version (GRIPP clamping accessories)

XL console



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

Order no. 6921885010042



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

Hand crank

Bestell-Nr. 6923015000142

Jaw width		90 - 160
Dimensions in mm	a	147
	SW	12

- Hand crank for the series NC-LCH hydraulic (90mm - 160mm)

Side clamps (pair)

Order no. 6921025000031

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

DUO side clamps

Order no. 6921285000031

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

Aligning and fixing set

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

Order no. – see table

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

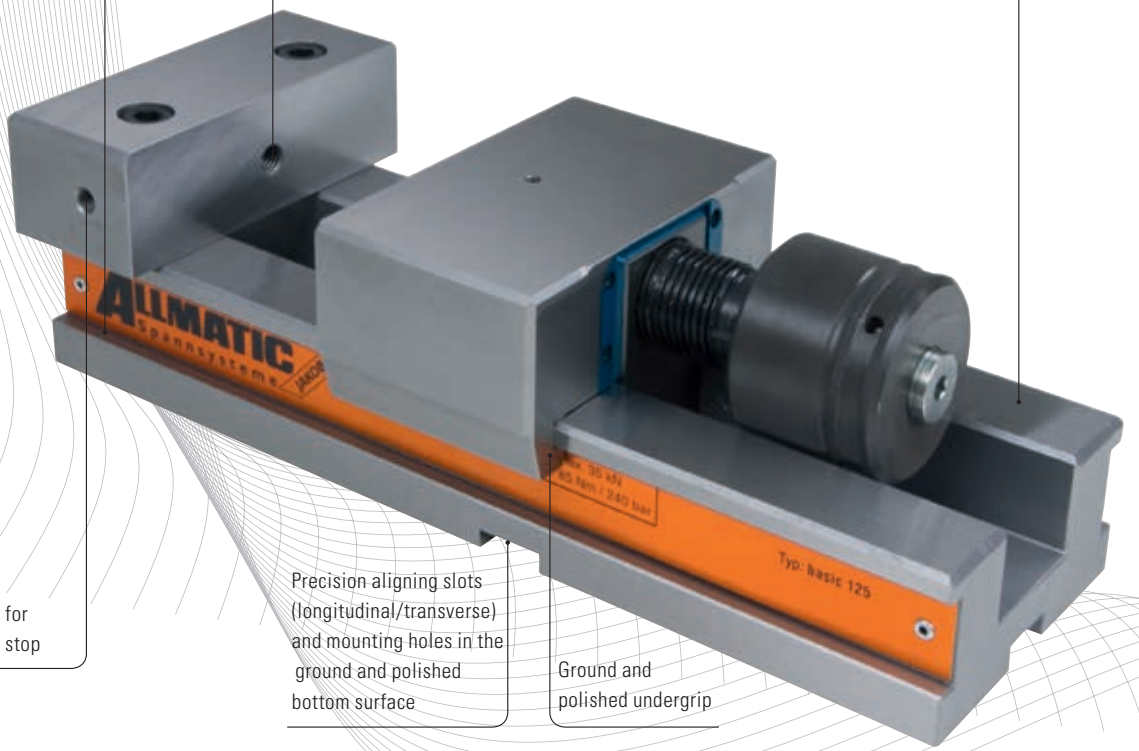
ALLMATIC basic – HYDRAULIC

Scope of application:

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

Product features :

- Excellent ease of operation guarantees optimal handling in every situation
- Fast adjustment for clamping range preselection
- The clamping force is generated and preset via the hydraulic pressure of a hydraulic unit
- Integrated scrapers ensure functional reliability and minimise cleaning
- Fixing on the machine table by means of mounting holes in the vice base. Additional holes can be made in the soft middle section of the vice base
- Optional centre jaw allows two or more workpieces to be clamped
- Coarse adjustment is performed by turning the spindle. The residual stroke of up to 4.5 mm is performed via a hydraulic unit with spring reset by means of a single-acting cylinder

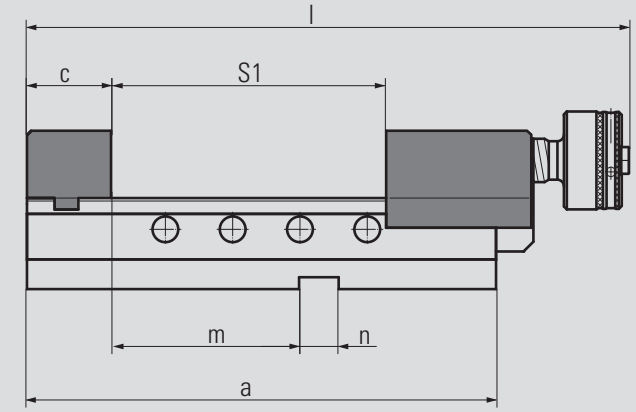


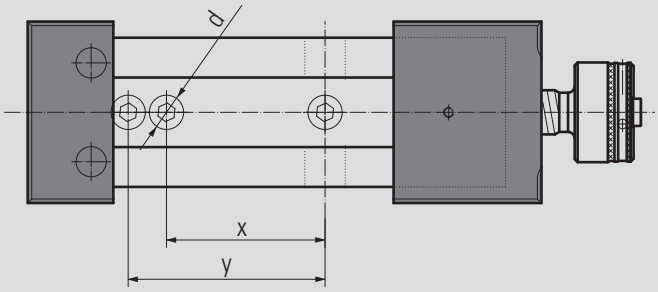
Order no. jaw width 125: 6921188000655
160: 6921208000655

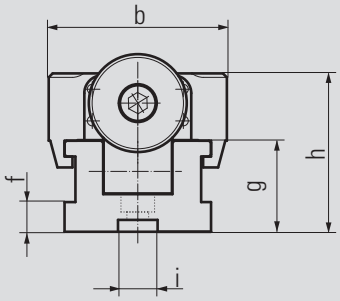
Scope of supply:

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

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







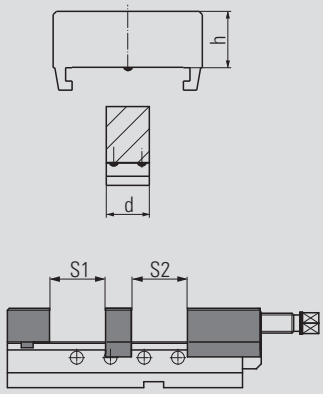
Technical Data

Jaw width		125	160
Dimensions in mm	a	310	405
	b	124	160
	c	50	66
	d	13	13
	f	15	15
	g	48	56
	h	87.5	105.5
	i	20	20
	l max	454	510
	m	120	128
	n	20	20
	x	100	100
	y	125	125

Jaw width	125	160
Clamping range S1 in mm	0 – 208	0 – 283
Hydraulic movement in mm	4.5	4.5
Max. clamping force in kN	35	50
At hydr. pressure in bar	240	220
Weight in kg	15	28

ALLMATIC basic – hydraulic (accessories)

Intermediate jaw

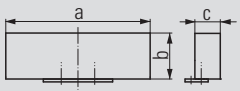


Order no. jaw width 125: 6921185024040
160: 6921205024040

Jaw width		125	160
Dimensions in mm	h	39.5	49.5
	d	33	41
Clamping range S1		0 – 87	0 – 121
Clamping range S2		0 – 87	0 – 121

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

Soft jaw

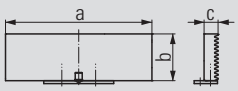


Order no. jaw width 125: 6921684023042

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

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

Jaw with cross grooving



Order no. jaw width 125: 6921684032040

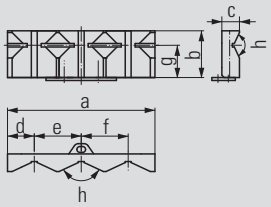
Jaw width		125
Dimensions in mm	a	125.6
	b	40.1
	c	12

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

ALLMATIC basic – hydraulic (accessories)

Prismatic jaws (pair)

Order no. jaw width 125: 6921684024042

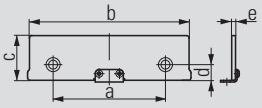


Jaw width		125
Dimensions in mm	a	125.6
	b	39.8
	c	15
	d	22.8
	e	40
	f	40
	g	27.5
	h	130°

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

Click parallels (pair)

Order no. jaw width 125: 6921185035042
160: 6921205044042

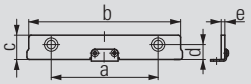


Jaw width		125	160
Dimensions in mm	a	88	88
	b	125	160
	c -0.01	35	44
	d	12.25	12.25
	e	3	3

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

Click parallels (pair)

Order no. jaw width 125: 6921185020042
160: 6921205025042



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

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

ALLMATIC basic –hydraulic (accessories)

Smooth jaws (pair)

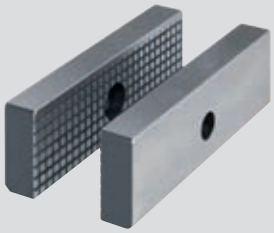
Order no. jaw width 125: 6921024022031
160: 6921034022031

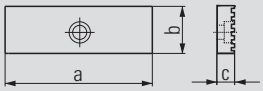
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

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

Serrated jaws (pair)

Order no. jaw width 125: 6921021005031
160: 6921031005031



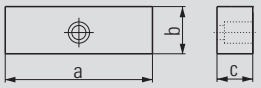


Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20

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

Soft basic jaws (pair)

Order no. jaw width 125: 6921024023031
160: 6921034023031



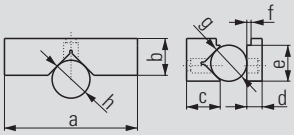
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	25	30

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

ALLMATIC basic – hydraulic (accessories)

Prismatic jaws (set)

Order no. jaw width 125: 6921024024031
160: 6921034024031

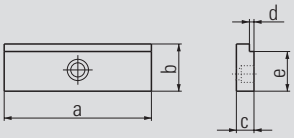


Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	35	45
	d	15	20
	e	35	45
	f	3	3
	g	Ø 12 – 28	Ø 15 – 40
	h	Ø 18 – 55	Ø 22 – 65

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

Step jaws (pair)

Order no. jaw width 125: 6921024025031
160: 6921034025031

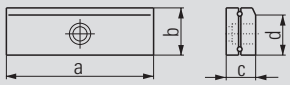


Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	15	20
	d	3	3
	e	35	45

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

Roller pull-down jaws (pair)

Order no. jaw width 125: 6921024005131
160: 6921034005131



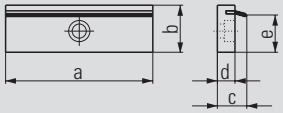
Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	26	35.5
	d	35	45

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

ALLMATIC basic –hydraulic (accessories)

Spring leaf pull-down jaws (pair)

Order no. jaw width 125: 6921024001042
160: 6921034001042



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

- Material: hardened steel
- For parts with rough clamping surfaces
- Spring leaves press the workpiece onto the support surface
- Spring leaves are interchangeable, see order no. 6921021005031 and 6921031005031 (see below)
- Please order fastening bolts separately (order no. 6921011023000)

Spring leaves (pair)

Order no. jaw width
125: 6921021001131
160: 6921031001131

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

Jaw fixing bolt

Order no. 6921011023000

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

Mechanical spindle kit

Order no. jaw width
125: 6922180000055
160: 6922200000055

- As spare spindle for basic mechanical

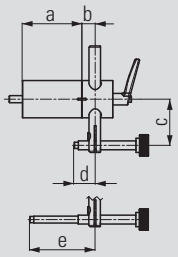
Hydraulic spindle kit

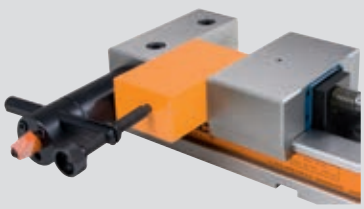
Order no. jaw width
125: 6922180000655
160: 6922200000655

- For retrofitting to hydraulic clamping system

Workpiece stop

Order no. 6921285650144



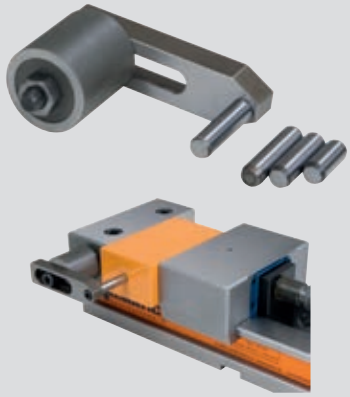


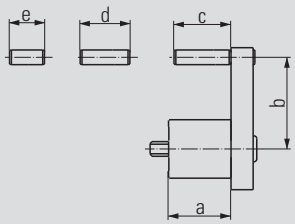
Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63.5
	e	53.5 – 113.5

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

ALLMATIC basic – hydraulic (accessories)

Workpiece stop





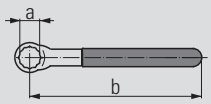
Order no. 6921685670042

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

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

Ring wrench

Order no. 0651110811210

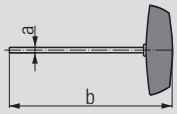


Dimensions in mm	a	SW 19
	b	192

- With grip sleeve made of soft plastic

T-wrench

Order no. 0651112010536



Dimensions in mm	a	SW 6
	b	182

- For adjusting the clamping range

Side clamps (pair)

Order no. 6921025000031

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

Suitable for the Series 125 mm up to 200 mm

Aligning and fixing set

Order no. – see table

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

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

Aligning and fixing set

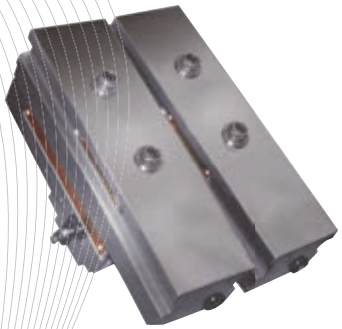
Order no. – see table

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

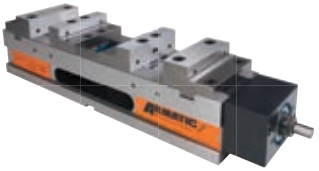
- For securing with side clamps
- For aligning (positioning) and securing the basic vices on the machine table
- Size according to T-slot in the machine table

ZERO-POINT CLAMPING SYSTEMS – IMPORTANT INFORMATION

All our NC-series high-pressure vices can be retrofitted with mounting holes for all standard zero-point clamping systems.
Please contact us!

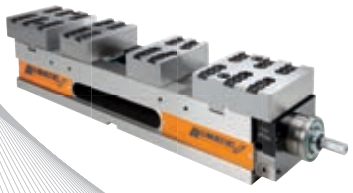


NC vice LC version



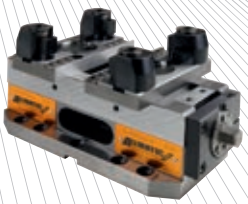
NC vice DUO 90 version

NC vice TC version

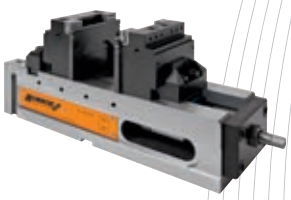


NC vice DUO Plus version

NC vice T-REX version



NC vice CENTRO Gripp version



Gripp vice TITAN 2 K-M-L version

STANDARD TERMS AND CONDITIONS OF DELIVERY, ASSEMBLY AND PAYMENT

§ 1 Conclusion of contract (general terms of contract, scope of delivery)

(1) Our deliveries, which also include services, suggestions, consultation and ancillary services, are made only on the basis of the Terms and Conditions laid out below. We hereby reject any contradictory or alternative terms and conditions of the Customer; they shall not be accepted even if we fail to reject them again after we have received them. Upon placement of the order, but at the latest upon acceptance of delivery, the Customer accepts these Terms and Conditions.

(2) Our offers are non-binding. Alterations and additions to the contract must be made in writing. This also applies to a decision to dispense with this requirement for written form.

(3) The rights of the Customer arising out of this Contract can only be transferred to third parties with our consent.

(4) The scope of delivery is in accordance with our written acknowledgement. We are only obliged to deliver in so far as it is possible to acquire the required raw materials, supplies and fuel with the relevant currency. Any reference to DIN (German Institute for Standardization) regulations is to be understood as a description of the contractual performance and not a warranty of specific characteristics. Drawings, illustrations, technical data, details of weight, dimensions and performance are meant only as a guide, unless they are expressly stated to be binding in the order acknowledgement. We retain rights of ownership and copyright to this documentation; third parties must not be granted access to it without our express authorisation.

§ 2 Prices

(1) Unless agreed otherwise, our quoted prices include loading ex works or warehouse, and excluding statutory value-added tax and all other packaging and freight costs, customs duties and transportation insurance premiums, which are to be charged to the Customer.

(2) Should the costs connected with the order increase substantially after conclusion of the contract, the contracting parties are obliged to agree an appropriate adjustment of the prices. If no agreement is reached, the contracting parties are entitled to withdraw from the contract. Any further claims are excluded.

§ 3 Payment terms

(1) Unless an alternative written agreement has been reached, payment is to be made without any deduction within 30 days.

(2) The withholding of payment or set-off against any possible counterclaims of the Customer that are disputed by us is not permissible. We are entitled, even contrary to the stipulation of the Customer, to set off his payments against another claim. Should the Customer default on payment to the sum of at least 10% of our overall claims against him, it shall be deemed agreed that:
All our claims shall become payable immediately. We shall be entitled to make the further processing of all orders from the Customer subject to an advance payment or the furnishing of security, or to refuse further fulfilment after the expiry of a reasonable set additional period.

§ 4 Time limits for delivery, acceptance and call-offs

(1) If delivery periods are agreed, these are to be calculated from the date on which the goods are made available ex works. Furthermore, they are only approximate. If the Customer does not fulfil his obligations, or if delivery is delayed as a result of unforeseeable or extraordinary events or events over which we have no control in our company or in any of our supplier or transport companies, then an appropriate extension of the delivery date shall be deemed agreed. The same applies in the case of strike or lock-out. Should the hindrance continue for longer than one month, we are entitled to withdraw from the contract. The delivery period begins on the date our order acknowledgement is issued, but not before all technical and commercial details have been settled. Any changes requested by the Customer in the execution of the product ordered have the effect of interrupting and extending the delivery date accordingly. Delays in returning documentation sent for approval also extend the delivery time.

(2) Should the Customer default on acceptance of goods or services offered to him in accordance with the terms of the contract, he will be required to reimburse our costs at a rate of 25% of the invoice value of the goods, beginning one month after notification that the goods are ready for dispatch, without proof of how such costs have been incurred or the extent of such costs. The Customer is entitled to prove that we have incurred no losses or considerably lower losses.

(3) We are entitled to otherwise dispose of the delivery goods after the granting and fruitless expiry of a reasonable period of time.

§ 5 Intellectual property rights

In the case of delivery on the basis of drawings, models or details supplied by the Customer, the Customer exempts us from all third-party rights. In the case of breach of contract by the Customer, his intellectual property rights shall not prevent our utilisation of the goods.

§ 6 Transfer of risk

All risk shall pass to the Customer as soon as the goods leave the supplier factory. If goods are taken back for reasons over which we have no control, then the Customer shall bear all risk until the goods are received by us.

§ 7 Warranty

(1) Standard trade tolerances with regard to dimensions, amounts, weight, grain size, quality, colour, etc., are not grounds for complaint by the Customer. In case of doubt, the weight established by us is applicable. In case of complaint, the specifications agreed with the Customer are applicable.

(2) Our technical advice and recommendations are based on appropriate examination, but are given without contractual obligation. In particular, checking whether the goods ordered or those suggested by us are suited to the purpose intended by the Customer is the sole responsibility of the Customer. A warranty of specific characteristics must always be given in writing. This also applies to any decision to dispense with the requirement for written form. The characteristics of the purchased object and the purpose for which it is intended are based solely upon our product description. Any other agreements reached must be confirmed in writing.

(3) Complaints must be made in writing no later than two weeks after receipt of the goods. Hidden defects must be reported immediately when they are discovered. We have a right to examine goods about which complaints are made. Should the Customer not permit this, his claims shall lapse. In the case of a justified complaint, the Customer's rights are restricted to supply of replacement goods free of charge and free of freight costs, or repair by us.

(4) Should repair or replacement fail, the Customer shall grant a reasonable additional period of time and can, after fruitless expiry of this period, demand either termination of the contract or reduction of the purchase price, at his option.
More far-reaching claims by the Customer, particularly to reimbursement of processing costs, costs of assembly and disassembly and for damage not affecting the object supplied, are excluded as far as legally permissible.

(5) If a partial delivery is defective, no rights in respect of the remaining partial delivery can be derived. We are entitled to refuse to fulfil claims based on defective performance as long as the Customer does not fulfil his obligations.

(6) The following circumstances do not constitute defects:
- damage resulting from normal wear and tear to wearing parts
- damage caused by improper handling, particularly as a result of inadequate maintenance or lack of maintenance
- damage caused by electrical connections in the building which do not conform to the regulations of the Federation of German Electrical Engineers (VDE)
- damage caused by a failure to observe our operating and maintenance instructions.

(7) In order that all repairs and replacement deliveries can be made which appear necessary to us in our fair judgment, the Customer must, after consultation with us, provide sufficient time and opportunity, otherwise we are released from liability for the defects. Only in the case of an emergency which endangers operational safety and to prevent disproportionately serious damage, in which case we must be informed immediately, or if we are in default regarding the rectification of defects, does the Customer have the right to rectify the fault himself or to have the fault rectified by a third party and demand reimbursement from us for the costs incurred.

(8) Warranty claims lapse 24 months from the date on which the Customer takes possession of the goods. In the case of deliveries and services that are subject to contracts for work and services, the warranty period is 24 months from acceptance. If acceptance does not take place in our factory, it is deemed to have taken place if a declaration is made to us after delivery or if the goods supplied are utilised for the purpose intended.

§ 8 General limitation of liability

We restrict our liability for negligent breach of obligations by us or by our servants or agents to liability for contractually typical, foreseeable damage.

§ 9 Liability under the German Product Liability Law

(1) Exclusions of liability under these Standard Terms and Conditions of Delivery, Assembly and Payment do not apply to claims of private consumers and users, irrespective of fault, under German Product Liability Law (Produkthaftungsgesetz).

(2) We are only liable to the Customer for compensatory and recourse claims if it can be proven that we are responsible for a defect in the goods supplied by us.

§ 10 Retention of title

(1) All the goods supplied by us remain our property (goods subject to retention of title) until all claims are fulfilled, in particular the balance claims due to us, regardless of the legal basis under which these claims arise. This also applies if payments are made in respect of specifically identified claims. The Customer is obliged to store and label separately the goods subject to retention of title.

(2) Handling and processing of goods subject to retention of title are done for us as the manufacturer according to § 950 BGB (German Civil Code), without imposing any obligations on us. The processed goods are deemed goods subject to retention of title according to Clause 1 above. If the Customer processes, combines or mixes goods subject to retention of title with other goods, we attain co-ownership of the new object in proportion to the ratio between the invoice value of the goods subject to retention of title and the invoice value of the other goods used. If our ownership is extinguished through mixing or combination, the Customer herewith assigns to us his rights of ownership of the new object to the extent of the invoice value and holds them in safe custody for us free of charge. The rights of co-ownership arising under this clause are deemed goods subject to retention of title according to Clause 1 above.

(3) The Customer may only sell the goods subject to retention of title in the ordinary course of business under his standard terms and conditions and as long as he is not in default, and only provided that the claims arising out of the resale in accordance with Clauses 4 and 5 are assigned to us. He is not entitled to dispose of the goods subject to retention of title in any other way.

(4) The Customer's claims arising out of the resale of the goods are herewith assigned to us. They serve as security to the same extent as the goods subject to retention of title themselves. Any further assignment of these claims is excluded. We accept the claims.

(5) If the goods in which we have co-ownership under Clause 2 above are sold, the assignment of claims applies in the amount of the co-ownership share or the invoice value. At our request, the Customer is obliged to immediately inform his buyer of the assignment to us and to provide us with the information and documentation required to enforce these claims. The Customer is obliged to inform us immediately of any seizure or impairment by third parties.

(6) If the value of the existing securities exceeds the secured claims by more than 10% in total, we are to this extent obliged to release securities of our choice upon request by the Customer

§ 11 Place of fulfilment and jurisdiction

(1) The place of fulfilment for payments and for all other obligations is our registered office.

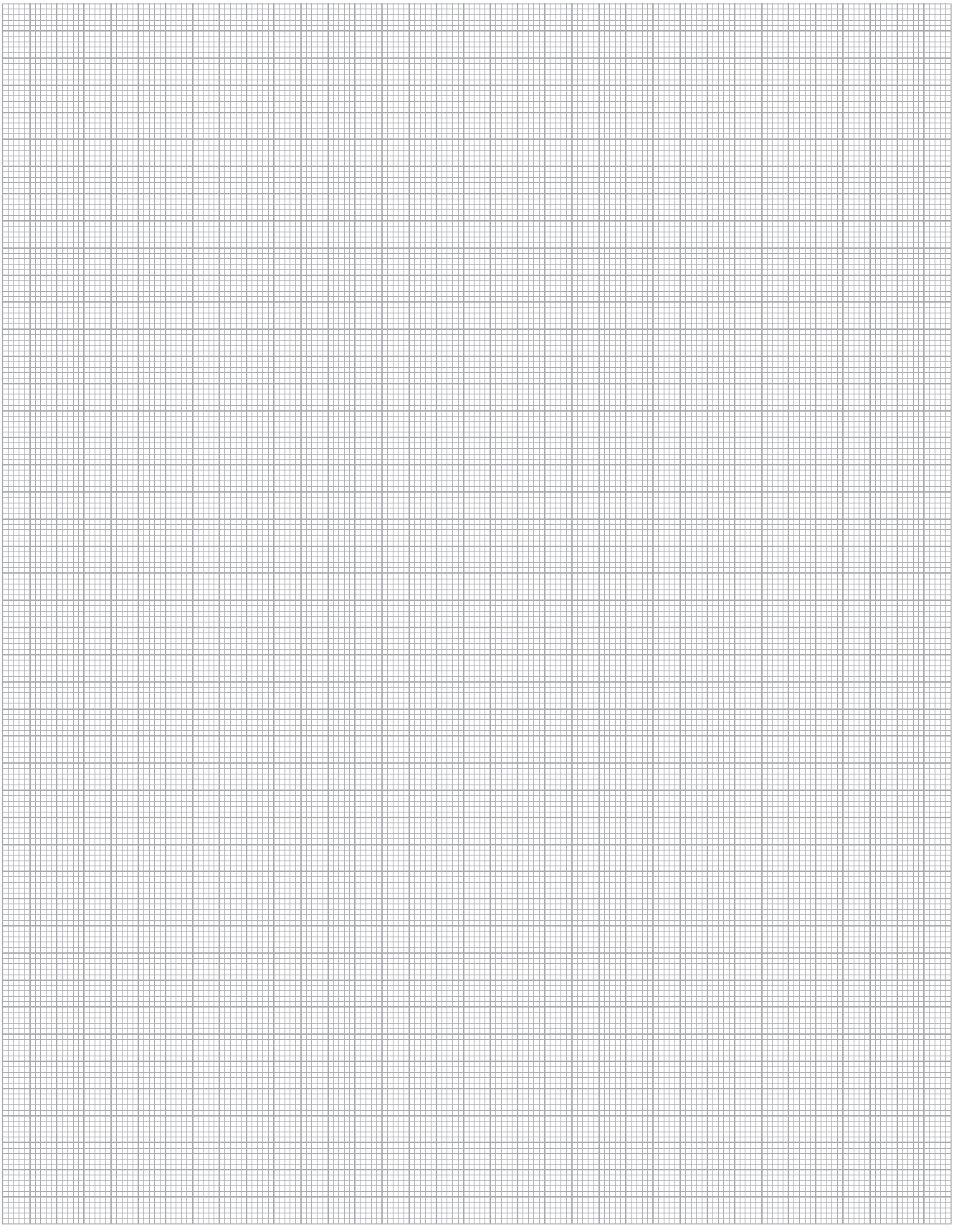
(2) Jurisdiction is that of our registered office, including for actions filed under the special procedure for claims arising from bills of exchange and cheque payments. We are entitled to take action against the Customer at his place of general jurisdiction. This is applicable unless otherwise stipulated in an arbitration agreement in individual cases.

(3) The law of the Federal Republic of Germany is exclusively applicable to all legal relations between the Customer and ourselves; application of the UN Convention on Contracts for the International Sale of Goods is excluded.

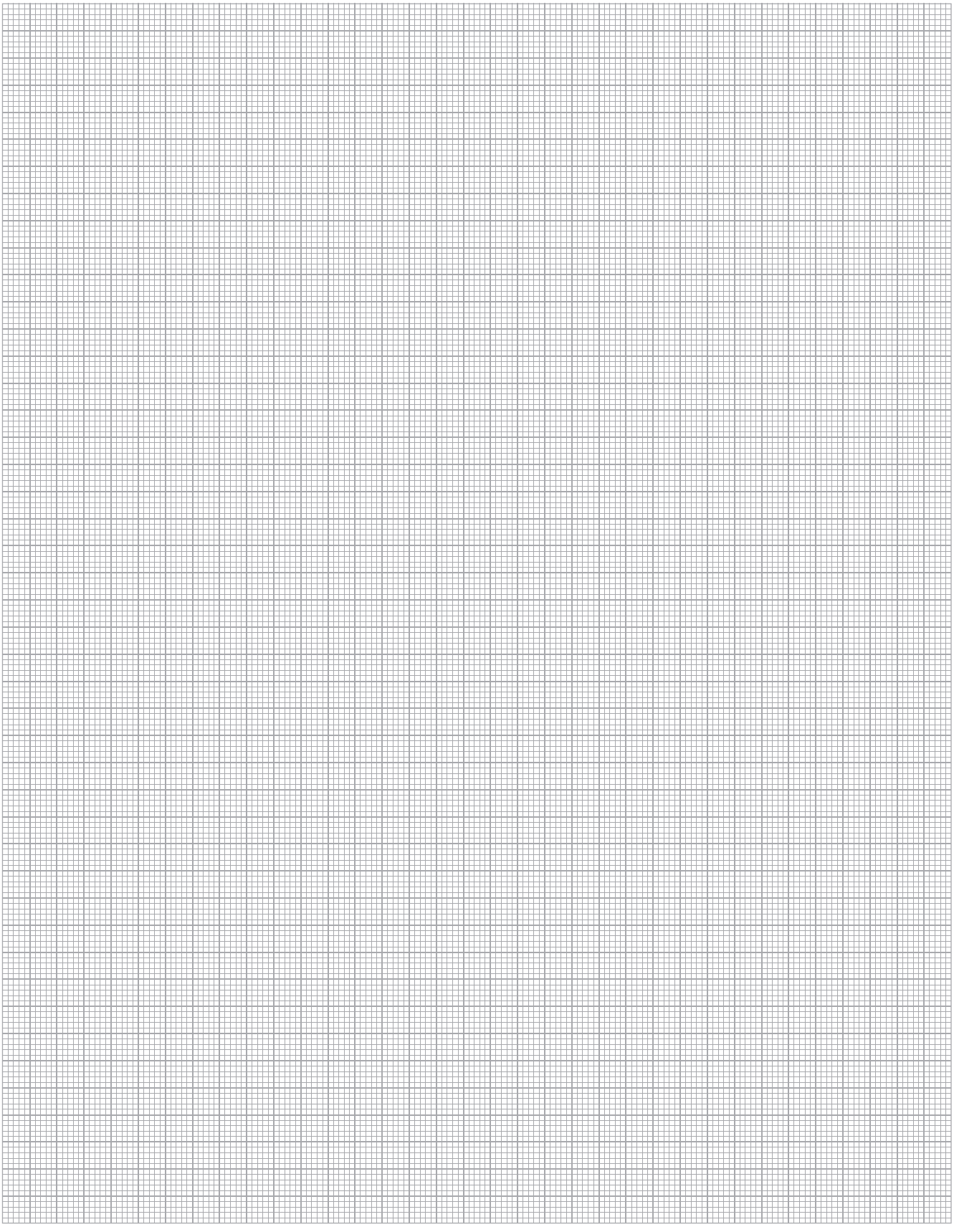
§ 12 Severability

Should individual provisions of these standard delivery and payment terms be completely or partially invalid or void, then the contracting parties are obliged to agree a provision by which the purpose and aim of the invalid or void provision is best achieved. For the rest, the valid contractual agreements are upheld.

SPACE FOR YOUR NOTES AND SKETCHES



SPACE FOR YOUR NOTES AND SKETCHES



ALLMATIC Spannsysteme JAKOB

ALLMATIC-Jakob Spannsysteme GmbH
Jägermühle 10, 87647 Unterthingau, Germany
Telefon: +49(0)8377 929-0
Fax: +49(0)8377 929-380
General Catalogue ALLMATIC 2014

info@allmatic.de
www.allmatic.de

Distributor's stamp