

SINGLE AND MULTIPLE CLAMPING SYSTEM



CLAMPING. SCREWING. LOCKING.



Catalogue 2015/2016

WE GENERATE EXCITEMENT

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

COMPANY HISTORY

- 1890** Company founded as a lock manufacturer by Andreas Maier.
- 1920** Product range extended to include spanners.
- 1928** Production line assembly of „Fellbach locks“.
- 1951** AMF introduces clamping elements and diversifies into workpiece and tool clamping technology.
- 1965** Toggle clamps extend the AMF product range. AMF catalogues are now printed in ten languages.
- 1975** Further specialisation into hydraulic clamping technology.
- 1982** Clamping and fixture systems round off AMF's clamping expertise.
- 1996** AMF team organisation in all sectors of the business. Quality management with certification to ISO 9001.
- 2001** AMF Service Guarantee for all products.
- 2004** Introduction of the ZPS zero-point clamping system.
- 2007** The magnetic clamping technology extends the AMF product range.
- 2009** Development and marketing of AMF Vacuum clamping technology
- 2012** Marking and cleaning tools included in the AMF product range.



MANAGING DIRECTORS

> Johannes Maier
Volker Göbel



THE AMF SERVICE GUARANTEE

> Assuredly on the way to the top

5 Individual development

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

4 Warranty

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

3 Guaranteed quality standard

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

2 Short delivery times

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

1 Service from genuine experts

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

E Made in Germany

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

PRODUCT ON THE COVER

Multiple clamping system No. 6371, page 17-21 · Mechanical collet No. 6375M, page 4
Collet attachment for clamping module No. 6370ZSZ-112, page 8

COLLET - MECHANICAL AND HYDRAULIC COLLET ATTACHMENT FOR ZERO-POINT CLAMPING MODULES

4 - 10



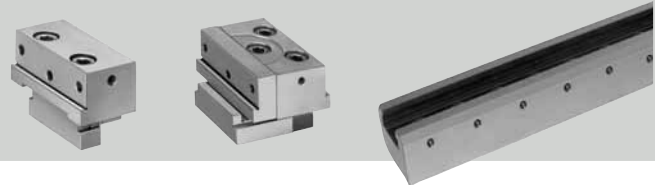
CENTRING VICE "BLACK EDITION"

11 - 16



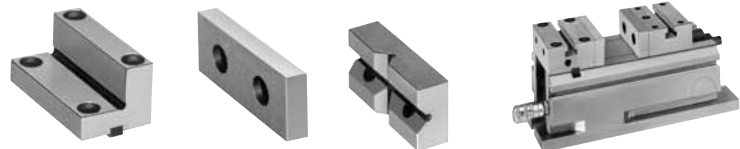
MULTIPLE CLAMPING SYSTEM NO. 6371

17 - 27



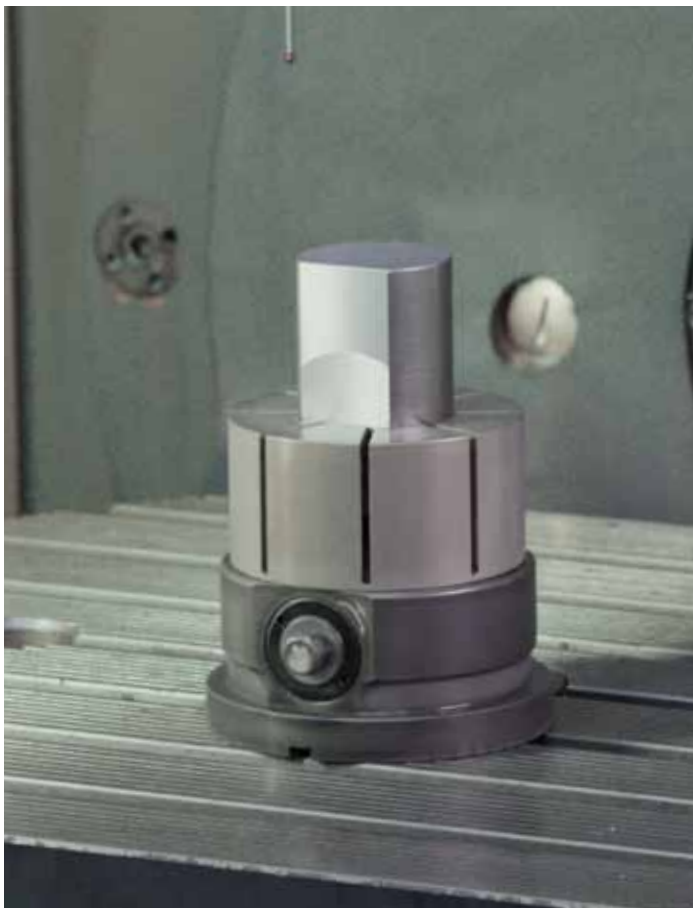
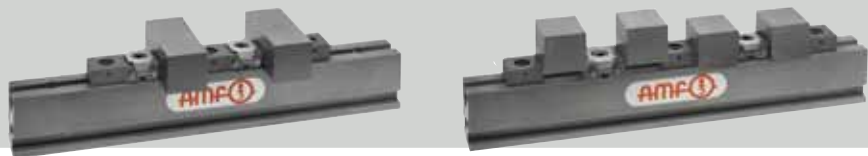
PNEUMATIC VICE

28 - 33



MULTIPLE CLAMPING SYSTEM NO. 6376

34 - 49



No. 6375M

Mechanical collet

Order no.	Clamping force max.* [kN]	Clamping stroke Ø [mm]	Max. tightening torque [Nm]	Weight [Kg]
533281	11	0,3	40	4,5

Design:

The main body is from burnished steel. The collet, which is supplied as standard, has a diameter of 99 mm and is made from anodised, high-strength aluminium. The mechanism in the main body is protected against dirt and coolant. Flanged base for fastening to the machine table. Provided on the underside is the holder for the AMF K20 Zero Point system as well as grooves for positioning on AMF Zero Point clamping modules with indexing.

Application:

For clamping complex workpiece contours for 5-sided machining in the machine tool. The collet is machined to the contours of the workpiece, with a minimum location depth of 2 mm. Because the clamping force is evenly applied to the component in a radial direction, the workpiece is clamped without distortion. The clamping force can be adjusted via the clamping screw, using a torque wrench for example. Consequently, especially suitable for thin-walled pipes and workpieces. Thanks to the simple collet replacement, various workpieces can be quickly and safely clamped for 5-sided machining.

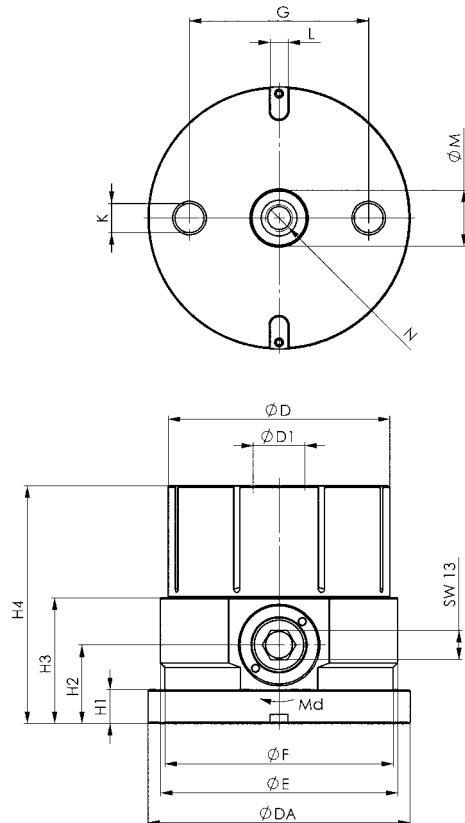
The collet can be milled off to 42 mm, allowing new workpiece contours to be introduced.

Note:

* The max. clamping force of 11kN is introduced into the collet in an axial direction, and does not describe the radial clamping force onto the component. This varies depending on the machining height on the collet.

Dimensions:

Order no.	dia. D	dia. D1	dia. DA	dia. E	dia. F	G	H1	H2	H3	H4	K	L	dia. M	N
533281	99	23	117	106	102	80	15	35	56	106	13	8 K7	25	M12



No. 6375H

Hydraulic collet

Operating pressure for opening: min. 40 bar - max. 60 bar.



Order no.	Clamping force max.*	Clamping stroke Ø	Weight
	[kN]	[mm]	[Kg]
545582	13	0,3	5,6

Design:

Hydraulic pressure of 40 - 60 bar is required for opening the collet. In the de-pressurised state, the collet is securely tensioned by the integrated spring package.

The main body is made from burnished steel. The collet, which is supplied as standard, has a diameter of 99 mm and is made from anodised, high-strength aluminium. The hydraulic clamping unit is protected against dirt and cooling water.

Circumferential clamping edge for fastening to the machine table.

The holder for the AMF K20 Zero Point system, as well as grooves for positioning on AMF Zero Point clamping modules with indexing, are applied to the underside.

For automated operation, a hydraulic connection, sealed in the delivered condition, is present on the underside.

The lateral hydraulic connection is suitable for the mounting of a quick-release coupling with connection thread G1/4.

Application:

For clamping complex workpiece contours for 5-sided machining in the machine tool. The counterplate of the workpiece is milled into the collet with a minimum clamping depth of 2 mm.

Since the clamping force is evenly applied to the component in a radial direction, the counterplate is clamped warp-free.

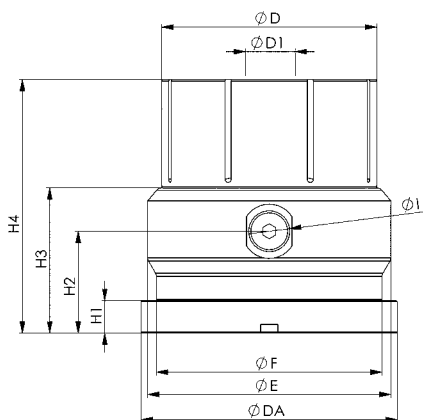
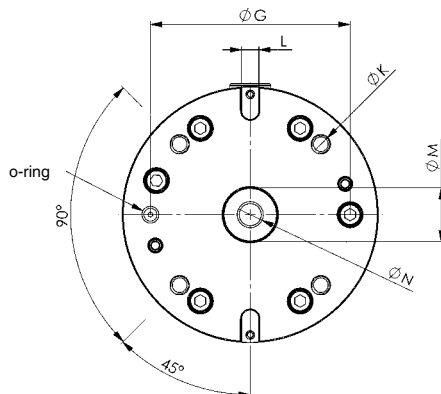
Thanks to the simple collet replacement, various workpieces can be quickly and securely clamped for 5-sided machining.

The collet can be milled off to 42 mm, allowing new workpiece contours to be introduced.

Note:

If the collet is assembled, the collet element must not be closed without a workpiece.

* The max. clamping force of 13 kN is exerted axially to the collet and does not refer to the clamping force exerted on the component. This varies according to the machining height of the collet.



Dimensions:

Order no.	dia. D	dia. D1	dia. DA	dia. E	dia. F	G	H1	H2	H3	H4	dia. I	K	L	dia. M	N
545582	99	23	118	112	104	92	15	47	67	117	G1/4	M8	8 K7	25	M12

No. 6375Z-99

Collet, single

Material: High-strength aluminium
suitable for collet 6375M / 6375H



Order no.	dia. D	dia. D1	Clamping stroke Ø [mm]	H	Weight [g]
428649	99	23	0,3	50	870

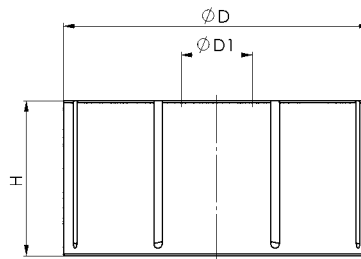
Design:

The 99 mm diameter collet is suitable for the collet element with order no. 533281. The collet is made from anodised, high-strength aluminium.

Application:

The collet is fastened to the main element by just one centrally applied screw, and is therefore quickly replaced. The workpiece contour is milled into the collet with a minimum clamping depth of 2 mm. Because the clamping force is evenly applied to the component in a radial direction, the workpiece is clamped without distortion.

The collet can be milled off to 42 mm, allowing new workpiece contours to be introduced. The maximum workpiece diameter is 90 mm.



No. 6375Z-149

Collet, single

Material: High-strength aluminium
suitable for collet 6375M / 6375H



Order no.	dia. D	dia. D1	dia. D2	Clamping stroke Ø [mm]	H	H1	Weight [g]
428656	149	23	99	0,3	50	10	870

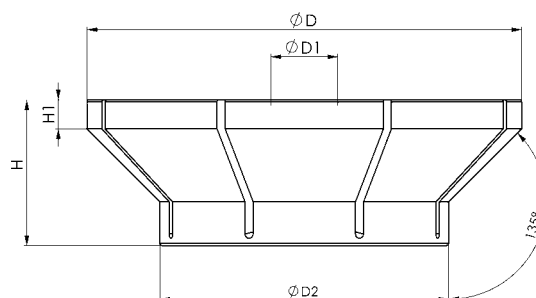
Design:

The 149 mm diameter collet is suitable for the collet element with order no. 533281. The collet is made from anodised, high-strength aluminium.

Application:

The collet is fastened to the main element by just one centrally applied screw, and is therefore quickly replaced. The workpiece contour is milled into the collet with a minimum clamping depth of 2 mm. Because the clamping force is evenly applied to the component in a radial direction, the workpiece is clamped without distortion.

The collet can be milled off to 20 mm, allowing new workpiece contours to be introduced. The maximum workpiece diameter is 140 mm.



No. 6375ZK-99

Collet, single

Material: polyamide.

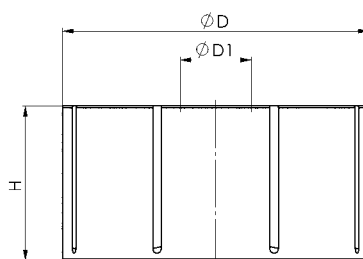
Order no.	dia. D	dia. D1	Clamping stroke Ø [mm]	H	Weight [g]
550278	99	23	1,0	50	360

Design:

The 99 mm diameter polyamide collet is suitable for the mechanical collet element with order no. 533281.

Application:

The polyamide collet is suitable for clamping pressure-sensitive workpieces and materials. The collet is fastened to the main element by just one centrally applied screw, and is therefore quickly replaced. The workpiece contour is milled into the collet with a minimum clamping depth of 2 mm. Because the clamping force is evenly introduced to the component in a radial direction, the counterplate is clamped warp-free. The collet can be milled off to 42 mm, allowing new workpiece contours to be introduced. The maximum workpiece diameter is 90 mm.

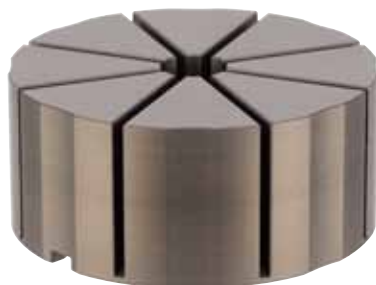


Subject to technical alterations.

No. 6370ZSZ-112

Collet attachment for clamping module K20, hydr.

Material: high-strength aluminium.



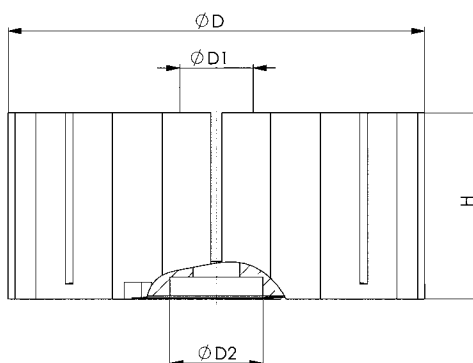
Order no.	dia. D	dia. D1	Clamping stroke Ø [mm]	H	Weight [g]
550286	112	20	0,5	50	1133

Design:

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

Application:

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



No. 6370ZSB

Mounting kit for collet attachment

for collet No. 6370ZSZ-112



Order no.	Size	Weight [g]
550287	K20	190

Design:

The mounting set comprises:

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

Application:

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

**Collet attachment for
clamping module K20, hydr.**
No. 6370ZSZ-112

**Mounting kit for collet
attachment**
No. 6370ZSB

**Assembly element K20,
hydraulic, with indexing**
No. 6210IH



Subject to technical alterations.





No. 6377

Centering vice soft clamping jaws „Black-Edition“

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

Design:

Base element and vice with smooth clamping surfaces from case hardened steel, nitro-carburised and oxidised.

The spindle with trapezoidal thread is rated for extremely high clamping and retaining forces and fabricated from special steel.

For optimal force transmission onto the workpiece, the jaw is one part and the clamping force is transmitted directly onto the jaw via the drive spindle with trapezoidal thread.

The max. clamping force is 14kN. Due to these extremely high clamping forces, workpieces are not required to be pre-embossed and/or contour-embossed.

Fastening:

- 1) Clamping grooves on both sides for fastening directly on the machine table with mechanical clamping elements.
- 2) Prepared for adapting to the mechanical 4-point clamping station with insertion dimension of 52mm, see drawing. Clamping nipples under order no. 535690 are required for this purpose.
- 3) Two 8H7 bores are provided on the underside for precise positioning on adapter and intermediate plates.

Application:

For the central clamping of workpieces.

The compact design of this centering vice makes it especially suitable for the 5-axis machining of workpieces. It is also, however, a multi-purpose tool and offers the user numerous day-to-day applications thanks to the jaw interchange option.

The jaws are easy to interchange and can, for example, be replaced by ribbed jaws, order no. 550659.

Note:

Extending the jaws beyond the max. dimension (L) of the outside contour of the main body is not recommended.

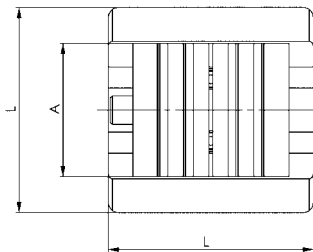
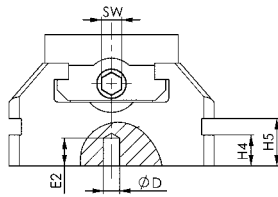
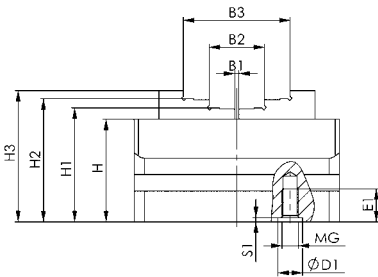
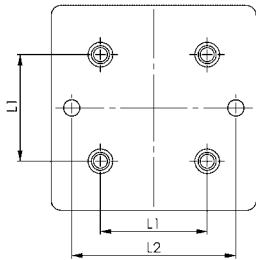
The max. clamping force is 14kN with a tightening torque of 60Nm, for further details on the clamping force, see clamping force diagram.

The clamping force is initiated on the spindle via the hexagon head with AF 10mm using either the crank handle provided or a torque wrench.

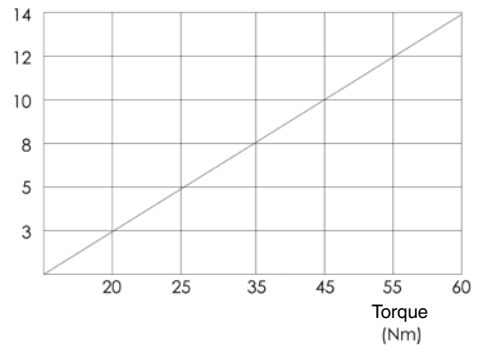
The inner hexagon on the rear of the spindle is suitable only for unscrewing and replacing the jaws. Initiating the clamping force using an inner hexagon is not permitted.



Smooth
clamping jaws



Clamping force
(kN)



Dimensions:

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

Subject to technical alterations.

No. 6377G

Centering vice ribbed clamping jaws
„Black-Edition“

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

Design:

Base element and vice with ribbed clamping surfaces from case hardened steel, nitro-carburised and oxidised.

The spindle with trapezoidal thread is rated for extremely high clamping and retaining forces and fabricated from special steel.

For optimal force transmission onto the workpiece, the jaw is one part and the clamping force is transmitted directly onto the jaw via the drive spindle with trapezoidal thread.

The max. clamping force is 14kN. Due to these extremely high clamping forces, workpieces are not required to be pre-embossed and/or contour-embossed.

Fastening:

- 1) Clamping grooves on both sides for fastening directly on the machine table with mechanical clamping elements.
- 2) Prepared for adapting to the mechanical 4-point clamping station with insertion dimension of 52mm, see drawing. Clamping nipples under order no. 535690 are required for this purpose.
- 3) Two 8H7 bores are provided on the underside for precise positioning on adapter and intermediate plates.

Application:

For the central clamping of workpieces.

The compact design of this centering vice makes it especially suitable for the 5-axis machining of workpieces. It is also, however, a multi-purpose tool and offers the user numerous day-to-day applications thanks to the jaw replacement option.

The jaws are easy to interchange and can, for example, be replaced by jaws with smooth clamping surface, order no. 550658.

Note:

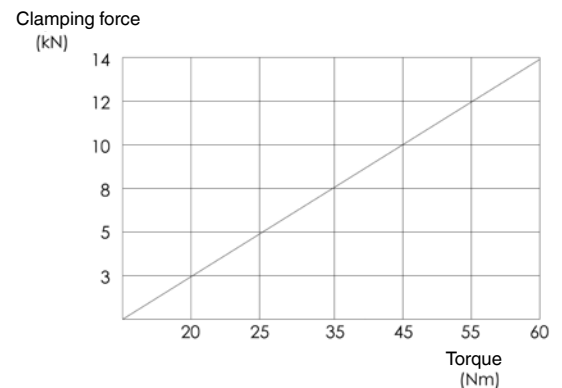
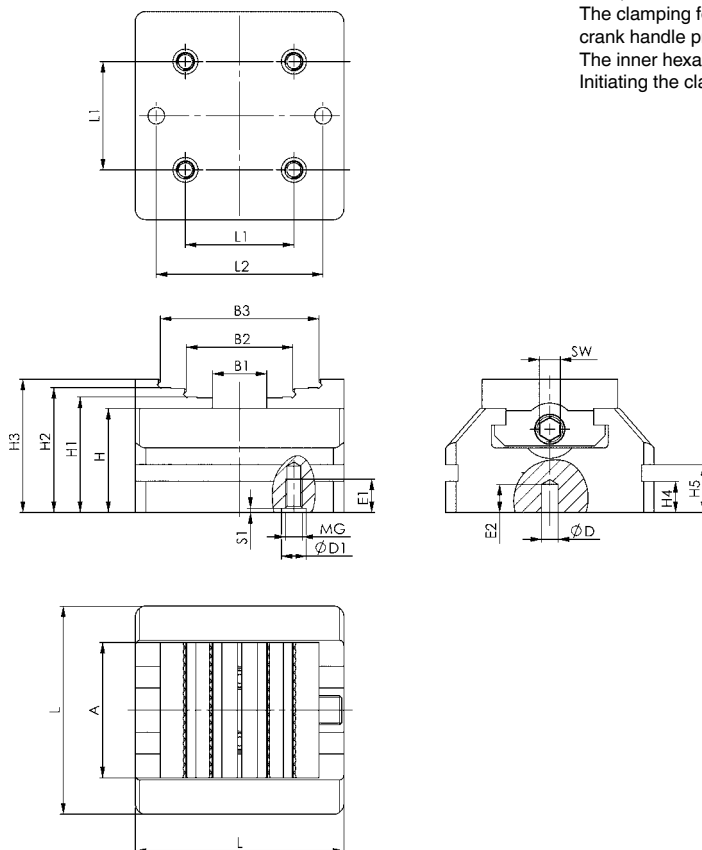
Extending the jaws beyond the max. dimension (L) of the outside contour of the main body is not recommended.

The max. clamping force is 14kN with a tightening torque of 60Nm, for further details on the clamping force, see clamping force diagram.

The clamping force is initiated on the spindle via the hexagon head with AF 10mm, either using the crank handle provided or a torque wrench.

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

**Serrated
clamping jaw**



Dimensions:

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

No. 6377B

Clamping Jaws, soft

for centering vice, size 65.

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

Design:

Base element and vice with smooth clamping surfaces from case hardened steel, nitro-carburised and oxidised.

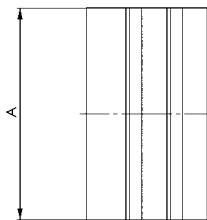
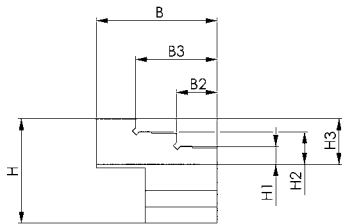
Suitable for „Black-Edition“ centering jaw, size 65.

Application:

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

Note:

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



No. 6377BG

Clamping Jaws, ribbed

for centering vice, size 65.

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

Design:

Vice with ribbed clamping surfaces from case hardened steel, nitro-carburised and oxidised.

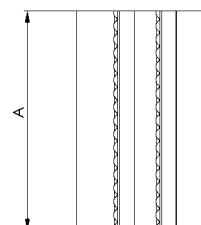
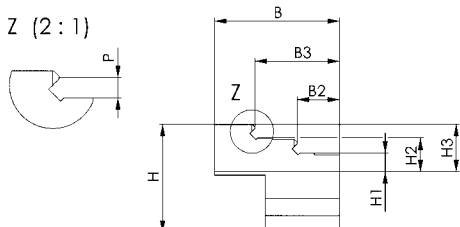
Suitable for „Black-Edition“ centering jaw, size 65.

Application:

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

Note:

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



Subject to technical alterations.

FAST, PRECISE AND FLEXIBLE - THE PERFECT COMBINATION FOR FAST VICE CHANGING

Centring vice "Black Edition"



Clamping nipple



Mechanical 4-point clamping station



No. 6207S4

4-point clamping station, mechanical

Case-hardened steel, plasma-nitrided.

Repetition accuracy 0.005 mm.

Mechanical opening and closing.

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

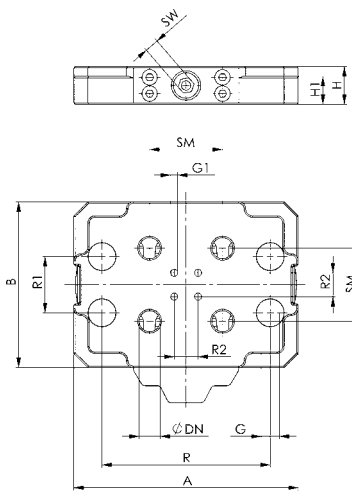
Application:

For quick, simple and time-optimised positioning and clamping of workpieces or fixtures on the machine table. Actuating the clamping screw opens or closes all four clamping points at the same time.

Extremely high retraction and retention forces are achieved thanks to the stable, high-quality design of this clamping station.

Note:

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



Dimensions:

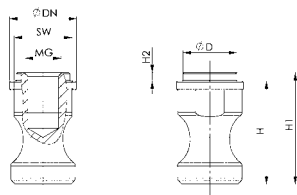
Order no.	Size	A	B	dia. DN	G	G1	H ±0.01	H1	R	R1	R2	SM	SW
535658	52	160	118	15	M12	M5	27	20	120	40	17	52	10
546788	96	200	165	20	M12	M6	27	22	160	80	30	96	10

No. 6207ZN-15

Clamping nipple

Tempered steel, burnished.

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

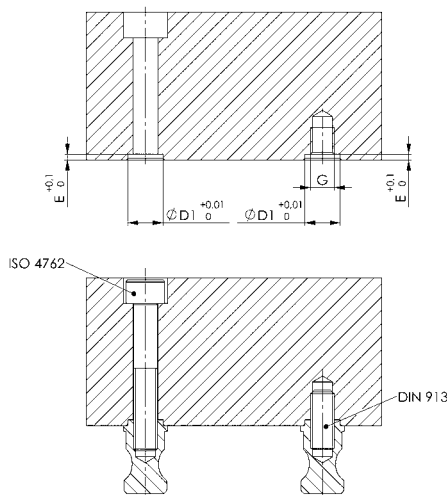


Application:

Clamping nipples suitable for mechanical 4-point clamping stations.

4 clamping nipples are required for clamping on the 4-point clamping station.

These nipples can, for example, be screwed into fixtures or into the workpieces themselves.

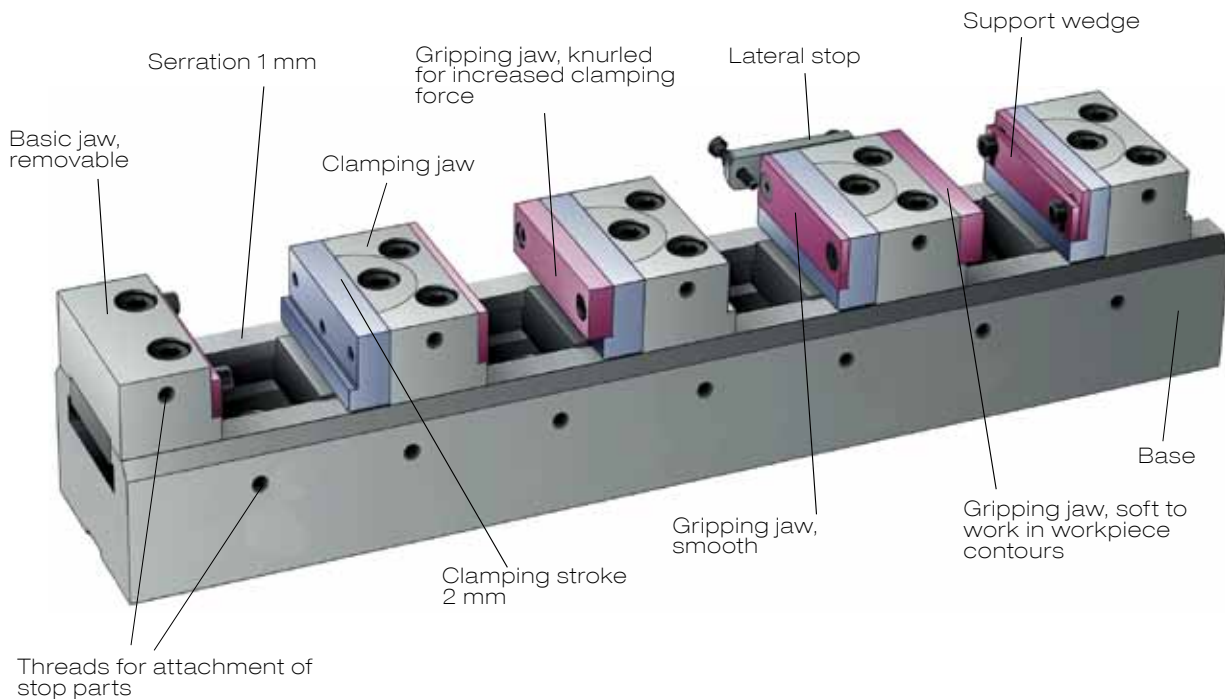


Subject to technical alterations.



MULTIPLE CLAMPING SYSTEM NO. 6371 - THE ADVANTAGES AT A GLANCE

- > Precision multiple clamping fixture
- > Insert steel hardened 60 HRC
- > Up to 16 clamping points, depending on the tool size
- > Simple and precise setting of the clamping jaws due to serrated contact surfaces
- > Positioning step 1 mm
- > Scaling on the basic module and reference mark on the jaws permit positioning without measurement and inspection equipment
- > Positive-locking connection of the clamping jaws
- > Clamping per clamping point with only one screw
- > Jaw width 50 or 80 and 120 mm
- > Modular design: equipment for one or more workpieces as desired
- > Workpiece contact surfaces integrated into jaws
- > Usable on machine tables, fixture and quick change systems



WORK-PIECE QUANTITIES FOR MULTIPLE CLAMPING SYSTEMS

Size	Length (mm)	Workpiece quantity															
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
		Max. workpiece dimension (mm)															
50	250	191	78	41	22	11											
	320	261	113	64	39	25	15	8									
	500	441	203	124	84	61	45	34	25	18	13	9					
	600	541	253	157	109	81	61	48	38	30	23	18	14	10			
	650	591	278	174	122	91	70	56	44	35	28	22	18	14	10		
	700	641	303	191	134	101	78	62	50	41	33	27	22	18	14	11	8
80	350	261	105	52	26	11											
	500	411	180	102	64	41	25	14									
	600	511	230	136	89	61	42	28	18	11							
	650	561	255	152	101	71	50	36	25	16							
	700	611	280	169	114	81	59	43	31	22	14						
120	500	381	158	83	46	24	9										
	600	481	208	117	71	44	26	13									
	700	581	258	150	96	64	42	27	15								

SIMPLE MOUNTING IN TWO STEPS

1 FASTENING THE JAWS ON THE BASIC ELEMENT (MOUNTING BOLTS)

Tightening torque for mounting bolts of strength class 12.9:

Jaw width	Attachment of basic jaws	Attachment of clamping jaws
50	2 x M6, max. 25 Nm	2 x M6, max. 20 Nm
80	2 x M10, max. 30 Nm	2 x M10, max. 30 Nm
120	4 x M10, max. 30 Nm	2 x M10, max. 30 Nm

2 CLAMPING THE WORKPIECE BY TIGHTENING THE CLAMPING JAWS

FIRST STEP:

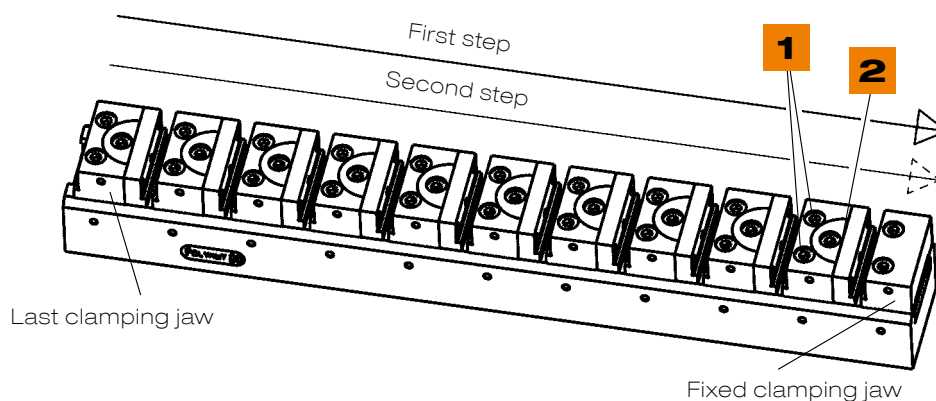
Lightly tighten the clamping bolt. As a result, the workpiece is correctly positioned.
Always start at the last clamping jaw.

SECOND STEP:

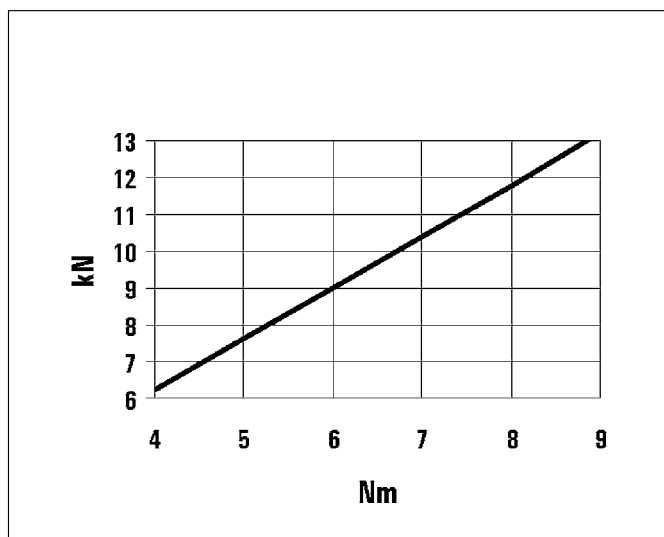
Then tighten the clamping bolt with a torque wrench (pay attention to the diagrams shown below). Also always start at the last clamping jaw.

NOTE:

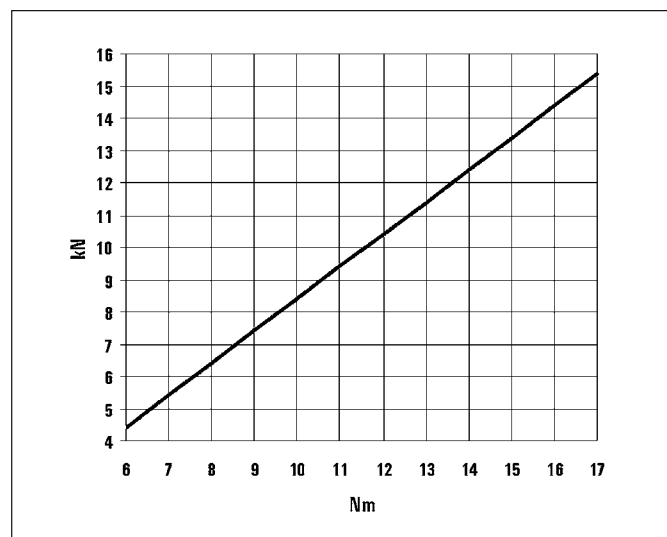
Recommended lubricant for the clamping screws of the jaws and the cone: **Molykote TP42**



CLAMPING JAW WIDTH 50 –
MAX. CLAMPING FORCE 12 kN



CLAMPING JAW WIDTH 80/120 –
MAX. CLAMPING FORCE 15 kN



No. 6371G-50

Base element

Jaw width 50 mm.

Bore spacing 40 mm. Hardened 60 HRC, 1 mm splines.
Fits all AMF pitch systems: 40 mm pitch, M12, ø16 F7.

Order no.	Size	Length [mm]	Clamping force [kN]	Weight [Kg]
304873	50-250-040	250	12	3,3
304923	50-320-040	320	12	4,2
304899	50-500-040	500	12	6,6
304949	50-600-040	600	12	8,0
304915	50-650-040	650	12	8,7
304964	50-700-040	700	12	9,3

No. 6371G-80

Base element

Jaw width 80 mm.

Bore spacing 40 mm. Hardened 60 HRC, 1 mm splines.
Fits all AMF pitch systems: 40 mm pitch, M12, ø16 F7.

Order no.	Size	Length [mm]	Clamping force [kN]	Weight [Kg]
304774	80-350-040	350	15	11,1
304824	80-500-040	500	15	15,8
304790	80-600-040	600	15	18,9
304840	80-650-040	650	15	20,6
304816	80-700-040	700	15	22,1

No. 6371G-80

Base element

Jaw width 80 mm.

Bore spacing 50 mm. Hardened 60 HRC, 1 mm splines.
Fits all AMF pitch systems: 50 mm pitch, M16, ø22 F7.

Order no.	Size	Length [mm]	Clamping force [kN]	Weight [Kg]
304766	80-350-050	350	15	10,7
304782	80-500-050	500	15	15,5
304733	80-600-050	600	15	18,6
304758	80-650-050	650	15	20,0
304808	80-700-050	700	15	21,7

No. 6371G-120

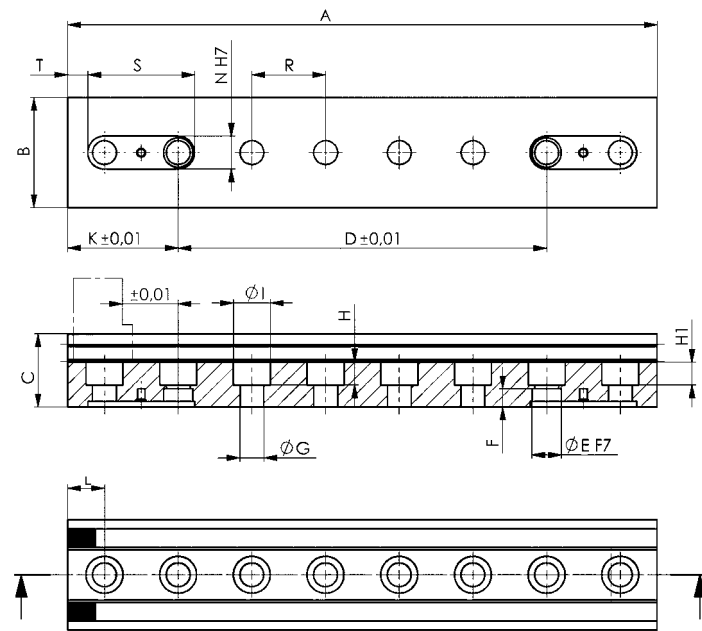
Base element

Jaw width 120 mm.

Bore spacing 50 mm. Hardened 60 HRC, 1 mm splines.
Fits all AMF pitch systems: 50 mm pitch, M16, ø22 F7.

Order no.	Size	Length [mm]	Clamping force [kN]	Weight [Kg]
304865	120-500-050	500	15	13,0
304881	120-600-050	600	15	15,9
304907	120-700-050	700	15	18,5





Dimensions:

Order no.	Size	A	B	C	D	E	F	G	H	H1	I	K	L	N	R	S	T
304873	50-250-040	250	60	40	200	16	10	13	12,5	12,5	19	25	25	18	40	58	16
304923	50-320-040	320	60	40	200	16	10	13	12,5	12,5	19	60	20	18	40	58	11
304899	50-500-040	500	60	40	400	16	10	13	12,5	12,5	19	30	30	18	40	58	21
304949	50-600-040	600	60	40	400	16	10	13	12,5	12,5	19	100	20	18	40	58	51
304915	50-650-040	650	60	40	400	16	10	13	12,5	12,5	19	100	20	18	40	58	51
304964	50-700-040	700	60	40	400	16	10	13	12,5	12,5	19	150	30	18	40	58	101

Order no.	Size	A	B	C	D	E	F	G	H	H1	I	K	L	N	R	S	T
304774	80-350-040	350	90	60	200	16	10	13	12,5	12,5	19	75	35	18	40	58	26
304824	80-500-040	500	90	60	400	16	10	13	12,5	12,5	19	30	30	18	40	58	21
304790	80-600-040	600	90	60	400	16	10	13	12,5	12,5	19	100	20	18	40	58	51
304840	80-650-040	650	90	60	400	16	10	13	12,5	12,5	19	125	45	18	40	58	76
304816	80-700-040	700	90	60	400	16	10	13	12,5	12,5	19	150	30	18	40	58	101

Order no.	Size	A	B	C	D	E	F	G	H	H1	I	K	L	N	R	S	T
304766	80-350-050	350	90	60	200	22	13	17	17	17	25	75	25	18	50	68	16
304782	80-500-050	500	90	60	400	22	13	17	17	17	25	75	25	18	50	68	16
304733	80-600-050	600	90	60	400	22	13	17	17	17	25	100	50	18	50	68	41
304758	80-650-050	650	90	60	400	22	13	17	17	17	25	125	25	18	50	68	66
304808	80-700-050	700	90	60	400	22	13	17	17	17	25	150	50	18	50	68	91

Order no.	Size	A	B	C	D	E	F	G	H	H1	I	K	L	N	R	S	T
304865	120-500-050	500	105	45	250	22	13	17	17	4x10	25	125	25	18	50	68	16
304881	120-600-050	600	105	45	300	22	13	17	17	4x10	25	150	50	18	50	68	41
304907	120-700-050	700	105	45	300	22	13	17	17	4x10	25	200	50	18	50	68	91

Subject to technical alterations.

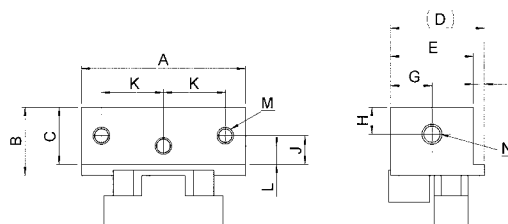
No. 6371

Base jaw, standard

First stop on base element, for 50, 80 or 120 mm jaw width.
Hardened 60 HRC.



Order no.	Size	for jaw width	Weight [g]
265793	4101-50	50	226
266809	4111-80	80	880
304980	12001-120	120	2300



Dimensions:

Order no.	Size	A	B	C	D	E	F	G	H	J	K	L	M	N
265793	4101-50	49	20,0	17	28	24,7	3,3	12,4	8	8,5	18,5	5,5	3xM5	2xM6
266809	4111-80	78	32,2	22	42	38,0	4,0	19,0	8	11,0	31,5	6,0	3xM6	2xM6
304980	12001-120	120	42,2	32	54	50,0	4,0	25,0	8	16,0	45,0	6,0	3xM6	2xM6

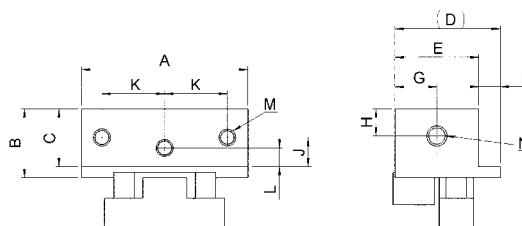
No. 6371

Base jaw, deep

First stop on base element, for 50 or 80 mm jaw width.
Hardened 60 HRC.



Order no.	Size	for jaw width	Weight [g]
290635	4121-50	50	230
290650	4120-80	80	900



Dimensions:

Order no.	Size	A	B	C	D	E	F	G	H	J	K	L	M	N
290635	4121-50	49	20,0	17	31	24,7	6,3	12,4	8	8,5	18,5	5,5	3xM5	2xM6
290650	4120-80	78	32,2	22	46	38,0	8,0	19,0	8	11,0	31,5	6,0	3xM6	2xM6

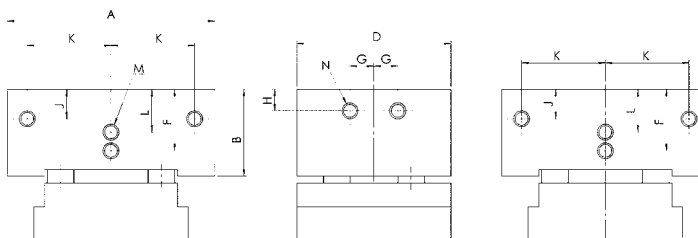
No. 6371

Base jaw, without step

First stop on base element, for 50 or 80 mm jaw width.
Hardened 60 HRC.



Order no.	Size	for jaw width	Weight [g]
304931	50105-50	50	340
304956	80107-80	80	1330



Dimensions:

Order no.	Size	A	B	D	F	G	H	J	K	L	M	N
304931	50105-50	49	20,0	32	-	0	8	8,5	18,5	11,5	6xM5	2xM6
304956	80107-80	78	32,2	50	23	9	8	11,0	31,5	16,0	8xM6	4xM6

Subject to technical alterations.

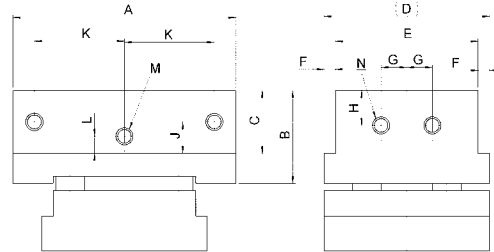
No. 6371

Central jaw

for clamping from two sides. For 50 or 80 mm jaw width. Hardened 60 HRC.



Order no.	Size	for jaw width	Weight [g]
300905	4112-50	50	370
300921	4300-80	80	1424



Dimensions:

Order no.	Size	A	B	C	D	E	F	G	H	J	K	L	M	N
300905	4112-50	49	20,0	17	40	33,4	3,3	4,5	8	8,5	18,5	5,5	6xM5	4xM6
300921	4300-80	78	32,2	22	58	50,0	4,0	9,0	8	11,0	31,5	6,0	6xM6	4xM6

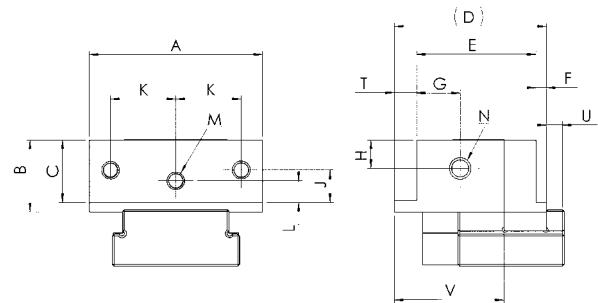
No. 6371

Clamping jaw, standard

For 50, 80 or 120 mm jaw width, with 1 mm positioning increments. Hardened 60 HRC. With one clamping bolt and two mounting bolts.



Order no.	Size	for jaw width	Clamping force [kN]	Clamping stroke [mm]	Weight [g]
265835	4102-50	50	12	2	373
266825	4110-80	80	15	2	1446
305003	12002-120	120	15	2	2900



Dimensions:

Order no.	Size	A	B	C	D	E	F	G	H	J	K	L	M	N	T	U	V
265835	4102-50	49	20,0	17	40	33,7	3	12,4	8	8,5	18,5	5,5	6xM5	2xM6	3,3	5	28
266825	4110-80	78	32,2	22	60	52,0	4	19,0	8	11,0	31,5	6,0	6xM6	2xM6	4,0	7	42
305003	12002-120	120	42,2	32	72	64,0	4	25,0	8	16,0	45,0	6,0	6xM6	2xM6	4,0	7	54

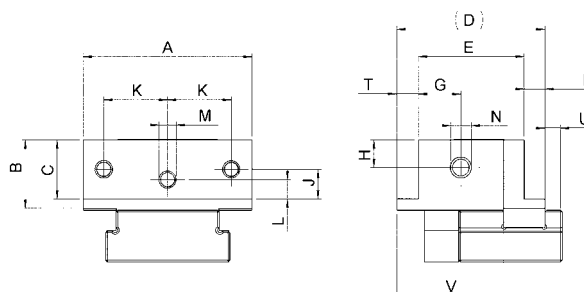
No. 6371

Clamping jaw, deep

For 50 or 80 mm jaw width, with 1 mm positioning increments. Hardened 60 HRC. With one clamping bolt and two mounting bolts.



Order no.	Size	for jaw width	Clamping force [kN]	Clamping stroke [mm]	Weight [g]
300863	4109-50	50	12	2	390
300889	4119-80	80	15	2	1430



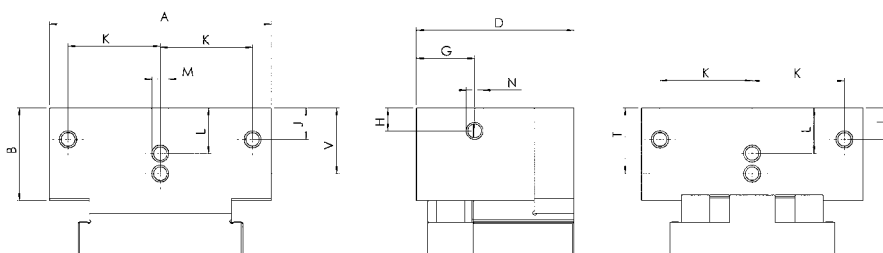
Dimensions:

Order no.	Size	A	B	C	D	E	F	G	H	J	K	L	M	N	T	U	V
300863	4109-50	49	20,0	17	43	30,7	6	12,4	8	8,5	18,5	5,5	6xM5	2xM6	6,3	5	31
300889	4119-80	78	32,2	22	64	48,0	8	19,0	8	11,0	31,5	6,0	6xM6	2xM6	8,0	7	46

No. 6371

Clamping jaw, without step

For 50 or 80 mm jaw width, with 1 mm positioning increments. Hardened 60 HRC. With one clamping bolt and two mounting bolts.



Order no.	Size	for jaw width	Clamping force [kN]	Clamping stroke [mm]	Weight [g]
304972	50101-50	50	12	2	370
304998	80101-80	80	15	2	1400

Dimensions:

Order no.	Size	A	B	D	G	H	J	K	L	M	N	T	V
304972	50101-50	49	20,0	36,5	13,0	8	8,5	18,0	11,5	7xM5	2xM6	-	17,5
304998	80101-80	78	32,2	55,5	20,5	8	11,0	31,5	16,0	8xM6	2xM6	23	23,0

Subject to technical alterations.

No. 6371

Clamping jaw, with crescent

For 50 or 80 mm jaw width, with 1 mm positioning increments. Hardened 60 HRC. With one clamping bolt for size 50 or two bolts for size 80, and with two mounting bolts.

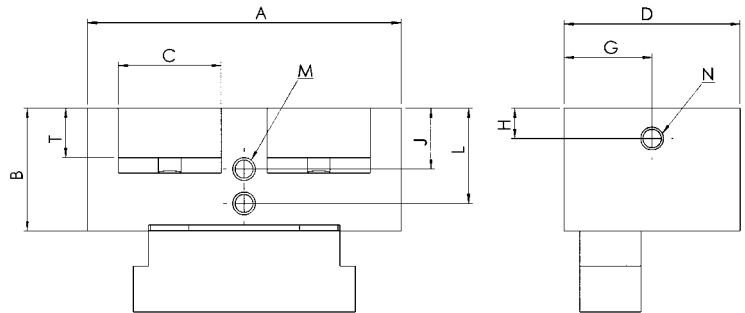
Order no.	Size	for jaw width	Clamping force [kN]	Clamping stroke [mm]	Weight [g]
305011	50110-50	50	12	1,4	280
305037	80110-80	80	15	1,4	1000



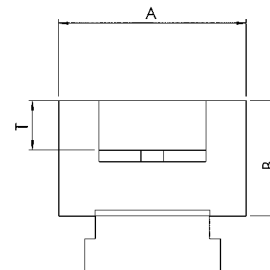
Jaw width 50



Jaw width 80



Jaw width 50



Jaw width 80

Dimensions:

Order no.	Size	A	B	C	D	G	H	J	L	M	N	T
305011	50110-50	49	23,0	28	30,5	15,3	8	-	-	-	2xM6	12
305037	80110-80	82	32,2	2x28	46,0	23,0	8	16	25	4xM6	2xM6	16

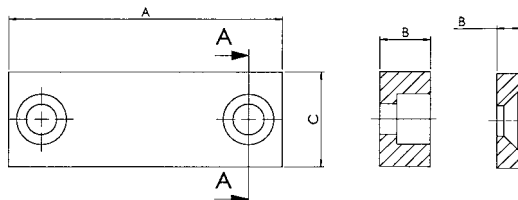
No. 6371

Gripping jaw, smooth

Hardened 60 HRC.



Order no.	Size	for jaw width	A	B	C	Weight [g]
300988	4107-50-04	50	49	4	17	23
301002	4108-50-09	50	49	9	17	51
301028	4117-80-04	80	78	4	22	49
301044	4118-80-11	80	78	11	22	135
304857	12024-120-04	120	119	4	32	115



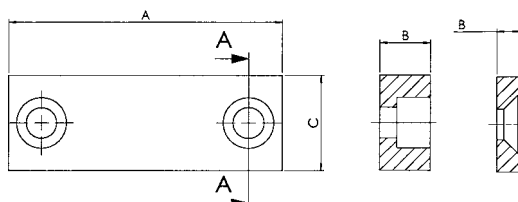
No. 6371

Gripping jaw, soft

not hardened.



Order no.	Size	for jaw width	A	B	C	Weight [g]
266569	4103-50-09	50	49	9	17	51
266585	4104-50-12	50	49	12	17	67
266841	4113-80-11	80	78	11	22	133
266866	4114-80-18	80	78	18	22	217
304832	12018-120-15	120	119	15	32	430



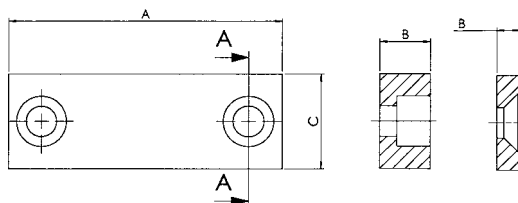
No. 6371

Gripping jaw, knurled

Hardened 60 HRC.



Order no.	Size	for jaw width	A	B	C	Weight [g]
300947	4105-50-04	50	49	4	17	21
266601	4106-50-09	50	49	9	17	51
300962	4115-80-04	80	78	4	22	46
266882	4116-80-11	80	78	11	22	133
305029	12025-120-04	120	119	4	32	110



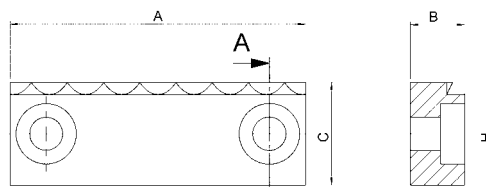
No. 6371

Gripping jaw, with claws

Hardened 60 HRC. Clamping edge height only 2 mm.



Order no.	Size	for jaw width	DIN 7894	A	B	C	H ±0.02	Weight [g]
305086	100-50-12	50	M5 x20	49	12	17	15	70
305094	100-80-12	80	M6 x 20	78	12	22	20	150
305102	100-120-12	120	M6 x 20	119	12	32	30	350

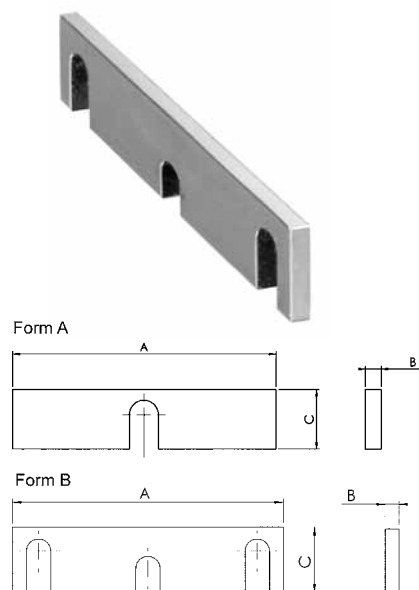


Subject to technical alterations.

No. 6371

Support wedge

For 50, 80 or 120 mm jaw width.



Order no.	Size	for jaw width	Form	A	B	C	Weight [g]
266627	4201-50-011	50	A	49	3	11	11
266643	4202-50-012	50	A	49	3	12	12
266668	4203-50-013	50	A	49	3	13	13
266684	4204-50-014	50	A	49	3	14	16
266700	4205-50-015	50	A	49	3	15	16
266726	4206-50-016	50	A	49	3	16	17
301069	4351-80-012	80	A	78	4	12	27
300871	4352-80-013	80	A	78	4	13	30
300897	4353-80-014	80	A	78	4	14	33
300913	4354-80-015	80	A	78	4	15	34
266908	4355-80-016	80	B	78	4	16	35
266577	4356-80-017	80	B	78	4	17	36
266593	4357-80-018	80	B	78	4	18	37
266619	4358-80-019	80	B	78	4	19	40
266635	4359-80-020	80	B	78	4	20	43
266650	4360-80-021	80	B	78	4	21	46
305045	1216-120-016	120	A	119	4	16	580
305060	1220-120-020	120	A	119	4	24	730
305052	1224-120-024	120	B	119	4	24	790
305078	1228-120-028	120	B	119	4	28	950

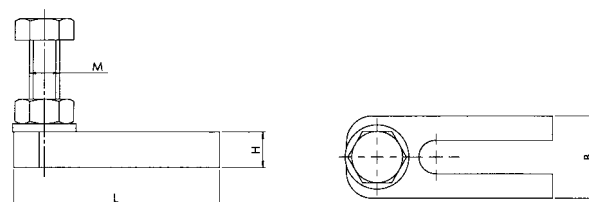
No. 6371

Lateral stop (additional)

For base, central and clamping jaw.



Order no.	Size	B	H	L	M	Weight [g]
266742	4220-50	16	7	40	6	35
266676	4380-80	18	8	60	6	69
295006	4380-1-80	18	8	78	6	80



No. 6371

Chip guard, right

No. 6371

Chip guard, left

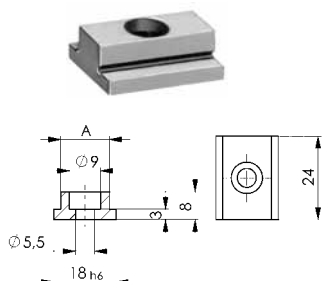


Order no.	Size	Weight [g]
300970	4222-50	19
300996	4391-80	43

Order no.	Size	Weight [g]
300939	4221-50	19
300954	4390-80	43

No. 6371

T-nut

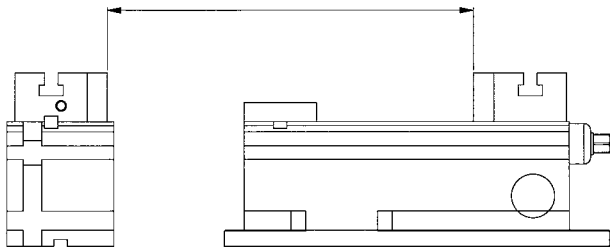
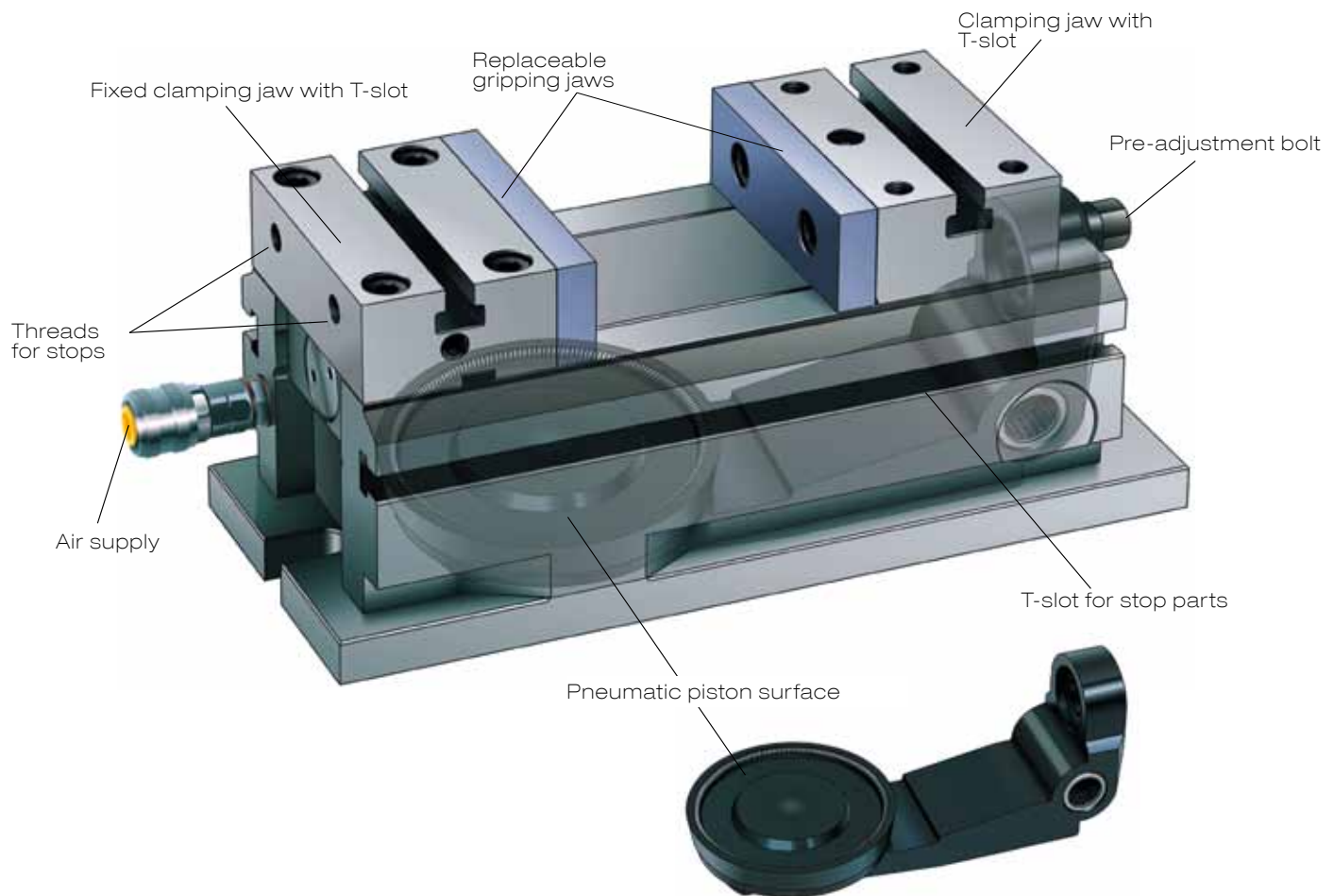


Order no.	Size	A	Weight [g]
301010	9010-10	10	16
301036	9012-12	12	17
301051	9014-14	14	18
301077	9018-18	18	23

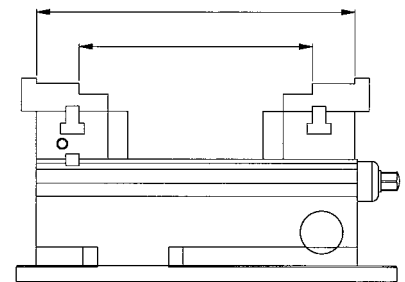
Subject to technical alterations.

PNEUMATIC VICE - THE ADVANTAGES AT A GLANCE

- > The pneumatic vice is specifically designed for the machining of single and series parts that require quick and precise clamping.
- > The clamping force is adjustable to different work-piece requirements.
- > Jaws case-hardened 60 HRC
- > Jaw widths 70 to 200 mm
- > Clamping forces up to 70 kN at 6 bar
- > The pneumatic operation significantly reduces the clamping time.
- > All supports and guides are hardened (55-60 HRC) and ground. The supports are manufactured to a height tolerance of ± 0.01 mm.
- > With 4 slots, locators, gauges and special jaws can be easily attached.



Vice with modular carrier



Vice with stepped gripping jaw

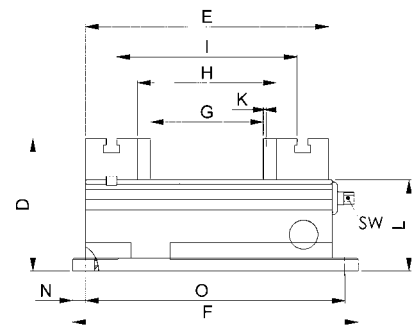
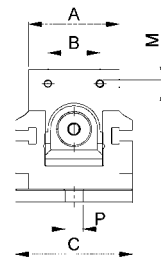
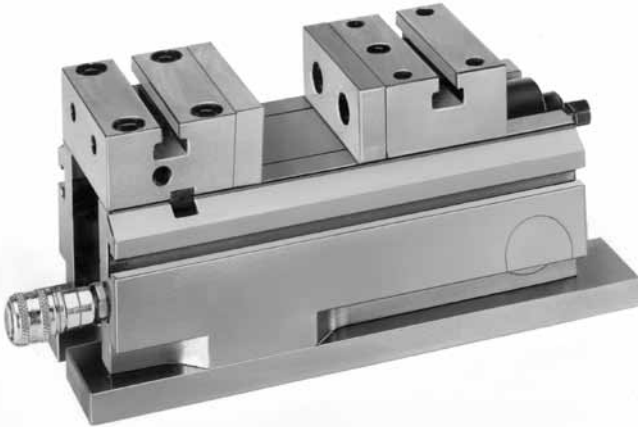
No. 6372

Base element

Hardened 56 HRC

With 1 pair of gripping jaws, smooth, hardened 60 HRc.

Order no.	Size	Jaw width A	Clamping force at 6 bar [kN]	Weight [Kg]
301085	0700-E070	70	5	8,5
301101	0900-E090	90	10	18
301127	1002-E100	100	15	25
301143	1150-E115	115	22	30
301168	1301-E130	130	30	39
301184	1600-E160	160	50	58
301200	2000-E200	200	70	112



Dimensions:

Order no.	B	C	D	E	F	G	H	I	Stroke K	L	M	N	O	P	SW
301085	40	90	102	187	220	87	107	139	2	70	M6	10	200	14	8
301101	44	112	128	241	248	103	133	177	4	92	M8	20	288	18	14
301127	46	128	145	260	317	86	116	178	4	105	M10	20	277	18	14
301143	60	140	145	290	340	112	142	206	3,2	105	M10	20	300	18	17
301168	65	160	155	315	370	127	163	229	3,5	110	M10	20	330	18	17
301184	80	196	160	368	403	164	200	272	4	115	M10	18,5	366	18	17
301200	100	236	195	475	480	235	275	361	4,5	135	M12	20	440	18	17

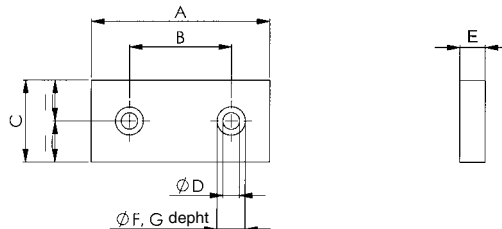
No. 6372

Gripping jaw, smooth

Hardened 60 HRc.



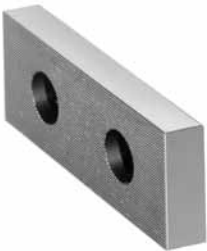
Order no.	Size	A	B	C	D	E	F	G	Weight [g]
301176	4048-E070	70	40	32	7,0	10	11	6,5	232
301192	4041-E090	90	44	36	8,5	15	14	9,0	352
301218	4042-E100	100	46	40	11,0	15	17	11,0	423
301234	4043-E115	115	60	40	11,0	15	17	11,0	493
301259	4044-E130	130	65	45	11,0	18	17	11,0	771
301275	4045-E160	160	80	45	11,0	18	17	11,0	950
301291	4046-E200	200	100	60	13,0	20	19	13,0	1790



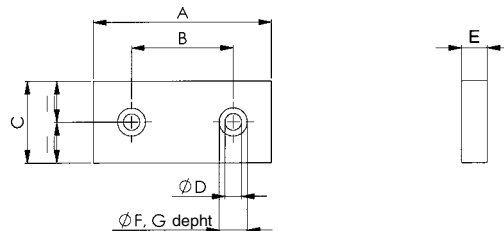
No. 6372

Gripping jaw, knurled

Hardened 60 HRc.



Order no.	Size	A	B	C	D	E	F	G	Weight [g]
301317	4071-E070	70	40	32	7,0	10	11	6,5	262
301333	4073-E090	90	44	36	8,5	15	14	9,0	322
301358	4074-E100	100	46	40	11,0	15	17	11,0	392
301374	4075-E115	115	60	40	11,0	15	17	11,0	455
301390	4076-E130	130	65	45	11,0	18	17	11,0	720
301416	4077-E160	160	80	45	11,0	18	17	11,0	896
301432	4078-E200	200	100	60	13,0	20	19	13,0	1661



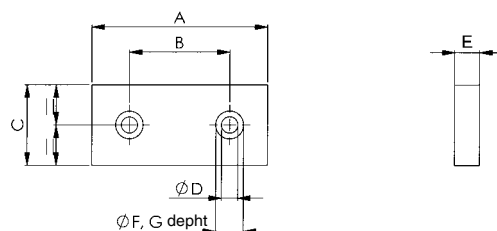
No. 6372

Gripping jaw, smooth

Not hardened, for individual processing.



Order no.	Size	A	B	C ±0.01	D	E ±0.01	F	G	Weight [g]
301580	4050-E070	70	40	32	7,0	10	11	6,5	235
301606	4001-E090	90	11	36	8,5	15	14	9,0	359
301622	4002-E100	100	46	40	11,0	15	17	11,0	426
301648	4003-E115	115	60	40	11,0	15	17	11,0	495
301663	4004-E130	130	65	45	11,0	18	17	11,0	775
301689	4005-E160	160	80	45	11,0	18	17	11,0	955
301705	4006-E200	200	100	60	13,0	20	19	13,0	1790



Subject to technical alterations.

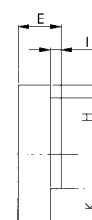
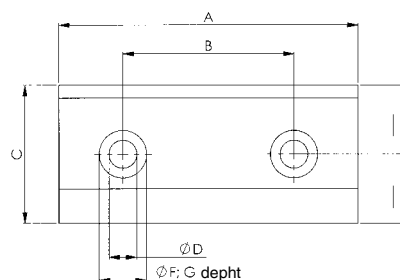
No. 6372

Gripping jaw, stepped

Hardened 60 HRc.



Order no.	Size	A	B	C ±0.01	D	E ±0.01	F	G	H ±0.01	I	K ±0.01	Weight [g]
301440	4061-E070	70	40	32	7,0	10	11	6,5	3	2,5	8	262
301465	4007-E090	90	44	36	8,5	15	14	9,0	4	3	9	322
301481	4008-E100	100	46	40	11,0	15	17	11,0	4	3	9	392
301507	4009-E115	115	60	40	11,0	15	17	11,0	4	3	9	455
301523	4010-E130	130	65	45	11,0	18	17	11,0	4	3	13	720
301549	4011-E160	160	80	45	11,0	18	17	11,0	4	3	13	896
301564	4012-E200	200	100	60	13,0	20	19	13,0	6	4	16	1661



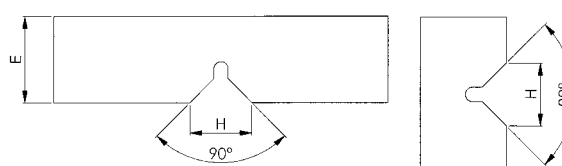
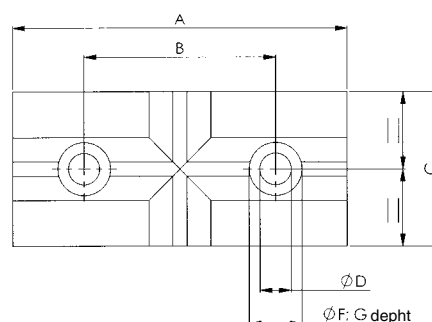
No. 6372

Gripping jaw, V-block

Hardened 60 HRc.



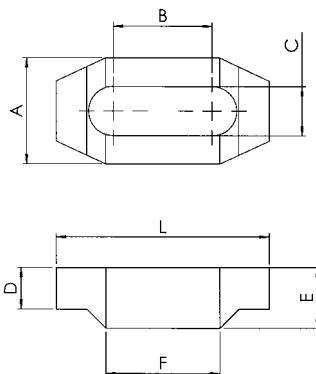
Order no.	Size	A	B	C ±0.01	D	E ±0.01	F	G	H	Weight [g]
301515	4054-E070	70	40	32	7	18	11	14	13,3	262
301531	4013-E090	90	44	36	9	26	14	20	20,3	532
301556	4014-E100	100	46	40	11	28	17	22	20,3	708
301572	4015-E115	115	60	40	11	28	17	22	20,3	822
301598	4016-E130	130	65	45	11	28	17	22	20,3	1079
301614	4017-E160	160	80	45	11	28	17	22	24,3	1296
301630	4018-E200	200	100	60	13	28	19	22	23,8	2260



No. 6372

Double-ended clamp

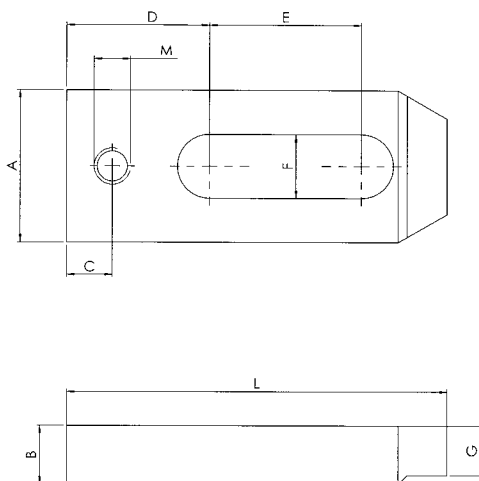
Order no.	Size	A	B	C	D	E	F	L	Weight [g]
301804	5003-E070-E090	28	26	13	11	16	30	56	135
301796	5001-E100-E200	38	30	17	16	18	34	60	226



No. 6372

Straight clamp

Order no.	Size	A	B	C	D	E	F	G	L	M	Weight [g]
301846	5006-E070-E090	26	16	12	33	25	13	11	86	12	278
301820	5002-E100-E200	50	19	15	47	50	21	16	125	12	524



No. 6372

Stop



Order no.	Size	Weight [g]
301861	5004	643

No. 6372

Pneumatic valve



Order no.	Size	Weight [g]
301903	6001	1037

No. 6372

Air filter and pressure regulator



Order no.	Size	Weight [g]
301929	6002	1079

No. 6376G

Clamping rail

Max. clamping force per clamping position 30 kN

Order no.	Size	B	dia. D1 +0,01	dia. D2	H ±0.02	H1	H2	L	dia. M	S1 +0,03	SM1 ±0,01	SM2 ±0,01	Weight [g]
429035	50x300	50	25	13	80	10	26	300	M12	5,5	50	100	6700
429050	50x400	50	25	13	80	10	26	400	M12	5,5	50	150	9160
429076	80x400	80	25	13	80	10	26	400	M12	5,5	50	150	16700
429092	50x500	50	25	13	80	10	26	500	M12	5,5	50	200	11650
429118	80x500	80	25	13	80	10	26	500	M12	5,5	50	200	21000
429134	80x600	80	25	13	80	10	26	600	M12	5,5	-	250	25200

Design:

Material: Case-hardened steel 21MnCr5, plasma-nitrided. Hardness 58 HRC.

Designed for the following mounting options on the machine table:

1. Lateral clamping rim for clamping shoe order no. 429258.
2. Through-hole in the clamping rail for socket head screw DIN ISO 4762-M12 for mounting using bolt and slot nut.
3. Prepared for clamping with the AMF Zero Point clamping system. Mounting holes at a distance of 50 or 100 mm for the clamping nipple K20.

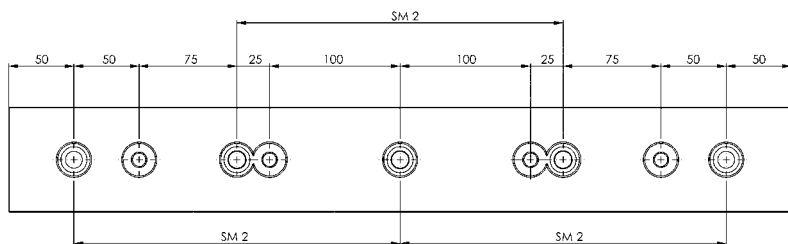
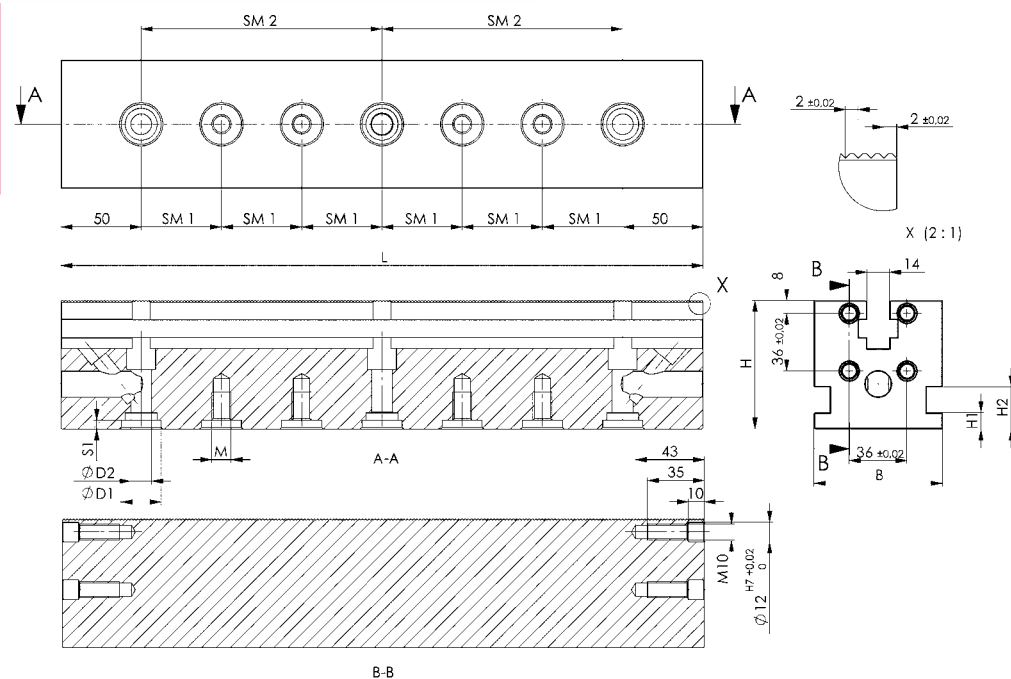
Other mounting holes, for example clamping nipple K10 or K40, can be supplied any time on request. Positioning steps on the clamping rail grating is possible at intervals of 2 mm.

Application:

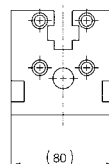
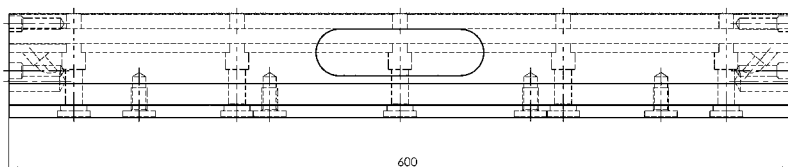
Modularly constructed clamping system, which has its advantages in the versatile application possibilities.

Optionally designed for one or more workpieces.

For rapid clamping of workpieces for machine processing. Through use of a wide array of fixed stops and wedge clamps, this clamping system is adapted to your needs.



for 429134



Subject to technical alterations.



No. 6376K

Wedge clamp

Smooth clamping surfaces

Scope of supply:

- Wedge clamp, smooth
- Fastening bolt
- T-nut



Order no.	Size	A min.	A max.	B1	B2	H min.	H max.	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429506	30	39	45	30	40	22	28	65	30	270
429522	40	39	45	40	50	22	28	65	30	340
429548	50	39	45	50	60	22	28	65	30	410
429563	72	47	57	72	84	29	38	65	30	530

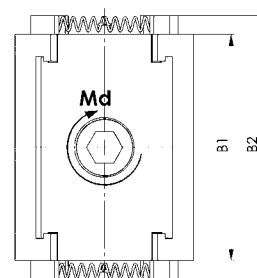
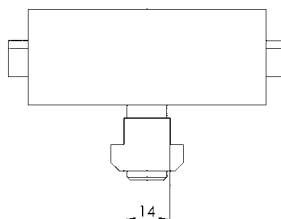
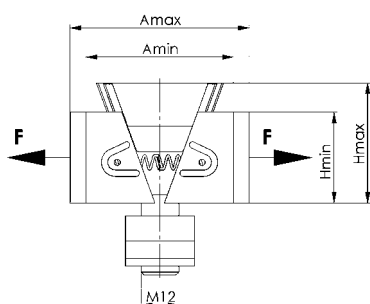
Design:

Material: case-hardened steel 21MnCr5

Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Application:

Workpieces are clamped quickly and securely with the AMF wedge clamp. Clamping takes place through a socket head screw and the wedge element, which moves the clamping jaw and so presses the workpiece against the stop.



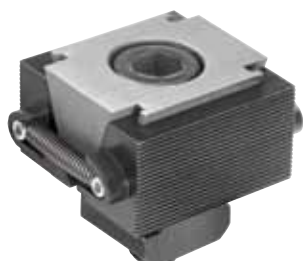
No. 6376KG

Wedge clamp

Serrated clamping surfaces

Scope of supply:

- Wedge clamp, serrated
- Fastening bolt
- T-nut



Order no.	Size	A min.	A max.	B1	B2	H min.	H max.	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429589	30	39	45	30	40	22	28	65	30	270
429605	40	39	45	40	50	22	28	65	30	340
429621	50	39	45	50	60	22	28	65	30	400
429647	72	47	57	72	84	29	38	65	30	870

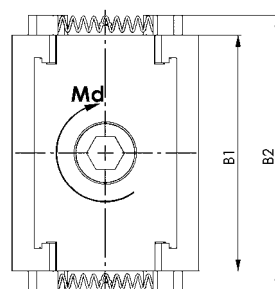
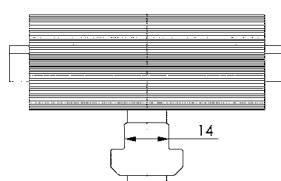
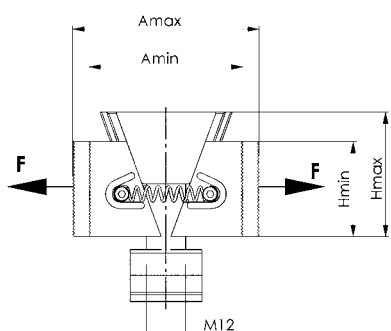
Design:

Material: case-hardened steel 21MnCr5

Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Application:

Workpieces are clamped quickly and securely with the AMF wedge clamp. Clamping takes place through a socket head screw and the wedge element, which moves the clamping jaw and so presses the workpiece against the stop.



No. 6376KW

Wedge clamp

Tolerance on clamping surfaces

Scope of supply:

- Wedge clamp with tolerance
- Fastening bolt
- T-nut



Order no.	Size	A min. *	A max. *	B1	B2	B3	G	H min.	H max.	H1	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429662	30	49	55	30	40	15	M5	22	28	11,0	65	30	320
429688	40	49	55	40	50	20	M5	22	28	11,0	65	30	400
429704	50	49	55	50	60	25	M5	22	28	11,0	65	30	500
429373	72	57	67	72	84	36	M6	29	38	14,5	65	30	1010

* Includes tolerance for inserting special geometries (5 mm).

Design:

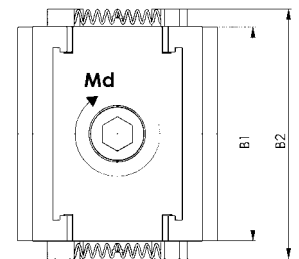
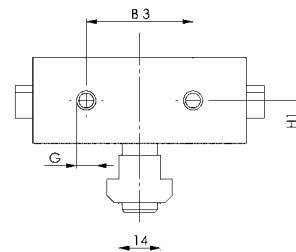
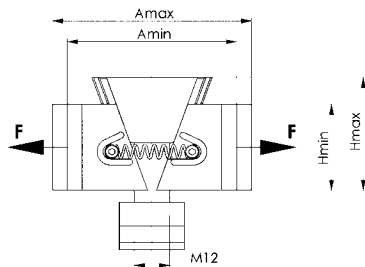
Material: case-hardened steel 21MnCr5

Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Wedge clamp with tolerance for inserting special geometries.

Application:

Workpieces are clamped quickly and securely with the AMF wedge clamp. Clamping takes place through a socket head screw and the wedge element, which moves the clamping jaw and so presses the workpiece against the stop.



No. 6376KK

Wedge clamp

With claw jaws

2 mm offset clamping step

Scope of supply:

- Wedge clamp with claw
- Fastening bolt
- T-nut



Order no.	Size	A min.	A max.	B1	B2	B3	G	H min.	H max.	H1	H3	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429399	30	49	55	30	40	15	M5	22	28	11,0	20	65	30	320
429415	40	49	55	40	50	20	M5	22	28	11,0	20	65	30	400
429431	50	49	55	50	60	25	M5	22	28	11,0	20	65	30	500
429456	72	57	67	72	84	36	M6	29	38	14,5	27	65	30	1100

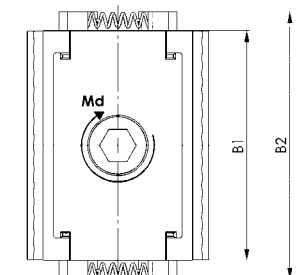
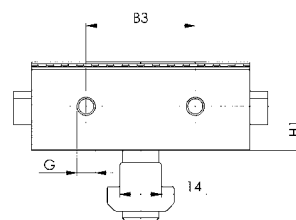
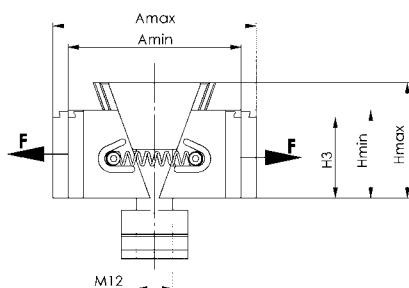
Design:

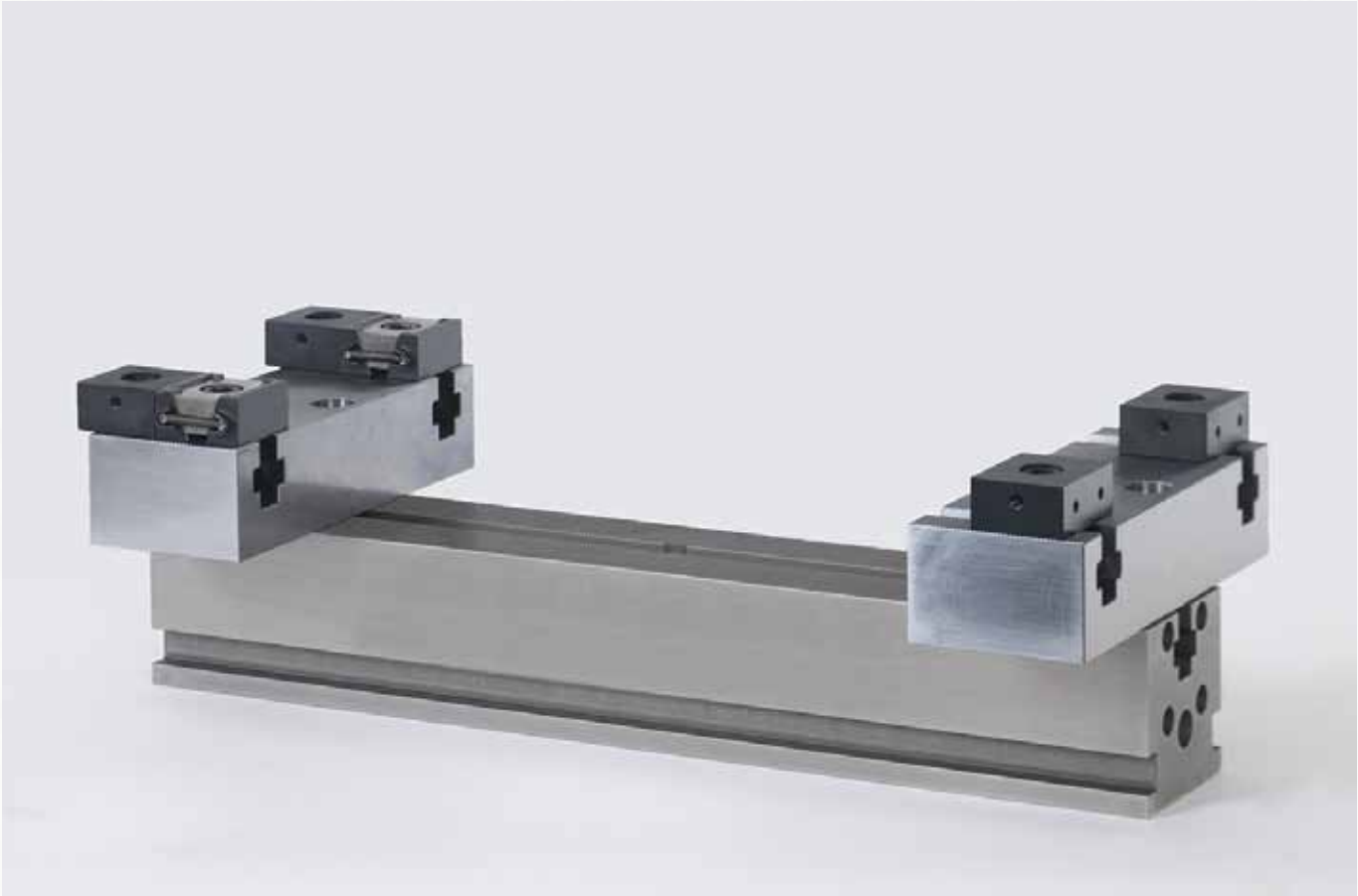
Material: case-hardened steel 21MnCr5

Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Application:

Workpieces are clamped quickly and securely with the AMF wedge clamp. Clamping takes place through a socket head screw and the wedge element, which moves the clamping jaw and so presses the workpiece against the stop.





No. 6376B

Fixed clamping jaw, smooth

Scope of supply:

- Fixed clamping jaw, smooth
- Fastening bolt
- T-nut



Order no.	Size	A	B	B3	G	H	H1	H2	Weight [g]
429274	30	42	30	15	M5	22	15	11,0	300
429290	40	42	40	20	M5	22	15	11,0	370
429316	50	42	50	25	M5	22	15	11,0	450
429332	72	42	72	36	M6	29	22	14,5	810

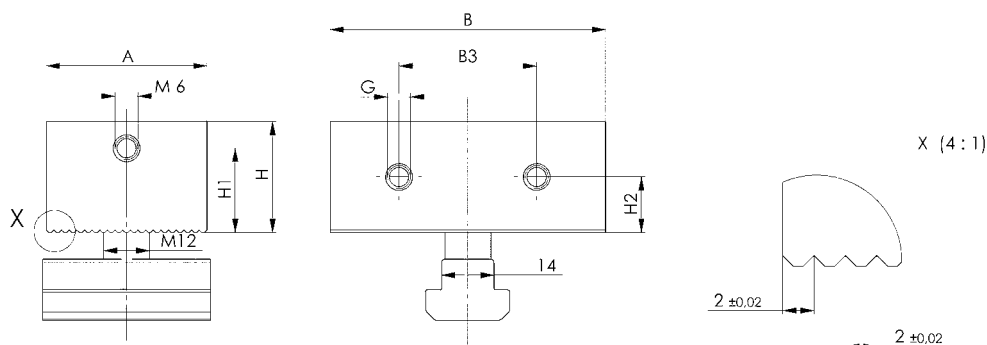
Design:

Material: case-hardened steel 21MnCr5

Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Application:

The fixed stop is positioned on the clamping rail via the tightening bolt and grips, positively interlocked, on the 2 mm serration. Workpieces can be positioned and clamped with great clamping force.



No. 6376BG

Fixed clamping jaw, serrated

Scope of supply:

- Fixed clamping jaw, serrated
- Fastening bolt
- T-nut



Order no.	Size	A	B	H	H1	Weight [g]
429357	30	42	30	22	15	300
429365	40	42	40	22	15	370
429381	50	42	50	22	15	450
429407	72	42	72	29	22	800

Design:

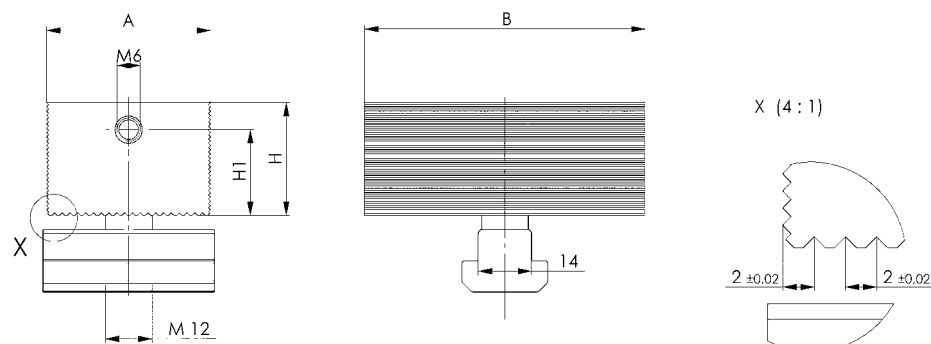
Material: case-hardened steel 21MnCr5

Highly tempered and case hardened to 52 HRC.

Hardness depth 0.6 mm

Application:

The fixed stop is positioned on the clamping rail via the tightening bolt and grips, positively interlocked, on the 2 mm serration. Workpieces can be positioned and clamped with great clamping force.



No. 6376BK

Fixed clamping jaw

With claw jaws,
2 mm offset clamping step
Scope of supply:
- Fixed clamping jaw with claw
- Fastening bolt
- T-nut



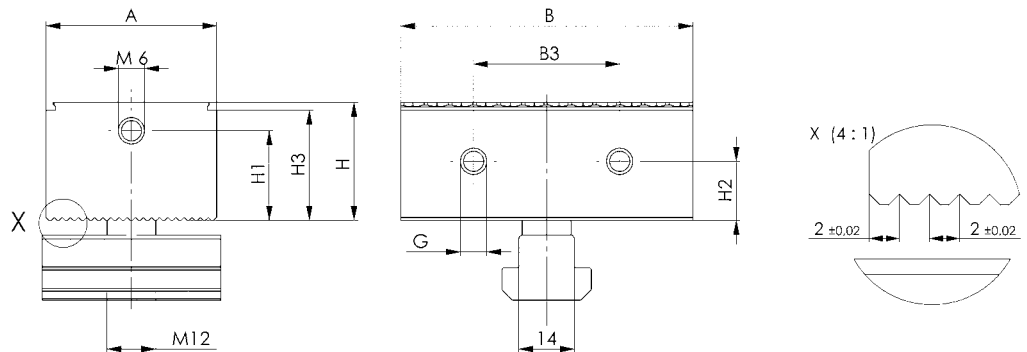
Order no.	Size	A	B	B3	G	H	H1	H2	H3	Weight [g]
429423	30	42	30	15	M5	22	15	11,0	20	300
429449	40	42	40	20	M5	22	15	11,0	20	370
429464	50	42	50	25	M5	22	15	11,0	20	450
429480	72	42	72	36	M6	29	22	14,5	27	800

Design:

Material: case-hardened steel 21MnCr5
Highly tempered and case hardened to 52 HRC. Hardness depth 0.6mm

Application:

The fixed stop is positioned on the clamping rail via the tightening bolt and grips, positively interlocked, on the 2 mm serration.
Workpieces can be positioned and clamped with great clamping force.



No. 6376VB

Front jaw



Order no.	A	B	D	H	H1	L1	L2	Weight [g]
429696	11	50	6	22	25	15	25	80
429712	22	72	7	29	32	25	36	320

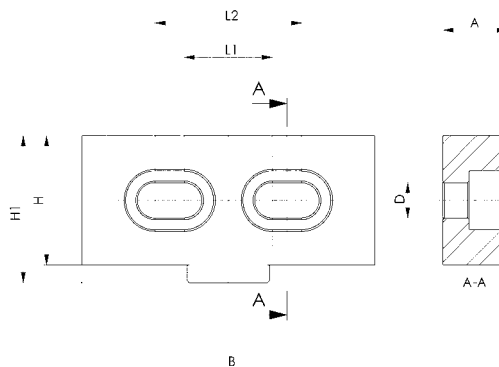
Design:

Aluminium

Application:

Aluminium front jaws for cutting customised contours.

Suitable for:
Order no. 429696: Wedge clamp no. 6376KW-30, -40 and -50
Fixed stop no. 6376B-30, -40 and -50.
Order no. 429712: Wedge clamp no. 6376KW-72
Fixed stop no. 6376B-72



No. 6376Z

Adapter set

Scope of supply:

- Adapter
- 2 threaded studs with hexagon socket



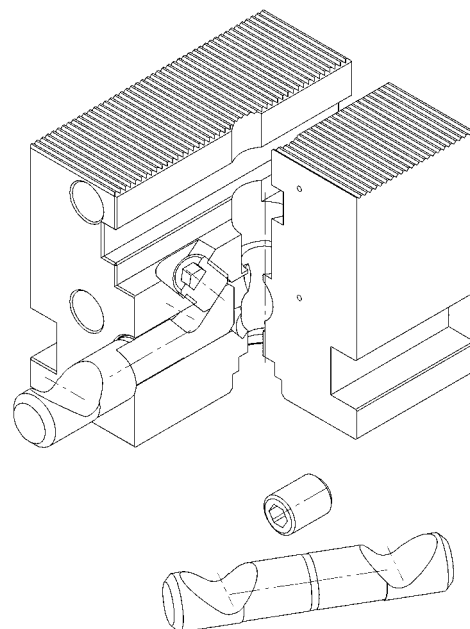
Order no.	for size	Weight [g]
429159	30, 40, 50, 72	350

Design:

Case-hardened steel, plasma-nitrided.

Application:

With the adapter, two clamping rails can be connected directly to each other without distance.



No. 6376Z

Stop, flexible

Scope of supply:

- Flexible stop
- Fastening bolt M6
- Adjusting screw M6



Order no.	For clamping jaw	Weight [g]
429175	6376B, 6376BG, 6376BK	150

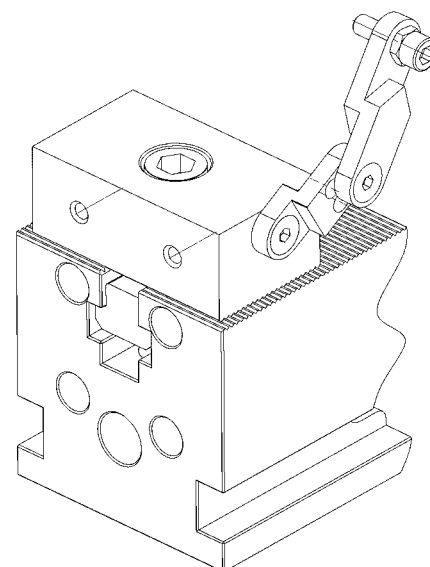
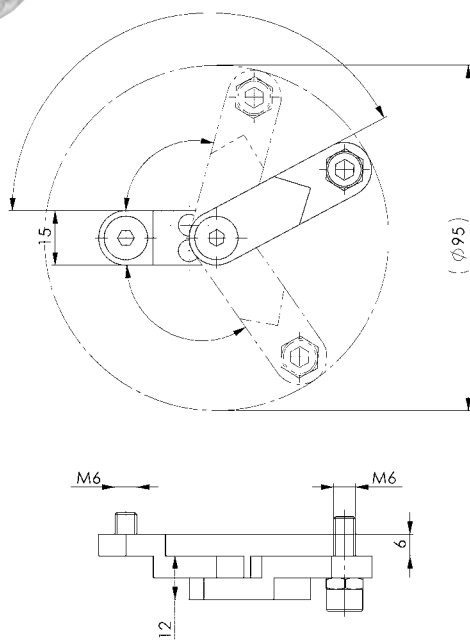
Design:

Aluminium

Application:

Lateral stop for positioning workpieces.

Stop is screwed to the fixed jaw and can be adjusted in two directions through its joint.

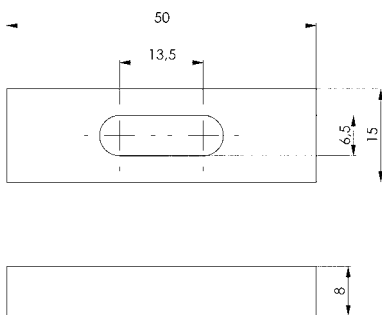


Subject to technical alterations.

No. 6376Z

Stop, fixed

Scope of supply:
- Stop
- Fastening bolt



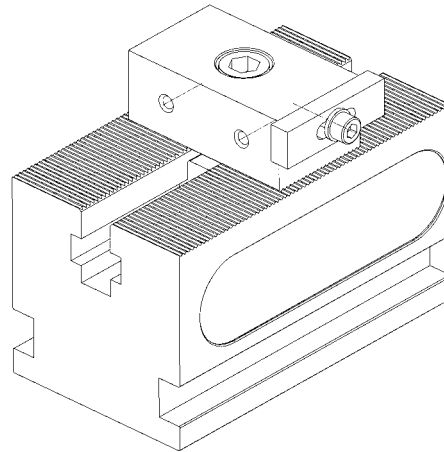
Order no.	For clamping jaw	Weight
		[g]
429191	6376B, 6376BG, 6376BK	40

Design:

Aluminium

Application:

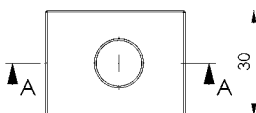
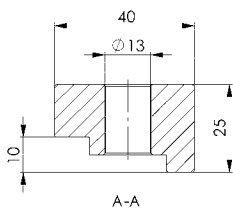
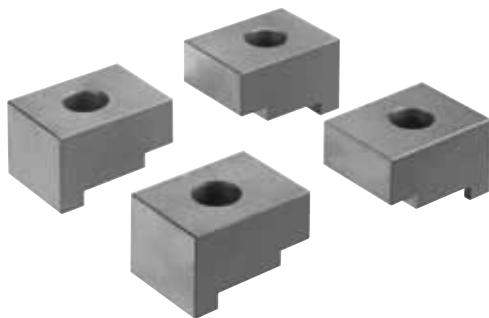
Lateral stop for positioning workpieces.
Stop is screwed to the fixed jaw and can be moved.



No. 6376Z

Clamping shoe

Scope of supply:
- 4 clamping shoes per packaging unit



Order no.	For clamping rail	Weight
		[g]
429258	6376G	480

Design:

Tempered steel, burnished.

Application:

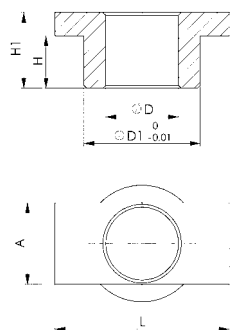
For mounting of the clamping rail on the machine table with slots.

Note:

Suitable slot nuts and threaded pins can be found in the AMF catalogue „Mechanical clamping elements“.

No. 6376Z

Positioning socket



Order no.	A	dia. D	dia. D1	H	H1	L	Weight [g]
429233	18	12,5	20	9	13	30	15
429217	14	12,5	20	9	13	30	14

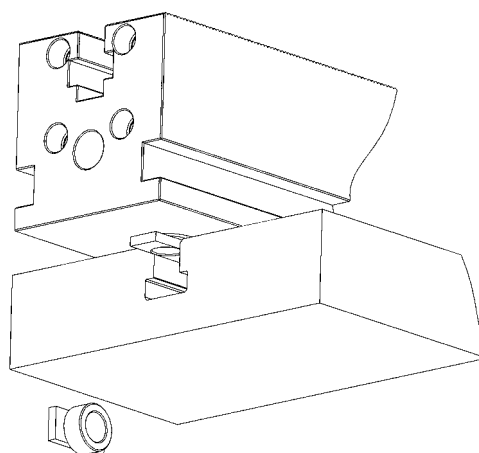
Design:

Tempered steel, burnished.

Application:

Positioning socket for simplified orientation of the clamping rail on the machine table.

All clamping rails are equipped on the bottom with fittings for the positioning sockets. As a result, the clamping rails can be oriented on the machine table quickly and easily.



No. 6376Z

Adapter set for ZPS clamping nipple K10

Supply scope:
- 1 Adapter sleeve
- 1 Positioning bush



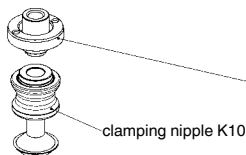
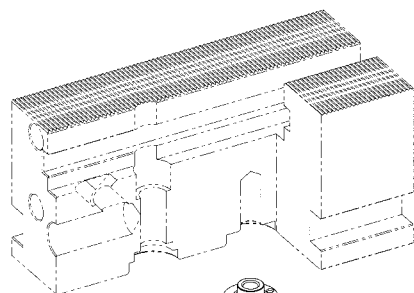
Order no.	D1	D2	S1	H	Weight [g]
430207	25	15	5,5	19	23

Design:

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

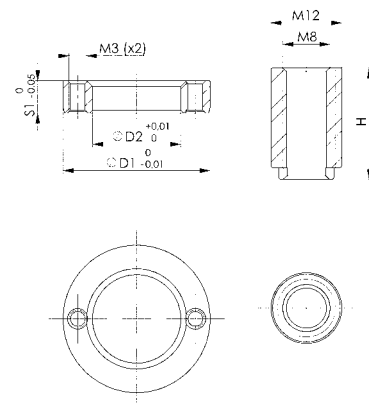
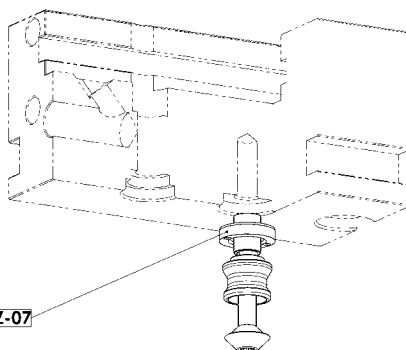
Application:

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



6376Z-07

clamping nipple K10



No. 6376Z

Adapter set for ZPS clamping nipple K10

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



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

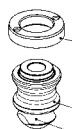
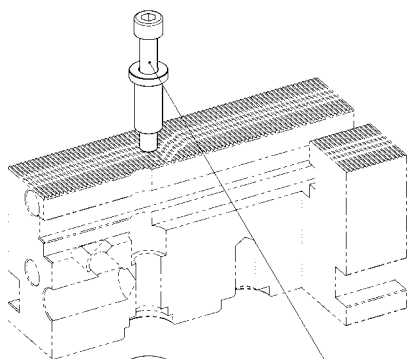
Design:

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

The fastening bolt conforms to strength class 10.9.

Application:

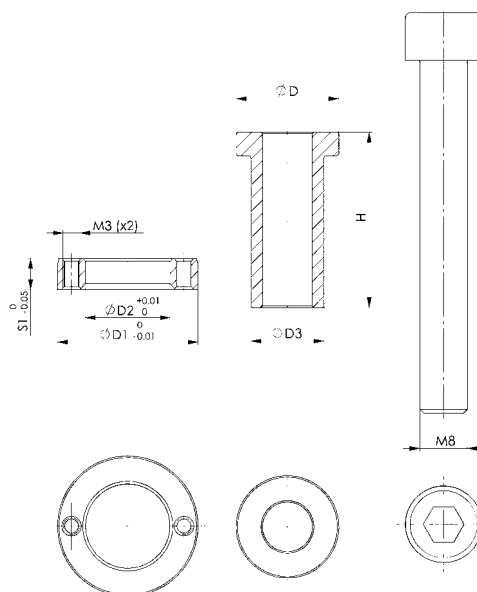
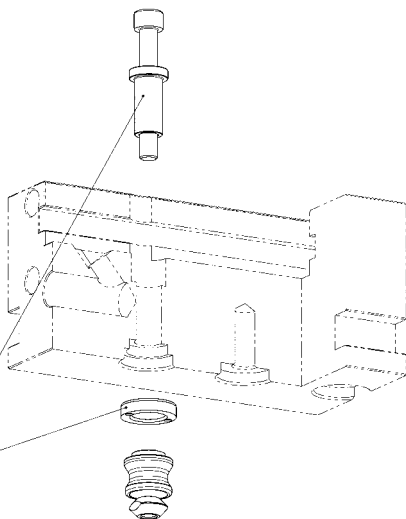
Adapter set for reducing the locating bore from K20 to K10 ZPS clamping nipple. For through-bores in the clamping rail, see Item No. 6376G.



clamping nipple K10

clamping female nipple K10
(Order no.: 429985)

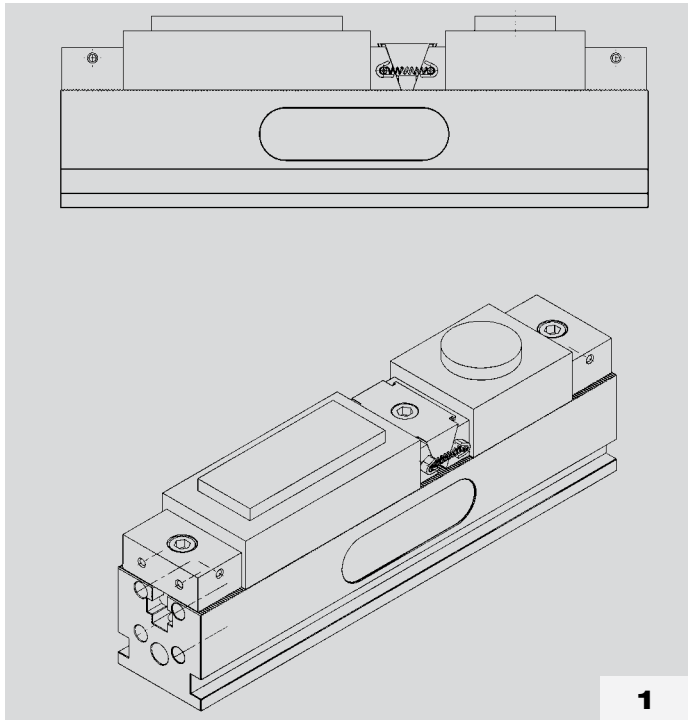
6376Z-08



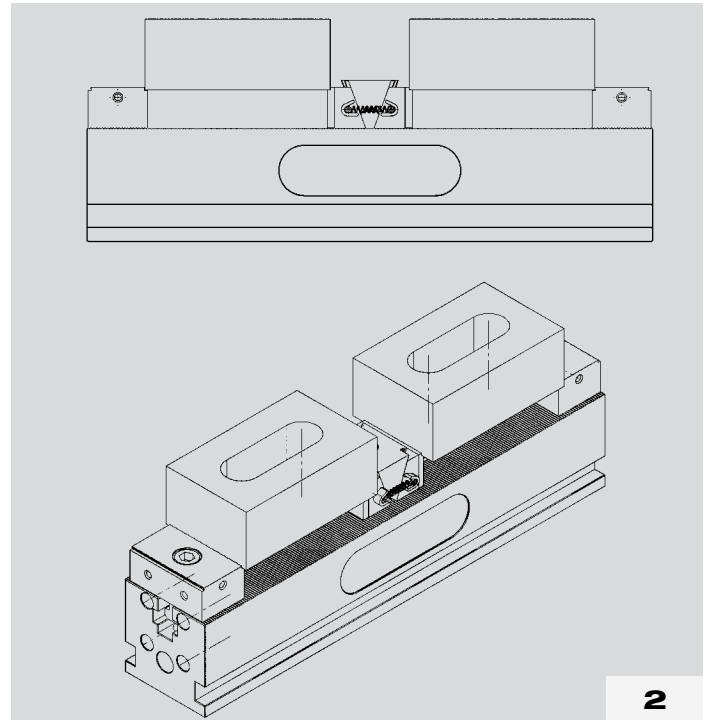
Subject to technical alterations.

Application examples

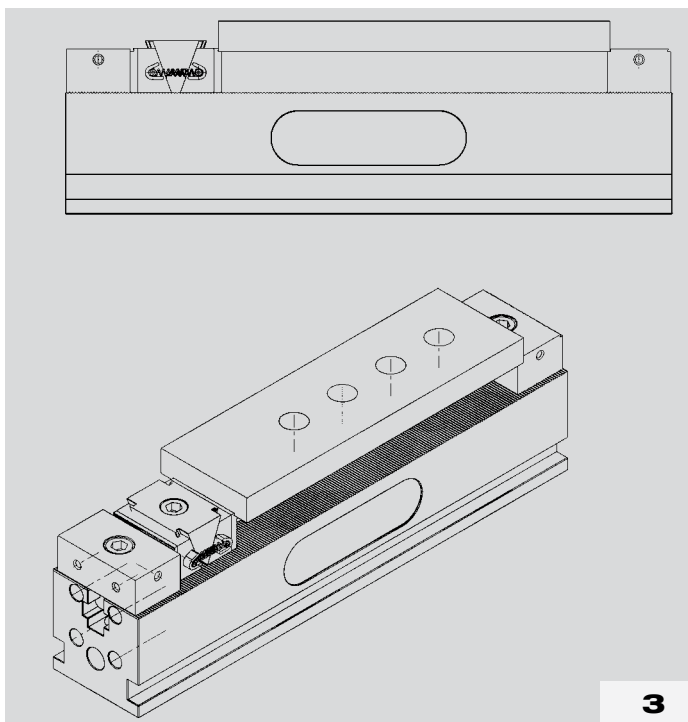
- > **1** clamping of workpieces with smooth clamping jaws
- > **2** clamping of workpieces with claw jaws
- > **3** clamping of a workpiece with claw jaws
- > **4** clamping of dissimilar workpieces with claw jaws



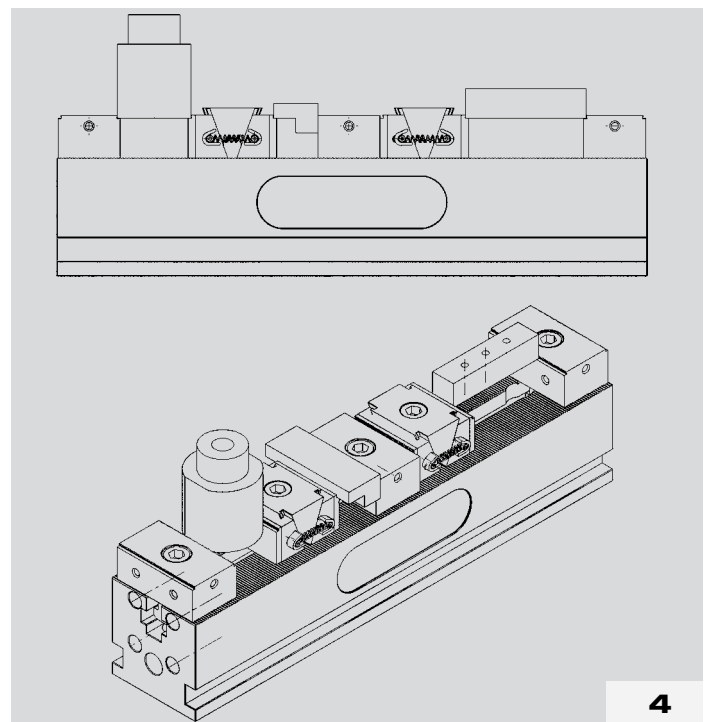
1



2



3



4

No. 6376A

5-axis clamp

Serration top and bottom

Scope of supply:

- 5-axis clamp, 1 piece
- Fastening bolt
- T-nut

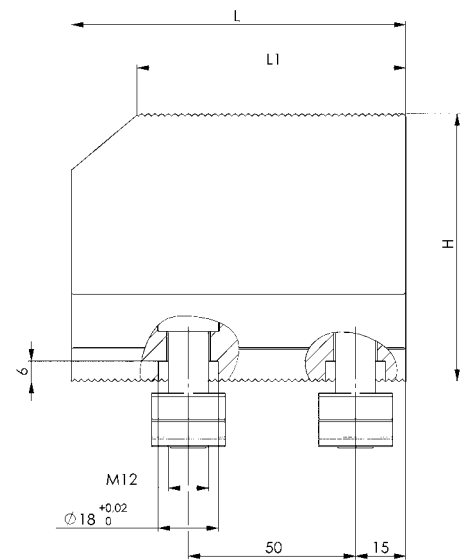
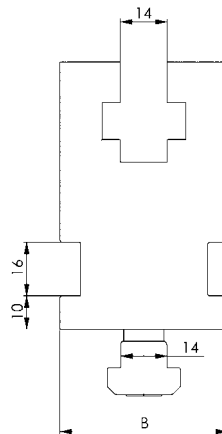
Order no.	Size	B	H	L	L1	Weight [Kg]
429472	50x100	50	80	100	80	2,4
429498	80x100	80	80	100	80	4,2

Design:

Material: case-hardened steel 21MnCr5, plasma-nitrided hardness 58 HRC.

Application:

The structure for 5-sided machining is mounted on the clamping rail no. 6376G. Through the serration, this structure grips the clamping rail positively interlocked and can be supplemented, for example, with wedge clamp no. 6376KA or no. 6376KKA and fixed stop no. 6376BA or no. 6376KA. This structure is suitable for converting the multiple clamping system into a clamping means for 5-sided machining. This conversion can be made with just a few hand movements.



Subject to technical alterations.

No. 6376KA

Wedge clamp

With fixed jaw for 5-axis clamp

Scope of supply:

- Wedge clamp, smooth
- Fastening bolt
- T-nut



Order no.	Size	A min.	A max.	B1	B2	B3	G	H min.	H max.	H1	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429514	40	58	65	40	50	20	M5	22	28	11,0	65	30	600
429530	72	60	70	72	84	36	M6	29	38	14,5	65	30	1150

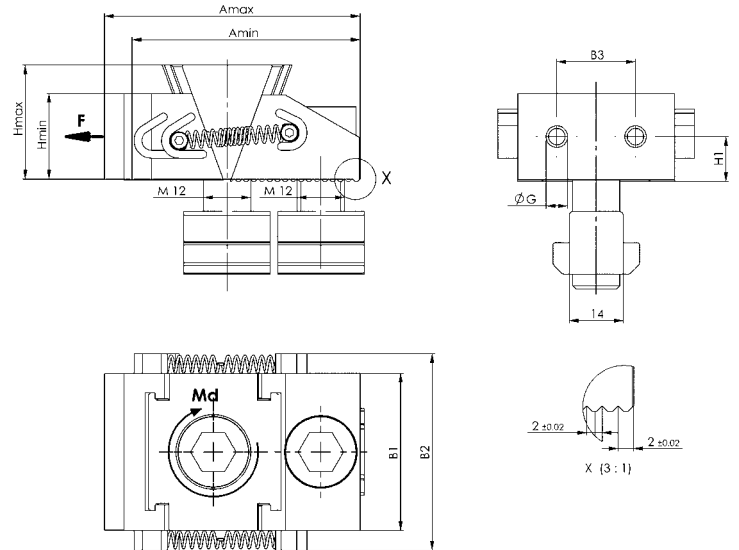
Design:

Material: case-hardened steel 21MnCr5

Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Application:

Workpieces are clamped quickly and securely with the AMF wedge clamp. Clamping takes place through a socket head screw and the wedge element, which moves the clamping jaw and so presses the workpiece against the stop.



No. 6376KKA

Wedge clamp

With fixed jaw for 5-axis clamp

With claw jaws

2 mm offset clamping step

Scope of supply:

- Wedge clamp with claw
- Fastening bolt
- T-nut



Order no.	Size	A min.	A max.	B1	B2	B3	G	H min.	H max.	H1	H3	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429613	40	53	60	40	50	20	M5	22	29	11,0	20	65	30	570
429639	72	65	75	72	84	36	M6	29	40	14,5	27	65	30	1120

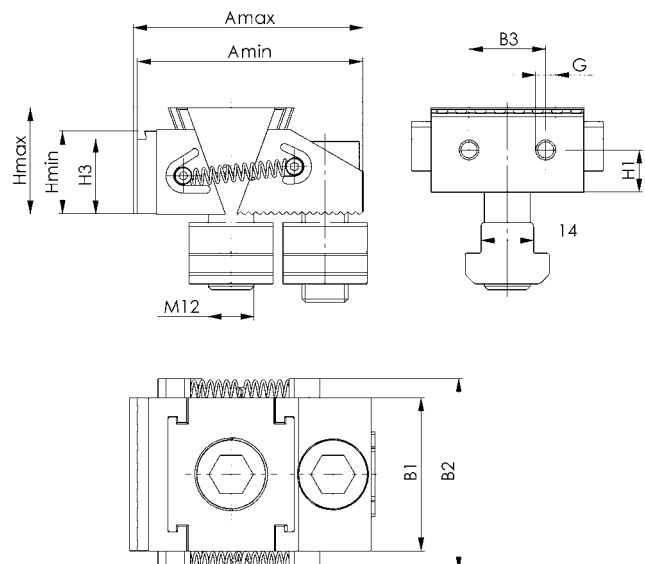
Design:

Material: case-hardened steel 21MnCr5

Highly tempered and case hardened to 52 HRC. Hardness depth 0.6 mm

Application:

Workpieces are clamped quickly and securely with the AMF wedge clamp. Clamping takes place through a socket head screw and the wedge element, which moves the clamping jaw and so presses the workpiece against the stop.



Subject to technical alterations.

No. 6376BA

Fixed clamping jaw, smooth

For 5-axis clamp design

Scope of supply:

- Fixed clamping jaw, smooth
- Fastening bolt
- T-nut



Order no.	Size	A	B	H	H1	H2	B3	G	Weight [g]
429555	40x40	42	40	22	15	11,0	20	M5	230
429571	72x40	42	72	29	22	14,5	36	M6	505

Design:

Material: case-hardened steel 21MnCr5

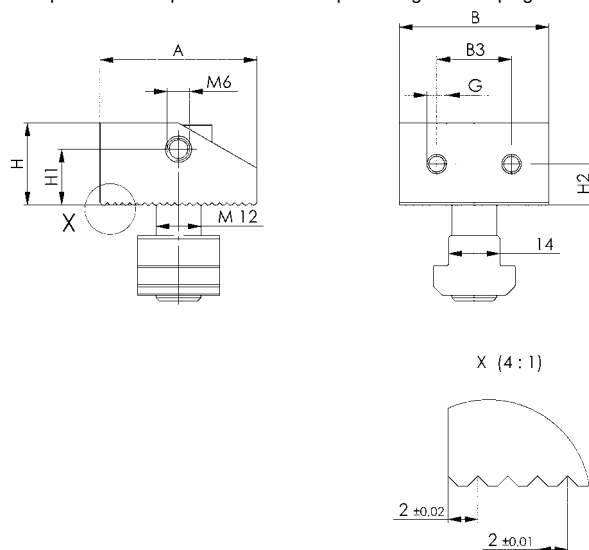
Highly tempered and case hardened to 52 HRC.

Hardness depth 0.6 mm

Application:

The fixed stop is positioned on the clamping rail via the tightening bolt and grips, positively interlocked, on the serration.

Workpieces can be positioned and clamped with great clamping force.



No. 6376BKA

Fixed clamping jaw

For 5-axis clamp design

With claw jaws,

2 mm offset clamping step

Scope of supply:

- Fixed clamping jaw with claw
- Fastening bolt
- T-nut



Order no.	Size	A	B	H	H1	H2	B3	G	Weight [g]
429654	40x40	42	40	22	15	11,0	20	M5	205
429670	72x40	42	72	29	22	14,5	36	M6	530

Design:

Material: case-hardened steel 21MnCr5

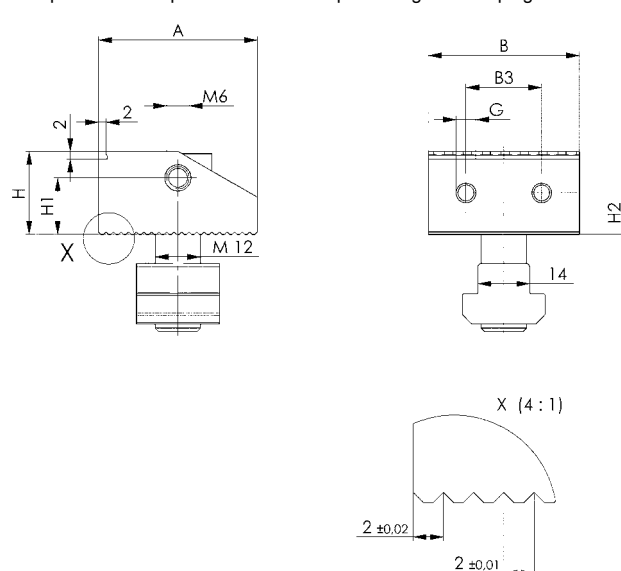
Highly tempered and case hardened to 52 HRC.

Hardness depth 0.6 mm

Application:

The fixed stop is positioned on the clamping rail via the tightening bolt and grips, positively interlocked, on the serration.

Workpieces can be positioned and clamped with great clamping force.



Subject to technical alterations.



- + Fully automatic cleaning of the fixture and the complete inside space of the machine
- + Removes from employees the burden of disliked and unproductive tasks



- + Economical marking of workpieces directly in the machine tool
- + Reduces throughput times of parts in production

... BY ITEM NO.

Article no.	Page	Article no.	Page	Article no.	Page	Article no.	Page	Article no.	Page
No. 6207S4	16	No. 6371G-80	20	No. 6376A	46	No. 6376K	36	No. 6376Z	42-44
No. 6207ZN-15	16	No. 6372	29-33	No. 6376B	39	No. 6376KA	47	No. 6377	12
No. 6370ZSB	8	No. 6375H	5	No. 6376BA	48	No. 6376KG	36	No. 6377B	14
No. 6370ZSZ-112	8	No. 6375M	4	No. 6376BG	39	No. 6376KK	37	No. 6377BG	14
No. 6371	22-27	No. 6375ZK-99	7	No. 6376BK	40	No. 6376KKA	47	No. 6377G	13
No. 6371G-120	20	No. 6375Z-149	6	No. 6376BKA	48	No. 6376KW	37		
No. 6371G-50	20	No. 6375Z-99	6	No. 6376G	34	No. 6376VB	40		

... BY ORDER NO.

Order no.	Page	Order no.	Page	Order no.	Page	Order no.	Page	Order no.	Page
265793	22	301002	26	301598	31	304998	24	429464	40
265835	23	301010	27	301606	30	305003	23	429472	46
266569	26	301028	26	301614	31	305011	25	429480	40
266577	27	301036	27	301622	30	305029	26	429498	46
266585	26	301044	26	301630	31	305037	25	429506	36
266593	27	301051	27	301648	30	305045	27	429514	47
266601	26	301069	27	301663	30	305052	27	429522	36
266619	27	301077	27	301689	30	305060	27	429530	47
266627	27	301085	29	301705	30	305078	27	429548	36
266635	27	301101	29	301796	32	305086	26	429555	48
266643	27	301127	29	301804	32	305094	26	429563	36
266650	27	301143	29	301820	32	305102	26	429571	48
266668	27	301168	29	301846	32	428649	6	429589	36
266676	27	301176	30	301861	33	428656	6	429605	36
266684	27	301184	29	301903	33	429035	34	429613	47
266700	27	301192	30	301929	33	429050	34	429621	36
266726	27	301200	29	304733	20	429076	34	429639	47
266742	27	301218	30	304758	20	429092	34	429647	36
266809	22	301234	30	304766	20	429118	34	429654	48
266825	23	301259	30	304774	20	429134	34	429662	37
266841	26	301275	30	304782	20	429159	41	429670	48
266866	26	301291	30	304790	20	429175	41	429688	37
266882	26	301317	30	304808	20	429191	42	429696	40
266908	27	301333	30	304816	20	429217	43	429704	37
290635	22	301358	30	304824	20	429233	43	429712	40
290650	22	301374	30	304832	26	429258	42	430207	44
295006	27	301390	30	304840	20	429274	39	430223	44
300863	24	301416	30	304857	26	429290	39	533281	4
300871	27	301432	30	304865	20	429316	39	535658	16
300889	24	301440	31	304873	20	429332	39	535690	16
300897	27	301465	31	304881	20	429357	39	545582	5
300905	23	301481	31	304899	20	429365	39	546788	16
300913	27	301507	31	304907	20	429373	37	549865	16
300921	23	301515	31	304915	20	429381	39	550278	7
300939	27	301523	31	304923	20	429399	37	550286	8
300947	26	301531	31	304931	22	429407	39	550287	8
300954	27	301549	31	304949	20	429415	37	550656	12
300962	26	301556	31	304956	22	429423	40	550657	13
300970	27	301564	31	304964	20	429431	37	550658	14
300988	26	301572	31	304972	24	429449	40	550659	14
300996	27	301580	30	304980	22	429456	37		

... IN ALPHABETICAL ORDER

Description	Page	Description	Page
A		Front jaw	40
Adapter set	41	G	
Adapter set for ZPS clamping nipple K10	44	Gripping jaw, knurled	26, 30
Air filter and pressure regulator	33	Gripping jaw, smooth	26, 30
B		Gripping jaw, soft	26
Base element	20, 29	Gripping jaw, stepped	31
Base jaw, deep	22	Gripping jaw, V-block	31
Base jaw, standard	22	Gripping jaw, with claws	26
Base jaw, without step	22	H	
C		Hydraulic collet	5
Centering vice ribbed clamping jaws „Black-Edition“	13	L	
Centering vice soft clamping jaws „Black-Edition“	12	Lateral stop (additional)	27
Central jaw	23	M	
Chip guard, left	27	Mechanical collet	4
Chip guard, right	27	Mounting kit for collet attachment	8
Clamping jaw, deep	24	P	
Clamping jaw, standard	23	Pneumatic valve	33
Clamping jaw, with crescent	25	Positioning socket	43
Clamping jaw, without step	24	S	
Clamping Jaws, ribbed	14	Stop	33
Clamping Jaws, soft	14	Stop, fixed	42
Clamping nipple	16	Stop, flexible	41
Clamping rail	34	Straight clamp	32
Clamping shoe	42	Support wedge	27
Collet attachment for clamping module K20, hydr.	8	T	
Collet, single	6, 7	T-nut	27
D		W	
Double-ended clamp	32	Wedge clamp	36, 37, 47
F		4	
Fixed clamping jaw	40, 48	4-point clamping station, mechanical	16
Fixed clamping jaw, serrated	39	5	
Fixed clamping jaw, smooth	39, 48	5-axis clamp	46

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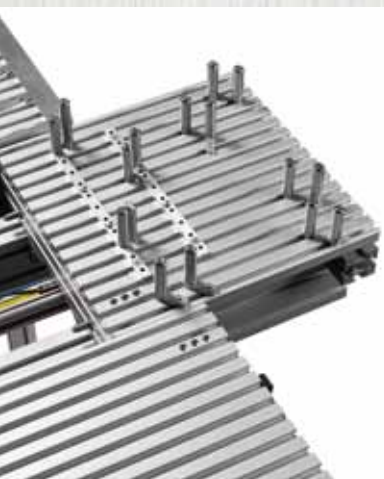
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Postfach 1760 · D-70707 Fellbach

Phone: +49 711 5766-0

Fax: +49 711 575725

E-mail: amf@amf.de

Internet: www.amf.de

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