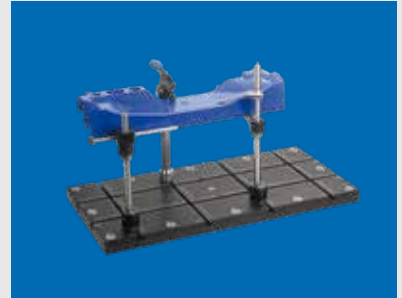
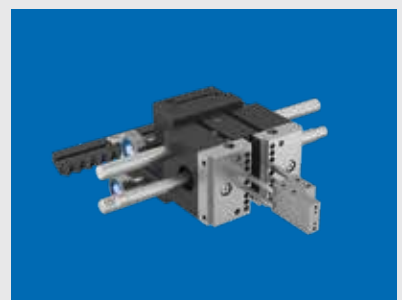
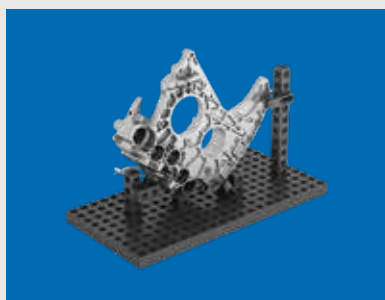


## *Fixturing systems*



## *Clamping systems for measuring technology*



## Good to know ...

Our range includes around 1000 products. We have clearly divided these into several thematic categories. Please consult the index or the detailed product finder which can be found at the start of each chapter.



### Pictogram legend

There is a detailed pictogram legend on page 11 of this catalogue which explains all pictograms and the corresponding connections in detail. The symbols illustrate the combination possibilities of the individual basic, structural and clamping elements to produce complete clamping fixtures.



### Combination possibilities for applications

In order to demonstrate the possible combinations as precisely as possible, a number of detailed application examples are included in this catalogue. These examples show which products have been combined and which products may be additionally combined.



### CADENAS – Data and downloads

CADENAS is a leading software producer in the field of strategic part management, part reduction (PARTsolutions) and electronic CAD product catalogues (eCATALOG-solutions). Generated CAD models, datasheets and the possibility to make a direct enquiry for the *SWA 39*, *SPANNFIX*, *QUADERFIX* and *SCHIENENFIX* ranges are available over the CADENAS database.

<http://dk.partcommunity.com/3d-cad-models>



**The digital version of our catalogue is available here:** [www.dk-fixiersysteme.de](http://www.dk-fixiersysteme.de)



### You have questions about our products?

We can advise you personally and look forward to your call. We are available weekdays from 8.00 to 16.00 under +49 (0) 7121 90 97 10.



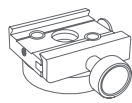


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Product advantages and information	10
Connections and pictogram legend	11

### Product overview

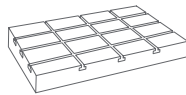
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#### SWA39

Quick-change system for tactile and optical measuring

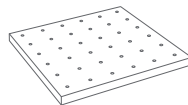
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#### SPANNFIX PRO

Professional clamping system for tactile measuring

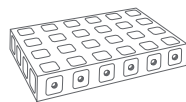
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#### SPANNFIX ECO

Economic clamping system for tactile measuring

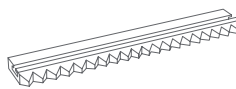
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#### QUADERFIX

3D clamping system for tactile measuring

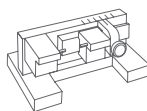
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#### SCHIENENFIX

Clamping system for optical and multi-sensorial measuring

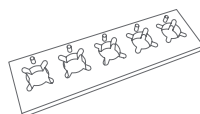
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#### MICROFIX

Clamping solutions for micro parts

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#### SPEZIALFIX

Customer-specific clamping fixtures

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Part number index

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## Company

dk FIXIERSYSTEME has been developing, producing and marketing metrological clamping systems for almost 30 years. At our site in Germany, we produce modular systems of standard elements and special solutions for tactile, optical and multi-sensorial measuring equipment and now for computer tomography. Our products enjoy an excellent reputation worldwide and are valued by measuring technicians from many branches. Our credo is "listening, understanding, thinking, acting" and many of our products are the result of direct dialogue with our customers.


Our solutions help make your work easier and improve the efficiency of your metrology machines, thereby contributing to your overall success. Generally, durable modular systems are more economical than part-specific special clamping devices. The modular structure combined with the quick-change capability make dk FIXIERSYSTEME products for parts from 0.1 to 1000 mm unique worldwide in terms of function and number of components.

Innovative product development also takes place in related application sectors such as laser, marking, dispensing and handling technology. This additional know-how benefits the overall modular system and thus also the measurement technology.

The new catalogue presents an even more comprehensive range of parts and explains them coherently. We wish you every success.



Karl Holzer  
*Sales Management*

 **Contact us directly:**  
[www.dk-fixiersysteme.de/request](http://www.dk-fixiersysteme.de/request)



## Certificates

Our company places a high value on long-term quality and customer satisfaction, which is why dk FIXIERSYSTEME has been certified for many years.

Our company's guiding principles are customer satisfaction, technical innovation and process orientation in thinking and acting. To ensure that we deliver on these, we also have to fulfil complex processes and workflow management requirements. To achieve this we have an efficient quality management system that controls internal workflows and maintains the highest levels of product quality and customer service.

To demonstrate this to our customers, dk FIXIERSYSTEME is certified according to ISO 9001 : 2015, which is a globally recognised proof to customers, partners and suppliers for our organised quality management and ensures a continuous improvement process by our employees.

The current DIN ISO 9001:2015 certificates are available to download at any time from [www.dk-fixiersysteme.de](http://www.dk-fixiersysteme.de).



### **Our mission:**

We solve our customer's clamping problems and make their tasks easier, more successful and more efficient.

## Our service for you

We also develop, design and manufacture special clamping devices specifically tailored to your individual requirements and perfectly suited to your test parts and processes. These include multiple clamping, part specific fixation, control and test gauges, purely mechanical as well as partially or fully automated solutions based on pneumatic or electromechanical drives. We are happy to project fixation systems with you, which are based on our standard elements or completely detached from them.

We supplement your special requests and ideas with our experience and so create new products. We support you any time personally and with commitment by providing data, know-how and creativity. Knowledge, product information and suggestions can be obtained by telephone, email and also directly on site from our field representatives, application technicians and partners. Together we can find the best solutions. Get to know the world of dk FIXIERSYSTEME – get in touch today!



### FAST REASSEMBLY LIFELONG

The basic principle of all dk fixturing systems. The compatibility of the dk programs makes the utility value perfect.



### CAD data

CAD 3D models of workpieces and fixturing systems is the ideal way to plan and document your fixtures. Models of all our products are available for download in any standard CAD data format at [dk.partcommunity.com/3D-cad-models](http://dk.partcommunity.com/3D-cad-models).

Simply open this site directly or access it via our homepage and log in to get started. You are welcome to contact our support for 3D drafting suggestions.



## Newsletter

To stay up to date with the latest news and not miss out on recent innovations, sign up to receive our free newsletter. We provide regular updates on new product developments, upcoming trade fairs and show customer-specific applications.



**Newsletter subscription:**

[www.dk-fixiersysteme.de/newsletter](http://www.dk-fixiersysteme.de/newsletter)

## Commercial agencies



Location: dk FIXIERSYSTEME Reutlingen, Germany



Countries in which our distributors are represented



**Our current distributors worldwide:**

[www.dk-fixiersysteme.de/representatives](http://www.dk-fixiersysteme.de/representatives)

## CT applications

Computer tomography has long since found its way into measurement and testing technology. External and internal geometries are non-destructive, data rich, comprehensive and quick to measure. CT can be used to test the inner workings of workpieces and assembled configurations. Not only measurements can be made, but also defects such as cavities, inclusions, cracks and even the grain direction can be detected. Data from CT can be quickly reused so that it can be utilised during production as well as reverse engineering in product development. However, these high-tech possibilities have so far not been supported by a functional fixation system.

The current level of technology is reflected in the manual, unreliable, time-consuming and high-waste rough machining of PS and PUR foams. dk FIXIERSYSTEME has been developing systematic, modular components for the reproducible, precise safe clamping of test parts for CT scans for a long time. Overall, the dkXRAY range builds on the basic and structural elements used in the product ranges shown in this catalogue. The CT capability however, is only achieved with clamping elements which we presented in a separate catalogue.





## Tactile and optical measuring and testing

The complete dk system consists of several differently orientated but mutually compatible ranges. In addition, we also develop customer-specific solutions. Our aim is to bring the part being tested into the optimum position and to hold it with the least possible clamping force and highest degree of repeat accuracy. This applies to both one-time part clamping and repetitive measuring tasks. The

most professional solutions are modular clamping systems. Single elements can be repeatedly used to constantly form new precise and reproducible fixture combinations. The CAD models available from dk support the planning of measuring fixtures as well as their documentation.



*modular. simple. better.*

## Product videos

The product animations on the dk FIXIERSYSTEME Youtube channel or directly on the homepage illustrate the function and benefits of essential modular programs simply and compactly using exemplary configurations.

The *QUADERFIX* film explains how large and heavy parts can be held securely and reproducibly. In the *SCHIENENFIX* films, the different construction and clamping possibilities are demonstrated for a wide variety of products. Turned, milled, formed plate or cast products, with *SCHIENENFIX* you can optimally position and hold all manner of parts. Finally, the *SWA39* range is conveyed dynamically and very clearly in the film about the modular systems.

Take a look and see for yourself!



**Access our product videos directly via the following link:**

[www.dk-fixiersysteme.de/startseite/technology](http://www.dk-fixiersysteme.de/startseite/technology)



## Product advantages of the dk system



### Quick assembly

The perfectly matched module elements enable complete clamping fixtures to be easily constructed and workpieces to be quickly clamped.

### Accessible measuring points

Optimum accessibility to the workpiece being measured so that, where possible, all measuring points can be reached in a single setup.

### Low fixture costs

With a wide selection of standard modules, the intelligent dk concept enables the construction of simple or complex clamping fixtures without the need for custom-made parts. The constructions can be repeatedly taken apart and re-assembled in a new configuration. High wear resistance guarantees many years of repeated use. This sustainably reduces processing times for new products and saves on fixture costs.

### Repeatable setup

After the first measuring process, further workpieces can always be located in the same position. Repeat measurements can be carried out in automatic mode, thereby reducing measuring time.

### Reproducible fixtures

Even after complete disassembly into their individual parts, previously generated fixtures can be reproduced quickly and accurately.

### Secure measuring

The parts being measured are held securely. Measurement results are not distorted and the measuring process is carried out without interruption.

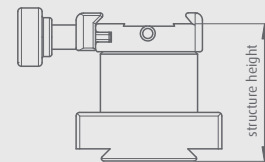
### Combinable systems

The scope of the modular system and the choice of configurations of the individual modules enable solutions to be produced for virtually any clamping task or measuring process. The mutual compatibility of the different dk product ranges facilitates further combinations in the future.

## Table references

### Height

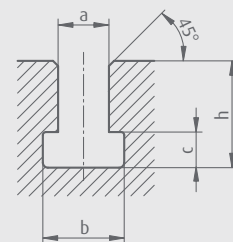
The heights given in the tables may be absolute values or structural heights. The structural height is the amount by which the height of a fixture changes when a structural element is added.



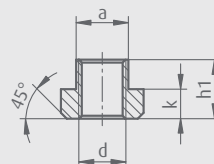
### T-slots and slot keys, Designations

When sending us dimensions for T-slots or slot keys, use the following DIN designations:

DIN 650



DIN 508



## Connections and pictogram legend

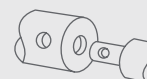
The connections are used for quick and easy combinations. All pictograms in the catalogue facilitate the combination of the individual basic, structural and clamping elements into complete clamping fixtures. The relevant connection is shown for each product. For adapters, both connection interfaces are shown if these are different.

**SWA 5**

Quick-change adapter. A 5 mm pin/hole connection interface. Locked with a grubscrew.

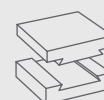
**SWA 8**

Quick-change adapter. An 8 mm pin/hole connection interface. Locked with a grubscrew.



**SWA 39**

Quick-change adapter. Connection over a 39 mm wide dovetail slide. Tool-free locking using a knurled screw.

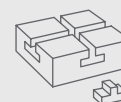


**T-Nut 5**

Connection over T-slot. Width 5/10 mm, height 2.5/2.5 mm. Mainly used with the *SCHIENENFIX* clamping system.

**T-Nut 6**

Connection over T-slot. Width 6/16 mm, height 5/5 mm. Mainly used with the *SPANNFIX* clamping system.

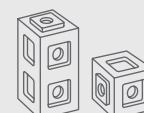


**T-Nut**

Connection over T-slot.

**Quad**

Cuboid push-fit system in 25 mm grid. Square 15 mm variant with M 5 and M 6 connection threads.



**M 6**

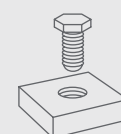
M 6 thread connection.

**M 10**

M 10 thread connection.

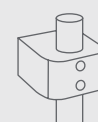
**M ...**

Metric thread connection.



**D 12**

12 mm column connection.



**MK 2**

Morse taper size 2.



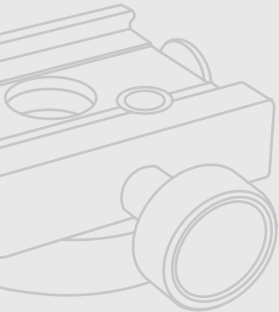
**M 5  
T-Nut 6**

Connecting block or adapter between different interfaces, e.g. a T-slot interface and a connection with an M 5 thread.

## SWA39

### Quick-change complete system for tactile and optical measuring

- » Quick-change complete system for zero-point fixture clamping
- » Basic elements for adaptation to metrology machines or inspection tables.
- » Structural elements for free positioning in 3D space
- » Clamping elements for all categories in many types and sizes
- » With stops for accurate repeat positioning of test parts
- » With scales for exact reproduction of complete fixtures
- » For tactile, optical and multi-sensorial measuring
- » Basis for computer tomography fixturing systems



#### Functioning principle

Pages 20/21



#### Clamping elements

Pages 38-93



## SPANNFIX PRO

### Modular clamping elements for tactile measuring

- » Basis formed by baseplates or quick-change mounts
- » Perfect reproducibility through slot system with scale
- » Wide range of structural and clamping elements
- » Flexible clamping solutions for diverse workpiece geometries
- » Quick and easy assembly
- » For tactile metrology machines

#### Functioning principle

Pages 102/103



#### Basic elements

Pages 104-107



#### Vacuum systems

Pages 144-147



#### SWA 39 connection

Pages 148-149



## SPANNFIX ECO

### Modular clamping elements for tactile measuring

- » Basis formed by baseplates or quick-change mounts
- » Economical solution with grid system
- » Wide range of structural and clamping elements
- » Flexible clamping solutions for diverse workpiece geometries
- » Quick and easy assembly
- » For tactile metrology machines

#### Functioning principle

Pages 156-157



#### Clamping elements

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**Basic elements**

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**Structural elements**

Pages 28-37



**Sets**

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**Structural elements**

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**Clamping elements**

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**Sets**

Pages 150-153



**Basic elements**

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**Structural elements**

Pages 162-171



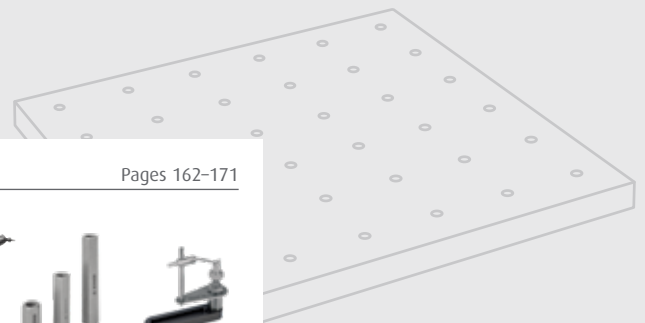
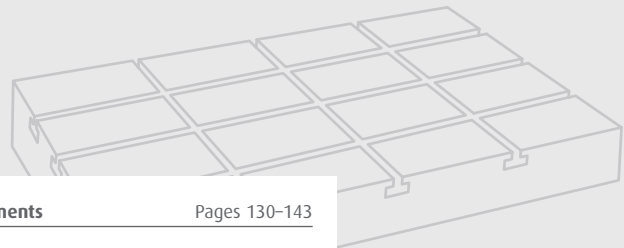
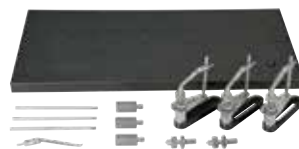
**SWA 39 connection**

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**Sets**

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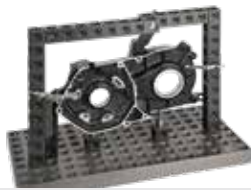
## QUADERFIX

### Clamping system for tactile measuring – cuboid elements

- » Modular fixture system constructed from standard Quader elements
- » Drilled through holes on a 25 mm grid
- » Compatible with the SPANNFIX product range

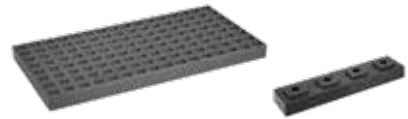
#### Functioning principle

Pages 190–191



#### Basic elements

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#### Clamping elements

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↳ All clamping elements in the Spannfix section can also be used with the Quaderfix system.

#### Sets

Pages 218–221



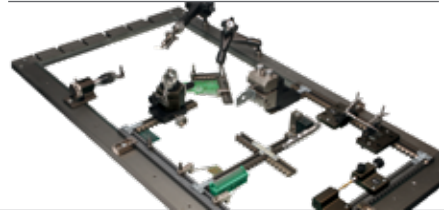
## SCHIENENFIX

### Clamping system for optical and multi-sensorial measuring

- » Modular clamping elements for optical or optical/tactile measuring
- » For high-precision edge measurement in reflected and transmitted light
- » Toothed rails as workpiece rests or for fastening clamping modules
- » For optical/tactile measuring machines, measuring projectors and measuring microscopes

#### Functioning principle

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#### Clamping elements

Pages 242–283



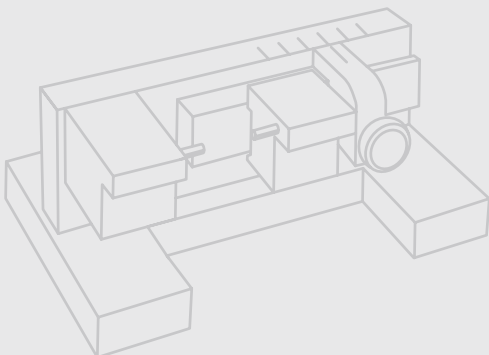
## MICROFIX

### Clamping solutions for micro parts from 0.3 mm to 10 mm

- » Gentle fixation with adjustable clamping forces
- » For rotationally symmetrical and cuboid test parts

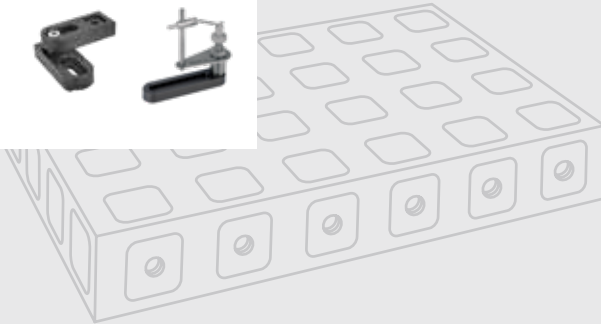
#### Micro clamping fixtures

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## Structural elements

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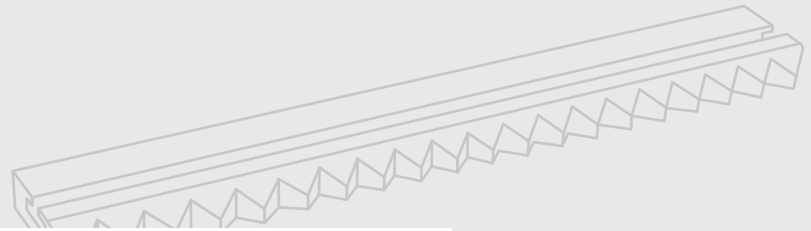
## Basic elements

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## Structural elements

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## Other systems

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## Sets

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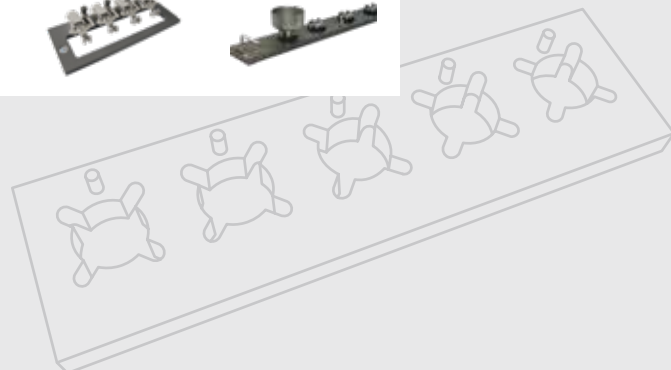
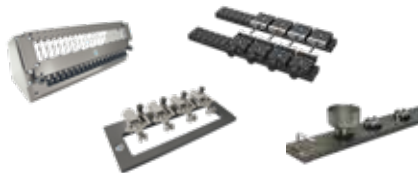
## SPEZIALFIX

### Customer-specific clamping fixtures

- » We also develop, design and manufacture special clamping fixtures
- » Simple or complex single or multi-clamping systems with mechanical, pneumatic, electro-mechanical or combined clamping and handling components

## Special solutions

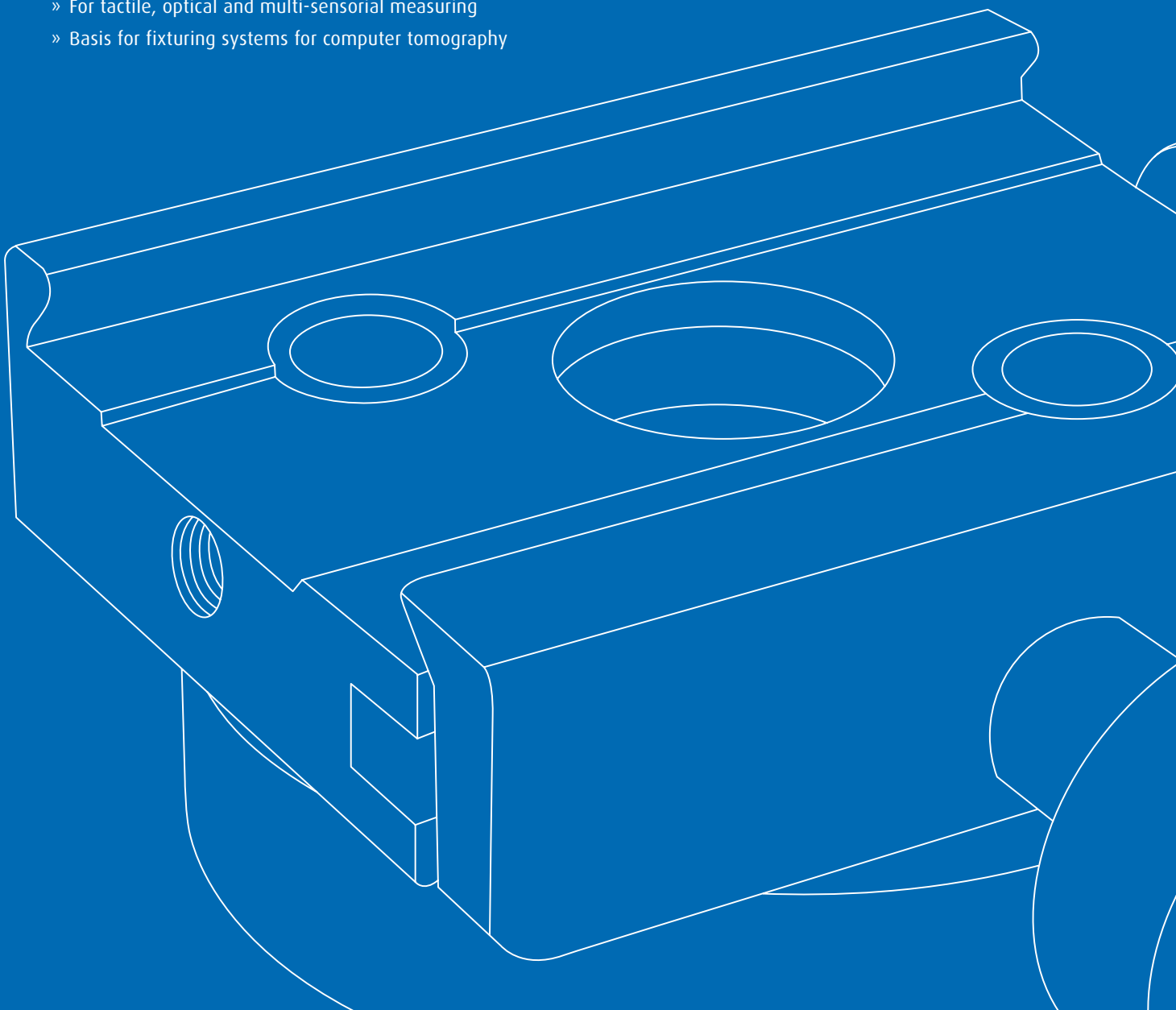
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**SWA39**

## ***Quick-change complete system for tactile and optical measuring***

- » Quick-change complete system for zero-point fixture clamping
- » Basic elements for adaptation to metrology machines or inspection tables
- » Structural elements for free spatial positioning
- » Clamping elements for all categories in many types and sizes
- » With stops for accurate repositioning of test parts
- » With scales for exact reproduction of complete fixtures
- » For tactile, optical and multi-sensorial measuring
- » Basis for fixturing systems for computer tomography





Basic elements



**Quick-action clamp with fastening screw**

Page 22



**Quick-action clamp with extension**

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**Quick-action clamp for mounting in a vice**

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**Quick-action clamp for Alufix**

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**Quick-action clamp for mounting in a vice**

Page 24



**Quick-action clamp with magnet**

Page 25



**Magnetic base**

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**Quick-action clamp, pneumatic glide foot**

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**Quick-action swivel clamp on a baseplate**

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Structural elements



**Adapter plates for customer machining**

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**Adapter plates with mounting thread**

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**Adapter plates with mounting holes**

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**Adapter plates with T-slot 6**

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**Quick-action clamp with fixed height extension**

Page 30



**Quick-action clamp with adjustable height extension**

Page 30



**Quick-action clamp rotated 90°**

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**Quick-action clamp 360° rotation**

Page 31



**Quick-action clamp with carriage guide or cross table**

Page 32



**Quick-action clamp fixed 45° or 90° angle element**

Page 33



**Quick-action clamp, swivel unit**

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**Quick-action clamp, swivel unit**

Page 34



**Quick-action clamp, rotary and swivel unit**

Page 35



**Swivel unit with universal joint**

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**Swivel unit with ball joint**

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**Swivel unit with geared head**

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Clamping elements  
+ accessories



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25 mm precision vice

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35 mm precision vice

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50 mm precision vice

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50 mm precision centric vice

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50 mm precision vice

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80 mm precision vice

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100 mm precision vice

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125 mm precision vice

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Precision mini chuck

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ER 16 precision collet chuck

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Information to dk precision three-jaw chucks

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34 mm precision three-jaw chuck

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50 mm precision three-jaw chuck

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65 mm precision three-jaw chuck

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100 mm precision three-jaw chuck

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160 mm precision three-jaw chuck

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Rotary table with precision three-jaw chuck

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NADELFIX function and advantages

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NADELFIX 2.5

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NADELFIX 5 Mini

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NADELFIX 5 Midi

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NADELFIX 5 Maxi

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Small-parts clamp, smooth

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Small-parts clamp, jaw stepped one side

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Small-parts clamp with horizontal prism

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Small-parts clamp with top-face prism

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Small-parts clamp for internal clamping

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Stop unit for small-parts clamps

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Permanent magnet clamping mounts

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Magnetic clamping mounts, switchable

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Permanent magnet V-block

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Magnetic V-block, switchable

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Small V-block with spring finger

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V-block

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V-blocks pairs, adjustable on SWA 39 rail

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Pneumatic glide foot Airbase

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Vacuum clamping plates - round

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Vacuum clamping plate - square

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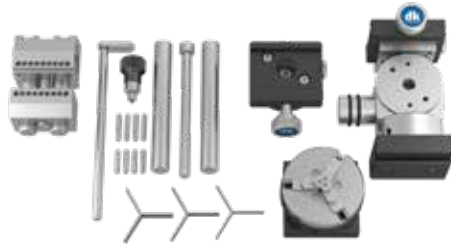
Clamping sets



Set "A"

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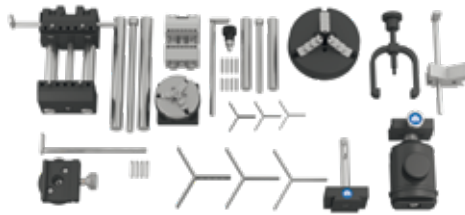
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Set "B"

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Set "C"

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# Quick-change adaptation system for reproducible zero points

**Unique, high-quality and reliable – dk SWA 39 modular system for fixating technology:**

- A huge selection of basic, structural, adjustment and clamping elements with standardised interfaces
- Individual elements and entire fixtures can be changed quickly
- Positive fixating with a high reference accuracy as a base for zero-point fixture clamping
- Highest quality for maximum service life

## Basic elements

- 1 Baseplate with tapped holes (page 158)



Other baseplates  
(Pages 104–105)



- 2 Quick-action clamp with fastening screw (page 22)



Other quick-action clamps  
(from page 23)



## Structural elements

- 3 Quick-action clamp with height extension (page 30)



Other versions and adaptations  
(pages 22–37)



- 4 Quick-action clamp angle element (page 33)





### Clamping elements

- 5 Rotary table with precision three-jaw chuck (page 74)



Other clamping elements and accessories (pages 38-91)



## FAST REASSEMBLY LIFELONG

The basic principle of all dk fixturing systems. The compatibility of the dk programs makes the utility value perfect.

### The result:

- quick, simple, workpiece and process-oriented positioning and clamping
- rapid conversion to new workpieces and processes
- possibility of workpiece setups outside of the machine during measuring process
- disassemble and reassemble entirely new or exactly the same fixtures countless times
- an alternative to classic, inflexible, single-use fixture constructions

## Quick-action clamp with fastening screw

### Description

SWA 39 quick-action base clamp for mounting all structural, adjustment and clamping elements of the SWA 39 system. For direct fastening in tapped holes or T-slots. Mounted on a 12 mm high intermediate plate.

### Material

Hard-coated aluminium/stainless steel.

### Supplied with

Fasteners



Order No.	Fastening screw	Height
285204	M4	23.5
285205	M5	23.5
285206	M6	23.5
285208	M8	23.5
285210	M10	23.5
285212	M12	23.5
285300	Set for T-slot 6	23.5

SWA 39  
M ...

### Application example



## Quick-action clamp with extension

### Description

SWA 39 quick-action clamp for direct fastening in tapped holes.  
Mounted on 50/100 mm extensions.

### Material

Hard-coated aluminium.

### Supplied with

Fastening screw.



Order No.	Fastening screw	Height
330506	M6	61.5
330508	M8	61.5
330510	M10	61.5
330512	M12	61.5
330606	M6	111.5
330608	M8	111.5
330610	M10	111.5
330612	M12	111.5

SWA 39  
M ...

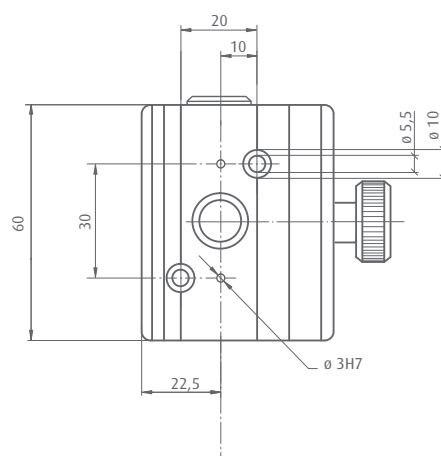
## Quick-action clamp for special mounts

### Description

SWA 39 quick-action clamp for screwing onto special mounts.

### Material

Hard-coated aluminium.



Order No.	Height
273300	11.5

SWA 39  
M ...

## Quick-action clamp for Alufix

### Description

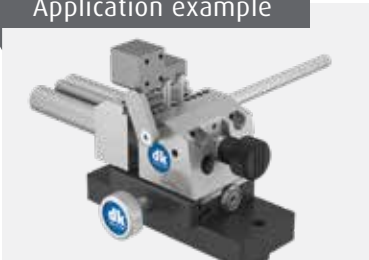
SWA 39 quick-action clamp for mounting on Alufix 16 or 25 system baseplates.

### Material

Hard-coated aluminium.



### Application example



Order No.	System	Length	Width	Height
274700	16	60	78	32
274710	25	66	78	32
274720	25/grid 50	116	78	32

## Quick-action clamp for mounting in a vice

### Description

SWA 39 quick-action clamp for mounting in any standard vice (min. jaw width 40 mm).

### Material

Hard-coated aluminium/steel.



Order No.	Height
330800	52

SWA 39



## Quick-action clamp with magnet

### Description

SWA 39 quick-action clamp on permanent magnet with On-Off switch for mounting on steel plates. Vertical lift-off force 1000 N.

### Material

Hard-coated aluminium/steel.



Order No.	Length	Width	Height	Lift-off force
313800	68	76	71.5	1000 N

SWA 39

## Magnetic base

### Description

Permanent magnet with On-Off switch and M 8 or M 10 tapped hole. Vertical lift-off force 800 N or 1000 N.

### Material

Steel.

### Application example



Order No.	Thread	Length	Width	Height	Lift-off force
251500	M10	68	53	60	1000 N
251400	M8	36	53	60	800 N

M 10

## Quick-action clamp on a pneumatic glide foot

### Description

Basic attachment for SWA 39 modular elements on smooth surfaces. Easy glide on an air cushion. Fix in place by vacuum. Connection modules with SWA 39 interface. Maximum load ca. 15 kg. Operating pressure 4.5 to 6 bar. Operate only with dry, oil-free air.

With port for vacuum generation in other elements that may be connected.  
See pages 92 to 93.



Order No.	Length	Width	Height	Version	Weight
270200	300	200	56	With ext. vacuum port	3.3

SWA 39

### Application example

#### SWA 39 pneumatic glide foot:

The pneumatic glide foot is the ideal basic attachment for smooth surfaces that have no mounting holes. The pneumatic foot glides on an air cushion and is secured by a vacuum. A clamping fixture can therefore be manoeuvred into, and locked in any point on the inspection table – no screws required. The SWA 39 interface on the products top face is ideal for quick, reliable and straightforward mounting of any module to swivel and fixate parts to be measured or tested.



## Quick-action rotate and swivel clamp on a baseplate

### Description

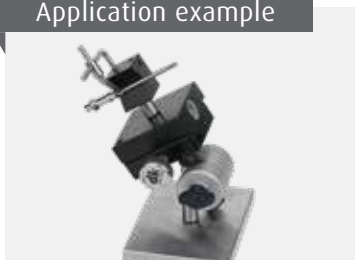
SWA 39 quick-action clamp mounted on baseplate.  
With 90° swivel element.

### Material

Hard-coated aluminium/stainless steel.



### Application example

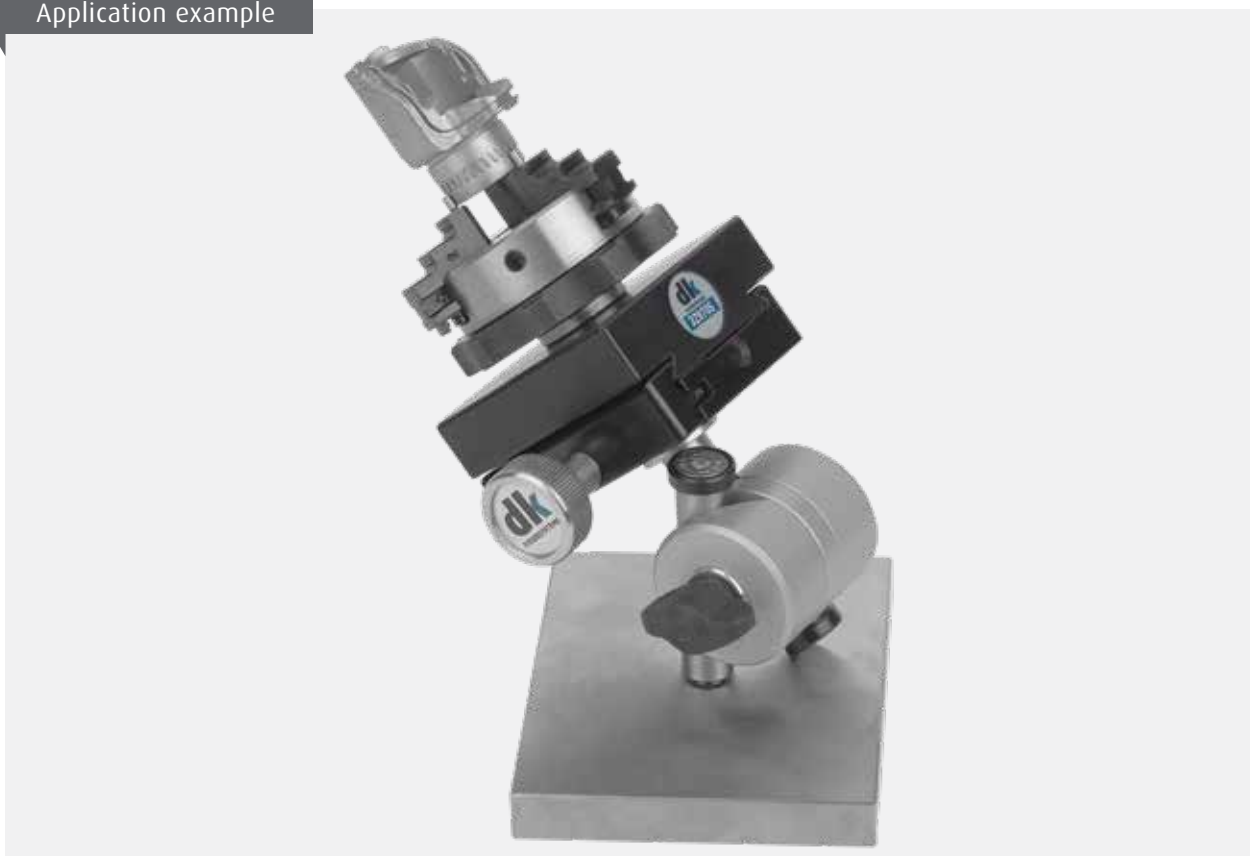


Order No.	Length	Width	Height*	Weight
270560	100	80	82	1.1

SWA 39

\* Minimum height with horizontal quick-action clamp

### Application example



Adapter plates for customer machining

**Description**

Baseplate with SWA 39 quick-change adapter. With standard or cross interface. The adapter with the standard interface can be installed in two positions on the quick-change mount, the cross interface four positions. Plate for machining by the user as required.

**Material**

Hard-coated aluminium.



Order No.	Version	Length	Width	Height	Fig.
273000	Standard interface	60	60	20	1
314500	Cross interface	60	60	20	



Adapter plates with central tapped hole

**Description**

Baseplate with SWA 39 quick-change adapter and central tapped hole.

**Material**

Hard-coated aluminium.



Order No.	Version	Length	Width	Height
273006	M6	60	60	20
273008	M8	60	60	20
273010	M 10	60	60	20
273012	M12	60	60	20



## Adapter plates with tapped holes

### Description

Baseplates with tapped holes. One central hole or four holes arranged in a square.

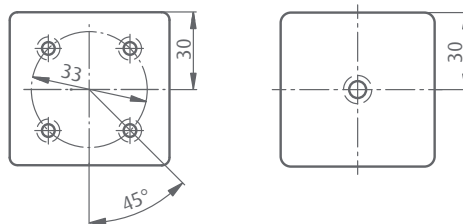
### Material

Hard-coated aluminium.

### Supplied with

4x M4 fastening screws or

1x M6 fastening screw.



Order No.	Version	Length	Width	Height	Fig.
397020	4x M4 holes with standard interface	60	60	20	1
397030	4x M4 holes with cross interface	60	60	20	
397040	1x M6 hole with standard interface	60	60	20	

M ...  
SWA 39

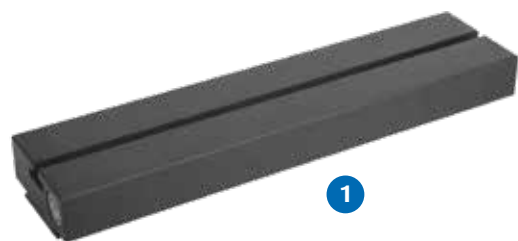
## Adapter plates with T-slot 6

### Description

Baseplate with T-slot 6 for mounting diverse modules, e.g. structural elements from the *SPANNFIX* range. With SWA 39 quick-change adapter for mounting on SWA 39 basic elements.

### Material

Hard-coated aluminium.



Order No.	Length	Width	Height	Fig.
305000	140	60	24	
305100	250	60	24	1
305110	500	60	24	

T-Nut 6  
SWA 39

## Quick-action clamp with fixed height extension

### Description

Extension modules with SWA 39 quick-change adapter.

### Material

Hard-coated aluminium.

### Application example



Order No.	Length	Width	Height
273600	60	80	61.5
273700	60	80	111.5

SWA 39

## Quick-action clamp with adjustable height extension (fine adjustment)

### Description

Extension modules, with threaded spindle for infinite fine adjustment, knurled screw and lock.

Mounted on an SWA 39 quick-change adapter.

### Material

Hard-coated aluminium.



Order No.	Length	Width	Height
273800	60	80	60-80
273900	60	80	80-120

SWA 39

## Quick-action clamp rotated 90°

### Description

SWA 39 quick-action clamp for the mounting modules offset at 90°. Mounted on an SWA 39 quick-change adapter.

### Material

Hard-coated aluminium.



Order No.	Length	Width	Height
314400	60	80	31.5

SWA 39

## Quick-action clamp 360° rotation

### Description

Quick-action clamp, rotates freely or indexed at 90°. Indexing function can be removed. Angular adjustment with a scale accurate to 2°. Knurled screw lock. Alternatively with fine adjustment. Mounted on an SWA 39 quick-change adapter.

### Material

Hard-coated aluminium, stainless steel shaft.



Order No.	Rotation	Function	Length	Width	Height	Fig.
283450	360°/indexed every 90°	manual	60	80	52	1
283460	360°/ fine adjustment	Gear drive	60	90	72	2

SWA 39

## Quick-action clamp with slide or cross table

### Description

SWA 39 quick-action clamp with infinite, high-precision X or X/Y adjustment.  
Mounted on an SWA 39 quick-change adapter.

### Material

Hard-coated aluminium.



Order No.	Function	Travel	Length	Width	Height	Fig.
314460	Cross table X/Y	25	80	80	78	1
314450	Slide X	25	80	80	55	2

SWA 39

### Application example





## Quick-action clamp fixed 45° or 90° angle element

### Description

Fixed 45° or 90° angle element for mounting positioning and clamping elements, with an SWA 39 quick-change clamp. With SWA 39 quick-change adapter.

### Material

Hard-coated aluminium.



Order No.	Angle	Length	Width	Height	Fig.
283300	90°	60	90	60	1
283320	45°	60	90	70	2

SWA 39

### Application example



### Quick-action clamp on a pivot unit (quick adjustment)

#### Description

SWA 39 quick-action clamp, infinite or 45° indexed pivot through  $\pm 90^\circ$ . Scale with 5° divisions. Mounted on an SWA 39 quick-change adapter.

#### Material

Hard-coated aluminium.

#### Supplied with

Detachable stop for 0°, 45° and 90°.



Order No.	Pivot range	Length	Width	Height
314000	+90°/-90°	60	80	87

SWA 39

### Quick-action clamp on a pivot unit (fine adjustment)

#### Description

SWA 39 quick-action clamp, infinite pivot through  $+90^\circ/-55^\circ$ . A worm gear drives the pivot. Scale for angular adjustment accurate to 2°. Mounted on an SWA 39 quick-change adapter.

#### Material

Hard-coated aluminium.



Order No.	Swivel range	Length	Width	Height
314010	+90°/-55°	85	80	97
314015	clamping set for pivot unit			

SWA 39

## Quick-action rotary and pivot unit clamp

### Description

SWA 39 quick-action pivot and rotating clamp Pivot range  $+90^\circ / -55^\circ$ . A worm gear drives the pivot. Infinite rotation through  $360^\circ$  or indexed every  $90^\circ$ . Indexing function can be removed. Angular adjustment with a scale accurate to  $2^\circ$ . Knurled screw lock. Mounted on an SWA 39 quick-change adapter.

### Material

Hard-coated aluminium, stainless steel shaft. Steel worm.



Order No.	Rotation	Pivot	Length	Width	Height	Fig.
314020	$360^\circ$ /indexed every $90^\circ$	$+90^\circ/-55^\circ$	85	80	114	1
314030	$360^\circ$ /fine worm drive	$+90^\circ/-55^\circ$	85	80	114	2
314015	clamping set for pivot unit					

SWA 39

### Application example



## Swivel unit with universal joint

### Description

SWA 39 quick-action clamp for quick and flexible spatial clamping of parts. Swivels up to 90°. Swivel element can be locked with a clamping screw. Mounted on an SWA 39 quick-change adapter.

### Material

Hard-coated aluminium, stainless steel shaft.



Order No.	Length	Width	Height*	Weight
270570	60	60	90	0.52

SWA 39

\* Minimum height with horizontal quick-action clamp

## Swivel unit with ball joint

### Description

Swivel unit for quick and flexible spatial clamping of parts. Rotates through 360°. Swivels up to 90°. Mounted on an SWA 39 quick-change adapter.

### Material

Hard-coated aluminium.

Application example



Order No.	Length	Width	Height	Weight
270500	70	90	120	0.86

SWA 39

## Swivel unit with geared head

### Description

3D geared head for quick and flexible spatial positioning of parts. Both the entire swivel unit and the upper quick-action clamp can be rotated through 360°. Two separate goniometers and a pivot unit enable swivelling up to 90°. Mounted on an SWA 39 quick-change adapter. Scales in all axis enable for reproducible clamping without any problem.

### Material

Body hard-coated aluminium.  
Guides and drive brass/steel.



Order No.	Length	Width	Height*	Weight
270650	110	110	126	1.3

SWA 39

### Application example



15 mm precision vice

Description

Miniature vice with prism jaws. With SWA 39, SWA 5 or M 4 connection. Brass or stainless steel versions available. M 4 hole centre distance is 42 mm.

Supplied with

Stainless steel (270921) and plastic exchange jaws.



Order No.	Version	Jaw width	Clamping width	Total height	Material	Fig.
270910	SWA 39	15	14.5	61	Brass	1
270915	SWA 39	15	14.5	61	Stainless steel	1
270900	SWA 5	15	14.5	27	Brass	2
270905	SWA 5	15	14.5	27	Stainless steel	2
270920	2x M4	15	14.5	15	Brass	3
270925	2x M4	15	14.5	15	Stainless steel	3

Accessories

+ Form jaw with prism

Order No.	Material	Jaw width	Supplied with	Description
270921	Stainless steel	15	1 set jaws one smooth and one prism jaw	With vertical and horizontal prisms



+ Stepped jaw

Order No.	Material	Jaw width	Contents	Description
270922	Stainless steel	15	1 jaw	Step height 1.5 mm Step depth 1.0 mm



Application examples



25 mm precision vice

Description

Miniature vice with prism jaws. With SWA 39, SWA 5 or M 4 connection. Aluminium and stainless steel versions available. M 4 hole centre distance is 62,5 mm.

Supplied with

Stainless steel (270971) and plastic exchange jaws.

Application example



SWA 39	SWA 5	M ...
--------	-------	-------

Order No.	Version	Jaw width	Clamping width	Total height	Material	Fig.
270960	SWA 39	25	24.5	53	Aluminium	1
270965	SWA 39	25	24.5	53	Stainless steel	1
270950	SWA 5	25	24.5	38	Aluminium	2
270955	SWA 5	25	24.5	38	Stainless steel	2
270970	2x M4	25	24.5	25	Aluminium	3
270975	2x M4	25	24.5	25	Stainless steel	3

Accessories

+ Form jaw with prism

Order No.	Material	Jaw width	Supplied with	Description
270971	Stainless steel	25	1 set jaws one smooth and one prism jaw	With vertical and horizontal prisms



+ Stepped jaw

Order No.	Material	Jaw width	Contents	Description
270972	Stainless steel	25	1 jaw	Step height 1.8 mm Step depth 1.3 mm



+ Stop

Order No.	Material	Length	Adjustment range
318250	Stainless steel/aluminium	75	50





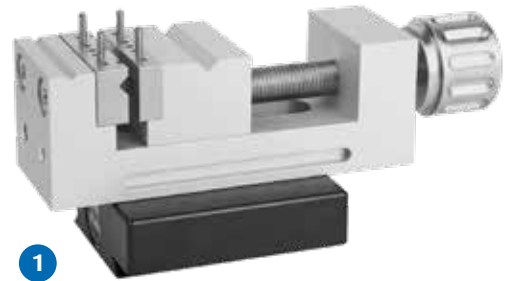
## 35 mm precision vice

### Description

Miniature vice with prism jaws. With SWA 39 or M 5 connection. Aluminium and stainless steel versions available. Jaws with Ø2 mm holes for clamping pins. M5 hole centre distance is 83 mm.

### Supplied with

Stainless steel (270861) and plastic exchange jaws and 4x Ø2 mm pins.



1



2

### Application example



SWA 39

M ...

Order No.	Version	Jaw width	Clamping width	Total height	Material	Fig.
270850	SWA 39	35	34.5	55	Aluminium	1
270855	SWA 39	35	34.5	55	Stainless steel	1
270860	2x M5 / 4x M4	35	34.5	35	Aluminium	2
270865	2x M5 / 4x M4	35	34.5	35	Stainless steel	2

### Accessories

#### + Form jaw with prism

Order No.	Material	Jaw width	Supplied with	Description
270861	Stainless steel	35	1 set jaws one smooth and one prism jaw	With vertical and horizontal prisms



#### + Stepped jaw

Order No.	Material	Jaw width	Contents	Description
270862	Stainless steel	35	1 jaw	Step height 2.0 mm Step depth 1.5 mm



#### + Stop

Order No.	Material	Length	Adjustment range
318250	Stainless steel/ aluminium	75	50



## 50 mm pull down precision vice

**Description**

Positive down force vice with quick adjustment and adjustable stop. SWA 39 quick-change adapter integrated into the vice base. With stepped jaws and Ø4 mm holes for clamping pins. Optional stainless steel exchange jaws.

**Material**

Surface hardened steel.

**Supplied with**

Adjustable stop (318110), 4 pins for pin clamping and operating tools.



Order No.	Jaw width	Clamping width	Weight
270700	50	80	1.46

SWA 39

## Accessories

## + Smooth jaws

Order No.	Material	Jaw width	Supplied with	Description
271200	Stainless steel	50	1 set exchangeable jaws and fastening screws	-



## + Form jaws with small prisms

Order No.	Material	Jaw width	Supplied with	Clamping diameter
271500	Stainless steel	50	1 set jaws one smooth and one prism jaw	recommended from 2.5 mm



## + Form jaws with large prisms

Order No.	Material	Jaw width	Supplied with	Clamping diameter
271900	Stainless steel	50	1 set jaws one smooth and one prism jaw	recommended from 6 mm



## + Clamping pins, stepped

Order No.	Contact face	Length	Contents	Description
282300	straight	24 x Ø4	Set of 4	for raised part positioning
282310	straight	35 x Ø4	Set of 4	
326500	120° prism	25 x Ø4	2 prism pairs	



## + Support discs with pins

Order No.	Version	Disc size	Contents	Description
338300	Adjustable	Ø16 x 9	Set of 4	For raised part positioning



## + Universal stop

Order No.	Material	Supplied with
277510	Steel	2 exchangeable stop points



## + Stop for vices

Order No.	Material	Length	Overhang	Description
318100	Steel	50	20	-
318200	Steel	50	40	
318110	Steel	150	20	
318210	Steel	150	40	



### Application example



## 50 mm precision centric vice

### Description

Centric vice with stepped jaws and adaptation options for a range of accessory elements. Pin holes for raised positioning of parts for access from all sides. Version with an SWA 39 quick-change adapter which can be mounted offset by 90°.

### Material

Surface hardened steel and hard-coated aluminium.

### Supplied with

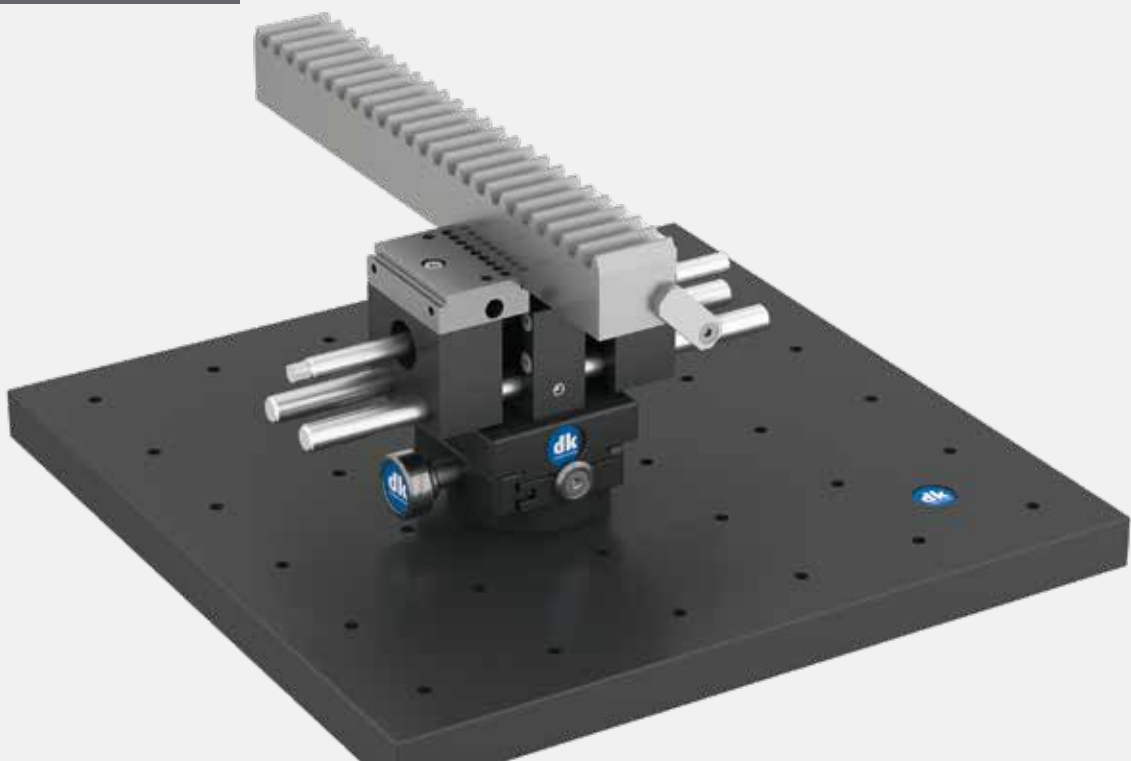
4 pins, adjustable stop and operating tools.



Order No.	Jaw width	Version	Clamping width
282150	50	SWA 39 (removable)	120 mm

SWA 39

### Application example



## Accessories

### + Smooth jaws

Order No.	Material	Jaw width	Contents	Description
282400	Stainless steel	50	1 set	-



### + Form jaws with prisms

Order No.	Material	Jaw width	Supplied with	Clamping diameter
282700	Stainless steel	50	1 set jaws one smooth and one prism jaw	recommended from 2 mm



### + Form jaws with prisms for end-face clamping

Order No.	Material	Jaw width	Contents	Clamping diameter
306610	Stainless steel	50	1 set	15-50 mm



### + Smooth jaws for small parts

Order No.	Material	Jaw width	Contents	Description
282410	Stainless steel	50	1 jaw	For clamping small parts



## Application example



## Accessories

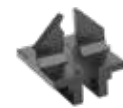
## + Pin jaws

Order No.	Material	Jaw width	Contents	Description
282430	Stainless steel	50	1 set	for shorter clamping widths



## + Two-point contact prism jaws

Order No.	Material	Jaw width	Supplied with	Clamping diameter
306900	Hard-coated aluminium	5	1 prism jaw and 1 straight jaw	3–20 mm



## + Three-point contact prism jaws

Order No.	Material	Jaw width	Supplied with	Clamping diameter
306800	Hard-coated aluminium	5+16	1 double prism jaw and 1 straight jaw	Recommended up to 30 mm



## + Clamping pins, stepped

Order No.	Contact face	Length	Contents
282300	Straight	24 x Ø4	Set of 4 for raised part positioning 2 prism pairs
282310	Straight	35 x Ø4	
326500	120° prism	25 x Ø4	



## + Support discs with pins

Order No.	Version	Disc size	Contents	Description
338300	adjustable	Ø16 x 9	Set of 4	for raised part positioning



## + Universal stop

Order No.	Material	Supplied with
277510	Steel	2 exchangeable stop points



## + Stop for vices

Order No.	Material	Length	Overhang	Description
318100	Steel	50	20	
318200	Steel	50	40	
318110	Steel	150	20	
318210	Steel	150	40	



Application example



50 mm precision vice

**Description**

Vice with exchangeable clamping width extension guide shafts. With stepped jaws and Ø4 mm holes for clamping pins.  
 Versions with and without SWA 39 quick-change adapter and with and without accessories are available. The versions without quick-change adapter have 4 contact faces at right angles to each other.

**Material**

Surface hardened steel.

**Supplied with**

Versions with accessories include an adjustable stop (318110), a set of shafts for extending the clamping width to 75 mm, 4 pins and a magnetic push-in knurled knob (282101).

⚡ A quick-change adapter (397020) can be retrofitted on versions without SWA 39, see page 29.

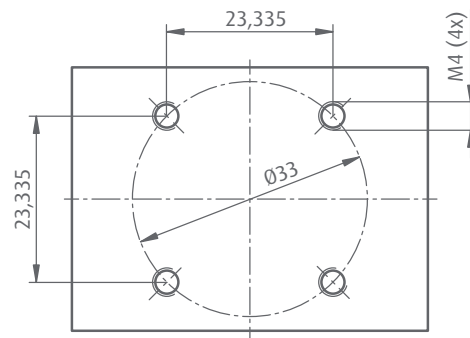
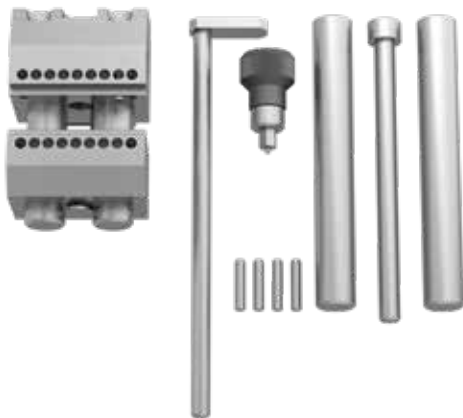


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Vice with accessories.



SWA 39 M ...

Order No.	Jaw width	Version	Accessories	Clamping width	Weight	Fig.
282100	50	SWA 39	yes	35 / 75*	1.05	1
282105	50	SWA 39	no	35*	0.87	
282110	50	4 contact faces	yes	35 / 75*	1.01	
282115	50	4 contact faces	no	35*	0.82	2

\* Can be extended up to 150 mm with extra shaft sets.



## Accessories

### + Shaft set for clamping range extension

Order No.	Material	Jaw width	Supplied with	Description
282200	Surface hardened steel	-	2 sets of 2 shafts with a threaded spindle	Clamping width extension to 100 mm or 150 mm



### + Smooth jaws

Order No.	Material	Jaw width	Contents	Description
282400	Stainless steel	50	1 set	-



### + Form jaws with prism

Order No.	Material	Jaw width	Supplied with	Clamping diameter
282700	Stainless steel	50	1 set jaws one smooth and one prism jaw	recommended from 2 mm



### + Form jaws with prisms for end-face clamping

Order No.	Material	Jaw width	Contents	Clamping diameter
306610	Stainless steel	50	1 set	15-50 mm



### + Smooth jaws for small parts

Order No.	Material	Jaw width	Contents	Description
282410	Stainless steel	50	1 jaw	For clamping small parts in the stepped jaws



## Application example



## Accessories

## + Pin jaws

Order No.	Material	Jaw width	Contents	Description
282430	Stainless steel	50	1 set	For shorter clamping widths



## + Two-point contact prism jaws

Order No.	Material	Jaw width	Supplied with	Clamping diameter
306900	Hard-coated aluminium	5	1 prism jaw and 1 straight jaw	3–20 mm



## + Three-point contact prism jaws

Order No.	Material	Jaw width	Supplied with	Clamping diameter
306800	Hard-coated aluminium	5+16	1 double prism jaw and 1 straight jaw	recommended up to 30 mm



## + Clamping pins, stepped

Order No.	Contact face	Length	Contents	Description
282300	Straight	24 x Ø4	Set of 4	for raised part positioning
282310	Straight	35 x Ø4	Set of 4	
326500	120° prism	25 x Ø4	2 prism pairs	



## + Support discs with pins

Order No.	Version	Disc size	Contents	Description
338300	Adjustable	Ø16 x 9	Set of 4	for raised part positioning



## + Universal stop

Order No.	Material	Supplied with
277510	Steel	2 exchangeable stop points



## + Stop for vices

Order No.	Material	Length	Overhang	Description
318100	Steel	50	20	
318200	Steel	50	40	
318110	Steel	150	20	
318210	Steel	150	40	



## + Knurled knobs

Order No.	Version
282101	magnetic
282102	magnetic with adjustable torque, ca. 0.1–0.3 Nm



Application examples



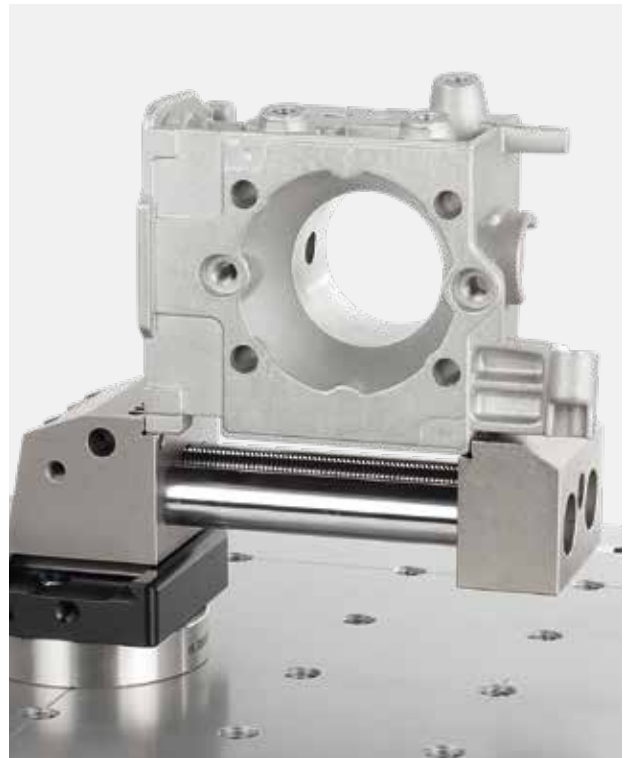
External clamping with pins for additional elevation for optimum accessibility to all faces.



Internal clamping with pins for additional elevation.



Precise repeatable clamping with adjustable stop.



Clamping width extended to 75 mm, 100 mm or 150 mm using accessories.

80 mm precision vice

Description

Vice with exchangeable clamping width extension guide shafts. SWA 39 quick-change adapter integrated in the vice base. For flexible fastening of the vice, version 308300 includes two additional SWA 39 quick-change adapters offset through 90°. With stepped jaws and Ø5 mm holes for clamping pins.

Material

Hard-coated aluminium with surface hardened steel jaws.

Supplied with

1 adjustable stop (318110), an extra set of shafts for extending the clamping width up to 130 mm, 4 clamping pins and operating tools.



Order No.	Jaw width	Clamping width	Fastening	Weight	Fig.
308200	80	80 / 130*	on the base	1.65	1
308300	80	80 / 130*	on the base or on two sides offset 90° to each other	1.7	

\* Can be extended up to 200 mm with extra shaft sets.

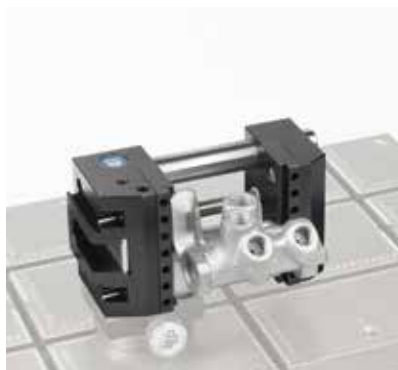
SWA 39

Positioning options for 308300 with an SWA 39 interface on 3 different sides:

Application example



a) Standard



b) Sideways



c) Upright

**+ Shaft set for clamping range extension**

Order No.	Material	Jaw width	Supplied with	Description
307700	Surface hardened steel	-	1 set of 2 guide shafts and 1 threaded spindle	for clamping range extension up to 200 mm



**+ Smooth jaws**

Order No.	Material	Jaw width	Contents	Description
307000	Stainless steel	80	1 set	-



**+ Form jaws with small prisms**

Order No.	Material	Jaw width	Supplied with	Clamping diameter
307300	Stainless steel	80	1 set jaws one smooth and one prism jaw	recommended vertical and horizontal from 5 mm



**+ Form jaws with prisms for end-face clamping**

Order No.	Material	Jaw width	Contents	Clamping diameter
307601	Stainless steel	80	1 set	recommended from 20 to 85 mm



**+ Two-point contact prism jaws**

Order No.	Material	Jaw width	Supplied with	Clamping diameter
306915	Hard-coated aluminium	7.5	1 prism jaw and 1 straight jaw	8-50 mm



**+ Three-point contact prism jaws**

Order No.	Material	Jaw width	Supplied with	Clamping diameter
306810	Hard-coated aluminium	5+16	1 double prism jaw and 1 straight jaw	2-50 mm



**+ Jaws with 2 rows of pins holes**

Order No.	Material	Jaw width	Contents	Description
307610	Steel	80	1 set	for Ø5 mm pins



## Accessories

## + Universal stop

Order No.	Material	Supplied with	Description
277510	Steel	With 2 exchangeable stop points	



## + Clamping pins, stepped

Order No.	Contact face	Length	Contents	Description
307800	Straight	26 x Ø5	Set of 4	for raised part
307810	Straight	36 x Ø5	Set of 4	positioning
326600	120° prism	30 x Ø5	2 prism pairs	
326610	120° prism	35 x Ø5	2 prism pairs	

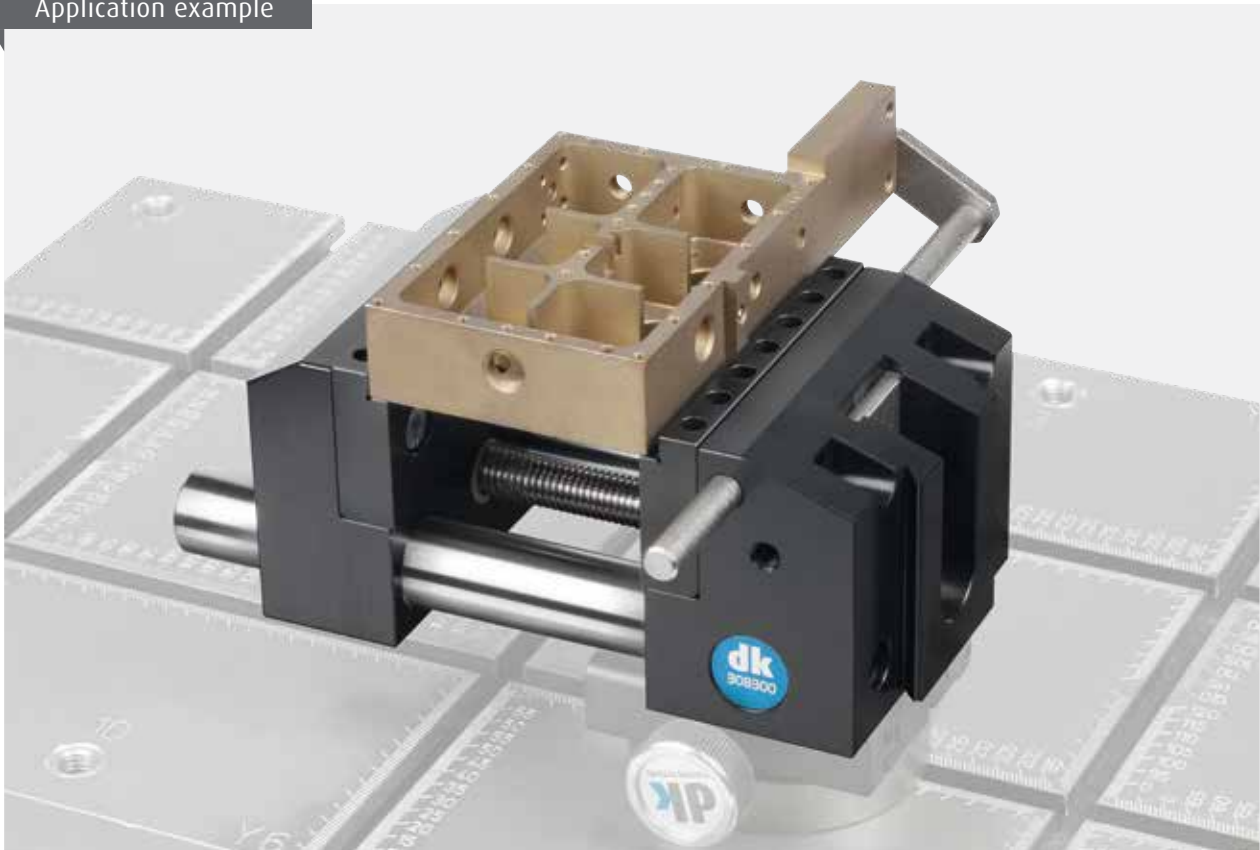


## + Stop for vices

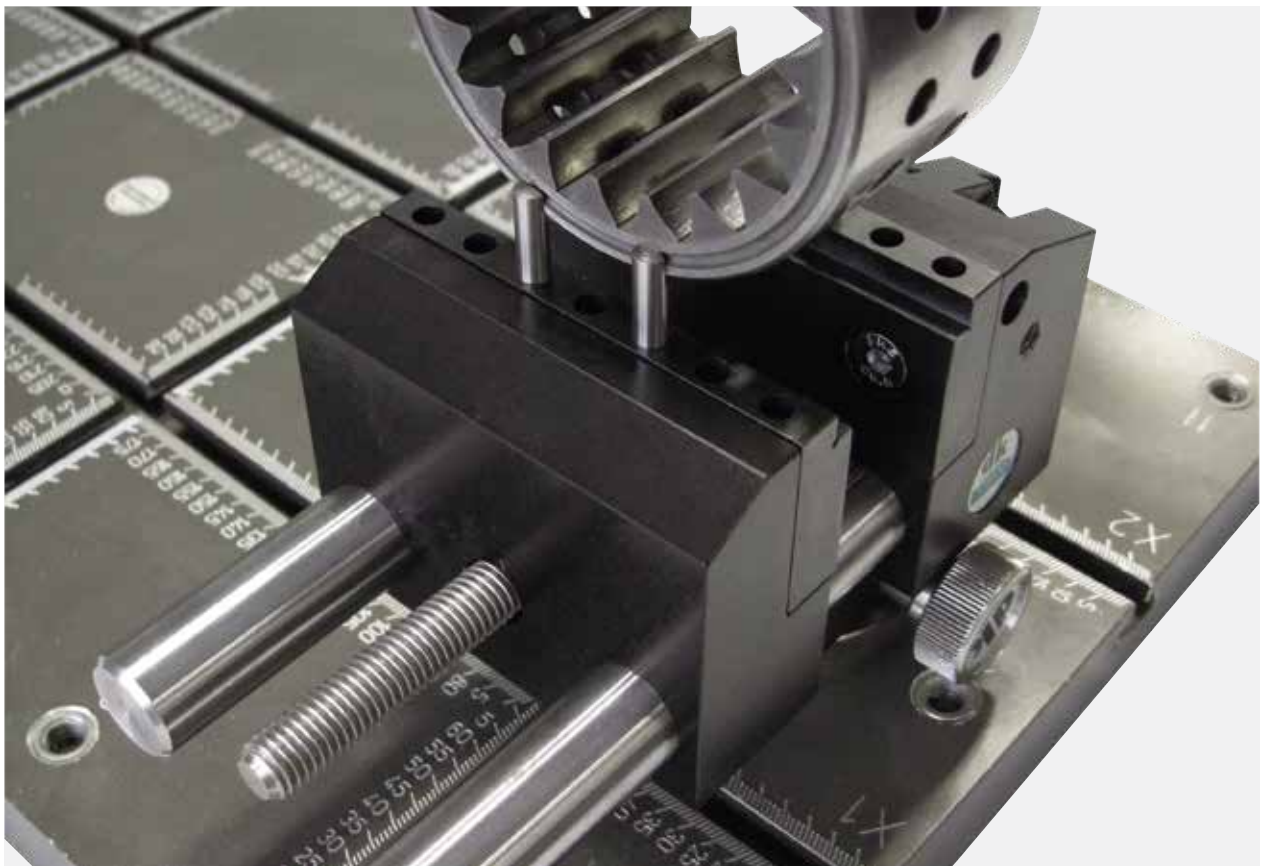
Order No.	Material	Length	Overhang	Description
318100	Steel	50	20	
318200	Steel	50	40	
318110	Steel	150	20	
318210	Steel	150	40	



## Application example



Application example



100 mm precision vice

**Description**

Vice with exchangeable clamping width extension guide shafts. SWA 39 quick-change adapter integrated in the vice base. With stepped jaws and Ø5 mm holes for clamping pins.

**Material**

Hard-coated aluminium with surface hardened steel jaws.

**Supplied with**

1 adjustable stop (318110), an extra set of shafts for extending the clamping width up to 170 mm, 4 pins and operating tools.



Order No.	Jaw width	Clamping width	Weight
308500	100	80 / 170*	2.45

SWA 39

\* Can be extended up to 220 mm with extra shaft sets.

Accessories

+ Shaft set for clamping range extension

Order No.	Material	Jaw width	Supplied with	Description
309600	Surface hardened steel	-	1 set of 2 guide shafts and 1 threaded spindle	for clamping range extension up to 220 mm



+ Smooth jaws

Order No.	Material	Jaw width	Contents	Description
308700	Stainless steel	100	1 set	-



+ Form jaws with small prisms

Order No.	Material	Jaw width	Supplied with	Clamping diameter
309000	Stainless steel	100	1 set jaws one smooth and one prism jaw	recommended vertical and horizontal from 5 mm



+ Form jaws with prisms for end-face clamping

Order No.	Material	Jaw width	Contents	Clamping diameter
309301	Stainless steel	100	1 set	recommended from 20 to 120 mm





## + Clamping pins, stepped

Order No.	Contact face	Length	Contents	Description
307800	Straight	26 x Ø5	Set of 4	for raised part positioning
307810	Straight	36 x Ø5	Set of 4	
326600	120° prism	30 x Ø5	2 prism pairs	
326610	120° prism	35 x Ø5	2 prism pairs	



## + Universal stop

Order No.	Material	Supplied with
277510	Steel	2 exchangeable stop points

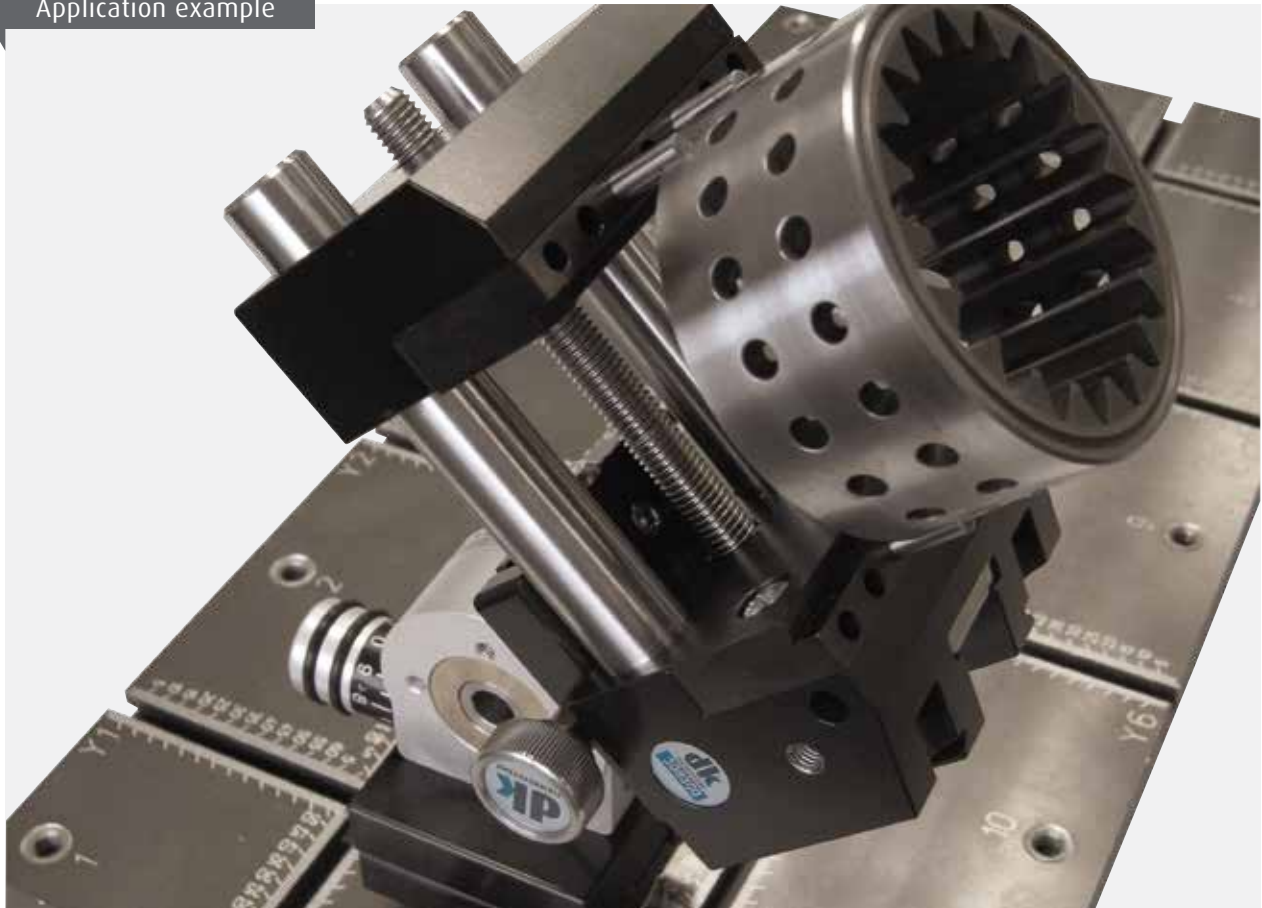


## + Stops for vices

Order No.	Material	Length	Overhang	Description
318100	Steel	50	20	
318200	Steel	50	40	
318110	Steel	150	20	
318210	Steel	150	40	



### Application example



## 125 mm precision vice

**Description**

Vice with exchangeable clamping width extension guide shafts. SWA 39 quick-change adapter integrated in the vice base. With stepped jaws and  $\varnothing 6$  mm holes for clamping pins.

**Material**

Hard-coated aluminium with surface hardened steel jaws.

**Supplied with**

1 adjustable stop (318110), an extra set of shafts for extending the clamping width up to 170 mm, 4 pins and operating tools.



Order No.	Jaw width	Clamping width	Weight
308600	125	80 / 170*	3.30

SWA 39

\* Can be extended up to 220 mm with extra shaft sets.

## Accessories

## + Shaft set for clamping range extension

Order No.	Material	Jaw width	Supplied with	Description
309600	Surface hardened steel	-	1 set of 2 guide shafts and 1 threaded spindle	For clamping range extension up to 220 mm



## + Smooth jaws

Order No.	Material	Jaw width	Contents	Description
308820	Stainless steel	125	1 set with fastening screws	-



## + Form jaws with small prisms

Order No.	Material	Jaw width	Supplied with	Clamping diameter
309400	Stainless steel	125	1 set jaws one smooth and one prism jaw	recommended vertical and horizontal from 5 mm



## + Form jaws with prisms for end-face clamping

Order No.	Material	Jaw width	Contents	Clamping diameter
309501	Stainless steel	125	1 set	25 to 180 mm



## + Clamping pins, stepped

Order No.	Contact face	Length	Contents	Description
307850	Straight	32 x Ø6	Set of 4	for raised part positioning
326650	120° prism	30 x Ø6	2 prism pairs	



## + Universal stop

Order No.	Material	Supplied with
277510	Steel	2 exchangeable stop points

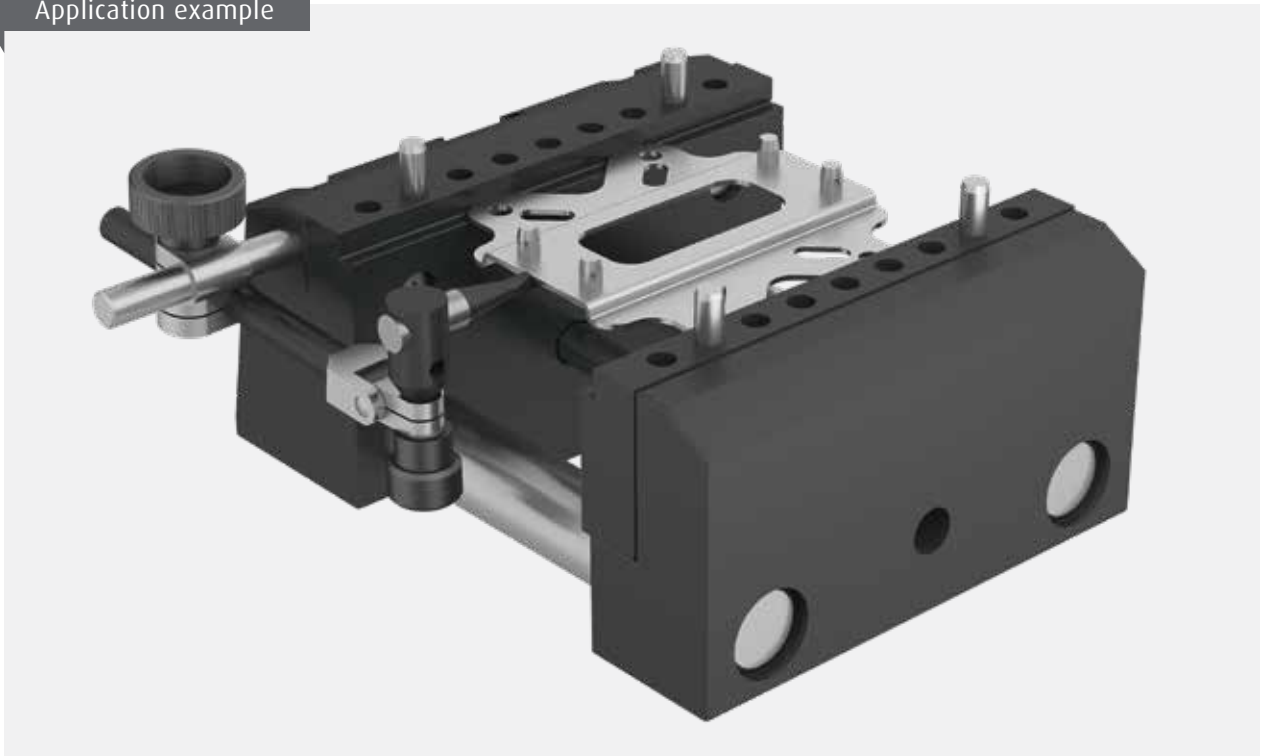


## + Stops for vices

Order No.	Material	Length	Overhang	Description
318100	Steel	50	20	
318200	Steel	50	40	
318110	Steel	150	20	
318210	Steel	150	40	



### Application example



## Precision mini chuck

### Description

Precision mini chuck with externally offset clamping jaws. For internal and external clamping of rotationally symmetrical parts. Mounted on an SWA 39 or SWA 5 quick-change adapter.

### Material

Hard-coated aluminium/steel.



2

SWA 39

SWA 5

Order No.	Connection	Int. clamping Ø	Ext. clamping Ø	Height	Diameter	Fig.
283700	SWA 39	0.2-3	3-5	59	24	
283900	SWA 39	0.5-5	5-9	79	32	1
283600	SWA 5	0.2-3	3-5	60	24	2
283800	SWA 5	0.5-5	5-9	80	32	

### Application example



## Precision collet chuck ER 16

### Description

ER 16 collet chuck for 0.5–10 mm collets. With SWA 39 quick-change adapter.



### Application example



Order No.	Version	Length	Width	Height	Weight
283480	ER 16	60	60	65	0.35

## Accessories

### + Collets

Order No.	Material	Clamping Ø	Description
263400	Steel	0.5–1	collets suitable for collet chuck ER 16
263401		1–2	
263402		2–3	
263403		3–4	
263404		4–5	
263405		5–6	
263406		6–7	
263407		7–8	
263408		8–9	
263409		9–10	



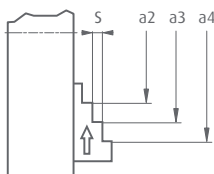
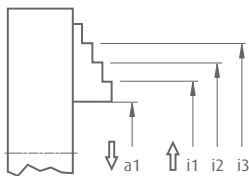
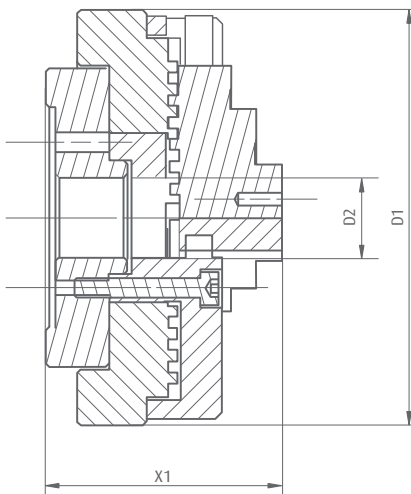
### + Complete set of collets

Order No.	Material	Clamping Ø	Description
263450	Steel	0.5–10	Complete set of collets 0.5–10 mm (parts 263400–263409) for ER 16 collet chuck

## Description

## General information about our dk precision three-jaw chucks

dk precision three-jaw manual chucks represent quality, precision and smooth operation. The compact design and use of aluminium for the 100 mm and 160 mm version bodies make the chucks easy and ergonomic to operate with metrology machines. The 34 mm to 100 mm sizes are fitted with reversible jaws, providing a wide clamping range for internal and external clamping. Exchange jaws are available as accessories with the 160 mm chuck. The diverse interfaces make the chucks compatible with the measurement fixating systems from dk.



### Technical data

	34 mm	50 mm	65 mm	100 mm	160 mm
d1	35	52.5	65	106	162
d2	12	11	13	15	34
x1	18.5	37.5	37.5	47.5	80

### Clamping range

	34 mm	50 mm	65 mm	100 mm	160 mm
i1	11-23	17-35	17-47	20-60	38-100
i2		35-53	35-65	40-80	90-160
i3				60-100	
a1	1-14	1-18	1-30	1-40	2.5-70
a2	20-32	18-36	18-48	28-66	42-120
a3		36-54	36-66	48-84	100-160
a4				68-102	
s	4.3	4	4	4.5	10

## Interfaces

Interface	34 mm	50 mm	65 mm	100 mm	160 mm
SWA 39	329000	329705	329700	283220	330310
SWA 5	329010				
3 x M2	329030				
3 x M4		329720	329710		
4 x M6				283225	330315
Plate 30x30x8	329020				
MK 2		329725	329715		



SWA 39



3 x M4



MK 2



SWA 5

## Application examples



## 34 mm precision three-jaw chuck

### Description

Hand operated three-jaw chuck with tool-free reversible jaws for internal and external clamping of rotationally symmetrical work-pieces.

Chuck precision without further attachments:

Radial run-out < 0.03 mm

Axial run-out < 0.01 mm

Repeat accuracy < 0.01 mm

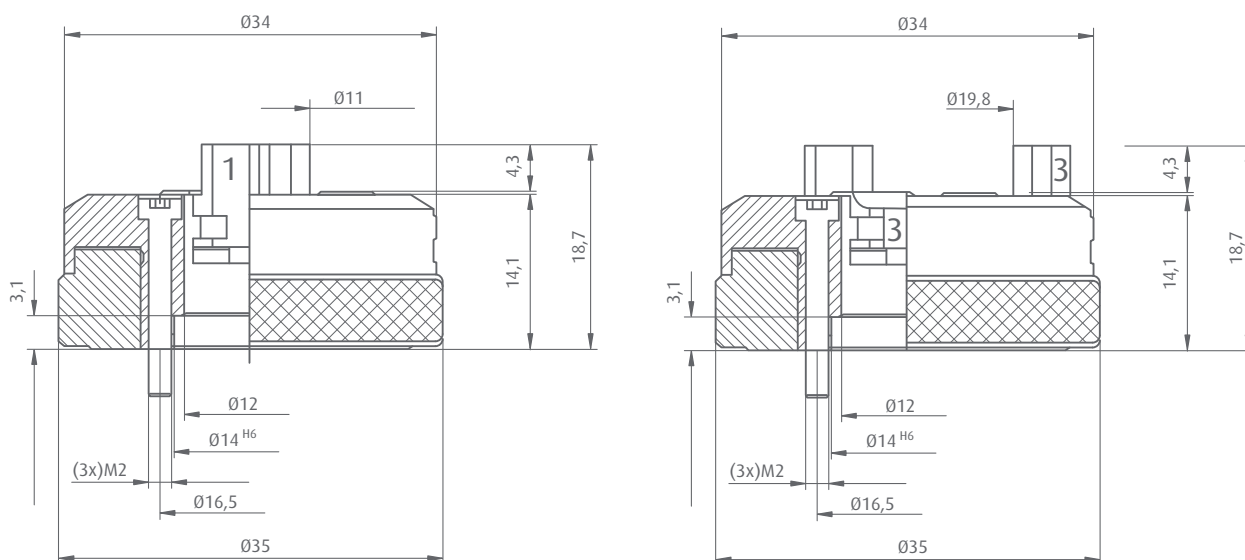
With an SWA 39 quick-change adapter.

Also available with an SWA 5 quick-change adapter that can also be held on the 14 mm OD.



### Material

Made completely from stainless steel.



Order No.	Size	Connection	Height
329000	34	SWA 39	72
329010	34	SWA 5	38.5
329020	34	Plate 30x30x8	26.5
329030	34	3x M2 on D 16.5	18.5

**Please note:** Part 329030 can only be used in conjunction with customer-specific attachments!



Application example



50 mm precision three-jaw chuck

Description

Hand operated three-jaw chuck with tool-free reversible jaws for internal and external clamping of rotationally symmetrical workpieces. With pin holes and 2 sets of pins of different lengths for elevating parts for access from all sides.

Pin holes  $\varnothing 2 \times 7$  mm deep.

Chuck precision without further attachments:

Radial runout < 0.03 mm

Axial run-out < 0.01 mm

Repeat accuracy < 0.01 mm

With an SWA 39 quick-change adapter.

Also available with fastening holes or MK 2 Morse taper.

Material

Steel and hard-coated aluminium.

Supplied with

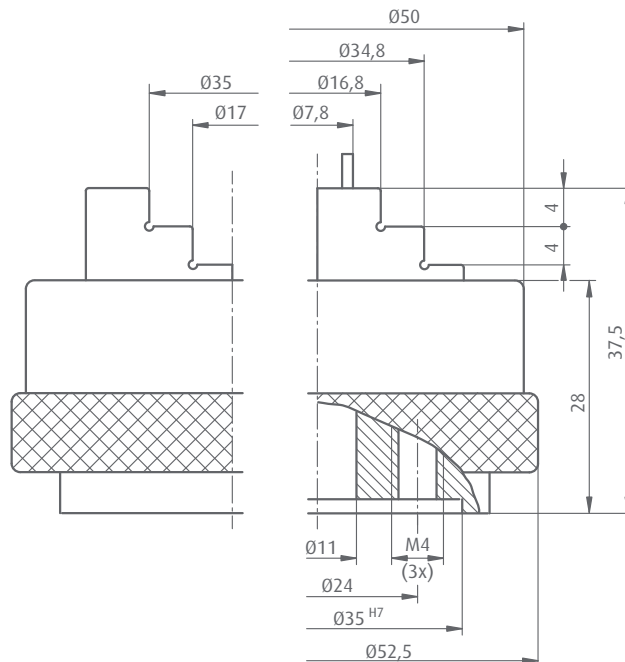
Operating tools and 2 sets of 3 pins 12 mm and 18 mm long.



2



3



Order No.	Size	Connection	Height	Fig.
329705	50	SWA 39	58	1
329720	50	3x M4	38	2
329725	50	MK 2*	46.5	3

\* Other adapter types available on request.



## + Seating spacers for 3-jaw chucks

### Description

A set of spacers used to limit the depth a workpiece is set in the jaws and ensure repeat setup accuracy.

### Material

Engineering plastic.

### Contents

3 spacers with different heights.



Order No.	Suitable for	Contents	Height 1	Height 2	Height 3
283250	50 mm and 65 mm 3 jaw chucks	Set of 3	3	5	7

## + Soft jaws for 3-jaw chucks

### Description

A set of soft jaws for machining to suit specific applications.

### Material

Bronze



Order No.	Suitable for	Contents
329730	50 mm and 65 mm 3-jaw chucks	Set of 3

### Application example



65 mm precision three-jaw chuck

**Description**

Hand operated three-jaw chuck with tool-free reversible jaws for internal and external clamping of rotationally symmetrical workpieces. With pin holes and 2 sets of pins of different lengths for elevating parts for access from all sides.

Pin holes  $\varnothing 2 \times 7$  mm deep.

Chuck precision without further attachments:

Radial runout < 0.03 mm

Axial run-out < 0.01 mm

Repeat accuracy < 0.01 mm

With an SWA 39 quick-change adapter.

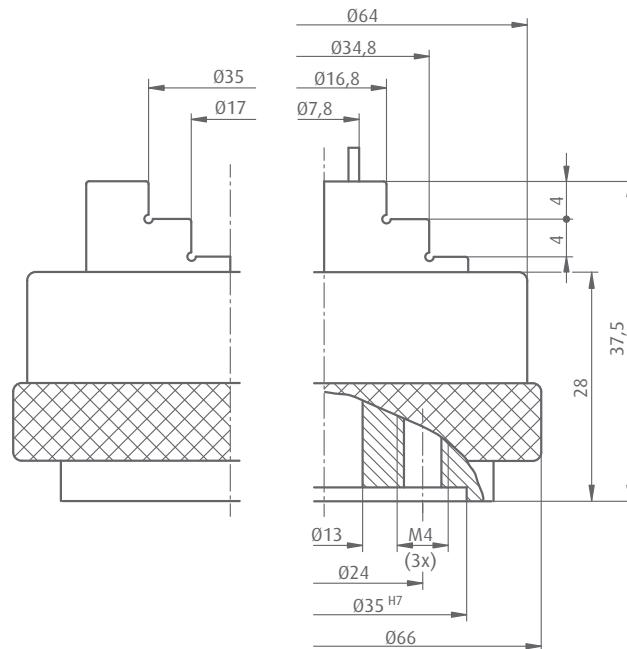
Also available with fastening holes or MK 2 Morse taper..

**Material**

Steel and hard-coated aluminium.

**Supplied with**

Operating tools and 2 sets of 3 pins 12 mm and 18 mm long.



Order No.	Size	Connection	Height	Fig.
329700	65	SWA 39	58	1
329710	65	3x M4	38	2
329715	65	MK 2*	46.5	3

\* Other adapter types available on request.



## + Seating spacers for 3-jaw chucks

### Description

A set of spacers used to limit the depth a workpiece is set in the jaws and ensure repeat setup accuracy.

### Material

Engineering plastic.

### Contents

3 spacers with different heights.



Order No.	Suitable for	Contents	Height 1	Height 2	Height 3
283250	50 mm and 65 mm 3-jaw chucks	Set of 3	3	5	7

## + Soft jaws for 3-jaw chucks

### Description

A set of soft jaws for machining to suit specific applications.

### Material

Bronze



Order No.	Suitable for	Contents
329730	50 mm and 65 mm 3-jaw chucks	Set of 3

### Application example



## 100 mm precision three-jaw chuck

**Description**

Hand operated three-jaw chuck with tool-free reversible jaws for internal and external clamping of rotationally symmetrical workpieces. With  $\varnothing 3 \times 8$  mm deep pin holes and 3 sets of pins of different lengths for elevating parts for access from all sides.

Chuck precision without further attachments:

Radial runout < 0.03 mm

Axial run-out < 0.01 mm

Repeat accuracy < 0.01 mm

Aluminium housing for weight reduction.

With an SWA 39 quick-change adapter.

Also available with fastening holes.

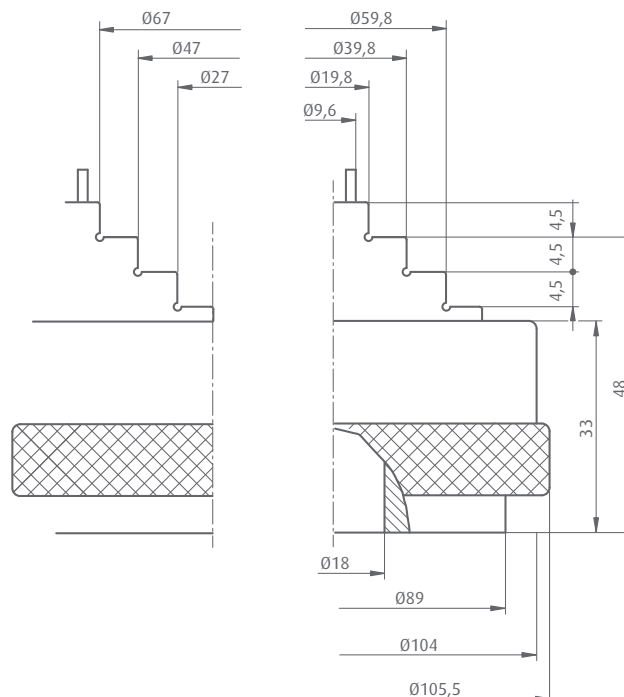
**Material**

Hard-coated aluminium. Hardened steel jaws.

**Supplied with**

Operating tools and 3 sets of pins 12 mm, 18 mm and 24 mm long.

↪ For hole dimensions for part 283225 see page 72.



Order No.	Size	Version	Height	Weight
283220	100	SWA 39	80	1.9
283225	100	4x M6	60	1.7

SWA 39

M ...

## + Seating spacers for 3-jaw chucks

### Description

A set of spacers used to limit the depth a workpiece is set in the jaws and ensure repeat setup accuracy.

### Material

Engineering plastic.

### Contents

3 spacers with different heights.



Order No.	Suitable for	Contents	Height 1	Height 2	Height 3
283255	100 mm and 160 mm 3-jaw chucks	Set of 3	5	8	12

## + Soft jaws for 3-jaw chucks

### Description

A set of soft jaws for machining to suit specific applications.

### Material

Soft steel.



Order No.	Suitable for	Contents
283230	100 mm 3-jaw chuck	Set of 3

### Application example



160 mm precision three-jaw chuck

**Description**

Hand operated three-jaw chuck with tool-free reversible jaws for internal and external clamping of rotationally symmetrical workpieces. With  $\varnothing 4 \times 8$  mm deep pin holes and 2 sets of pins of different lengths for elevating parts for access from all sides.

With an SWA 39 quick-change adapter.  
Also available with fastening holes.

**Material**

Hard-coated aluminium. Hardened steel jaws.

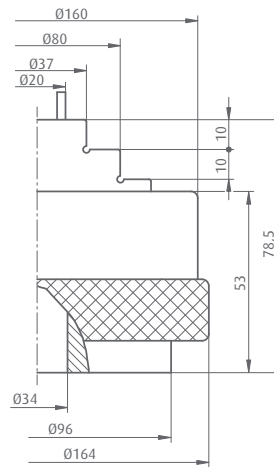
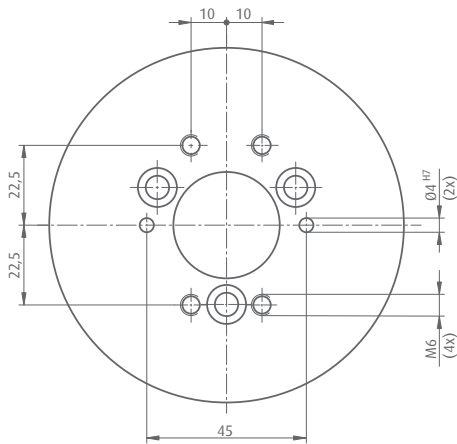
**Supplied with**

Operating tools and 2 sets of 3 pins 18 mm and 24 mm long.



*Hole dimensions below are for 160 mm and 100 mm chucks.*

Connections underneath



Order No.	Size	Version	Height	Weight
330310	160	SWA 39	102	4.9
330315	160	4x M6	82	4.7





## Accessories

### + OD chuck jaws

Order No.	Material	Size	Contents	Description
330311	Steel	160	Set of 3 jaws	Hardened



### + Soft jaws

Order No.	Material	Size	Contents	Description
330312	Steel	160	Set of 3 jaws	Soft



### + Seating spacers for 3-jaw chucks

#### Description

A set of spacers used to limit the depth a workpiece is set in the jaws and ensure repeat setup accuracy.

#### Material

Engineering plastic.

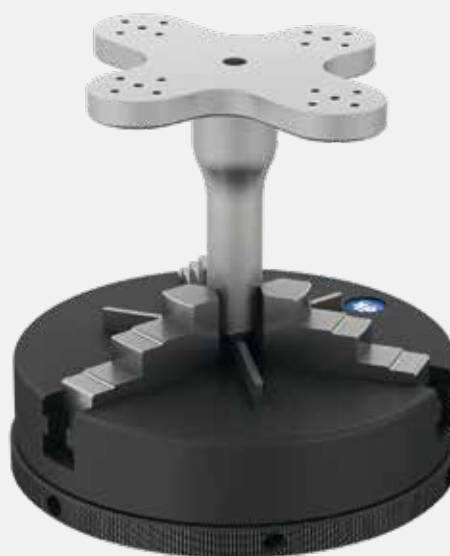
#### Contents

4 spacers with different heights.



Order No.	Suitable for	Contents	Height 1	Height 2	Height 3	Height 4
283260	160 mm chuck	Set of 4	5	8	12	18

### Application example



## Rotary table with precision three-jaw chuck

### Description

Rotary mounted three-jaw manual chuck with high concentricity. For internal and external clamping of rotationally symmetrical parts. With  $\varnothing 2 \times 7$  mm deep holes and 2 sets of pins of different lengths for elevating parts for access from all sides. Available with an SWA 39 quick-change adapter or base plate.

### Material

Hard-coated aluminium. Hardened steel jaws.

### Supplied with

Operating tools and 2 sets of pins 12 mm and 18 mm long.



### Application example



Order No.	Size	Version	Radial runout	Height
267365	50	Base plate	+/- 0.025	71
267370	50	SWA 39	+/- 0.025	71
267355	65	Base plate	+/- 0.025	71
267360	65	SWA 39	+/- 0.025	71

SWA 39

M ...

Application example



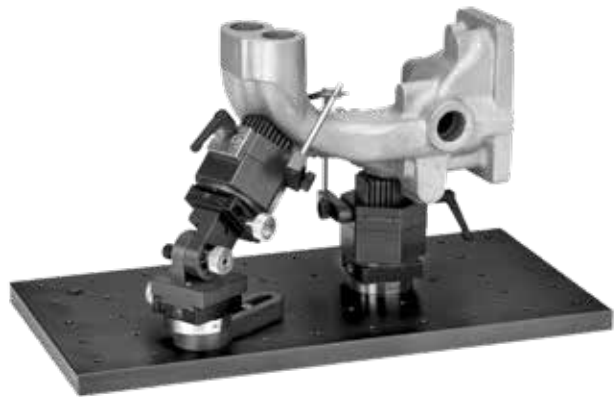
**NADELFIX: fix-variable self-moulding from products**

**Function**

Workpieces with complicated free-form geometries for which no conventional clamping equipment exists can be securely and reproducibly fixated and held with *NADELFIX*. Parts to be tested are pressed into a bed of individually sprung pins or needles which are then locked in place by a central clamp. This rapidly produced exact negative form of the test piece perfectly holds the part in place with minimum clamping force using e.g. a spring finger. There is no surface damage, as with normal vices, nor are there unreliable, improvised fixations.

**Advantages**

- Excellent suitability for free-form surfaces
- Secure and gentle hold through positive fit with minimum clamping force
- Time saving and cost effective due to rapid adjustment to variable workpiece geometries
- Universal clamping element rather than manufacturing and storing product-specific special fixtures
- Simple and tool-free operating principle
- Can be combined with other dk product ranges
- Modular system with a wide range of possible applications



**NADELFIX 2.5**

**Description**

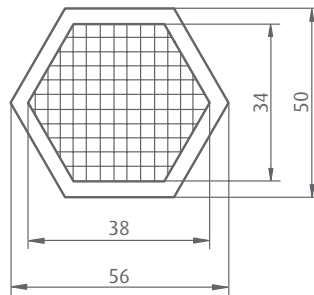
Ideal for clamping moulded parts.  
With an SWA 39 quick-change mount.

**Supplied with**

A clamping fixture comprising rail (396120), column (269043) and spring finger (269038). Fasteners also included.



**Application example**



Order No.	Pin Ø	Support surface	Total height	Spring travel
396030	2.5	38 x 34	55	max. 10

SWA 39

## NADELFIX 5 Mini

### Description

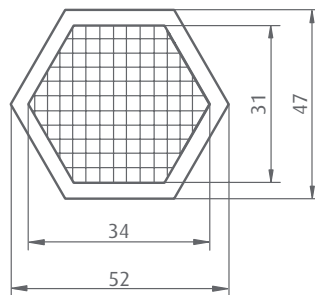
Ideal for clamping moulded parts.  
Available with an SWA 39 quick-change mount or an SWA 8 quick-change mount for flexible use on articulated arms.

### Supplied with

A clamping fixture, comprising rail (396110), column (368300) and spring finger (302800). Fasteners are included.



2



1

SWA 8

SWA 39

Order No.	Pin Ø	Support surface	Total height	Spring travel	Interface	Fig.
396000	5	34 x 31	90	max. 12	SWA 39	1
396005	5	34 x 31	80	max. 12	SWA 8	2

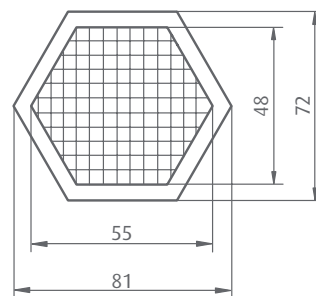
## NADELFIX 5 Midi

### Description

Ideal for clamping moulded parts.  
With an SWA 39 quick-change mount.

### Supplied with

A clamping fixture, comprising rail (396110), column (368300) and spring finger (302800).  
Fasteners are included.



Order No.	Pin Ø	Support surface	Total height	Spring travel
396010	5	55 x 48	80	max. 12

SWA 39

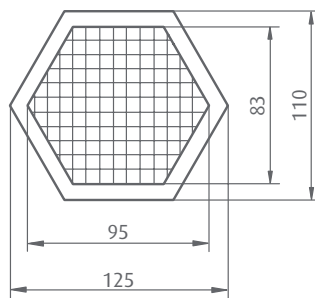
## NADELFIX 5 Maxi

### Description

Ideal for clamping moulded parts.  
With an SWA 39 quick-change mount.

### Supplied with

A clamping fixture, comprising rail (396100), column (368300) and spring finger (302800).  
Fasteners are included.



Order No.	Pin Ø	Support surface	Total height	Spring travel
396020	5	95 x 83	90	max. 12

SWA 39

### Application example



## + Attachment rails

### Description

For flexible positioning of spring fingers on "NADELFIX".

### Material

Hard-coated aluminium.



Order No.	Total length	Adjustment range	Thread
396120	50	34	M4
396110	60	33	M6

## + Columns for spring fingers

### Description

Columns for mounting spring fingers.

### Material

Stainless steel.



Order No.	Column Ø	Thread	Length
269042	4	M 4	30
269043	4	M 4	50
269044	4	M 4	75
368100	6	M 6	30
368200	6	M 6	50
368300	6	M 6	75
368400	6	M 6	100
368500	6	M 6	125

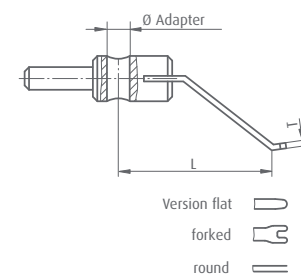
## + Spring fingers

### Description

For quickly and easily holding test parts.

### Material

Stainless steel.



Order No.	Adapter Ø	T	L	Version	Fig.
269037	4	0.4	30	Flat	1
343700	4	0.8	30	Flat	
269038	4	1.1	40	Round	
269039	4	1.1	60	Round	
302800	6	1	50	Flat	
302900	6	1	75	Flat	

## Small-parts clamp, smooth

**Description**

Small-parts clamp with smooth jaws. Available with an SWA 39 quick-change adapter or with M 6 female thread.

**Material**

Hard-coated aluminium/steel.

**Application example**

1



2

Order No.	Version	Jaw width	Width (W)	Height	Fig.
275600	SWA 39	12	0.5-5	100	
276000	SWA 39	18	1.5-8	100	1
276200	SWA 39	25	3-10	120	
390200	M 6	12	0.5-5	80	
391600	M 6	18	1.5-8	80	2
276210	M 6	25	3-10	100	

SWA 39

SWA 6



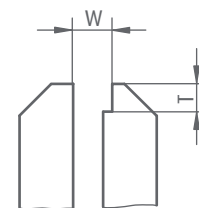
## Small-parts clamp, stepped jaw one side

### Description

Small-parts clamp with stepped jaw one side. Available with an SWA 39 quick-change adapter or with M 6 female thread.

### Material

Hard-coated aluminium/steel.



### Application example



Order No.	Version	Jaw width	Width (W)	Depth (T)	Height	Fig.
275700	SWA 39	12	1-5	2	100	
276100	SWA 39	18	2.5-8	2	100	1
276300	SWA 39	25	4-10	2	120	
390300	M 6	12	1-5	2	80	
391500	M 6	18	2.5-8	2	80	2
276310	M 6	25	4-10	2	100	

SWA 39

SWA 6

Small-parts clamp with horizontal prism

Description

Small-parts clamp with horizontal prism jaws. For clamping rotationally symmetrical parts. Available with an SWA 39 quick-change adapter or with M 6 female thread.

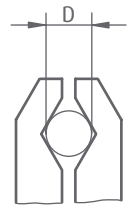
Application example



2



1



Order No.	Version	Clamping Ø (D)	Jaw width	Height	Fig.
275800	SWA 39	3.2-6	3.5	100	
275900	SWA 39	5-8.5	5	100	1
275810	M 6	3.2-6	3.5	80	
275910	M 6	5-8.5	5	80	2

SWA 39

SWA 6

Small-parts clamp with end-face prism

Description

Small-parts clamp with prismatic top face and stepped jaws for holding rotationally symmetrical parts. Mounted on an SWA 39 quick-change adapter or with an M6 female thread.

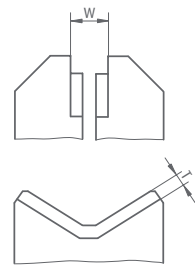
Application example



2



1



Order No.	Version	Clamping Ø	Width (W)	Depth (T)	Height	Fig.
277305	SWA 39	3-25	3-6	2	100	1
277320	SWA 39	5-35	4-10	2	100	
277300	SWA 39	6-55	4-12	3	120	
390010	M 6	3-25	3-6	2	80	2
277315	M 6	5-35	4-10	2	80	
277325	M 6	6-55	4-12	3	100	

SWA 39

M 6

## Small-parts clamp for internal clamping

### Description

Small-parts clamp for holding workpieces in the bore. The clamping diameter is stepped in 3 mm increments (276800 + 276805 first step = 4 mm).

Mounted on an SWA 39 quick-change adapter or with an M6 thread.



Order No.	Version	Clamping Ø	Step depth	Height	Fig.
276800	SWA 39	5-30	2	120	1
276805	M 6	5-30	2	100	2

SWA 39

M 6

### Application example



## Stop for small-parts clamps

### Description

Stop for reproducible clamping of small parts on all types of small-parts clamps with SWA 39 adapter.

### Supplied with

M6 connection screw, a flat point and Ø2 mm ball point (M2.5 screw on points).



Order No.

Overhang

277500

100

M 6

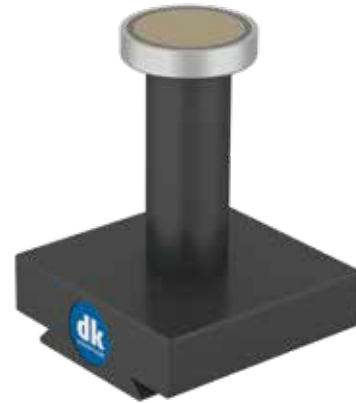
### Application example



## Permanent magnetic clamping fixture

### Description

Permanent magnetic plate for the quick and easy holding of steel parts. Mounted on an SWA 39 quick-change adapter.



Order No.	Height	Magnet Ø	Magnetic force (N)	Weight
278000	80	32	350	0.29

SWA 39

## Magnetic clamping fixture with on/off switch

### Description

Permanent magnet with on/off switch for the quick and easy holding of steel parts. Mounted on an SWA 39 quick-change adapter.



Order No.	Height	Magnet Ø	Magnetic force (N)	Weight	Fig.
278200	70	50	85	0.86	1
278210	85	80	500	2.50	

SWA 39

## Magnetic V-block, permanent

### Description

Permanent magnetic 90° V-block for holding rotationally symmetrical parts. Mounted on an SWA 39 quick-change adapter.

### Material

Hard-coated aluminium.



Order No.	Clamping range	Prism depth	Magnetic force (N)	Height
313700	Ø 15–35	16	15	100

SWA 39

## Magnetic V-block with on/off switch

### Description

Magnetic V-block with on/off switch for holding rotationally symmetrical parts. With mounting hole for adjustable length stop. Mounted on an SWA 39 quick-change adapter.

### Material

Hard-coated aluminium/steel.

↳ See pages 43 and 46 for length stop.



Order No.	Clamping range	Prism depth	Magnetic force (N)	Height
278300	Ø 5–50	37	800	80
278310	Ø 5–50	67	1000	80

SWA 39

## Small V-block with spring finger

### Description

Small 120° V-block for holding rotationally symmetrical parts with spring fingers.

Mounted on an SWA 39 quick-change adapter.

### Material

Aluminium/stainless steel.

### Supplied with

Bracket (343800) and spring finger (343700).

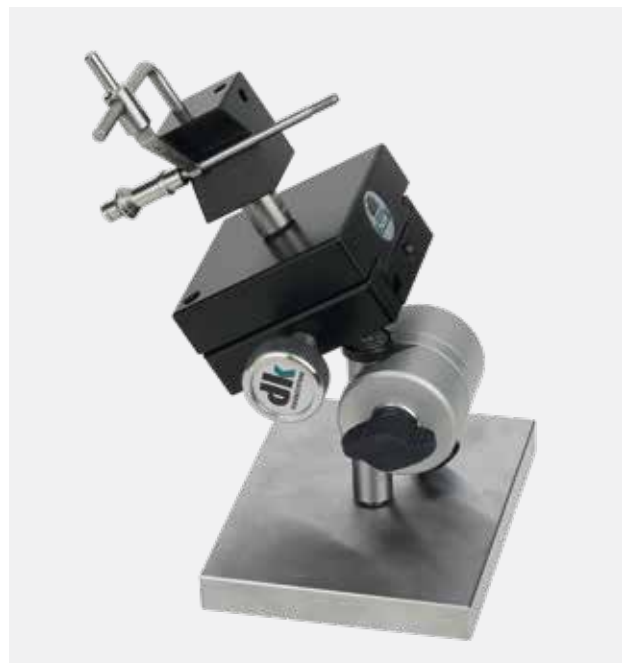


Order No.	Clamping range	Prism depth	Prism width	Connection	Height	Fig.
277410	Ø 2-25	10	30	SWA 39	65	1
277400	Ø 2-25	25	30	SWA 39	45	2
267900	Ø 2-25	25	30	SWA 5	25	3

SWA 39

SWA 5

### Application examples



## V-block

**Description**

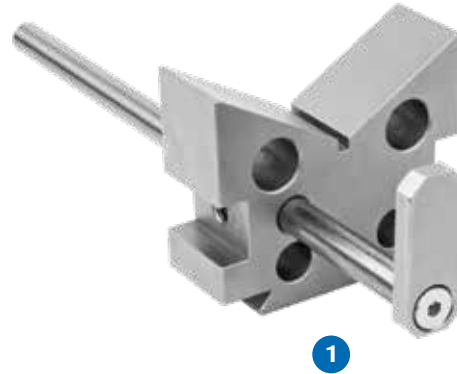
120° V-block for mounting rotationally symmetrical test parts. Adjustable length stop for reproducible clamping. With an SWA 39 quick-change adapter on the V-block base and SWA 8 connection option (272700 only). Also with lateral slots and tapped holes for mounting a tensioning strap fixture, U-clamp or spring finger.

**Material**

Hardened steel.

**Supplied with**

Adjustable length stop (318110).



Order No.	V-block length	V-block width	Prism	Fig.
272700	20	60	120°	1
272810	60	60	120°	

SWA 39

SWA 8

## Application example





## + U-clamp

### Description

For clamping rotationally symmetrical parts.

### Material

Aluminium.



### Order No.

272920

### Clamping range

Ø 4-45 (for 120° V-block)

## + Spring finger with mount

### Description

For quickly and easily holding parts.

### Supplied with

Spring finger (302800),  
Column (368300) and  
Column holder (272910).



### Order No.

272930

### Clamping range

Ø 4-90 (for 120° V-block)

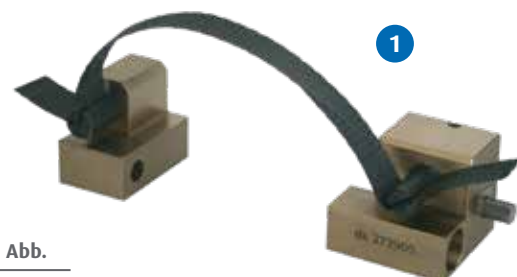
## + Tensioning strap fixture

### Description

Ideal for clamping irregularly shaped parts.

### Supplied with

M5 fastening screw, operating tools and 5m tensioning strap.



### Order No.

272900

### Clamping range

Ø 15-100

### Description

Standard

### Abb.

1

272850

Ø 15-100

Extra strong

272855

Adapter for mounting 272850 on T-slots 6

272902

Adjustable torque wrench

## Pair of V-block halves on a T-slot 6

### Description

V-blocks halves for T-slots. The clamping range is freely adjustable. With lateral slots and tapped holes for mounting a tensioning strap fixture or spring finger. Part 306500 with mounting hole for stops.

☞ See pages 43 and 46 for length stops (stop for vices).

### Material

Hard-coated aluminium/steel.

### Supplied with

Screws and slot keys



Order No.	Prism	Block length	Height	Fig.
305500	120°	18	42	1
305700	120°	25	42	
306500	120°	40	52	

T-Nut 6

### Application example



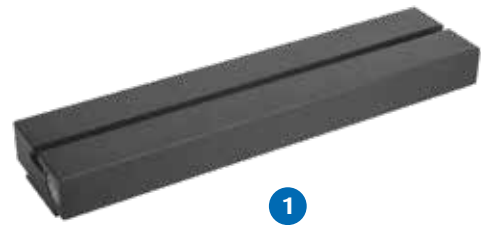
## + Adapter plates with T-slot 6

### Description

Baseplate with T-slot 6 for mounting various modules e.g. structural elements from the *SPANNFIX* range. With an SWA 39 quick-change adapter for mounting on the SWA 39 basic elements.

### Material

Hard-coated aluminium/steel.



Order No.	Length	Width	Height	Fig.
305000	140	60	24	
305100	250	60	24	1
305110	500	60	24	

T-Nut 6  
SWA 39

## + Spring finger with mount

### Description

For quickly and easily holding parts.

### Supplied with

Adjustable spring finger (302810), column (368500) and column holder (272910).



Order No.	Clamping range
272940	Ø 40-120

↳ See pages 130 and 133 for other spring fingers in *Spannfix PRO* range.

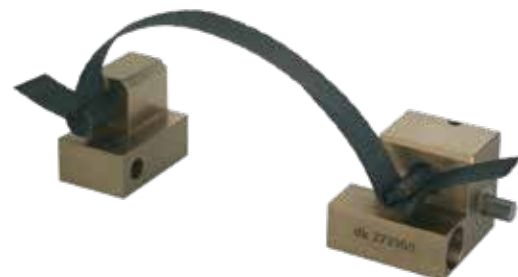
## + Tensioning strap fixture

### Description

Ideal for clamping irregularly shaped parts.

### Supplied with

M5 fastening screw, operating tools and 5m tensioning strap.



Order No.	Clamping range	Description
272900	From ca. Ø 40	Standard
272850	From ca. Ø 40	Extra strong
272902	Adjustable torque wrench	

## Airbase pneumatic glide foot

### Description

Basic attachment for SWA 39 modular elements on smooth surfaces. Easy glide on an air cushion. Fix in place by vacuum. Connection module with SWA 39 interface. Maximum load ca. 15 kg. Operating pressure 4.5 to 6 bar. Operate only with dry, oil-free air.

With port for vacuum generation in other elements that may be connected.



Order No.	Length	Width	Height	Weight
270200	300	200	110	3.3

SWA 39

## Vacuum plate – round

### Description

High-strength aluminium round vacuum plate. With seal grooves and stop for reproducible part setups. ON/OFF switch with rapid air venting. Mounted on an SWA 39 quick-change adapter.

### Material

Aluminium.

### Supplied with

Seal and connection hose (D 5).



Order No.	Max. vacuum area
294700	Ø 30

SWA 39

## Vacuum plate – square

### Description

High-strength aluminium vacuum plate. With seal grooves and stops for reproducible part setups. ON/OFF switch with rapid air venting. Mounted on an SWA 39 quick-change adapter.

### Material

Aluminium.

### Supplied with

Seal and connection hose (D 5).



Order No.

Max. vacuum area

294000

100 x 100

SWA 39

### Application example



## Clamping sets "A"

### Description

Set "A" with basic, structural and key clamping elements. The precision vice and the chuck from the expanded set can both be mounted directly to the quick-action base as a kind of zero-point clamping fixture.

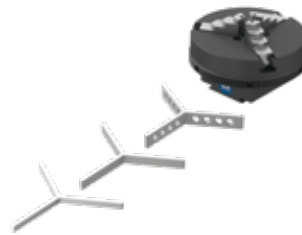
Alternatively, a swivel unit can be mounted in between enabling 3D spatial positioning of the clamping element and workpiece. This enables zero-point clamping with variable alignment, and scales ensure that positions can always be exactly reproduced for different workpieces.

### Ordering information

When ordering, select the appropriate quick-action clamp or let us know the thread or T-slot size on your measuring equipment.

### Set „A3+“

Set „A3“



### Set versions

Order No.	Description
340530	Clamping set "A3"
340540	Clamping set "A3+"

### Set contents

Order No.	Description	Set "A3"	Set "A3+"
308200	80 mm precision vice	1	1
307800	Pins with straight faces for vice jaws (set of 4)	1	1
326600	Pins with prism faces for vice jaws (set of 4)	1	1
283220	100 mm precision three-jaw chuck		1
314010	Quick-action clamp swivel unit	1	1
283255	Seating spacers to raise workpieces for 100 mm chuck, 5 mm, 8 mm and 12 mm high.		1
See below	Quick-action clamp	1	1
	<b>Order No.</b>	<b>Fastening</b>	
	285206	M 6	
	285208	M 8	
	285210	M 10	
	285212	M 12	
	285300	T-slot	

## Clamping set "B"

### Description

Set "B" with basic, structural and essential clamping elements. The precision vice with a range of accessories, chuck and small-parts clamp can be mounted directly to the quick-action basic clamp as a kind of zero-point clamping fixture. Alternatively, a rotary and swivel unit can be mounted in between enabling 3D spatial positioning of the clamping element and workpiece. This enables zero-point clamping with variable alignment, and scales ensure that positions can always be exactly reproduced for different workpieces.

### Ordering information

When ordering, select the appropriate quick-action clamp or let us know the thread or T-slot size on your measuring equipment.



### Set versions

Order No.	Description
340615	Clamping set "B"

### Set contents

Order No.	Description	Quantity
282100	50 mm vice with accessories	1
329700	65 mm chuck	1
283250	Seating spacers to raise workpieces for 65 mm chuck, 3 mm, 5 mm and 7 mm high.	1
275600	Small-parts clamp, smooth	1
314020	Quick-action rotary and pivot unit clamp	1
See below	Quick-action clamp	
	<b>Order No.</b>	<b>Fastening</b>
	285206	M 6
	285208	M 8
	285210	M 10
	285212	M 12
	285300	T-slot

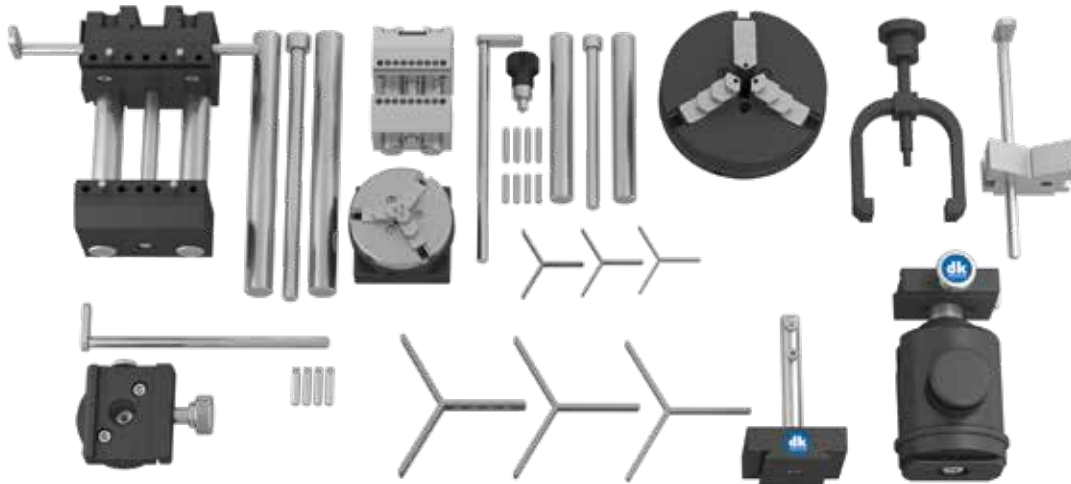
## Clamping set "C"

### Description

Set "C" with basic, structural and a range of clamping elements in various sizes. The 50 mm precision vice with a range of accessories, 80 mm vice, 65 mm and 100 mm chucks, small-parts clamp and V-block with stop and U-clamp can be mounted directly to the quick-action basic clamp as a kind of zero-point clamping fixture. Alternatively, a 3D adjustment unit can be mounted in between enabling 3D spatial positioning of the clamping element and workpiece. This enables zero-point clamping with variable, spatial alignment for a variety of workpiece geometries and sizes.

### Ordering information

When ordering, select the appropriate quick-action clamp or let us know the thread or T-slot size on your measuring equipment.



### Set versions

Order No.	Description
340700	Clamping set "C"

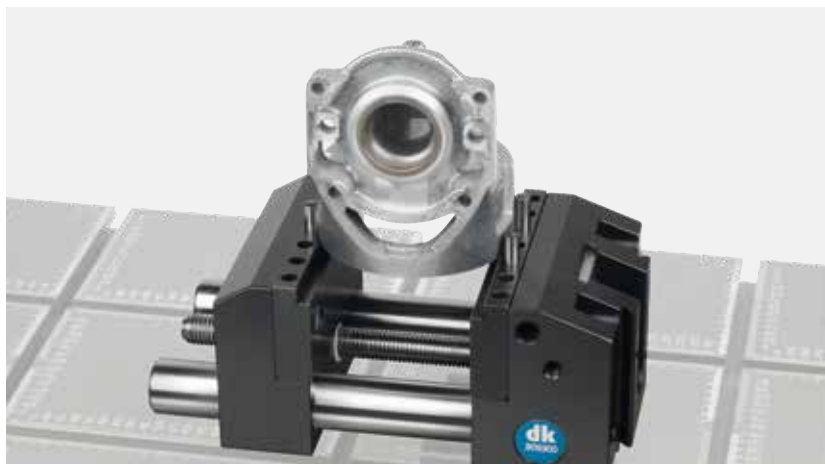
### Set contents

Order No.	Description	Quantity
282100	50 mm vice with accessories	1
282300	Set of stepped pins for 50 mm vice	1
308300	80 mm vice with connections for SWA 39 on 3 faces	1
307800	Set of stepped pins for 80 mm vice	1
329700	65 mm chuck	1
283250	Seating spacers for 65 mm chuck, 3, 5, and 7 mm high.	1
283220	100 mm chuck	1
283255	Seating spacers for 100 mm chuck, 5, 8, and 12 mm high.	1
272700	120° V-block	1
272920	U-clamp for V-block	1



Order No.	Description	Quantity
275600	Small-parts clamp, smooth	1
270500	Swivel unit with ball joint	1
See below	Quick-action clamps	
Order No.	Fastening	
285206	M 6	
285208	M 8	
285210	M 10	
285212	M 12	
285300	T-slot	

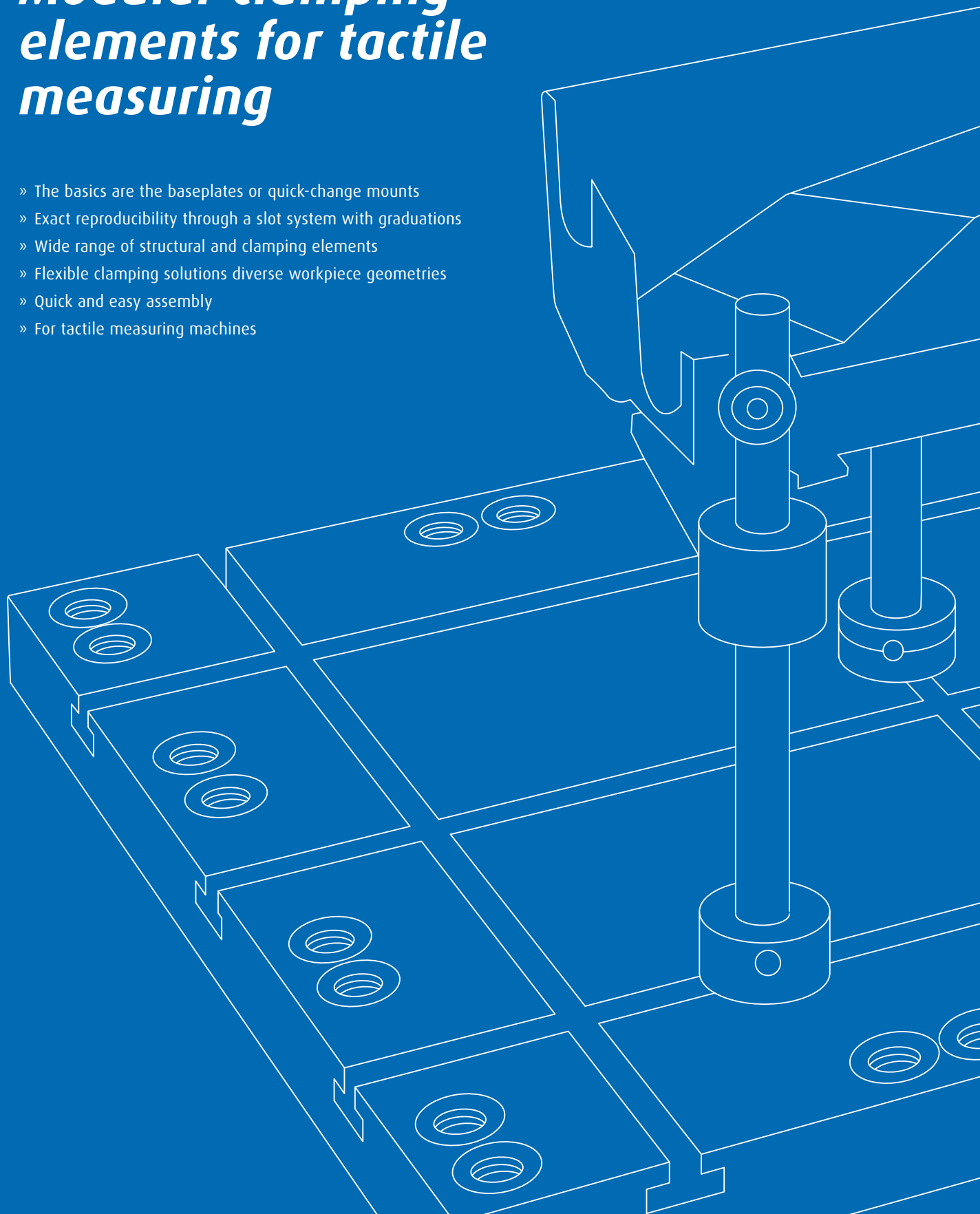
### Application examples



**SPANNFIX** PRO

## *Modular clamping elements for tactile measuring*

- » The basics are the baseplates or quick-change mounts
- » Exact reproducibility through a slot system with graduations
- » Wide range of structural and clamping elements
- » Flexible clamping solutions diverse workpiece geometries
- » Quick and easy assembly
- » For tactile measuring machines



Basic elements  
+ accessories



Baseplates with T-slots

Page 104



Intermediate plates

Page 105



Mounting frame with T-slots

Page 106

Structural elements  
+ accessories



T-slot nuts

Page 108



T-slot screws

Page 108



Satellite mount with slot key

Page 109



Base rails M 10

Page 110



Base rails M 10 XL

Page 111



Hexagonal extensions M 8 and M 10

Page 112



Self-aligning pads M 10

Page 113



Jack screws M 10

Page 113



Quick-change adapter M 10

Page 114



Screw jack set with spring finger

Page 115



T-slot 6 columns for arm construction, with holder

Page 116



Columns without holder

Page 117



Column cross connector D 12 and M 10

Page 117



Support arm

Page 118



Pins for support arm

Page 119



Bridge supports

Page 120



Mounts with slot

Page 121



Pair V-block halves

Page 121



Adjustable stop

Page 122



Extensions for clamping supports

Page 124



Pairs of V-block halves

Page 125



Side clamp with draw-down jaw

Page 125



Thread reducer

Page 126



Columns with screw

Page 127



Articulated arms

Page 128

Clamping elements  
+ accessories



Spring fingers

Page 130



Columns with screw for spring fingers

Page 131



Adapter plates for columns

Page 132



Spring finger with quick-change adapter

Page 133



Toggle clamp with support

Page 134



Parallel clamps

Page 136



Parallel clamps with guide pin

Page 137



Tension clamp

Page 138



Prism support with spring finger

Page 138



Clips

Page 139



Pair of V-block halves for mounting directly on clamping elements

Page 140



Tailstock

Page 142

Vacuum systems  
+ accessories



Suction cups

Page 144



Vacuum pumps

Page 146



Vacuum pumps for compressed air operation

Page 146

SWA 39 connection  
+ accessories



Quick-action clamp for T-slots

Page 148



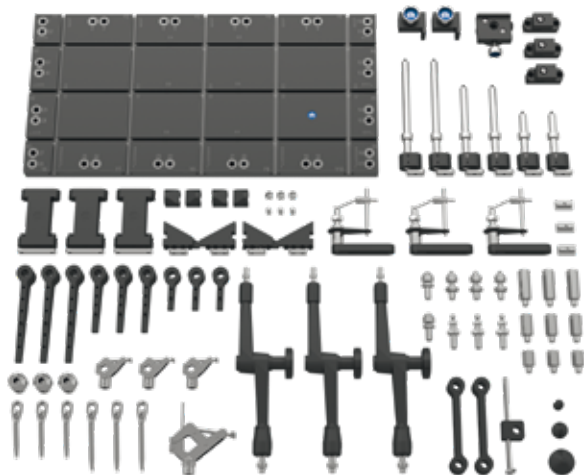
**SPANNFIX PRO basic set**

Page 150



**SPANNFIX PRO expansion set**

Page 151



**SPANNFIX PRO complete set**

Page 152

# Precisely reproducible fixtures with scales and angular alignment

SPANNFIX PRO modular system fixtures for exact positioning, fixating and clamping of complex geometries while maintaining maximum workpiece accessibility. Comprising basic, structural and clamping elements which can all be connected to each other over standardised interfaces. In the interests of overall cost-effectiveness and sustainability, the configurations can thus be repeatedly dismantled and rebuilt identically or completely anew. Especially during product development, where changes are usually made, the structure can be easily adapted to changed dimensions or forms. Instead of shelf-filling special clamping elements of classical fixture construction which cannot be adapted, and are therefore scrap after the product life cycle of the test part, professionals use modular systems with intelligent components. Since these only make sense when enough different basic, structural and clamping elements form a functional program, SPANNFIX PRO offers not only a wealth of individual parts, but also their trouble-free combination with other dk fixation systems.



**FAST  
REASSEMBLY  
LIFELONG**

## Basic elements

- 1 Baseplate with T-slots (page 104)  
Other baseplates (pages 105-107)



## Structural elements

- 2 T-slot 6 columns (page 116)



- 3 Support arm (page 118)



- 4 Satellite mount (page 109)





Clamping elements

- 5 Hexagonal columns M8 + M10 (page 112)  
Other columns (pages 116-117)



- 6 Adjustable stop (page 122)



- 7 Spring fingers (page 130)  
Others (page 133)



- 8 Toggle clamp with support (page 134)



Baseplates with T-slots

Description

Baseplates with T-slot 6 and connection threads. With scale for exact and reproducible positioning of fixture elements.

Material

Hard-coated aluminium / Stainless steel tapped bushes

↳ Custom-made versions available on request. See pages 150 to 153 for complete sets with fixture elements.



With scales

Order No.	Dimensions	Scale	Long/cross slots	Thread	Weight
281200	400 x 400 x 24	yes	4/4	M 8	10.2
280500	500 x 250 x 24	yes	2/4	M 8	10.5
280800	600 x 300 x 24	yes	3/5	M 8/M 10	12.4
280900	800 x 400 x 24	yes	4/6	M 8/M 10	22.4

Application example





## Intermediate plate T-slot 6

### Description

Plates with T-slots for mounting on baseplates with T-slots or M6 mounting threads. For X/Y adjustment.

### Material

Hard-coated aluminium.



Order No.	No. of slots	Length	Width	Height	Weight
325100	3	117	117	20	0.68

T-Nut 6

T-Nut 6  
M 6

## Accessories



Handgrip

### Description

Grip for mounting in a T-slot to ease transporting the baseplates with T-slots.

### Contents

1 set of 2 handgrips with fasteners.



Order No.	Length	Height
328500	150	45

T-Nut 6

Mounting frame with T-slot

Description

Slot rails with T-slot 6, can be joined to form angle constructions or complete frames. With scales for exact and reproducible positioning of fixture elements.

Material

Hard-coated aluminium.



Frame construction as set

Order No.	Description	Length	Width	Height	Weight
281600	Frame construction	500	300	24	3.6
281900	Frame construction	650	410	24	4.3

Individual elements

Order No.	Description	Length	Width	Height	Weight
281730	Cross rail	300	30	24	0.5
281735	Cross rail	350	30	24	0.6
281750	Long rail	500	30	24	0.8
281760	Long rail	600	30	24	1.1
281700	Screw set				0.1

Application example



## + Plate clamping claws with stop

### Description

A set of clamping claws for the 24 mm thick dk slot plates. The claws are screwed onto the measuring machine table. Check the table thread sizes before ordering. These elements provide a stop for repeat accuracy while simultaneously securing dk baseplates.



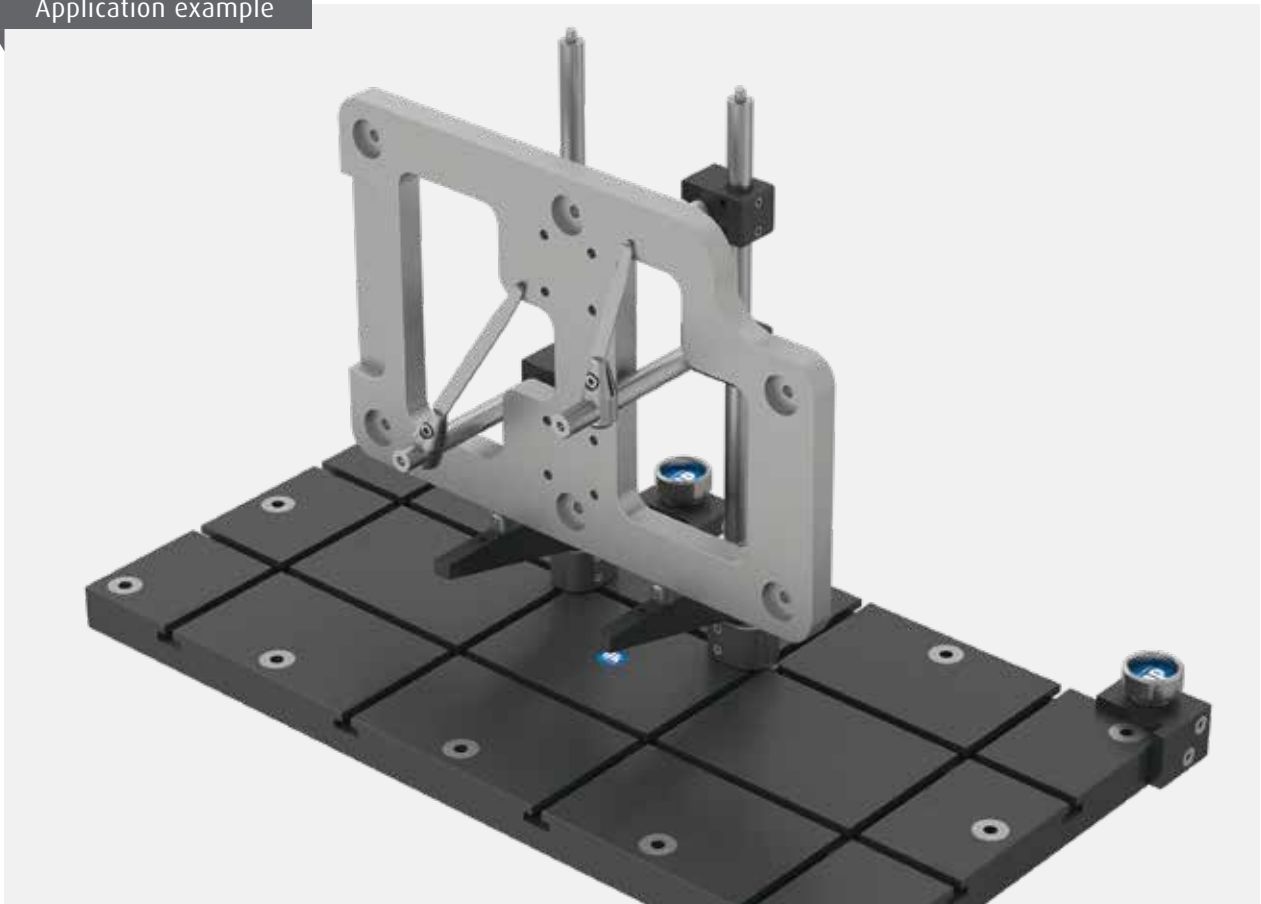
### Contents

One set with knurled nuts.

Order No.	For plate thickness	Thread
281406	24	M 6
281408	24	M 8
281410	24	M 10
281412	24	M 12

M ...

### Application example



T-slot nuts

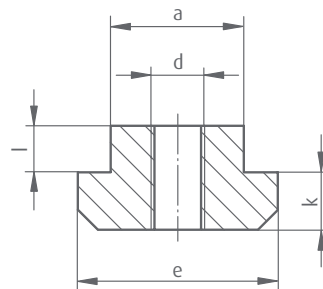
**Description**

M6 T-slot nuts fit in plates and rails with T-slot 6. Used to connect basic rails, columns, SWA 39 quick-action clamps etc. and customer specific structural elements with M6 male threads.

Special sizes for other slot systems available on request.

**Material**

Stainless steel.



Order No.	d	a	e	k	l
326400	M 6	5.9	16	4.8	4.9

M 6  
T-Nut 6

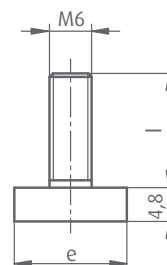
T-slot screws

**Description**

M6 T-slot screws fit in plates and rails with T-slot 6. Used to connect structural elements with M6 female threads.

**Material**

Stainless steel.



Order No.	e	l	Thread
326800	16	16.2	M 6

M 6  
T-Nut 6

## Satellite mounts with T-slot key

### Description

Mount for M 8 and M 10 modules. With slot key for T-slot 6 for free positioning on a baseplate.

### Material

Stainless steel/brass.

### Supplied with

T-slot key for T-slot 6.



Order No.	Version
290600	M 8 female thread
290700	M 10 female thread

M 8	M 10
T-Nut 6	T-Nut 6

### Application examples



**Base rail M 10**

**Description**

Adjustable base rail with slot and M10 connection thread for screwing in columns and articulated arms.

**Material**

Hard-coated aluminium.

**Supplied with**

M6 screw for connecting to a T-slot key or nut.  
(Order T-slot nut 326400 from page 108 separately)



Order No.	Slot width	Adjustment range	Length	Width	Height
322010	6	60	105	25	12

M 10	M 10
M ...	T-Nut

Application examples



## Base rails M 10 XL

### Description

Large, highly adjustable base rail with slot and M10 connecting thread for screwing on columns and articulated arms. Includes 4 holes for securing i.e. quick-action clamp 285206 or vices 270860 and 282110 or customer specific elements.

### Material

Hard-coated aluminium.



Order No.	Slot width	Adjustment range	Length	Width	Height
397012	12.5	80	150	50	20
397013	12.5	130	200	50	20



## + Fastening accessories

(Order T-slot nut 326400 from page 108 separately)

Order No.	Description	Version
397014	Screw with washer	M 6
397015	Screw with washer	M 8
397016	Screw with washer	M 10
397017	Screw with washer	M 12

### Application example



Hexagonal extensions M 10 and M 8

Description

Hexagonal extension pieces with male thread one end and female thread other end. For screwing onto satellite mounts and base rails. Screw together to increase height.

Material

Stainless steel.



Order No.	Male thread	Female thread	Length
304100	M 8	M 8	50
304200	M 8	M 8	100
322200	M 10	M 10	25
322300	M 10	M 10	35
322400	M 10	M 10	50
304400	M 10	M 10	100
253500	M 10	M 10	150



Application example





## Self-aligning pads M 10

### Description

Support with flattened, swivel ball to compensate for surface irregularities. Can be screwed onto hexagonal extension pieces or directly into base rails.

### Material

Stainless steel/black oxidised steel.

### Supplied with

Locknut.



Order No.	Support	Swivel range	Adjustment range	Length
323000	Ø 8	± 15°	15	46

M 10

## Jack screws M 10

### Description

Height adjustable supports for centring and supporting test parts.

### Material

Stainless steel.

### Supplied with

Locknut.



Order No.	Version	Adjustment range	Length	Fig.
322600	With 90° point, Ø10	15	50	1
322700	With 5 mm ball end	25	63	2

M 10

Quick-change adapter M 10

Description

Quick-change adapter M 10 for SWA 5 / SWA 8 modules.

Material

Stainless steel.

Supplied with

Locknut.



Order No.	Version	Adjustment range	Length
329400	SWA 5	25	55
329500	SWA 8	25	57

SWA 5	SWA 8
M 10	M 10

Accessories

+ Centre points

Description

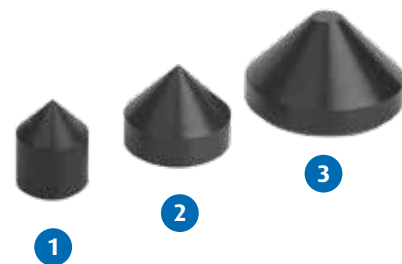
90° centre points with SWA 8 quick-change mount.

Material

Hard-coated aluminium.

Order No.	Diameter	Height	Fig.
303600	15	20	1
303700	25	20	2
303800	40	24	3

SWA 8



+ Prism supports

Description

120° prism supports with SWA 8 quick-change mount.

Material

Hard-coated aluminium.

Order No.	Clamping range	Prism length	Connection	Height	Fig.
323500	Ø 2-60	8	SWA 8	35	1
323400	Ø 2-60	40	SWA 8	33	2

SWA 8



## + Flat supports

### Description

Flat supports in various versions: flat face, straight step and prism step. With SWA 8 quick-change mounts.

### Material

Hard-coated aluminium.



Order No.	Version	Diameter	Height	Step height	Fig.
303805	Flat face	25	20		1
303810	Straight step	25	20	5	2
303815	Prism step	25	20	5	3

SWA 8

## Screw jack set with spring finger

### Description

Adjustable base rail with support and spring finger. The support height is adjustable.

### Material

Hard-coated aluminium/stainless steel.

### Supplied with

Base rail (322010), extension piece (322200), jack screw (322700), adapter plate for columns (353700), column with screw (368300), spring finger (302800), locknut and fastening screw.

↳ See T-slot nuts page 108 for fastening the base rail in a T-slot.



Order No.	Adjustment range	Length	Width	Support height
322005	60	105	25	80-90

M 6

T-Nut

T-slot 6 columns for arm construction, with holder

**Description**

Column with holder and slot key. Flat side for precise alignment of support arms and bridges relative to the slot directions of the baseplate. Remove the guide pin in the base of the holder for free angular positioning.

**Material**

Aluminium and stainless steel.

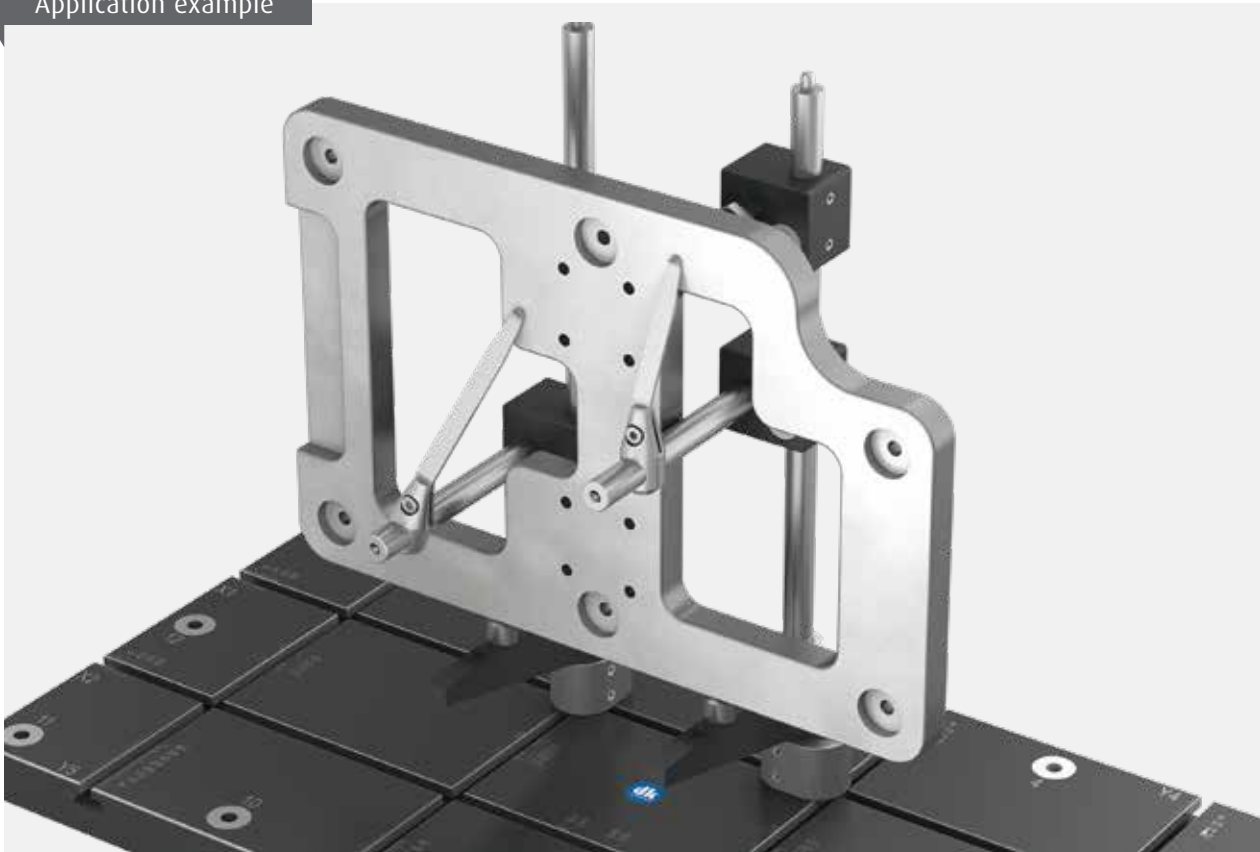
**Supplied with**

Ø5 mm contact pins and adjustable height rests.



Order No.	Column Ø	Length
288605	12	100
288805	12	150
288905	12	200
289005	12	250
289105	12	300
288650	Column holder with slot key	

Application example



## Columns without holder

### Description

Column with flat side for precise alignment relative to the slots of the baseplate.

### Material

Stainless steel.

### Supplied with

Ø5 mm contact pin.

Order No.	Column Ø	Length
352200	12	100
352300	12	150
352400	12	200
352500	12	250
352550	12	300



D 12

## Column cross connector D 12 and M 10

### Description

Connection element enabling a T-slot 6 column and a column without holder to be fitted together at a 90° angle as an alternative to assembling an M10 support at a 90° angle.

### Material

Hard-coated aluminium.



1

### Application example



Order No.	Description	Length	Width	Height	Fig.
352150	Connector for Ø12 and M10 columns	38	24	25	1
352110	Cross connector for Ø12 columns	38	24	25	

D 12

Support arm

Description

Support arm for mounting on Ø12 mm columns. With Ø4 mm holes for contact pins and support pins. Arm width 10mm for mounting V-block halves and adjustable supports.

Material

Hard-coated aluminium.

Supplied with

Ø4 mm pin.

See page 121 for V-block halves and supports with slots

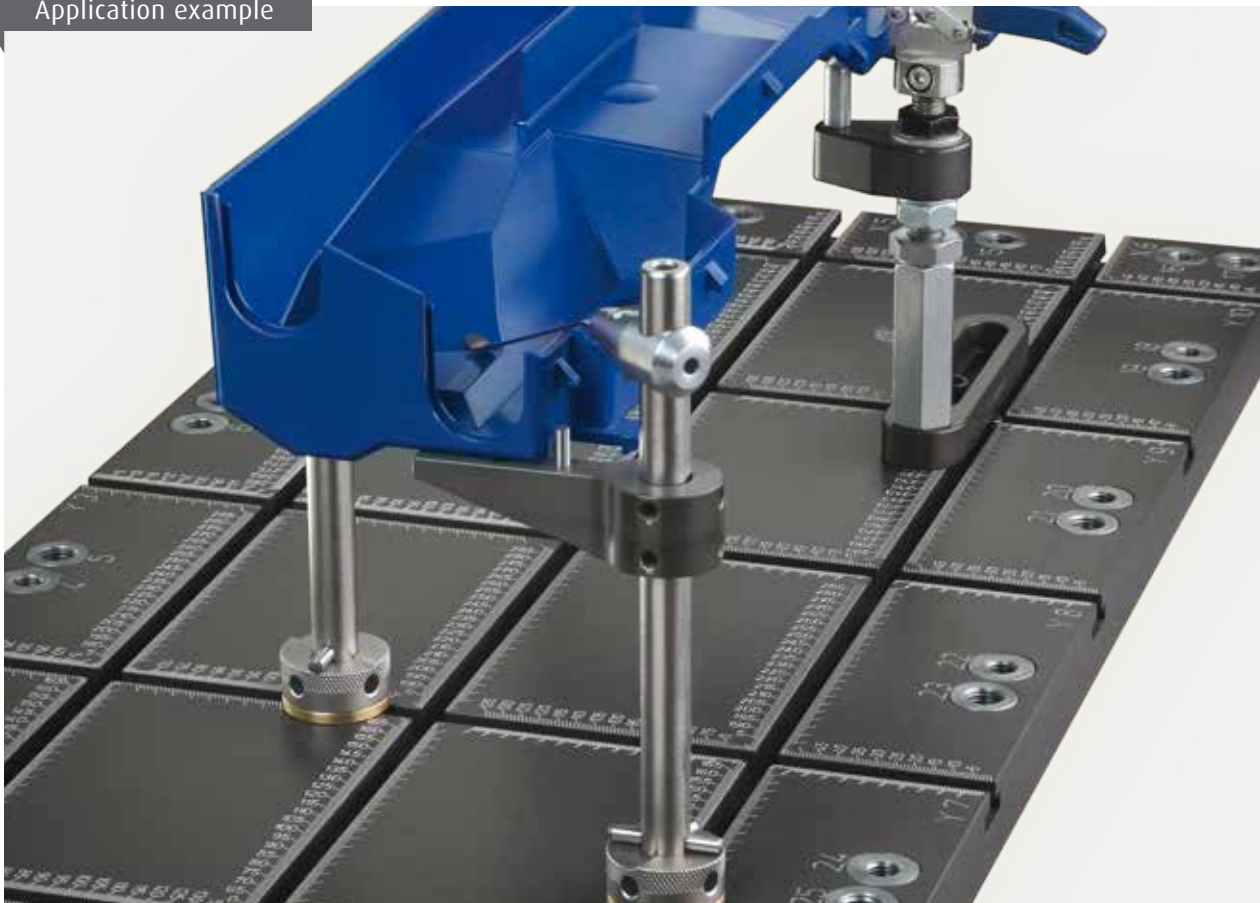


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Order No.	Overhang	Pin holes	Hole spacing	Height	Fig.
286800	60	2	15	20	
286700	100	4	15	30	1
286600	150	6	20	30	

D 12

Application example



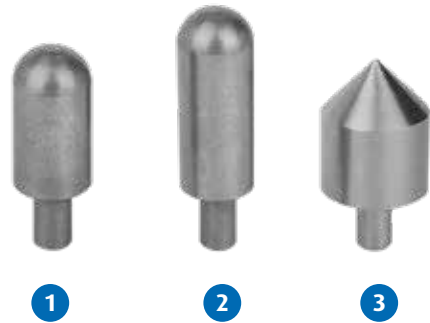
## Support pins for support arm

### Description

Ball-end and point supports for fitting into arms with  $\varnothing 4$  mm holes.

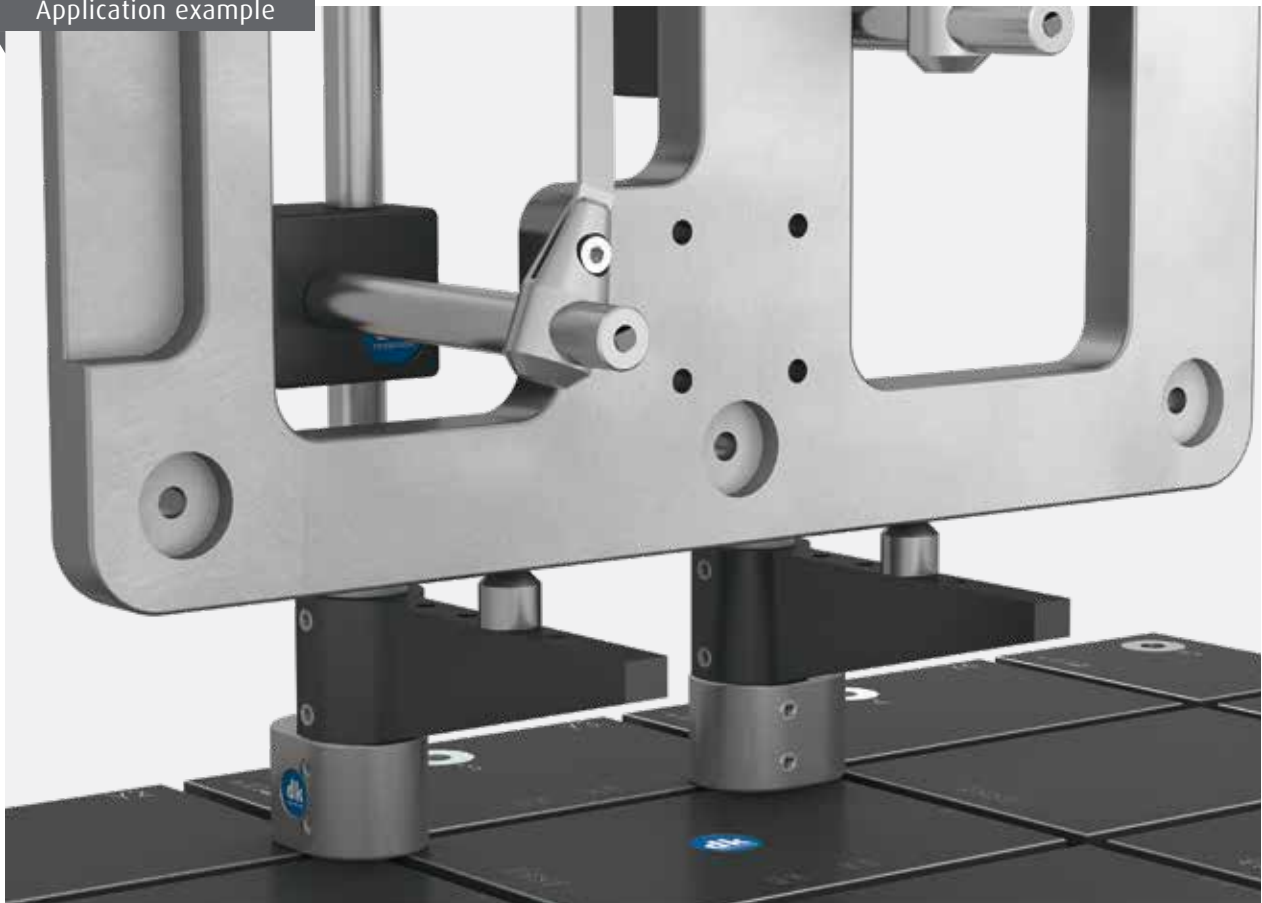
### Material

Stainless steel.



Order No.	Version	Diameter	Fig.
319400	R4 ball-end x 15 mm	8	1
319500	R4 ball-end x 20 mm	8	2
319300	90° point	12	3

### Application example



Bridge supports

Description

Bridge support with 10 mm bridge width for mounting on two Ø12 mm support columns. V-block halves and supports with slots can be mounted on the bridge. Laterally adjustable stops can also be mounted (Ø7 mm).

See page 46 stops for vices for adjustable stops.



Order No.	Centre distance	Fig.
287000	90	
287100	125	1

D 12

Application example





## Mounts with slot

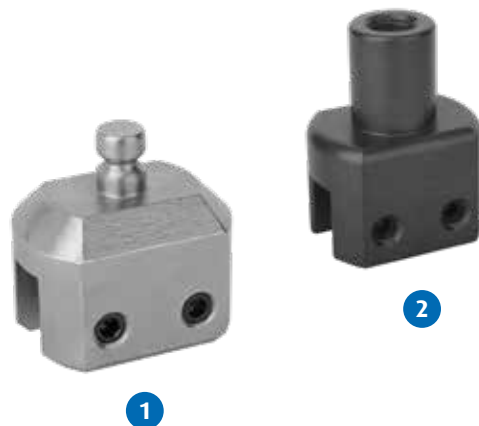
### Description

Adjustable mounts with 10 mm slot for mounting on support arms and bridge supports. For easy adaptation of the SWA 8 quick-change support elements or supports and elements with M 10.

### Material

Hard-coated aluminium/stainless steel.

↳ See pages 113 to 115 for accessories.



### Application example



Order No.	Version	Length	Width	Height	Fig.
303200	SWA 8	25	25	35	1
303300	M 10	25	25	35	2

## Pair of V-block halves

### Description

Pair of 120° V-block halves with 10 mm slot, mounting on support arms and bridge supports.

### Material

Hard-coated aluminium.

### Contents

One pair.



### Application example



Order No.	V-block width	Total height	Fig.
287210	10	47	
287200	24	27	1

**Adjustable stop**

**Description**

Stop for mounting on Ø12 mm columns. Effective length of the stop ca. 130 mm (to centre of column).

**Material**

Hard-coated aluminium/nickel plated steel.



Order No.	Length	Width	Height
287500	35	30	20

D 12

**Application example**



Application examples



Extensions for clamping supports

Description

Extension pieces for raising stop and positioning elements. M6 connecting thread.

Material

Hard-coated aluminium.

Supplied with

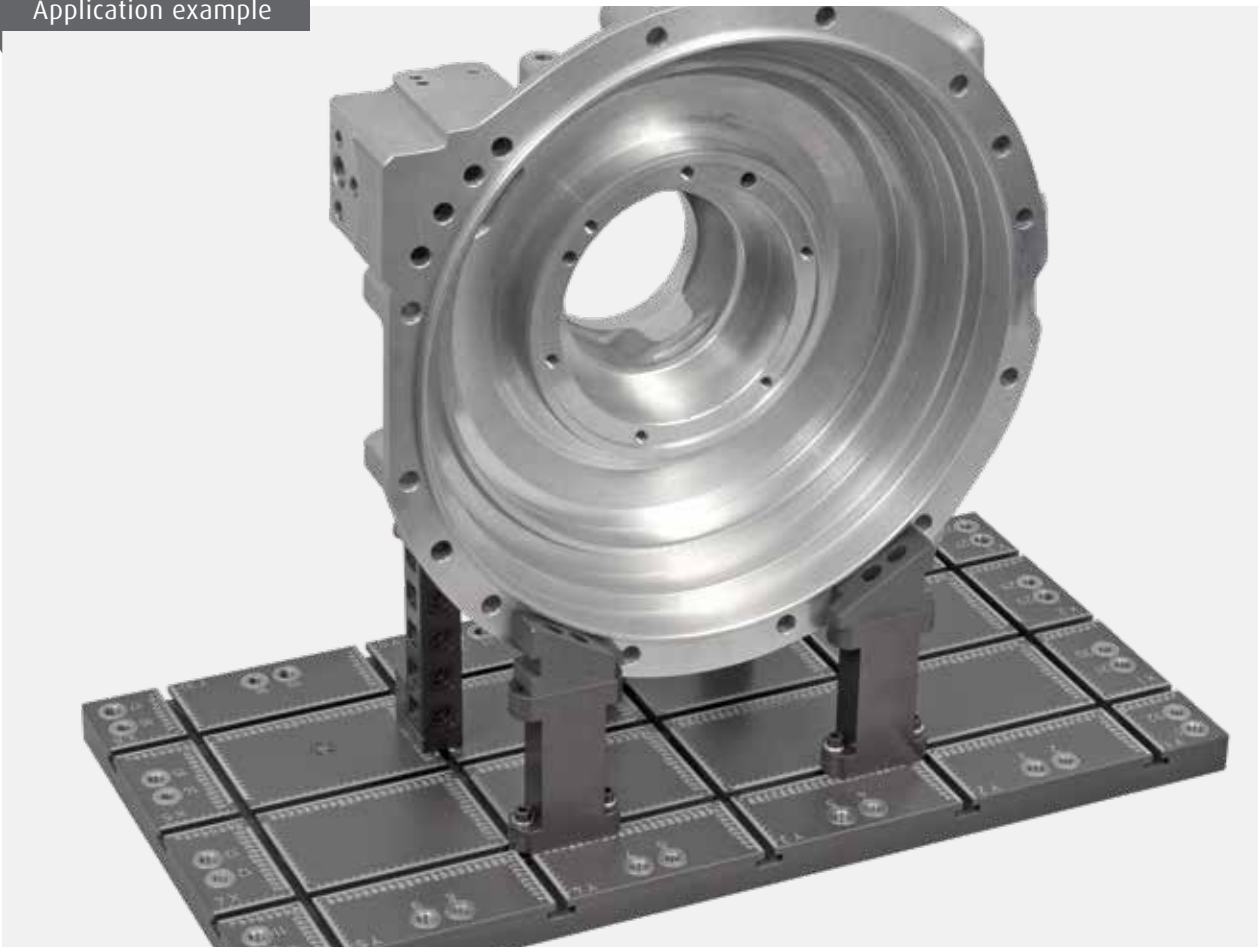
Slot keys.



Order No.	Height	Fig.
324100	100	1
324600	88-112	2

M 6	M 6
T-Nut 6	M ...

Application example



## Pair of V-block halves on a T-slot 6

### Description

Pairs of V-block halves for T-slots. The clamping range is freely adjustable. With lateral slots and tapped holes for mounting a tensioning strap fixture or spring finger. Part 306500 with mounting hole for stops.

🔗 See pages 43 and 46 suitable for stops.

### Material

Hard-coated aluminium/steel.

### Supplied with

Screws and T-slot nuts



Order No.	Prism	Block width	Height	Fig.
305500	120°	18	42	1
305700	120°	25	42	
306500	120°	40	60	

T-Nut 6

## Side clamp with draw-down jaw

### Description

Support with fixed stop and draw-down clamping jaw. For mounting on extensions or with T-slot nuts.

### Supplied with

T-slot nuts.



### Application example



Order No.	Stop	Adjustment range	Length	Width	Height	Fig.
320500	Straight	2.5	65	25	27	1
320600	Radius	2.5	65	25	27	

M 6

T-Nut 6

Thread reducer

**Description**

Thread reducer for connecting different thread sizes e.g. columns, extension pieces, articulated arms, supports, satellite mounts etc.

**Material**

Stainless steel.



Order No.	Male thread	Female thread
275030	M 4	M 8
369000	M 5	M 6
269500	M 5	M 8
275000	M 6	M 8
275010	M 6	M 10
297800	M 8	M 10
275110	M 10	M 6
275100	M 10	M 8
275200	M 12	M 8
275300	M 12	M 10

M ...

Application example



## Columns with screw

### Description

Columns with screws for mounting spring fingers or for use as a stop element.

### Material

Stainless steel.



### Application example



Order No.	Column Ø	Thread	Length
269042	4	M 4	30
269043	4	M 4	50
269044	4	M 4	75
368100	6	M 6	30
368120	6	M 8	30
368200	6	M 6	50
368220	6	M 8	50
368300	6	M 6	75
368400	6	M 6	100
368500	6	M 6	125
368505	6	M 6	150
368600	12	M 6	50
368620	12	M 8	50
368700	12	M 6	100
368720	12	M 8	100
368800	12	M 6	150
368820	12	M 8	150
368900	12	M 6	200
368920	12	M 8	200
368610	12	M 10	50
368710	12	M 10	100
368810	12	M 10	150
368910	12	M 10	200

M ...

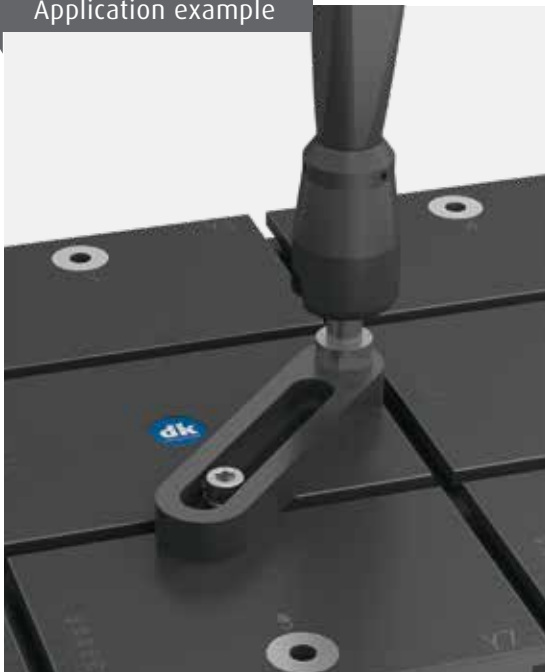
Articulated arms

Description

Progressive clamping articulated stands with a connection screw in the base and a quick-change adapter on the arm. Mechanical articulated clamping arm. Central locking. Holding force at right angles 100 N (type MU) or 80 N (type SU).



Application example

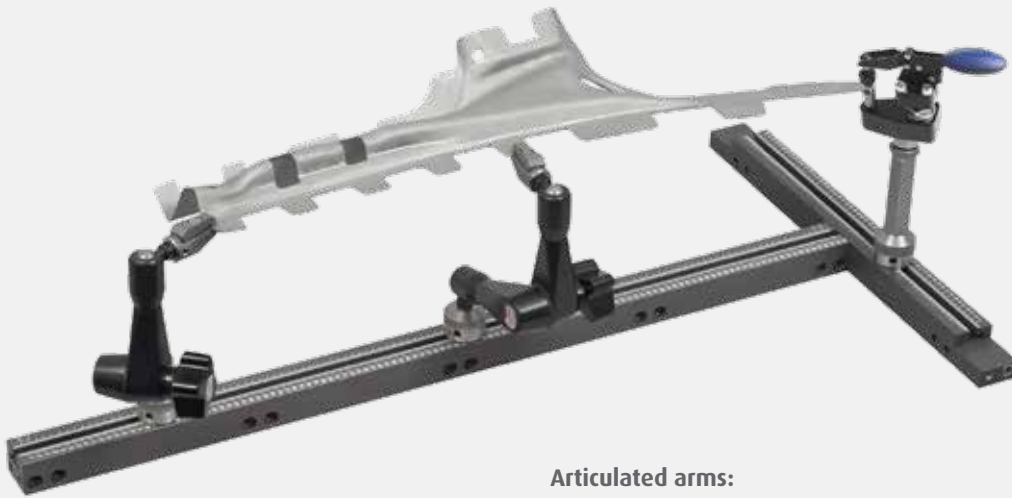


Order No.	Type	Thread	Adapter	Action range (R)
296800	SU	M 8	SWA 5	160
296700	SU	M 8	SWA 8	160
296900	MU	M 10	SWA 5	280
297000	MU	M 10	SWA 8	280





## Application examples



### Articulated arms:

- Highest clamping force due to special, patented mechanical clamping principle
- Quick fixation – all rotary movements are locked by one clamping screw
- Comfortable operation through progressive clamping: the arms are locked and released in a defined sequence



Spring fingers

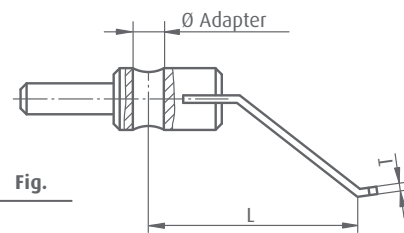
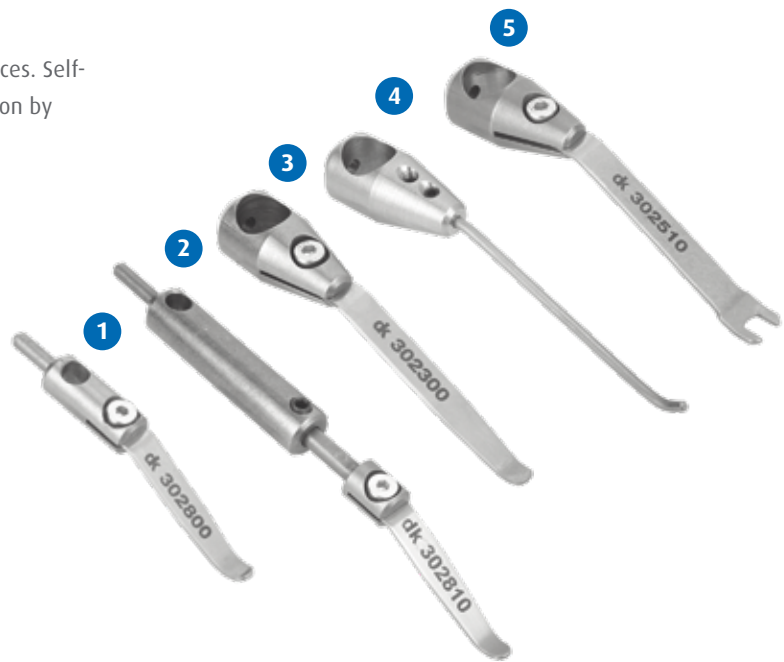
Description

For the simple and quick holding down of workpieces. Self-locking on round columns due to the applied tension by manually pressing down.

Material

Stainless steel.

Application example



Order No.	Adapter Ø	Version	T	L	Fig.
269037	4	Flat	0.4	30	
343700	4	Flat	0.8	30	
269038	4	Round	1.1	40	
269039	4	Round	1.1	60	
343710	4	Flat	0.8	30	
302750	6	Round	1.1	50	
302760	6	Round	1.5	50	
302800	6	Flat	1	50	1
302900	6	Flat	1	75	
302810	6	Flat	1	90-125	2
302910	6	Flat	1	115-150	
302300	12	Flat	1	75	3
302400	12	Flat	1	95	
302320	12	Flat	1	120-150	
302500	12	Flat	1.5	75	
302600	12	Flat	1.5	95	
302520	12	Flat	1.5	120-150	
302350	12	Round	2.5	80	4
302340	12	Round	3	80	
302510	12	Forked	1.5	75	5
302610	12	Forked	1.5	95	

## Columns with screw

### Description

Columns with threaded connection for mounting spring fingers or for use as a stop element.

### Material

Stainless steel.



### Application example



Order No.	Column Ø	Thread	Length
269042	4	M 4	30
269043	4	M 4	50
269044	4	M 4	75
368100	6	M 6	30
368120	6	M 8	30
368200	6	M 6	50
368220	6	M 8	50
368300	6	M 6	75
368400	6	M 6	100
368500	6	M 6	125
368505	6	M 6	150
368600	12	M 6	50
368620	12	M 8	50
368700	12	M 6	100
368720	12	M 8	100
368800	12	M 6	150
368820	12	M 8	150
368900	12	M 6	200
368920	12	M 8	200
368610	12	M 10	50
368710	12	M 10	100
368810	12	M 10	150
368910	12	M 10	200

M ...

Adapter plates for columns

**Description**

Adapter plates for columns with M6 threads (e.g. for spring fingers) for mounting on M8 and M10 hexagonal extension pieces, self-aligning pads, rest pins and M10 quick-change adapters mounts.

**Material**

Stainless steel.



Order No.	Hole	Overhang
353700	∅ 10	50
353800	∅ 10	72

Application example



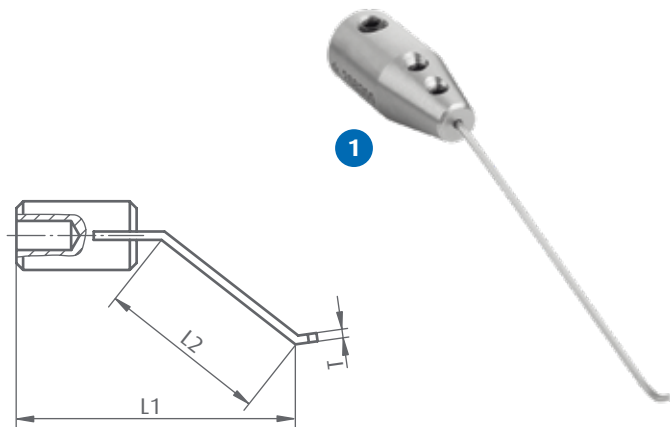
## Spring fingers with quick-change adapter

### Description

Spring finger with SWA 5 quick-change adapter for connecting to articulated arms.

### Material

Stainless steel.

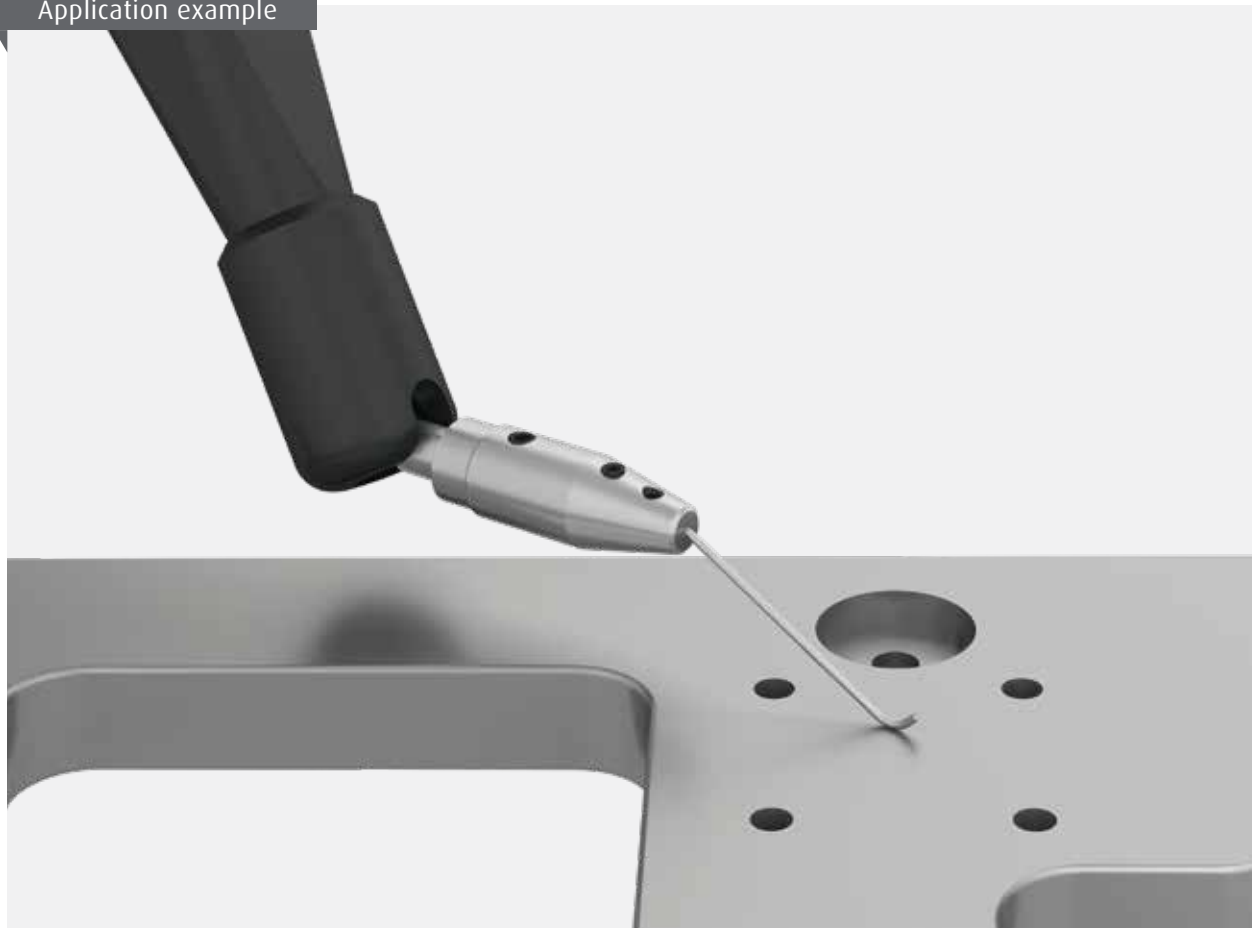


Order No.	Connection	T	L1	L2	Version	Fig.
269300	SWA 5	1.1	55	35	Round	
268300	SWA 5	1.1	70	50	Round	1

SWA 5

SWA 8

### Application example



Toggle clamps with support

Description

Toggle clamp with support and M10 thread.

Supplied with

Locknut.



Application example



Order No.	Overhang	Clamping range	Height
336300	32	0-20	100
336400	51	0-27	115

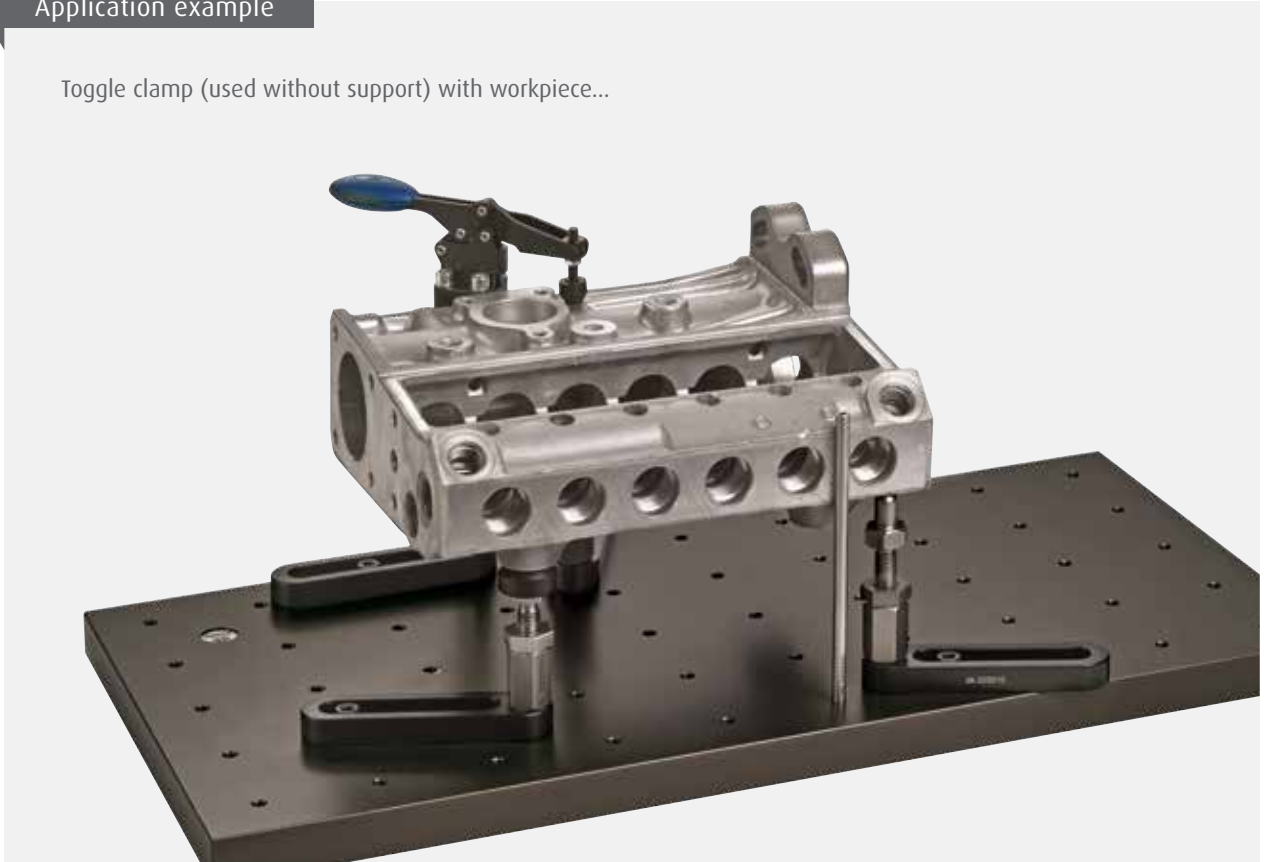
M 10

Application example



### Application example

Toggle clamp (used without support) with workpiece...



...and without workpiece



Parallel clamps

Description

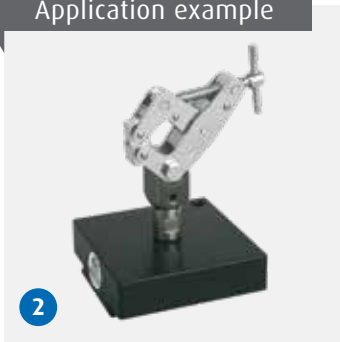
Parallel clamps with a maximum clamping range of 75 mm. The jaw blocks have 4 faces and are available in different versions - flat, with a prism for holding round workpieces or convex for holding workpieces that are highly sensitive to bending. The clamps are mounted on SWA 5 or SWA 8 quick-change adapters.

Material

Stainless steel/steel/aluminium.



Application example



Combined with an SWA 5 quick-change mount on an SWA 29 adapter... or on an articulated arm

SWA 5	SWA 8	SWA 39
-------	-------	--------

Order No.	Clamping range	Connection	Jaw faces	Version	Fig.
278800	0-25	SWA 5	3 flat, 1 long prism	Both jaws rotatable	1
278600	0-25	SWA 5	2 flat, 1 long prism, 1 convex	Both jaws rotatable	1
278400	0-25	SWA 8	3 flat, 1 long prism	Both jaws rotatable	1
334900	0-25	SWA 8	2 flat, 1 long prism, 1 convex	Both jaws rotatable	1
278500	0-25	SWA 39	3 flat, 1 long prism	Both jaws rotatable	2
279610	0-50	SWA 8	3 flat, 1 long prism	Both jaws rotatable	
279620	0-75	SWA 8	3 flat, 1 long prism	Both jaws rotatable	



## Parallel clamps with guide pin

### Description

Parallel clamp with guide pin fixed in lower jaw to secure the jaws against rotation. Mounted on SWA 5, SWA 8 or SWA 39 quick-change adapters.

### Material

Stainless steel/aluminium.

#### Application example



Order No.	Clamping range	Connection	Version	Fig.
279200	0–25	SWA 5	cross prism in lower jaw	
279210	0–25	SWA 8	cross prism in lower jaw	
279600	0–50	SWA 8	cross prism in lower jaw	1
279300	0–50	SWA 39	cross prism in lower jaw	2

SWA 5

SWA 8

SWA 39

#### Application example



Tension clamp

Description

Tension clamp for mounting on articulated arms. The tension clamp is designed for use with an articulated arm, the draw hook is pulled out by hand and hooked over a workpiece to provide tension. Connection with SWA 8 quick-change mount.

Material

Stainless steel.



Order No.	Connection	Size	Length	Hook travel	Tensile force (N)
376800	SWA 8	hook shaft Ø10	81	11	80

SWA 8

Prism with spring finger

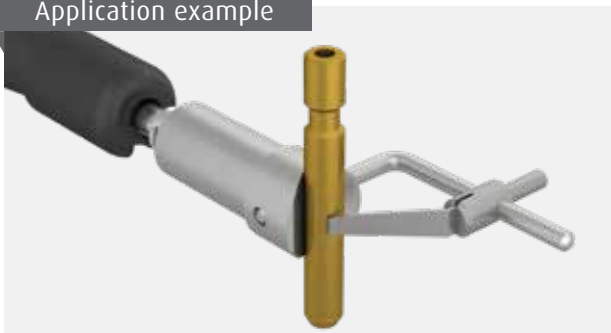
Description

120° prism on a column with a spring finger. Connection with SWA 8 quick-change mount.

Material

Stainless steel.

Application example



Order No.	Connection	Clamping range	Prism length	Height
285810	SWA 8	Ø 2–25	20	45

SWA 8

## Clips

### Description

Clip for fixating thin, rigid parts.  
Clamping with a ball-head screw. Connection with SWA 5 or SWA 8 quick-change mount.

### Material

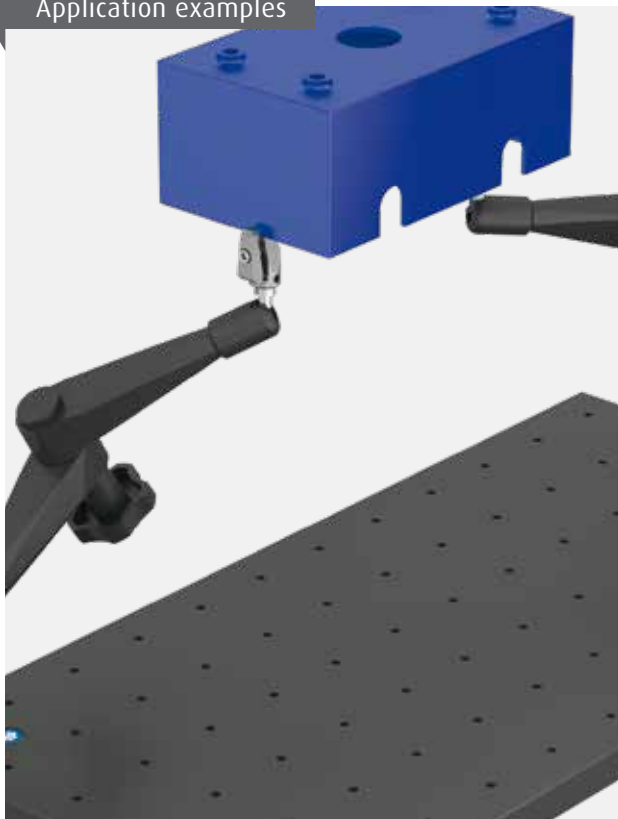
Steel.



Order No.	Connection	Jaw depth	Clamping width
302100	SWA 5	5	3
302000	SWA 8	5	3

SWA 5 SWA 8

### Application examples



Pairs of V-block halves

**Description**

V-block halves for T-slot. The clamping range is freely adjustable. With lateral slots and tapped holes for mounting a tensioning strap fixture or spring finger. Part 306500 with mounting hole for stops.

↳ See pages 43 and 46 for suitable stops.

**Material**

Hard-coated aluminium/steel.

**Supplied with**

Screws and T-slot nuts.



Order No.	Prism	Prism length	Height	Fig.
305500	120°	18	42	1
305700	120°	25	42	
306500	120°	40	52	

T-slot 6

Application example



## + Spring finger with mount

### Description

For quickly and easily holding parts.

### Supplied with

Adjustable spring finger (302810), column (368500) and column holder (272910).



Order No.	Clamping range
272940	Ø 40-120 Ø 40-120

↳ See pages 130 and 133 for more spring fingers.

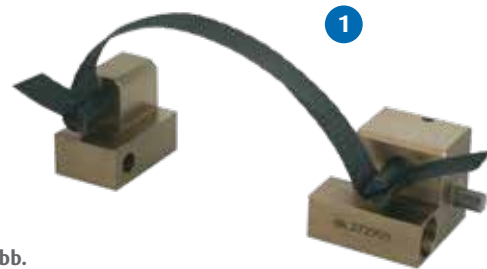
## + Tensioning strap fixture

### Description

Ideal for clamping irregularly shaped parts.

### Supplied with

M5 fastening screw, operating tools and 5 m tensioning strap.



Order No.	Clamping range	Description	Abb.
272900	From Ø 40	Standard	1
272850	From Ø 40	Extra strong	
272855	Adapter for mounting 272850 on T-slots 6		
272902	Adjustable torque wrench		

**Tailstocks**

**Description**

Pair of tailstocks with one fixed and one movable centre. The movable centre is spring-loaded and can be locked. For location in a T-slot.

**Material**

Hard-coated aluminium/steel.

**Supplied with**

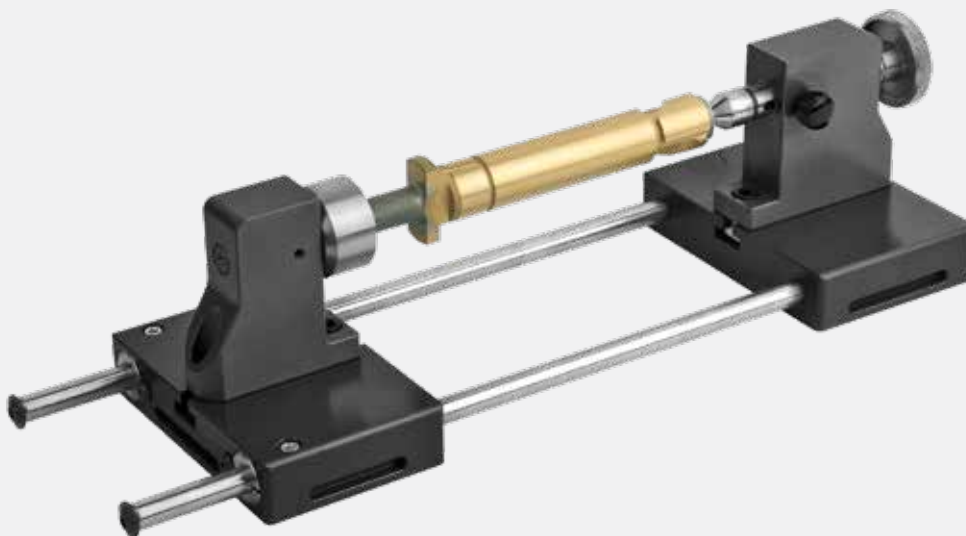
T-slot nuts and  $\varnothing 15 / 60^\circ$  centres.



Order No.	Centre height	Length	Width	Height	Weight
306000	50	150	25	75	0.72

T-Nut 6

Application example



## + Adjustable baseplate

### Description

Mounting plate with T-slot (6 mm) for the mounting tailstocks and/or other equipment. Suitable for transmitted light measurements on projectors. Infinitely variable adjustment on guide shafts with lock. Plate can be fixated with claw clamps.

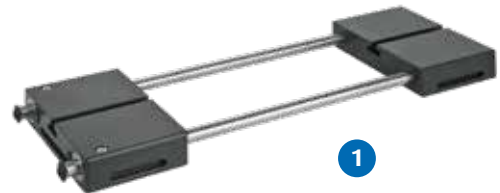
↳ See page 271 for claw clamps.

### Material

Hard-coated aluminium/steel.

### Extension

0–210 mm.



Order No.	Length	Width	Height	Version
262510	370	120	25	1

T-Nut 6

## + Fixed centres

### Description

One pair of fixed tailstock centres.

### Material

Hardened steel.



Order No.	Centre angle	Diameter
306100	60°	Ø15–30 mm

## + Female centres

### Description

### Material

Hardened steel.



Order No.	Centre angle	Diameter
306320	90°	Ø3–15 mm
306325	90°	Ø15–30 mm

## Suction cups

### Description

Suction units with removable support pin.

### Material

Silicone/brass.

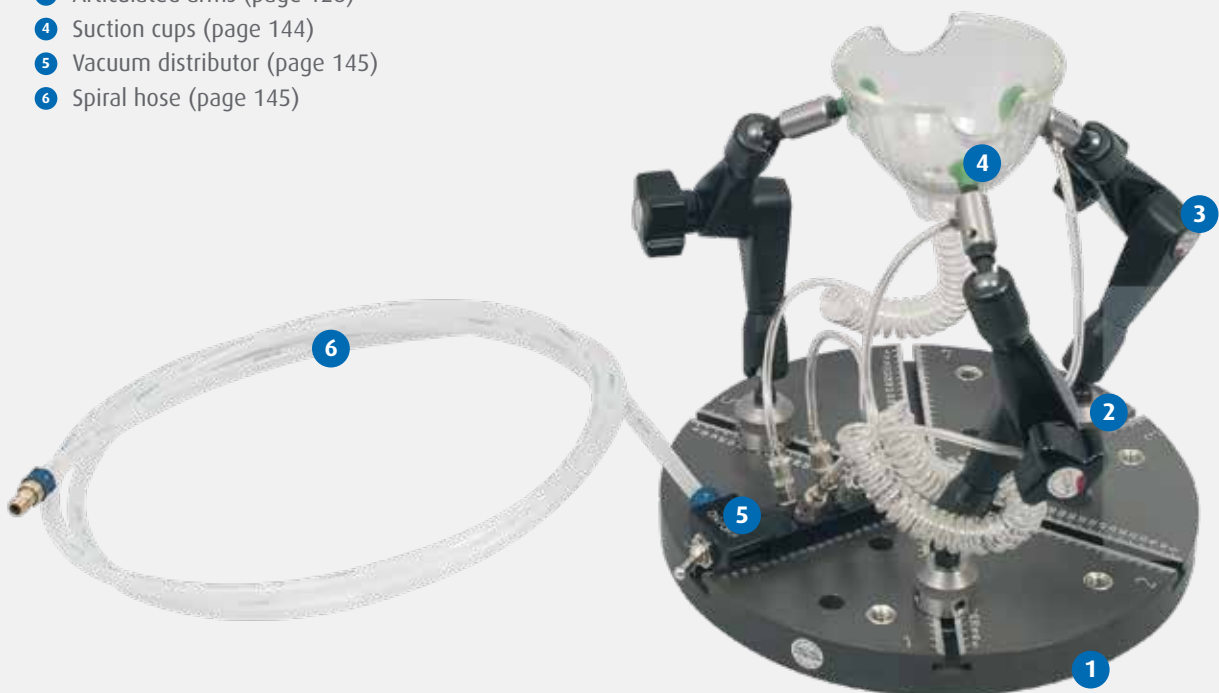
↪ See page 145 for suitable suction cup adapters.



Order No.	Cup Ø	Connection thread
295800	12	M 5
295900	18	M 5
296000	25	1/8
296100	34	1/8

### Application example

- 1 Round T-slot baseplate (page 104)
- 2 Satellite mount with T-slot nut (page 109)
- 3 Articulated arms (page 128)
- 4 Suction cups (page 144)
- 5 Vacuum distributor (page 145)
- 6 Spiral hose (page 145)





## + Spiral hose

### Description

Transparent spiral hose with quick lock (D 5) and M5 connection thread.



Order No.	Length (relaxed)	Length max.	ID
293600	350	1000	2

## + Vacuum distributor

### Description

Multi-port vacuum distributor with quick lock couplings (D 5) and 1/8" connection line to vacuum pump. ON/OFF switch with rapid air vent.

### Material

Aluminium/steel.



Order No.	No. of ports	Supplied with
293800	6	Connection line

T-Nut 6

## + Suction cup adapter

### Description

SWA 5 mount for suction cups. Connection for M5 spiral hose.

### Material

Steel/stainless steel.



Order No.	Version
292700	For cups with M 5 mount
292800	For cups with 1/8" mount

SWA 5

**Vacuum pumps**

**Description**

Dry-running rotary-vane vacuum pumps. Absolutely oil-free. Mains voltage 220–240 V. Mounted on rubber vibration-damping elements, with ON/OFF switch in power cable and 1/8" port for connecting vacuum outlet.

Order No.	Nom. suction capacity	Final pressure	Nom. motor power	Noise level
298510	4.1 m <sup>3</sup> /h	150 mbar	0.18 kW	58 dB (A)
298610	8.0 m <sup>3</sup> /h	150 mbar	0.31 kW	58 dB (A)

**Vacuum pumps for compressed air operation**

**Description**

Compressed air powered vacuum pump with connection hose and ON/OFF switch.

**Material**

Aluminium.



Order No.	Nom. suction capacity	Operating pressure	Air consumption
298700	7.4 m <sup>3</sup> /h	5 bar	30 l / min

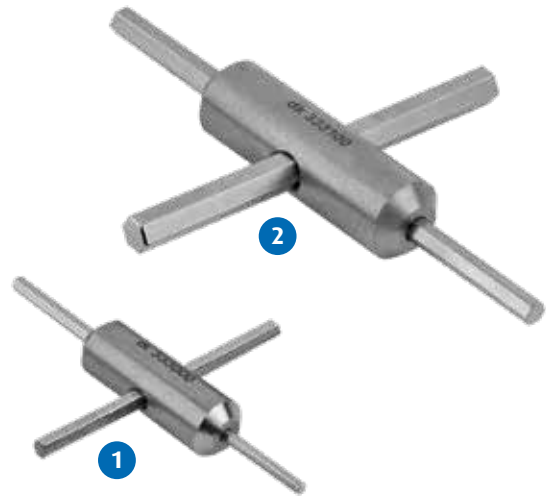
## + Four-way hexagon key

### Description

Practical and compact cross design with 3 key sizes per tool. Covers all hexagon socket sizes used in the Spannfix and Schienenfix ranges.

### Material

Steel/stainless steel.



Order No.	Size	Fig.
333000	2 / 2.5 / 3	1
333100	4 / 5 / 6	2

**Quick-action clamp for T-slot**

**Description**

SWA 39 quick-action clamp for direct fastening on T-slot plates. Mounted on a 12 mm high intermediate plate.

**Material**

Hard-coated aluminium/stainless steel.

**Supplied with**

T-slot nut and fastening screw.



Order No.	Height
285300	23.5

**SWA 39**  
**T-Nut 6**



**Information**

The quick-action clamp for T-slot 6 from the SPANNFIX system opens up the entire world of the dk modular system with all manner of structural, adjustment and clamping elements that we present in the SWA 39 range from page 16.

Take a look at the product video on our home page. Simply scan the QR code or click the link below to watch now:

 [www.dk-fixiersysteme.de/technology/modular\\_system](http://www.dk-fixiersysteme.de/technology/modular_system)

## Application examples



The SWA39 elements can form a support in the context of the fixation of large parts, for example by means of the flexibly adjustable negative form program NADELFIX.

Especially in combination with standard clamping elements such as vice and chucks, the system offers a rapid and extremely flexible, exactly reproducible positioning of clamping elements by means of the quick-action clamping clamp for T-slot 6.

The result is a zero-point clamping setup for workpieces which can be dismantled and identically reassembled.



**SPANNFIX PRO basic set**

**Description**

Set with supports, extension pieces and stops. A baseplate with T-slots and mounting holes provides the basis. Available in sizes 500 x 250 mm or 600 x 300 mm.



**Ordering information**

When ordering, let us know the thread or T-slot size on your measuring equipment.

**Set versions**

Order No.	Description
399710	Spannfix PRO basic set "3"
399720	Spannfix PRO basic set "4"

**Set contents**

Order No.	Description	Set "3"	Set "4"
280500	Baseplate with T-slot, 500 x 250 mm	1	
280800	Baseplate with T-slot, 600 x 300 mm		1
see right	Claw clamps for Spannfix baseplates Order numbers 281406, 281408, 281410, 281412 for fastening in M6, M8, M10 or M12	1	1
290700	Satellite mount M 10	2	2
322200	25 mm extension	1	1
322300	35 mm extension	2	2
322400	50 mm extension	1	1
322500	60 mm extension	1	1
288805	150 mm columns with T-slot nuts	2	2
288905	200 mm columns with T-slot nuts	1	1
286700	100 mm arm	2	2
286600	150 mm arm	1	1
319300	Support pins with 90° point	3	3
319400	R4 x 20 mm support pins	3	3
287200	Pair of V-blocks	1	1
287500	Adjustable stop	1	1
323000	Self-aligning pads	1	1
322600	Jack screws with cone point	1	1
322700	Jack screws with ball-end	1	1
302300	75 mm spring finger	2	2
302400	95 mm spring finger	1	1

## SPANNFIX PRO expansion set

### Description

Expansion set with diverse support and clamping modules for the reproducible fixation of test parts.



### Set versions

Order No.	Description
399730	Spannfix PRO expansion set

### Set contents

Order No.	Description	Quantity
325100	Intermediate plate	1
297000	MU/SWA 8 articulated arm	1
322010	Base rails	2
326400	T-slot nuts	2
322200	25 mm extension	2
322300	35 mm extension	2
322400	50 mm extension	2
288805	150 mm columns with T-slot nuts	2
288905	200 mm columns with T-slot nuts	2
286700	100 mm arm	2
286600	150 mm arm	1
287200	Pair of V-blocks	1
303200	SWA 8 adapter for arm	1
303300	M 10 adapter for arm	1
322700	Jack screws with ball-end	2
329500	Quick-change mounts	2
303600	Ø15 mm centre for quick-change mount	1
303700	Ø25 mm centre for quick-change mount	1
303800	Ø40 mm centre for quick-change mount	1
323500	8 mm prism support for quick-change mount	1
323400	40 mm prism support for quick-change mount	1
302300	75 mm spring finger	2
302400	95 mm spring finger	1
368710	100 mm columns	2
368810	150 mm columns	2
368910	200 mm columns	2
278400	Parallel clamp	1
279600	Parallel clamp with guide pin	1

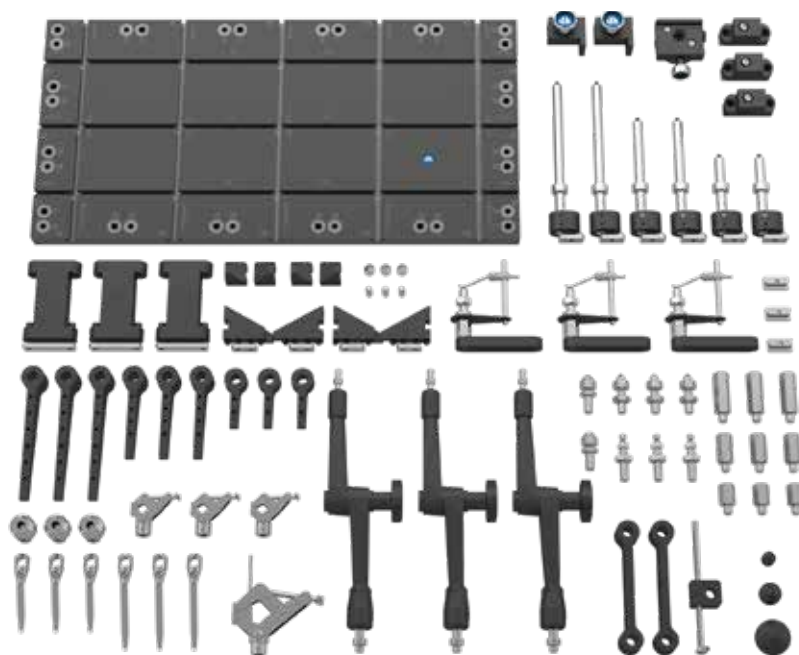
**SPANNFIX PRO complete set**

**Description**

Set that includes articulated arms and parallel clamps for quick and flexible positioning of various test parts. Structural and clamping elements are mounted onto a 600 mm x 300 mm Spannfix baseplate. Various support and clamping modules can be used to achieve reproducible fixation. The high locking forces possible on the articulated arms enable even heavy parts to be held securely.

**Ordering information**

When ordering, let us know the thread or T-slot size on your measuring equipment.



**Set versions**

Order No.	Description
399700	Spannfix PRO complete set

**Set contents**

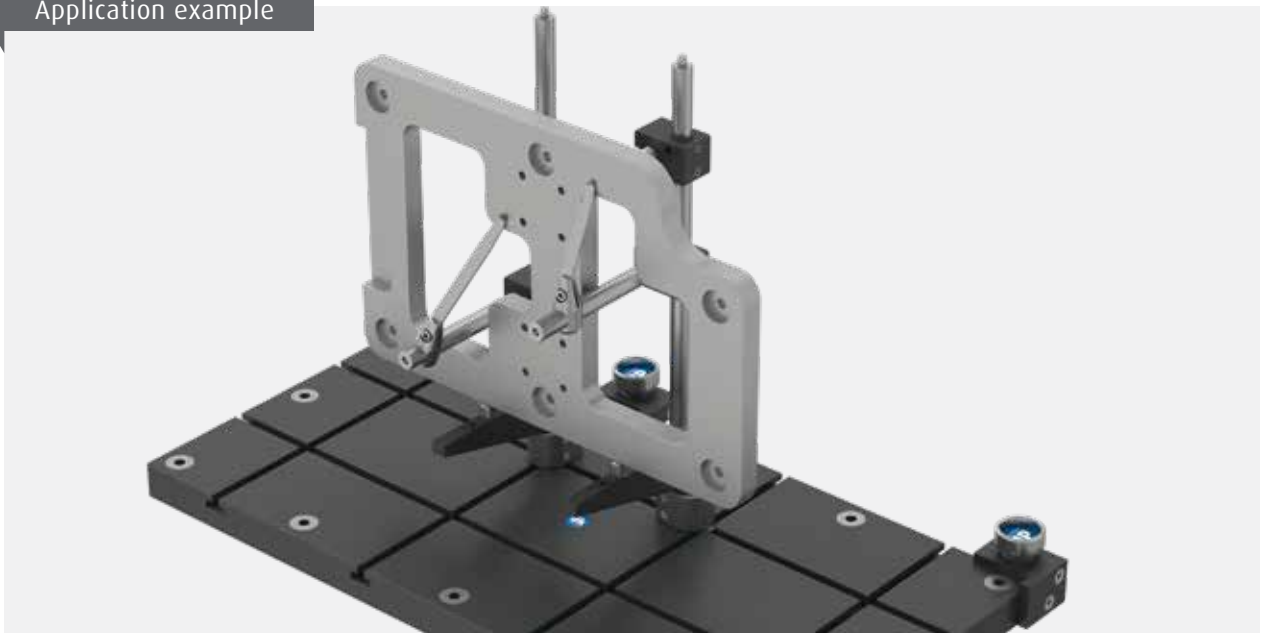
Order No.	Description	Quantity
280800	600 x 300 mm baseplate with T-slots	1
288605	100 mm columns	2
288805	150 mm columns with T-slot nuts	3
288905	200 mm columns with T-slot nuts	2
see right	Claw clamps for Spannfix baseplates Order numbers 281406, 281408, 281410, 281412 for fastening in M6, M8, M10 or M12	1
285300	Quick-action clamp for T-slot	1
320500	Side clamp with draw-down jaw	3
305500	Pair of V-block halves	2
324100	100 mm extension pieces	3
286700	100 mm arm	3



## Set contents

Order No.	Description	Quantity
286600	150 mm arm	3
286800	60 mm arm for column	3
287200	Pairs of V-block halves	2
322005	Screw jack set with spring finger	3
326400	T-slot nuts	3
322200	25 mm extension	3
322300	35 mm extension	3
322400	50 mm extension	3
322600	Jack screws with cone point	3
329500	M 10/SWA 8 quick-change mount	3
323000	M 10 self-aligning pads	2
287500	Adjustable stop	1
287100	Bridge support, centre distance 125 mm	2
302500	75 mm spring finger	3
302600	95 mm spring finger	3
29700	MU/SWA 8 articulated arm	3
290700	M 10 satellite mounts	3
279600	Parallel clamp with guide pin	1
278400	Parallel clamps	3
303600	15 mm centre	1
303700	25 mm centre	1
303800	40 mm centre	1
319500	R4 x 20 mm support pins	3
319300	Support pins with 90° point	3

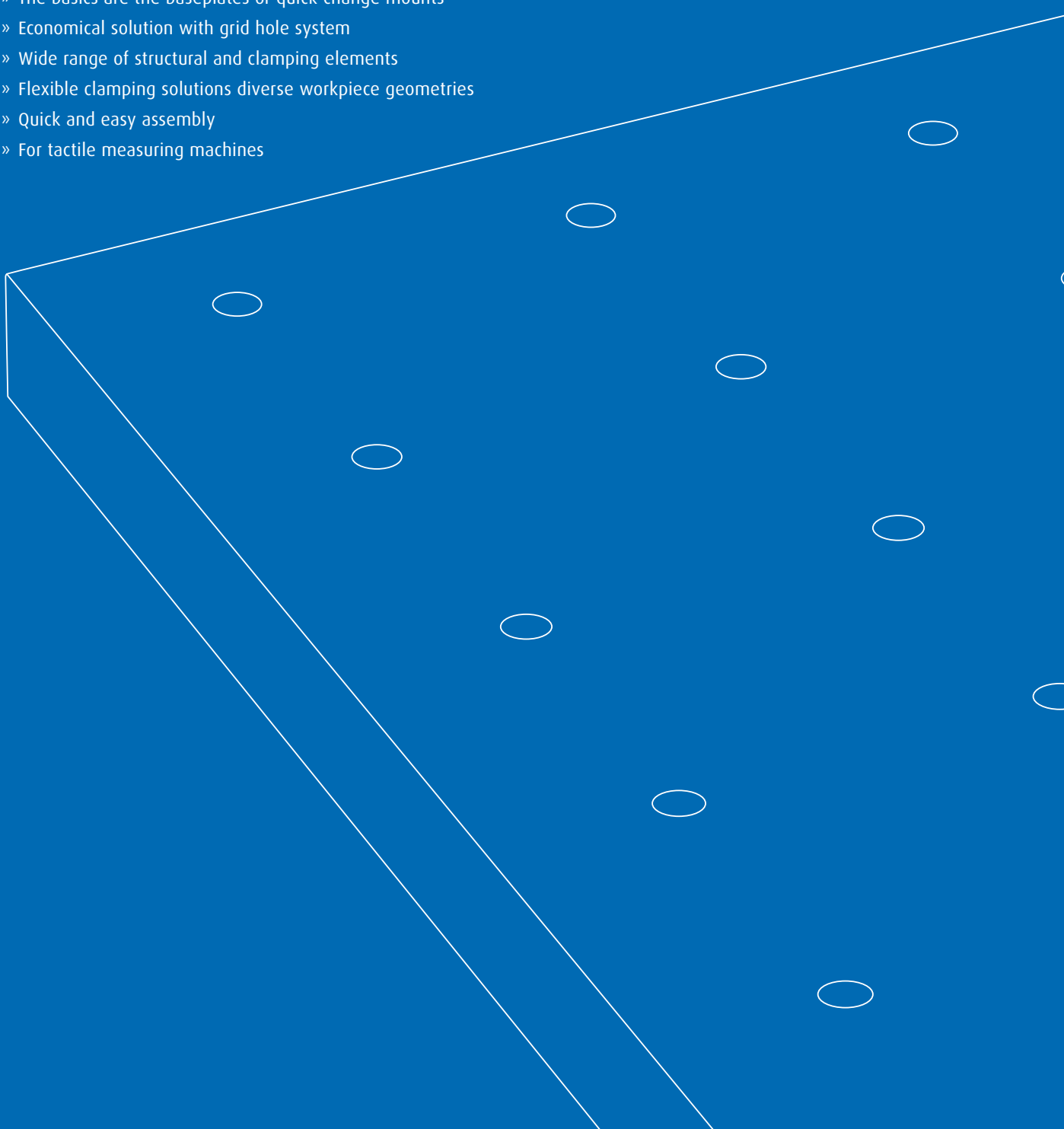
## Application example



**SPANNFIX** ECO

## *Modular clamping elements for tactile measuring*

- » The basics are the baseplates or quick-change mounts
- » Economical solution with grid hole system
- » Wide range of structural and clamping elements
- » Flexible clamping solutions diverse workpiece geometries
- » Quick and easy assembly
- » For tactile measuring machines



Basic elements  
+ accessories



Baseplate with tapped holes

Page 158



Intermediate plates

Page 159



Structural elements  
+ accessories



Base rail M 10

Page 161



M 10 XL base rail

Page 162



Hexagonal extensions M 8 and M 10

Page 163



Self-aligning pads M 10

Page 164



Jack screws M 10

Page 164



Quick-change adapter M 10

Page 165



Screw jack set with spring finger

Page 166



Adjustable stop

Page 167



Thread reducer

Page 168



Columns with screw

Page 169



Articulated arms

Page 170

Clamping elements  
+ accessories



Spring fingers

Page 172



Columns with screw

Page 173



Adapter plates for columns

Page 174



Spring finger with quick-change adapter

Page 175



Toggle clamps with support

Page 176



Parallel clamps

Page 178



Parallel clamps with guide pin

Page 179



Tension clamp

Page 180



Prism with spring finger

Page 180



Clips

Page 181



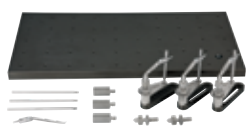
SWA 39 connections



Quick-action clamp with fastening screw

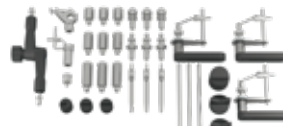
Page 182

Sets



Spannfix ECO basic set

Page 184



Spannfix ECO expansion set

Page 185



Spannfix ECO complete set

Page 186

# Reproducible fixtures through grid holes and base rails

The SPANNFIX ECO is the simpler, more economical alternative to the PRO version with fewer and simplified modules on a baseplate with tapped holes in a standard 50 mm grid. The base rails enable any X/Y position can be easily achieved. Because there are no lateral or angular scales as by the PRO version, repeat constructions of exactly the same fixture are more difficult, but are still possible.

**Basic elements**

- 1 Baseplate with tapped holes (page 158)




Intermediate plates and accessories (pages 159-160)




**Structural elements**


- 2 M 10 XL base rail (pages 161-162)




2 + 3 + 4 or 2 + 3 + 3 + 5 + 6 + 7 also available as screw jack set with spring finger (page 166).



- 3 M8 or M10 hexagonal extensions (page 163)



- 4 Screw jacks (page 164)  
Other accessories (pages 164-166)





### Clamping elements

- 5 Adapter plate for columns (page 174)



- 6 Columns with screw (page 173)



- 7 Spring fingers (page 172)



## FAST REASSEMBLY LIFELONG

The basic principle of all dk fixating systems. The compatibility of the dk programs makes the utility value perfect.

The wider range of additional elements included in the PRO system can also be used directly, or with adapters together with the *SPANNFIX ECO* elements shown here. Overall, a much better and quicker solution for the safe and repeatable fixation of test pieces than specially designed and manufactured single-use fixtures.

Here, too, we have such an extensive range of basic, structural, support and clamping elements that, together with the other dk programs, they make up such a complete world of fixation elements that the user only requires additional, customer-specific fabrications for absolutely special parts or very specific processes. Of course, we can also develop and implement these together with you.

Baseplates with tapped holes

Description

Baseplate with M6 holes arranged in a grid pattern.

Material

Hard-coated aluminium.

☞ Custom-made versions available on request.  
See pages 184 to 187  
for complete sets with fixture elements.



Order No.	Dimensions	Grid	Thread	Weight
395020	300 x 300 x 20	50	M 6	5.0
395030	500 x 250 x 20	50	M 6	7.4
395040	600 x 300 x 20	50	M 6	10.6
395050	800 x 400 x 20	50	M 6	17,6
2999XX	to customer specs.	to customer specs.	to customer specs.	

M 6

Application example



## Intermediate plates

### Description

T-slot plates for mounting on baseplates with T-slots or M6 tapped holes. For X/Y positioning.

### Material

Hard-coated aluminium.

### Supplied with

T-slot nuts.



Order No.	No. of slots	Length	Width	Height	Weight
325000	2	117	117	20	0.71
325100	3	117	117	20	0.68

T-Nut 6  
T-Nut 6  
M 6

## Accessories

### + Hand grip

#### Description

Grip for mounting in a T-slot or M6 hole ease carrying the baseplates.

#### Contents

1 set of 2 grips and fasteners.



Order No.	Length	Height
328500	150	45

T-Nut 6  
M 6

Accessories

**+** Plate clamping claws with stop

**Description**

A set of clamping claws for the 20 mm thick dk grid hole plates. The claws are screwed onto the measuring machine table. Check the table thread sizes before ordering. These elements provide a stop for repeat positioning accuracy while simultaneously securely clamping the dk baseplates.



Order No.	For plate thickness	Thread
281436	20	M 6
281438	20	M 8
281430	20	M 10
281432	20	M 12

Application example





## M10 base rail

### Description

Adjustable base rail with slot and M10 mounting thread for screwing on columns and articulated arms.

### Material

Hard-coated aluminium.

### Supplied with

M6 screw for securing to the baseplate.



Order No.	Slot width	Adjustment range	Length	Width	Height
322010	6	60	105	25	12

M 10	M 10
M ...	T-Nut

### Application example



M 10 XL base rail

Description

Large and extremely adjustable base rail with slot and M10 mounting thread for screwing on columns and articulated arms. Also has 4 holes for fastening e.g. the quick-action clamps 285206 or vices 270860 and 282110 as well as the users own elements.



Material

Hard-coated aluminium.

Order No.	Slot width	Adjustment range	Length	Width	Height
397012	12.5	80	150	50	20
397013	12.5	130	200	50	20

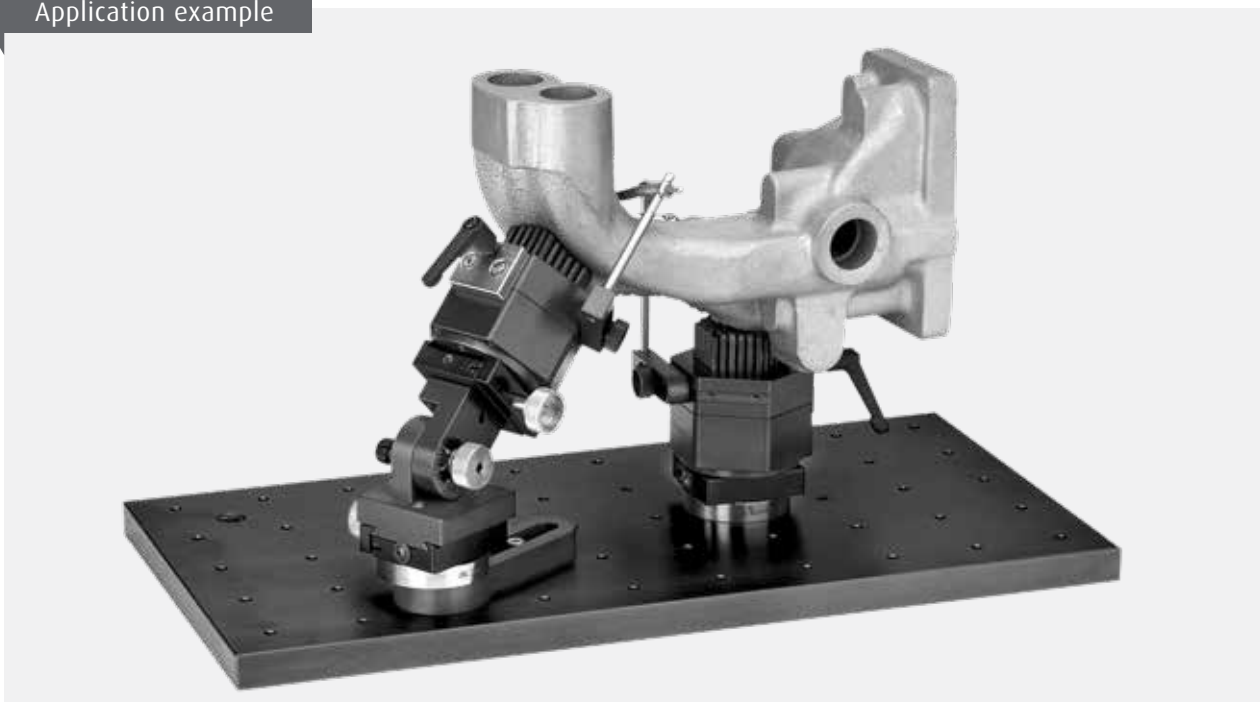


Fastening accessories



Order No.	Description	Version
397014	Screw with washer	M6 for dk standard plates
397015	Screw with washer	M 8
397016	Screw with washer	M 10
397017	Screw with washer	M 12

Application example



## M8 and M10 hexagonal extensions

### Description

Hexagonal extension pieces with male thread one end and female thread other end. For screwing on to base rails and, with a thread reducer directly on to dk baseplates. Screw together to increase the height. Width across flats 17 mm.

### Material

Stainless steel.

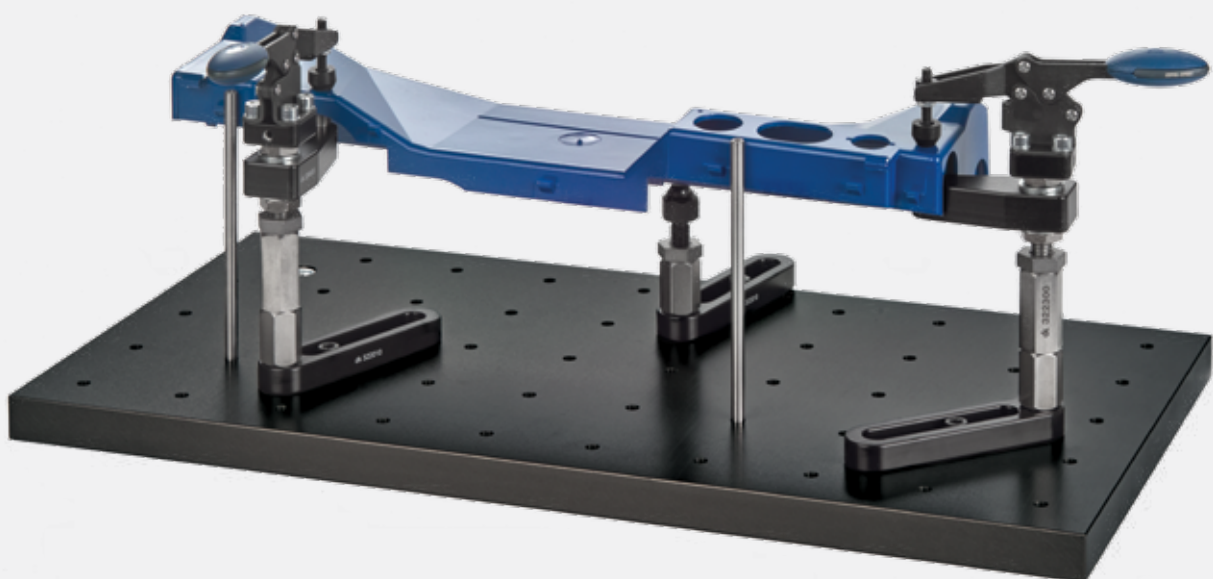


Order No.	Male thread	Female thread	Length
304100	M 8	M 8	50
304200	M 8	M 8	100
322200	M 10	M 10	25
322300	M 10	M 10	35
322400	M 10	M 10	50
304400	M 10	M 10	100
253500	M 10	M 10	150

M 8

M 10

### Application example



### Self-aligning pads M10

**Description**

Support with flattened, swivel ball to compensate for surface irregularities. Can be screwed onto hexagonal extension pieces or directly into base rails.

**Material**

Stainless steel/black oxidised steel.

**Supplied with**

Locknut.



Order No.	Support	Swivel range	Adjustment range	Length
323000	Ø 8	± 15°	15	46

M 10

### Screw jacks M10

**Description**

Height adjustable supports for centring and supporting test parts.

**Material**

Stainless steel.

**Supplied with**

Locknut.



Order No.	Version	Adjustment range	Length	Fig.
322600	With 90° point, Ø10	15	50	1
322700	With R5 mm ball end	25	63	2

M 10

## Quick-change adapter M 10

### Description

Quick-change adapter M 10 for SWA 5 / SWA 8 modules.

### Material

Stainless steel.

### Supplied with

Locknut.



Order No.	Version	Adjustment range	Length	Fig.
329400	SWA 5	25	55	
329500	SWA 8	25	57	1

SWA 5	SWA 8
M 10	M 10

## Accessories

### + Centre points

#### Description

90° centre points with SWA 8 quick-change mount.

#### Material

Hard-coated aluminium.

Order No.	Diameter	Height	Fig.
303600	15	20	1
303700	25	20	2
303800	40	24	3

SWA 8



### + Prism supports

#### Description

120° prism supports with SWA 8 quick-change mount.

#### Material

Hard-coated aluminium.

Order No.	Clamping range	Prism length	Connection	Height	Fig.
323500	Ø 2-60	8	SWA 8	35	1
323400	Ø 2-60	40	SWA 8	33	2

SWA 8



**+ Flat supports**

**Description**

Flat supports in various versions: flat face, straight step and prism step. With SWA 8 quick-change mounts.

**Material**

Hard-coated aluminium.



Application example



Order No.	Version	Diameter	Height	Step height	Fig.
303805	Flat face	25	20		1
303810	Straight step	25	20	5	2
303815	Prism step	25	20	5	3

SWA 8

**Screw jack set with spring finger**

**Description**

Adjustable base rail with support and spring finger. The support height is adjustable.

**Material**

Hard-coated aluminium/stainless steel.

**Supplied with**

Base rail (322010), extension piece (322200), jack screw (322700), adapter plate for columns (353700), column with screw (368300), spring finger (302800), locknut and fastening screw.

*See T-slot nuts on page 27 for fastening the base rail in a T-slot.*



Order No.	Adjustment range	Length	Width	Support height
322005	60	105	25	80-90

M 6 T-Nut

## Adjustable stop

### Description

Adjustable stop for mounting on  $\varnothing 12$  mm columns. Effective length of the stop ca. 130 mm to centre of column.

### Material

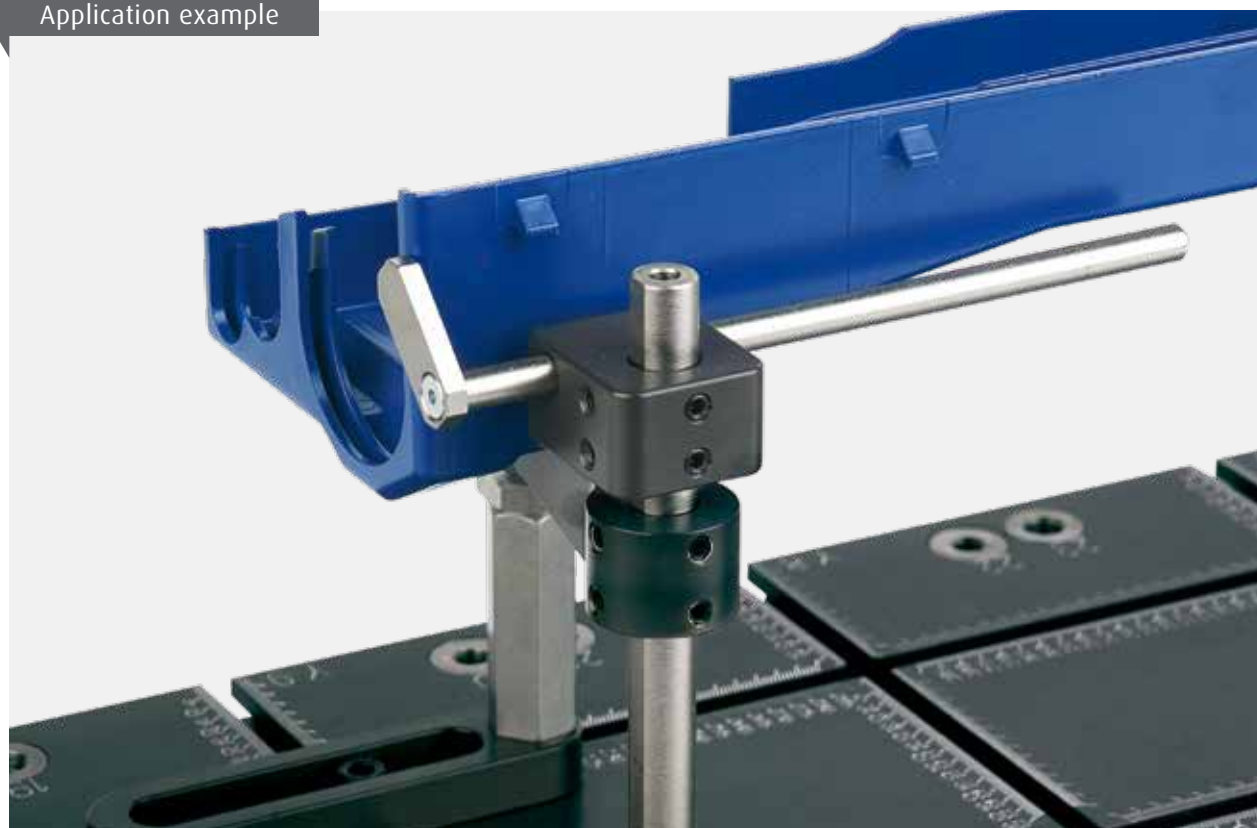
Hard-coated aluminium/nickel-plated steel.



Order No.	Length	Width	Height
287500	35	30	20

D 12

### Application example



**Thread reducer**

**Description**

Thread reducer for connecting different thread sizes e.g. columns, extension pieces, articulated arms, supports etc.

**Material**

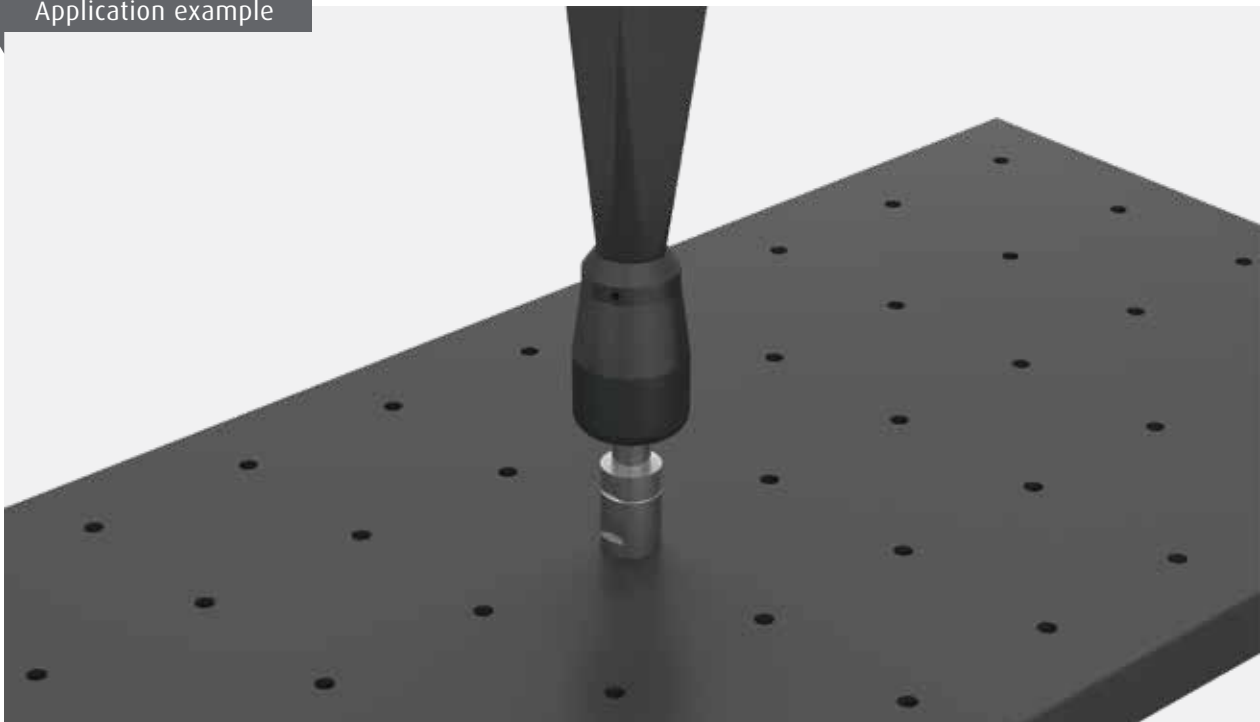
Stainless steel.



Order No.	Male thread	Female thread
275030	M 4	M 8
369000	M 5	M 6
269500	M 5	M 8
275000	M 6	M 8
275010	M 6	M 10
297800	M 8	M 10
275110	M 10	M 6
275100	M 10	M 8
275200	M 12	M 8
275300	M 12	M 10

M ...

**Application example**





## Columns with screw

### Description

Columns with threaded connection for mounting spring fingers or for use as a stop element.

### Material

Stainless steel.



### Application example



Order No.	Column Ø	Thread	Length
269042	4	M 4	30
269043	4	M 4	50
269044	4	M 4	75
368100	6	M 6	30
368120	6	M 8	30
368200	6	M 6	50
368220	6	M 8	50
368300	6	M 6	75
368400	6	M 6	100
368500	6	M 6	125
368505	6	M 6	150
368600	12	M 6	50
368620	12	M 8	50
368700	12	M 6	100
368720	12	M 8	100
368800	12	M 6	150
368820	12	M 8	150
368900	12	M 6	200
368920	12	M 8	200
368610	12	M 10	50
368710	12	M 10	100
368810	12	M 10	150
368910	12	M 10	200

M ...

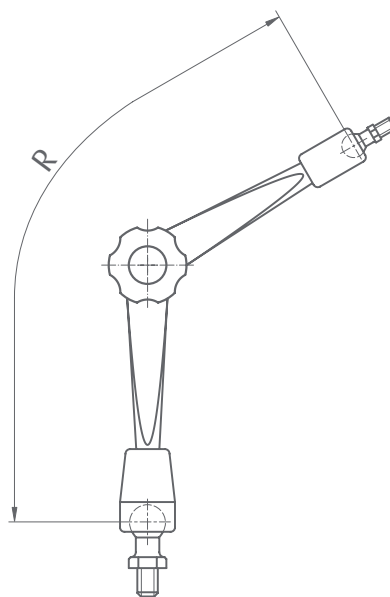
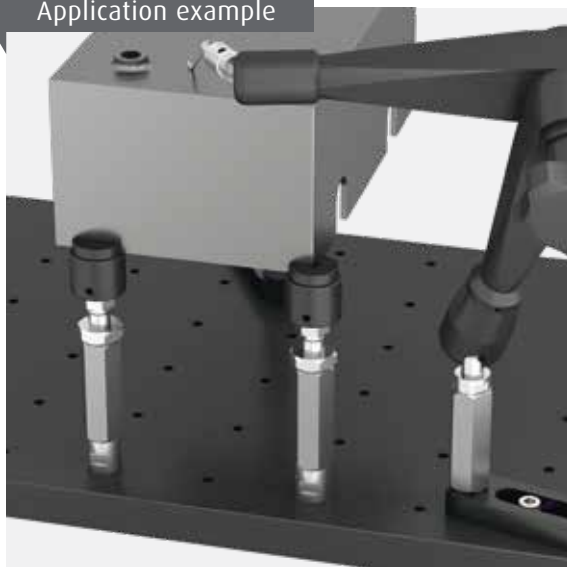
Articulated arms

Description

Progressive clamping articulated arms with a connection screw in the base and a quick-change adapter on the arm. Mechanical articulated arm. Central locking. Holding force at right angles 100 N (type MU) or 80 N (type SU).



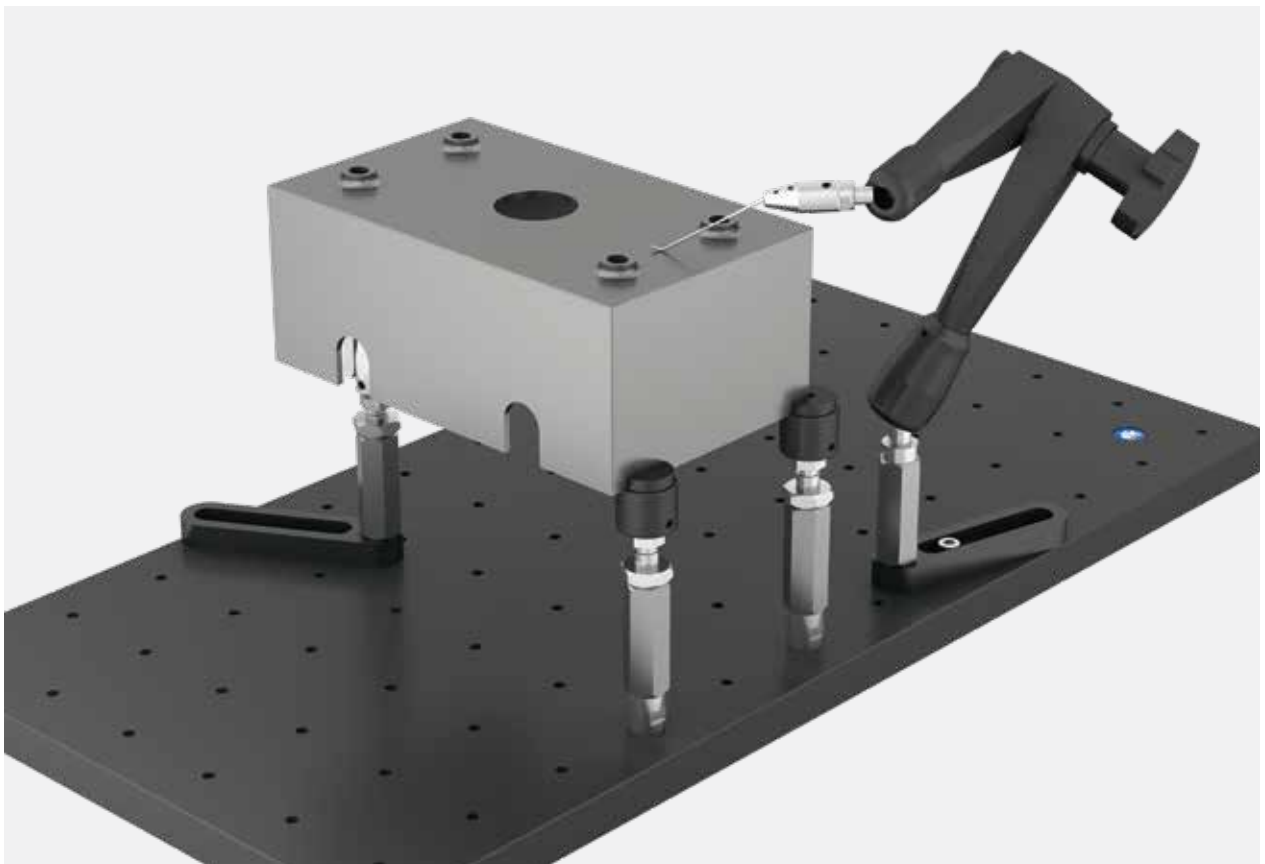
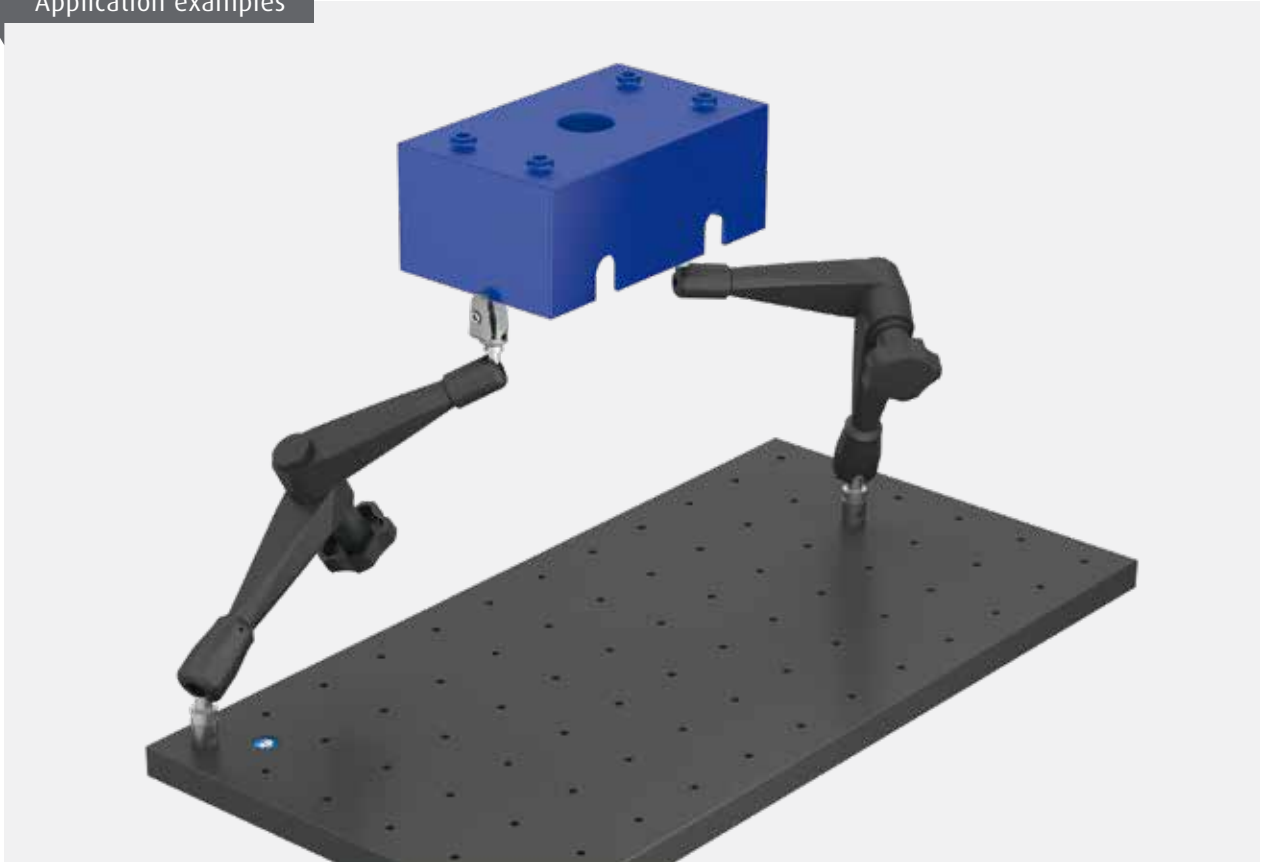
Application example



Order No.	Model	Thread	Adapter	Action range (R)
296800	SU	M 8	SWA 5	160
296700	SU	M 8	SWA 8	160
296900	MU	M 10	SWA 5	280
297000	MU	M 10	SWA 8	280



Application examples



Spring fingers

Description

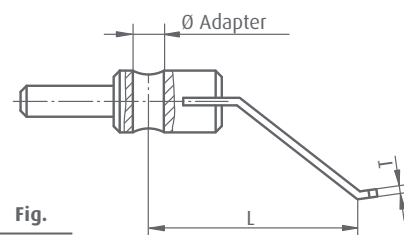
For the simple and quick holding down of workpieces.  
Self-locking on round columns due to the applied tension by manually pressing down.

Material

Stainless steel.



Application example



Order No.	Adapter Ø	Version	T	L	Fig.
269037	4	Flat	0.4	30	
343700	4	Flat	0.8	30	
269038	4	Round	1.1	40	
269039	4	Round	1.1	60	
343710	4	Flat	0.8	30	
302750	6	Round	1.1	50	
302760	6	Round	1.5	50	
302800	6	Flat	1	50	1
302900	6	Flat	1	75	
302810	6	Flat	1	90-125	2
302910	6	Flat	1	115-150	
302300	12	Flat	1	75	3
302400	12	Flat	1	95	
302320	12	Flat	1	120-150	
302500	12	Flat	1.5	75	
302600	12	Flat	1.5	95	
302520	12	Flat	1.5	120-150	
302350	12	Round	2.5	80	4
302340	12	Round	3	80	
302510	12	Forked	1.5	75	5
302610	12	Forked	1.5	95	

## Columns with screw

### Description

Columns with threaded connection for mounting spring fingers or for use as a stop element.

### Material

Stainless steel.



### Application example



Order No.	Column Ø	Thread	Length
269042	4	M 4	30
269043	4	M 4	50
269044	4	M 4	75
368100	6	M 6	30
368120	6	M 8	30
368200	6	M 6	50
368220	6	M 8	50
368300	6	M 6	75
368400	6	M 6	100
368500	6	M 6	125
368505	6	M 6	150
368600	12	M 6	50
368620	12	M 8	50
368700	12	M 6	100
368720	12	M 8	100
368800	12	M 6	150
368820	12	M 8	150
368900	12	M 6	200
368920	12	M 8	200
368610	12	M 10	50
368710	12	M 10	100
368810	12	M 10	150
368910	12	M 10	200

M ...

Adapter plates for columns

**Description**

Adapter plates for columns with M6 threads (e.g. for spring fingers) for mounting on M8 and M10 hexagonal extension pieces, self-aligning pads, rest pins and M10 quick-change adapters.

**Material**

Stainless steel.



Order No.	Hole	Overhang
353700	Ø 10	50
353800	Ø 10	72

Application example



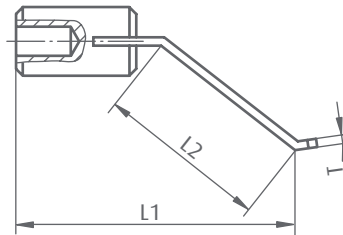
## Spring fingers with quick-change adapter

### Description

Spring finger with SWA 5 quick-change mount for fastening to articulated arms.

### Material

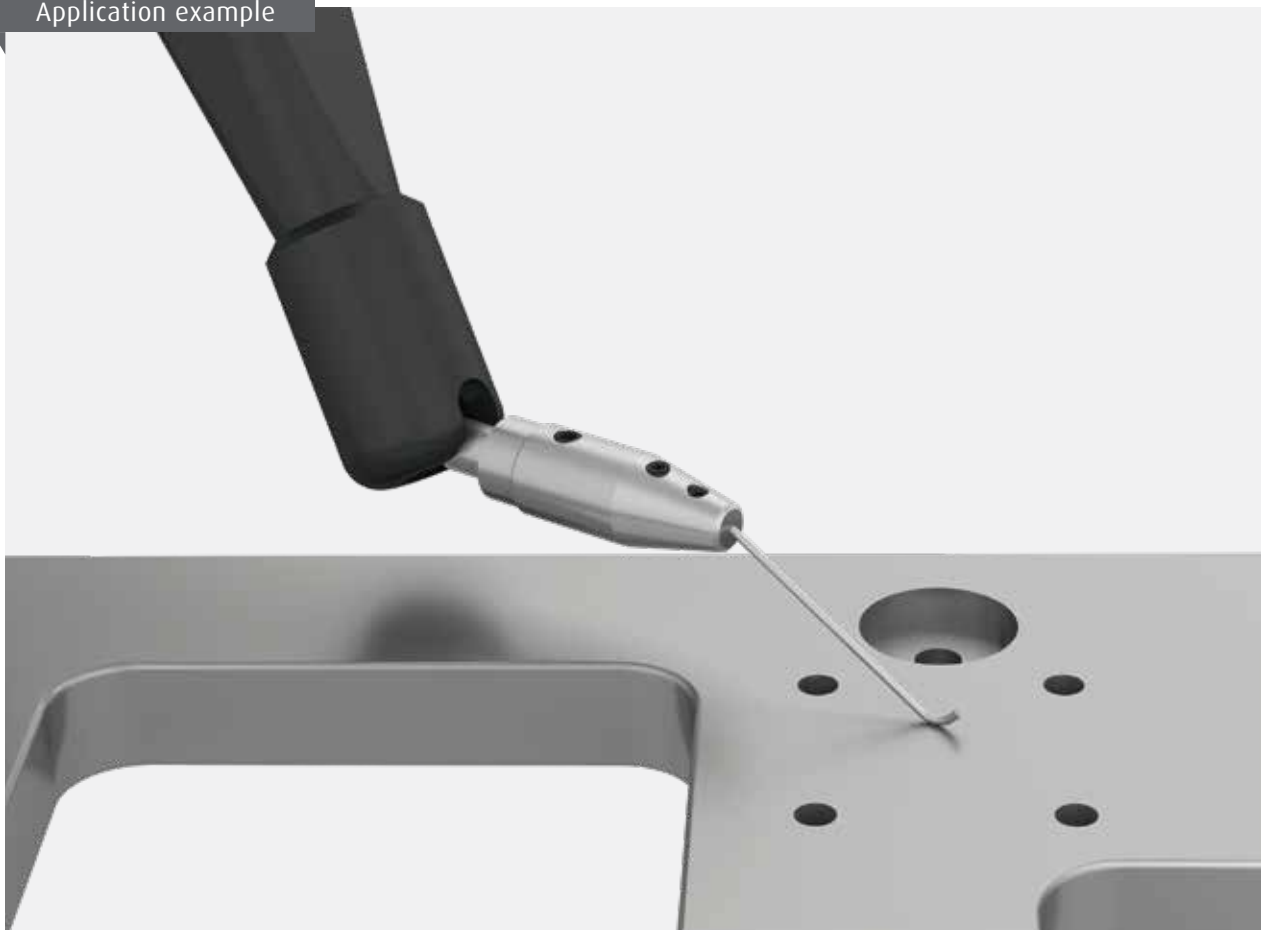
Stainless steel.



Order No.	Connection	T	L1	L2	Version	Fig.
269300	SWA 5	1.1	55	35	Round	
268300	SWA 5	1.1	70	50	Round	1

SWA 5

### Application example



**Toggle clamps with support**

**Description**

Toggle clamps with support and M10 thread.

**Supplied with**

Locknut.



Application example



Order No.	Overhang	Clamping range	Height
336300	32	0-20	100
336400	51	0-27	115

M 10

Application example





## Application example

Toggle clamp (used without support) with workpiece...



...and without workpiece



Parallel clamps

**Description**

Parallel clamps with a maximum clamping range of 75 mm. The jaw blocks have 4 faces and are available in different versions - flat, with a prism for holding round workpieces or convex for holding workpieces that are highly sensitive to bending. The clamps are mounted on SWA 5 or SWA 8 quick-change adapters.

**Material**

Stainless steel/steel/aluminium.



Application examples



Combined with an SWA 5 quick-change mount on an SWA 29 adapter... or on an articulated arm



Order No.	Clamping range	Connection	Jaw faces	Version	Fig.
278800	0-25	SWA 5	3 flat, 1 long prism	Both jaws rotatable	1
278600	0-25	SWA 5	2 flat, 1 long prism, 1 convex	Both jaws rotatable	1
278400	0-25	SWA 8	3 flat, 1 long prism	Both jaws rotatable	1
334900	0-25	SWA 8	2 flat, 1 long prism, 1 convex	Both jaws rotatable	1
278500	0-25	SWA 39	3 flat, 1 long prism	Both jaws rotatable	2
279610	0-50	SWA 8	3 flat, 1 long prism	Both jaws rotatable	
279620	0-75	SWA 8	3 flat, 1 long prism	Both jaws rotatable	

## Parallel clamps with guide pin

### Description

Parallel clamp with guide pin fixed in lower jaw to secure the jaws against rotation. Mounted on SWA 5, SWA 8 or SWA 39 quick-change adapters.

### Material

Stainless steel/aluminium.

### Application example



Order No.	Clamping range	Connection	Version	Fig.
279200	0-25	SWA 5	cross prism in lower jaw	
279210	0-25	SWA 8	cross prism in lower jaw	
279600	0-50	SWA 8	cross prism in lower jaw	1
279300	0-50	SWA 39	cross prism in lower jaw	2

SWA 5

SWA 8

SWA 39

### Application example



### Tension clamp

**Description**

Tension clamp for mounting on articulated arms. The tension clamp is designed for use with an articulated arm, the draw hook is pulled out by hand and hooked over a workpiece to provide tension. Connection with SWA 8 quick-change mount.

**Material**

Stainless steel.



Order No.	Connection	Size	Length	Hook travel	Tensile force (N)
376800	SWA 8	hook shaft Ø10	81	11	80

SWA 8

### Prism with spring finger

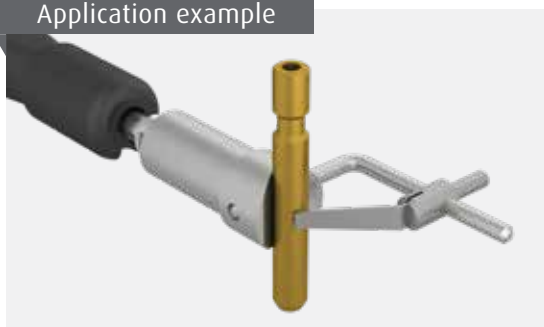
**Description**

120° prism on a column with a spring finger. Connection with SWA 8 quick-change mount.

**Material**

Stainless steel.

Application example



Order No.	Connection	Clamping range	Prism length	Height
285810	SWA 8	Ø 2–25	20	45

SWA 8

## Clips

### Description

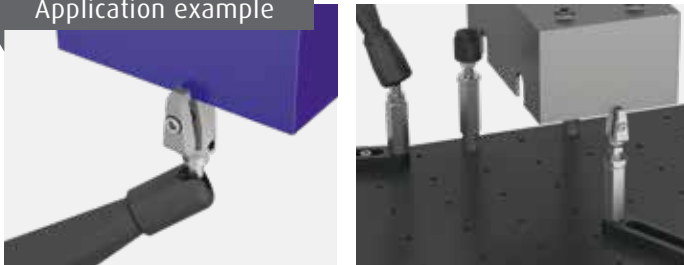
Clip for fixating thin, rigid parts.  
Clamping with a ball-head screw. Connection with SWA 5 or SWA 8 quick-change mount.

### Material

Steel.



### Application example



Order No.	Connection	Jaw depth	Clamping width
302100	SWA 5	5	3
302000	SWA 8	5	3

SWA 5

SWA 8

## Accessories

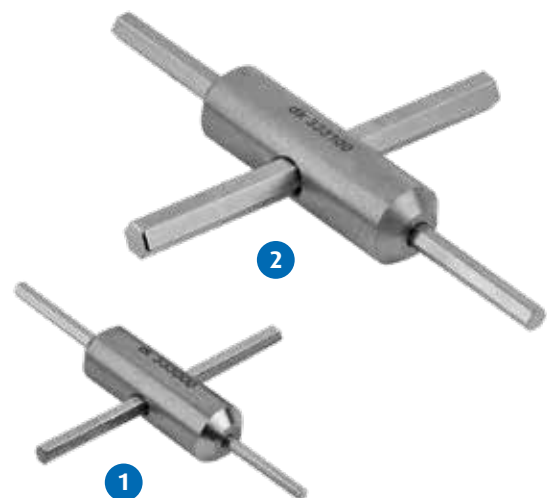
### + Four-way hexagon key

#### Description

Practical and compact cross design with 3 key sizes per tool. Covers all hexagon socket sizes used in the Spannfix and Schienenfix ranges.

#### Material

Steel/stainless steel.



Order No.	Size	Fig.
333000	2 / 2.5 / 3	1
333100	4 / 5 / 6	2

**Quick-action clamp with fastening screw**

**Description**

SWA 39 quick-action clamp for direct mounting in tapped holes or T-slots. Mounted on a 12mm high intermediate plate.

**Material**

Hard-coated aluminium/stainless steel.

**Supplied with**

Fasteners



Order No.	Fastening screw	Height
285204	M 4	23.5
285205	M 5	23.5
285206	M 6	23.5
285208	M 8	23.5
285210	M 10	23.5
285212	M 12	23.5

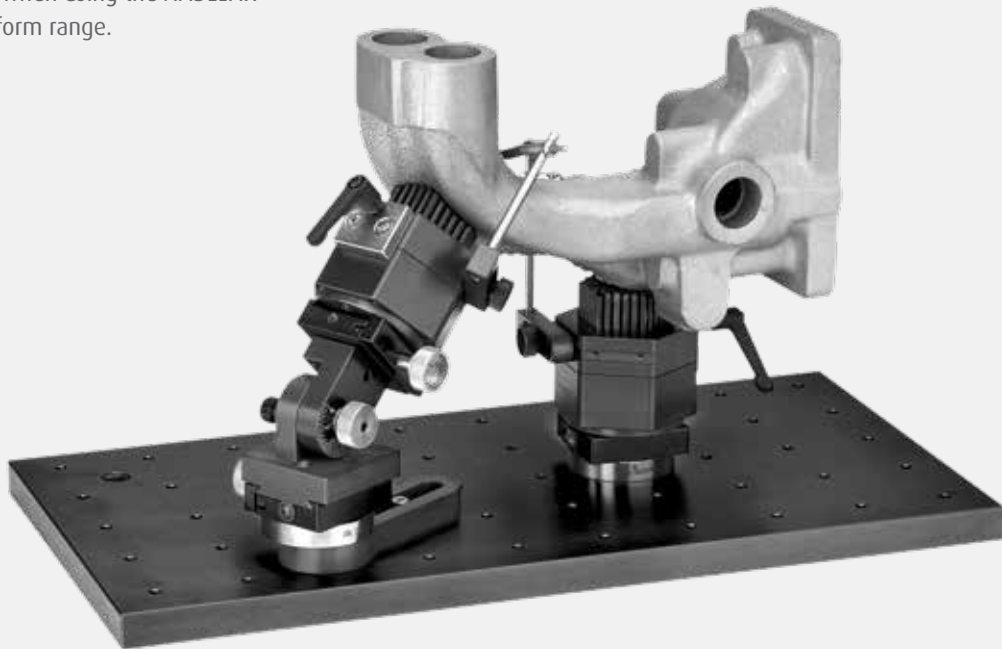
SWA 39  
M ...

**Application example**



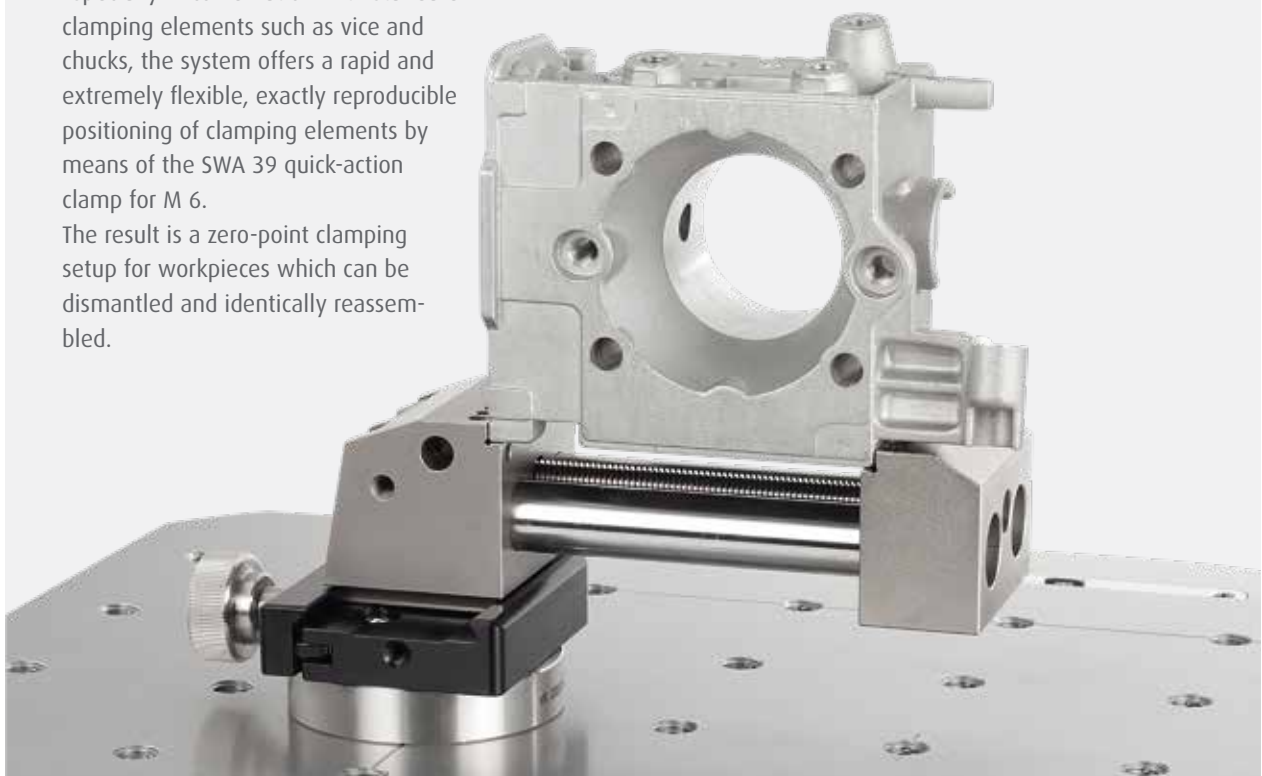
## Application examples

The SWA39 elements can form a support in the context of the fixation of large parts e.g. when using the *NADELFIX* negative form range.



Especially in combination with standard clamping elements such as vice and chucks, the system offers a rapid and extremely flexible, exactly reproducible positioning of clamping elements by means of the SWA 39 quick-action clamp for M 6.

The result is a zero-point clamping setup for workpieces which can be dismantled and identically reassembled.



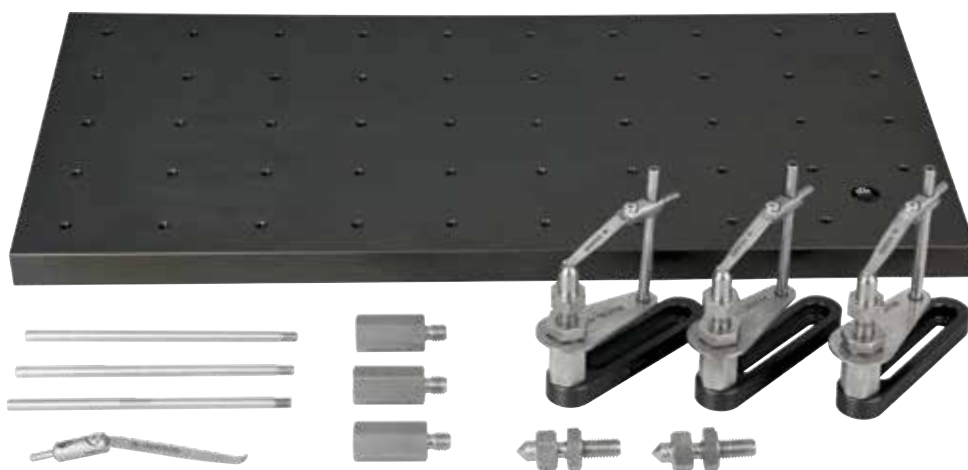
## Spannfix ECO basic set

### Description

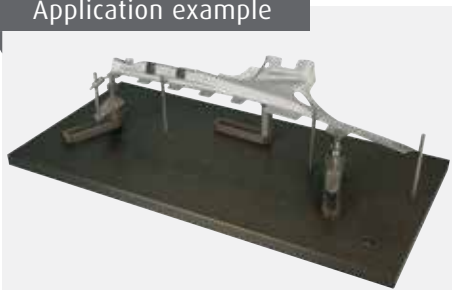
Set with diverse supports, extension pieces and stops. Workpieces are held using spring fingers.

The basic part is a baseplate with M6 mounting holes for rapid and flexible positioning of modular elements.

Available in sizes 500 x 250 mm or 600 x 300 mm.



### Application example



### Set versions

Order No.	Description
285130	Spannfix ECO basic set "1"
285140	Spannfix ECO basic set "2"

### Set contents

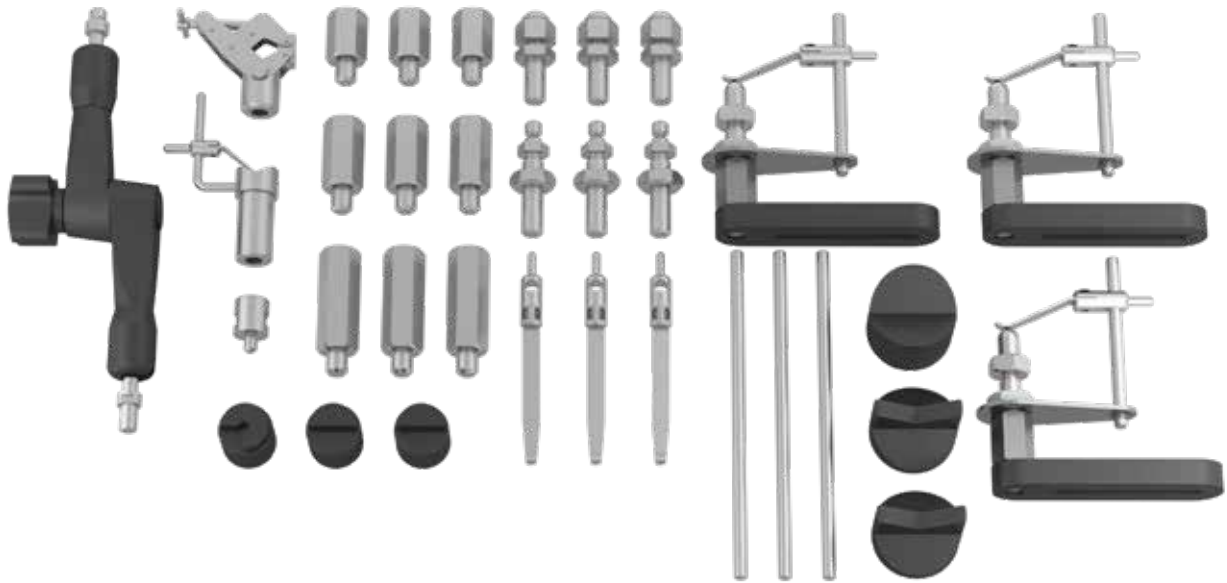
Order No.	Description	Set "1"	Set "2"
395030	Baseplate with tapped holes, 500 x 250 mm	1	-
395040	Baseplate with tapped holes, 600 x 300 mm	-	1
322005	Screw jack set with spring finger	3	3
322600	Screw jack with 90° point	2	2
322300	35 mm extension piece	3	3
368500	125 mm columns, for spring finger or as stops	3	3
302900	75 mm spring finger	1	1



## Spannfix ECO expansion set

### Description

Expansion set with diverse support, extension and clamping modules.



### Set versions

Order No.	Description
285155	Spannfix ECO expansion set

### Set contents

Order No.	Description	Quantity
296700	SU/SWA 8 articulated arm	1
278400	0-25 mm parallel clamp	1
285810	Prism with spring finger	1
322200	25 mm extension piece	3
322300	35 mm extension piece	3
322400	50 mm extension piece	3
323000	Self-aligning pads M10	3
329500	M 10/SWA 8 quick-change mount	3
275000	Thread reducer M6/M8	1
322005	Screw jack set with spring finger	3
368505	150 mm column for spring finger	3
302900	75 mm spring finger	3
303810	SWA 8 stepped support	2
303815	SWA 8 angular support	1
323500	SWA 8 120° prism, 8 mm	2
323400	SWA 8 120° prism, 40 mm	1

## Spannfix ECO complete set

### Description

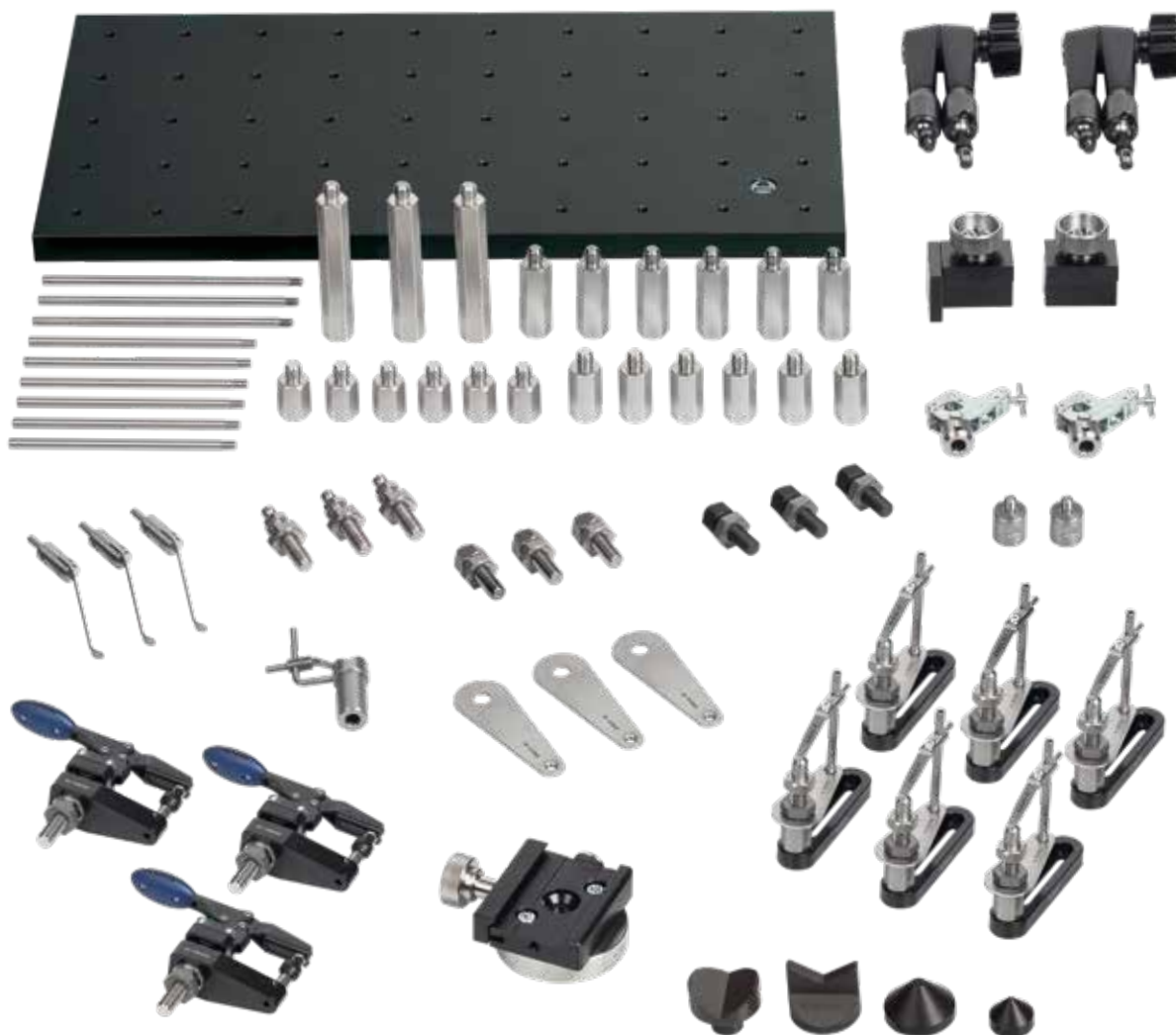
The set contains diverse supports, extension pieces and stops. Workpieces are held using spring fingers or parallel clamps. The basic part is a baseplate with M6 mounting holes for rapid and flexible positioning of modular elements. Set "1" includes a 500 x 250 mm baseplate, set "2" includes a 600 x 300 mm baseplate. The complete set enables a wide variety of metal and plastic plate, milled and turned parts to be clamped.

### Ordering information

When ordering, let us know the thread or T-slot size on your measuring equipment.

### Set contents

Order No.	Description
285160	Spannfix ECO complete set "1"
285170	Spannfix ECO complete set "2"



## Set contents

Order No.	Description	Set "1"	Set "2"
395030	Baseplate with tapped holes, 500 x 250 mm	1	
395040	Baseplate with tapped holes, 600 x 300 mm		1
281436	Baseplate clamping claws (set)	1	1
285206	Quick-action clamp	1	1
322005	Screw jack set with spring finger	6	6
322600	Screw jack with 90° point	3	3
323000	Self-aligning pads	3	3
368500	125 mm columns, for spring finger or as stops	6	6
368505	150 mm columns, for spring finger or as stops	3	3
353800	Adapter plates for columns	3	3
302900	75 mm spring finger	3	6
322200	25 mm extension	6	6
322300	35 mm extension	6	6
322400	50 mm extension	6	6
304400	100 mm extension	3	3
336400	Toggle clamps with support	3	3
329500	Quick-change mounts	3	3
323500	8 mm prism 120°	1	1
323400	40 mm prism 120°	1	1
303700	25 mm centre point, 90°	1	1
303800	40 mm centre point, 90°	1	1
275000	Thread reducer M6/M8	2	2
296700	Articulated arms type SU	2	2
278400	0–25 mm parallel clamp	2	2
285810	120° prism with spring finger	1	1

## Application example



**QUADERFIX**

## ***Clamping system for tactile measuring – Cuboid elements***

- » Modular fixture system constructed from standard cuboid elements
- » Drilled through holes on a 25 mm grid
- » Compatible with the *SPANNFIX* product range



Basic elements  
+ accessories



Cuboid baseplates

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Structural elements  
+ accessories



Cuboid columns

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Cuboid plates

Page 195



Cuboid V-blocks

Page 196



Cuboid inverted V-block pairs

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Cuboid reinforcement brackets

Page 198



Cuboid reinforcement struts

Page 198



Cuboid rotatable adapters

Page 199



Column connector swivelling

Page 199



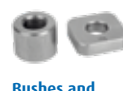
Cuboid adjustable mounting rails

Page 200



Cuboid X/Y positioning elements

Page 200



Bushes and adapters

Page 201



Adapter nut

Page 201



Rail for support pins

Page 202



Adapter for support pins

Page 202



Support pins

Page 203



Hexagonal extensions M6

Page 204



Jack screws M6

Page 204



Base rail M10

Page 206



Thread reducer extension piece

Page 206



Hexagonal extensions M10

Page 207



Self-aligning pads M10

Page 208



Jack screws M10

Page 208



Quick-change mount M10

Page 209



Screw jack set with spring finger

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Cuboid stops

Page 211

Clamping elements



Spring fingers

Page 212



Columns with screw

Page 213



Adapter plates for columns

Page 214



Toggle clamps with support

Page 215



Cuboid T-slot adapter

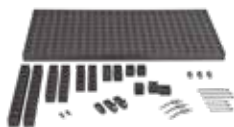
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Quick-action clamp Quaderfix

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Sets



Quaderfix basic set

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Quaderfix expansion set

Page 220



Quaderfix fasteners

Page 221

# Reproducible, anti-twist 3D fixtures through profile grid pattern

QUADERFIX elements are as easy to understand as building blocks, free spatial positioning and as rigid as if milled from a solid block. The program is so variable and simultaneously, equipped with so many accessories and high compatibility to the other dk fixating systems that highest versatility is the result. Even though QUADERFIX is basically designed to support dk's market leadership in the field of test piece sizes up to 1,000 mm, there is no weight and size limit for the workpieces to be mounted in this fixation program. It is therefore ideal for providing users optimum support where part sizes are mainly, but not only in the medium size range. The system integrity over basic, construction, positioning and clamping elements applies within QUADERFIX and at the same time extends over the majority of the other dk fixation systems. This makes this program incredibly high-performance.

QUADERFIX is therefore integral to dk's unique market position as developer, manufacturer and retailer of user-oriented, efficient and sustainable fixturing systems.

## Basic elements

- 1 Cuboid baseplate (page 192)



- Other accessories (page 193)



## Structural elements

- 2 Cuboid columns (page 194)



- 3 Support pins (page 203)

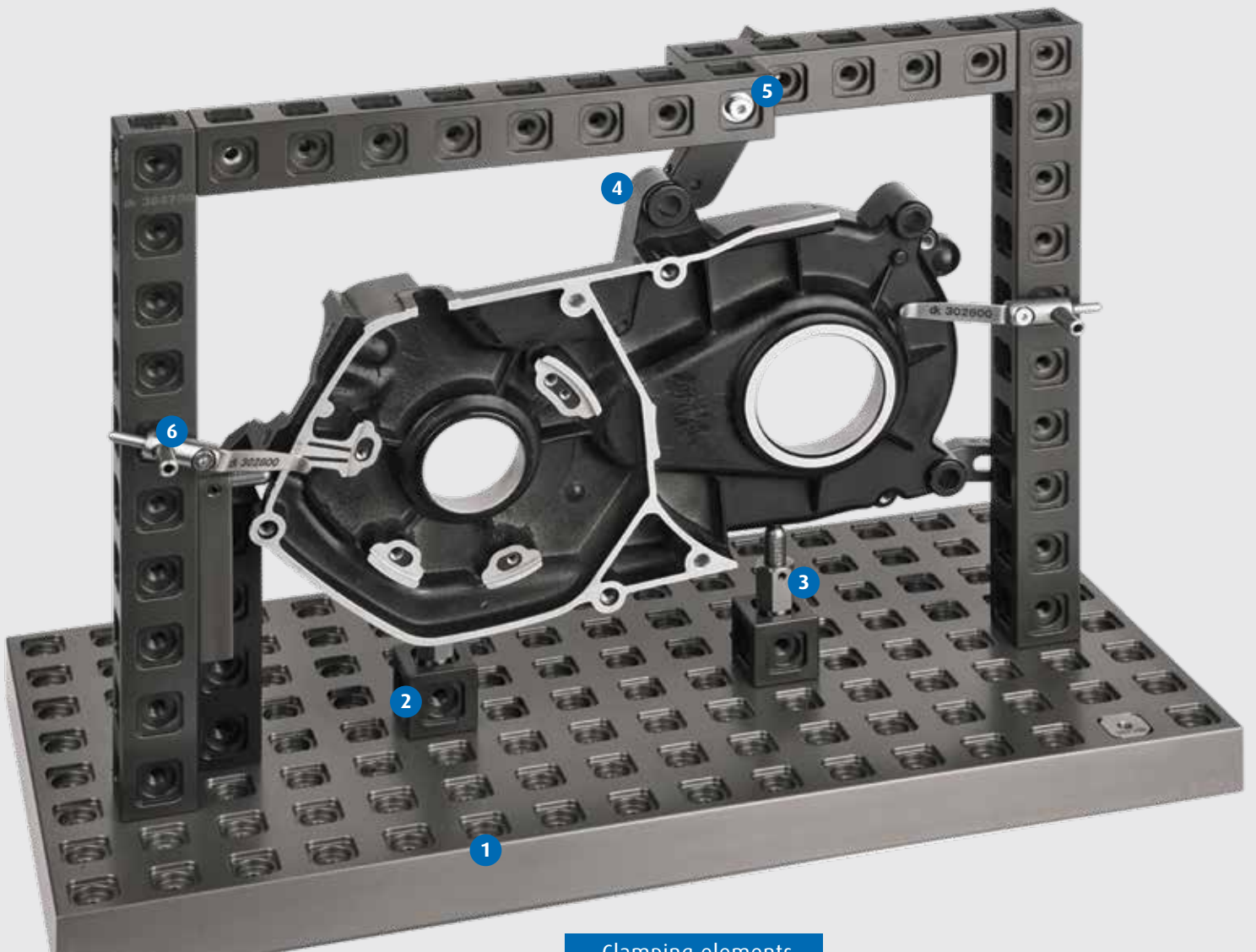


- 4 Cuboid X/Y positioning element (page 200)



- 5 Adapter nut (page 201)





Other versions  
(pages 195–197)



Accessories (page 202)



Other versions (page 200)



### Clamping elements

6 Spring fingers (page 212)



All clamping elements included in Spannfix PRO (pages 130 to 143) and Spannfix ECO (pages 172 to 181) can also be used with the QUADERFIX system.



**FAST  
REASSEMBLY  
LIFELONG**

Cuboid baseplates

**Description**

Baseplate with square push-fit sockets for anti-twist mounting of the modular elements and M6 connection threads in a 25 mm grid pattern.

**Material**

Hard-coated aluminium.



Order No.	Length	Width	Height	Weight
361700	400	200	25	4.7
362000	500	250	25	7.4
362100	600	300	25	10.7

Quad

Application example





## + Column and plate connector

### Description

Plate connector for Quaderfix baseplates. For joining columns and plates.

### Material

Hard-coated aluminium.



Order No.	Length	Width	Height	
363300	100	25	12	Quad

## + Clamping claws

### Description

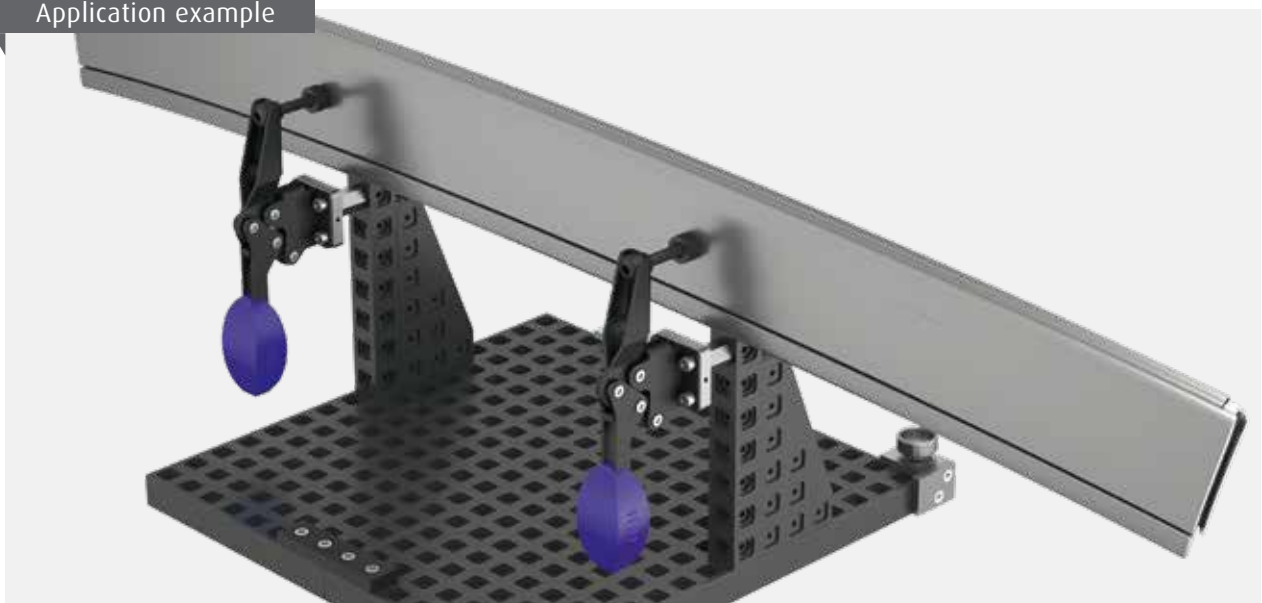
A set of clamping claws for the 25 mm thick dk Quaderfix plates. The claws are screwed onto the measuring machine table. Check the table thread sizes before ordering. These elements provide a stop for repeat positioning accuracy while simultaneously securely clamping the dk baseplates.



Order No.	For plate thickness	Thread	Contents
281406	25	M 6	1 set
281408	25	M 8	1 set
281410	25	M 10	1 set
281412	25	M 12	1 set

M ...

### Application example



Cuboid columns

Description

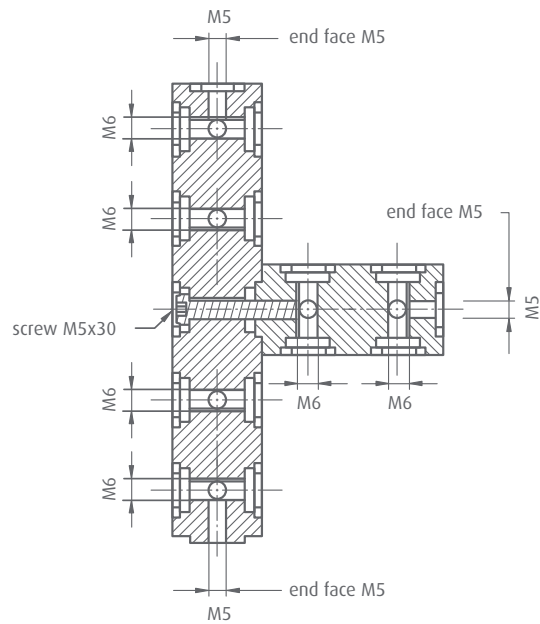
Cuboid column with a 25 mm connection thread spacing. Square push-fit sockets for anti-twist mounting of module elements with M6 connection threads, M5 on end faces.

Material

Hard-coated aluminium.



Application example



Order No.	Length	Width	Height	Weight
364000	25	25	25	0.03
364100	50	25	25	0.07
364200	75	25	25	0.1
364300	100	25	25	0.13
364400	125	25	25	0.17
364500	150	25	25	0.2
364600	200	25	25	0.27
364700	250	25	25	0.34
364800	500	25	25	0.68



## Cuboid plates

### Description

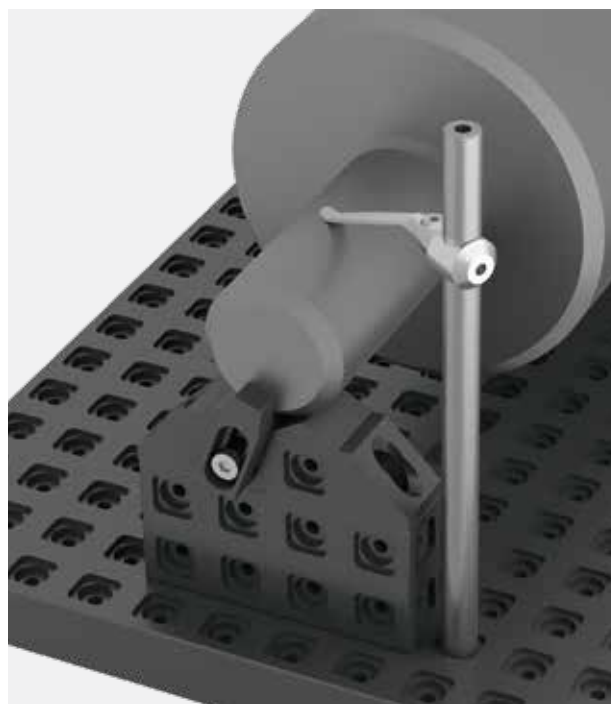
Cuboid plates with a 25 mm grid pattern. Square push-fit sockets for anti-twist mounting of module elements with M6 connection threads, M5 on side faces. Also suitable as baseplate for smaller clamping tasks.

### Material

Hard-coated aluminium.



### Application examples



Order No.	Length	Width	Height	Weight
360100	50	100	25	0.29
360300	50	150	25	0.43
360400	50	200	25	0.57
360500	50	250	25	0.72
360600	50	500	25	1.44
360900	100	200	25	1.3
361600	200	300	25	3.6

Quad

Cuboid V-blocks

Description

Cuboid 120° V-blocks Square push-fit socket for anti-twist mounting of module elements with M6 connection threads, M5 on top faces.

Material

Hard-coated aluminium.

Contents

1 pair.



Order No.	Length	Width	Height	Clamping Ø	Weight	Fig.
359400	100	25	50	100	0.27	1
359500	150	25	50	200	0.36	

Quad

Cuboid inverted V-block pairs

Description

Pair of inverted V-blocks. Square push-fit sockets for anti-twist mounting of module elements with M6 connection threads, M5 on bottom face.

Material

Hard-coated aluminium.

Contents

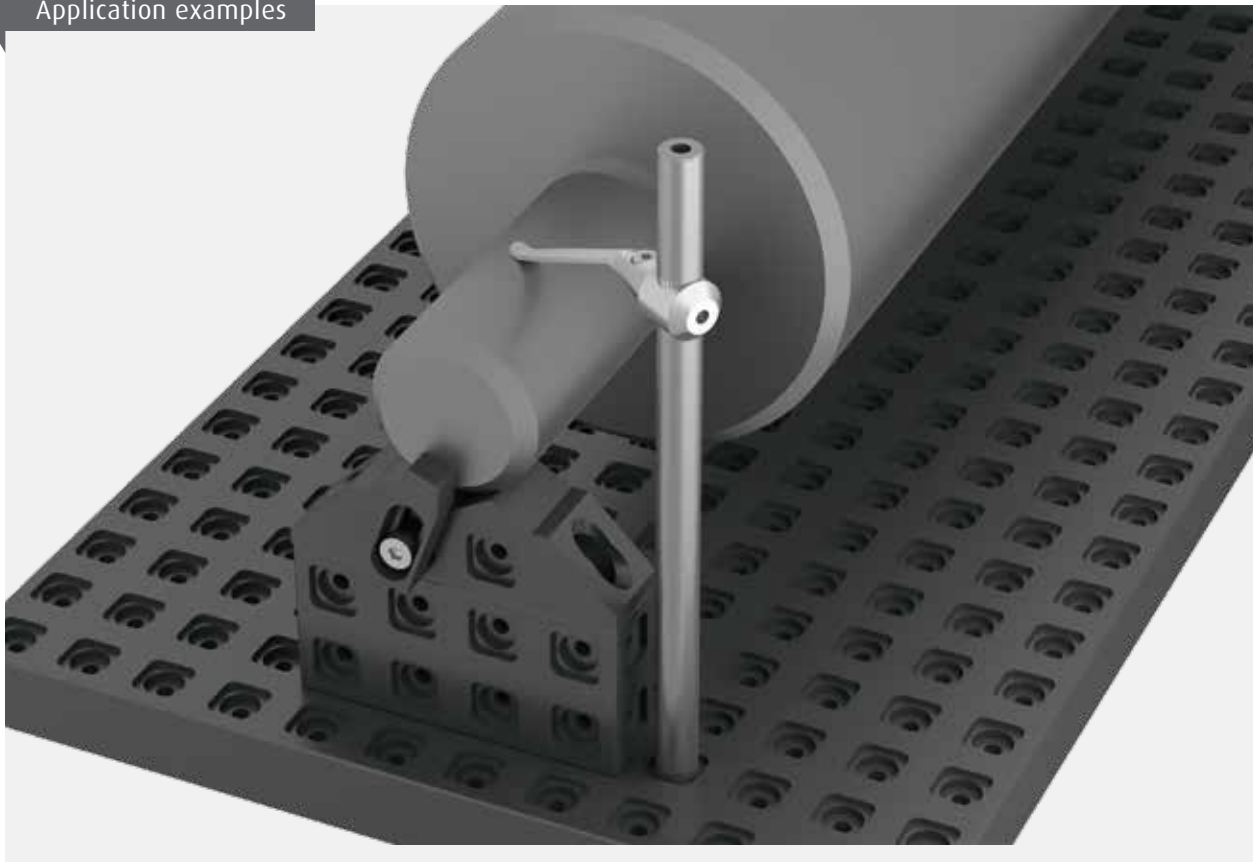
One pair.



Order No.	Prism	Length	Width	Height	Weight	Fig.
359600	90°	25	25	25	0.04	1
359700	90°	50	25	25	0.08	
359800	120°	25	25	25	0.04	
359900	120°	50	25	25	0.07	

Quad

Application examples



Cuboid reinforcement brackets

Description

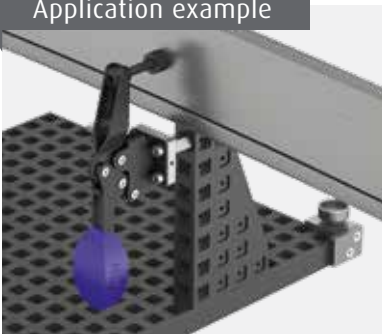
Angle block for reinforcement or to ease assembly. With the bracket 366000 cuboid columns or V-block elements can be mounted on the baseplate from above. Fastening from the plate underside is not required.

Material

Hard-coated aluminium.



Application example



Order No.	Length	Width	Height	Weight
366000	25	25	25	0.04
357000	100	50	25	0.24
357100	150	75	25	0.49

Quad

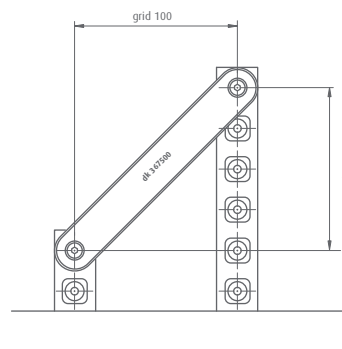
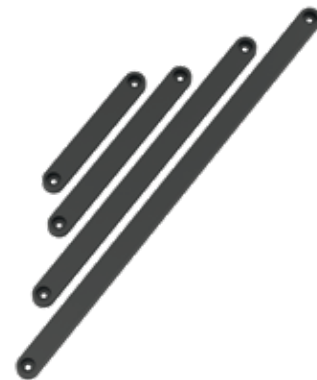
Cuboid reinforcement struts

Description

Struts for increasing rigidity and strengthening larger constructions or by very heavy workpieces.

Material

Hard-coated aluminium.



Order No.	Pattern	Length	Hole spacing	Width	Thickness
367500	100/100	166	142	25	12
367600	150/150	236	212	25	12
367700	250/250	378	354	25	12
367800	350/350	520	495	25	12

Quad

## Cuboid rotatable adapters

### Description

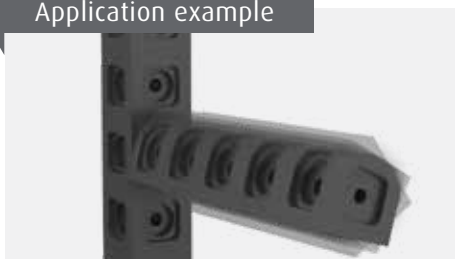
Cuboid rotatable adapters Enable e.g. cuboid columns or V-blocks to be mounted in a rotated position.

### Material

Hard-coated aluminium.



### Application example



Order No.	Length	Width	Height	Weight
366500	25	25	25	0.04

Quad

## Column connector, swivelling

### Description

Swivelling connector for columns. To connect columns in a continuously adjustable angle.

### Material

Hard-coated aluminium.

### Contents

1 pair.



### Application example



Order No.	Length	Width	Height	Version
363600	58	25	8	Swivelling

Quad

### Cuboid adjustable mounting rails

**Description**

Adjustable rails for mounting cuboid elements or threaded columns.

**Material**

Hard-coated aluminium.



Application example



Quad

Order No.	Length	Width	Height	Adjustment range	Fig.
357800	83	25	12.5	38	1
366400	60	25	25	15	2

### Cuboid X/Y positioning elements

**Description**

X/Y adjustment element for positioning cuboid elements outside the 25 mm grid pattern.

**Material**

Hard-coated aluminium.

Application example



Quad

Order No.	Length	Width	Height	Adjustment range
357500	65	65	25	15



## Bushes and adapters

### Description

Centring bush and plate for locating cuboid elements that are to be screwed together. Centring plate secured against rotation.

### Material

Stainless steel.



Order No.	Description	Fig.
367000	Centring plate	1
367200	Centring bush	2

Quad

## Adapter nut

### Description

Adapter for fastening cuboid elements with M5 threads.

### Material

Stainless steel.



Order No.	Description
367100	M5 adapter nut

Quad

Rail for support pins

Description

Adjustable rail for support pins.  
Hole Ø4 mm / Slot width 6 mm.

Material

Hard-coated aluminium.



Application example



Order No.	Length	Width	Height	Adjustment range
357700	72	20	12	25

Adapter for support pins

Description

With Ø4 mm hole for support pins.  
M5 or M6 connection thread.

Material

Stainless steel.



Order No.	Male thread	Female thread	Height	Fig.
356600	M 5	-	20	
356400	M 6	-	20	1
356700	-	M 5	20	2



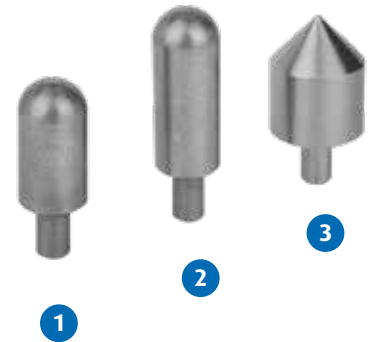
## Support pins

### Description

Support pins and centre points for adapters and rails with  $\varnothing 4$  mm holes.

### Material

Stainless steel.



### Application example



Order No.	Version	Diameter	Fig.
319400	R4 x 15 mm pin	8	1
319500	R4 x 20 mm pin	8	2
319300	90° centre point	12	3

### Application example



### Hexagonal extensions M6

**Description**

M6 extension pieces for screwing directly onto baseplates or onto cuboid columns. Hexagon 13 mm.



Order No.	Male thread	Female thread	Length
322250	M 6	M 6	15
322350	M 6	M 6	25
322450	M 6	M 6	50

### Jack screws M6

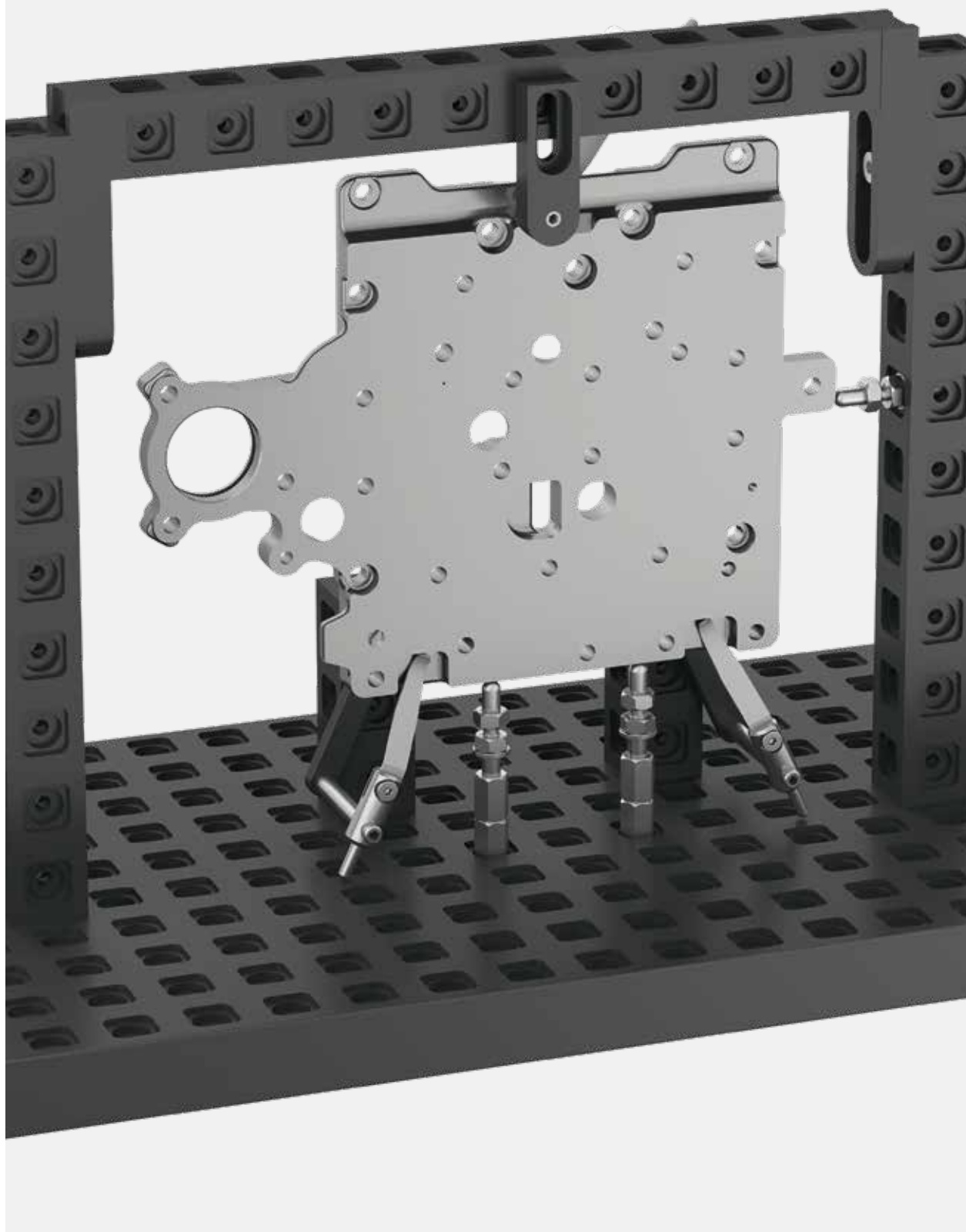
**Description**

Height adjustable supports. The M6 thread enables screwing directly into baseplates, horizontally into cuboid columns or joining to M6 hexagonal extensions.



Order No.	Version	Length	Fig.
322750	R3 mm ball-end	40	1
323050	self-aligning pad, steel, +/- 10°	35	2
323060	self-aligning pad, plastic, +/- 10°	35	
323070	Ø6 mm 5 N magnetic pin	42	3

Application example



Base rails M 10

**Description**

Adjustable base rail with slot and M10 thread for mounting M10 extension pieces.

**Material**

Hard-coated aluminium.

**Supplied with**

M6 screw.



Order No.	Slot width	Adjustment range	Length	Width	Height
322010	6	60	105	25	12

M 10	M 10
M ...	T-Nut

Thread reducer extension piece

**Description**

Adapter element with centring ring for cuboid elements.

**Material**

Stainless steel.



Order No.	Connection 1	Connection 2	Length
369000	Male M 5	Female M 6	12
369200	Male M 5	Female M 8	28
356200	Male M 5	Female M 10	39
369100	Male M 6	Female M 8	28
356000	Male M 6	Female M 10	39
356300	Female M 5	Female M 10	30

M ...
Quad

## Hexagonal extensions M10

### Description

Hexagonal extension pieces with male thread one end and female thread other end. For screwing onto thread reducers and base rails to incrementally raise the height. Width across flats 17 mm.

### Material

Stainless steel.



Order No.	Male thread	Female thread	Length
322200	M 10	M 10	25
322300	M 10	M 10	35
322400	M 10	M 10	50
304400	M 10	M 10	100
253500	M 10	M 10	150

M 8

M 10

### Application example



## Self-aligning pads M10

**Description**

Support with flattened, swivel ball to compensate for surface irregularities. Can be screwed onto hexagonal extension pieces or directly into base rails.

**Material**

Stainless steel/black oxidised steel.

**Supplied with**

Locknut.



Order No.	Support	Swivel range	Adjustment range	Length
323000	Ø 8	± 15°	15	46

M 10

## Jack screws M 10

**Description**

Height adjustable supports for centring and supporting test parts.

**Material**

Stainless steel.

**Supplied with**

Locknut.



Order No.	Version	Adjustment range	Length	Fig.
322600	90° cone point, Ø10	15	50	1
322700	R5 mm ball-end	25	63	2

M 10



## M 10 quick-change mount

### Description

Quick-change adapter M 10 for SWA 5 / SWA 8 modules.

### Material

Stainless steel.

### Supplied with

Locknut.



Order No.	Version	Adjustment range	Length
329400	SWA 5	25	55
329500	SWA 8	25	57

SWA 5	SWA 8
M 10	M 10

## Accessories

### + Centre points

#### Description

90° centre points with SWA 8 quick-change mount.

#### Material

Hard-coated aluminium.

Order No.	Diameter	Height	Fig.
303600	15	20	1
303700	25	20	2
303800	40	24	3



SWA 8

### + Prism supports

#### Description

120° prism supports with SWA 8 or SWA 5 quick-change mount.

#### Material

Hard-coated aluminium.

Order No.	Clamping range	Prism length	Connection	Height	Fig.
323500	Ø 2-60	8	SWA 8	35	1
323400	Ø 2-60	40	SWA 8	33	2



SWA 5 SWA 8

Accessories

**+ Flat supports**

**Description**

Flat supports in various versions: flat face, straight step and prism step. With SWA 8 quick-change mounts.

**Material**

Hard-coated aluminium.



Order No.	Version	Diameter	Height	Step height	Fig.
303805	Flat face	25	20		1
303810	Straight step	25	20	5	2
303815	Prism step	25	20	5	3

SWA 8

**Screw jack set with spring finger**

**Description**

Adjustable base rail with support and spring finger. The support height is adjustable.

**Material**

Hard-coated aluminium/stainless steel.

**Supplied with**

Base rail (322010), extension piece (322200), jack screw (322700), adapter plate for columns (353700), column with screw (368300), spring finger (302800), locknut and M6 fastening screw.

See T-slot nuts page 108 for fastening the base rail in a T-slot.



Order No.	Adjustment range	Length	Width	Support height
322005	60	105	25	80-90

M 6 T-Nut

## Cuboid stops

### Description

Stops for cuboids. Fixed or adjustable versions with ball support.

### Material

Hard-coated aluminium/steel.



Order No.	Version	Adjustment range	Fig.
366600	Fixed	15 mm rail	1
366700	Adjustable	15 mm rail, 20 mm stop	2

Quad

### Application example



Spring fingers

Description

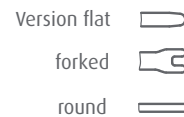
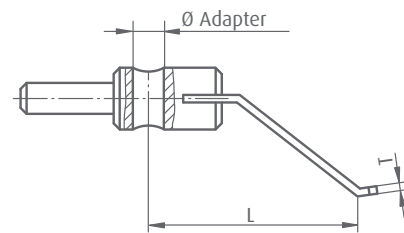
For the simple and quick holding down of workpieces.  
Self-locking on round columns due to the applied tension by manually pressing down.

Material

Stainless steel.



Application example



Order No.	Adapter Ø	Version	T	L	Fig.
302750	6	Round	1.1	50	
302760	6	Round	1.5	50	
302800	6	Flat	1	50	1
302900	6	Flat	1	75	
302810	6	Flat	1	90-125	2
302910	6	Flat	1	115-150	
302300	12	Flat	1	75	3
302400	12	Flat	1	95	
302320	12	Flat	1	120-150	
302500	12	Flat	1.5	75	
302600	12	Flat	1.5	95	
302520	12	Flat	1.5	120-150	
302350	12	Round	2.5	80	4
302340	12	Round	3	80	
302510	12	Forked	1.5	75	5
302610	12	Forked	1.5	95	

## Columns with screw

### Description

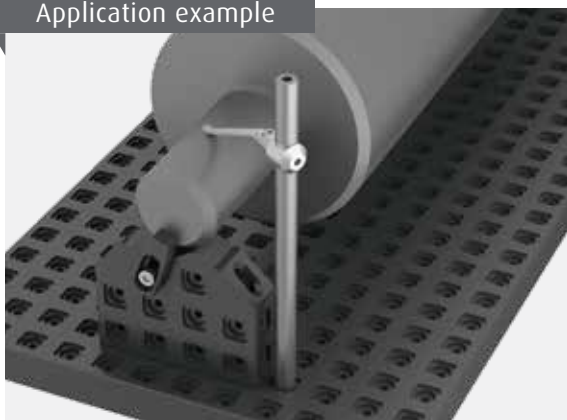
Columns with threaded connection for mounting spring fingers or for use as a stop element.

### Material

Stainless steel.



### Application example



Order No.	Column Ø	Thread	Length
368100	6	M 6	30
368120	6	M 8	30
368200	6	M 6	50
368220	6	M 8	50
368300	6	M 6	75
368400	6	M 6	100
368500	6	M 6	125
368505	6	M 6	150
368600	12	M 6	50
368620	12	M 8	50
368700	12	M 6	100
368720	12	M 8	100
368800	12	M 6	150
368820	12	M 8	150
368900	12	M 6	200
368920	12	M 8	200
368610	12	M 10	50
368710	12	M 10	100
368810	12	M 10	150
368910	12	M 10	200

M ...

Adapter plates for columns

**Description**

Adapter plates for columns with M6 threads (e.g. for spring fingers) for mounting on M10 hexagonal extension pieces, self-aligning pads, rest pins and quick-change adapters.

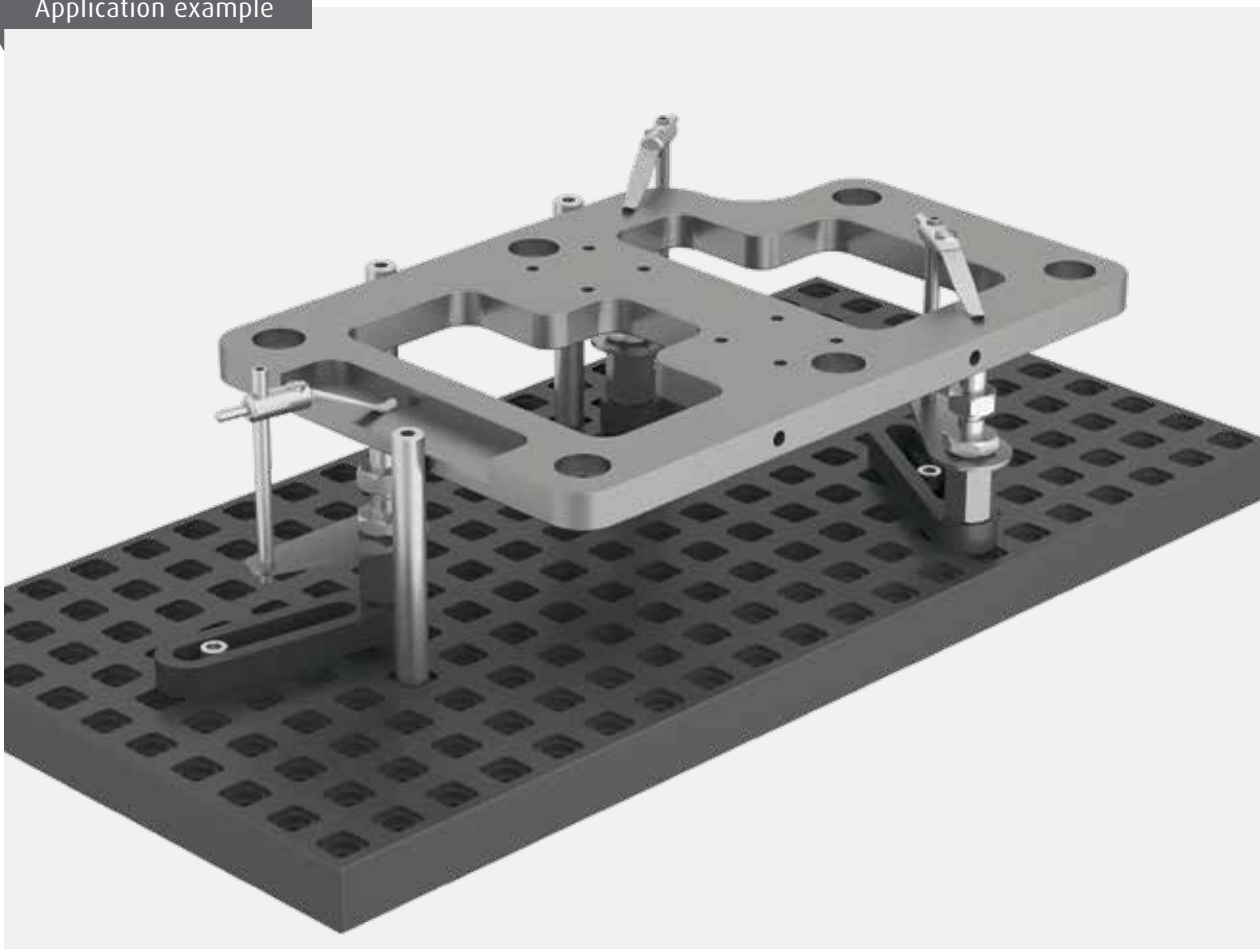
**Material**

Stainless steel.



Order No.	Hole	Overhang
353700	Ø 10	50
353800	Ø 10	72

Application example



## Toggle clamps with support

### Description

Toggle clamp with support and M10 thread.

### Supplied with

Locknut.



Application example



Order No.	Overhang	Clamping range	Height
336300	32	0-20	100
336400	51	0-27	115

M 10

Application example



Toggle clamp (used without support) with workpiece.

T-slot / Cuboid adapter

Description

Adapter for mounting cuboid modules on Spannfix T-slot plates.

Material

Aluminium/steel.

Supplied with

T-slot nut.



Application example



Order No.	Length	Width	Height	Weight
366300	50	25	35	0.09

Quad  
T-Nut 6

Application example

With this interface, *QUADERFIX* components can be mounted onto *SPANNFIX COMPONENTS*.





## SWA 39 quick-action clamp for QUADERFIX

### Description

SWA 39 quick-action clamp for direct fastening on cuboid plates.

### Material

Hard-coated aluminium.

### Supplied with

Fastening screw.



Order No.

Height

362900

21.5

SWA 39  
Quad

### Application example

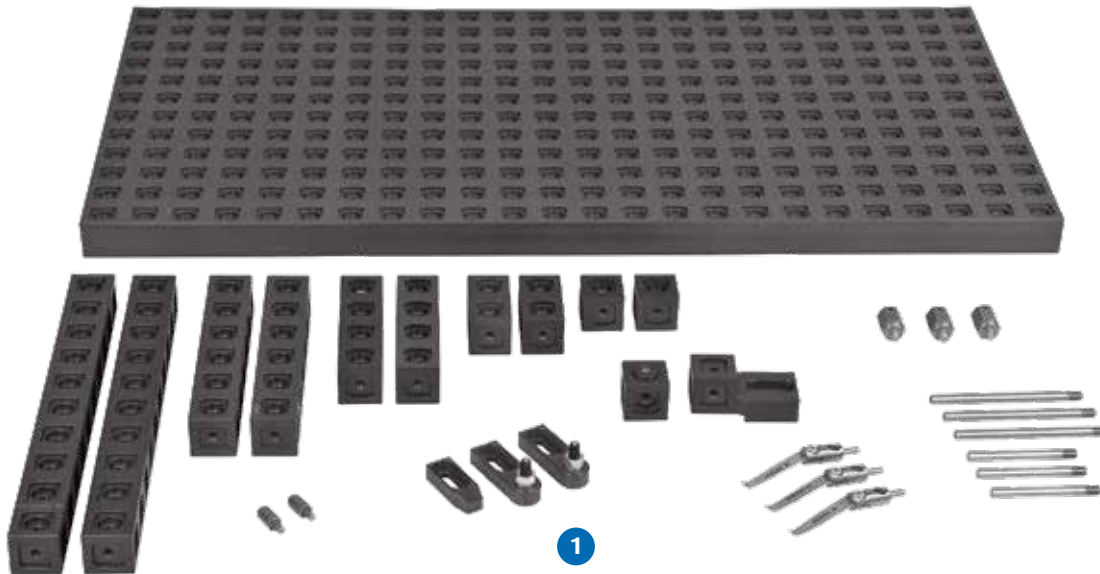
With this interface, quick-change SWA 39 components can be mounted onto the QUADERFIX system.



### Quaderfix basic sets

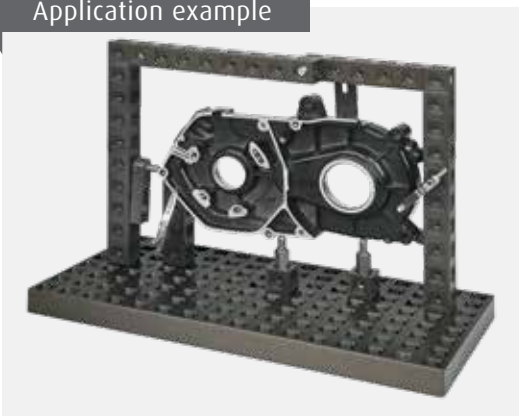
#### Description

Set with various cuboid elements for mounting medium-sized test parts. The basis is formed by a 500 mm x 250 mm or 600 mm x 300 mm baseplate.



\* Fasteners not shown.

#### Application example



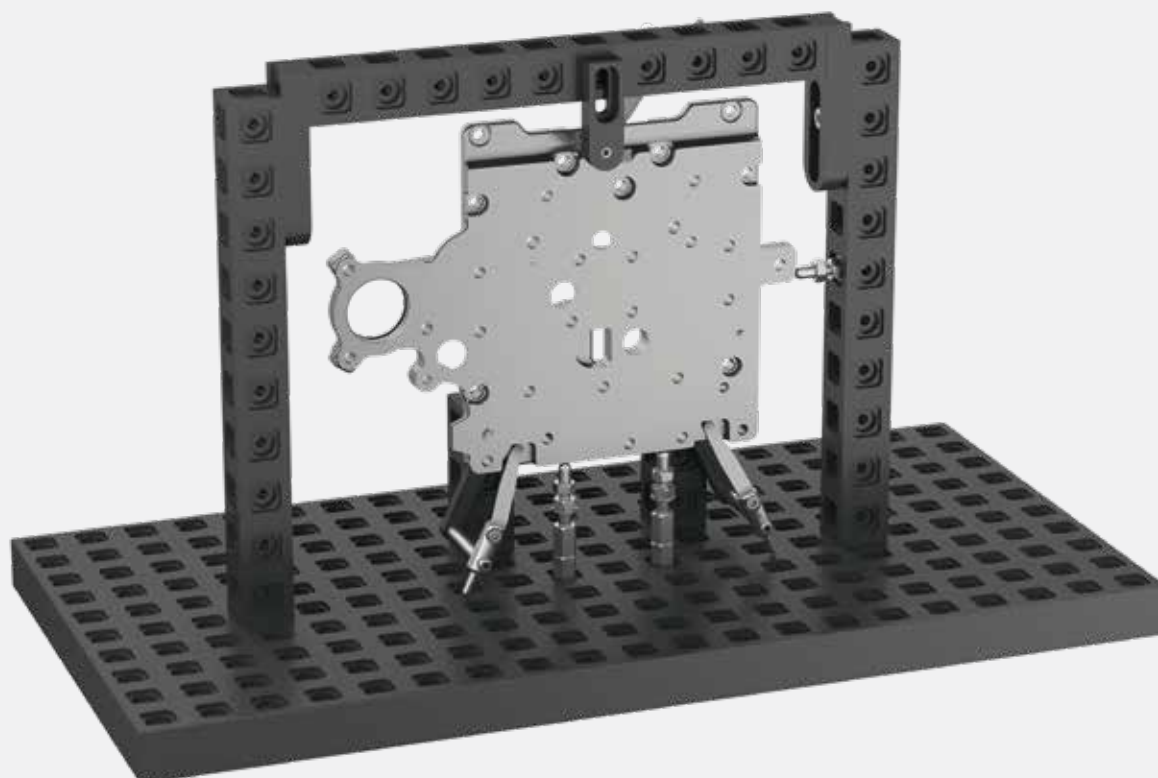
#### Set versions

Order No.	Description	Baseplate	Fig.
369915	Quaderfix basic set "1"	500 x 250	
369920	Quaderfix basic set "2"	600 x 300	1

## Set contents

Order No.	Description	Set "1"	Set "2"
362000	500 x 250 mm cuboid baseplate	1	-
362100	600 x 300 mm cuboid baseplate	-	1
364700	250 mm cuboid columns	2	2
364500	150 mm cuboid columns	2	2
364300	100 mm cuboid columns	2	2
364100	50 mm cuboid columns	2	2
364000	25 mm cuboid columns	2	2
366500	Cuboid rotatable adapters	1	1
366400	Cuboid adjustable mount	1	1
366700	Cuboid adjustable stop	2	2
366600	Cuboid fixed stop	1	1
368200	50 mm columns for spring fingers	3	3
368300	75 mm columns for spring fingers	3	3
302800	50 mm spring finger	3	3
356600	M5 adapter for support pins	2	2
356400	M6 adapter for support pins	1	1
319400	R4 x 15 mm support pin	3	3
369800	Quaderfix fastener set "1"	1	1

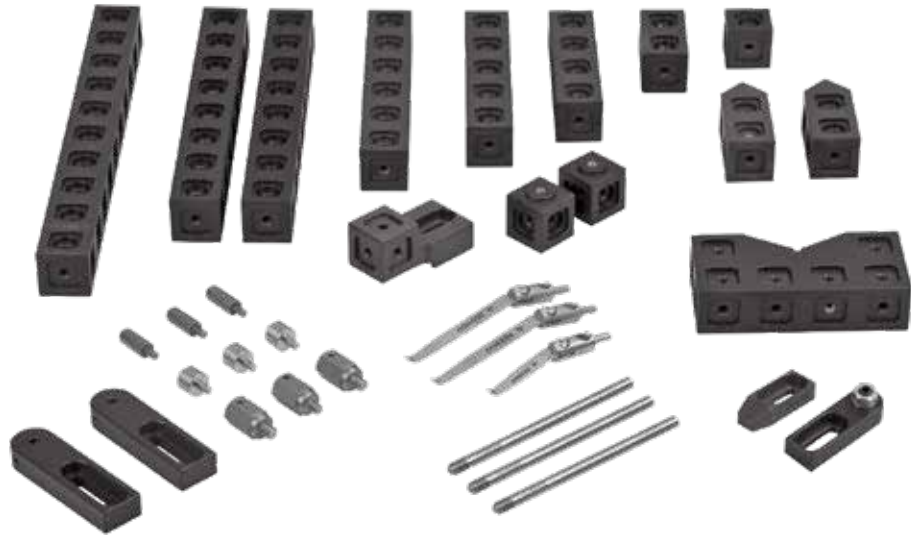
## Application example



**Quaderfix expansion set**

**Description**

Expansion set with further Quaderfix modules for assembling more complex clamping fixtures.



**Set versions**

Order No.	Description
369930	Quaderfix expansion set

**Set contents**

Order No.	Description	Quantity
364700	250 mm cuboid column	1
364600	200 mm cuboid column	2
364500	150 mm cuboid column	1
364400	125 mm cuboid column	1
364300	100 mm cuboid column	1
364100	50 mm cuboid column	1
364000	25 mm cuboid column	1
366500	Cuboid rotating adapter	2
366400	Cuboid adjustable mount	1
366700	Cuboid adjustable stop	1
366600	Cuboid fixed stop	1
359700	Pair of cuboid 90° inverted V-blocks, 50 mm	1
359400	Pair of 120° cuboid V-blocks, 100 mm	1
368400	100 mm columns for spring fingers	3
302800	50 mm spring finger	1
302900	75 mm spring finger	2
356600	M5 adapter for support pins	1
356400	M6 adapter for support pins	2
357700	Rails for support pins	2
319500	R4 x 20 mm support pins	3
319300	90° centre point for support pins	3

## Quaderfix fasteners

### Description

Fasteners for Quaderfix in a practical assortment box. Consisting of i.e. bushes, adapters and clamping screws in various lengths, for mounting individual cuboid elements. Two set versions available.



### Set versions

Order No.	Description	Fig.
369800	Quaderfix fastener set "1"	1
369900	Quaderfix fastener set "2"	

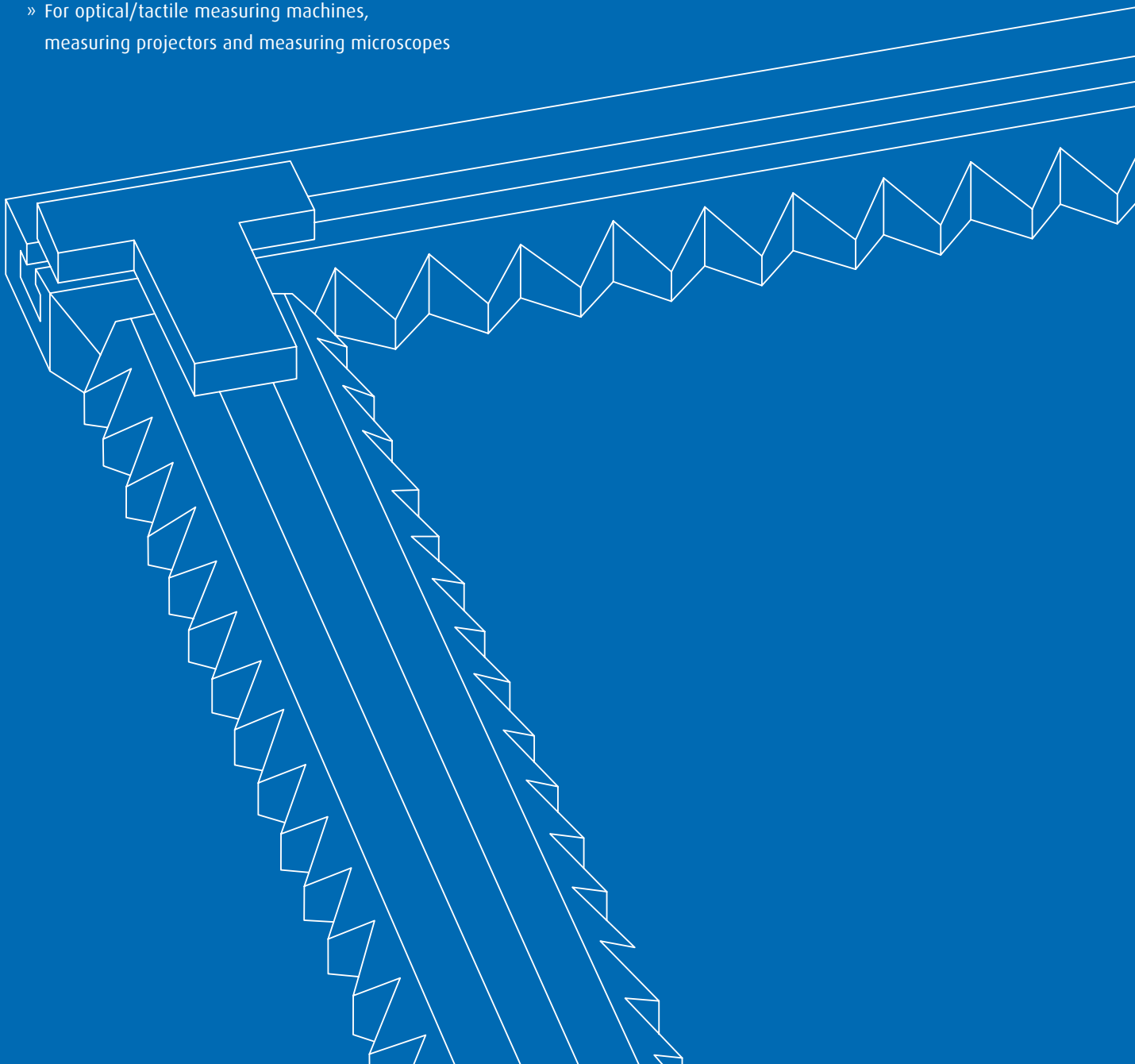
### Set contents

Order No.	Description	Set "1"	Set "2"
367000	Centring plates	10	20
367100	M5 tapped bushes	5	10
367200	Centring rings	5	10
369100	Thread reducers - male M6 / female M8	-	2
369200	Thread reducers - male M5 / female M8	-	1
	Screws M5 x 14	15	30
	Screws M5 x 16	15	30
	Screws M5 x 30	15	30
	Screws M5 x 45	10	20
	Screws M6 x 12	15	30
	Screws M6 x 16	15	30
	Screws M6 x 20	15	30
	Screws M6 x 25	15	30
	M5 washers	40	40
	M6 washers	40	40
	2.5 mm hexagonal key	-	1
	3 mm hexagonal key	-	1
	4 mm hexagonal key	-	1

**SCHIENENFIX**

## *Clamping system for optical and multi-sensorial measuring*

- » Modular clamping elements for optical or optical/tactile measuring
- » For high-precision edge measurement in reflected and transmitted light
- » Toothed rails as workpiece rests or for fastening clamping modules
- » For optical/tactile measuring machines, measuring projectors and measuring microscopes



Basic elements  
+ accessories



Base rails

Page 228



Connecting rails

Page 229



Rail connecting adapters

Page 230



T-slot nuts and screws

Page 230



Clamping claws

Page 231



Clamping elements

Page 232



Base mount

Page 233



Quick-action clamp

Page 234



Quick-action clamp 90° angle element

Page 235



90° angle element

Page 235

Structural elements  
+ accessories



Articulated arms

Page 236



Satellite mount

Page 236



Rotary unit

Page 237



SWA 5 quick-change mount

Page 238



Rotary unit with fine adjustment and indexing

Page 239



Quick-change pallet system

Page 240

Clamping elements  
+ accessories



Spring finger for horizontal clamping

Page 242



Spring finger for vertical clamping

Page 243



Square columns for spring finger

Page 243



SWA 5 spring finger for vertical clamping

Page 245



Spring finger with fastener

Page 245



Spring clamp for vertical clamping

Page 244



Stop set

Page 246



Rest angle with spring finger

Page 247



Small screw jack set

Page 248



Small screw jack set with spring finger

Page 248



Toggle clamp for toothed rails

Page 251



15 mm precision vice

Page 252



25 mm precision vice

Page 254



35 mm precision vice

Page 255



50 mm precision centric vice

Page 256



50 mm precision vice

Page 257



50 mm precision vice

Page 258



Clamping elements  
(continued)



**V-block with spring finger**  
Page 262



**V-block with magnetic prism**  
Page 262



**V-block bracket**  
Page 263



**V-blocks**  
Page 264



**Mini tailstock**  
Page 266



**Tailstock**  
Page 268



**Dividing head**  
Page 270



**Precision mini chuck**  
Page 274



**34 mm precision three-jaw chuck**  
Page 275



**50 mm precision three-jaw chuck**  
Page 276



**65 mm precision three-jaw chuck**  
Page 277



**Small-parts clamp, stepped jaw**  
Page 278



**Small-parts clamp, smooth**  
Page 279



**Small-parts clamp with prism jaw**  
Page 280



**Small-parts clamp with screw tightener**  
Page 280



**Stop for small-parts clamps**  
Page 281



**U-clamp**  
Page 281



**Magnet**  
Page 282



**Parallel clamps**  
Page 283

Other clamping elements  
+ accessories



**Multispannfix**  
Page 284



**Nadelfix 2.5**  
Page 286



**Inspection vice**  
Page 287



**Four-way hexagon key**  
Page 287



## Sets



**Schienenfix basic sets**

Page 288



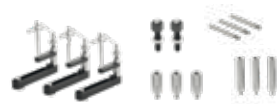
**Schienenfix expansion sets for turned parts**

Page 290



**Schienenfix expansion sets for milled and plate parts**

Page 291



**3-point support set**

Page 292



**Pallets with clamping elements**

Page 293



**Universal clamping sets**

Page 294



**Clamping component sets**

Page 296

# Perfect modularity for optical and multi-sensorial measuring with zero-point referencing

The outstanding advantages begin with the simplest toothed rail angle rests:

- Wide or fine tooth pitch as a secure yet virtually transparent unit for easy edge measurement
- Standard tooth pitches for precise repeat aligning of parts or structural elements
- Integrated T-slot for redesigning the rest angle or expansion to more complex base rail layouts
- T-slot as a mount for a wide range of attachable base, structural, adjustment, support and clamping elements

"Fast Reassembly Lifelong" also and particularly applies to *SCHIENENFIX*, which not only fully integrates the *SWA39* parts via standard interfaces, but also offers interfaces for the *SWA5* and *SWA8* quick-change adapter systems. dk only supplies rigid angles milled from solid material or Plexiglas plates with tapped holes if very special parts require them or if special processes are improved by them. Interchangeable pallet systems to set-up outside the machine for measuring other identical or completely different test parts are available

in many variants with all conceivable workpiece carriers.

dk *FIXIERSYSTEME* developed and standardised these efficient interchangeable systems as part of the *SPANNFIX* range from the conception of optical measurement technology.



## Basic elements

- 1 Base rails (page 228)



- 2 Connecting rails (page 229)



- 3 Rail connecting pieces (page 230)



## Structural elements

- 6 Clamping claws (page 231)



- 10 Quick-action clamp 90° angle element (page 235)



- 12 Rotary swivel mount (page 239)



- 13 Thread adapter (page 206)

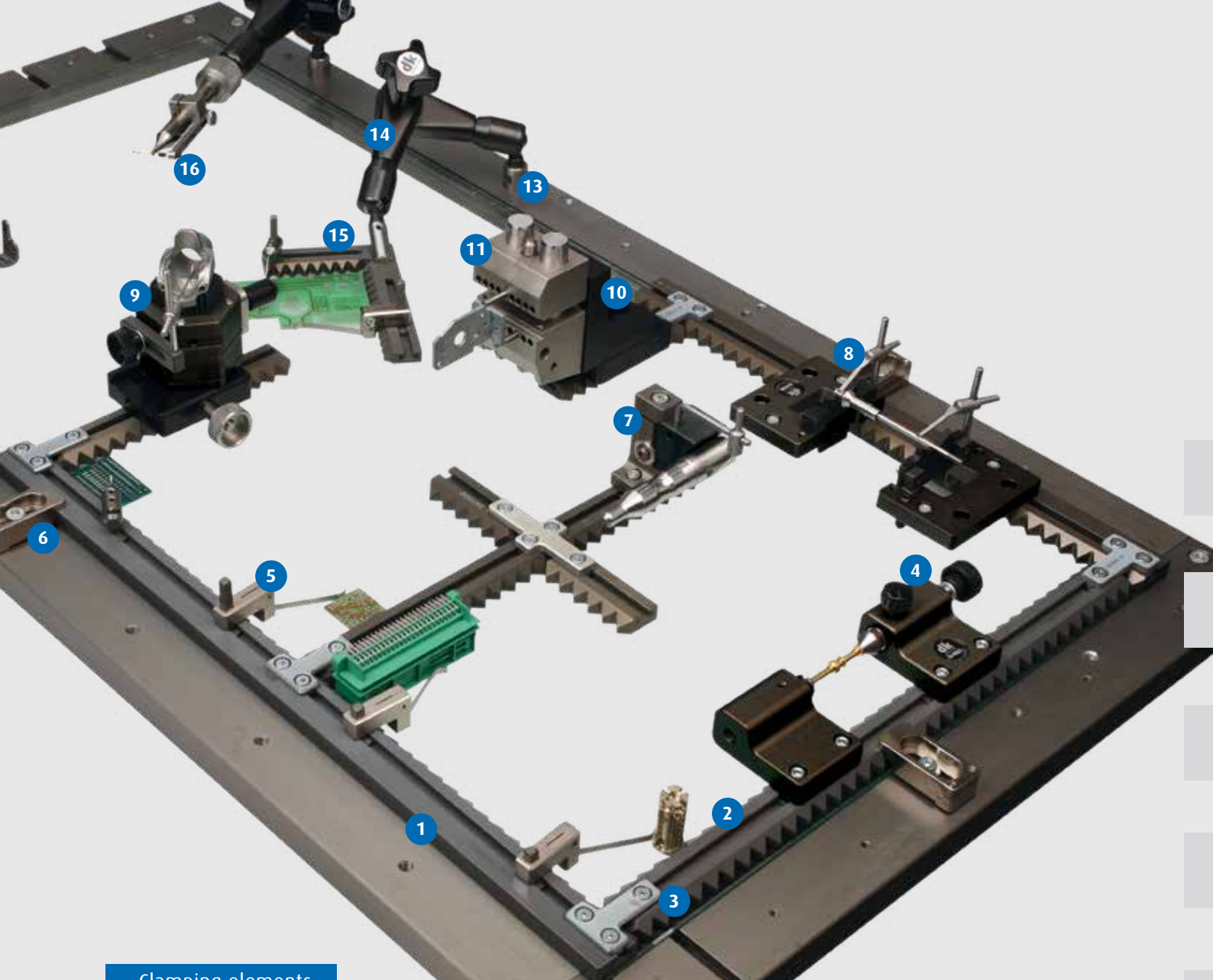


- 14 Articulated arm (page 236)



Other accessories (page 237)





## Clamping elements

- 4 Mini tailstock (page 266)  
Other accessories (pages 26 & 269)



- 5 Spring finger for horizontal clamping (page 242)



- 7 V-block bracket (page 263)



- 8 V-blocks (page 264)



- 9 Nadelfix 2.5 (page 286)



- 11 50 mm precision vice (page 257)



- 15 Stop angle with spring finger (page 247)



- 16 Small-parts clamp, stepped jaw (page 278)



## FAST REASSEMBLY LIFELONG

The basic principle of all dk fixing systems. The compatibility of the dk programs makes the utility value perfect.

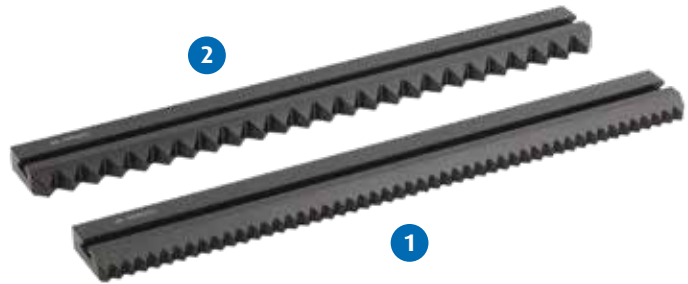
Base rails

Description

Single-side toothed rail with T-slot. To use as a rest or for mounting modular structural and clamping elements. With 5 mm or 10 mm tooth pitch.

Material

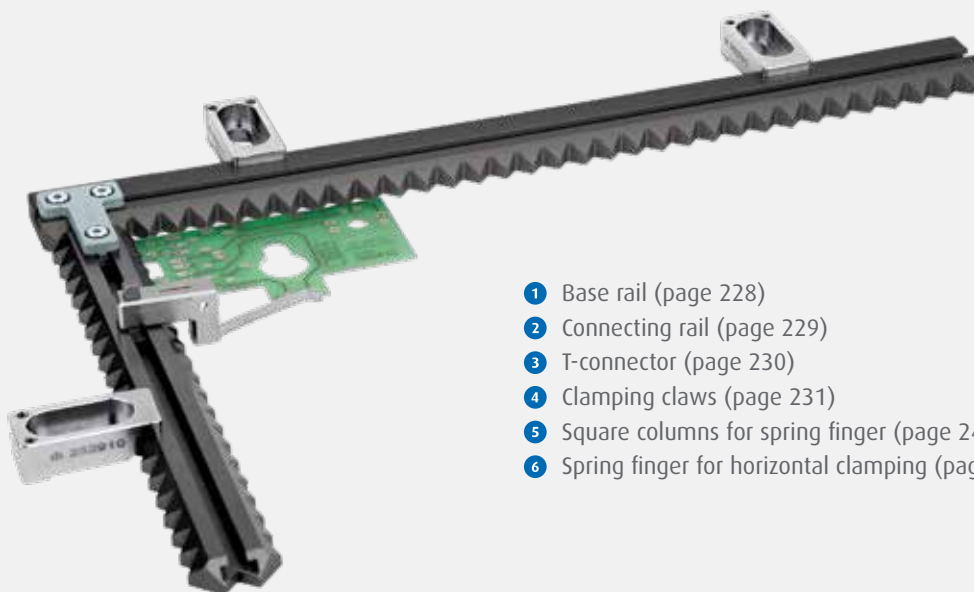
Hard-coated aluminium.



Order No.	Tooth pitch	Length	Width	Height	Fig.
344920	5	200	28	10	
345020	5	250	28	10	1
345220	5	350	28	10	
345420	5	450	28	10	
345620	5	500	28	10	
344900	10	200	28	10	
345000	10	250	28	10	2
345200	10	350	28	10	
345400	10	450	28	10	
345600	10	500	28	10	
2999XX	5 or 10	acc. to customer specs.		10	

T-Nut 5

Application example



- 1 Base rail (page 228)
- 2 Connecting rail (page 229)
- 3 T-connector (page 230)
- 4 Clamping claws (page 231)
- 5 Square columns for spring finger (page 243)
- 6 Spring finger for horizontal clamping (page 242)

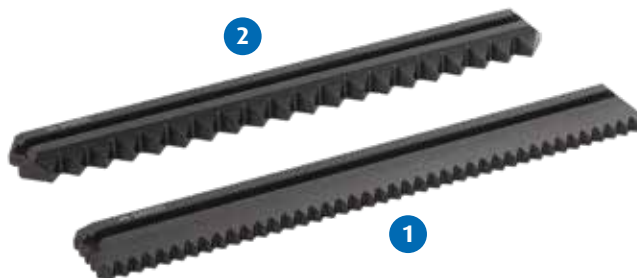
## Connecting rails

### Description

Rails with T-slot to use as a rest or for mounting modular structural and clamping elements. Connecting rails, toothed on 2 long sides and one end face. Rails toothed all 4 sides can also be used as connecting rails between 2 other rails. Angle or frame constructions also possible as a combination of different tooth pitches.

### Material

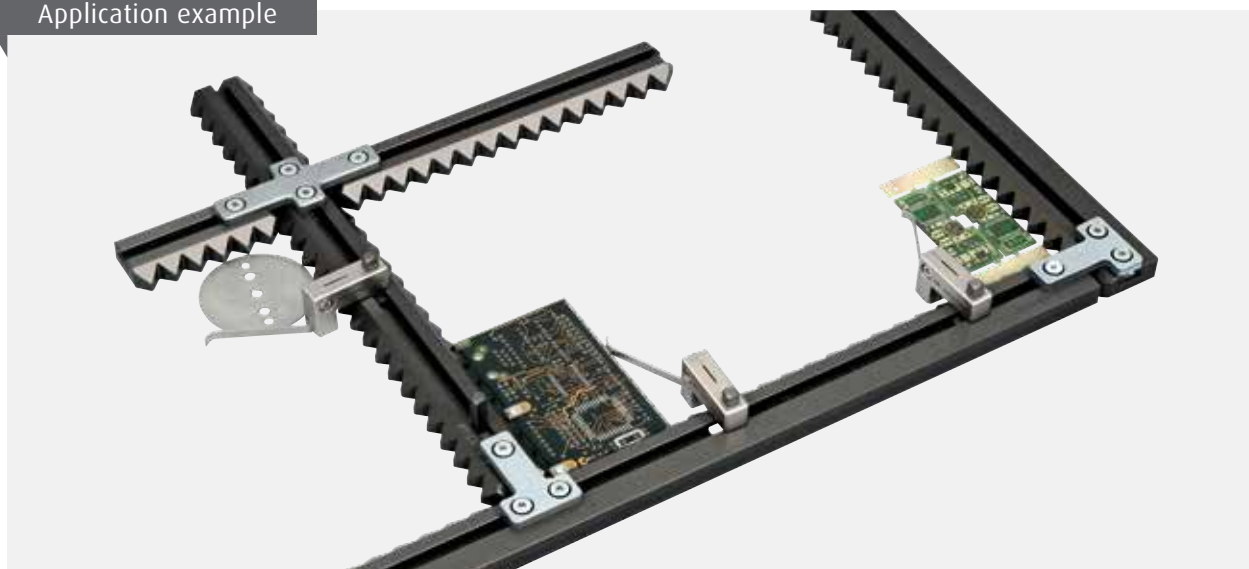
Hard-coated aluminium.



Order No.	Grid	Tooth pitch	Length	Width	Height	Fig.
347020	3	5	60	28	10	
347220	3	5	100	28	10	
347420	4	5	150	28	10	
346020	4	5	200	28	10	1
346220	4	5	250	28	10	
346420	4	5	350	28	10	
346620	4	5	400	28	10	
347000	3	10	60	28	10	
347200	3	10	100	28	10	
347400	4	10	150	28	10	
346000	4	10	200	28	10	2
346200	4	10	250	28	10	
346400	4	10	350	28	10	
346600	4	10	400	28	10	

T-Nut 5

### Application example



Rail connecting pieces

Description

Connecting piece for toothed rails.  
Aligned and clamped in a T-slot.

Material

Hard-coated aluminium/steel.

Supplied with

T-slot nuts and fastening screws.



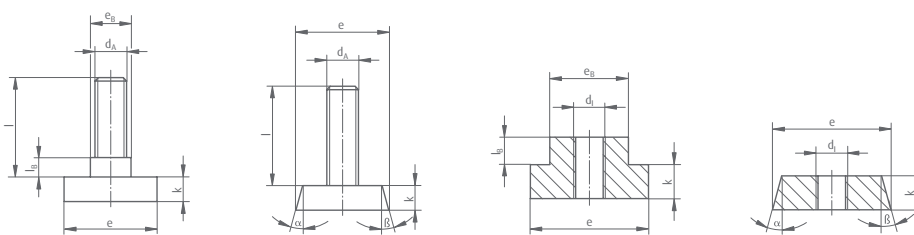
Order No.	Form	Length	Width	Height	Fig.
348000	T connector	28	40	3.5	1
348200	Cross connector	28	73	3.5	2

T-Nut 5

T-slot nuts and screws

Description

T-slot nuts and screws for clamping claws, fastening joints and satellite mounts.



Order No.	dA	dl	e	eB	k	l	lB	$\alpha$	$\beta$	Type
265300	M 5	-	10	-	2.5	14.5	-	-	-	I
265310	M 5	-	10	-	3	20	-	-	-	I
264100	M 5	-	11.8	-	2.8	15	-	-	-	I
265000	M 6	-	10.2	-	1.8	12	-	-	-	I
264600	M 6	-	11	-	4.8	16	-	-	-	I
264000	M 6	-	11.8	-	2.8	10.5	-	-	-	I
264800	M 6	-	15	7.9	7	15	5	-	-	I
347700	-	M 4	10	-	2.5	-	-	-	-	IV
264700	-	M 5	11	-	4.8	-	-	-	-	IV
265500	-	M 5	15	7.9	7	-	5	-	-	III

## Clamping claws

### Description

Clamping claw for clamping toothed rails to the measuring equipment table. Setscrews enable compensation for height differences of the glass plate. Different clamping claw lengths to match the distance between the measuring field on the machine and the mounting holes on the measuring table.



### Supplied with

Fastening screws. When clamping in a T-slot, order T-slot nuts separately.

↳ See page 244 for T-slot nuts

Order No.	Length	Fastener/thread	Measuring field to hole centre
262910	35	no screw	35-55
262914	35	M 4	35-55
262915	35	M 5	35-55
262916	35	M 6	35-55
262918	35	M 8	35-55
262920	45	no screw	35-65
262924	45	M 4	35-65
262925	45	M 5	35-65
262926	45	M 6	35-65
262928	45	M 8	35-65
262940	60	no screw	60-80
262944	60	M 4	60-80
262945	60	M 5	60-80
262946	60	M 6	60-80
262948	60	M 8	60-80
262950	110	no screw	70-110
262954	110	M 4	70-110
262955	110	M 5	70-110
262956	110	M 6	70-110
262958	110	M 8	70-110

M ...

### Application example



Clamping elements

Description

Fastening set for connecting toothed rails. Connecting rails can be secured in the T-slot of the lower rail using these clamps.



Application example



Order No.

Contents

349800

1 set of 2 clamps

T-Nut 5

Application example





## Base mount

### Description

SWA 39 quick-action clamp for the direct mounting of fixturing modules from the SWA 39 product range on measuring equipment tables. With slot for screws up to M6.

### Material

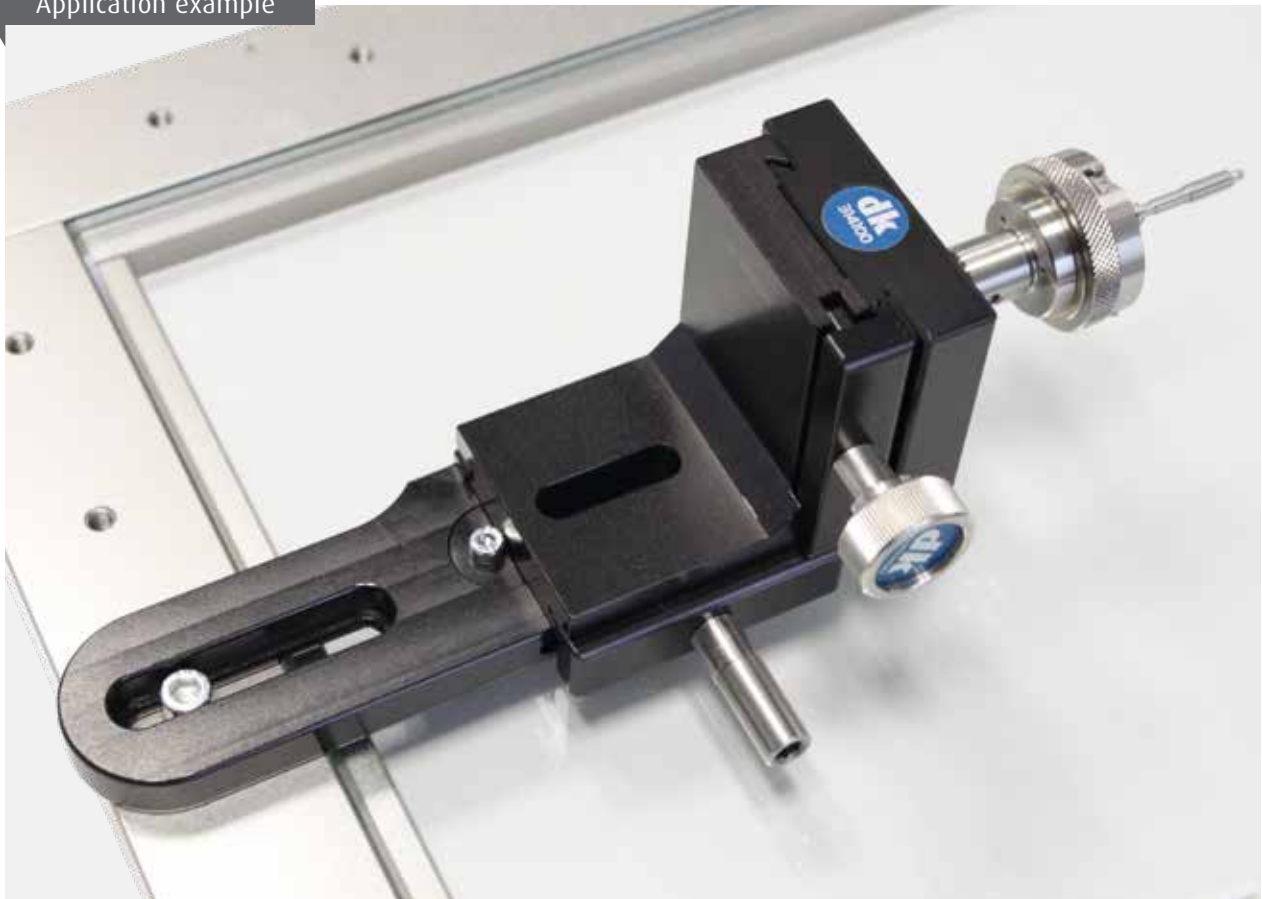
Hard-coated aluminium.



Order No.	Length	Width	Height
263710	150	85	15

SWA 39  
M ...

### Application example



Quick-action clamp

**Description**

SWA 39 quick-change mount for mounting on toothed rails. Alignment on T-slots via centring pins in the base.

**Material**

Hard-coated aluminium/steel.

**Supplied with**

T-slot nuts.



Order No.	Length	Width	Height
273320	80	63	15

SWA 39  
T-Nut 5

Application example



## Quick-action clamp 90° angle element

### Description

Quick-action clamp angle element for mounting clamping elements. The angle element is fitted to a quick-action clamp or can be fastened using screws up to M8.

### Material

Hard-coated aluminium.



### Application example



Order No.	Length	Width	Height
283300	60	90	48

SWA 39

SWA 39  
M ...

## 90° angle element

### Description

Angle element for mounting quick-action clamp 273320 from the SWA 39 product range. The angle element is mounted directly onto the toothed rail.

### Material

Hard-coated aluminium.

↳ For quick-action clamp, see page 234.



### Application example



Order No.	Length	Width	Height
273330	25	40	50

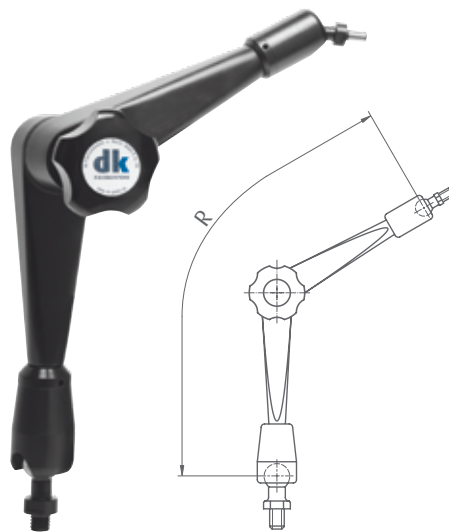
T-Nut 5

Articulated arms

Description

Progressive clamping articulated stands with a connection screw in the base and a quick-change adapter on the arm. Mechanical articulated arm. Central locking. Holding force at right angles 100 N (type MU) or 80 N (type SU).

↳ For thread reducer for other thread sizes, see page 168.



Application example



Order No.	Model	Thread	Adapter	Action radius (R)
296800	SU	M 8	SWA 5	160
296700	SU	M 8	SWA 8	160
296900	MU	M 10	SWA 5	280
297000	MU	M 10	SWA 8	280

SWA 8	SWA 5
M ...	M ...

Satellite mounts

Description

Adapter for mounting articulated arms on tables with slots or threads. This element enables the articulated arm to be position at a shallower angle.

Material

Stainless steel.

Contents

Supplied without T-slot nut.

↳ For T-slot nuts, see page 230. Ordering information: include the thread size on your measuring equipment.



Application example



Order No.	Connection	Joint connection	For articulated arm	Mount
269700	M4-M8 or slot	M 8	SU	Horizontal

M ...	M ...
T-Nut	M ...

## Rotary unit

### Description

Attachment module that indexes every 90°. This module enables equipment such as small-parts clamps or magnetic V-blocks to be rotated and indexed every 90°.

### Material

Stainless steel.



### Application example



Order No.	Length	Connection 1	Connection 2
269600	30	SWA 5 female	SWA 5 male

SWA 5

### Application examples



SWA 5/SWA 8 quick-change mount

Description

SWA 5 and SWA 8 quick-change mount. Mounted on quick-change clamp SWA 39 or T-slot nut for mounting in T-slots 5.

Material

Stainless steel.



Application example



Order No.	Length	Width	Height	Bottom adapter	Top connector	Fig.
314620	15	15	17	T-slot	SWA 5	1
314100	60	60	34	SWA 39	SWA 5	2
314200	60	60	34	SWA 39	SWA 8	2

SWA 5	SWA 5	SWA 8
T-Nut 5	SWA 39	SWA 39

Application example



## Rotary unit with fine adjustment and indexing

### Description

Free rotating spindle, indexing every 30° and can be clamped at any rotary angle. With SWA 5 connection for many clamping elements such as mini chucks and small-parts clamps. Position of increments and horizontal spindle position can be finely adjusted. Mounting on toothed rail or measuring table.

### Material

Hard-coated aluminium/stainless steel.

### Supplied with

T-slot nut and fastening screw for mounting on toothed rails. With operating tools



### Application examples



Order No.

Centre height

Swivel

Weight

314900

25

± 15°

0.17

SWA 5  
T-Nut

SWA 5  
M ...

### Application example



Quick-change pallet system

Description

Pallets with T-slot and M6 threads for mounting diverse clamping modules. For reproducible positioning the pallets can be set against a square and held there using spring fingers or toggle clamps. Can also be held magnetically using fixation set 345815.

Material

Hard-coated aluminium.

↳ Special sized versions available on request.



Order No.	Outer dimensions	Window dimensions	Version	Fig.
345801	305 x 100 x 10	200 x 72	Normal	1
345821	195 x 100 x 10	160 x 72	Short	2
345830	305 x 136 x 10	200 x 100	KY	
345815	Fixation set for magnetically holding pallets on toothed rail angles			3

T-Nut 5

M 6

Application example





# Benefits of the quick-change pallet systems from dk

- Universal and mobile carrier plate
- Elements from the SWA 39, SWA 5 and SWA 8 systems can be mounted and positioned
- Improved metrology machine OEE through setup and fixating the test piece outside the machine
- Precise repeat positioning on the machine by using the rail system
- Rapid, tool-free positioning and fixation on dk rail systems using magnetic contacts or mechanically with spring fingers or toggle clamps
- Measuring table not occupied with permanently mounted clamping modules
- Durable aluminium hard-coat pallets instead of fragile acrylic glass
- no acrylic glass between test part and light source and thus no falsifying deflection of light by thread matrix and damage to the sensitive plastic surface
- Ideal utilization of the metrology machines together with the dk toothed rail system, which can be assembled in completely arbitrary geometries and also permits the placement of several pallets



## Application examples



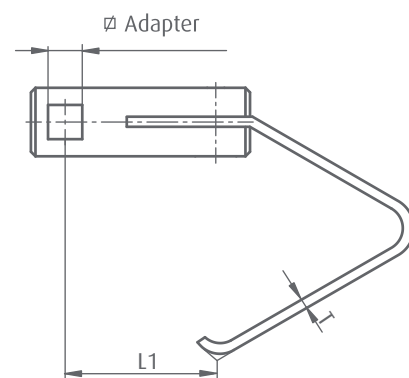
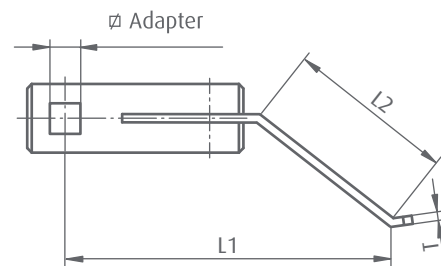
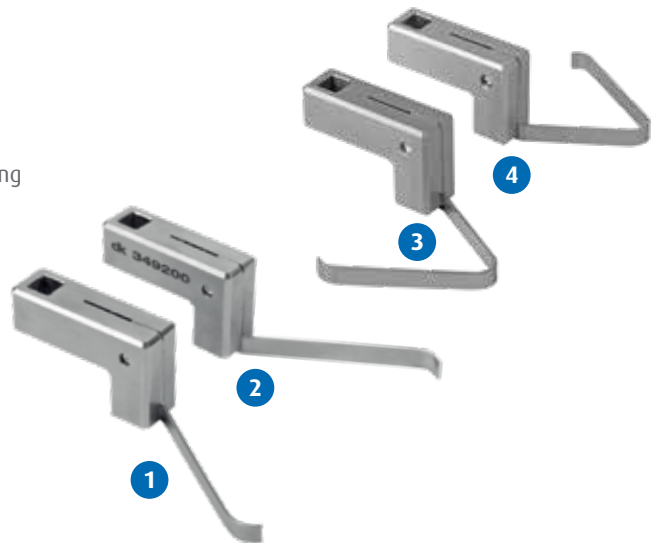
Spring fingers for horizontal clamping

Description

Spring fingers for clamping workpieces horizontally on toothed rails. Versions with different finger lengths and for right or left clamping. Small parts can be held in the angle corners using the bent finger versions. Lock effected by tilting the spring finger adapter (5 mm square).

Material

Brass/stainless steel.



Application example



Order No.	Adapter square $\varnothing$	Clamping direction	T	L1	L2	Fig.
349100	5	Left	0.6	60	34	1
349200	5	Right	0.6	60	34	2
349300	5	Left	0.6	66	50	
349400	5	Right	0.6	66	50	
349150	5	Left	0.6	23	-	3
349250	5	Right	0.6	23	-	4

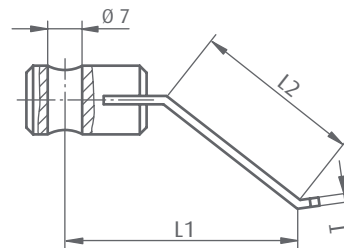
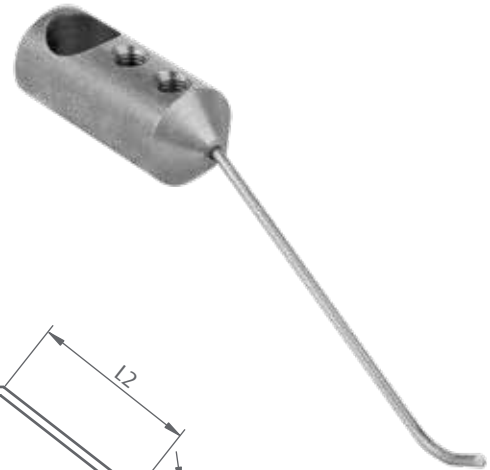
## Spring fingers for vertical clamping - square column

### Description

Spring finger for the vertical clamping of test parts on rail elements. Lock effected by tilting the spring finger adapter (5 mm square).

### Material

Hard-coated aluminium/steel.



Order No.	Adapter $\varnothing$	Version	T	L1	L2
269100	5	Round	1.1	50	34
268100	5	Round	1.1	70	50

## Square columns for spring fingers

### Description

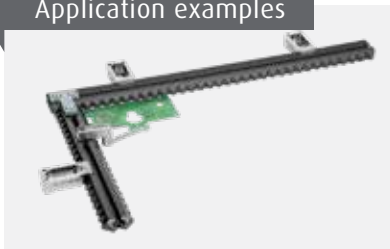
Clamping column (5 mm square) for mounting spring fingers. For T-slots.

### Material

Hard-coated aluminium.



### Application examples



Order No.	Mount $\varnothing$	Length
268500	5	20
268600	5	30
268700	5	50

T-Nut

Accessories

+ Spring fingers for vertical clamping - round column

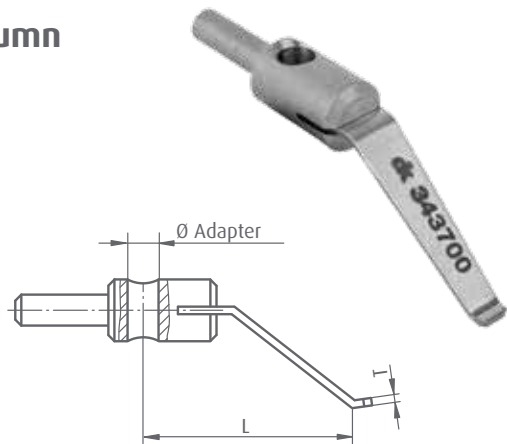
**Description**

Quick and easy holding of workpieces.

**Material**

Stainless steel

Order No.	Adapter Ø	Version	T	L
269037	4	Flat	0.4	30
343700	4	Flat	0.8	30
343710	4	Flat/narrow	0.8	30



+ Columns for spring fingers

**Description**

Columns for mounting spring fingers.

**Material**

Stainless steel

Order No.	Column Ø	Thread	Length
269042	4	M 4	30
269043	4	M 4	50
269044	4	M 4	75



+ Slot key for spring fingers

**Description**

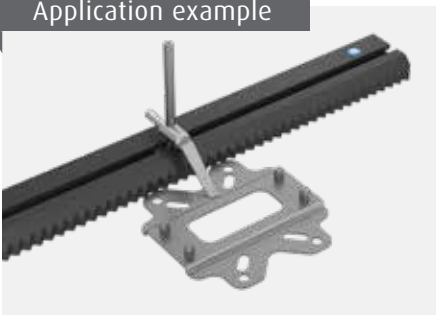
Slot key for mounting 4 mm round columns on slot rails and quick-change pallets of the Schienenfix range.

**Material**

Stainless steel



Application example



Order No.	Suitable for	Thread
347700	T-slot 5	M 4

## Spring finger for vertical clamping – SWA 5

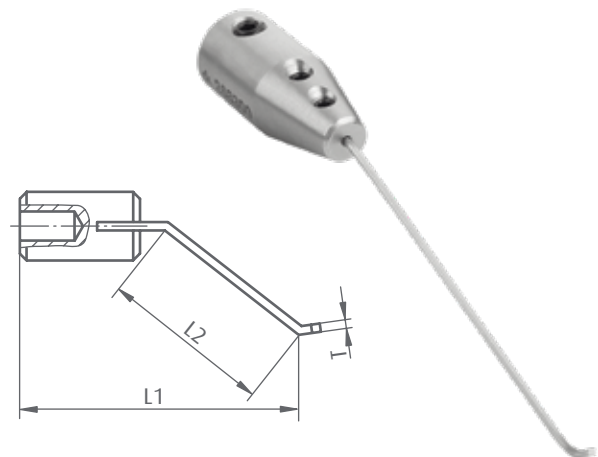
### Description

Spring fingers with SWA 5 quick-change mount.  
The spring fingers clamp can be flexibly positioned using an articulated arm.

### Material

Stainless steel.

### Application example



SWA 5

Order No.	Adapter Ø	Version	T	L1	L2
269300	SWA 5	Round	1.1	60	34
268300	SWA 5	Round	1.1	75	50

## Spring finger with fastener

### Description

Spring finger with mount for toothed rails. Columns with M4 threads can be mounted vertically or horizontally on the holder.

### Material

Aluminium/stainless steel.

### Supplied with

Spring finger (343700), column (269043) and column holder (347900).

↳ For other spring fingers, see the "Spannfix" section on page 59 or for columns with other lengths see page 60.



### Application examples



T-Nut 5

Order No.	Length	Width	Height
267915	90	12	14

Stop set

Description

The stop teeth are located on the toothed rails and can be positioned anywhere along the T-slot. Complex parts can be positioned securely and reproducibly with three point of contact. The stop teeth are available in two lengths.

Material

Hard-coated aluminium/stainless steel.

Supplied with

3x stop teeth and 3x connectors (348100).



Order No.	Tooth length	Version	Fig.
347500	30 mm	Aluminium	1
347510	50 mm	Aluminium	

Application example



## Rest angle with spring clamp

### Description

Toothed rail angle with T-slot and two spring fingers for holding small parts. With the integrated quick-change interface SWA 5, the angle can be flexibly positioned on the measuring table using an articulated arm.

### Material

Hard-coated aluminium/stainless steel.

### Supplied with

2 T-slot nuts (268600) and 2 spring fingers.

For 268900: 1 x 269200, 1 x 269100

↪ For articulated arms, see page 236.



Order No.	Connection	Leg length	Leg height	Tooth pitch
268900	SWA 5	120 x 80	10	7.5

T-Nut 5  
SWA 5

### Application examples



Small screw jack set

Description

Adjustable base rail with height-adjustable support.

Supplied with

1x base rail (322050), 1x 15 mm extension piece (322250),  
1x screw jack (322750), 1x T-slot nut (347700).

Application example



Order No.	Adjustment range	Length	Width	Height
322001	50	81	12	53

T-Nut 5

Small screw jack set with spring finger

Description

Adjustable base rail with height-adjustable support.  
With spring finger for holding the workpiece.

Supplied with

1x base rail (322050), 1x 15 mm extension piece (322250),  
1x screw jack (322750), 1x 30 mm adapter plate (353750), 1x 50 mm  
column (269043), 1x spring finger (343700),  
1x T-slot nut (347700).

Application example



Order No.	Adjustment range	Length	Width	Height
322006	50	81	12	80

T-Nut 5



## Accessories

### + Base rail

#### Description

Adjustable base rail with slot and M 6 mounting thread.

#### Supplied with

Fastening screw and T-slot nut.



Order No.	Adjustment range	Total length	Width	Height
322050	50	81	12	10
322051	50	131	12	10

### + Mounting plates

#### Description

Mounting plates for spring finger columns with M 4 or M 6 thread. For mounting on extension pieces or directly on base rail.



Order No.	Thread for columns	Mounting hole	Overhang
353750	M 4	6	30
353850	M 6	6	50

### + Columns for spring fingers

#### Description

Columns for holding spring fingers.



Order No.	Column Ø	Thread	Length
269042	4	M 4	30
269043	4	M 4	50
269044	4	M 4	75
368100	6	M 6	30
368200	6	M 6	50
368300	6	M 6	75

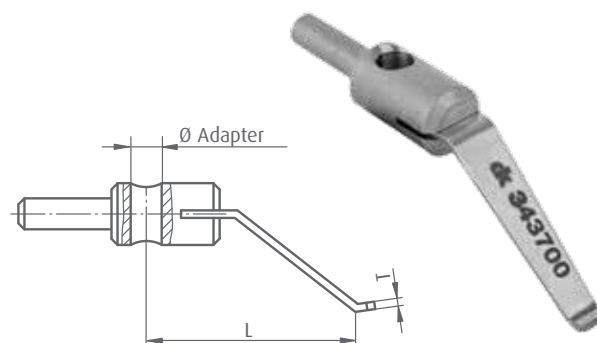
### + Spring finger

#### Description

For the quick and easy holding of workpieces.

For other versions, see page 130.

Order No.	Adapter Ø	T	L
269037	4	0.4	30
343700	4	0.8	30
302800	6	1	50



Accessories (continued)

**+ Screw jacks**

**Description**

Height-adjustable supports for supporting test parts.  
With M 6 thread an adjustment range of 15 mm.



Order No.	Version	Length	Fig.
322750	With R3 mm ball end	40	1
323050	Self-aligning pad, steel, +/- 10°	35	2
323070	Ø 6 mm magnet, magnetic force 5 N	42	3

**+ Hexagonal extension pieces**

**Description**

Extension pieces with M 6 male and female thread.  
Width across flats 10 mm.



Order No.	Male thread	Female thread	Length
322250	M 6	M 6	15
322350	M 6	M 6	25
322450	M 6	M 6	50

## Horizontal toggle clamp for toothed rails

### Description

Horizontal toggle clamp for mounting on toothed rails.

### Material

Steel/hard-coated aluminium.

↳ Risers can be used to increase the clamping height, see below.



Order No.	Overhang	Clamping range	Height
336900	18-32	0-16	35

T-Nut 5

## Accessories

### + Risers

#### Description

1 pair of risers to increase horizontal toggle clamp height.

#### Material

Hard-coated aluminium.



Order No.	Height
349640	12
349645	30

T-Nut 5

## Application example



15 mm precision vice

Description

Miniature vice with prism jaw. With SWA 39, SWA 5 or M 4 connection. Brass or stainless steel versions available. M4 hole centre distance is 42 mm.

Supplied with

Stainless steel (270921) and plastic exchangeable jaws.



SWA 39	SWA 5	M ...
--------	-------	-------

Order No.	Version	Jaw width	Clamping width	Total height	Material	Fig.
270910	SWA 39	15	14.5	61	Brass	1
270915	SWA 39	15	14.5	61	Stainless steel	1
270900	SWA 5	15	14.5	27	Brass	2
270905	SWA 5	15	14.5	27	Stainless steel	2
270920	2 x M 4	15	14.5	15	Brass	3
270925	2 x M 4	15	14.5	15	Stainless steel	3

Accessories

+ Prism jaws

Order No.	Material	Jaw width	Supplied with	Description
270921	Stainless steel	15	1 set with 1 smooth and 1 prism jaw	With vertical and horizontal prisms



+ Stepped jaw

Order No.	Material	Jaw width	Contents	Description
270922	Stainless steel	15	1 jaw	Step height 1.5 mm Step depth 1 mm



Application examples



25 mm precision vice

Description

Miniature vice with prism jaw. With SWA 39, SWA 5 or M 4 connection. Aluminium and stainless steel versions available. M4 hole centre distance is 62.5 mm.

Supplied with

Stainless steel (270971) and plastic exchangeable jaws.

Application example



1



2



3

SWA 39

SWA 5

M ...

Order No.	Version	Jaw width	Clamping width	Total height	Material	Fig.
270960	SWA 39	25	24.5	53	Aluminium	1
270965	SWA 39	25	24.5	53	Stainless steel	1
270950	SWA 5	25	24.5	38	Aluminium	2
270955	SWA 5	25	24.5	38	Stainless steel	2
270970	2 x M 4	25	24.5	25	Aluminium	3
270975	2 x M 4	25	24.5	25	Stainless steel	3

Accessories

+ Prism jaws

Order No.	Material	Jaw width	Contents	Description
270971	Stainless steel	25	1 set with 1 smooth and 1 prism jaw	With vertical and horizontal prisms



+ Stepped jaw

Order No.	Material	Jaw width	Contents	Description
270972	Stainless steel	25	1 jaw	Stepped height 1.8 mm Step depth 1.3 mm



+ Stop

Order No.	Material	Length	Adjustment range
318250	Stainless steel/ aluminium	75	50



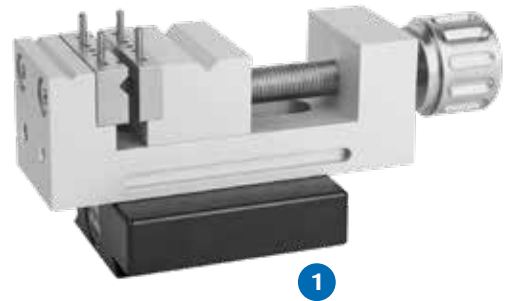
## 35 mm precision vice

### Description

M 5 connection. Aluminium and stainless steel versions available. Jaws with Ø2 mm holes for clamping pins. M5 hole centre distance is 83 mm.

### Supplied with

Stainless steel (270861) and plastic exchangeable jaws and 4x Ø2 pins.



1



2

### Application example



SWA 39

M ...

Order No.	Version	Jaw width	Clamping width	Total height	Material	Fig.
270850	SWA 39	35	34.5	55	Aluminium	1
270855	SWA 39	35	34.5	55	Stainless steel	1
270860	2 x M 5 / 4 x M 4	35	34.5	35	Aluminium	2
270865	2 x M 5 / 4 x M 4	35	34.5	35	Stainless steel	2

### Accessories

#### + Prism jaws

Order No.	Material	Jaw width	Contents	Description
270861	Stainless steel	35	1 set with 1 smooth and 1 prism jaw	With vertical and horizontal prisms



#### + Stepped jaw

Order No.	Material	Jaw width	Contents	Description
270862	Stainless steel	35	1 jaw	Step height 2 mm Step depth 1.5 mm



#### + Stop

Order No.	Material	Length	Adjustment range
318250	Stainless steel/ aluminium	75	50



50 mm precision centric vice

**Description**

Centric vice with stepped jaws and adaptation options for a range of accessory elements.  
 Pin holes for raised positioning of parts for access from all sides.  
 Versions with an SWA 39 quick-change adapter which can be offset through 90°.

**Material**

Surface-hardened steel and hard-coated aluminium.

**Supplied with**

4 pins, adjustable stop and operating tools.

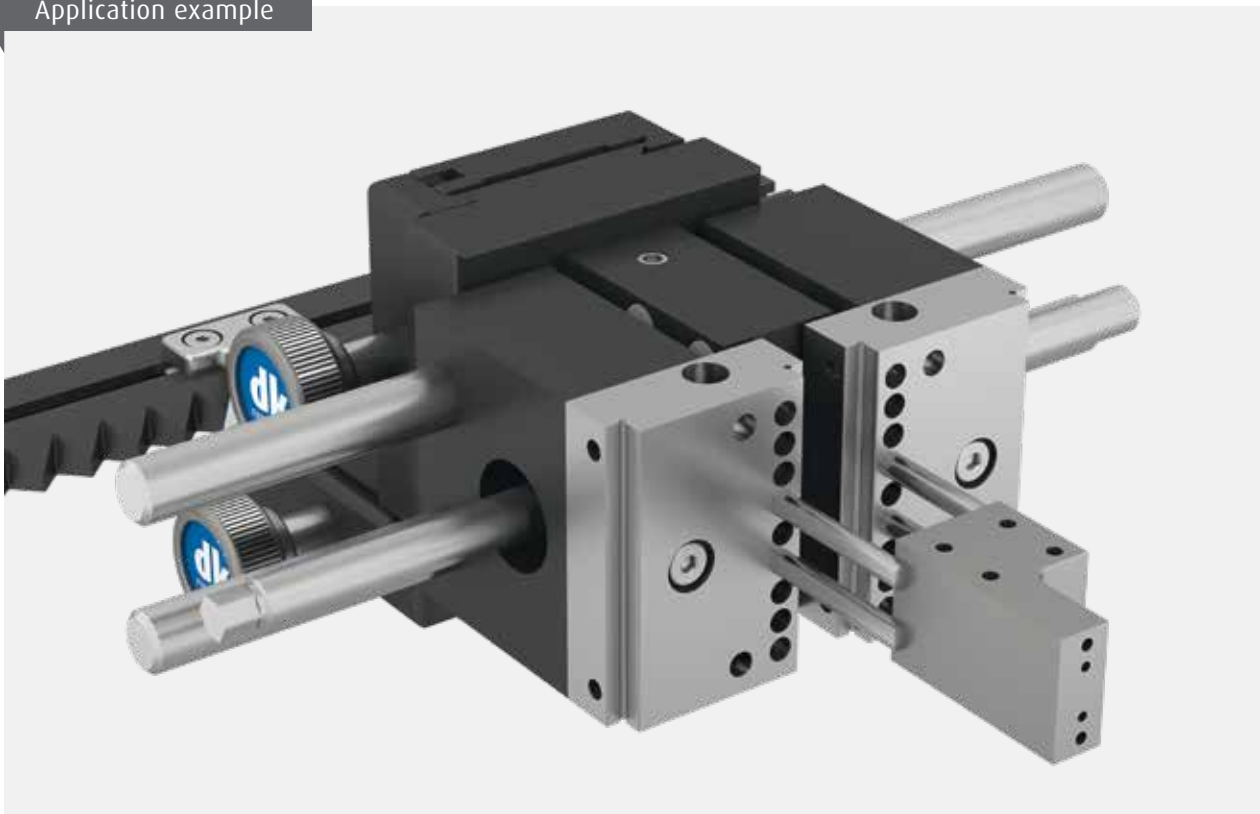


Order No.	Version	Jaw width	Clamping width
282150	SWA 39 (removable)	50	120 mm

SWA 39

M ...

Application example





## 50 mm precision vice

### Description

Vice with exchangeable clamping width extension guide shafts. With stepped jaws and Ø4 mm holes for clamping pins. Available with and without SWA 39 quick-change adapter and with and without accessories. The versions without quick-change adapter have 4 contact faces at right angles to each other.

### Material

Surface-hardened steel.

### Supplied with

Versions with accessories include an adjustable stop (318110), a set of shafts for extending the clamping width to 75 mm, 4 pins and a magnetic push-in knurled knob (282101).

✂ A quick-change adapter (397020) can be retrofitted on versions without SWA 39, see page 29.



1



2

### Application example



SWA 39

M ...

Order No.	Jaw width	Version	Accessories	Clamping width	Weight	Fig.
282100	50	SWA 39	yes	75*	1.05	1
282105	50	SWA 39	no	35*	0.87	
282110	50	4 contact faces	yes	75*	1.01	
282115	50	4 contact faces	no	35*	0.82	2

\* Can be extended up to 150 mm with extra shaft sets.

50 mm spring-loaded vice

**Description**

Spring-loaded clamping system for rapid and repeatable positioning with limitable clamping force. Can be set to push or pull. For horizontal or vertical mounting on slot rails of the dk SCHIENENFIX range or on quick-change pallets.

**Material**

Hard-coated aluminium.

**Supplied with**

Screws, T-slot nuts and springs in 3 different strengths.



Order No.	Version	Jaw width	Clamping width	Clamping force
349900	For T-slot 5	50	Unlimited	Limitable

T-Nut 5

Application examples



Accessories for all 50 mm clamping elements (centric clamping vice, vice, spring-loaded vice)

**+ Smooth jaws**

Order No.	Material	Jaw width	Contents	Description
282400	Stainless steel	50	1 set	-



**+ Prism jaws**

Order No.	Material	Jaw width	Contents	Clamping diameter
282700	Stainless steel	50	1 set with 1 smooth and 1 prism jaw	Recommended from 2 mm



**+ Prism jaws for end face clamping**

Order No.	Material	Jaw width	Contents	Clamping diameter
306610	Stainless steel	50	1 set	15-50 mm



**+ Smooth jaws for small parts**

Order No.	Material	Jaw width	Contents	Description
282410	Stainless steel	50	1 jaw	For clamping small parts in the stepped jaw



Application examples



Accessories (continued)

+ Pin jaws

Order No.	Material	Jaw width	Contents	Description
282430	Stainless steel	50	1 set	For shorter clamping widths



+ Two-point contact prism jaws

Order No.	Material	Jaw width	Contents	Clamping diameter
306900	Hard-coated aluminium	5	1 prism jaw and 1 straight jaw	3–20 mm



+ Three-point contact prism jaws

Order No.	Material	Jaw width	Contents	Clamping diameter
306800	Hard-coated aluminium	5+16	1 double prism jaw and 1 straight jaw	Recommended up to 30 mm



+ Clamping pins, stepped

Order No.	Contact face	Length	Contents	Description
282300	Straight	24 x Ø 4	Set of 4	For raised parts positioning
282310	Straight	35 x Ø 4	Set of 4	
326500	120° prism	25 x Ø 4	2 prism pairs	



+ Support discs with pins

Order No.	Version	Disc size	Contents	Description
338300	Adjustable	Ø 16 x 9	Set of 4	For raised parts positioning



+ Universal stop

Order No.	Material	Supplied with
277510	Steel	2 exchangeable stop points



+ Stop for 50 mm vices (not for spring-loaded vices)

Order No.	Material	Length	Overhang	Description
318100	Steel	50	20	
318200	Steel	50	40	
318110	Steel	150	20	
318210	Steel	150	40	



+ Knurled knob for 50 mm vice (not spring-loaded vice or centric vice)

Order No.	Version
282101	Magnetic
282102	Magnetic with adjustable torque, approx. 0.1–0.3 Nm



Application examples



V-block with spring finger

Description

Small 120° V-block for holding rotationally symmetrical parts with spring fingers. Mounted on an SWA 39 quick-change adapter.

Supplied with

Bracket (343800) and spring finger (343700).



Order No.	Clamping range	Prism length	Block width	Connection	Height	Fig.
277410	Ø 2-25	10	30	SWA 39	45	2
277400	Ø 2-25	25	30	SWA 39	45	3
267900	Ø 2-25	25	30	SWA 5	25	1



V-block with magnetic prism

Description

Small 120° V-block for holding parts magnetically. With an SWA 5 quick-change mount.

Material

Hard-coated aluminium.



Application example



Order No.	Clamping range	Prism length	Block width	Mount	Height
268000	Ø 2-25	25	30	SWA 5	25



## V-block holder

### Description

90° support for mounting small V-blocks on T-slot. The V-blocks can be clamped in 3 different positions.

### Material

Hard-coated aluminium/steel.

### Application example



Order No.	Length	Width	Height
267910	20	42	52

T-Nut 5

### Application example



V-block support

Description

V-block support set for holding shafts horizontally. The ends of the test pieces can be seen through the openings in the plate. The V-block supports can be mounted on the rail system at any distance from each other. The height of one of the V-blocks is adjustable. Prism width 4 mm.

Material

Aluminium/steel.

Supplied with

2 V-block supports with T-slot nuts, columns and spring fingers.



Order No.	Clamping range	Length	Width	Height
345100	Ø 2-28	75	50	40

T-Nut 5

Application example





## Application examples for special V-block supports

Special V-blocks for 2 shafts on a pallet.



Special V-blocks for 3 shafts on a pallet.



Small tailstocks

**Description**

Pair of tailstocks, one with a fixed centre and one with a movable centre, for mounting in T-slots. The movable centre is spring-loaded and can be locked. The tailstocks can be mounted left or right. The centre height of 22 mm when mounted on a toothed rail can be increased with riser blocks.

**Material**

Hard-coated aluminium/steel.

**Supplied with**

Dead centres  $\varnothing 12/60^\circ$  (2x 349758), T-slot nuts and fastening screws.



Order No.	Centre height
349600	12 (22 mm on toothed rails)

T-Nut 5

Application examples



## + Dead centres

### Description

60° centre for small tailstocks.

### Material

Steel.

Order No.	Point	Diameter	Version	Fig.
349758	60°	0-12	-	1
349759	60°	0-12	half centre	2
349770	60°	10-22	flat point	



## + Female centres

### Description

Female centres for small tailstock.

The end of the test piece can be viewed through the slit.

### Material

Steel.

Order No.	Cone	Clamping range	Slit width	Fig.
349700	90°	Ø 0.5-5	0.3	1
349720	90°	Ø 2-15	1	2
349730	90°	Ø 14-30	3	



## + V centres

### Description

V centre for small tailstock. The end of the test piece can be viewed through the slit.

### Material

Steel.

Order No.	Prism	Diameter	Slit width
349752	90°	2-15	1



## + Riser blocks

### Description

1 pair of riser blocks to increase tailstock

### height.

Hard-coated aluminium.

Order No.	Height
349640	12
349645	30



Tailstocks

Description

Pair of tailstocks with one fixed and one movable centre. The movable centre is spring-loaded and can be locked. Can be mounted on all elements with T-slot 6 i.e. baseplate 262510 or Spannfix Pro slot plates. The one-part version 306020 can be combined with dividing head 261050 (page 270).

Material

Hard-coated aluminium/steel.

Supplied with

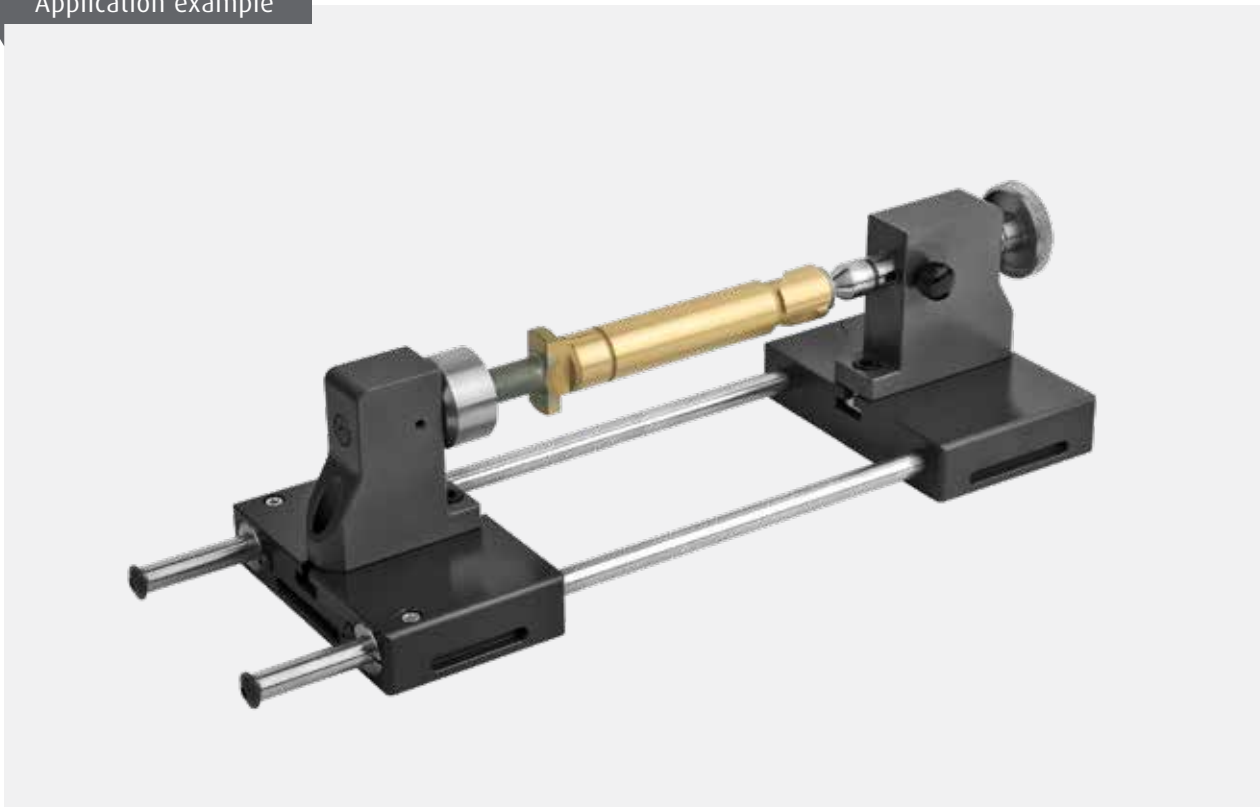
1 piece, movable centre only



Order No.	Version	Centre height	Width	Height	Fig.
306000	2 piece	50	30	75	1
306020	Single-part, only movable centre	50	30	75	

T-Nut 6

Application example



## + Adjustable baseplate

### Description

Mounting plate with 6 mm T-slot for mounting tailstocks and/or dividing heads. Suitable for transmitted light measurements on projectors. Infinite adjustment on shaft guides with lock. Plate can be anchored with clamping claws.

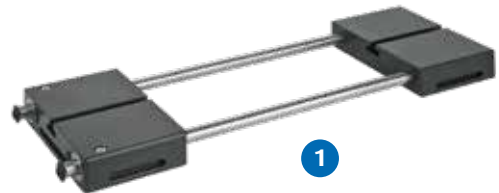
↳ For clamping claws, see page 271.

### Material

Hard-coated aluminium/steel.

### Clamping length

0–210 mm.



Order No.	Length	Width	Height	Fig.
262510	370	120	25	1

T-Nut 6

## + Revolving centres

### Description

60° live centre for movable tailstock.

### Material

Stainless steel. Point hardened.



Order No.	Point angle	Diameter
306110	60°	10
306120	60°	20

## + Dead centres

### Description

A set of dead centres.

### Material

Hardened steel.



Order No.	Point angle	Diameter
306100	60°	15–30

## + Female centres

### Description

A set of female centres.

### Material

Hardened steel.



Order No.	Cone angle	Diameter	Slit width
306320	90°	9–15	1.5
306325	90°	16–30	3

Dividing heads

Description

Dividing head with spindle ratio reduction 1:40. Precise indexing with a graduated dial and vernier scale. With ER16 collet chuck for 0.5–10 mm collets. Chucks from the range of accessories can also be mounted. Spindle locked with a knurled screw. The dividing head can be flexibly mounted using a variety of baseplates, attachment plates and mounting plates from the accessory range. Longer components can also easily be set up by using the movable tailstock (page 268) and the adjustable baseplate (page 271). The dividing head riser must be used for use with the tailstock.

Material

Aluminium/steel.

Supplied with

Collet chuck.



ER 16	ER 16
T-Nut 6	4x M4

Order No.	Version	Spindle concentricity	Vernier scale accuracy	Centre height	L/W/H	Mount	Fig.
261000	Standard	± 0.01 mm	± 10 min	24	90 / 120 / 60	4 x M 4	1
261050	Riser for use with tailstock	-	-	50	90 / 90 / 26	T-slot 6	

Application example



## + Adjustable baseplate

### Description

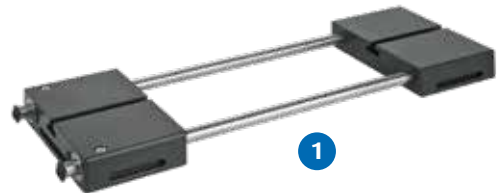
Mounting plate with 6 mm T-slot for mounting tailstocks and/or dividing heads. Suitable for transmitted light measurements on projectors. Infinite adjustment on shaft guides with lock. Plate can be anchored with clamping claws.

### Material

Hard-coated aluminium/steel.

### Span

0–210 mm.



Order No.	Length	Width	Height	Fig.
262510	370	120	25	1

T-Nut 6  
M ...

## + Attachment plate for clamping claws

### Description

Intermediate plates for dividing heads for mounting on measuring instruments and for raising the centre height when three-jaw chucks are used.



Order No.	Length	Width	Height	Fastening
262800	60	60	30	clamping claws

4 x M4  
M ...

## + Clamping claws

### Description

Clamping claw set for anchoring attachment plates for dividing heads. With slot for screws up to M8.

### Supplied with

2 claws with fastening screws acc. to customer specifications.



Order No.	Adjustment range	Length
263000	20	60

Accessories

**+ Mounting plate**

**Description**

Baseplate with SWA 39 quick-change mount for dividing heads. For mounting on SWA 39 quick-change clamps. For raising the centre heights when using three-jaw chucks.

**Material**

Hard-coated aluminium.



Order No.	Length	Width	Height
263100	60	60	20

**+ Display unit**

**Description**

Digital display unit for dividing heads. Display accuracy  $\pm 10$  s. Connection 230 V / 50 Hz.

**Supplied with**

Rotary encoders and connectors for standard dividing heads.



Order No.	Length	Width	Height
261200	235	220	85

Application example





## + Precision three-jaw chuck

### Description

Version with ER16 for mounting on dividing heads. Intermediate plates for raising the dividing head may be required with larger chucks or workpieces.

### Material

Steel



Order No.	OD	Mount	Concentricity	Information
261350	50	ER 16	± 0.04	On request
261351	65	ER 16	± 0.04	
261352	34	ER 16	± 0.04	On request

ER 16

## + Collets

### Description

For the dividing head collet chuck.

### Material

Steel



↪ A complete set of collets which includes all diameters can be ordered under part number 263450. See table below.

Order No.	Clamping Ø
263400	0.5-1
263401	1-2
263402	2-3
263403	3-4
263404	4-5
263405	5-6
263406	6-7
263407	7-8
263408	8-9
263409	9-10
263450	Complete set of collets 0.5-10 mm (art. No. 263400 to 263409)

ER 16

Precision mini chuck

Description

Precision mini chuck with inside jaws. For internal and external clamping of rotationally symmetrical parts. Mounted on SWA 39 or SWA 5 quick-change adapters.

Material

Hard-coated aluminium/steel.



Order No.	Connection	For OD	For ID	Height	Diameter	Fig.
283700	SWA 39	0.2-3	3-5	59	24	
283900	SWA 39	0.5-5	5-9	79	32	1
283600	SWA 5	0.2-3	3-5	60	24	2
283800	SWA 5	0.5-5	5-9	80	7932	



Application example



## 34 mm precision three-jaw chuck

### Description

Hand-operated three-jaw chuck with tool-free reversible jaws for internal and external clamping of rotationally symmetrical workpieces.

Chuck precision without further attachments:

Radial runout < 0.03 mm

Axial run-out < 0.01 mm

Repeat accuracy < 0.01 mm

With SWA 39 quick-change adapter. Also available with SWA 5 quick-change adapter which can be held on the shaft OD (14 mm).

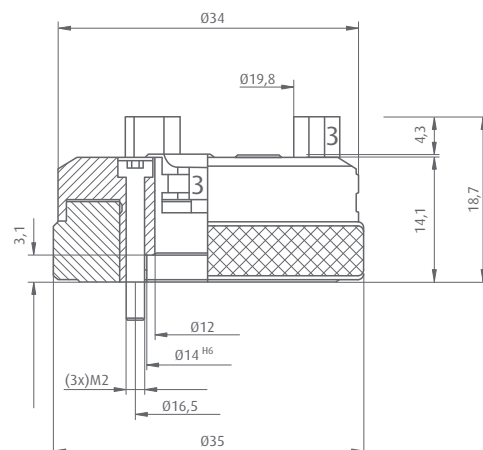
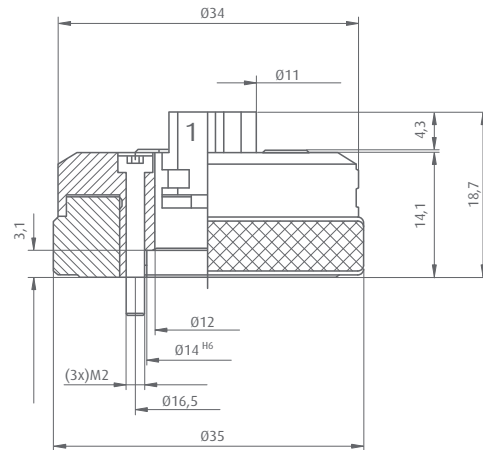
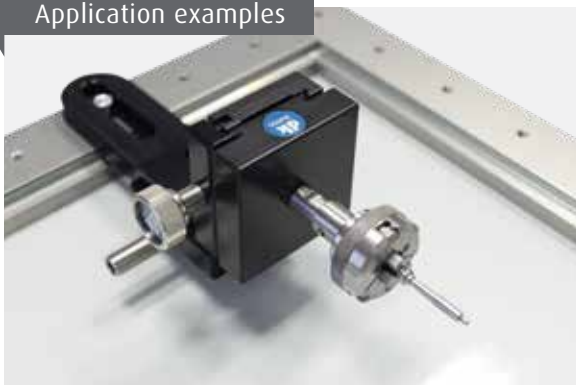
### Material

Completely stainless steel.

More information available in the SWA 39 section from page 16.



### Application examples



Order No.	Connection	Size	Height	SWA 39	SWA 5
329000	SWA 39	34	72		
329010	SWA 5	34	38.5		

50 mm precision three-jaw chuck

Description

Hand-operated three-jaw chuck with tool-free reversible jaws for internal and external clamping of rotationally symmetrical workpieces. With pin hole and 2 sets of pins in a range of heights for raised fixing of parts for access from all sides. Pin holes  $\varnothing 2$ , depth 7 mm.

Precision of jaw chucks without additional extensions:  
 Radial runout < 0.03 mm  
 Axial run-out < 0.01 mm  
 Repeat accuracy < 0.01 mm  
 With SWA 39 quick-change adapter. Also available with mounting holes or MK 2 supports.

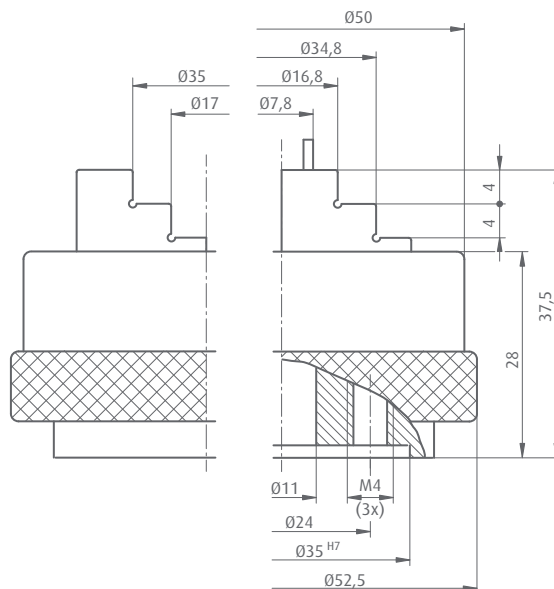
Material

Hard-coated steel and aluminium.

Supplied with

With control apparatus and 2 sets of 3 12 mm and 18 mm pins.

More information available in the SWA 39 section from page 62 onwards.



Order No.	Connection	Size	Height	Fig.
329705	SWA 39	50	58	1
329720	3 x M 4	50	38	2
329725	MK 2*	50	46.5	3



\* Other supports available on request.

## 65 mm precision three-jaw chuck

### Description

Hand-operated three-jaw chuck with tool-free reversible jaws for internal and external clamping of rotationally symmetrical workpieces. With pin holes and 2 sets of pins of different lengths for elevating parts for access from all sides. Pin holes  $\varnothing 2 \times 7$  mm deep.

Chuck precision without further attachments:

Radial runout < 0.03 mm

Axial run-out < 0.01 mm

Repeat accuracy < 0.01 mm

Available with SWA 39 quick-change adapter, mounting holes or MK 2 Morse taper.

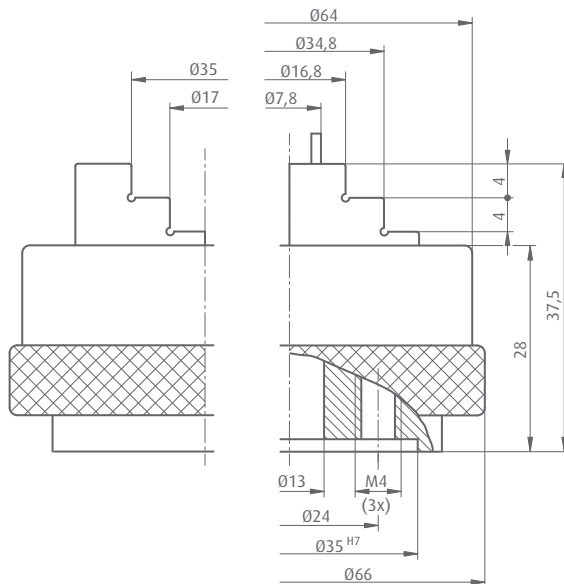
### Material

Hard-coated steel and aluminium.

### Supplied with

Operating tools and 2 sets of 3 pins, 12 mm and 18 mm long.

↪ More information in the SWA 39 section from page 62.



Order No.	Connection	Size	Height	Fig.
329700	SWA 39	65	58	1
329710	3 x M 4	65	38	2
329715	MK 2*	65	46.5	3

\* Other tapers available on request.

SWA 39

M ...

MK 2

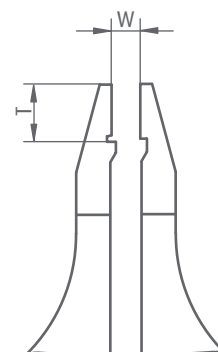
Small-parts clamp with stepped jaw

**Description**

Small-parts clamp with stepped jaw one side. For clamping small parts. Clamps with spring force. With an SWA 5 quick-change mount.

**Material**

Steel.



Order No.	Jaw width	Clamping width (W)	Jaw depth (T)	Length
265700	1.5	0-1.6	2.1	82
266100	3	0-1.6	2.1	82
266600	5	0-1.6	2.1	82

SWA 5

Application example



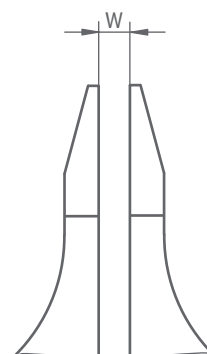
## Small-parts clamp, smooth

### Description

Small-parts clamp with smooth jaw. For clamping small parts. Clamps with spring force. With an SWA 5 quick-change mount.

### Material

Steel.



Order No.	Jaw width	Clamping width (W)	Length
265800	1.5	0-1.6	82
266000	3	0-1.6	82
266500	5	0-1.6	82

SWA 5

### Application example



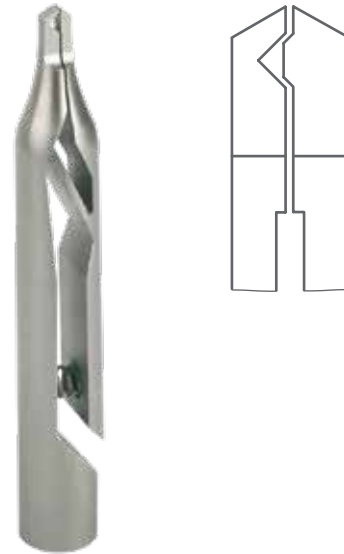
Small-parts clamp with prism jaw

Description

Small-parts clamp with prism jaw. For holding rotationally symmetrical parts. Clamps with spring force. With an SWA 5 quick-change mount.

Material

Steel.



Order No.	Jaw width	Clamping diameter	Length
265900	1.5	0.3-1.5	82
266200	2	0.5-2.0	82
266700	2.5	1.5-3.0	82

SWA 5

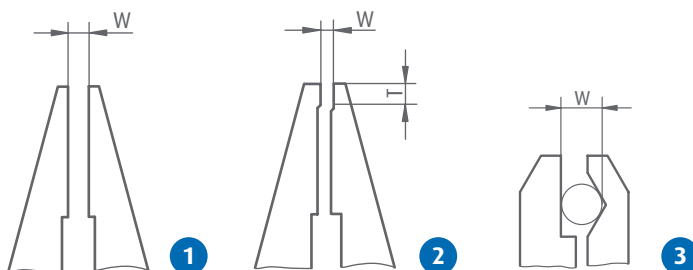
Small-parts clamp with screw tightener

Description

Small-parts clamps with different jaw types. Clamps with a screw. With an SWA 5 quick-change mount.

Material

Steel.



Order No.	Jaw type	Jaw width	Clamping width (W)	Jaw depth	Length	Fig.
267500	Smooth	4.8	0-5	-	82	1
267600	Stepped	4.8	0-5	1.8	82	2
267610	Prism	4.8	3.2-6	-	82	3

SWA 5



## Stop for small-parts clamps

### Description

Adjustable stop for small-parts clamps. Fits on all spring operated small-parts clamps.

### Material

Steel/stainless steel.



### Application example



Order No.	Length	Width	Height
266800	55	17	27

## U-clamp

### Description

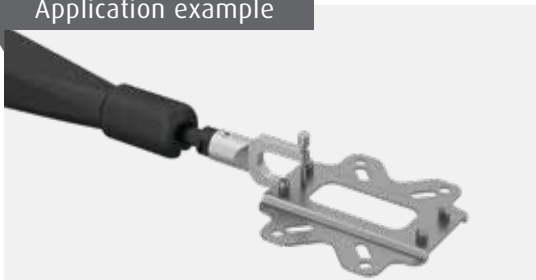
Micro U-clamp for holding small parts with a screw. Connection with an SWA 5 quick-change mount.

### Material

Stainless steel.



### Application example



Order No.	Jaw thickness	Clamping width	Clamping depth
266900	4	0-12	15

SWA 5

Magnet

Description

Permanent magnet with an SWA 5 quick-change mount.

Material

Stainless steel.



Order No.	Magnet Ø	Magnetic force (N)	Length
267810	16	95	26

SWA 5

Application example



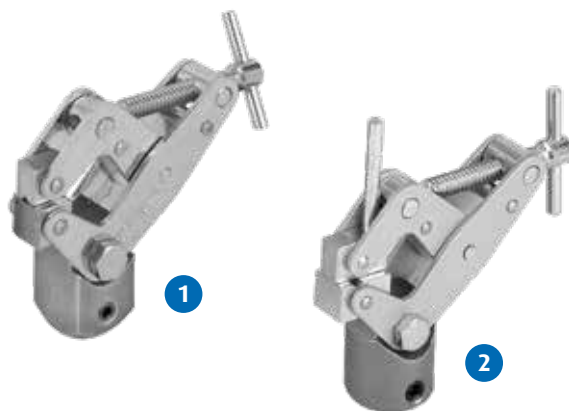
## Parallel clamps

### Description

Parallel clamps with a clamping range of 0–25 mm. The jaws without a guide pin can be rotated. Those with a guide pin are held parallel. The jaw faces are available in different versions: Flat, with a prism for holding round workpieces or convex for holding highly sensitive workpieces. The parallel clamps are mounted on an SWA 5 quick-change adapter.

### Material

Stainless steel/steel/aluminium.



Order No.	Lower jaws	Upper jaws	Version	Fig.
278800	3 flat, 1 long prism	3 flat, 1 long prism	Both jaws rotatable	1
278600	2 flat, 1 long prism, 1 convex	2 flat, 1 long prism, 1 convex	Both jaws rotatable	1
279200	Cross prism	Flat	With guide pin	2

SWA 5

### Application example



Multispannfix

**Description**

Universal clamping device for simple, quick fixation of rotationally symmetrical and cubic parts. Rest frame height 5 mm.

**Material**

Hard-coated aluminium/safety glass/ acrylic glass rest frame.

**Supplied with**

Spring-loaded thrust clamp and cone tip (269055).



Order No.	Size	Length	Width	Clamping range	Fig.
269050	1	124	100	40	1

Application example



## + Spring thrust clamp

### Description

Spring thrust clamp with cone tip and adapter for T-slots.

### Material

Stainless steel/brass.



Order No.	Length	Application
269057	115	For size 1

T-Nut 5

## + Cone tip

### Description

Thrust tip for spring thrust clamp for high and precise clamping force transfer.

### Material

Stainless steel.



Order No.	Version
269055	Cone tip

## + Movable clamping tip

### Description

Movable clamping tip for a secure hold even by imperfectly aligned spring thrust clamps.

### Material

Stainless steel.



Order No.	Version
269056	Movable clamping tip

**NADELFIX 2.5**

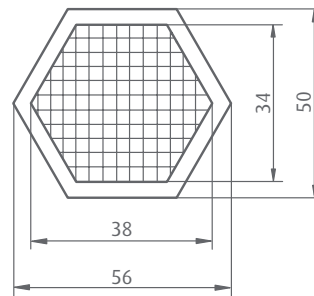
**Description**

NADELFIX for fix-variable self-moulding from products. Ideal for clamping moulded parts. With SWA 39 quick-change mount. Function and advantages are described on page 76.

**Supplied with**

Clamping fixture comprising rail (396120), column (269043) and spring finger (269038). Fasteners included

↳ For other Nadelfix clamping elements and accessories, see the SWA 39 section on pages 76 to 79.



Order No.	Pin Ø	Support area	Total height	Spring travel
396030	2.5	38 x 34	55	Max. 10

SWA 39

Application example



## Inspection vice

### Description

Due to a perpendicularity and parallelism precision of 0.005 mm, all 4 sides can be used. Horizontally and vertically ground prism jaws. Vice and fixed jaw machined from a single piece. By using the attachment sets the vices can also be used in the SWA 39 system.

### Material

Alloyed tool steel, hardened to 60 HRC and finely ground.



Order No.	Total length		Width	Height	Clamping width	Weight	Perpendicularity / parallelism
	Open	Closed					
270720	116	91	20	22	24.5	0.175 kg	5 µm
270730	SWA 39 adapter set for 20 mm vice (270720)						
270740	175	140	35	35	34.5	0.775 kg	5 µm
270750	SWA 39 adapter set for 35 mm vice (270740)						
270760	235	175	50	50	59.5	1.970 kg	5 µm
270770	SWA 39 adapter set for 50 mm vice (270760)						

SWA 39

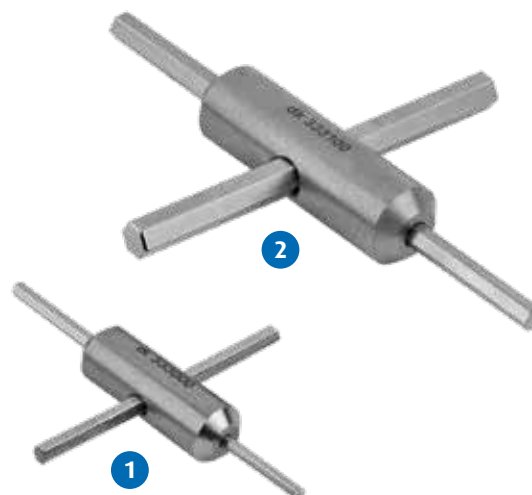
## Four-way hexagon key

### Description

Practical and compact cross design with 3 key sizes per tool. Covers all hexagon socket sizes used in the Spannfix and Schienenfix ranges.

### Material

Steel.



Order No.	Size	Fig.
333000	2 / 2.5 / 3	1
333100	4 / 5 / 6	2

Schienenfix basic sets

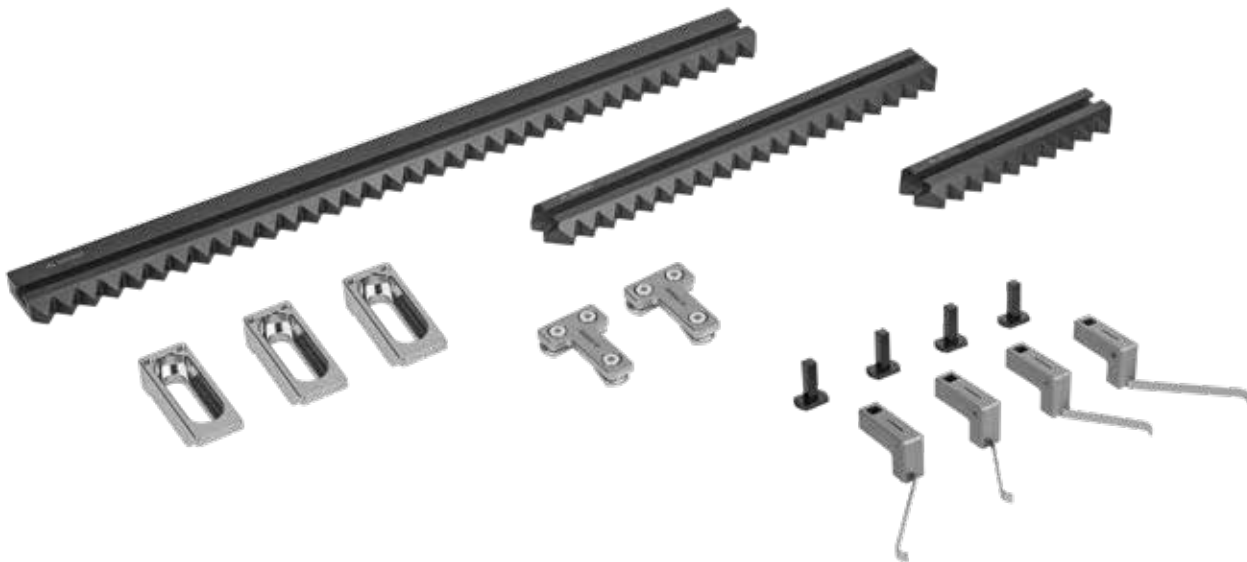
**Description**

Clamping set for optical measurement tasks. For constructing a simple frame that can be clamped to the measuring equipment table using claw clamps. Includes 4 spring fingers for quick and easy holding of test parts. There are sets with 5 mm or 10 mm tooth pitch each in three set versions for different measuring table sizes available.

**Ordering information**

All sets are supplied with M4, M5 and M6 screws. If the thread on your equipment is different, please let us know when placing your order.

↳ *Toothed rails for other table sizes available on request.*



**Set versions**

Order No.	Description	Tooth pitch	Measuring window
269915	Basic set, model "1"	5	200 x 100
269925	Basic set, model "2"	5	300 x 200
269935	Basic set, model "3"	5	400 x 200
269910	Basic set, model "4"	10	200 x 100
269920	Basic set, model "5"	10	300 x 200
269930	Basic set, model "6"	10	400 x 200



### Set contents – toothed rails with fine toothing

Order No.	Description	Set "1"	Set "2"	Set "3"
345020	Base rail, 250 mm / T 5	1	-	-
345220	Base rail, 350 mm / T 5	-	1	-
345420	Base rail, 450 mm / T 5	-	-	1
347220	Connecting rail, 100 mm / T 5	2	1	1
346020	Connecting rail, 200 mm / T 5	-	1	1
348000	Rail connecting pieces	2	2	2
262924...26	45 mm clamping claws, M 4-M 6	3	3	3
349100	34 mm spring finger, left	1	1	1
349200	34 mm spring finger, right	1	1	1
349300	50 mm spring finger, left	1	1	1
349400	50 mm spring finger, right	1	1	1
268500	Mounts for spring finger, 20 mm	4	4	4
-	Screws M 4 / M 5 / M 6 (3 of each)	1	1	1

### Set contents – toothed rails with standard toothing

Order No.	Description	Set "4"	Set "5"	Set "6"
345000	Base rail, 250 mm / T 10	1	-	-
345200	Base rail, 350 mm / T 10	-	1	-
345400	Base rail, 450 mm / T 10	-	-	1
347200	Connecting rail, 100 mm / T 10	2	1	1
346000	Connecting rail, 200 mm / T 10	-	1	1
348000	Rail connecting pieces	2	2	2
262924...26	45 mm clamping claws, M 4-M 6	3	3	3
349100	34 mm spring finger, left	1	1	1
349200	34 mm spring finger, right	1	1	1
349300	50 mm spring finger, left	1	1	1
349400	50 mm spring finger, right	1	1	1
268500	Mounts for spring finger, 20 mm	4	4	4
-	Screws M 4 / M 5 / M 6 (3 of each)	1	1	1



Schienenfix expansion sets for turned parts

Description

Expansion sets with different support and clamping elements for rotationally symmetrical parts. These modules are for fastening to Schienenfix toothed rails.

"Standard" set

"Small" set



Set versions

Order No.	Description
269950	"Standard" Schienenfix expansion set for turned parts
269951	"Small" Schienenfix expansion set for turned parts

Set contents

Order No.	Description	"Standard" set	"Small" set
267900	V-block with spring finger	1	1
267910	V-block holder	1	1
273320	Quick-action clamp	1	-
283300	Quick-action clamp 90° angle element	1	-
329705	50 mm precision three-jaw chuck	1	-
345100	V-support (1 pair) with spring finger	1	-
349600	Tailstock	1	1

## Schienenfix expansion sets for milled and sheet parts

### Description

Expansion sets with different clamping elements for milled and sheet parts. The modules can be attached to Schienenfix toothed rails.

### "Standard" set

#### "Small" set



### Set versions

Order No.	Description
269960	"Standard" Schienenfix expansion set for milled and sheet parts
269961	"Small" Schienenfix expansion set for milled and sheet parts

### Set contents

Order No.	Description	"Standard" set	"Small" set
266100	Small-parts clamp with stepped jaw	1	-
269050	Multispannfix	1	-
273320	Quick-action clamp	1	1
283300	Quick-action clamp 90° angle element	1	1
282100	50 mm precision vice with accessories	1	1
282300	Pins for raised parts clamping	1	1
314900	Rotary swivel mount	1	-

### 3-point support set

**Description**

3-point support for plate, bent and moulded parts. Flexible adjustment of supports in X, Y and Z axis. Quick and easy workpiece holding using spring fingers. The adjustable base rails can be anchored anywhere along the T-slot of the toothed rails. The supports are height-adjustable. Height differences can be accommodated using extension pieces.



**Set versions**

Order No.	Description
269965	3-point support set

**Set contents**

Order No.	Description	"Standard" set
322006	Screw jack with spring finger	3
322350	25 mm extension pieces	3
322450	50 mm extension pieces	3
323050	Steel self-aligning pads	2
269042	30 mm columns for spring fingers	3

**Application example**



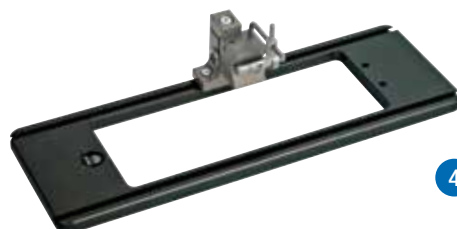
## Pallets with clamping elements

### Description

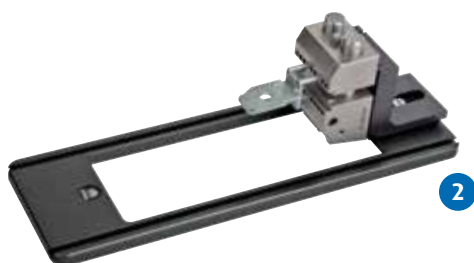
Sets with pallets and differently mounted clamping elements. Available in pallet sizes 305 mm x 100 mm (345801) and 195 mm x 100 (345821) mm.



1



4



2



5



3

### Application example



The clamped workpieces shown are application examples and are not supplied.

### Set versions

Order No.	Description	Basic pallet	Supplied with	Fig.
345802	Pallet with 1 tailstock	305 x 100 x 10	345801, 349600	1
345822	Pallet with 1 tailstock	195 x 100 x 10	345821, 349600	
345804	Pallet with precision vice	305 x 100 x 10	345801, 283300, 282100	2
345824	Pallet with precision vice	195 x 100 x 10	345821, 283300, 282100	
345805	Pallet with mini chuck and rotary/swivel mount	305 x 100 x 10	345801, 314900, 283600	3
345825	Pallet with mini chuck and rotary/swivel mount	195 x 100 x 10	345821, 314900, 283600	
345806	Pallet with small V-block	305 x 100 x 10	345801, 267910, 267900	4
345826	Pallet with small V-block	195 x 100 x 10	345821, 267910, 267900	
345807	Pallet with V-block support	305 x 100 x 10	345801, 345100	5
345827	Pallet with V-block support	195 x 100 x 10	345821, 345100	

Universal clamping sets

Description

The clamping elements can be placed directly onto the measuring table or, if the SWA 39 quick-change adapter is fitted, positioned using the swivel unit.



Set versions

Order No.	Description	Fig.
269850	"Universal with swivel unit" clamping set incl. case	1
269855	"Universal" clamping set incl. case	

## Set contents

Order No.	Description	"Universal with swivel unit" set	"Universal" set
270920	15 mm precision vice	1	1
270860	35 mm precision vice	1	1
282115	50 mm precision vice	1	1
282300	Set of 4 stepped pins for vice	1	1
267900	V-block with spring finger	1	1
270560	Swivel unit with attachment plate and quick-action clamp	1	
397020	SWA 39 adapter plate for 35 mm and 50 mm vices	1	
314100	SWA 39 adapter plate for 15 mm vice or V-block	1	
329705	50 mm precision three-jaw chuck with SWA 39 quick-change adapter	1	



The clamping elements contained in the set.



The clamping elements can be placed directly onto the measuring table or they can be positioned at any angle using the swivel unit.

**Clamping component sets**

**Description**

For optical measuring instruments and microscopes. For clamping e.g. plastic, punched or turned parts. The basis is a high-quality articulated arm on which clamping elements such as a mini chuck, spring finger or parallel clamp can be mounted.

**Ordering information**

When ordering, let us know the thread or T-slot size on your measuring equipment.



**Set versions**

Order No.	Description	Fig.
269805	"Standard model II" clamping component set with storage box	1
269815	"Small model II" clamping component set with storage box	



## Set contents

Order No.	Description	"Standard model II" set	"Small model II" set
296800	Articulated arm, type SU	1	1
268900	Rest angle with spring clamp including: 120 x 80 mm rest angle 2 columns for spring fingers (268600) left-hand spring fingers for horizontal clamping (269200) 35 mm spring finger for vertical clamping (269100)	1	1
268200	Right-hand spring finger for horizontal clamping	1	
268100	50 mm spring finger for vertical clamping	1	
283600	Precision mini chuck	1	
267900	V-block with spring finger	1	1
266100	Small-parts clamp with stepped jaw	1	
278800	Parallel clamp	1	1
269300	Spring finger with SWA 5	1	
269600	Rotary unit	1	
269700	Satellite mount, horizontal	1	
270900	15 mm precision vice	1	1
333000	Four-way hexagon key	1	1
Customer specifications	Adapter or T-slot nuts (see ordering information)	1	1

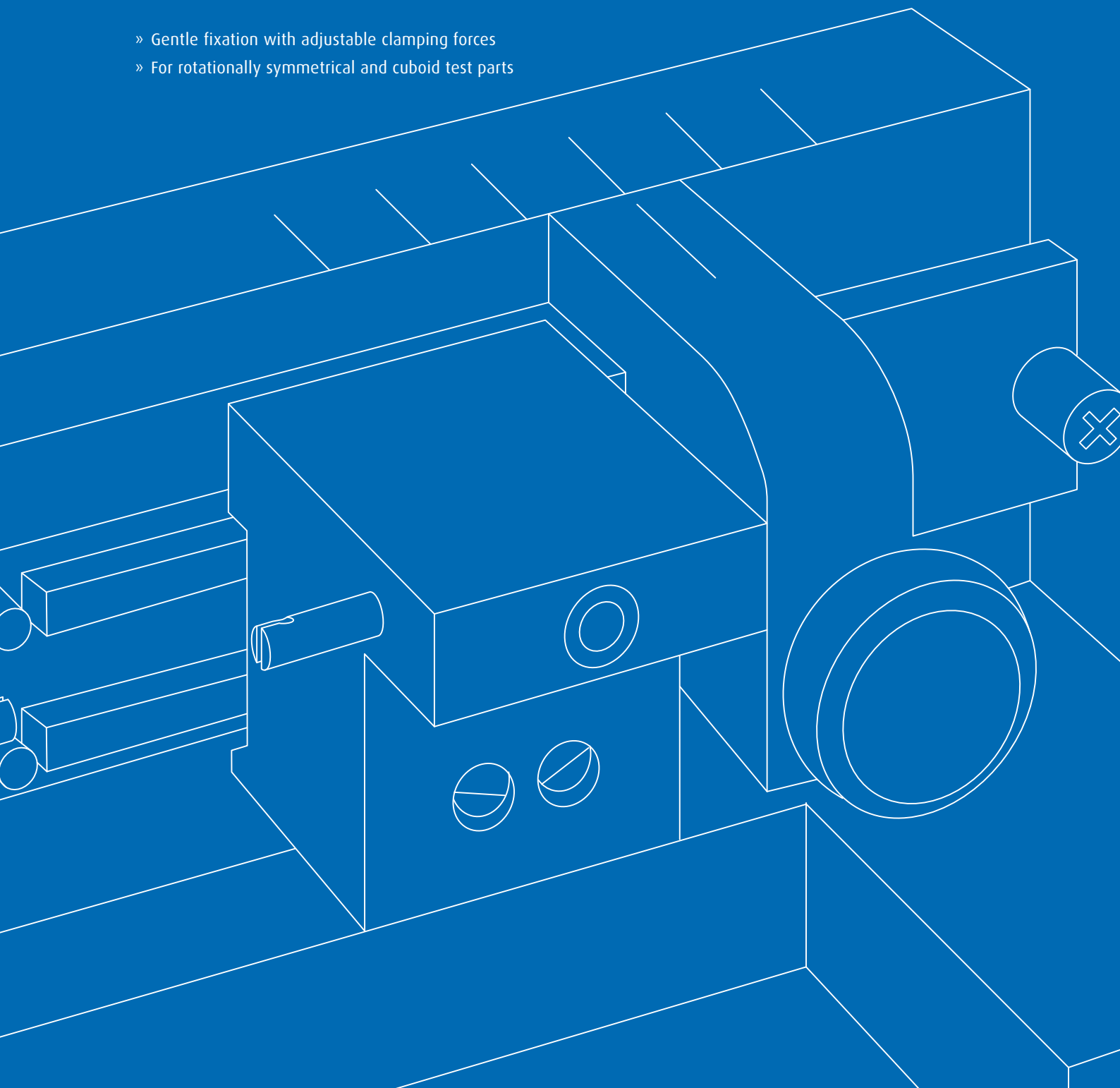
## Application examples



**MICROFIX**

***Clamping solutions  
for micro parts from  
0.3 mm to 10 mm***

- » Gentle fixation with adjustable clamping forces
- » For rotationally symmetrical and cuboid test parts



Clamping elements



Micro fixture for cubic parts

Page 300



Micro fixture "Prisma"

Page 300



Micro tailstock

Page 301

Micro fixture for cubic parts

Description

For holding cubic parts with constant and adjustable clamping force. The clamping force is generated by a slanting plane and can be adapted to specific requirements by adding ball weights. To ensure that test parts are held securely even by low clamping forces, the fixed jaw can be adapted using adjustable stops. The movable part of the fixture is also fitted with a pendulum jaw.



Application example



Order No.	Clamping range	Length	Width	Height	Jaw width	Supplied with
398030	< 0.3-10	85	60	30	6	10 steel balls

Micro fixture "Prisma"

Description

For holding rotationally symmetrical test parts with a diameter of 0.5 mm to 6 mm or up to 10 mm with accessories. The holding force is adjustable and exerted by several micro springs.

Accessories

Interchangeable plates (398035) enabling the clamping range for rotationally symmetrical test parts to be increased to 5 mm to 10 mm.



Application example



Order No.	Clamping range	Length	Width	Height	Jaw width
398032	∅ 0.5-6	85	60	32	10
398035	∅ 0.5-10	1 set of interchangeable plates			

## Micro tailstock

### Description

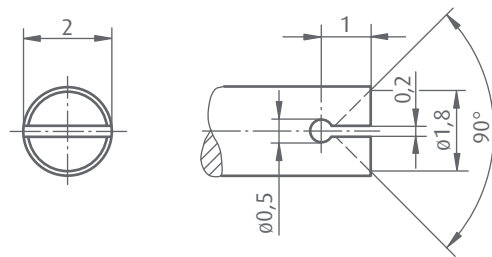
For holding rotationally symmetrical test parts. The test pieces can be measured along their whole length as they are mounted between female centres with measurement slits. With adjustable holding force. The clamping range can be freely adjusted up to a maximum of 25 mm.

### Supplied with

Female centres (see diagram).

### Accessories

60° male centres (398060).



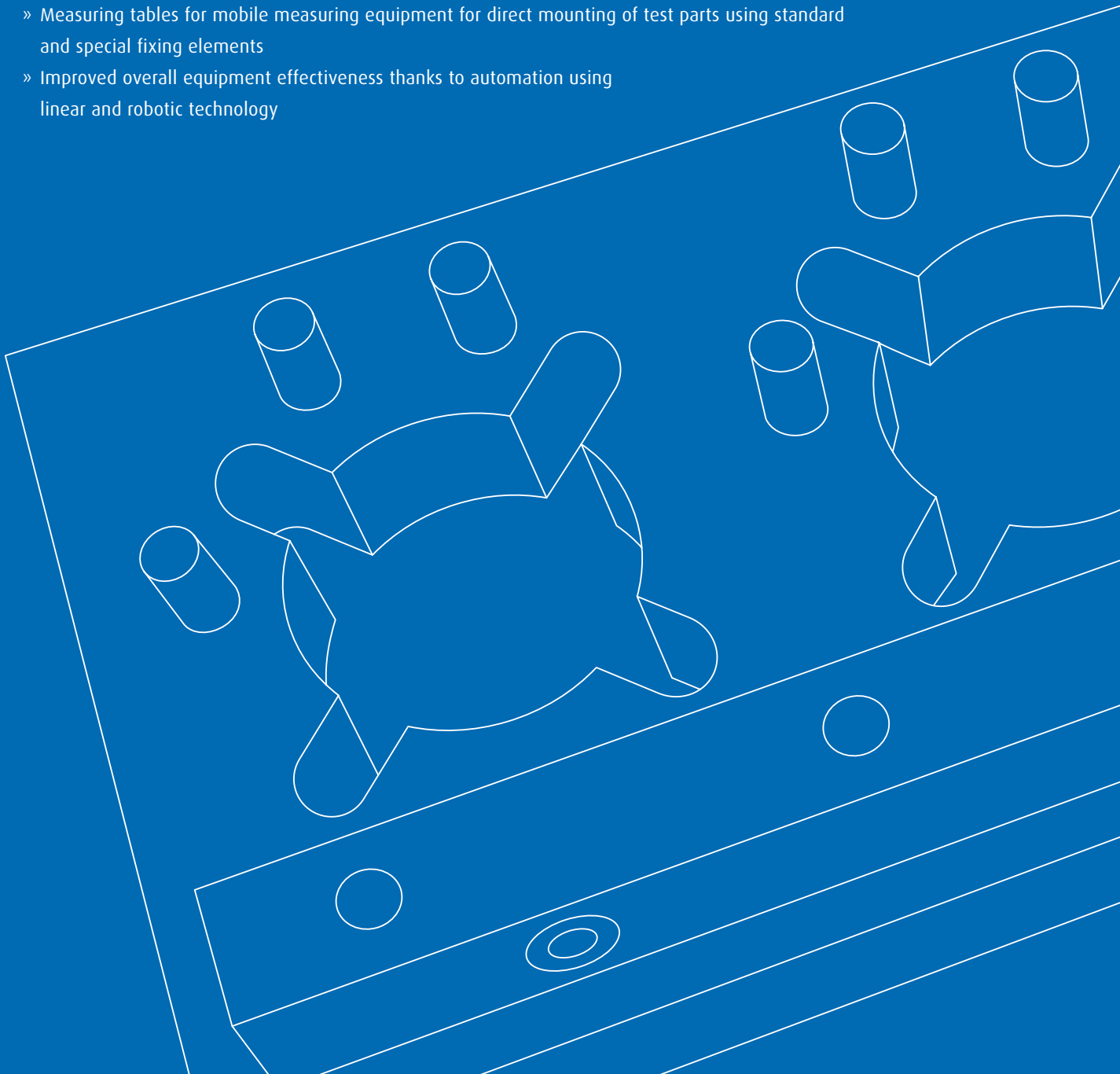
Order No.	Centre height	Length	Width	Height	Version	Fig.
398052	37	90	60	40	With mounting plate	1
398060			Ø2 x 60° male centres (1 pair)			



**SPEZIALFIX**

## *Customer-specific clamping fixtures*

- » We develop, design and manufacture special clamping devices according to your specifications
- » Testing and measuring fixtures, analysis stations, inspection and test gauges
- » Simple or complex multi-clamping systems with mechanical, pneumatic, electromechanical or combined fixturing, clamping and handling components
- » Economical solutions using components from the dk standard ranges
- » Measuring tables for mobile measuring equipment for direct mounting of test parts using standard and special fixing elements
- » Improved overall equipment effectiveness thanks to automation using linear and robotic technology



Special solutions



**Clamping and measuring equipment connection for batteries**

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**Multi-clamping for milled, turned and punched parts**

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**Multi-clamping for turned parts**

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**Multi-clamping for round deep drawn parts**

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**Vacuum multi-clamping device**

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**Multi-clamping for optical and tactile measuring**

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**Precision module system Q-Line**

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**Motor-driven tailstock configuration**

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**Measuring tables for mobile measuring equipment for direct mounting of fixturing systems**

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**Automation: set-up and loading systems with linear and robotic technology**

Page 310

## Clamping and measuring equipment connection for batteries

- Designed for one-hand operation
- Colour coding to prevent incorrect operation: red anodised jaw at positive pole
- Spring-loaded fixture for secure electrical contact
- Stepped supports that can be adjusted without tools for different battery sizes for central positioning on the poles
- Stroke and clamping force can be preset without tools
- Covered and protected cable guide in the guide columns
- Completely new design in line with customer requirements

### Application example



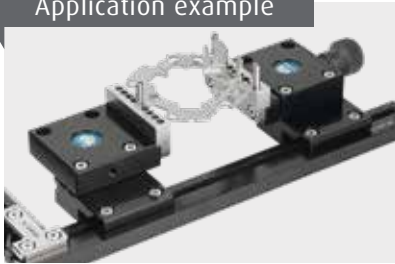


## Multi-clamping for milled, turned and punched parts

- Multiple fixturing system for any number of parts as a combination of standard modules on special plates or frames
- Fixed and movable jaws separately positionable for a wide clamping range
- Jaws can be mounted vertically or horizontally
- Interchangeable jaws from the module range or as a custom-made product for part-specific fixation
- Force strength, force direction and travel of the movable jaw are freely adjustable, limitable and reproducible
- For optical or tactile measuring machines

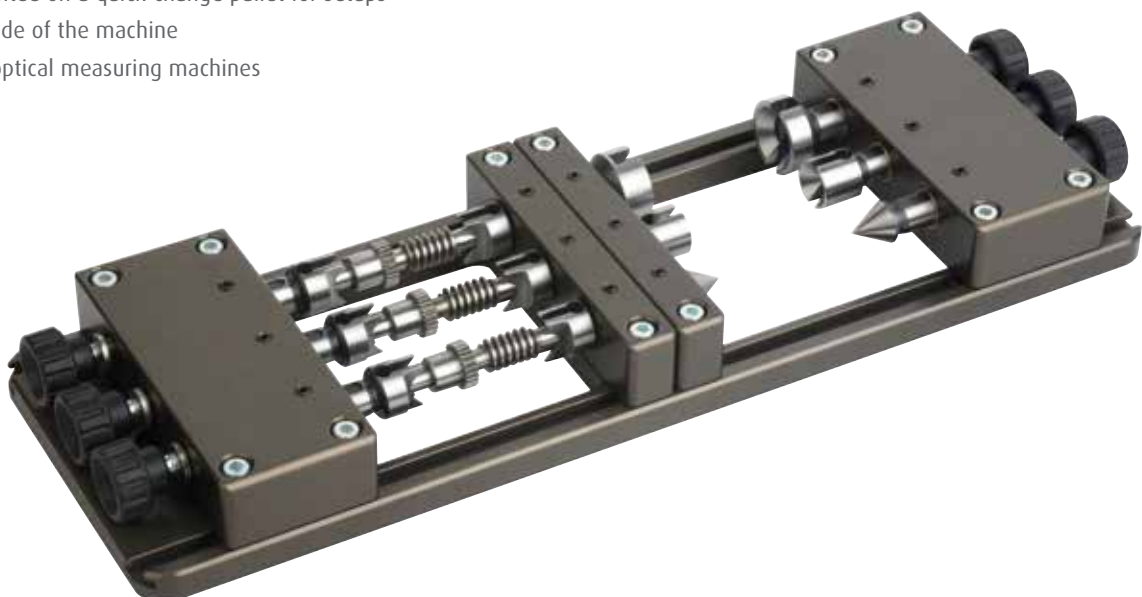


Application example



## Multi-clamping for turned parts

- 6x tailstocks for turned parts
- Held using spring-loaded, stepped female centres from the Schienenfix range
- Mounted on a quick-change pallet for setups outside of the machine
- For optical measuring machines



## Multi-clamping for round deep drawn parts

- 4x pallet construction; easy handling through low weight and grips
- Positioning in Z axis using exchangeable pins
- Centric fixturing using hand-operated three-jaw chuck from the standard range
- Mounted on a quick-change pallet for setups outside of the machine
- For tactile measuring machines



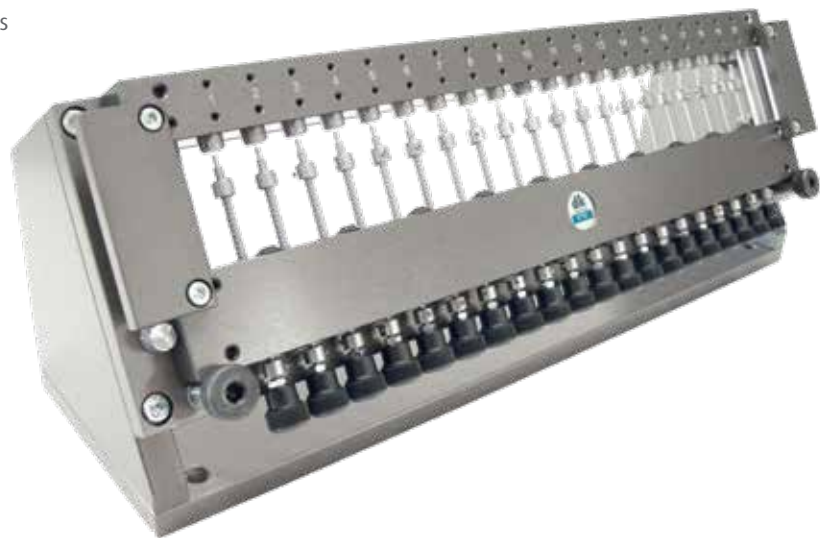
## Vacuum multi-clamping device

- 12x clamping for disc-shaped ceramic test pieces
- Each clamping point can be actuated individually
- Maximum equipment configuration for given measuring volume
- For tactile measuring machines



## Multi-clamping for optical measuring

- 20x clamping fixture for small plastic parts for medical technology
- With insertion aid
- Individual clamping
- For optical measuring instruments



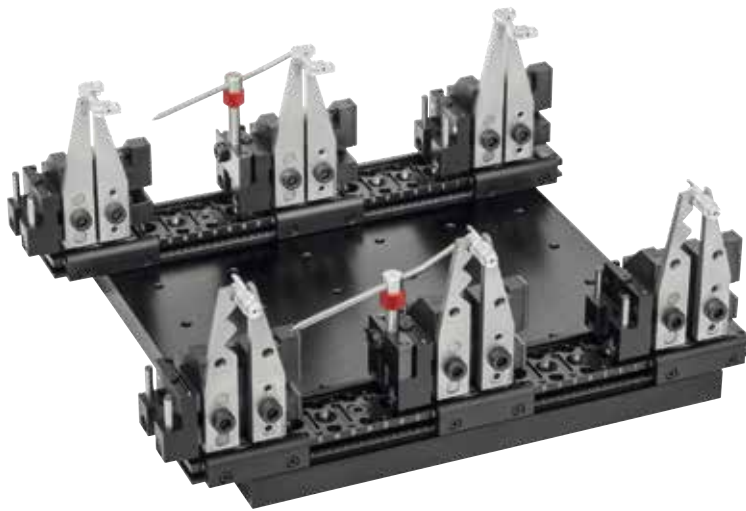
## Multi-clamping for optical and tactile measuring

- 4x clamping fixture for sheet metal parts
- Individual clamping
- For multi-sensorial measuring equipment



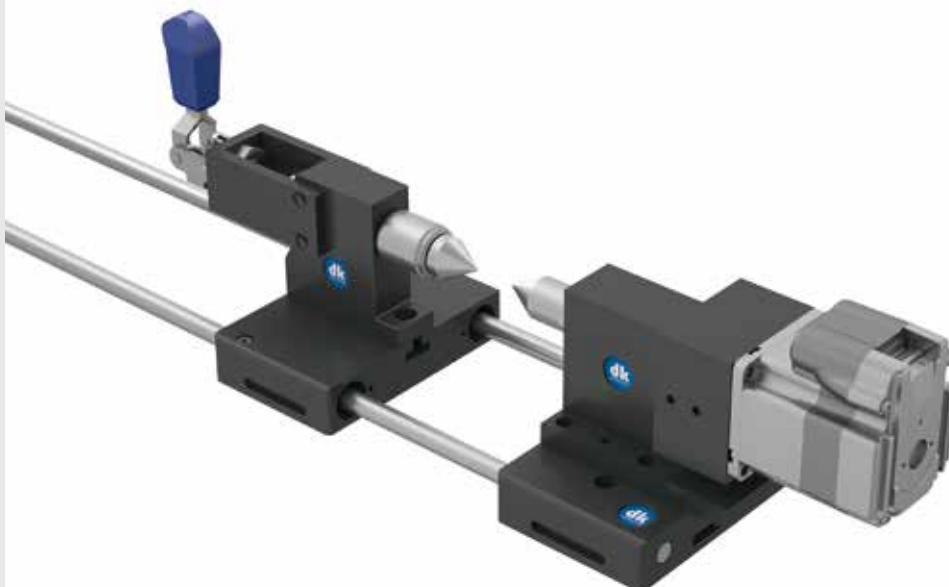
**Precision module system Q-Line**

- Vice and spring-loaded vice system for special and multi-clamping using standard parts
- High precision even for the smallest workpieces
- Jaws positioned for easy implementation of even highly part-specific geometries
- System rails for positioning elements in precise increments
- Fully compatible with the SWA 39 product range



**Motor-driven tailstock configuration**

- Tailstock with movable centre for holding
- For testing the entire circumference of parts or in controllable rotated positions
- For dimension and surface inspection



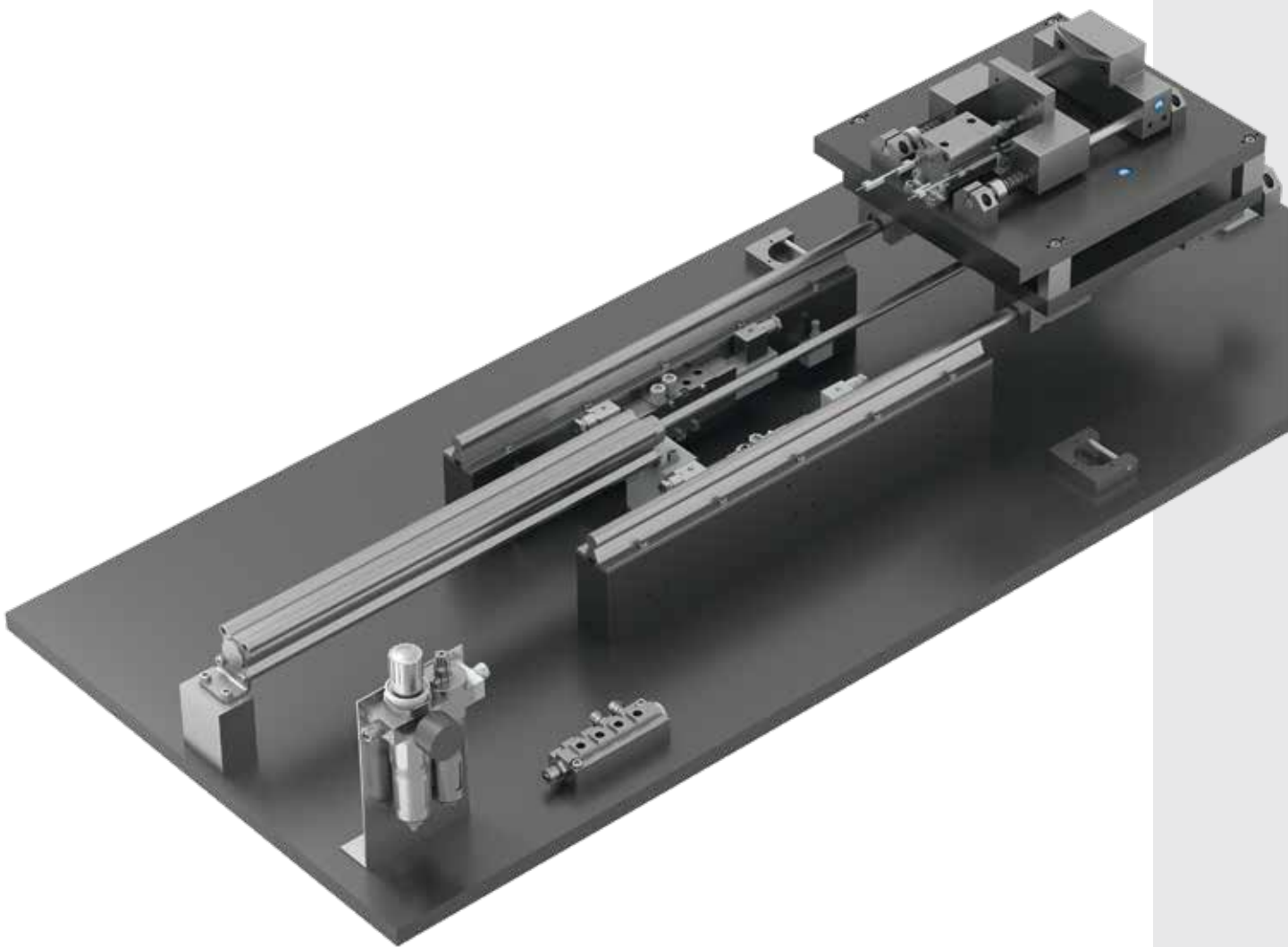
## Tables for mobile equipment for direct mounting of fixturing systems

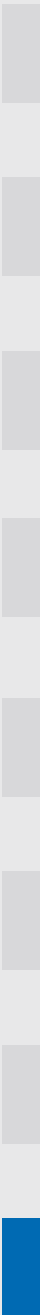
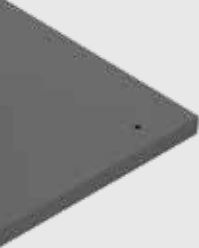
- For CMM, white light, laser and combi systems
- System plates for direct mounting of clamping systems:
  - > For example, drilling plate for use with the *SPANNFIX ECO* range
  - > Customer-specific grid holes with or without threaded bushings
- Customer, part and process-specific bench sizes and frame design
- Material: hard-coated aluminium plate on a stable aluminium profile frame
- Frame with fixed height, fixed and variable adjustment or freely adjustable
- Levelling feet to accommodate uneven floors
- Can be moved with a forklift and includes positioning aids for the forks
- Also available with freely positionable adapter plates for measuring equipment
- Standard height of 900 mm
- Standard depth of 800
- Standard widths of 800, 1200, 1600 and 2000 mm
- Available in all manner of part and process-specific versions
- Many versions of below table draws or hinged door cabinets optionally available



## Automation: set-up and loading systems with linear and robotic technology

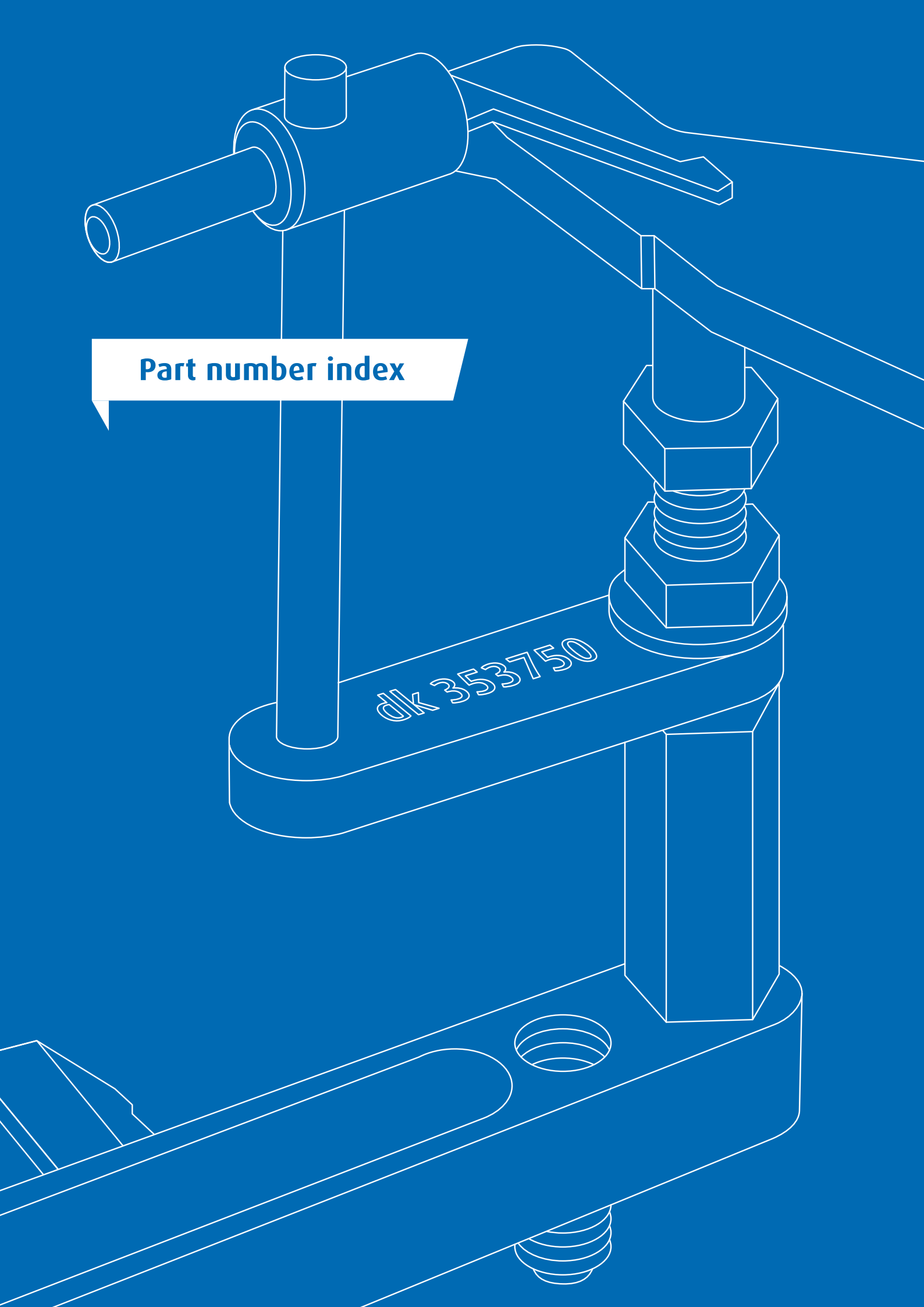
- Process-specific systems for moving setup processes outside of the measuring machine
- Direct automatic equipping of measuring machines with individual test parts or with mounting plates already equipped with several test parts
- Significantly reduced downtime on costly measuring equipment and improved overall equipment effectiveness
- Possible applications:
  - Simple manual systems for situation-dependent positioning of palletised test parts
  - Efficient and compact linear systems made from standard industry modules
  - Flexible, highly functional and non-application-specific robot systems
- Pallet station in front of the actual loading system to ensure efficient processing with high-throughput; modular assembly, manual or automatic transport, measuring equipment-specific dimensions
- Integrated parts clamping fixtures from the dk standard ranges or as a custom-made product





**Part number index**

dk 353750





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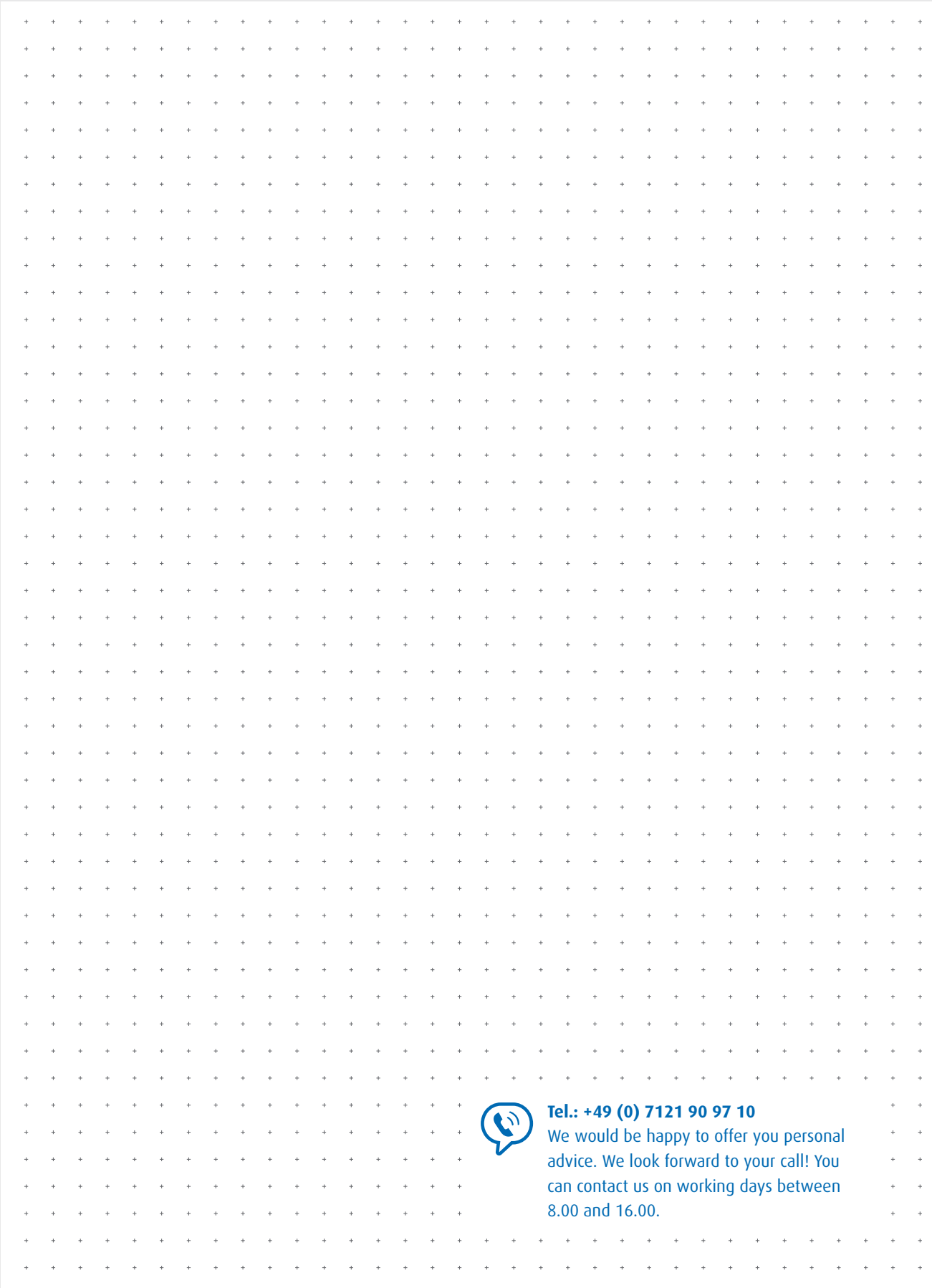
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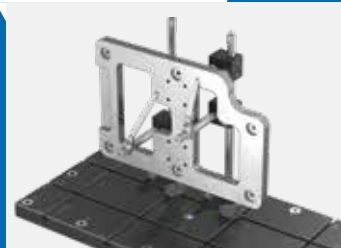
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