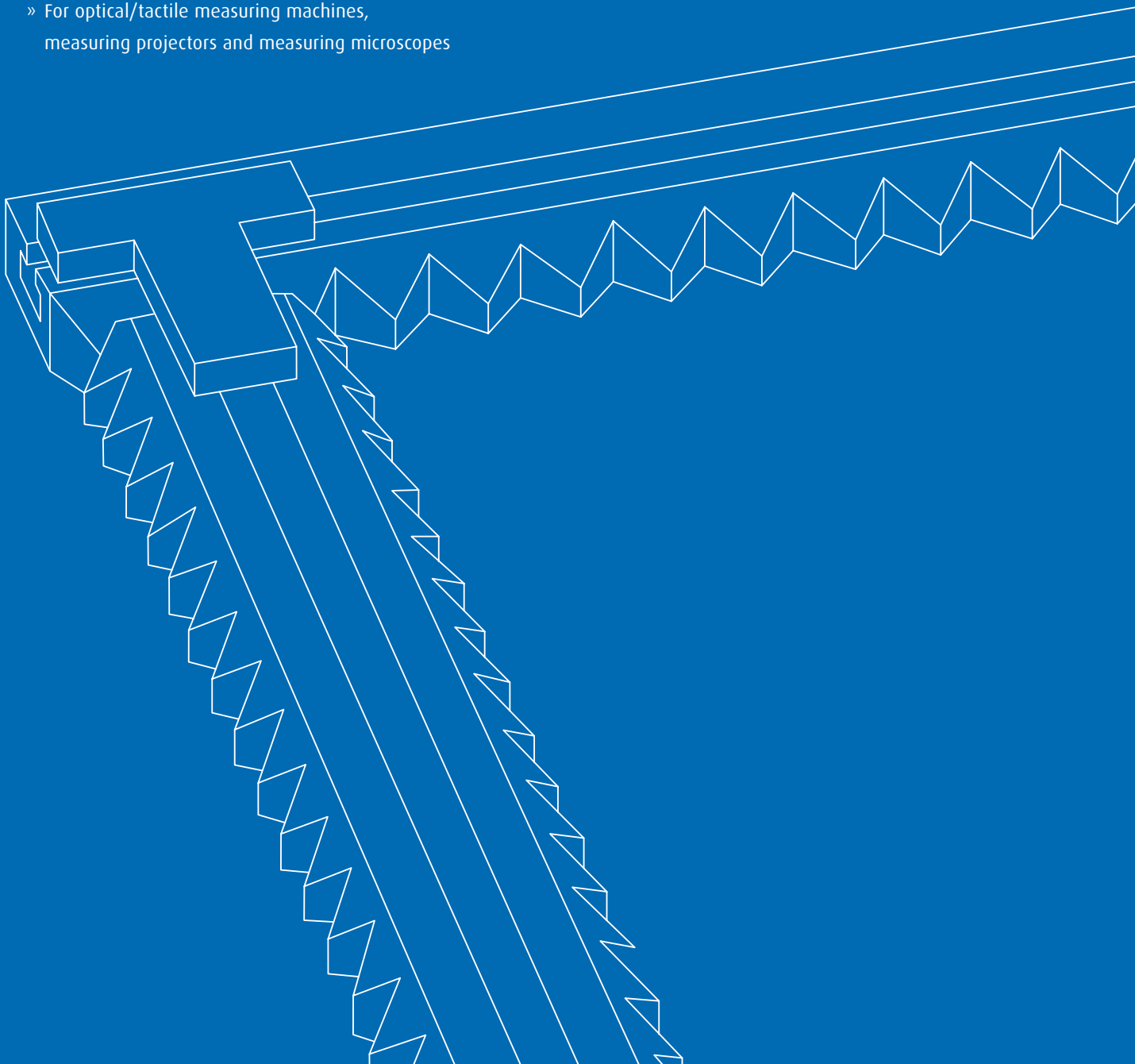


**SCHIENENFIX**

## *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

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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



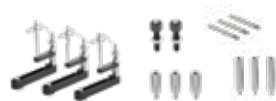
**Schienenfix expansion sets for turned parts**

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

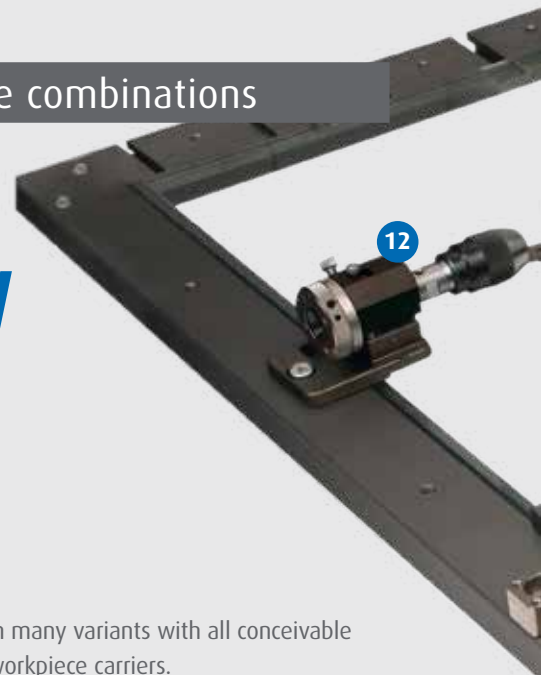
The outstanding advantages begin with the simplest toothed rail angle rests:

- 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)

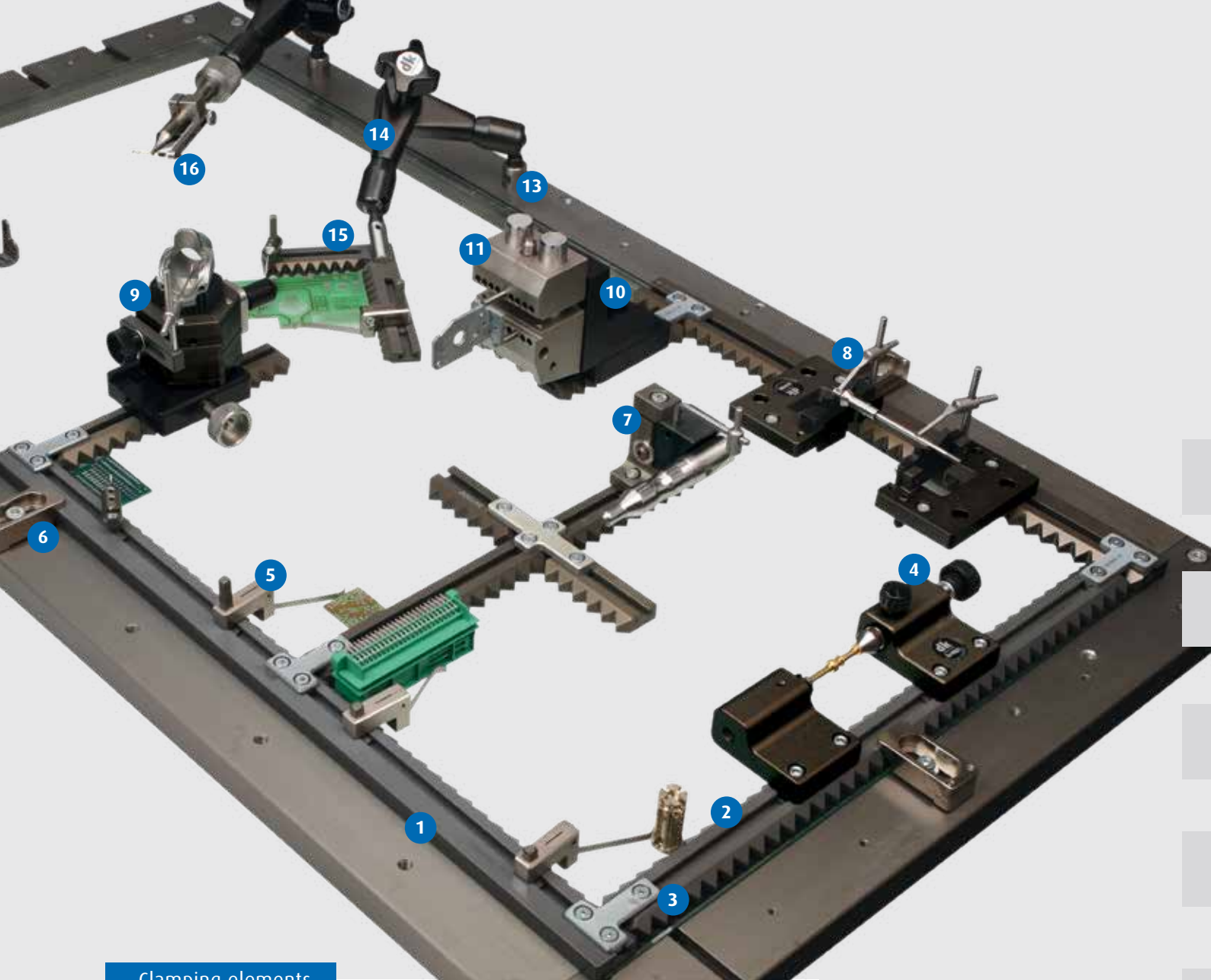


- 14 Articulated arm (page 236)



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.

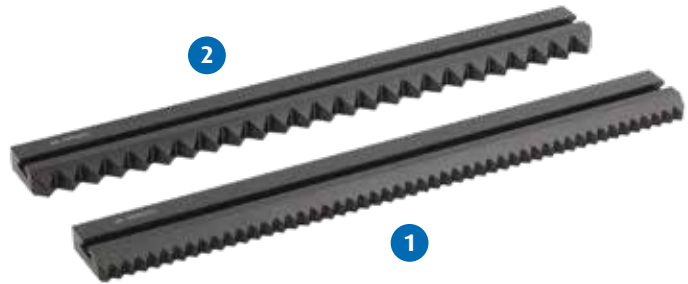
Base rails

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

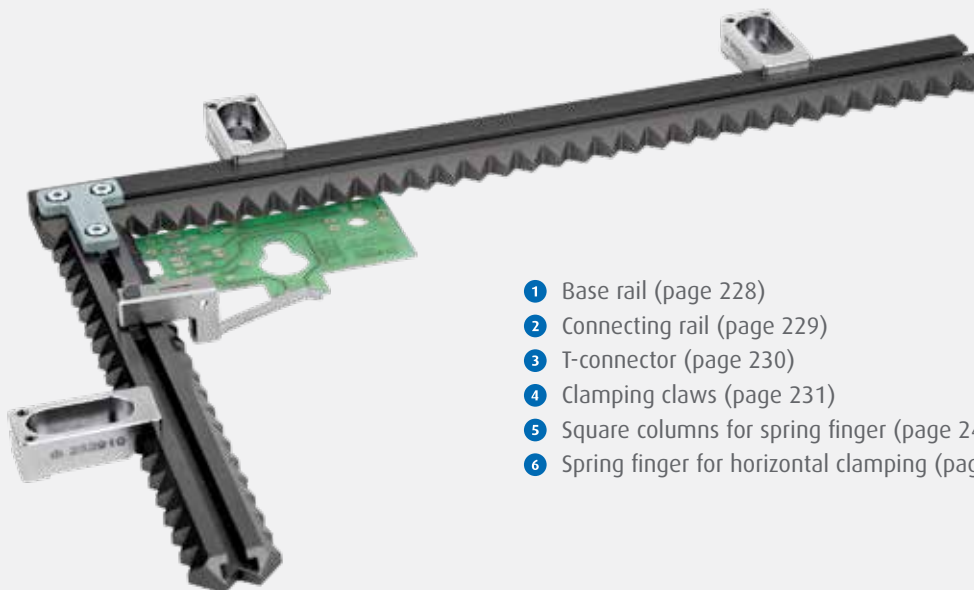
Hard-coated aluminium.



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)

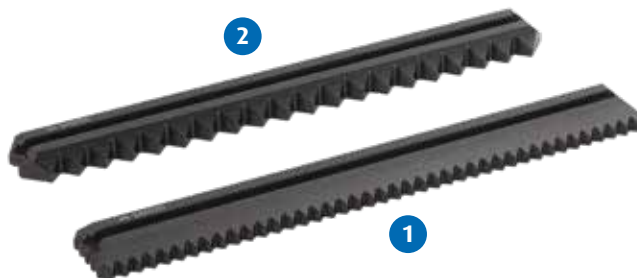
## Connecting rails

### 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.



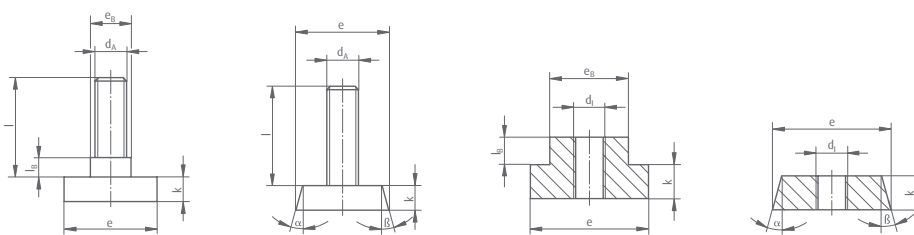
Order No.	Form	Length	Width	Height	Fig.
348000	T connector	28	40	3.5	1
348200	Cross connector	28	73	3.5	2

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.



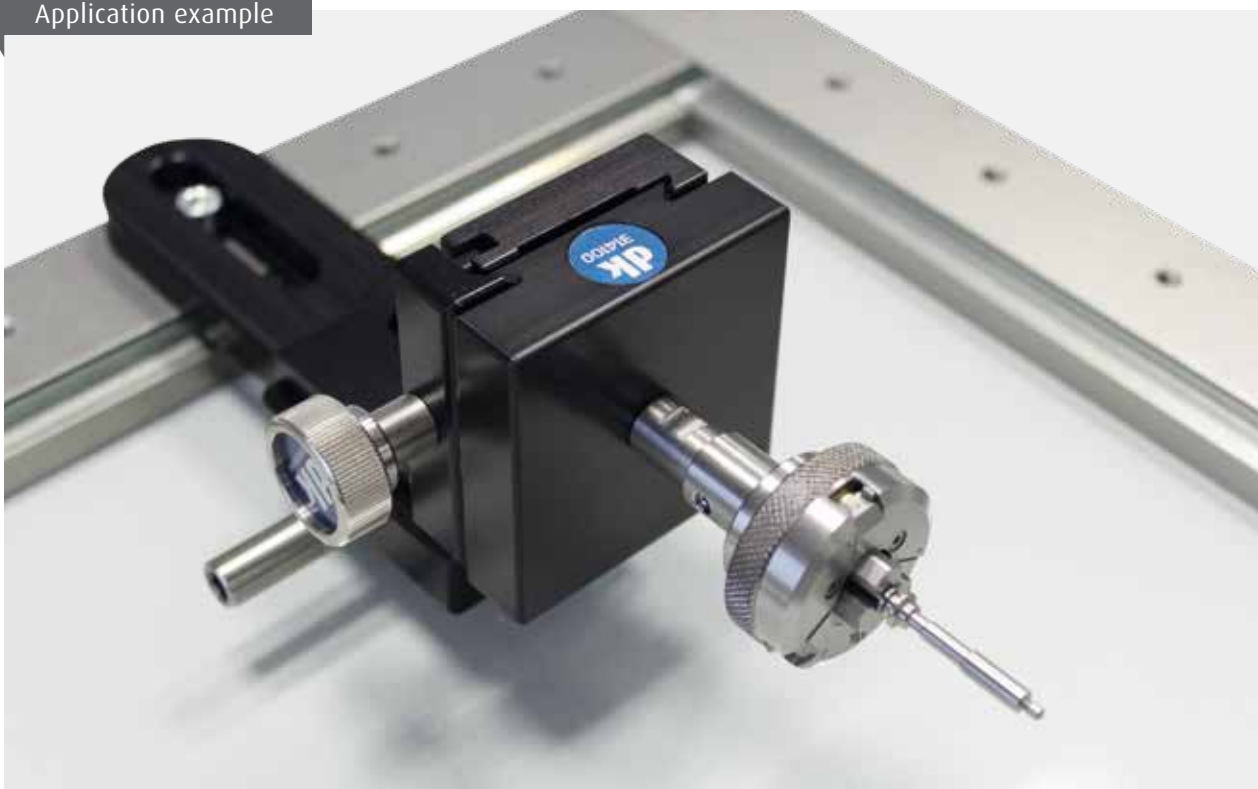
Application example



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

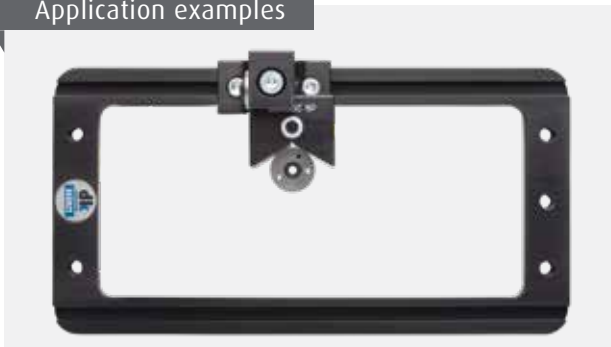


# Benefits of the quick-change pallet systems from dk

- 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



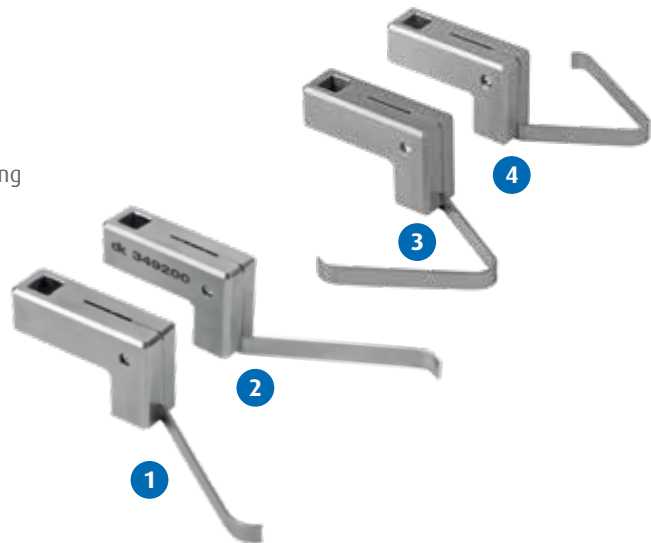
Spring fingers for horizontal clamping

Description

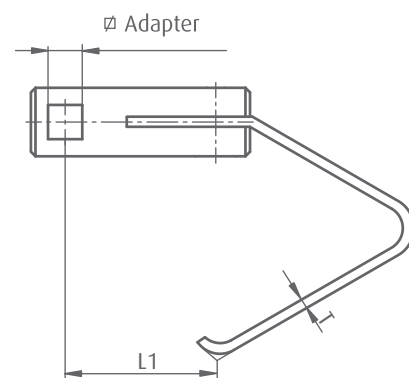
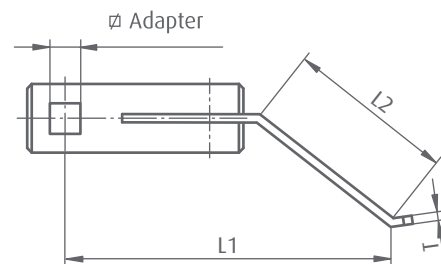
Spring fingers for clamping workpieces horizontally on toothed rails. Versions with different finger lengths and for right or left clamping. Small parts can be held in the angle corners using the bent finger versions. Lock effected by tilting the spring finger adapter (5 mm square).

Material

Brass/stainless steel.



Application example



Order No.	Adapter square ∅	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

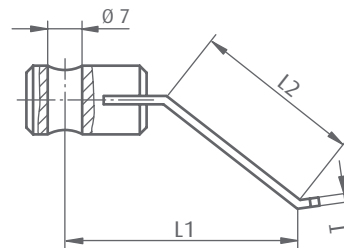
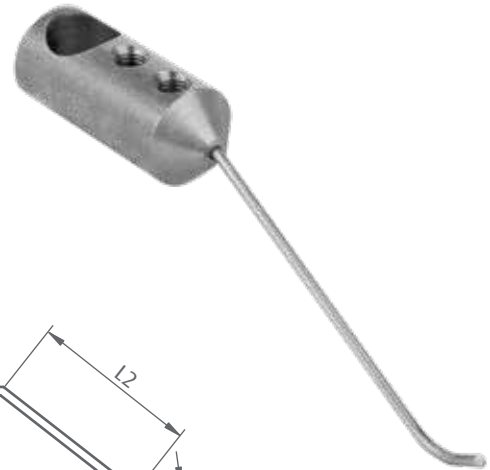
## Spring fingers for vertical clamping - square column

### 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

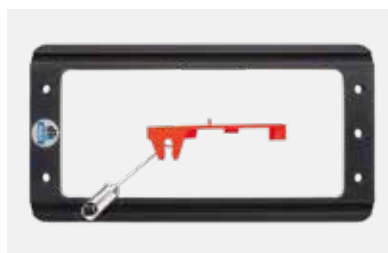
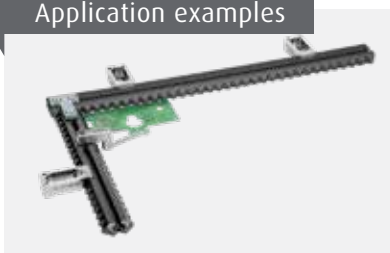
Clamping column (5 mm square) for mounting spring fingers. For T-slots.

### 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

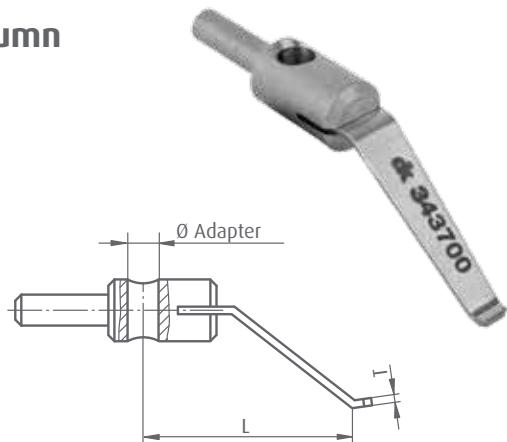
**Description**

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

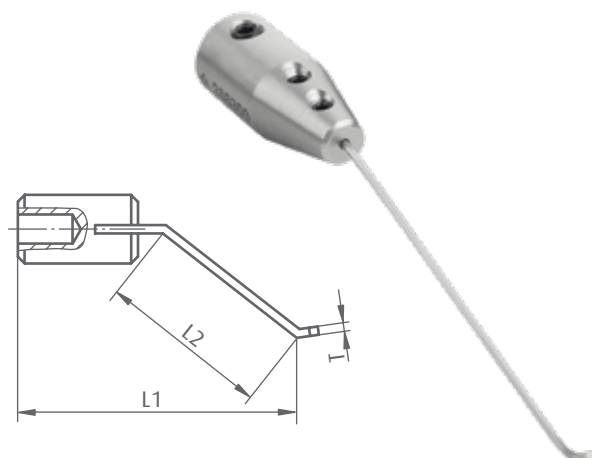
### Description

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.



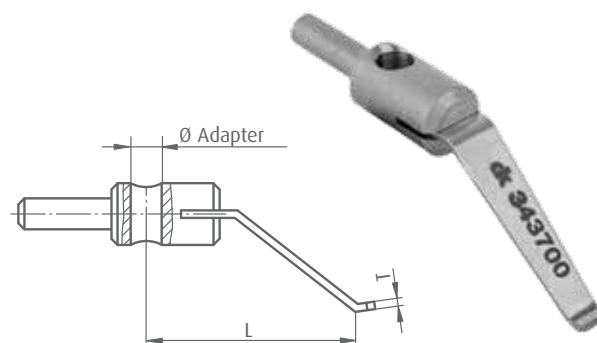
Order No.	Column Ø	Thread	Length
269042	4	M 4	30
269043	4	M 4	50
269044	4	M 4	75
368100	6	M 6	30
368200	6	M 6	50
368300	6	M 6	75

### + 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



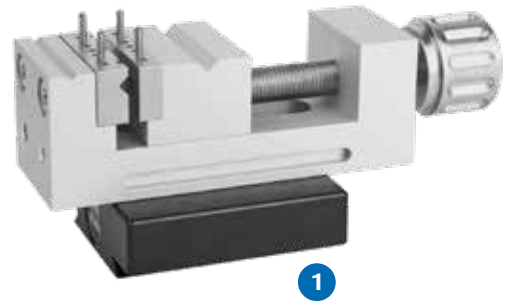
## 35 mm precision vice

### Description

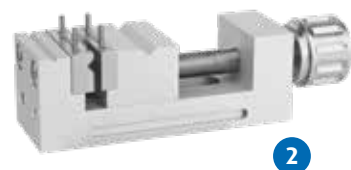
M 5 connection. Aluminium and stainless steel versions available. Jaws with Ø2 mm holes for clamping pins. M5 hole centre distance is 83 mm.

### 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.

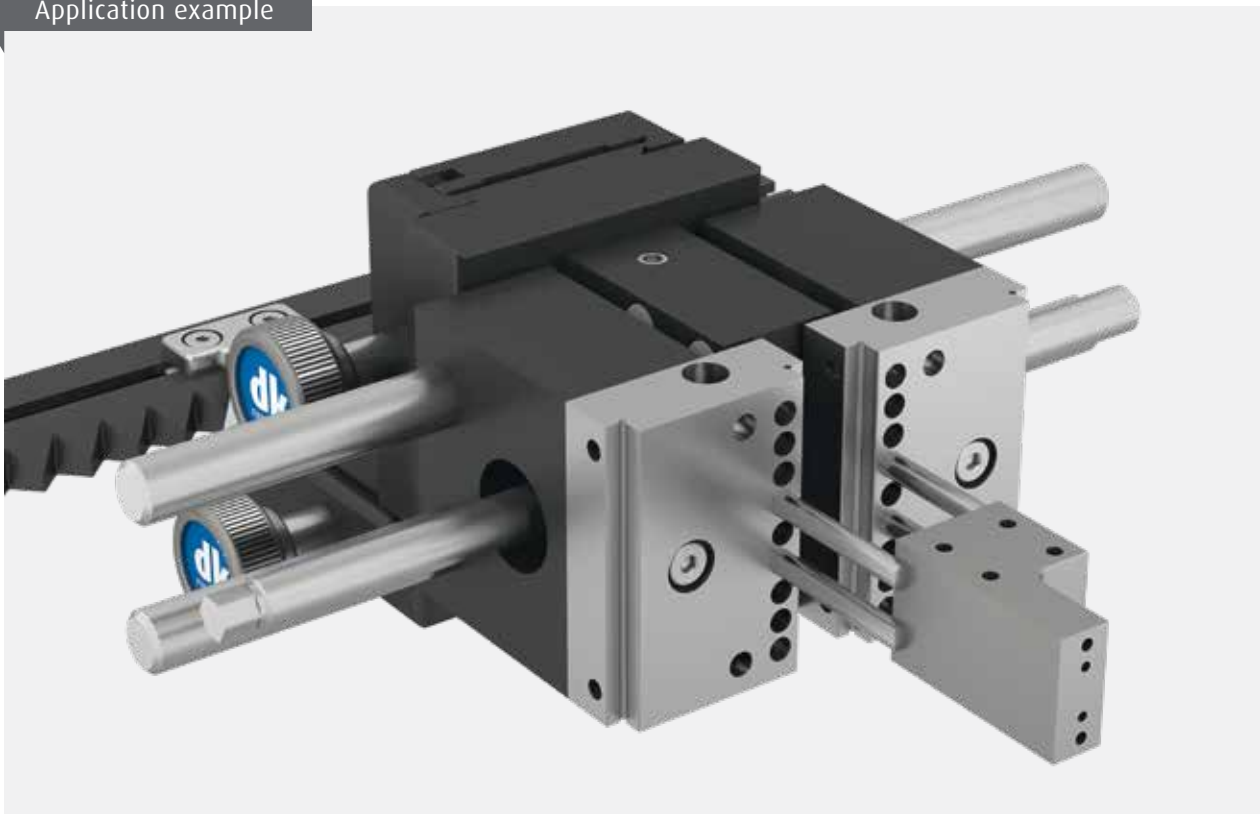


Order No.	Version	Jaw width	Clamping width
282150	SWA 39 (removable)	50	120 mm

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





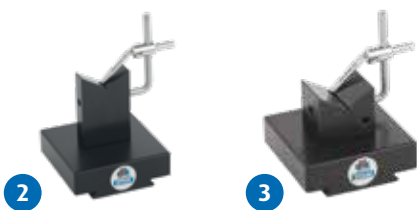
V-block with spring finger

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

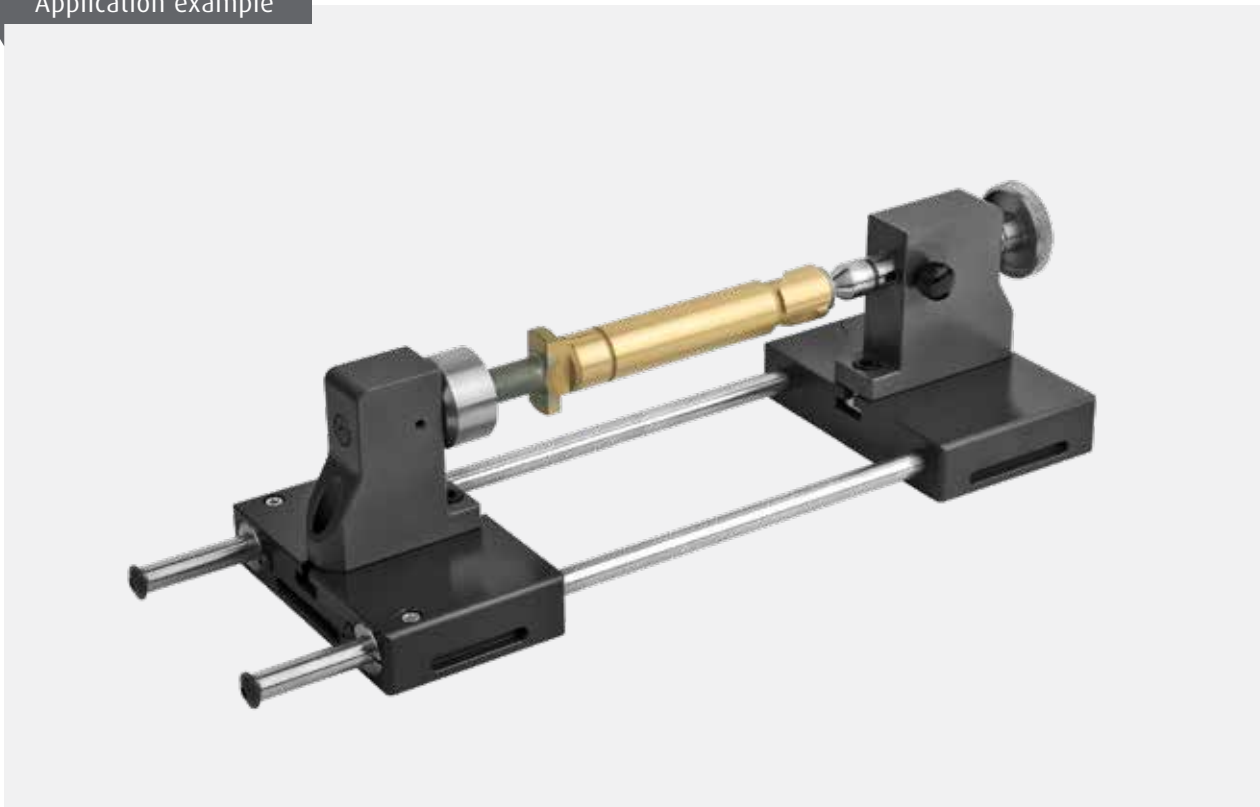
1 piece, movable centre only



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.

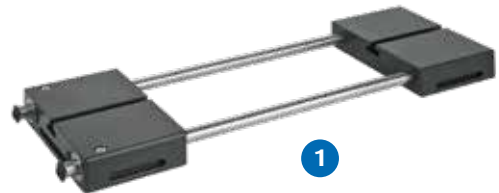
↳ For clamping claws, see page 271.

### 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

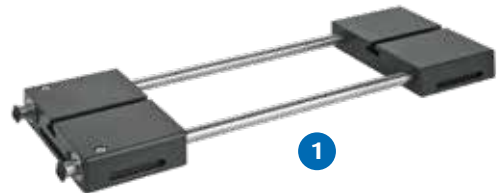
Mounting plate with 6 mm T-slot for mounting tailstocks and/or dividing heads. Suitable for transmitted light measurements on projectors. Infinite adjustment on shaft guides with lock. Plate can be anchored with clamping claws.

### 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).

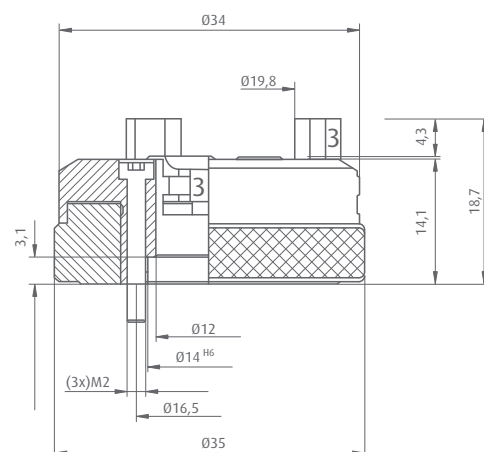
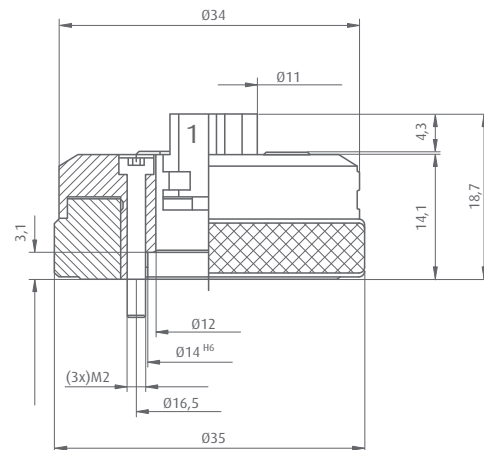
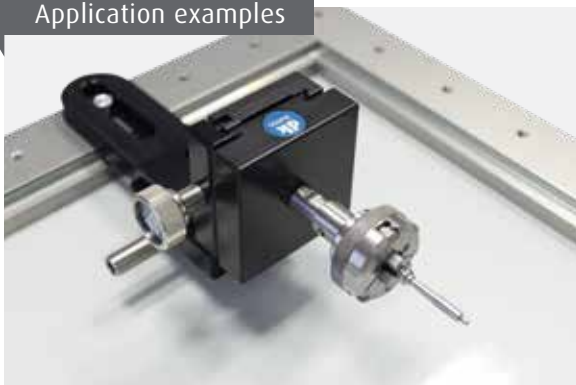
### Material

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		



## 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.

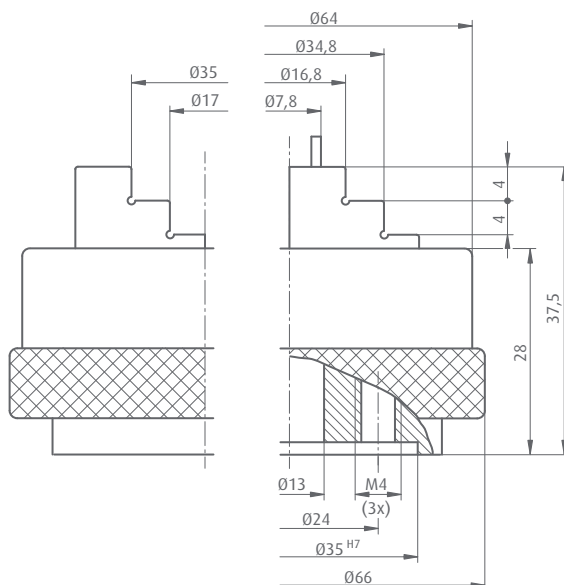
### Material

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



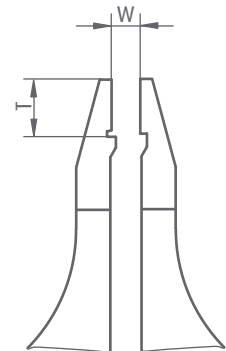
Small-parts clamp with stepped jaw

**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



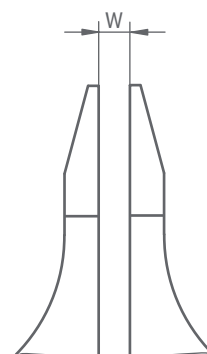
## Small-parts clamp, smooth

### 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



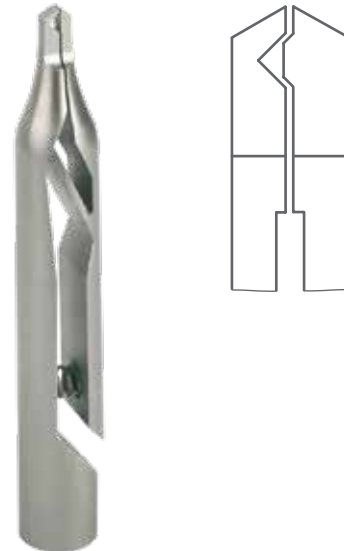
Small-parts clamp with prism jaw

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

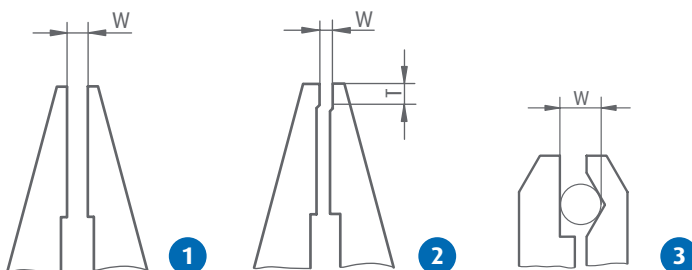
Small-parts clamp with screw tightener

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

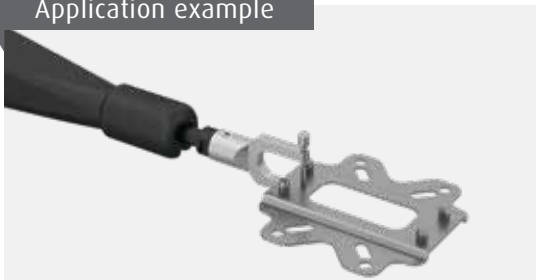
Micro U-clamp for holding small parts with a screw. Connection with an SWA 5 quick-change mount.

### 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



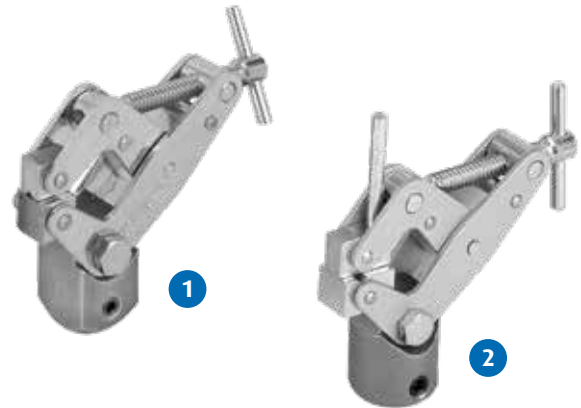
## Parallel clamps

### 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**

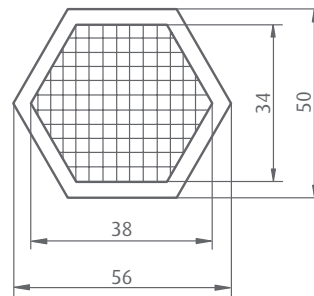
**Description**

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

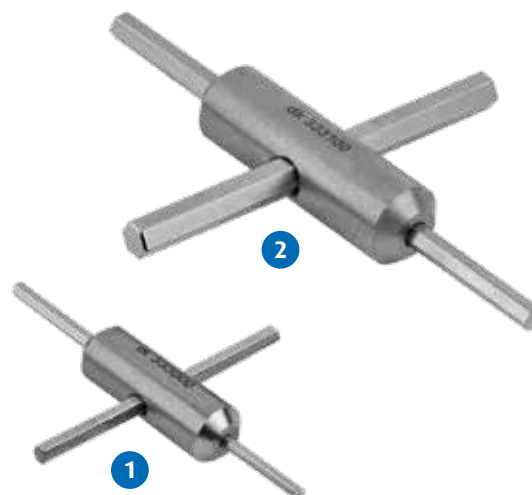
## Four-way hexagon key

### 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

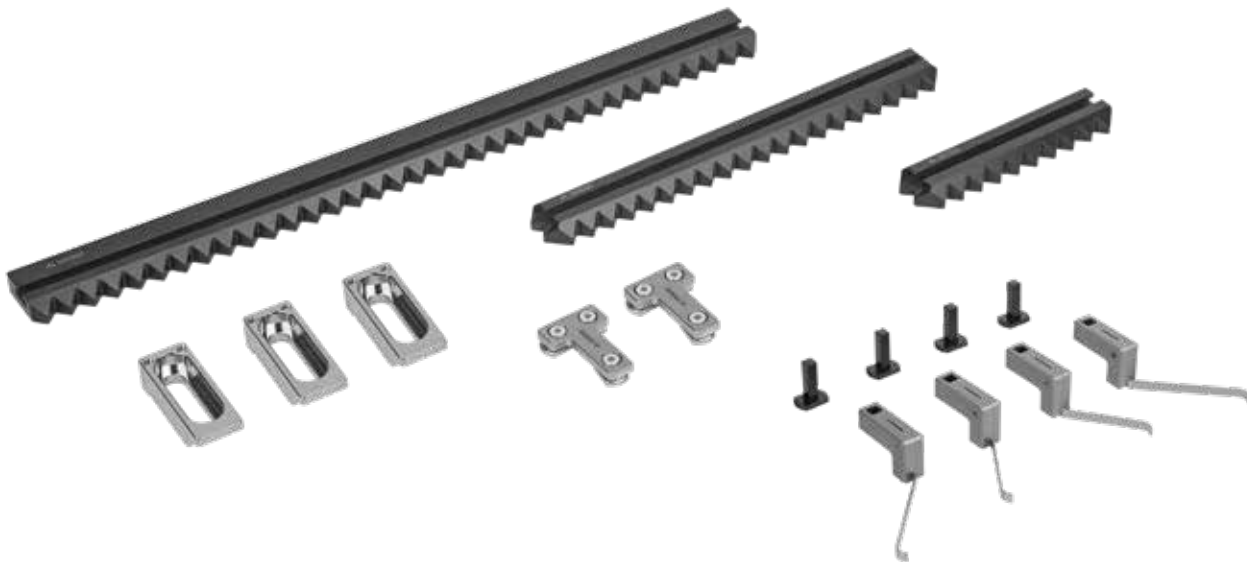
Description

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

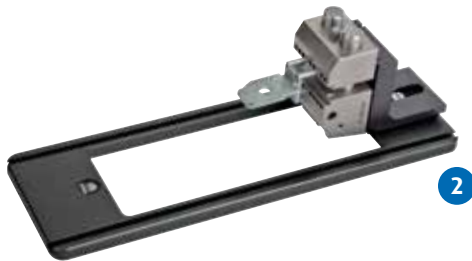
Sets with pallets and differently mounted clamping elements. Available in pallet sizes 305 mm x 100 mm (345801) and 195 mm x 100 mm (345821) mm.



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

