

SINGLE AND MULTIPLE
CLAMPING SYSTEMS



**OFICJALNY PRZEDSTAWICIEL w
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CATALOGUE 2017/2018

WE GENERATE EXCITEMENT.

Since the foundation of the company in 1890 until today the goal has remained the same: the highest quality in products and services. Nevertheless, the circumstances, tasks and challenges have changed, of course. By focussing on our core areas of expertise, we have long set new standards for innovative clamping technology - driven by our own development, the greatest possible flexibility and passion for individual solutions.

All this is only possible with committed and contented employees. Respectful interaction with others, personal development and measures for the wellbeing of each individual are therefore values that matter to us.



Company Management:
Wolfgang Balle, Johannes Maier (CEO), Jürgen Förster

OUR COMPANY HISTORY

- 1890 Company founded as a lock manufacturer by Andreas Maier.
- 1920 Product range extended to include spanners.
- 1928 Production line assembly of FELLBACH LOCKS.
- 1951 Introduces clamping elements and diversifies into workpiece and tool clamping technology.
- 1965 Toggle clamps extend the AMF product range, AMF catalogues are now printed in ten languages.
- 1975 Further specialisation into hydraulic clamping technology.
- 1982 Clamping and fixture systems round off AMF's clamping expertise.
- 1996 AMF team organisation in all sectors of the business, Quality management with certification to ISO 9001.
- 2001 AMF Service Guarantee for all products.
- 2004 Introduction of the ZPS zero-point clamping system.
- 2007 The magnetic clamping technology extends the AMF product range.
- 2009 Development and marketing of AMF Vacuum clamping technology.
- 2012 LOW-COST AUTOMATION gripping, clamping, marking and cleaning.
- 2014 AMF presents the most extensive product range of automation solution in zero-point clamping technology.
- 2017 Wireless sensing systems extend the expertise into Industry 4.0 and blends seamlessly into the AMF product range.

PLEDGES THAT COUNT IN EVERYDAY LIFE

For this reason, we have a few principles that we follow by conviction and which always apply..

INDIVIDUAL DEVELOPMENT

Even if the product you need does not even exist yet, we will find the right solution with you: from special designs to new developments, everything is possible.

WARRANTY

If, despite our high quality standard, there is a complaint, this is dealt with quickly and unbureaucratically, even beyond the warranty period.

HIGHEST QUALITY STANDARDS

Careful manufacturing based on tradition since 1890, and naturally with a modern quality management system according to ISO 9001 for many years.

SHORT DELIVERY TIME

With over 5,000 articles in our warehouse, you can expect your order to be dispatched on the same day.

COMPETENT SERVICE FROM EXPERTS

Your local retail partner or the specialists in our team will find the right solution for every task.

MADE IN GERMANY

Our entire product range is developed and manufactured exclusively by our employees in Germany.

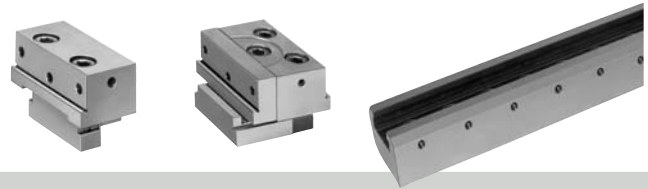
**COLLET - MECHANICAL AND HYDRAULIC
COLLET ATTACHMENT FOR ZERO-POINT CLAMPING MODULES**

4 - 10



MULTIPLE CLAMPING SYSTEM NO. 6371

12 - 23



PNEUMATIC VICE

24 - 29



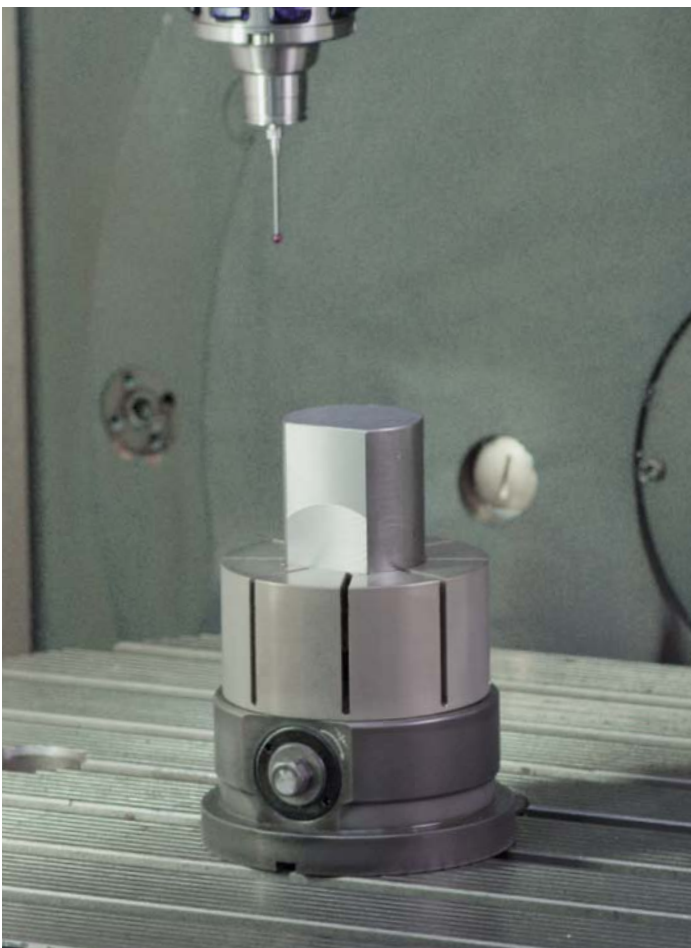
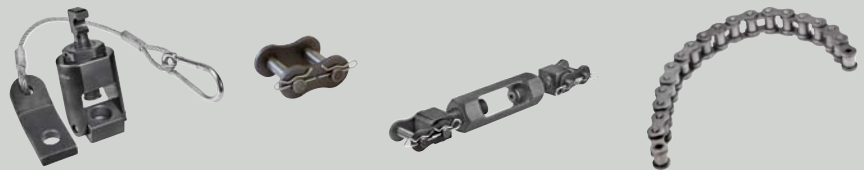
MULTIPLE CLAMPING SYSTEM NO. 6376

30 - 44



CHAIN CLAMPING SET

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Subject to technical alterations.

No. 6375M

Mechanical collet
incl. body

Order no.	Clamping force max.* [kN]	Clamping stroke \emptyset [mm]	Tightening torque Md max. [Nm]	Weight [Kg]
533281	11	0,3	40	4,5

Design:

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

Application:

For clamping complex workpiece contours for 5-sided machining in the machine tool. The counterplate of the workpiece is milled into the collet attachment with a minimum clamping depth of 2 mm. Because the clamping force is evenly applied to the component in a radial direction, the counterplate is clamped warp-free. The clamping force can be adjusted via the clamping screw, using a torque wrench, for example. Consequently, it is especially suitable for thin-walled pipes and workpieces.

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

The collet attachment can be milled off up to a height of H1, thus allowing new workpiece contours to be introduced.

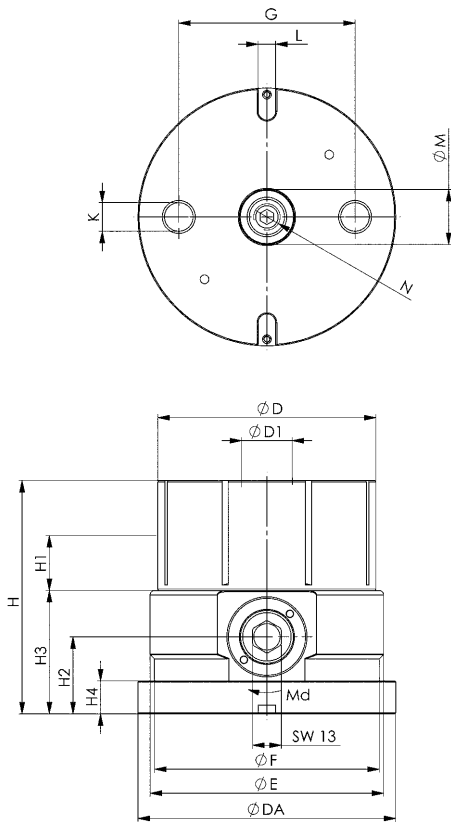
Note:

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



Dimensions:

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



No. 6375H

Hydraulic collet incl. body

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



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

Design:

Hydraulic pressure of 40 - 60 bar is required for opening the collet. In the de-pressurised state, the collet attachment is securely tensioned by the integrated spring package. The main body is made of burnished steel. The collet attachment, which is supplied as standard, has a diameter of 99 mm and is made of anodised, high-strength aluminium. The hydraulic clamping unit is protected against dirt and cooling water. Circumferential clamping edge for fastening to the machine table. The holder for the AMF K20 Zero Point system, as well as grooves for positioning on AMF Zero Point clamping modules with indexing, are applied to the underside. For automated operation, a hydraulic connection, sealed in the delivered condition, is present on the underside. The lateral hydraulic connection is suitable for the mounting of a quick-release coupling with connection thread G1/4.

Application:

For clamping complex workpiece contours for 5-sided machining in the machine tool. The counterplate of the workpiece is milled into the collet attachment with a minimum clamping depth of 2 mm. Since the clamping force is evenly applied to the component in a radial direction, the counterplate is clamped warp-free. Thanks to the simple collet attachment replacement, various workpieces can be quickly and securely clamped for 5-sided machining. The collet attachment can be milled off up to a height of H1, thus allowing new workpiece contours to be introduced.

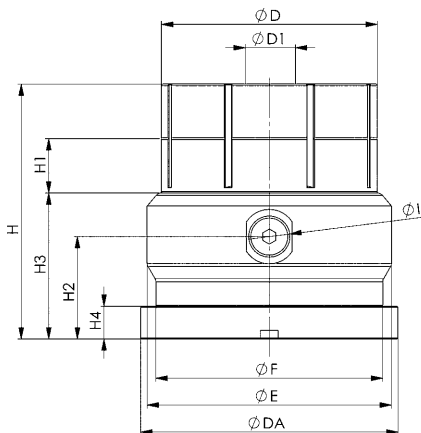
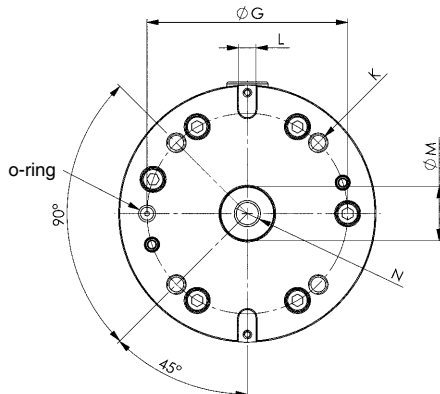
Note:

With a mounted collet attachment, the clamping unit must not be closed without a workpiece.

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

Dimensions:

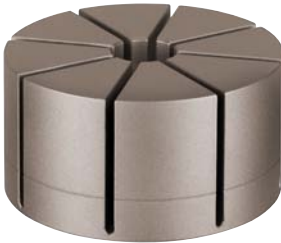
Order no.	dia. D	dia. D1	dia. DA	dia. E	dia. F	dia. G	H	H1	H2	H3	H4	dia. I	K	L	dia. M	N
545582	99	23	118	112	104	92	117	25	47	67	15	G1/4	M8	8 K7	25	M12



No. 6375Z-99

Collet attachment dia. 99

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



Order no.	dia. D	dia. D1	Clamping stroke Ø [mm]	H	H1	Weight [g]
428649	99	23	0,3	50	25	870

Design:

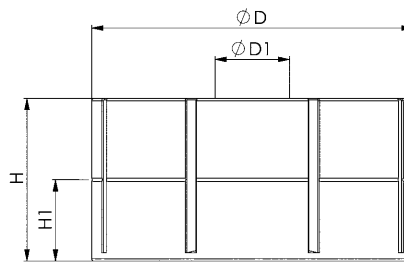
The collet attachment with diameter 99 mm fits the collet elements order no. 533281 and order no. 545582. The collet attachment is made of anodised, high-strength aluminium.

Application:

The collet attachment is fastened to the main element by just one centrally applied screw and is therefore quickly replaced. The workpiece contour is milled into the collet attachment with a minimum clamping depth of 2 mm. Because the clamping force is evenly applied to the component in a radial direction, the counterplate is clamped warp-free.

The collet attachment can be milled off to a height of H1, allowing new workpiece contours to be introduced.

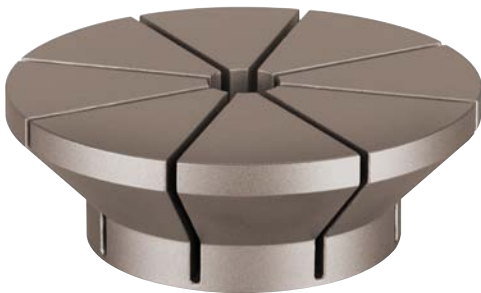
The maximum workpiece diameter is 90 mm.



No. 6375Z-149

Collet attachment dia. 149

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



Order no.	dia. D	dia. D1	dia. D2	Clamping stroke Ø [mm]	H	H1	H2	Weight [g]
428656	149	23	99	0,3	50	25	10	870

Design:

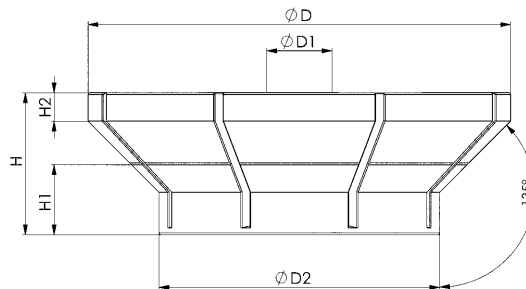
The collet attachment with diameter 149 mm fits the collet elements order no. 533281 and order no. 545582. The collet attachment is made of anodised, high-strength aluminium.

Application:

The collet attachment is fastened to the main element by just one centrally applied screw and is therefore quickly replaced. The workpiece contour is milled into the collet attachment with a minimum clamping depth of 2 mm. Because the clamping force is evenly applied to the component in a radial direction, the counterplate is clamped warp-free.

The collet attachment can be milled off to a height of H1, allowing new workpiece contours to be introduced.

The maximum workpiece diameter is 140 mm.



No. 6375ZK-99

Collet attachment dia. 99

Material: polyamide.

Order no.	dia. D	dia. D1	Clamping stroke \varnothing [mm]	H	H1	Weight [g]
550278	99	23	1,0	50	25	360

Design:

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

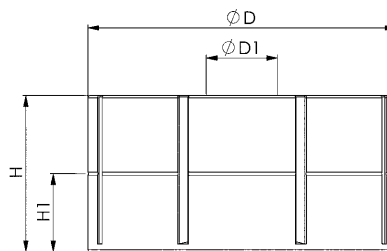
Application:

The collet attachment, made of polyamide, is suitable for clamping pressure-sensitive workpieces and materials.

The collet attachment is fastened to the main element by just one centrally applied screw and is therefore quickly replaced. The workpiece contour is milled into the collet attachment with a minimum clamping depth of 2 mm. Since the clamping force is evenly applied to the component in a radial direction, the counterplate is clamped warp-free.

The collet attachment can be milled off to a height of H1, allowing new workpiece contours to be introduced.

The maximum workpiece diameter is 90 mm.

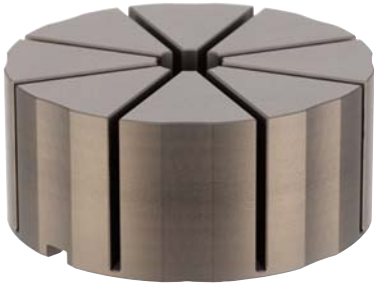


Subject to technical alterations.

No. 6370ZSZ-112

Collet attachment for clamping module K20, hydr.

Material: high-strength aluminium.



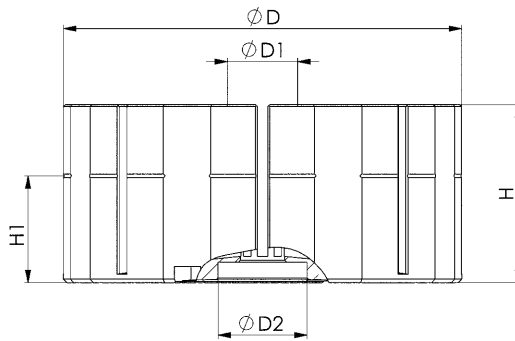
Order no.	dia. D	dia. D1	dia. D2	Clamping stroke Ø [mm]	H	H1	Weight [g]
550286	112	20	25	0,5	50	30	1133

Design:

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

Application:

The collet attachment is placed on the AMF Zero Point clamping system K20 in the hydraulic version and guides the radial clamping force to the workpiece after the clamping module is closed. The workpiece contour is milled into the collet attachment with a minimum clamping depth of 2 mm. The collet attachment can be milled off to a height of H1, allowing new workpiece contours to be introduced. The maximum workpiece diameter is 100 mm.



No. 6370ZSB

Mounting kit for collet attachment

for collet No. 6370ZSZ-112



Order no.	Size	Weight [g]
550287	K20	190

Design:

The mounting set includes:
 - 1 clamping nipple K20, design: strut
 - 1 clamping nipple screw K20
 - 1 lock nut M12
 - 2 indexing slot nuts, width 8 mm

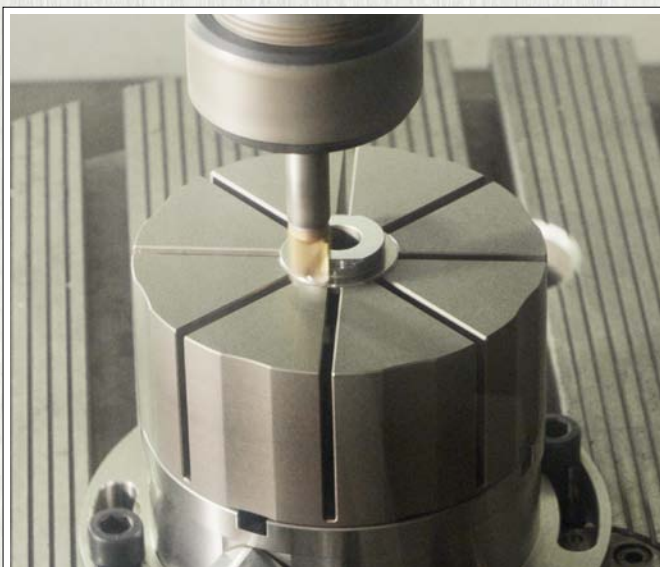
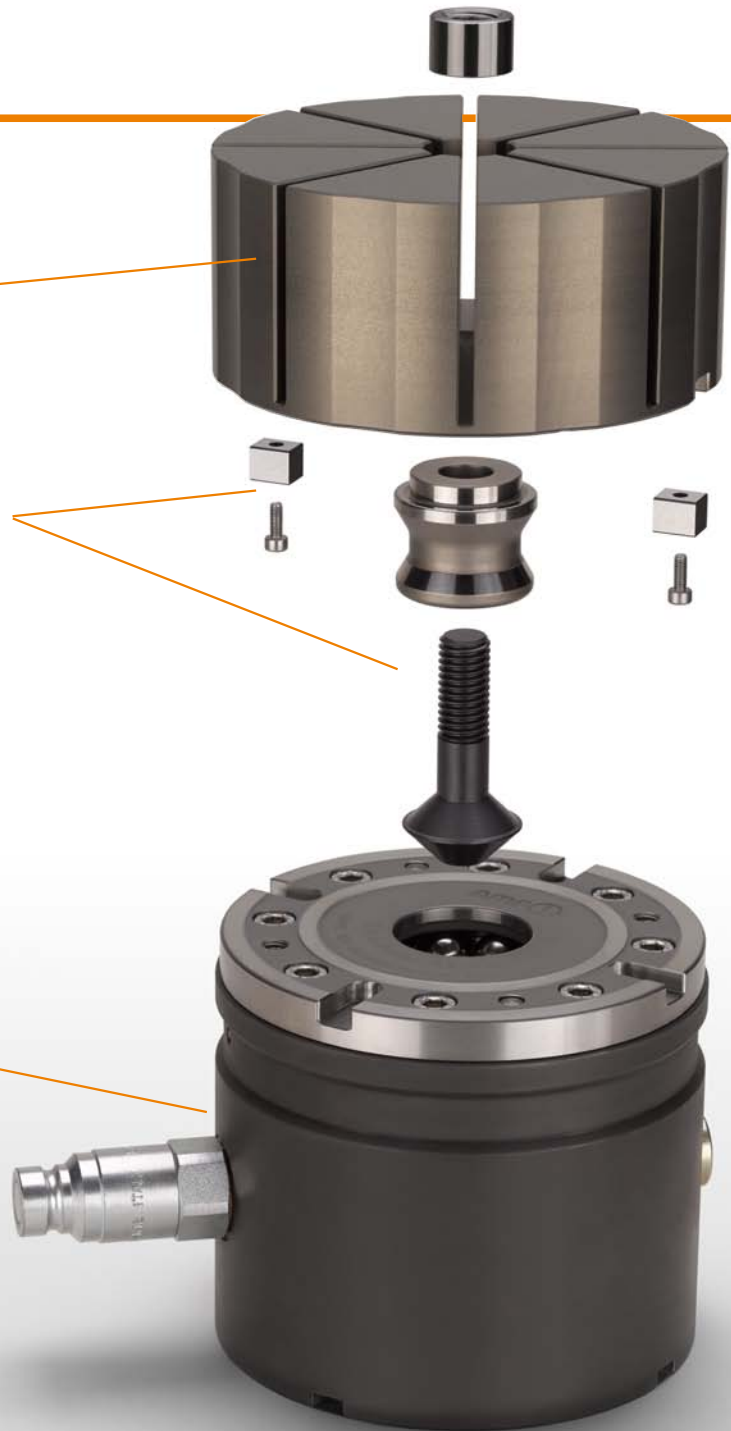
Application:

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

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

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

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



Subject to technical alterations.

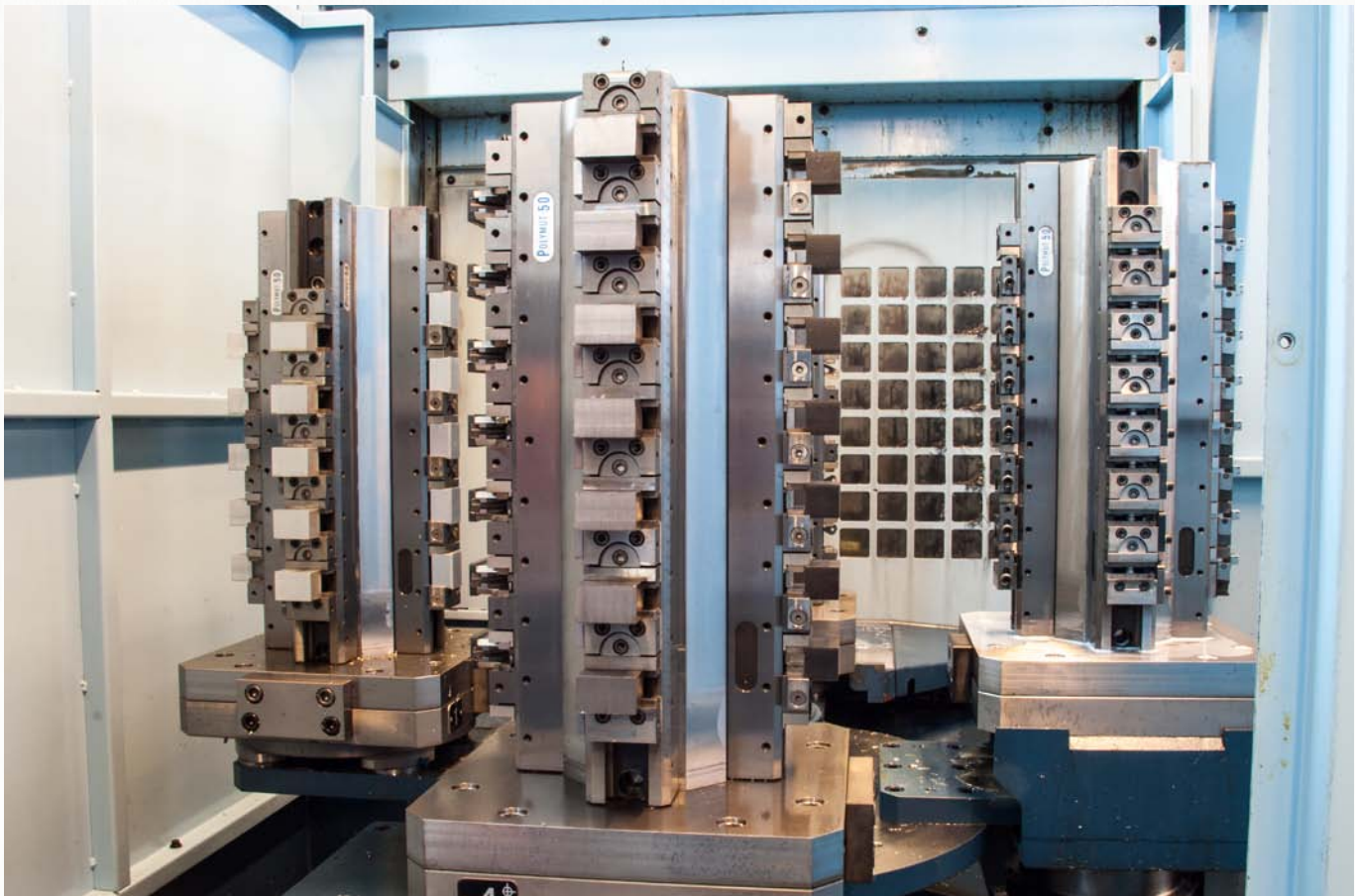


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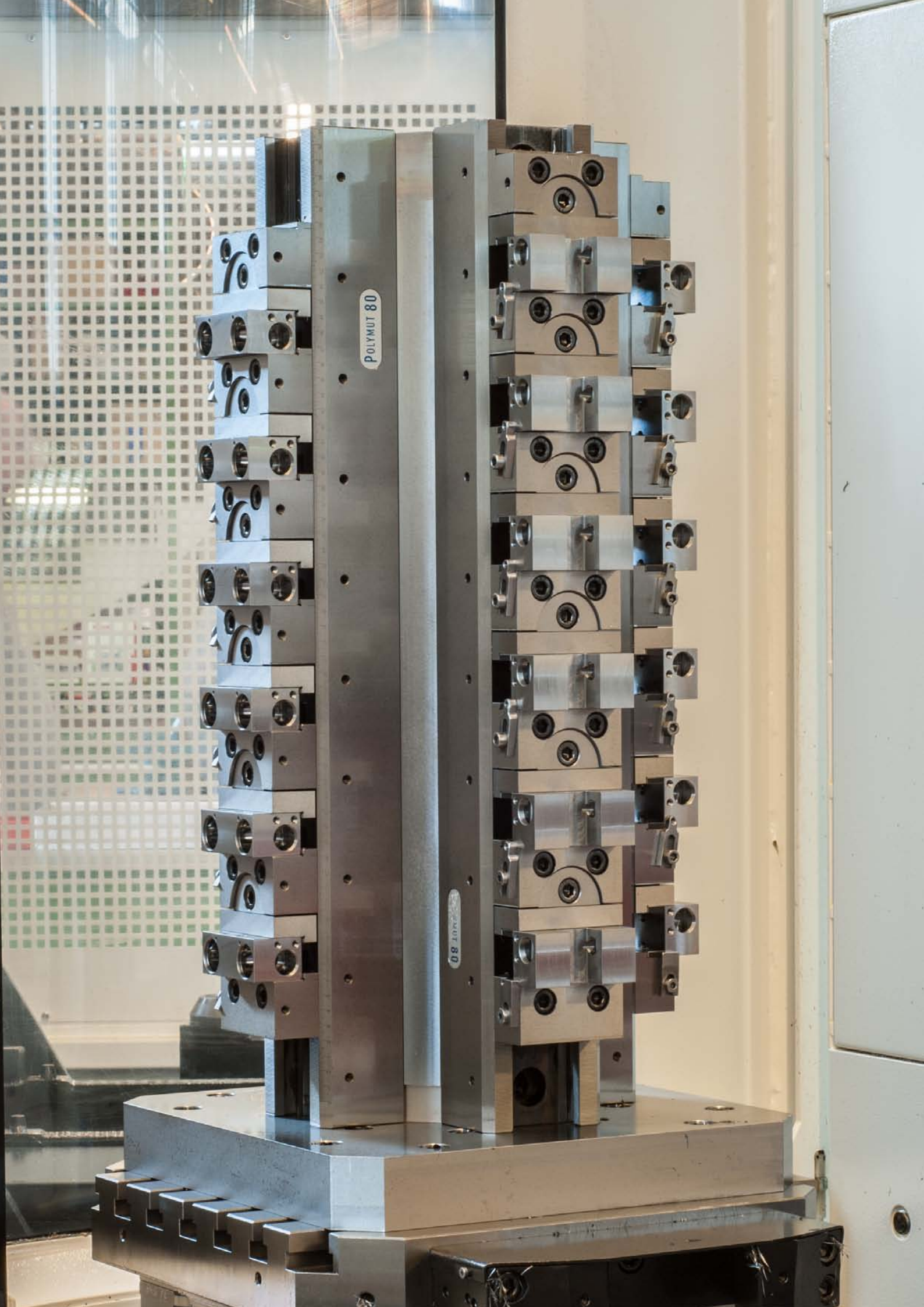


- + Outstanding price-performance ratio
- + Drastically reduced tooling time
- + Immediate improvement of productivity
- + Repeat accuracy < 5µm
- + Stainless steel
- + Form fit





Subject to technical alterations.

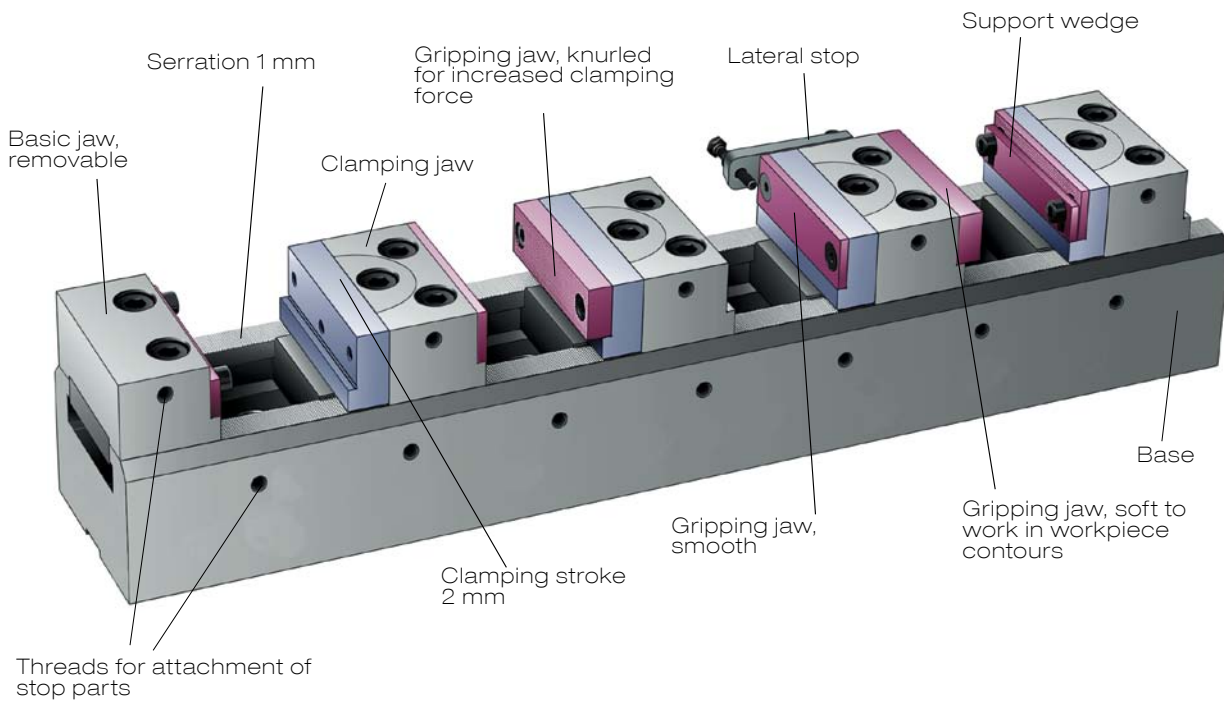


POLYMUT 80

80

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

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



WORK-PIECE QUANTITIES FOR MULTIPLE CLAMPING SYSTEMS

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

SIMPLE MOUNTING IN TWO STEPS

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

Tightening torque for mounting bolts of strength class 12.9:

Clamping jaw width	Attachment of basic jaws	Attachment of clamping jaws
50	2 x M6, max. 25 Nm	2 x M6, max. 20 Nm
80	2 x M10, max. 30 Nm	2 x M10, max. 30 Nm

2 CLAMPING THE WORKPIECE BY TIGHTENING THE CLAMPING JAWS

FIRST STEP:

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

SECOND STEP:

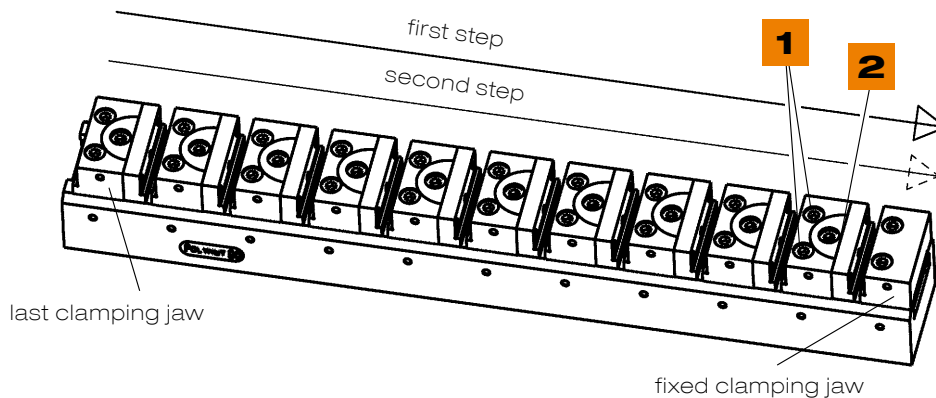
Then tighten the clamping bolt with a torque wrench (pay attention to the diagrams shown below).
Also always start at the last clamping jaw.

NOTE:

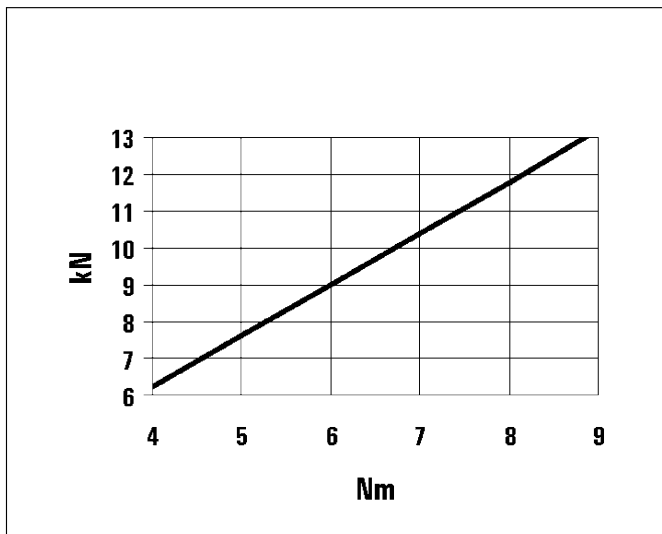
Recommended lubricant for the clamping screws of the jaws and the cone: **Molykote TP42**

You can obtain a centring sleeve for marking and positioning under the following order numbers:

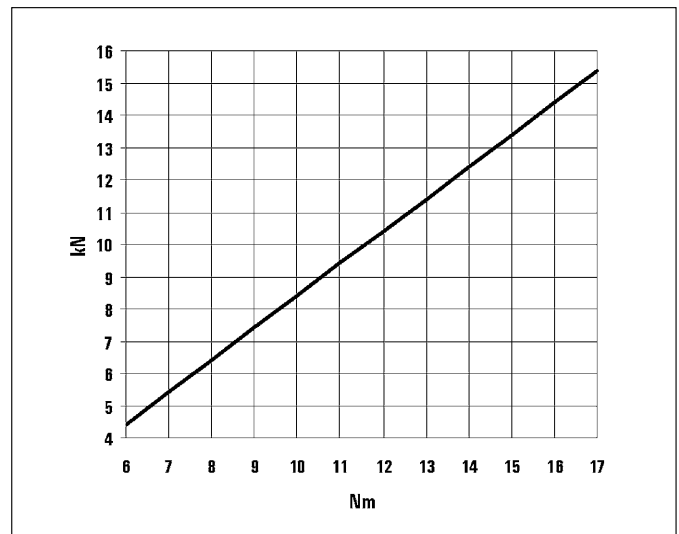
1. For fitting diameter 16F7 with thread M12 = Order No. 78006
2. For fitting diameter 22F7 with thread M16 = Order No. 78238



Clamping jaw width 50 – **max. clamping force 12 kN**



Clamping jaw width 80 – **max. clamping force 15 kN**



No. 6371G-50

Base element

Jaw width 50 mm.

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

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

No. 6371G-80

Base element

Jaw width 80 mm.

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

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

No. 6371G-80

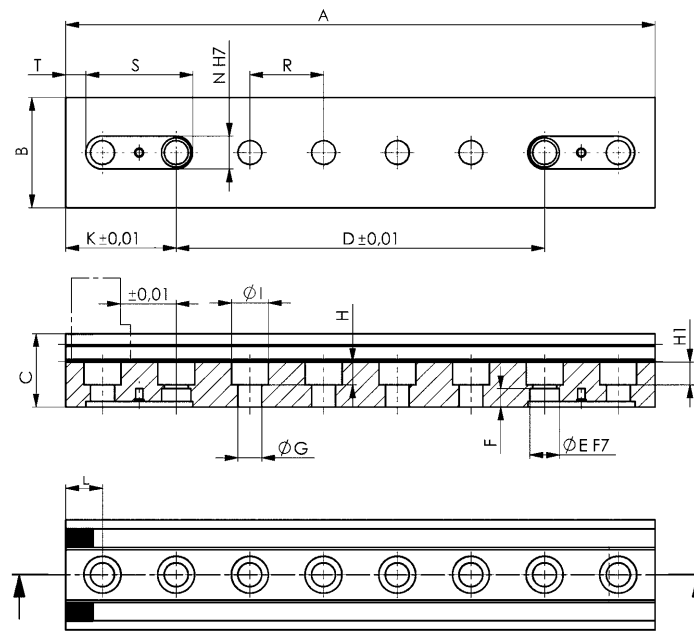
Base element

Jaw width 80 mm.

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

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





Dimensions:

Order no.	Size	A	B	C	D	dia. E F7	F	dia. G	H	H1	dia. I	K	L	NH7	R	S	T
304873	50-250-040	250	60	40	200	16	10	13	12,5	12,5	19	25	25	18	40	58	16
304923	50-320-040	320	60	40	200	16	10	13	12,5	12,5	19	60	20	18	40	58	11
304899	50-500-040	500	60	40	400	16	10	13	12,5	12,5	19	30	30	18	40	58	21
304949	50-600-040	600	60	40	400	16	10	13	12,5	12,5	19	100	20	18	40	58	51
304915	50-650-040	650	60	40	400	16	10	13	12,5	12,5	19	100	20	18	40	58	51
304964	50-700-040	700	60	40	400	16	10	13	12,5	12,5	19	150	30	18	40	58	101

Order no.	Size	A	B	C	D	dia. E F7	F	dia. G	H	H1	dia. I	K	L	NH7	R	S	T
304774	80-350-040	350	90	60	200	16	10	13	12,5	12,5	19	75	35	18	40	58	26
304824	80-500-040	500	90	60	400	16	10	13	12,5	12,5	19	30	30	18	40	58	21
304790	80-600-040	600	90	60	400	16	10	13	12,5	12,5	19	100	20	18	40	58	51
304840	80-650-040	650	90	60	400	16	10	13	12,5	12,5	19	125	45	18	40	58	76
304816	80-700-040	700	90	60	400	16	10	13	12,5	12,5	19	150	30	18	40	58	101

Order no.	Size	A	B	C	D	dia. E F7	F	dia. G	H	H1	dia. I	K	L	NH7	R	S	T
304766	80-350-050	350	90	60	200	22	13	17	17	17	25	75	25	18	50	68	16
304782	80-500-050	500	90	60	400	22	13	17	17	17	25	75	25	18	50	68	16
304733	80-600-050	600	90	60	400	22	13	17	17	17	25	100	50	18	50	68	41
304758	80-650-050	650	90	60	400	22	13	17	17	17	25	125	25	18	50	68	66
304808	80-700-050	700	90	60	400	22	13	17	17	17	25	150	50	18	50	68	91

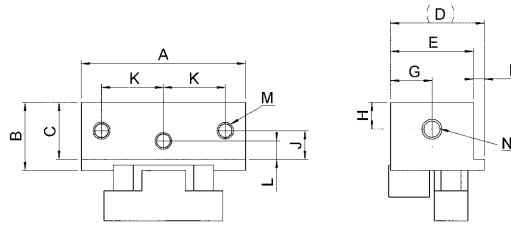
No. 6371

Base jaw, standard

First stop on base element, hardened 60 HRC.



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



Dimensions:

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

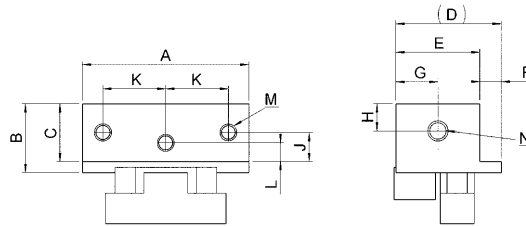
No. 6371

Base jaw, deep

First stop on base element, hardened 60 HRC.



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



Dimensions:

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

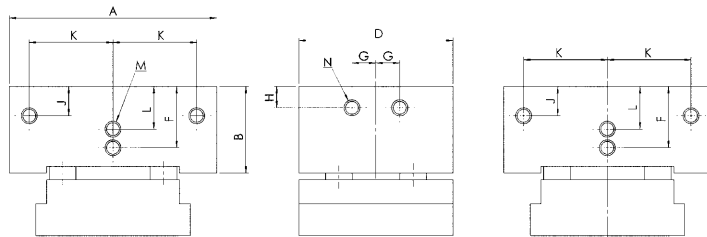
No. 6371

Base jaw, without step

First stop on base element, hardened 60 HRC.



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



Dimensions:

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

Subject to technical alterations.

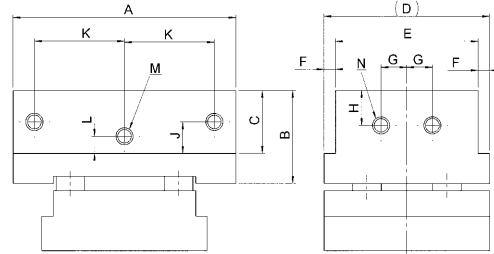
No. 6371

Central jaw

For clamping from two sides, hardened 60 HRC.



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



Dimensions:

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

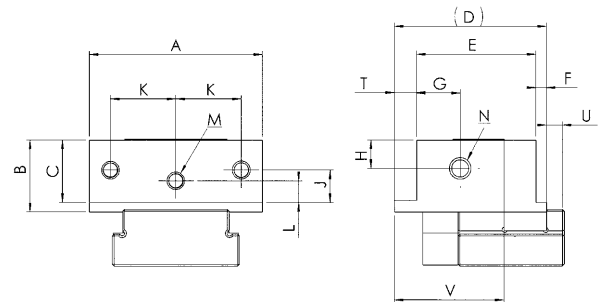
No. 6371

Clamping jaw, standard

With one clamping bolt and two mounting bolts. Hardened 60 HRC.



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



Dimensions:

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

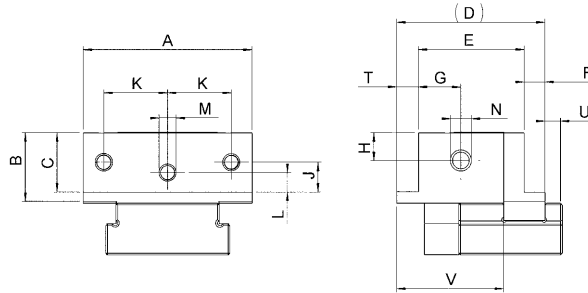
Subject to technical alterations.

No. 6371

Clamping jaw, deep

With one clamping bolt and two mounting bolts.
Hardened 60 HRC.

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



Dimensions:

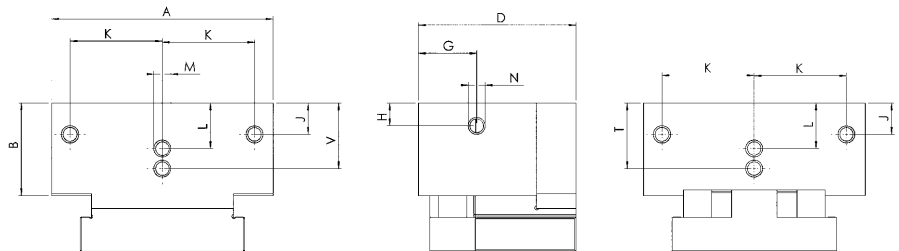
Order no.	Size	A	B	C	D	E	F	G	H	J	K	L	M	N	T	U	V
300863	4109-50	49	20,0	17	43	30,7	6	12,4	8	8,5	18,5	5,5	6xM5	2xM6	6,3	5	31
300889	4119-80	78	32,2	22	64	48,0	8	19,0	8	11,0	31,5	6,0	6xM6	2xM6	8,0	7	46

No. 6371

Clamping jaw, without step

With one clamping bolt and two mounting bolts.
Hardened 60 HRC.

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



Dimensions:

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

Subject to technical alterations.

No. 6371

Clamping jaw, with crescent

With one clamping bolt for size 50 or two bolts for size 80, and with two mounting bolts.
Hardened 60 HRC.

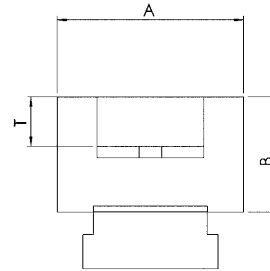
Order no.	Size	for jaw width	Clamping force [kN]	Clamping stroke [mm]	Weight [g]
305011	50110-50	50	12	1,4	280
305037	80110-80	80	15	1,4	1000



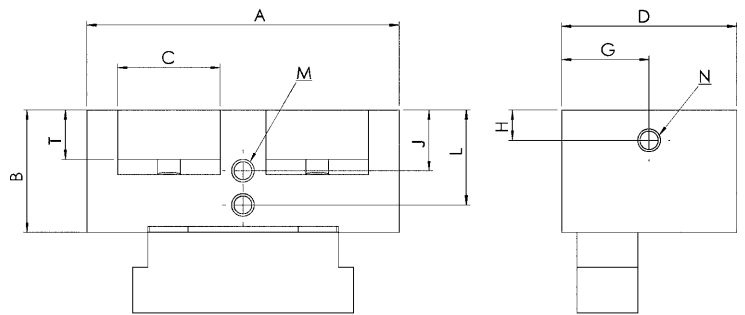
Jaw width 50



Jaw width 80



Jaw width 50



Jaw width 80

Dimensions:

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

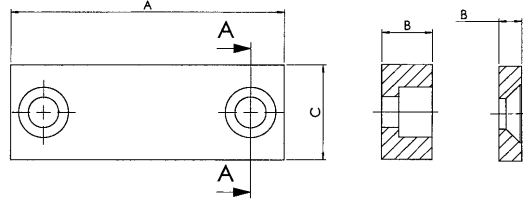
No. 6371

Gripping jaw, smooth

Hardened 60 HRC.



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



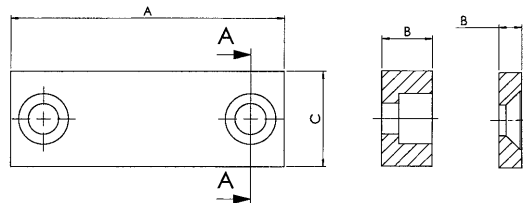
No. 6371

Gripping jaw, smooth

not hardened.



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



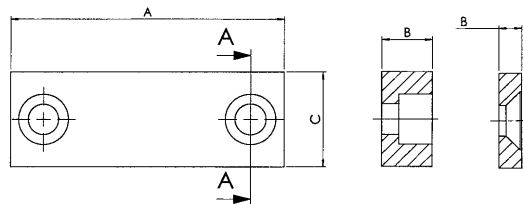
No. 6371

Gripping jaw, knurled

Hardened 60 HRC.



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



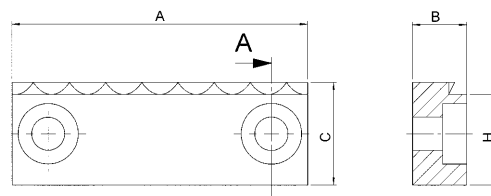
No. 6371

Gripping jaw, with claws

Hardened 60 HRC. Clamping edge height only 2 mm.



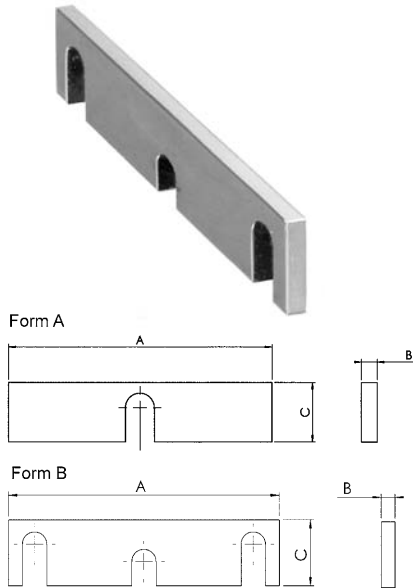
Order no.	Size	for jaw width	DIN 7894	A	B	C	H ±0.02	Weight [g]
305086	100-50-12	50	M5 x20	49	12	17	15	70
305094	100-80-12	80	M6 x 20	78	12	22	20	150



Subject to technical alterations.

No. 6371

Support wedge



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

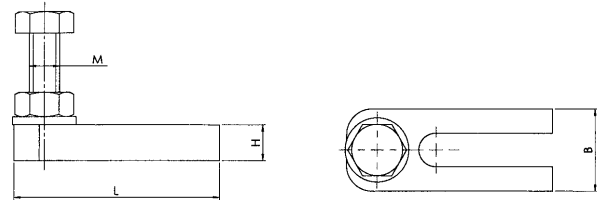
No. 6371

Lateral stop (additional)

For base, central and clamping jaw.



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



No. 6371

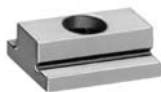
Chip guard



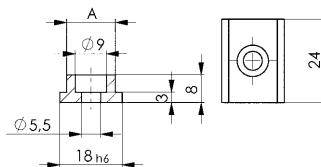
Order no.	Size	for jaw width	Weight [g]
300939	4221-50	50	19
300954	4390-80	80	43

No. 6371

T-nut



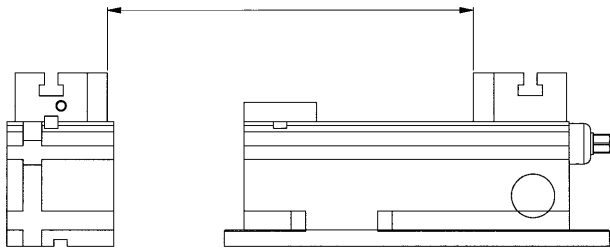
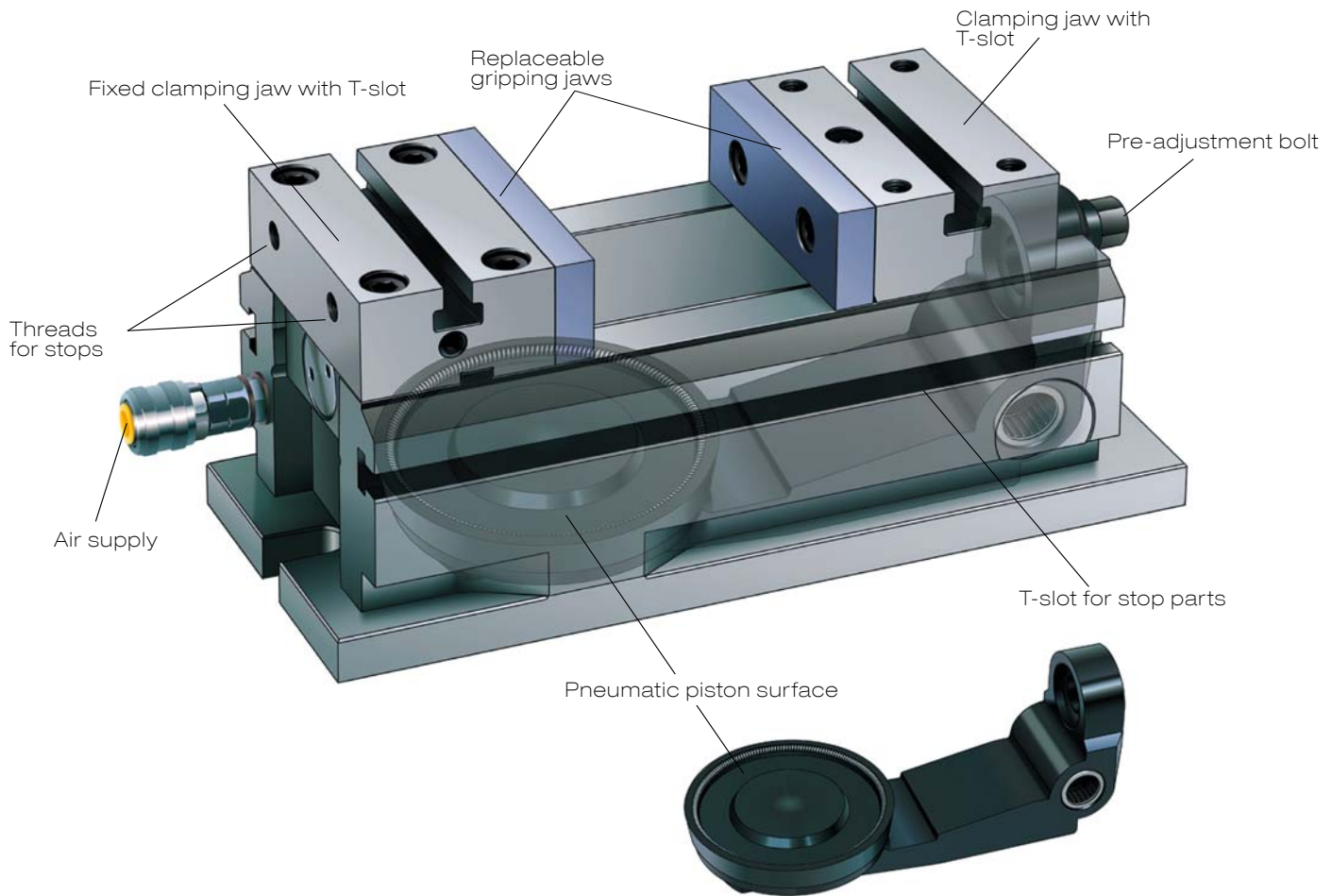
Order no.	Size	A	Weight [g]
301010	9010-10	10	16
301036	9012-12	12	17
301051	9014-14	14	18
301077	9018-18	18	23



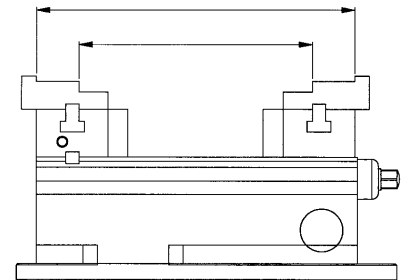
Subject to technical alterations.

PNEUMATIC VICE - THE ADVANTAGES AT A GLANCE

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



Vice with modular carrier



Vice with stepped gripping jaw

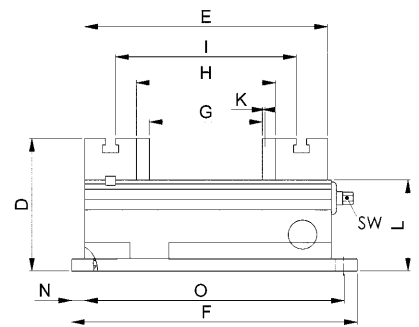
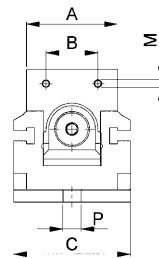
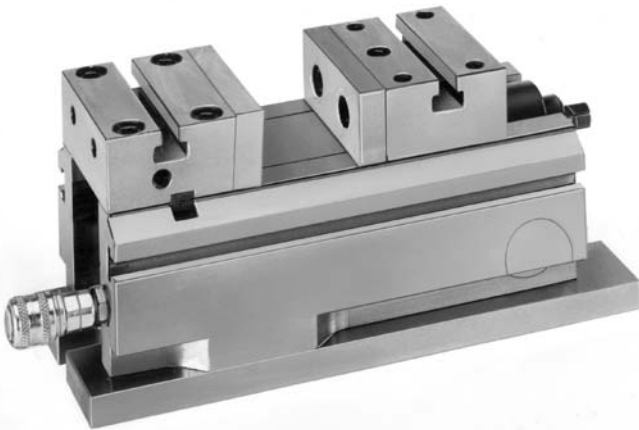
No. 6372

Base element

Hardened 56 HRC

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

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



Dimensions:

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

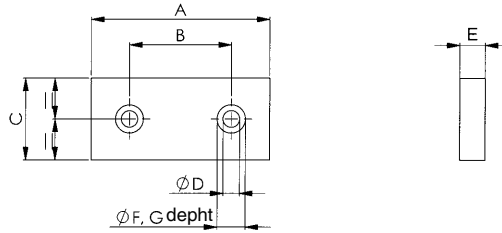
No. 6372

Gripping jaw, smooth

Hardened 60 HRC.



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



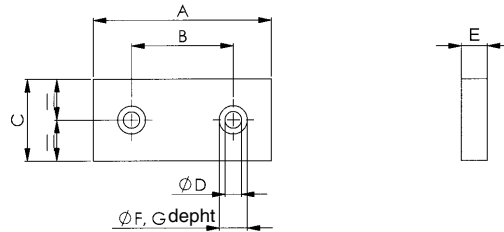
No. 6372

Gripping jaw, knurled

Hardened 60 HRC.



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



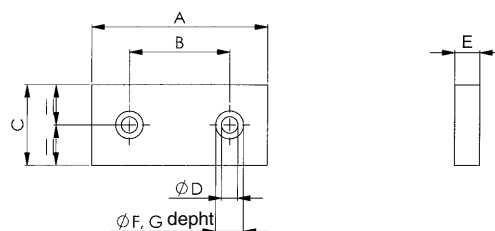
No. 6372

Gripping jaw, smooth

Not hardened, for individual processing.



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



Subject to technical alterations.

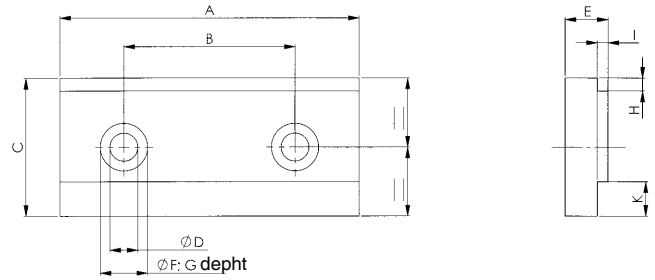
No. 6372

Gripping jaw, stepped

Hardened 60 HRC.



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



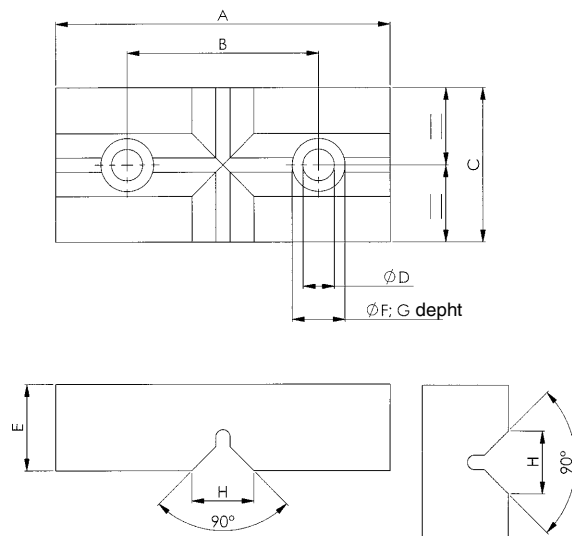
No. 6372

Gripping jaw, V-block

Hardened 60 HRC.



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

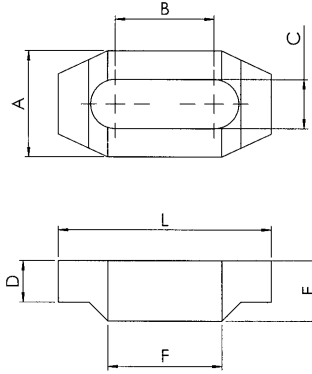


Subject to technical alterations.

No. 6372

Double-ended clamp

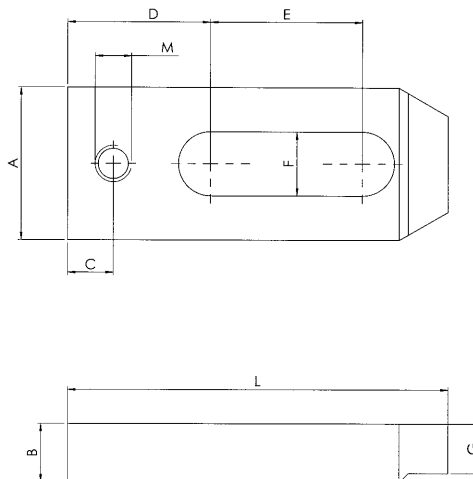
Order no.	Size	A	B	C	D	E	F	L	Weight [g]
301804	5003-E070-E090	28	26	13	11	16	30	56	135
301796	5001-E100-E200	38	30	17	16	18	34	60	226



No. 6372

Straight clamp

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

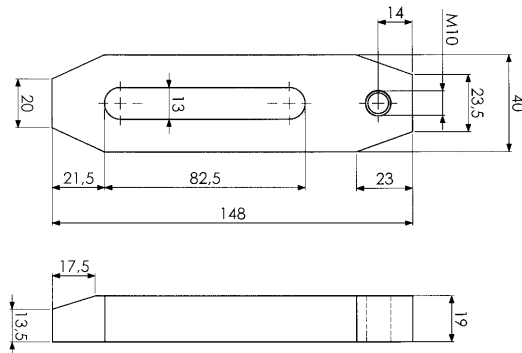


No. 6372

Stop



Order no.	Size	Weight [g]
301861	5004	643



No. 6372

Pneumatic valve



Order no.	Size	Weight [g]
301903	6001	1037

No. 6372

Air filter and pressure regulator



Order no.	Size	Weight [g]
301929	6002	1079

No. 6376G

Clamping rail

Max. clamping force per clamping position 30 kN

Order no.	Size	B	dia. D1 +0.01	dia. D2	H ±0.02	H1	H2	L	M	S1 +0.03	SM1 ±0.01	SM2 ±0.01	Weight [g]
429035	50x300	50	25	13	80	10	26	300	M12	5,5	50	100	6700
429050	50x400	50	25	13	80	10	26	400	M12	5,5	50	150	9160
429076	80x400	80	25	13	80	10	26	400	M12	5,5	50	150	16700
429092	50x500	50	25	13	80	10	26	500	M12	5,5	50	200	11650
429118	80x500	80	25	13	80	10	26	500	M12	5,5	50	200	21000
429134	80x600	80	25	13	80	10	26	600	M12	5,5	-	250	25200

Design:

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

Designed for the following mounting options on the machine table:

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

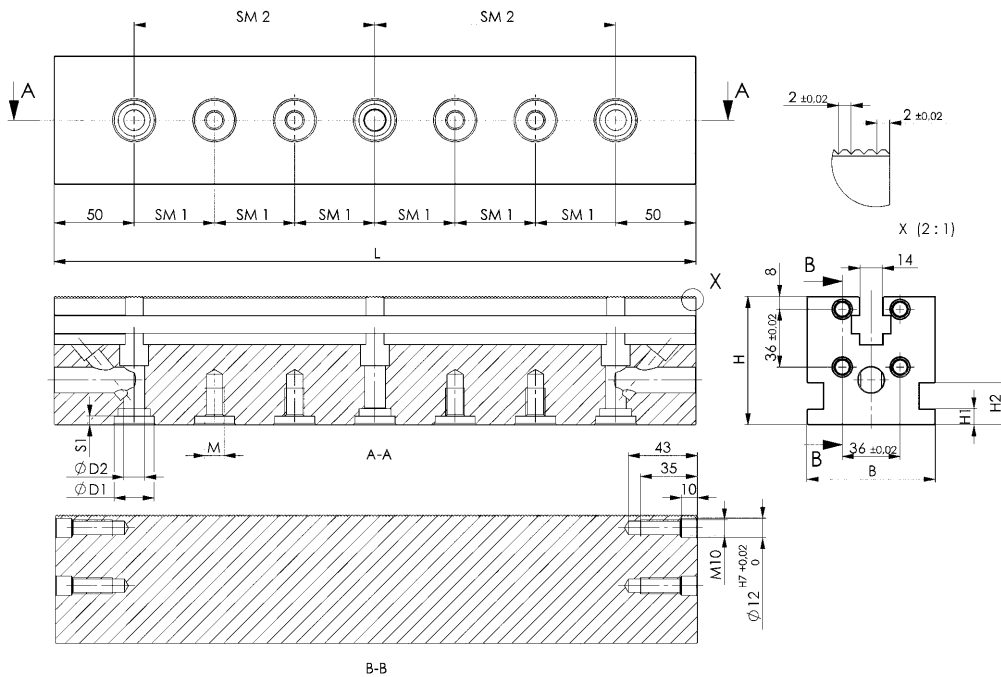
Other mounting holes, for example clamping nipple K10 or K40, can be supplied any time on request. Positioning steps on the clamping rail grating is possible at intervals of 2 mm.

Application:

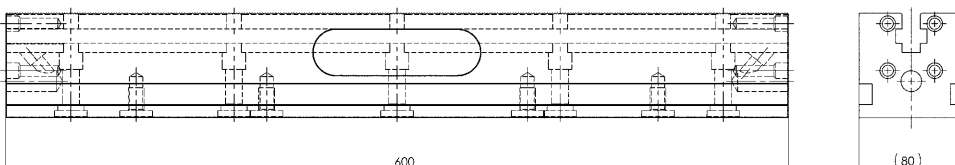
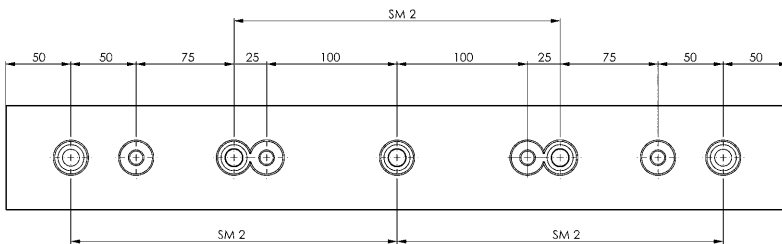
Modularly constructed clamping system, which has its advantages in the versatile application possibilities.

Optionally designed for one or more workpieces.

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



for 429134



Subject to technical alterations.



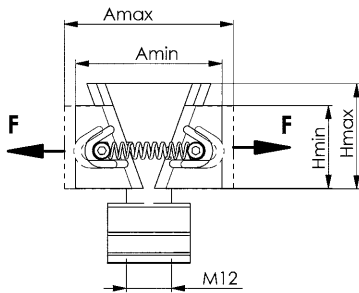
No. 6376K

Wedge clamp

Smooth clamping surfaces

Scope of supply:

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



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

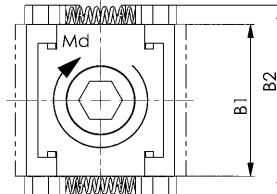
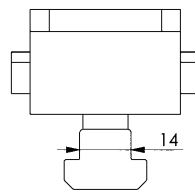
Design:

Material: case-hardened steel 21MnCr5

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

Application:

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



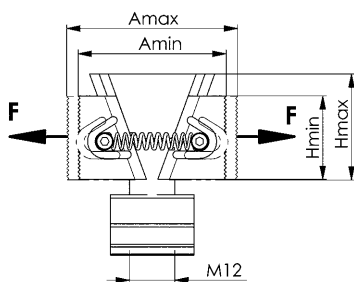
No. 6376KG

Wedge clamp

Serrated clamping surfaces

Scope of supply:

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



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

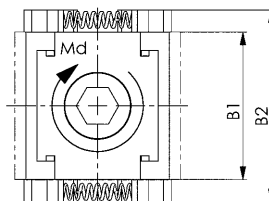
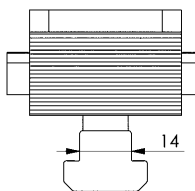
Design:

Material: case-hardened steel 21MnCr5

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

Application:

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



No. 6376KW

Wedge clamp

Tolerance on clamping surfaces

Scope of supply:

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



Order no.	Size	A min. *	A max. *	B1	B2	B3	G	H min.	H max.	H1	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429662	30	49	55	30	40	15	M5	22	28	11,0	65	30	320
429688	40	49	55	40	50	20	M5	22	28	11,0	65	30	400
429704	50	49	55	50	60	25	M5	22	28	11,0	65	30	500
429373	72	57	68	72	84	36	M6	29	38	14,5	65	30	1010

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

Design:

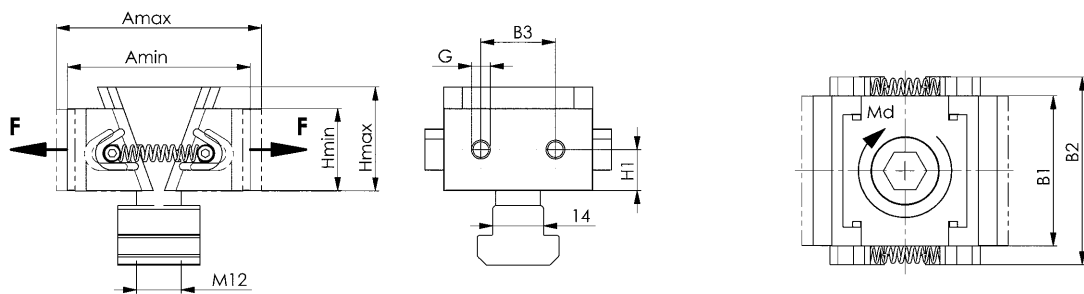
Material: case-hardened steel 21MnCr5

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

Wedge clamp with tolerance for inserting special geometries.

Application:

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



No. 6376KK

Wedge clamp

With claw jaws

2 mm offset clamping step

Scope of supply:

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



Order no.	Size	A min.	A max.	B1	B2	B3	G	H min.	H max.	H1	H3	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429399	30	49	55	30	40	15	M5	22	28	11,0	20	65	30	320
429415	40	49	55	40	50	20	M5	22	28	11,0	20	65	30	400
429431	50	49	55	50	60	25	M5	22	28	11,0	20	65	30	500
429456	72	58	68	72	84	36	M6	29	38	14,5	27	65	30	1100

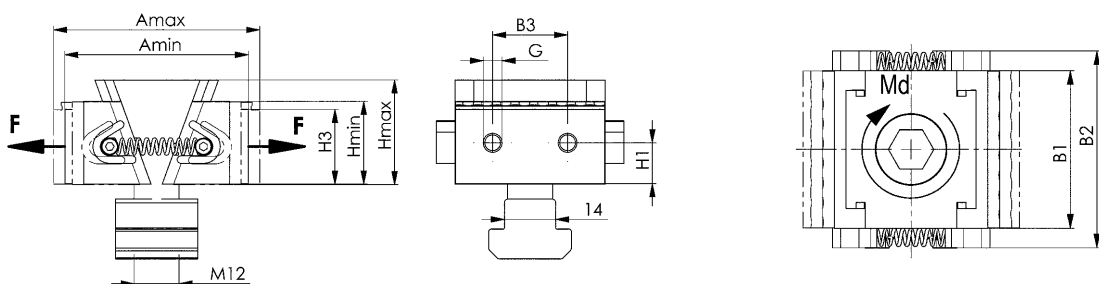
Design:

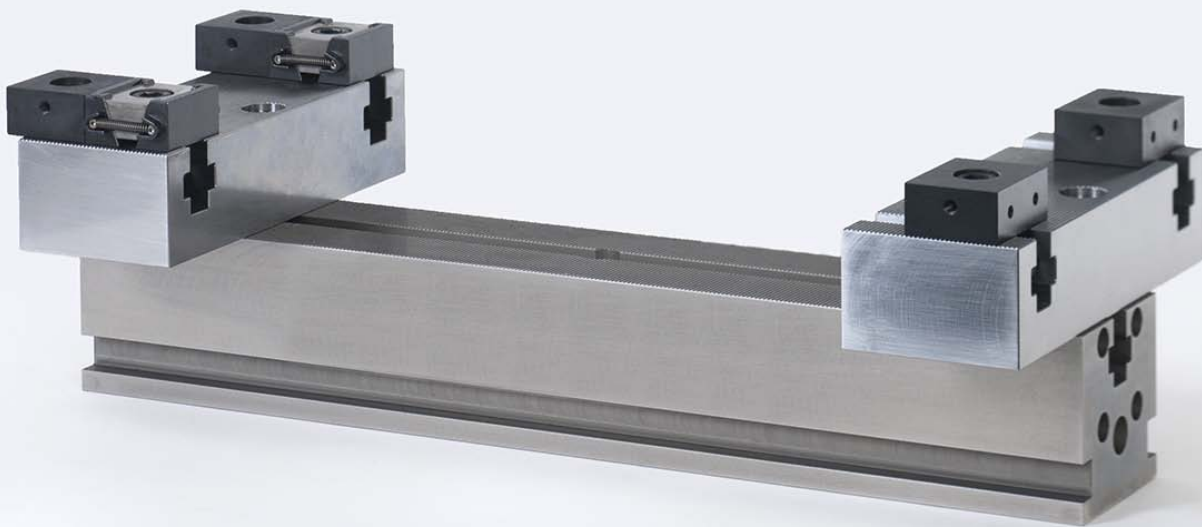
Material: case-hardened steel 21MnCr5

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

Application:

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



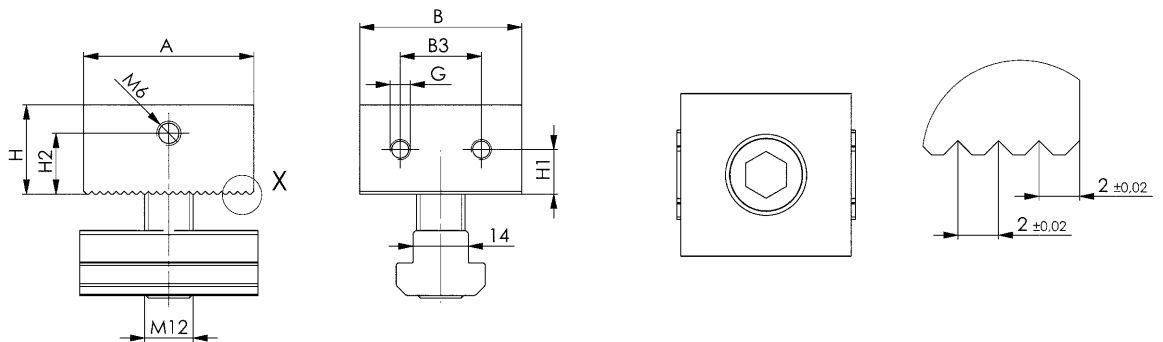


Subject to technical alterations.

No. 6376B

Fixed clamping jaw, smooth

- Scope of supply:
 - Fixed clamping jaw, smooth
 - Fastening bolt
 - T-nut



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

Design:

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

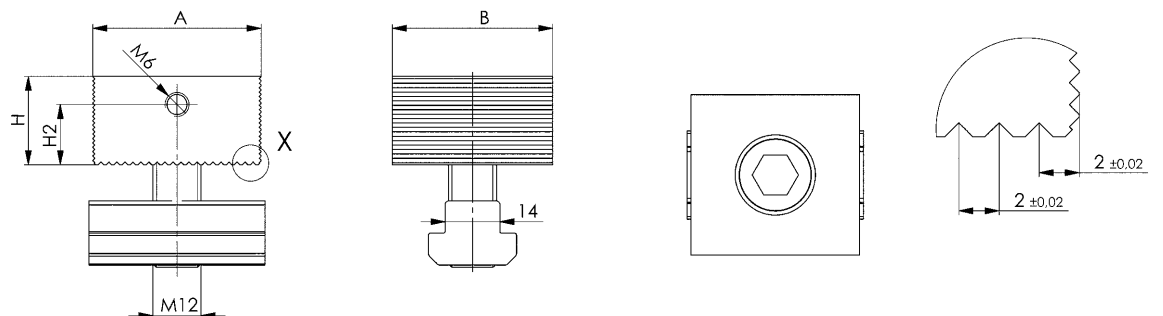
Application:

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

No. 6376BG

Fixed clamping jaw, serrated

- Scope of supply:
 - Fixed clamping jaw, serrated
 - Fastening bolt
 - T-nut



Order no.	Size	A	B	H	H2	Weight [g]
429357	30	42	30	22	15	300
429365	40	42	40	22	15	370
429381	50	42	50	22	15	450
429407	72	42	72	29	22	800

Design:

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

Application:

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

No. 6376BK

Fixed clamping jaw

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

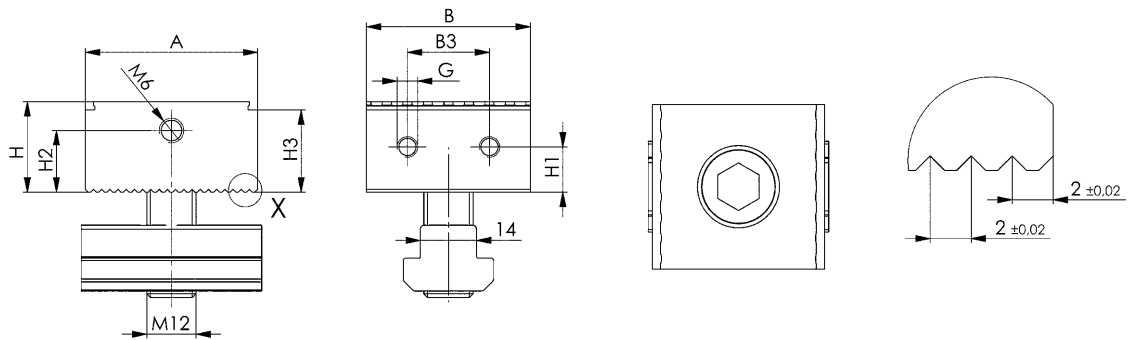
Order no.	Size	A	B	B3	G	H	H1	H2	H3	Weight [g]
429423	30	42	30	15	M5	22	11	15	20	300
429449	40	42	40	20	M5	22	11	15	20	370
429464	50	42	50	25	M5	22	11	15	20	450
429480	72	42	72	36	M6	29	15	22	27	800

Design:

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

Application:

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



No. 6376VB

Front jaw

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

Design:

Aluminium

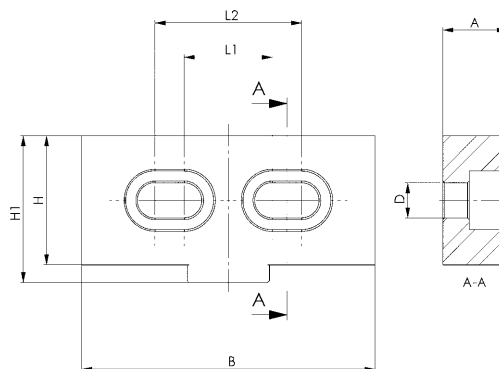
Application:

Aluminium front jaws for cutting customised contours.

Suitable for:

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

Order no. 429712: Wedge clamp no. 6376KW-72
Fixed stop no. 6376B-72



No. 6376Z

Adapter set

Scope of supply:

- Adapter
- 2 threaded studs with hexagon socket



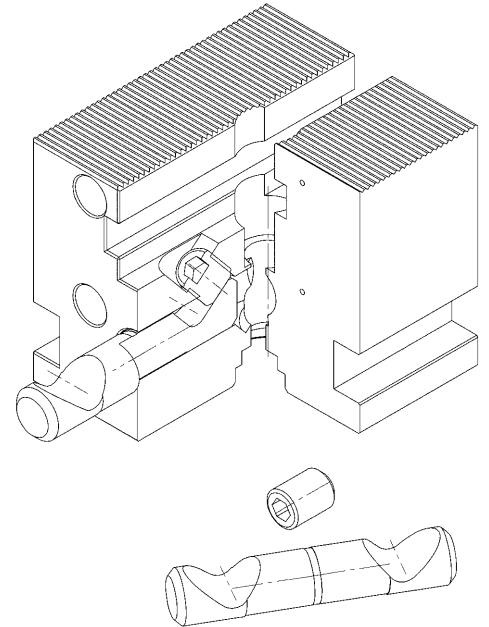
Order no.	for size	Weight [g]
429159	30, 40, 50, 72	350

Design:

Case-hardened steel, plasma-nitrided.

Application:

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



No. 6376Z

Stop, flexible

Scope of supply:

- Flexible stop
- Fastening bolt M6
- Adjusting screw M6



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

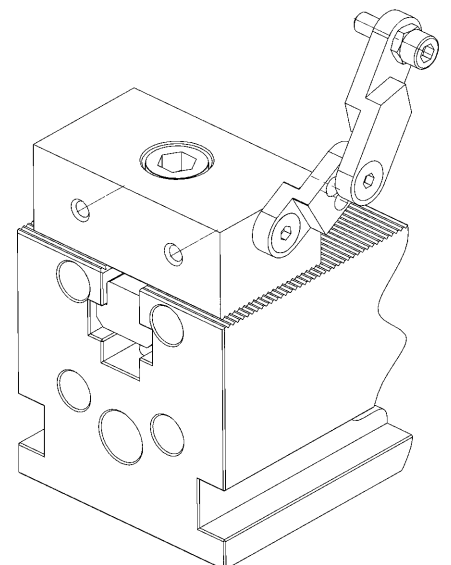
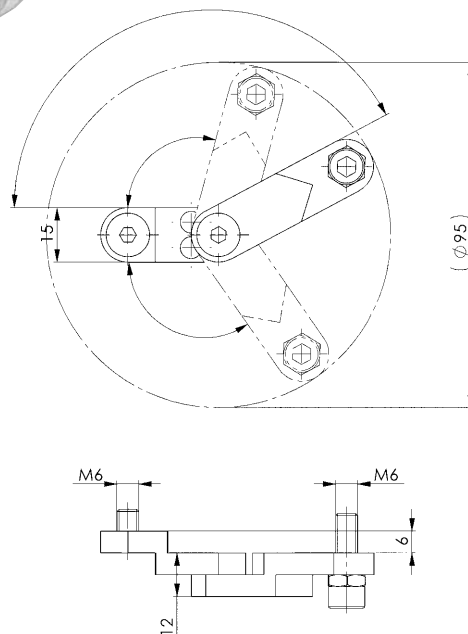
Design:

Aluminium

Application:

Lateral stop for positioning workpieces.

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

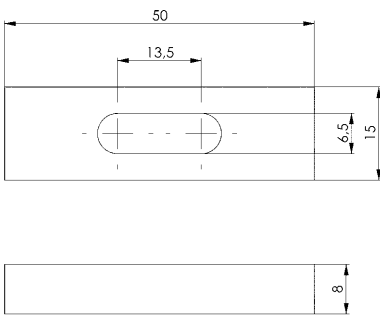


Subject to technical alterations.

No. 6376Z

Stop, fixed

Scope of supply:
- Stop
- Fastening bolt



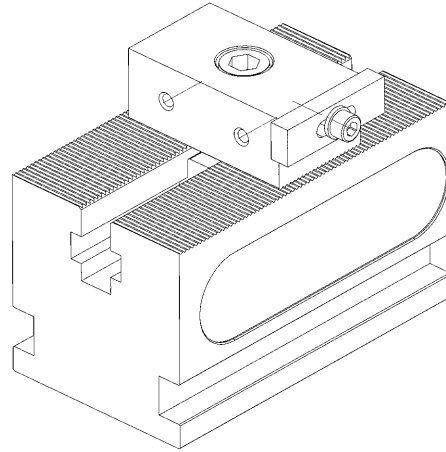
Order no.	For clamping jaw	Weight [g]
429191	6376B, 6376BG, 6376BK	40

Design:

Aluminium

Application:

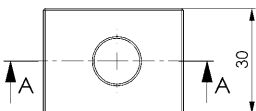
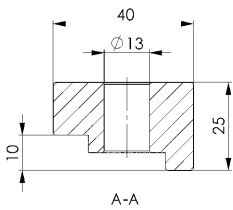
Lateral stop for positioning workpieces.
Stop is screwed to the fixed jaw and can be moved.



No. 6376Z

Clamping shoe

Scope of supply:
- 4 clamping shoes per packaging unit



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

Design:

Tempered steel, burnished.

Application:

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

Note:

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

No. 6376Z

Positioning socket

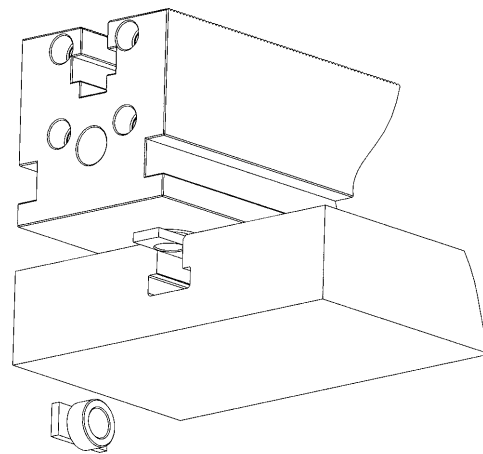
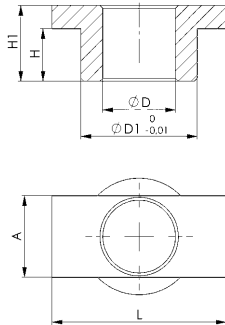
Order no.	A	dia. D	dia. D1	H	H1	L	Weight [g]
429233	18	12,5	20	9	13	30	15
429217	14	12,5	20	9	13	30	14

Design:

Tempered steel, burnished.

Application:

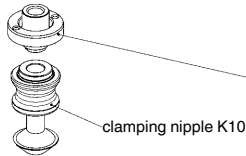
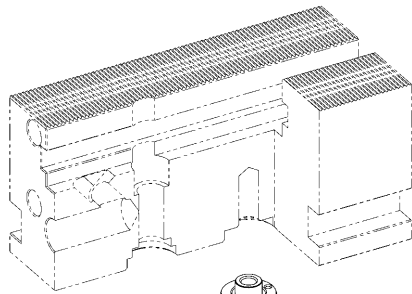
Positioning socket for simplified orientation of the clamping rail on the machine table.
All clamping rails are equipped on the bottom with fittings for the positioning sockets. As a result, the clamping rails can be oriented on the machine table quickly and easily.



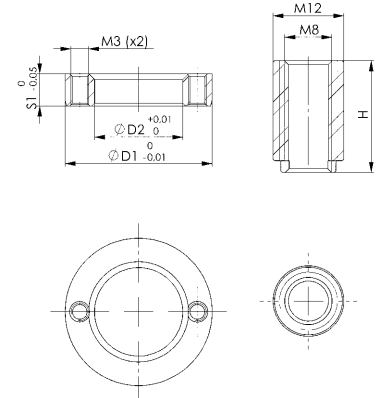
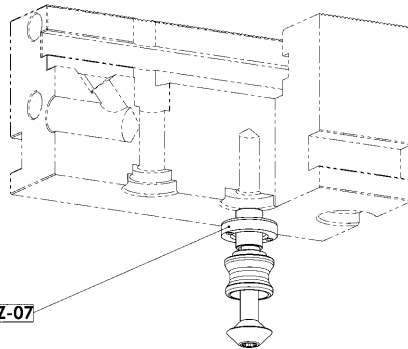
No. 6376Z

Adapter set for pull-stud K10

- Supply scope:
 - 1 Adapter sleeve
 - 1 Positioning bush



6376Z-07



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

Design:

For blind hole thread and clamping rail, see article no. 6376G.
 The threaded sleeve is produced from alloyed heat-treated steel, the adapter ring from case-hardened steel.

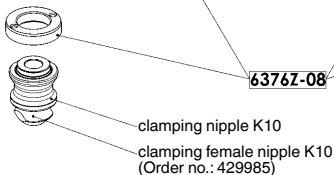
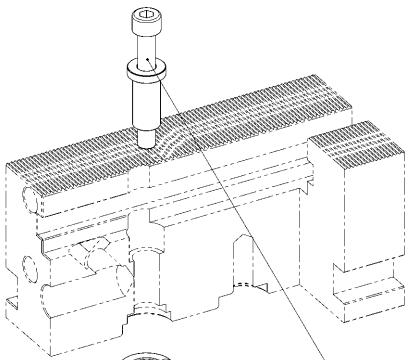
Application:

Adapter set for reducing the mounting bore from K20 to K10 pull-stud.

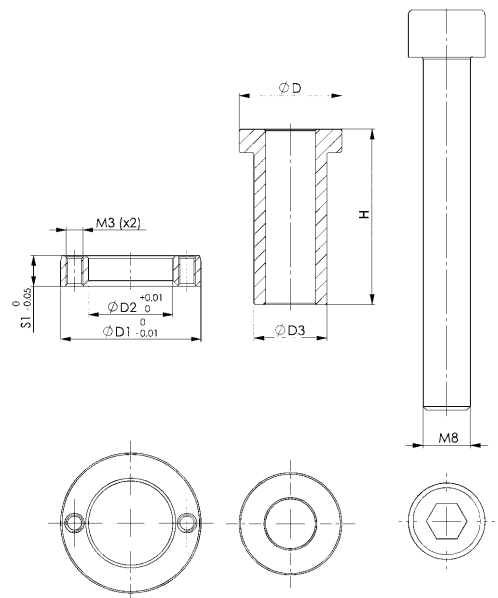
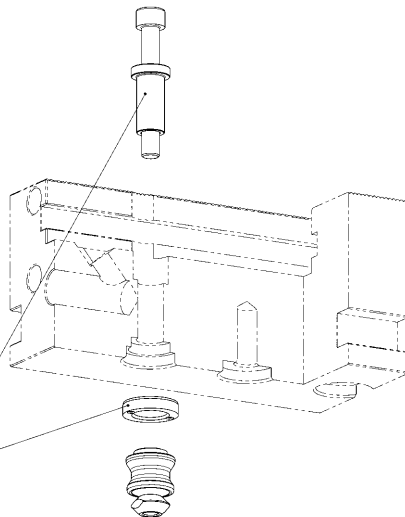
No. 6376Z

Adapter set for pull-stud K10

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



6376Z-08



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

Design:

For through-bores in the clamping rail, see Item No. 6376G.
 The threaded sleeve is produced from alloyed heat-treated steel, the adapter ring from case-hardened steel.
 The fastening bolt conforms to strength class 10.9.

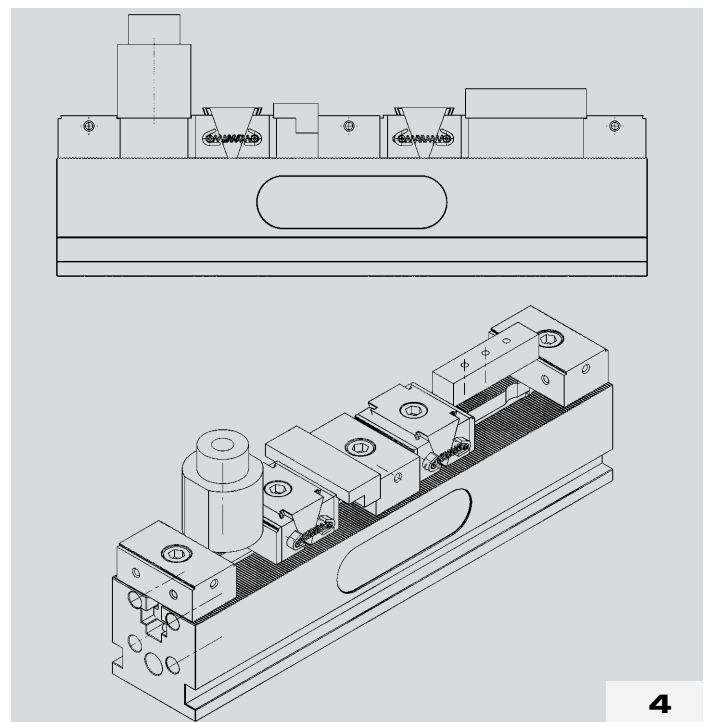
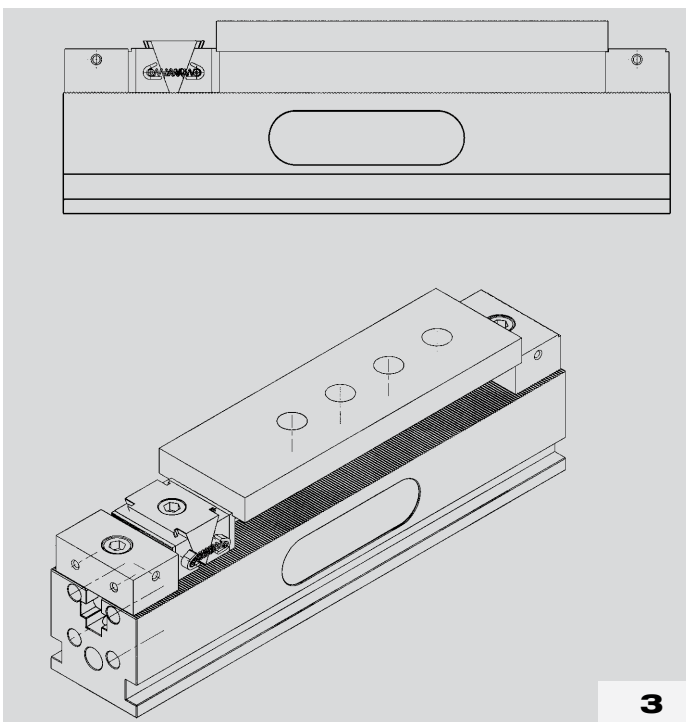
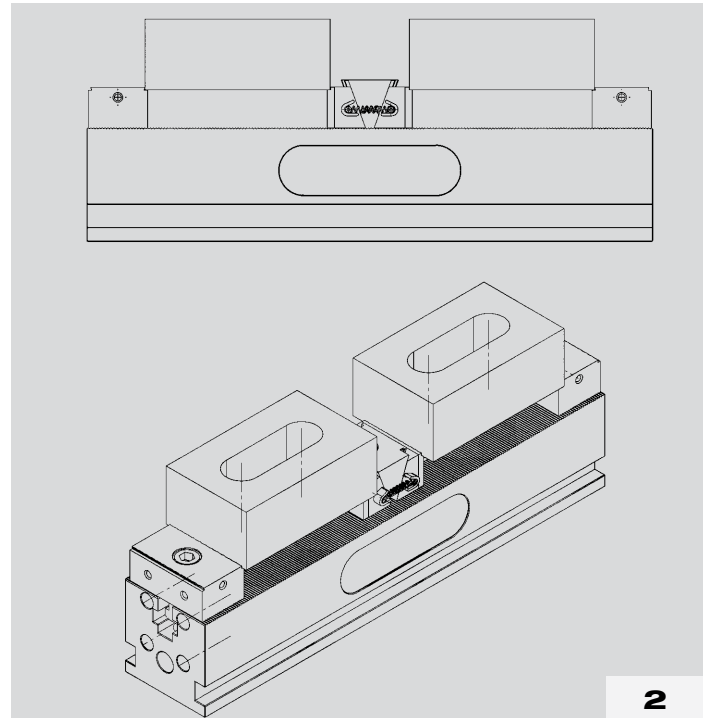
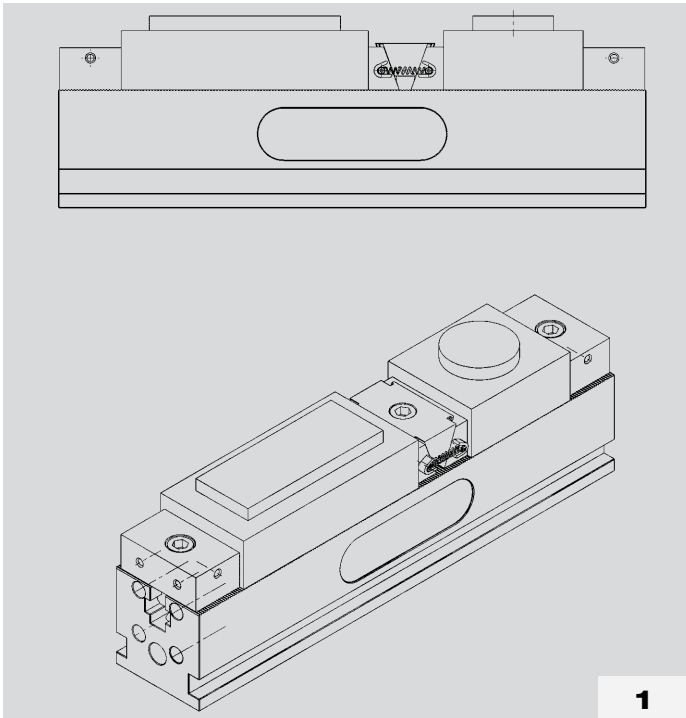
Application:

Adapter set for reducing the mounting bore from K20 to K10 pull-stud.

Subject to technical alterations.

Application examples

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



No. 6376A

5-axis clamp

Serration top and bottom

Scope of supply:

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

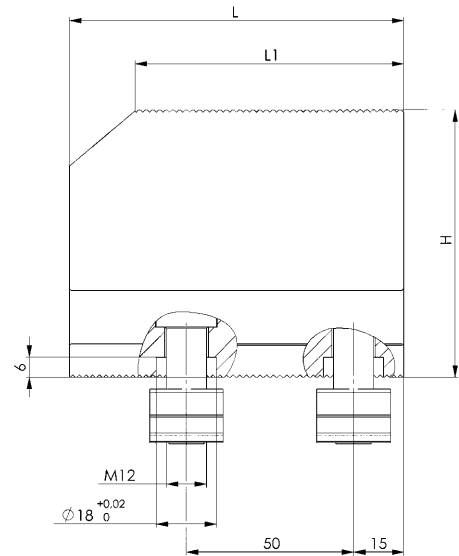
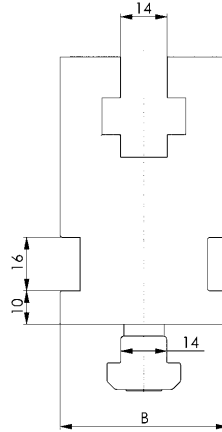
Order no.	Size	B	H	L	L1	Weight [g]
429472	50x100	50	80	100	80	2367
429498	80x100	80	80	100	80	4175

Design:

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

Application:

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



Subject to technical alterations.

No. 6376KA

Wedge clamp

With fixed jaw for 5-axis clamp

Scope of supply:

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



Order no.	Size	A min.	A max.	B1	B2	B3	G	H min.	H max.	H1	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429514	40	58	66	40	50	20	M5	22	28	11,0	65	30	600
429530	72	66	76	72	84	36	M6	29	38	14,5	65	30	1150

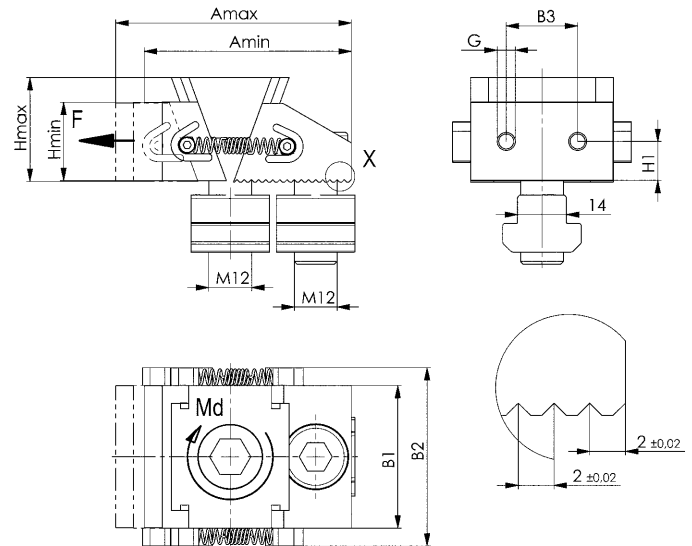
Design:

Material: case-hardened steel 21MnCr5

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

Application:

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



No. 6376KKA

Wedge clamp

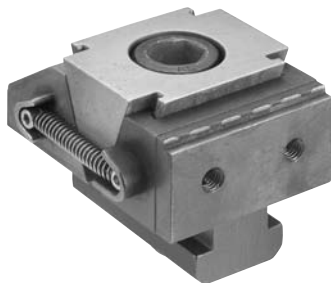
With fixed jaw for 5-axis clamp

With claw jaws

2 mm offset clamping step

Scope of supply:

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



Order no.	Size	A min.	A max.	B1	B2	B3	G	H min.	H max.	H1	H3	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429613	40	58	66	40	50	20	M5	22	29	11,0	20	65	30	570
429639	72	66	76	72	84	36	M6	29	40	14,5	27	65	30	1120

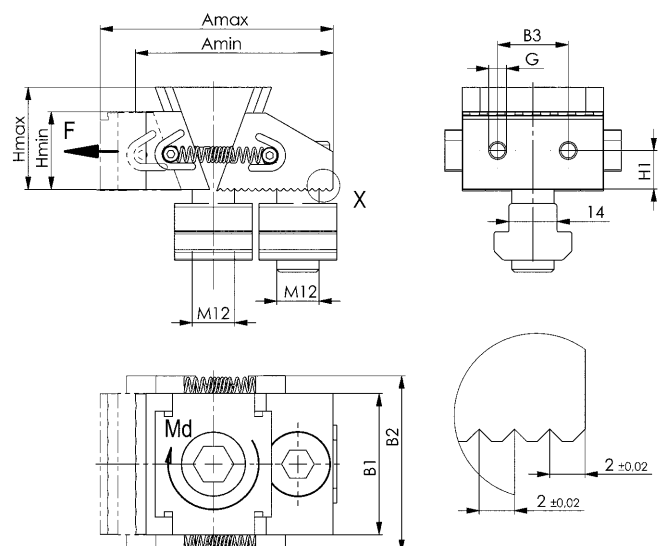
Design:

Material: case-hardened steel 21MnCr5

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

Application:

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



Subject to technical alterations.

No. 6376BA

Fixed clamping jaw, smooth

For 5-axis clamp design

Scope of supply:

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



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

Design:

Material: case-hardened steel 21MnCr5

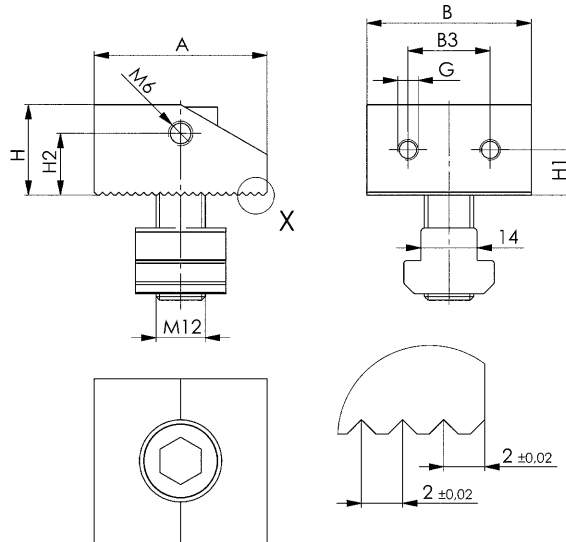
Highly tempered and case hardened to 52 HRC.

Hardness depth 0.6 mm

Application:

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

Workpieces can be positioned and clamped with great clamping force.



No. 6376BKA

Fixed clamping jaw

For 5-axis clamp design

With claw jaws,

2 mm offset clamping step

Scope of supply:

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



Order no.	Size	A	B	H	H1	H2	H3	B3	G	Weight [g]
429654	40	42	40	22	11,0	15	20	20	M5	205
429670	72	42	72	29	14,5	22	27	36	M6	530

Design:

Material: case-hardened steel 21MnCr5

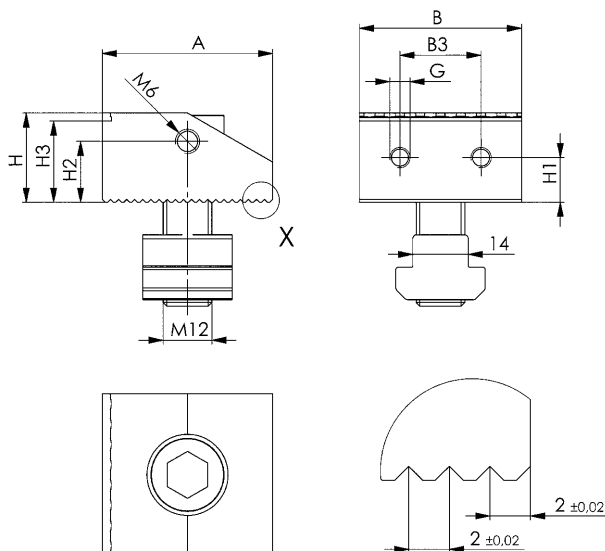
Highly tempered and case hardened to 52 HRC.

Hardness depth 0.6 mm

Application:

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

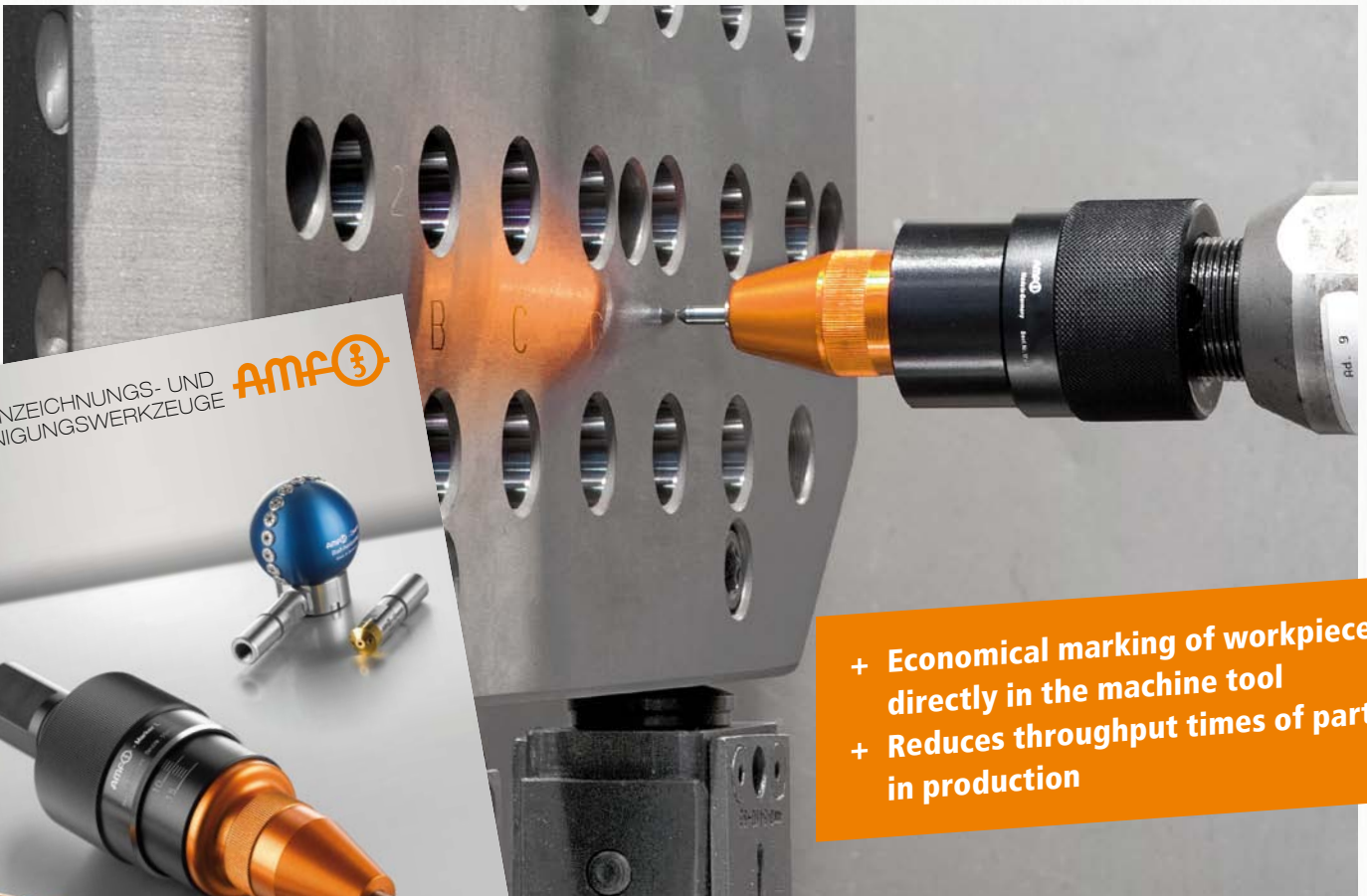
Workpieces can be positioned and clamped with great clamping force.



Subject to technical alterations.



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



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



No. 6540

Chain clamping set

Hook ends and counter catches tempered. Chain made of tempered steel. Please order fixture for T-slots 6541 separately. Consisting of:

- hook end
- protection set for clamp chain
- counter catch
- 4 roller chains
- 87601: 492 mm (2x), 238 mm (1x), 15.9 mm (1x)
- 87627: 991 mm (1x), 229 mm (1x), 483 mm (1x), 25.4 mm (1x)
- 4 locking links with split pins for connecting
- 6 snap-in plastic elements (for workpiece protection)

Order no.	Slot	Screw G	max. permissible torque [Nm]	max. possible clamping force [kN]	Weight [g]
87601	14, 16, 18	M12	45	15	2628
87627	18, 20, 22, 24	M16	90	40	7640

Application:

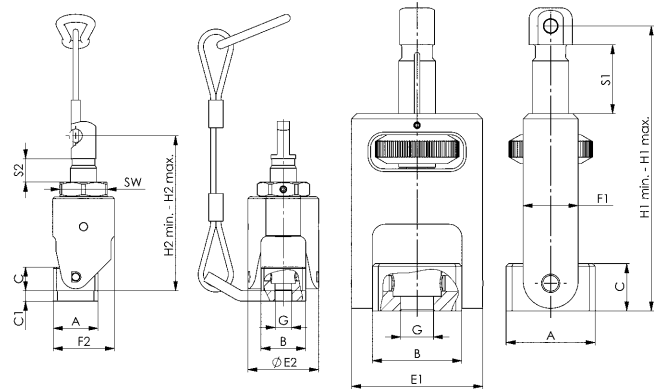
Mainly used for clamping cylindrical parts, such as valve bodies, flanges, pump housings, pistons etc. this device can be used both on machine tables and on clamping pallets. Initial selection of the chain length and setting clamping force is carried out at the take-up unit by turning the knurled nut. Finally, the torque necessary to generate clamping force is applied to the tensioning hook. Plastic pressure pads can be inserted in the chain links to protect the workpiece surface.

Advantage:

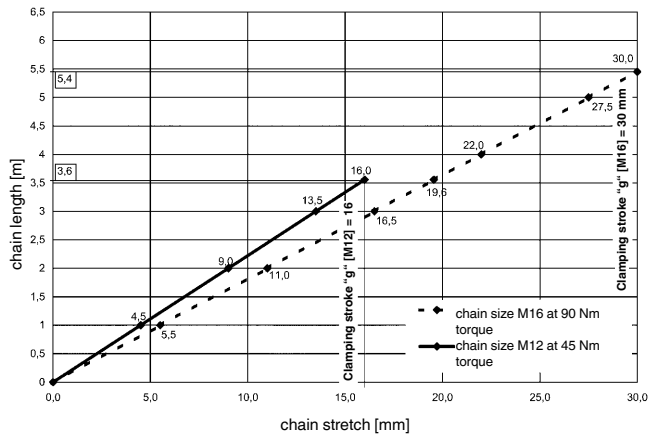
- Uniform pressure distribution reduces workpiece deformation.
- Workpiece can be protected by plastic pressure pads inserted in the chain links.
- Large range of adjustment (tensioning stroke) at take-up unit and tensioning hook.

Note:

For larger clamping tasks, the clamping hooks, counterholders and clamping chains of size 20 and 24 are used.

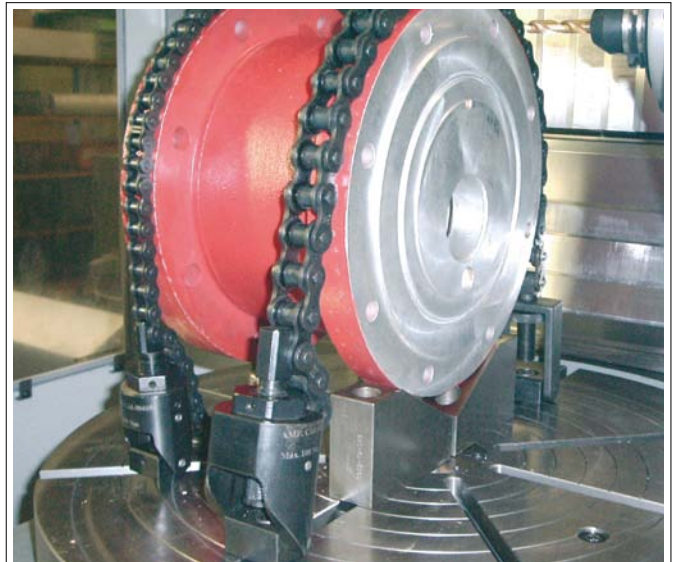
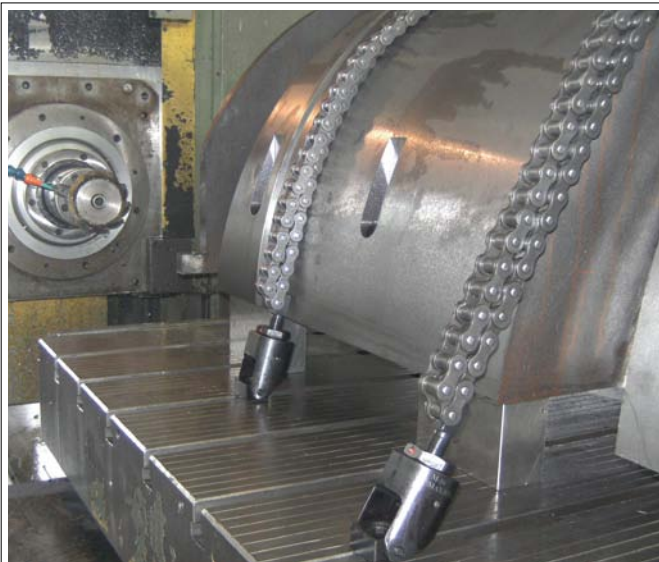


Chain stretch at specified torques



Dimensions:

Order no.	A	B	C	C1	E1	F1	H1 min.	H1 max.	Clamping stroke S1	E2	F2	H2 min.	H2 max.	Clamping stroke S2	SW
87601	34	34	18	8	50	21	83	108	25	54	46,5	100	118	18	36
87627	37	44	25	10	64	29	110	146	36	70	61,5	122	153	31	46



Subject to technical alterations.

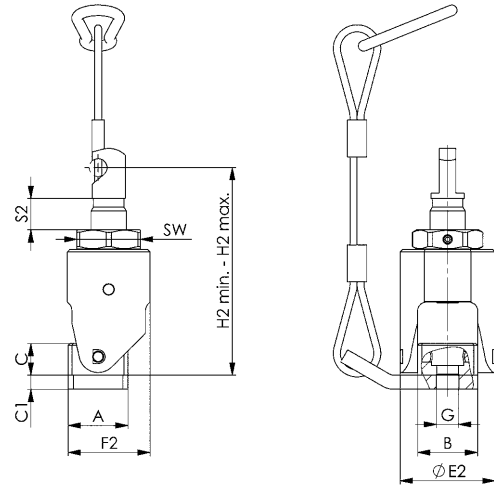
No. 6540H

Hook end, mechanical

incl. protection set no. 6540KS



Order no.	Size	Slot	G	max. permissible torque [Nm]	max. possible clamping force [kN]	SW	Weight [g]
374934	12	14, 16, 18	M12	45	15	36	853
374959	16	18, 20, 22, 24	M16	90	40	46	1902
376517	20	22-28	M20	190	75	65	6037
376533	24	28-36	M24	300	120	65	6040



Dimensions:

Order no.	Size	A	B	C	C1	E2	F2	H2 min.	H2 max.	Clamping stroke S2
374934	12	34	34	18	8	54	47	100	118	18
374959	16	37	44	25	10	70	62	122	153	31
376517	20	58	64	41	10	98	86	195	250	55
376533	24	58	64	41	10	98	86	199	260	61

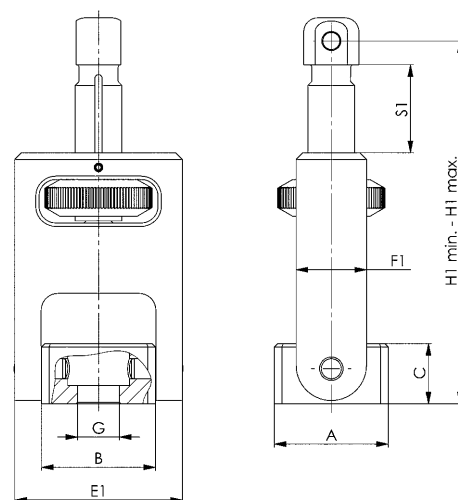


No. 6540G

Counter catch



Order no.	Size	Slot	G	S1 Stroke	max. possible clamping force [kN]	Weight [g]
374710	12	14, 16, 18	M12	25,0	15	553
374728	16	18, 20, 22, 24	M16	36,0	40	1235
376657	20	22-28	M20	43,5	75	4088
376632	24	28-36	M24	43,0	120	4145



Dimensions:

Order no.	Size	A	B	C	E1	F1	H1 min.	H1 max.
374710	12	34	34	18	50	21	83	108,0
374728	16	37	44	25	64	29	110	146,0
376657	20	58	64	41	91	48	162	205,5
376632	24	58	64	41	91	48	166	209,0

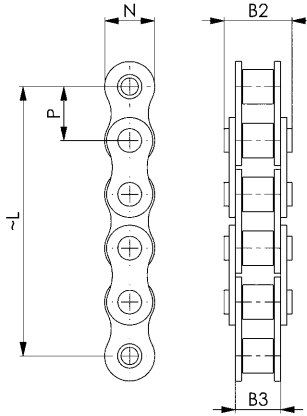


Subject to technical alterations.

No. 6540K

Roller chain

Single roller chain DIN 8187, ISO R 606 B, ST 37-2.
Surface: plain.



Order no.	Size	Nominal size	L	B2	B3	N	P	max. possible clamping force [kN]	Weight [g]
374736	12	125	111	20	13	15	15,875	15	114
374744	12	250	238	20	13	15	15,875	15	228
374751	12	500	492	20	13	15	15,875	15	455
374769	12	1000	1000	20	13	15	15,875	15	910
374777	16	125	127	23	25	21	25,400	40	335
374785	16	250	229	23	25	21	25,400	40	670
374793	16	500	483	23	25	21	25,400	40	1340
374801	16	1000	991	23	25	21	25,400	40	2680
376673	20	1000	984	44	29	26	31,750	75	3720
376699	20	1500	1492	44	29	26	31,750	75	5580
376715	20	2000	2000	44	29	26	31,750	75	7440
376723	24	1000	1028	54	38	33	38,100	120	7050
376749	24	1500	1485	54	38	33	38,100	120	10575
376764	24	2000	2019	54	38	33	38,100	120	14100

Application:

The individual chain lengths can be joined as required using the connecting links (No. 6540V). The chain can be shortened to any length as required.

Advantage:

- Chain can be extended or shortened to the required length with ease
- both sides usable with counter catches or hook ends
- resistant to temperature influences and soiling
- chains are tensioned to minimise elongation.

On request:

Customised lengths available!

No. 6540KS

Clamp chain protection set

Completely pre-assembled.



Order no.	Size	Max. clamping force to be secured [kN]	Weight [g]
376111	12	15	280
376129	16	40	350
376491	20	75	1313
376558	24	120	1313

Application:

To use the clamp chain safely, the protection set is simply screwed below the hook end or the counterholder. Then, using the supplied connecting link, the protection set is fastened above the hook end or counterholder. This prevents the clamp chain from snapping uncontrolledly if the hook end or counterholder breaks.

Advantage:

- Easy mounting of the protection set
- Safe handling of the clamp chain
- Improved work safety.

Note:

If the protection set is damaged, the entire set must be replaced.

No. 6540F

Spring cotter pin

Packaging unit: 10 pcs.



Order no.	Size	Packaging unit [St]	Weight [g]
374835	12	10	0,5
374843	16	10	1,0
376822	20	10	2,2
376848	24	10	6,5

No. 6540V

Connecting links with spring cotter pin



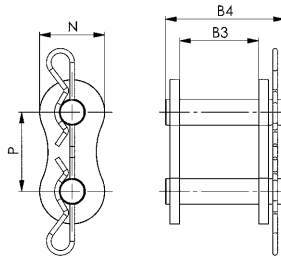
Order no.	Size	B3	B4	N	P	max. possible clamping force [kN]	Weight [g]
374819	12	13	22	14	15,875	15	15
374827	16	25	39	21	25,400	40	67
376780	20	29	44	26	31,750	75	113
376806	24	38	59	33	38,100	120	274

Application:

The connecting links are used for joining two chains together.

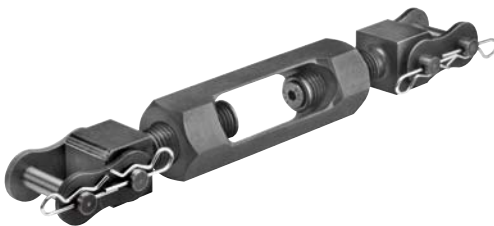
Advantage:

Chains simple and quick to combine and replace.



No. 6540VS

Turnbuckle



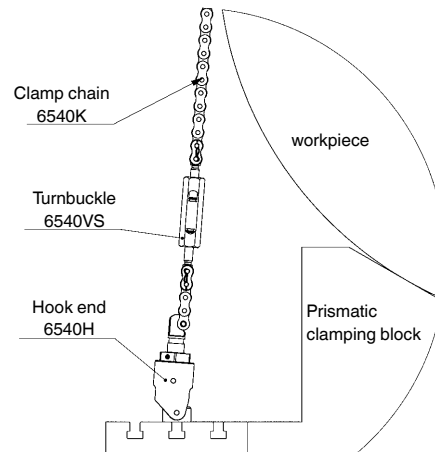
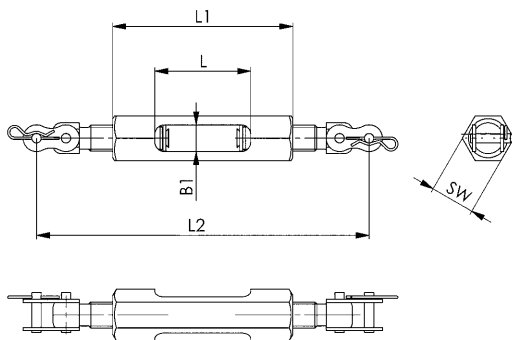
Order no.	Size	L	L1	L2	B1	SW	max. possible clamping force [kN]	Weight [g]
376459	12	52	97	111 - 147	14	24	15	240
376616	16	66	126	151 - 203	20	30	40	720
551514	20	100	180	206 - 270	31	50	75	2222
551515	24	105	180	214 - 284	31	50	120	3517

Application:

The turnbuckle is clamped between the chains using two locking links. The chain is pretensioned through turning, and the play (caused by lengthening of the chain) is removed.

Advantage:

- Optimal application of pretensioning with use of long clamping chains (3 m or longer)
- Counteracting chain stretching for long chains



No. 6540S

Protective elements

for workpiece protection.
Packaging unit: 6 pcs.



Order no.	Size	Packaging unit [St]	Weight [g]
374850	12	6	3
374868	16	6	5
376574	20	6	10
376590	24	6	16

Application:

The protective elements are pushed into the gaps between the chain links.

Advantage:

The workpiece surface is protected.

Subject to technical alterations.

No. 6540P

Angle block, 120°

Tempered and burnished.



Order no.	Size	2R	B	B2	F1	F2	G	H2	H3	H4	L	L1	L2	L3	L4	dia. S	dia. S1	Weight [g]
375568	12	80	47	20	27	67	M6	80	35	5,5	118	19	59	42	-	13,5	20	3230
375584	16	100	47	20	33	33	M6	100	44	5,5	148	24	74	44	-	17,5	26	3960
35121	20	270	78	20	91	161	M6	250	102	5,5	360	45	100	44	160	22,0	33	32455
35162	24	270	78	20	91	161	M6	250	102	5,5	360	45	100	44	160	26,0	40	31760

Advantage:

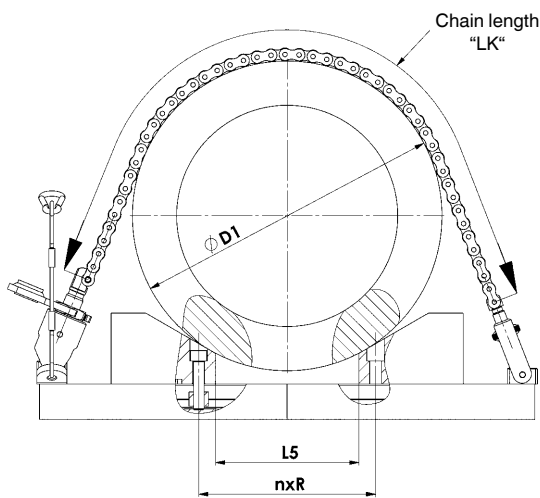
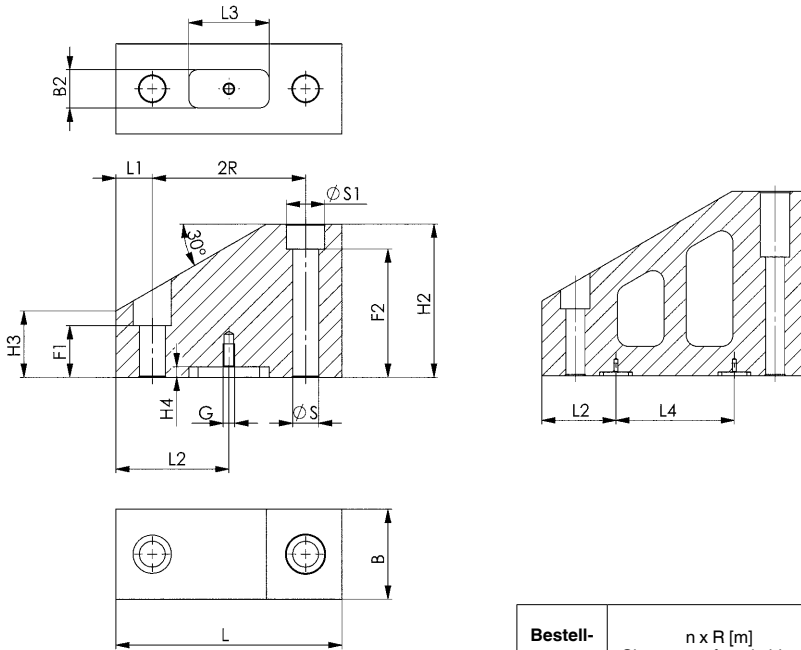
Optimised use of the clamp chain thanks to flexible positioning of the clamping prisms in the machine table groove.

Note:

The use of a flat T-nut no. 6322A or no. 6322B enables the clamping prisms to be precisely positioned in the machine table groove.

On request:

Special versions are available on request.



Bestell-Nr.	n x R [m] Clearance of angle blocks	Ø D1 [mm]	Chain length LK [mm] (x) = Number of links	L5
375568	1 x 40 = 40	190 - 280	413 (26) - 635 (40)	2
	2 x 40 = 80	250 - 360	540 (34) - 826 (52)	42
	3 x 40 = 120	270 - 440	603 (38) - 1048 (66)	82
	4 x 40 = 160	300 - 520	635 (40) - 1238 (78)	122
	5 x 40 = 200	350 - 600	762 (48) - 1429 (90)	162
	6 x 40 = 240	430 - 680	953 (60) - 1619 (102)	202
	7 x 40 = 280	510 - 760	1143 (72) - 1810 (114)	242
	8 x 40 = 320	620 - 840	1397 (88) - 2000 (126)	282
	9 x 40 = 360	760 - 920	1778 (112) - 2191 (138)	322
	10 x 40 = 400	920 - 1000	2191 (138) - 2413 (152)	362
375584	1 x 50 = 50	250 - 370	559 (22) - 864 (34)	2
	2 x 50 = 100	320 - 470	711 (28) - 1118 (44)	52
	3 x 50 = 150	320 - 570	711 (28) - 1372 (54)	102
	4 x 50 = 200	320 - 670	711 (28) - 1575 (62)	152
	5 x 50 = 250	430 - 770	965 (38) - 1829 (72)	202
	6 x 50 = 300	530 - 870	1168 (46) - 2083 (82)	252
	7 x 50 = 350	630 - 970	1422 (56) - 2337 (92)	302
	8 x 50 = 400	760 - 1070	1727 (68) - 2591 (102)	352
	9 x 50 = 450	960 - 1170	2235 (88) - 1794 (110)	402
	10 x 50 = 500	1160 - 1270	2743 (108) - 3048 (120)	452
35121	3 x 135 = 405	1200 - 1550	2889 (91) - 3842 (121)	315
	5 x 135 = 675	1550 - 2100	3683 (116) - 5175 (163)	585
	7 x 135 = 945	2100 - 2500	5017 (158) - 6096 (192)	855
35162	3 x 135 = 405	1200 - 1550	2324 (61) - 3848 (101)	315
	5 x 135 = 675	1550 - 2100	3657 (96) - 5143 (135)	858
	7 x 135 = 945	2100 - 2500	5029 (132) - 6096 (160)	855

Subject to technical alterations.

No. 6541

Mounting kit

For attaching the chain clamping set no. 6540 on the subplate, composed of nut for T-nut, resembling DIN 508, and screw complying with ISO 4762, class 8.8.

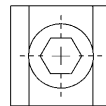
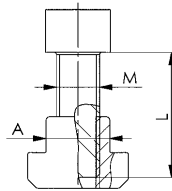


Order no.	A	L	M	Weight [g]
84251	14	25	M12	60
376483	14	35 *	M12	88
84269	16	30	M12	80
376509	16	40 *	M12	114
84277	18	30	M12	105
376525	18	40 *	M12	141
84285	18	30	M16	115
376541	18	45 *	M16	189
84293	20	35	M16	170
376566	20	50 *	M16	248
84343	22	40	M16	240
376582	22	50 *	M16	305
84350	24	45	M16	335
376608	24	55 *	M16	407

* For use of the protection set no. 6540KS

Note:

Mounting kit for the sizes 20 and 24 available on request.



No. 902Md

Open-ended spanner with torque wrench socket

for clamping nuts. Drive 1/2" square socket with ball-engagement groove. Special steel, hardened and zinc-plated.



Order no.	SW	L	S	SW1 [inch]	T	T1	Weight [g]
52514	36	101	60	1/2	7	16	255
52522	46	108	60	1/2	8	16	340

Advantage:

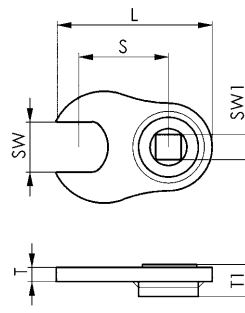
Controlled tightening prevents damage to spindle changing tools on a machine.

Note:

The set value for the torque wrench is dependant on insertion dimension „S“. The operating manual provided with your torque wrench contains the requisite information and calculation formulae.

On request:

SW 65 fits clip no. 6540H - size M20/M24 available on request.



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266577	23	301234	26	304949	16	376749	48	429662	33
266585	22	301259	26	304956	18	376764	48	429670	44
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266601	22	301291	26	304972	20	376806	49	429696	36
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266635	23	301358	26	305037	21	428649	6	430207	40
266643	23	301374	26	305086	22	428656	6	430223	40
266650	23	301390	26	305094	22	429035	30	52514	51
266668	23	301416	26	35121	50	429050	30	52522	51
266676	23	301432	26	35162	50	429076	30	533281	4
266684	23	301440	27	374710	47	429092	30	545582	5
266700	23	301465	27	374728	47	429118	30	550278	7
266726	23	301481	27	374736	48	429134	30	550286	8
266742	23	301507	27	374744	48	429159	37	550287	8
266809	18	301515	27	374751	48	429175	37	551514	49
266825	19	301523	27	374769	48	429191	38	551515	49
266841	22	301531	27	374777	48	429217	39	84251	51
266866	22	301549	27	374785	48	429233	39	84269	51
266882	22	301556	27	374793	48	429258	38	84277	51
266908	23	301564	27	374801	48	429274	35	84285	51
290635	18	301572	27	374819	49	429290	35	84293	51
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300897	23	301630	27	374934	47	429381	35		
300905	19	301648	26	374959	47	429399	33		
300913	23	301663	26	375568	50	429407	35		
300921	19	301689	26	375584	50	429415	33		
300939	23	301705	26	376111	48	429423	36		
300947	22	301796	28	376129	48	429431	33		
300954	23	301804	28	376459	49	429449	36		
300962	22	301820	28	376483	51	429456	33		
300988	22	301846	28	376491	48	429464	36		
301002	22	301861	29	376509	51	429472	42		
301010	23	301903	29	376517	47	429480	36		
301028	22	301929	29	376525	51	429498	42		
301036	23	304733	16	376533	47	429506	32		
301044	22	304758	16	376541	51	429514	43		
301051	23	304766	16	376558	48	429522	32		
301069	23	304774	16	376566	51	429530	43		
301077	23	304782	16	376574	49	429548	32		
301085	25	304790	16	376582	51	429555	44		
301101	25	304808	16	376590	49	429563	32		
301127	25	304816	16	376608	51	429571	44		
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All our offers are always subject to change without notice unless otherwise explicitly agreed. Our delivery contracts are based on the latest version of our catalogue. Dimension and weight values, as well as illustrations, drawings and data, are non-binding and can be changed by us at any time. Therefore, deviations cannot be ruled out and do not justify any compensation claims against us.

Orders are considered accepted only when confirmed by us in writing. If, for organisational reasons, the customer does not receive a separate confirmation upon the delivery of goods, the invoice shall also be deemed the order confirmation.

2. Prices

The prices are in EURO, ex-works, excluding VAT, packing, freight, postage and insurance. Unless otherwise agreed, our list prices valid on the day of delivery shall apply. For orders below 50 EUR goods net, we must make a minimum quantity surcharge of a 10 EURO for cost reasons.

3. Tool costs

Unless any other agreements have been reached, the tools fabricated for the purpose of executing the order shall remain our property in all cases, even if we have invoiced a tool cost component separately.

4. Payment

Unless otherwise stated on the invoice, the purchase price falls due for net payment within 30 days of the invoice date (without deduction of discount). Invoice amounts of below 50 EURO are due for payment immediately.

In case of payment default, we shall be entitled to charge default interest. The amount corresponds to our interest rate for current account credits at our main bank; the minimum however being 8 percentage points above the relevant base interest rate applied by the European Central Bank. Moreover, in case of default following written notice to the customer, we shall be entitled to cease to fulfil our obligations until payments are received.

5. No set-off

The customer can set-off only with legally confirmed or undisputed counterclaims.

6. Right of withdrawal in case of delayed acceptance or payment and insolvency

If the customer fails to accept the goods in due time, we shall be entitled to set a reasonable period of grace, after which we can dispose of the goods elsewhere and supply the customer on a reasonably longer term. Our rights to withdraw from the contract under the provisions of Section 326 BGB and demand damages for non-performance shall not be affected. If the customer fails to pay for the goods once payment is due, we shall be entitled, at the end of a reasonable period of grace we have set, to withdraw from the contract and demand the return of any goods already supplied. Section 323 BGB remains unaffected in all other cases.

If the customer applies for the opening of insolvency proceedings, we shall be entitled, prior to the ordering of security measures by the insolvency court, to withdraw from the contract and demand the immediate return of the goods.

7. Customer-specific fabrications/project fabrications (custom fabrications)

Customer-specific fabrications require binding information on design, quantity etc. in written form at the time of ordering. For manufacturing reasons, we reserve the right to supply up to 10% above or below the order quantity. Technical modifications or cancellations are subject to any costs incurred. The return of customer-specific fabrications is impossible.

8. Delivery and packaging, transfer of risk

The delivery date is non-binding; although stated to the best of our knowledge. It is subject to us receiving correct, defect-free and complete deliveries. The stated delivery dates relate to completion in the factory, starting on the day the order is accepted by us. Delivery is EXW (ex-works) in accordance with Incoterms 2010. Therefore, the costs are borne by the customer. The risk is transferred to the customer when the goods are passed to the person, company or facility nominated to execute the shipment. This applies also for partial deliveries, or if we have assumed responsibility for delivery and installation. The risk shall be transferred to the customer even in the case of delayed acceptance.

In the absence of specific shipping instructions, we shall proceed as we deem fit and without any obligation to the cheapest or most expedient method. The customer agrees that the order can also be delivered in parts, insofar as this is reasonable for the customer. We shall charge a 5 EURO processing free for shipping to third parties that we supply on behalf of the customer.

The packaging complies with the packaging ordinance. Disposable packaging shall be charged at cost price. The packaging cannot be taken back.

9. Performance impediment and/or impossibility

If we are hindered in the fulfilment of our obligation due to the onset of unforeseeable circumstances, which we are unable to avoid despite reasonable effort in relation to the nature of the circumstances (e.g. operational interruption, delay in the delivery of important raw materials, defects in the delivery), the delivery time shall be extended by a reasonable period, insofar as the supply of goods or services is not rendered unreasonably difficult or impossible.

If we have to accept that these circumstances are not only temporary, we shall be entitled to withdraw from the contract either in whole or in part.

If the supply of goods or services becomes impossible, the customer shall not be obliged to furnish its own contractual service. Section 275 BGB applies mutatis mutandis. If, however, the customer is solely or predominantly responsible for the

circumstances that led to impossibility, it shall remain under an obligation to render the return service. The same applies if this circumstance occurs at a time when the customer is behind schedule with acceptance.

10. Samples/returns

Samples shall be provided only against payment. If samples or models are provided, a credit note shall be issued with the subsequent order if the order value is 125 EURO net or more. Goods can be returned only by agreement, although custom fabrications are excluded from such return.

In the case of returns for which we are not responsible (e.g. incorrect order), we shall charge a processing fee of 10%, the minimum value, however, being 7.50 EURO.

11. Retention of title

The goods shall remain our property unless full payment of all claims and/or until the cheques provided for this purpose are honoured. The itemisation of claims in an ongoing invoice, as well as balancing the account and the recognition thereof does not affect the retention of title. The customer is entitled to sell on the retained goods during the ordinary course of business. However, the customer is not permitted to pledge the goods or transfer them by way of security. It shall assign its claim ensuing from the selling on of the retained goods to us in advance. The customer shall be entitled to collect the claim to the extent that it has fulfilled its obligations towards us. At our request, the customer shall be obliged to state third-party debtors and we shall be entitled to report this and the assignment.

12. Property rights

We reserve property rights and copyrights to all contractual documents such as drafts, drawings, calculations and cost estimates. Such documents must not be reproduced or disclosed to third parties without our consent. Any rights to patents, utility models etc. reside solely with us, insofar as such patents have not yet been filed. Our products are allowed to be replicated only with our written consent.

If objects are fabricated according to drawings or samples, the customer shall warrant that any third party property rights are not infringed by manufacture or delivery. If a third party forbids manufacture and delivery on account of property rights, we shall be entitled to stop manufacture and delivery immediately. The customer shall be obliged to reimburse us with all costs incurred and indemnify us from third party compensation claims. Compensation claims by the customer are impossible.

13. Warranty

If the customer agrees with us a particular quality of the goods, we shall base this agreement on our technical delivery specifications. If we have to deliver according to customer drawings, specifications, samples etc., the customer shall assume the risk for suitability for the intended purpose. If, after the contract is concluded, the scope of goods or services is changed at the customer's request and this impairs the quality or suitability of the goods, claims for defects on the part of the customer shall be ruled out, insofar as such impairments are caused by the customer's requests for change.

The time at which the risk is transferred is decisive for the contractual state of the goods. Wear and tear of wearing parts caused by ordinary use does not constitute a defect. Claims for defects are ruled out in the following cases in particular: Unsuitable or improper use, incorrect installation and/or commissioning by the customer or third party, normal wear and tear, incorrect or negligent handling - in particular excessive use -, unsuitable equipment, replacement materials, chemical, electrochemical or electrical influences, unless such defects are caused by ourselves.

If the goods contain a defects, we shall provide, following a reasonable period of grace set by the customer, either a replacement or a repair as we deem fit. If such subsequent performance fails, the customer shall be entitled to either reduce the purchase price or withdraw from the contract. Any further warranty claims are ruled out. In case of negligible deviations from the agreed quality, no claims for defects shall be recognised.

The discovery of defects must be communicated to us immediately in writing. In the case of recognisable defects, however, within 10 days of acceptance, in the case of non-recognisable defects immediately after they become evident. The warranty is 12 months, starting with delivery of the goods ex-works.

14. Liability

With the exception of harm to life, body or health on account of a breach of duty by ourselves, our liability shall be limited to intent or gross negligence.

15. Place of fulfilment, place of jurisdiction and governing law

The place of fulfilment for all obligations ensuing from this contractual relationship is D-70734 Fellbach.

The place of jurisdiction for all legal disputes ensuing from the contractual relationship is the court responsible for the headquarters of Andreas Maier GmbH & Co. KG.

All disputes ensuing from the contract or regarding the validity thereof shall be finally decided by a court of arbitration in accordance with the Court of Arbitration Ordinance of the German Committee for Arbitration Court Procedures or the Conciliation and Arbitration Arrangement of the International Chamber of Commerce, recourse to ordinary courts of law being excluded. The legal dunning process, however, remains permissible.

German law shall govern (BGB and HGB). The applicability of the UN Convention on Contracts for the International Sale of Goods (CISG) is ruled out.

16. Severability clause

If individual provisions become legally invalid, the remaining provisions shall not be affected. The legally invalid provision shall be replaced by regulations that most closely reflect the economic purpose of the contract with reasonable consideration for the mutual interests. The publication of these Terms of Sale, Delivery and Payment renders all previous versions invalid. This does not apply for any contracts concluded prior to announcement.

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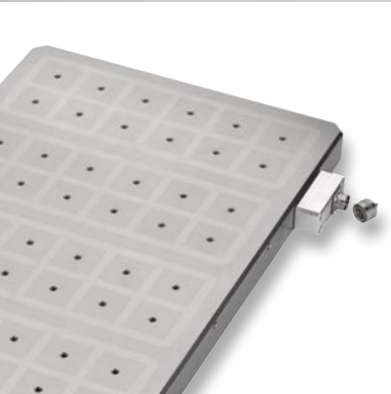
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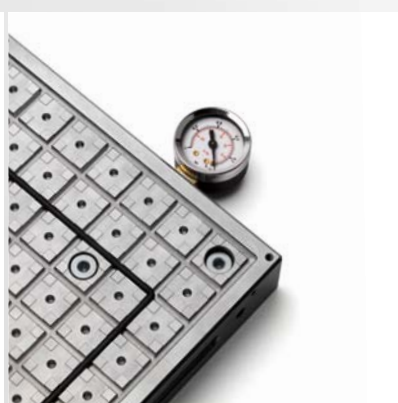
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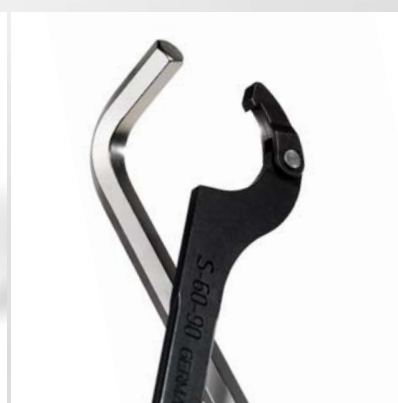
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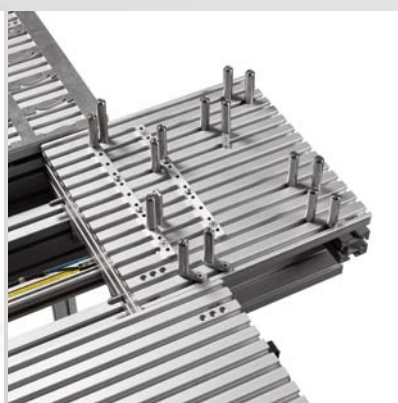
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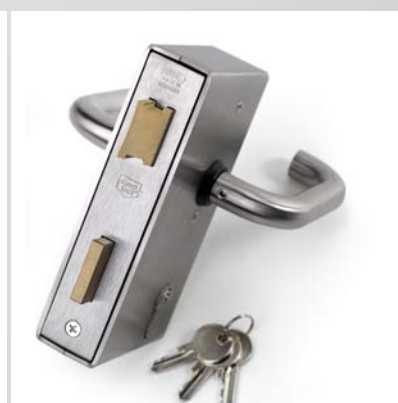
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