

9 MULTIPLE CLAMPING SYSTEMS



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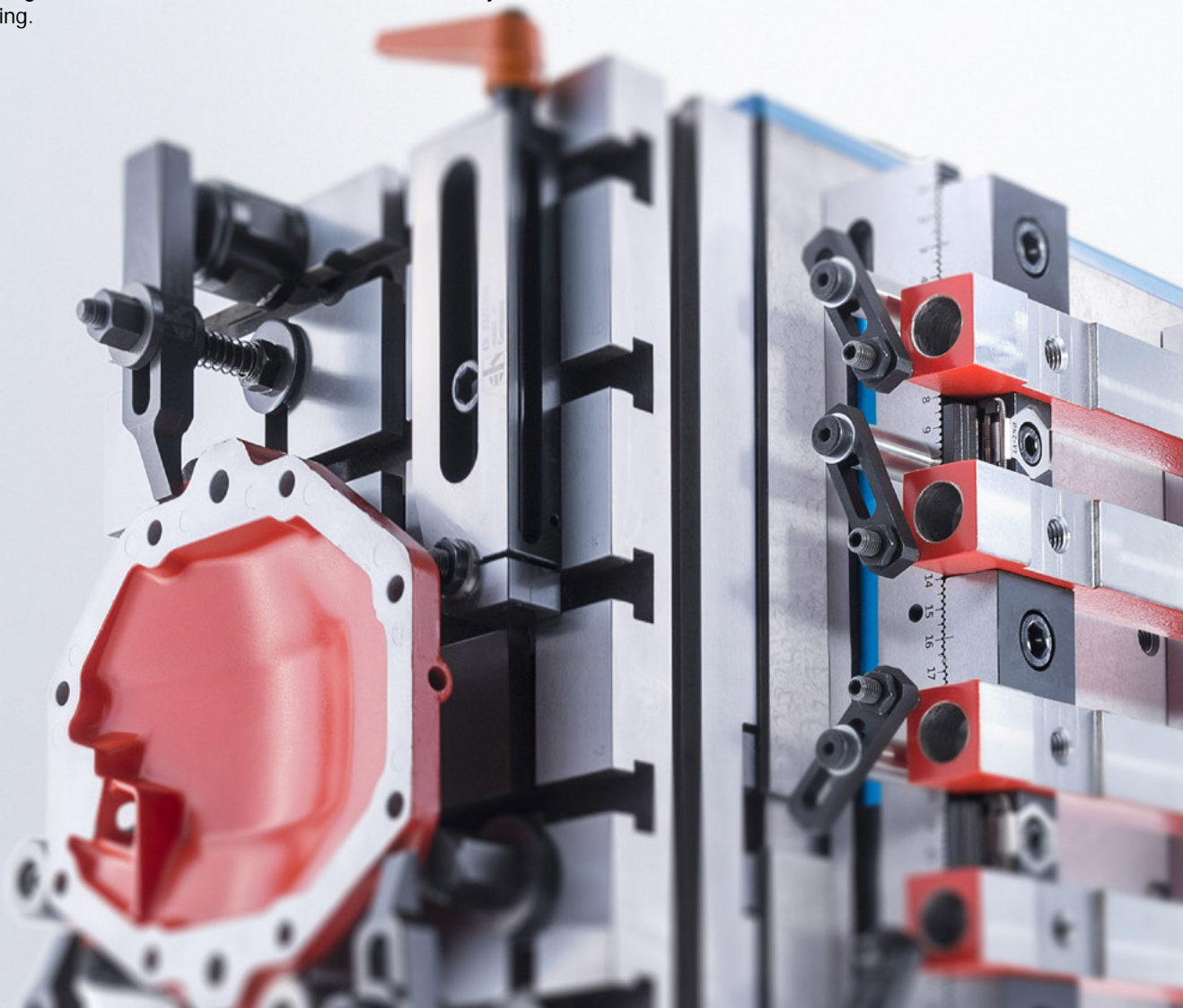
Standard Ranges	879
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MULTIPLE CLAMPING SYSTEM

Boasting a modular design, our multiple clamping system lets you clamp workpieces in a quick and secure manner. The system is made up of serrated clamping bars, stops, taper clamping units, supports and a lateral stop. Thanks to our wide selection of single parts you can clamp workpiece of various dimensions with perfect ease – either one at a time or simultaneously as a batch of workpieces.

GENERAL PROPERTIES

- The clamping bars are designed to accommodate taper clamping units in the sizes of M8 and M12.
- Their serrated profile makes it possible to securely clamp components with a clamping force of up to 4 tonnes.
- The pitch of the serration amounts to 2.5 mm.
- The accuracy of each row of teeth relative to the positioning holes is +/- 0.01 mm
- In addition, the M6 threads fitted on both sides allow for the attachment of lateral stops.
- New: A magnetic version is also available - for fast assembly / dismantling.



Clamping Bars • length 100
EH 1585.

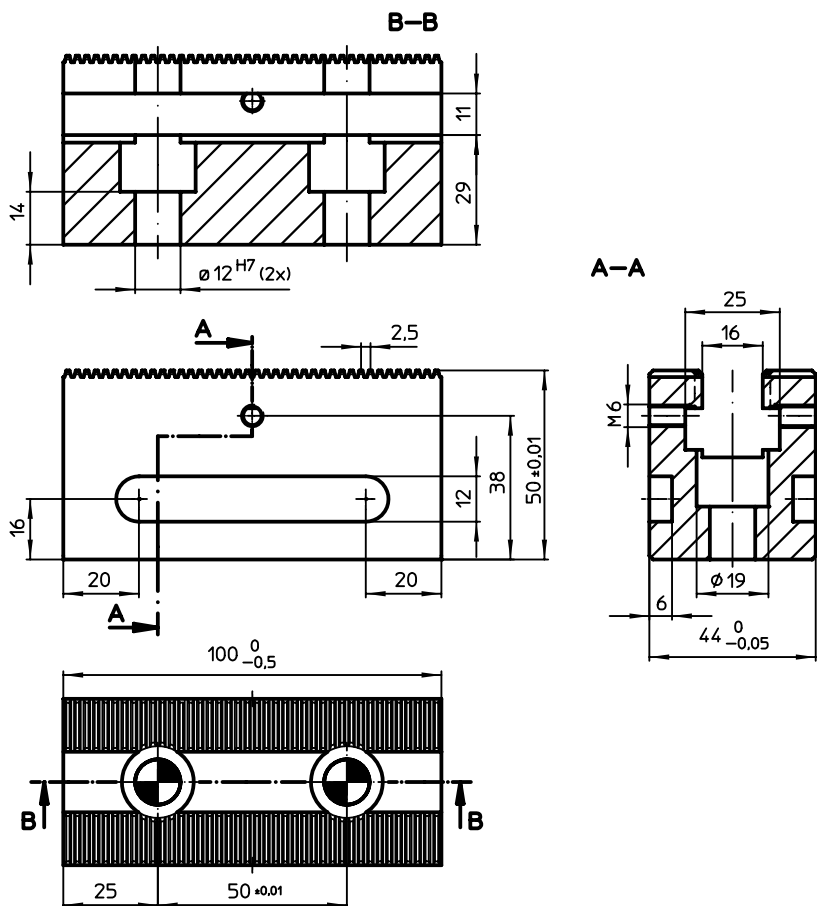


PRODUCT DESCRIPTION


Material

- Tool steel, hardened



DRAWING



ORDER INFORMATION

	Art. No.
 [g] 1160	1585.100

ACCESSORIES

	Number locating screws M12 x 45	 [g]	Art. No.
fixing screws 	2	106	1585.101

Clamping Bars • length 300

EH 1585.

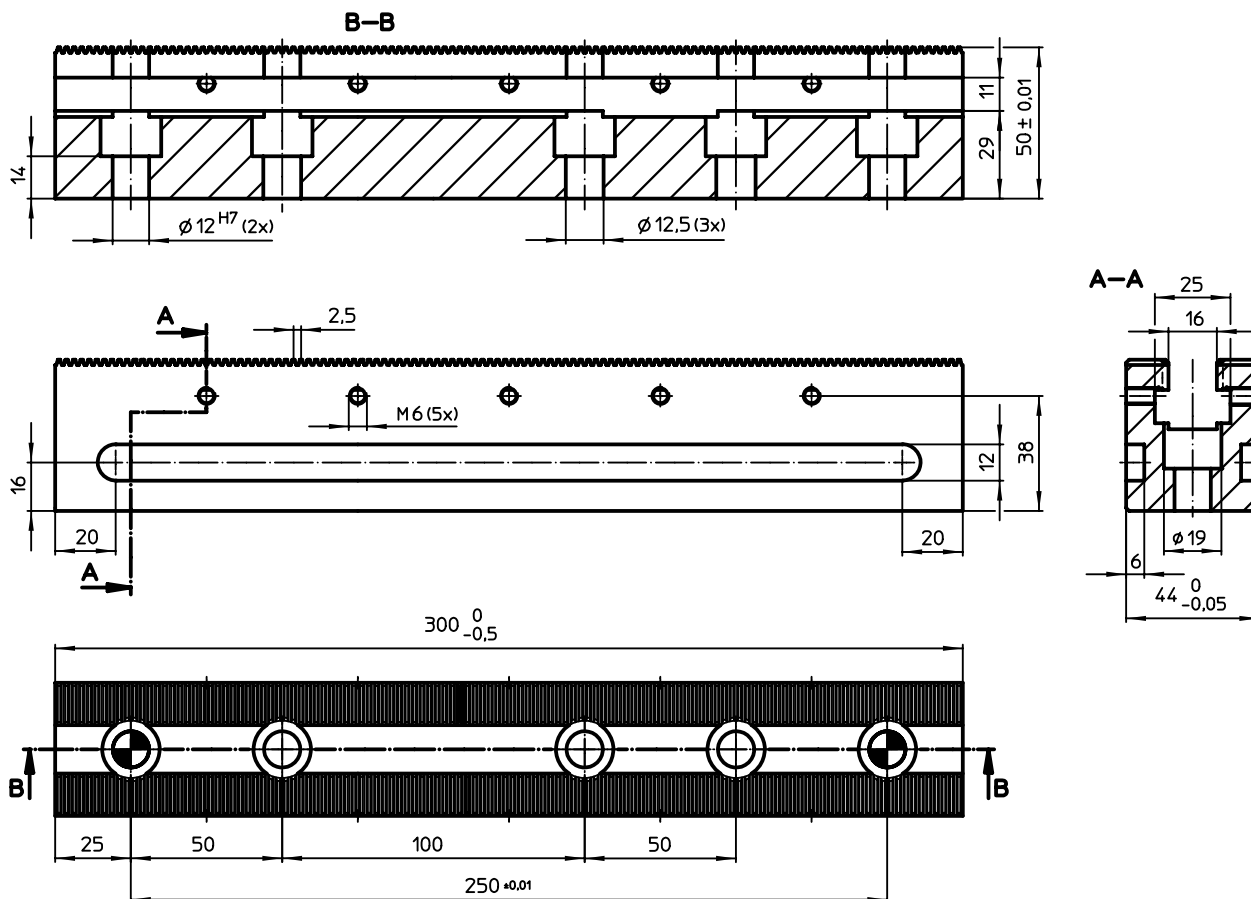


PRODUCT DESCRIPTION


Material

- Tool steel, hardened



DRAWING



ORDER INFORMATION

	Art. No.
[g] 3450	1585.300

ACCESSORIES

	Number locating screws M12 x 45	Number cap screws M12 x 45	 [g]	Art. No.
fixing screws				
	2	3	253	1585.301

Clamping Bars • length 400 - 700

EH 1585.

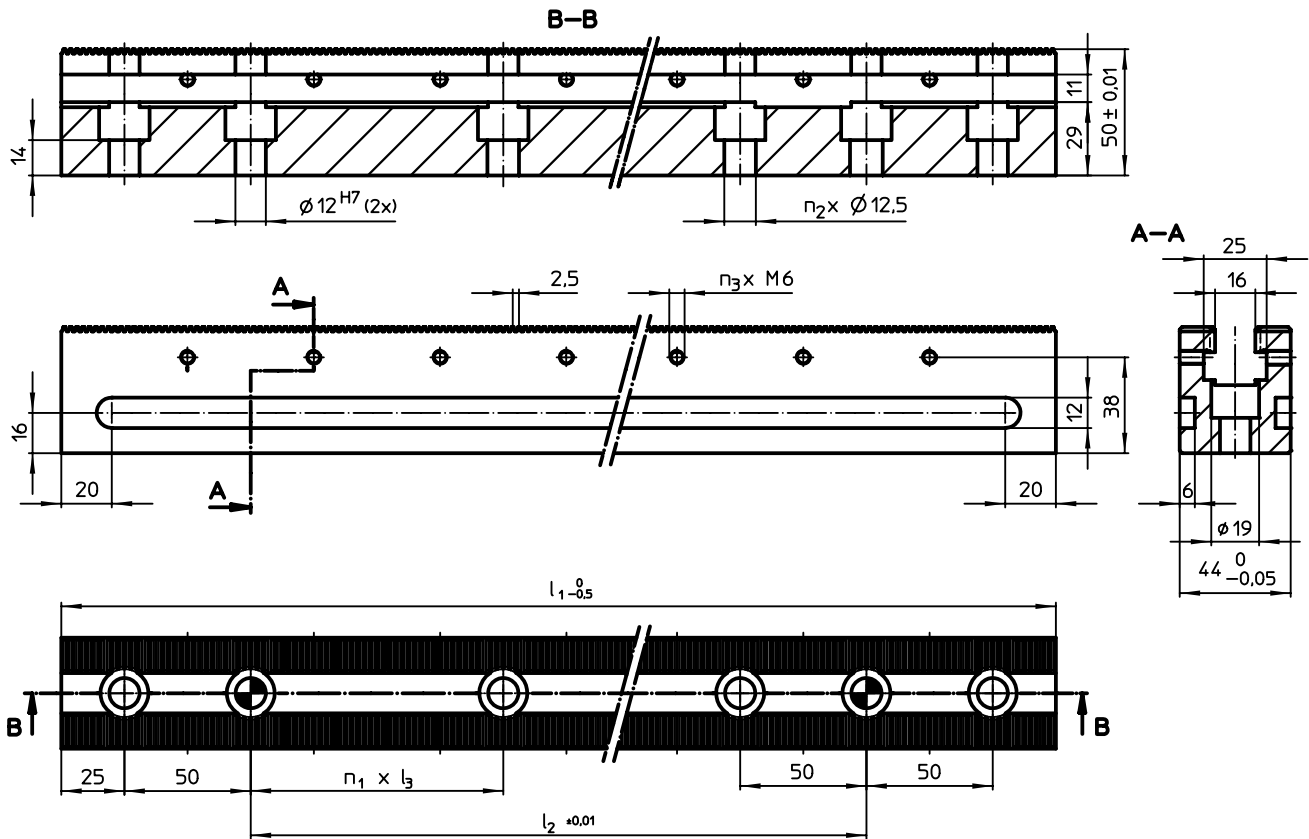


PRODUCT DESCRIPTION

Material

- Tool steel, hardened

DRAWING



ORDER INFORMATION

Dimensions			Amount			[g]	Art. No.
l_1	l_2 [mm]	l_3	n_1	n_2	n_3		
400	250	100	2	4	7	4620	1585.400
500	350	100	3	5	9	5800	1585.500
600	450	100	4	6	11	6960	1585.600
700	550	100	5	7	13	8150	1585.700

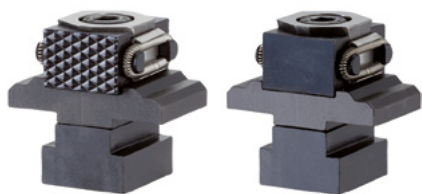
ACCESSORIES

	Number locating screws M12 x 45	Number cap screws M12 x 45	[g]	Art. No.
fixing screws				
	2	4	302	1585.401
		5	351	1585.501
		6	400	1585.601
		7	449	1585.701

9

Taper Clamping Units • plain / ribbed, M8

EH 23250.



PRODUCT DESCRIPTION

Inserting the socket head screw moves the two clamping chucks outwards and presses the workpieces against a stop. Stroke of taper clamping units with M8 = +/- 0.5 mm, M12 = +/- 1 mm.

Material

Body

- Tool steel, hardened, bright

Screw

- Heat-treated steel, tempered, quality 12.9

Spring

- Spring steel wire

Clamping jaws

- Tool steel, hardened, blackened and ground

MORE INFORMATION

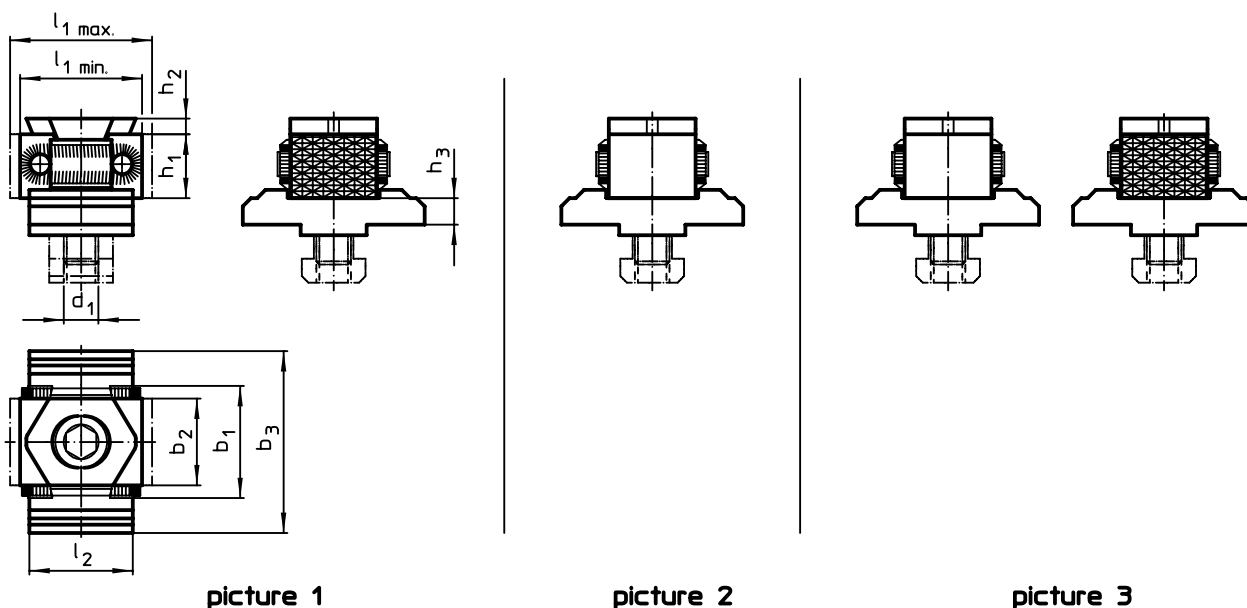
Notes

Clamping jaws protected against rotating

Further products

Taper Clamping Units → p. 448

DRAWING

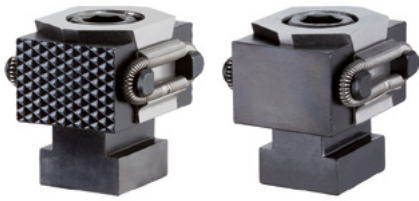


ORDER INFORMATION

d ₁	l ₁ min.	l ₁ max.	l ₂	Dimensions			h ₁	h ₂	h ₃	[g]	Art. No.
				b ₁	b ₂	b ₃					
[mm]											
clamping jaw, ribbed on both sides – picture 1											
M8	27	31	25	29	21	44	15	2,5	6,4	200	23250.0501
clamping jaw, plain on both sides – picture 2											
M8	27	31	25	29	21	44	15	2,5	6,4	200	23250.0502
clamping jaw, plain and ribbed – picture 3											
M8	27	31	25	29	21	44	15	2,5	6,4	200	23250.0503

Taper Clamping Units • plain / ribbed, M12

EH 23250.



PRODUCT DESCRIPTION

Inserting the socket head screw moves the two clamping chucks outwards and presses the workpieces against a stop. Stroke of taper clamping units with M8 = +/- 0.5 mm, M12 = +/- 1 mm.

Material

Body

- Tool steel, hardened, bright

Screw

- Heat-treated steel, tempered, quality 12.9

Spring

- Spring steel wire

Clamping jaws

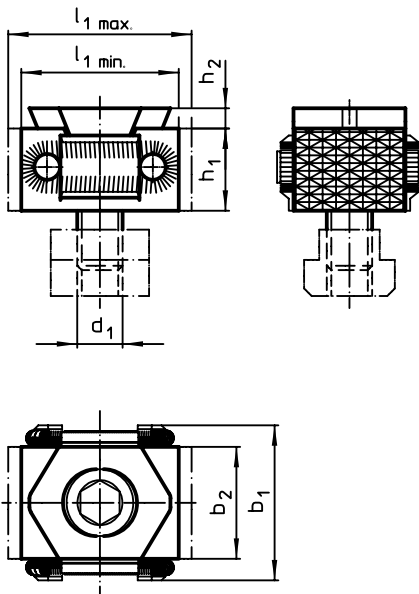
- Tool steel, hardened, blackened and ground

MORE INFORMATION

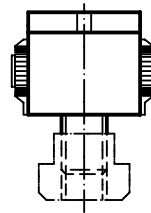
Further products

Taper Clamping Units → p. 448

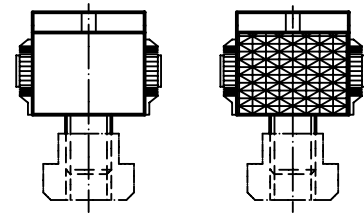
DRAWING



picture 1



picture 2



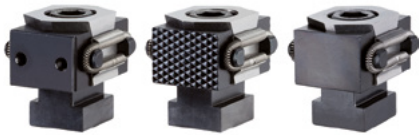
picture 3

ORDER INFORMATION

d ₁	l ₁ min.	l ₁ max.	Dimensions				[g]	Art. No.
			b ₁	b ₂	h ₁	h ₂		
[mm]								
clamping jaw, ribbed on both sides – picture 1								
M12	42	49	41	30	22	4	280,00	23250.0510
clamping jaw, plain on both sides – picture 2								
M12	42	49	41	30	22	4	280,84	23250.0511
clamping jaw, plain and ribbed – picture 3								
M12	42	49	41	30	22	4	280,00	23250.0512

Taper Clamping Units • with screw fastened thread, M12

EH 23250.



PRODUCT DESCRIPTION

Inserting the socket head screw moves the two clamping chucks outwards and presses the workpieces against a stop. Stroke of taper clamping units with M8 = +/- 0.5 mm, M12 = +/- 1 mm.

Material

Body

- Tool steel, hardened, bright

Screw

- Heat-treated steel, tempered, quality 12.9

Spring

- Spring steel wire

Clamping jaws

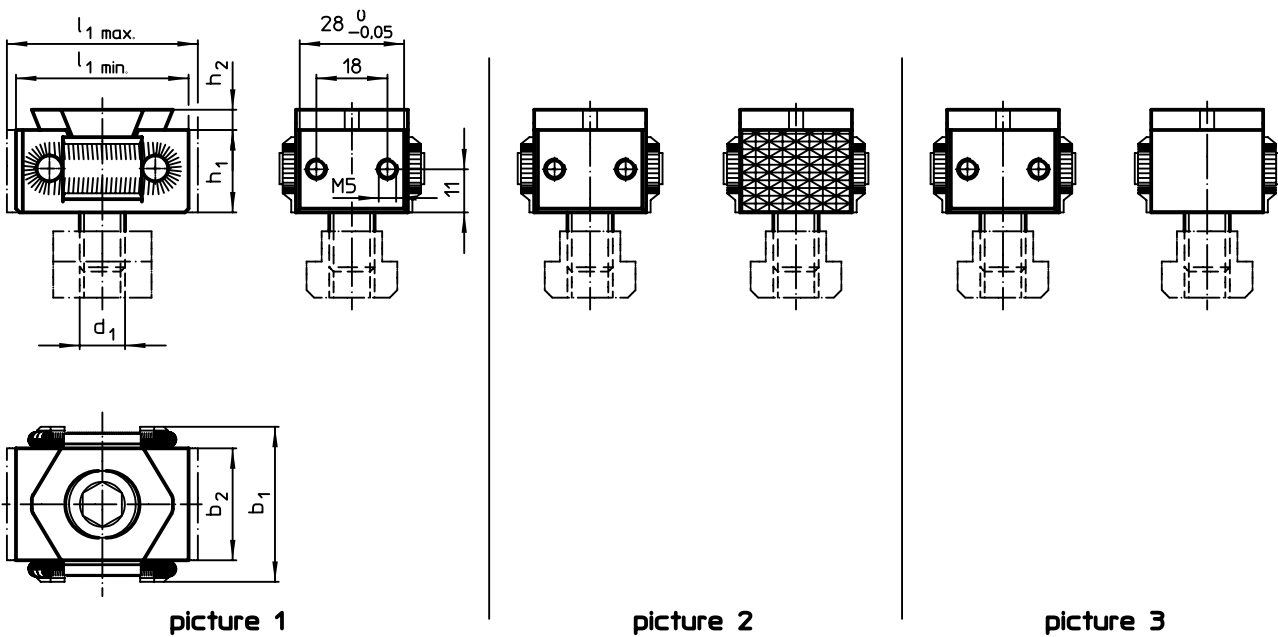
- Tool steel, hardened, blackened and ground

MORE INFORMATION

Further products

Taper Clamping Units → p. 448

DRAWING



ORDER INFORMATION

d ₁	l ₁ min.	l ₁ max.	Dimensions				[g]	Art. No.
			b ₁	b ₂	h ₁	h ₂		
[mm]								
clamping jaw with mounting thread on both sides – picture 1								
M12	47,0	54,0	41	30	22	4	300	23250.0513
clamping jaw, ribbed and with mounting thread – picture 2								
M12	44,5	51,5	41	30	22	4	290	23250.0514
clamping jaw, plain and with mounting thread – picture 3								
M12	44,5	51,5	41	30	22	4	290	23250.0515

Adapters for Taper Clamping Units • for clamping bars

EH 23250.



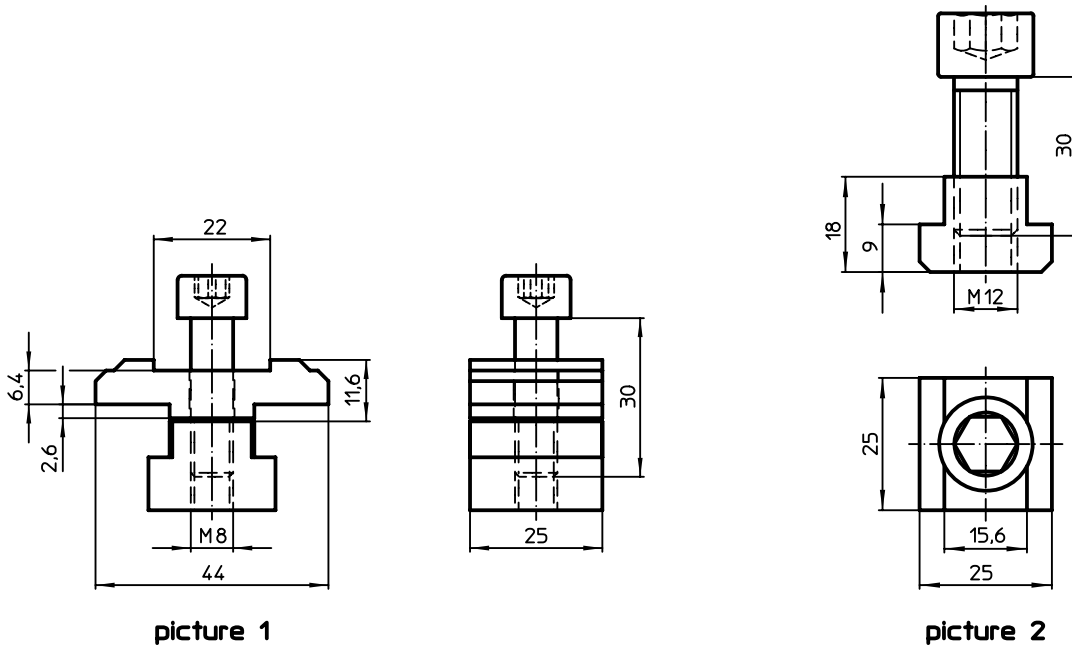
PRODUCT DESCRIPTION

With the adapter, all taper clamping units M8 - M12 can be mounted on the clamping bars. The adapter for the size M8 includes a twist-lock.

Material

- Tool steel


DRAWING



picture 1

picture 2

ORDER INFORMATION

	 [g]	Art. No.
picture 1	140	23250.0530
picture 2	100	23250.0531

Anti-Turn Locking Devices for Taper Clamping Units • for clamping bars

EH 23250.



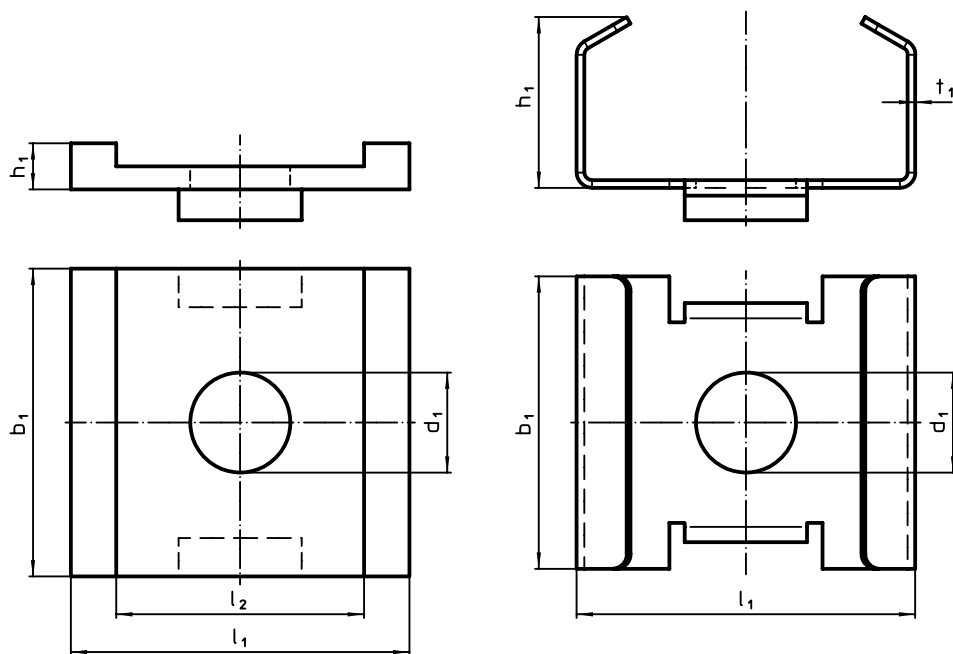
PRODUCT DESCRIPTION

Both versions prevent turning of the taper clamping unit on the clamping bar. The version "picture 2" additionally protects against damage from scales of wood and dirt.

Material

- Steel

DRAWING



picture 1

picture 2

ORDER INFORMATION

d ₁	b ₁	Dimensions				t ₁	[g]	Art. No.
		h ₁	l ₁	l ₂	[mm]			
picture 1								
13	40	3	44	32,2	-	54	23250.0532	
picture 2								
13	38	23	44	-	1	25	23250.0535	

Stop Plates for Taper Clamping Units • for clamping bars

EH 23250.



PRODUCT DESCRIPTION

The stop plate is used when clamping only on one side of the taper clamping unit. One side of the taper clamping unit rests against the step of the stop plate and is thus fixed.

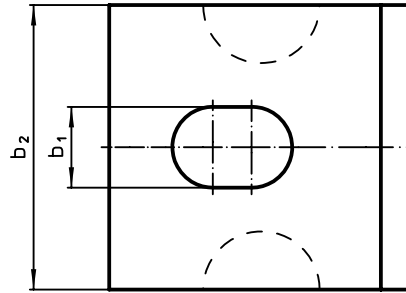
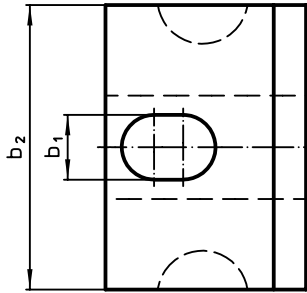
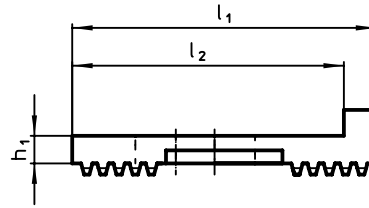
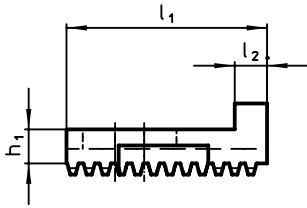
Material

- Tool steel, hardened

Assembly

The stop plate is mounted between the clamping bar and the taper clamping unit.


DRAWING



picture 1

picture 2

ORDER INFORMATION

l_1	l_2	Dimensions			For taper clamping units	 [g]	Art. No.
		b_1	b_2	h_1			
[mm]							
picture 1							
31	5	10,0	44	6,4	23250.0501 - .0503	57	23250.0540
picture 2							
47	42	12,5	44	4,4	23250.0510 - .0515	60	23250.0541

Lateral Stops

EH 1586.



PRODUCT DESCRIPTION

Material

- Steel

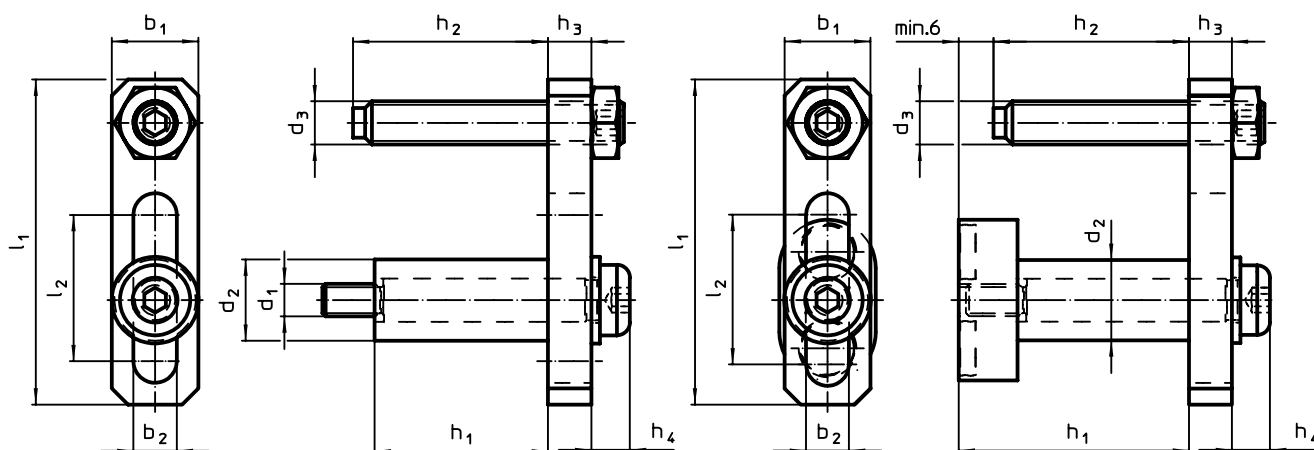
Assembly

The stop can be mounted on both sides of the clamping bar.

Magnetic version- picture 2:

The stop can be quickly and easily removed before machining the workpiece due to the tool-free mounting.

DRAWING



picture 1

picture 2

ORDER INFORMATION

d ₁	d ₂	d ₃	l ₁	l ₂	Dimensions						[g]	Art. No.	
					b ₁	b ₂	h ₁	h ₂	h ₃	h ₄			
[mm]													
picture 1													
M6	15	M8	60	27	16	8	32	0 – 37	8	7	110	1586.250	
picture 2													
–	15	M8	60	27	16	8	43	0 – 37	8	7	151	1586.252	

Insertion Tools

EH 1586.



PRODUCT DESCRIPTION

Keeps the workpiece in position during the clamping process.

Material

- Steel, blackened

Assembly

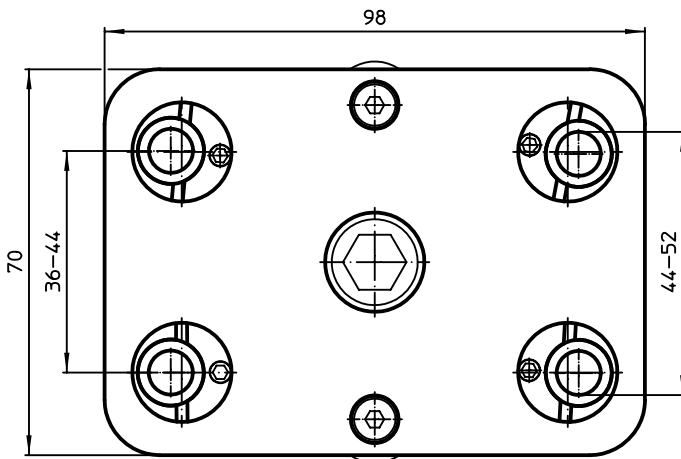
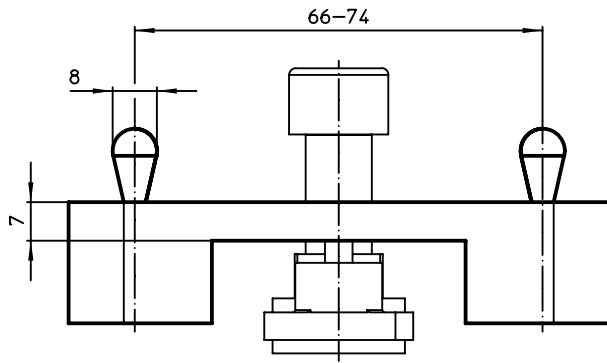
The supports (Art. No. 1586.200, 1586.201 and 1586.202) are required.

MORE INFORMATION

Notes

Spring load of 100 N per lateral spring plunger.

DRAWING



ORDER INFORMATION

	Art. No.
 [g] 800	1586.260

Supports for Clamping Bar

EH 1586.

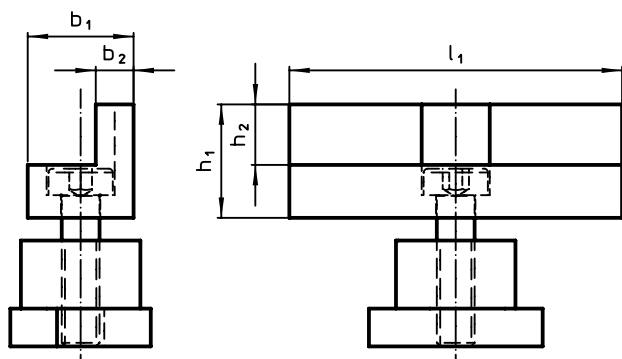


PRODUCT DESCRIPTION

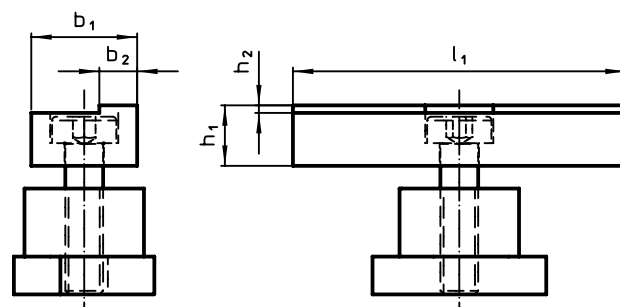
Material

- Tool steel, hardened

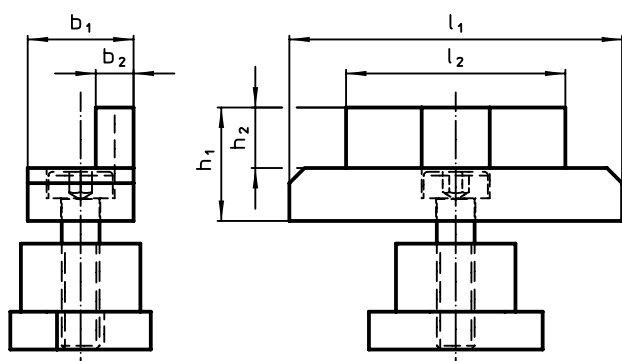
DRAWING



picture 1



picture 2



picture 3

ORDER INFORMATION

Dimensions						Art. No.
l_1	l_2	b_1	b_2	h_1	h_2	
[mm]						[g]
high – picture 1						
44	–	14	5	15	8	70 1586.200
low – picture 2						
44	–	14	5	8	1	50 1586.202
high, width shortened – picture 3						
44	29	14	5	15	8	60 1586.201

Supports for Clamping Bar • with spring-loaded catch

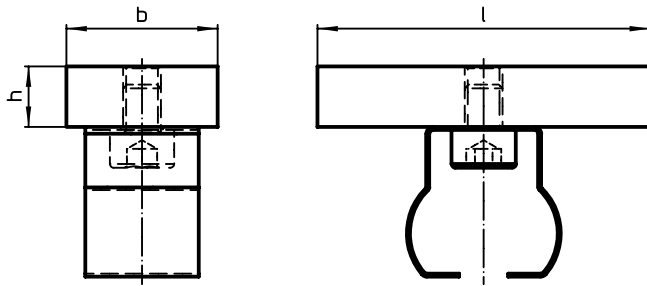
EH 1586.



PRODUCT DESCRIPTION

- Material**
- Aluminium Al

DRAWING



ORDER INFORMATION

l	Dimensions		[g]	Art. No.
	b [mm]	h		
44	20	8	30	1586.210

Supports for Clamping Bar • magnetic

EH 1586.



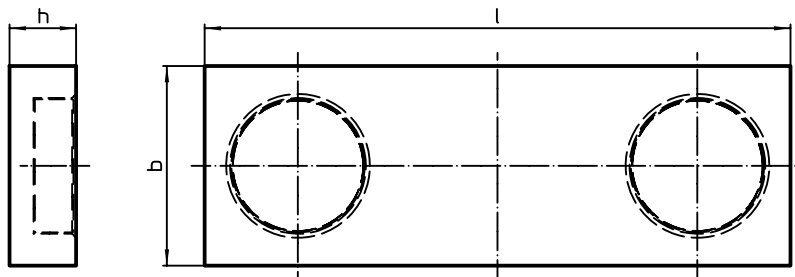
PRODUCT DESCRIPTION

- Material**
- Tool steel, hardened

Assembly

Tool-free mounting on the clamping bar or a stop by means of an integrated magnet.

DRAWING



ORDER INFORMATION

l	Dimensions		[g]	Art. No.
	b ±0,02 [mm]	h ±0,01		
44	15	5	25	1586.205

9



PRODUCT DESCRIPTION

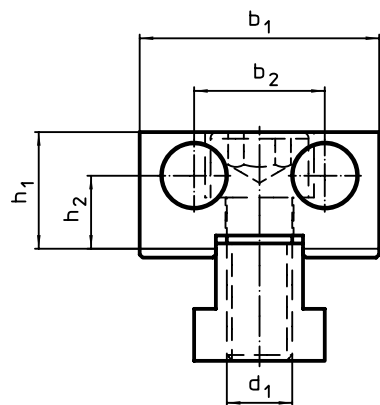
Material

- Pin**
 - Diamond coating

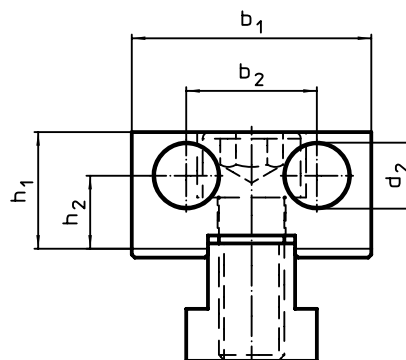
Body

- Tool steel, hardened

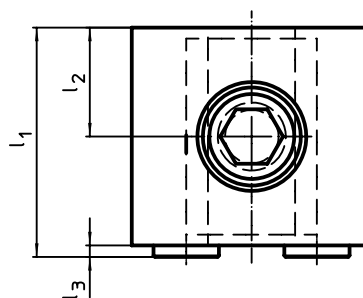
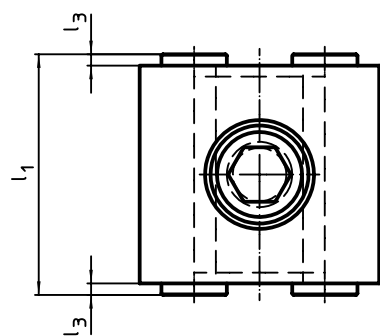
DRAWING



picture 1



picture 2



ORDER INFORMATION

d ₁	d ₂	l ₁	l ₂	Dimensions						[g]	Art. No.
				[mm]							
diamond coated, two-sided – picture 1											
M12	12	44	-	2	44	24	21,4	13,4	390	1586.010	
diamond coated one-sided, flat – picture 2											
M12	12	42	20	2	44	24	21,4	13,4	390	1586.011	

Stops • gripper studs

EH 1586.



PRODUCT DESCRIPTION

Gripper insert consists of two pins from HSS, when clamped they penetrate into the work-piece surface and may leave residual marks.

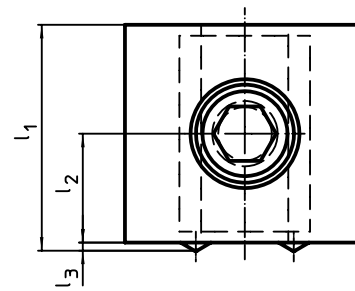
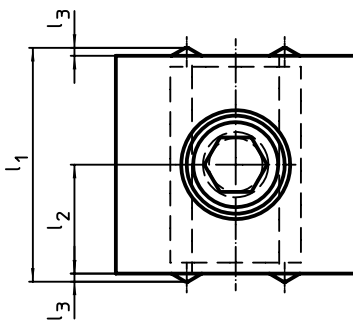
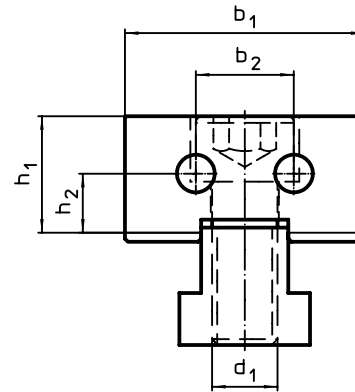
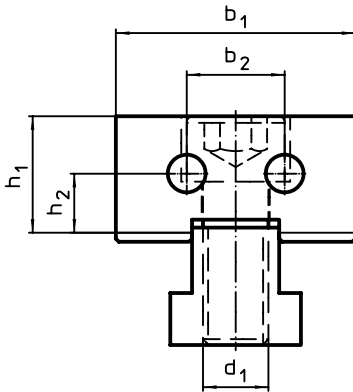
Material

- Inserts**
 - Hard metal, pointed

Body

- Tool steel, hardened

DRAWING

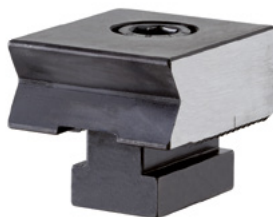


picture 1

picture 2

ORDER INFORMATION

d ₁	l ₁	l ₂	Dimensions					[g]	Art. No.
			l ₃	b ₁	b ₂	h ₁	h ₂		
gripper studs, two-sided – picture 1									
M12	42	20	1	44	18	21,4	11	400	1586.020
gripper studs, plain – picture 2									
M12	41	20	1	44	18	21,4	11	390	1586.021

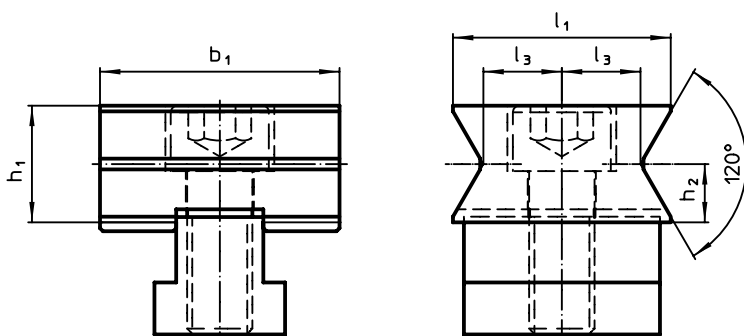


PRODUCT DESCRIPTION

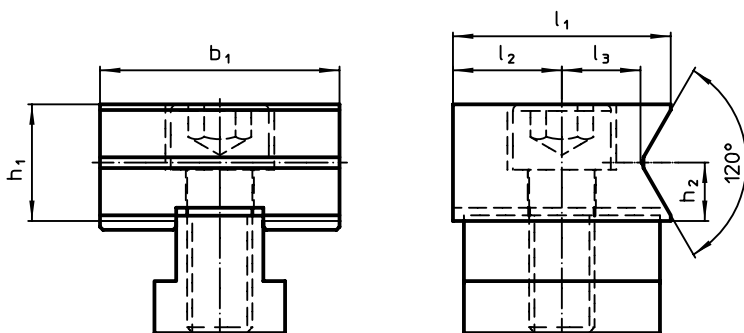
Material

- Tool steel, hardened

DRAWING



picture 1

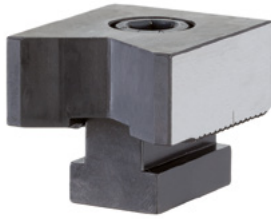


picture 2

ORDER INFORMATION

Dimensions									[g]	Art. No.
d ₁	d ₂	l ₁	l ₂	l ₃	b ₁	h ₁	h ₂	[mm]		
horizontal prisms on both sides – picture 1										
M12	8 – 20	40	–	14,4	44	21,4	10,7		390	1586.030
horizontal prism, plain – picture 2										
M12	8 – 20	40	20	14,4	44	21,4	10,7		450	1586.031

Stops • vertical prisms
EH 1586.

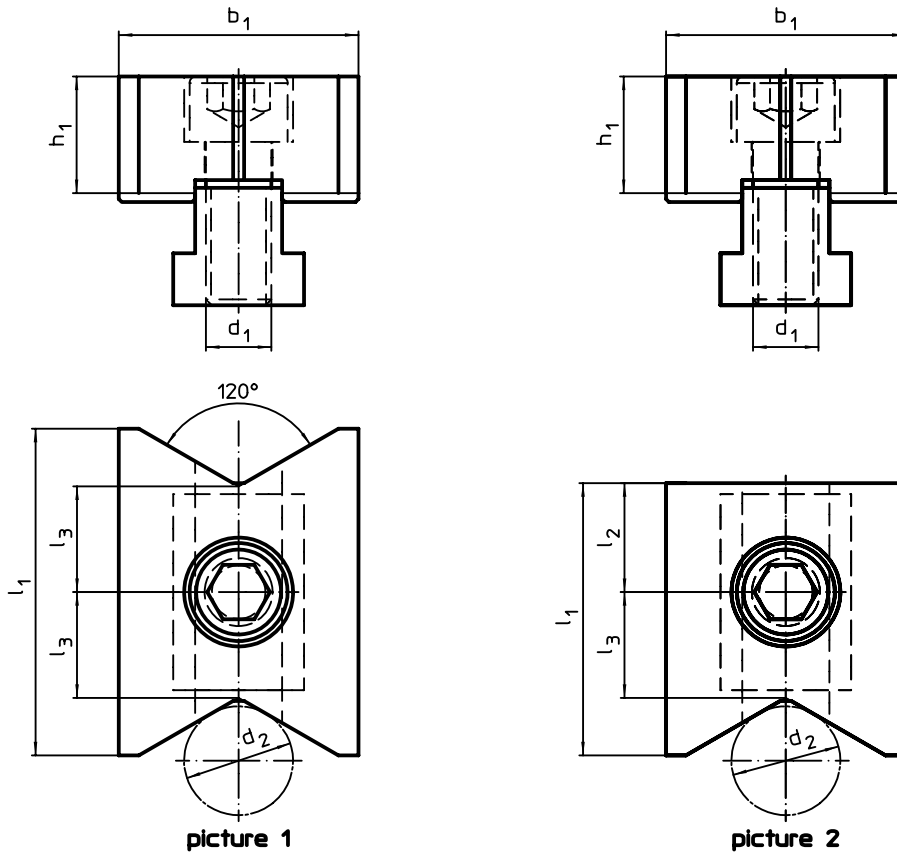


PRODUCT DESCRIPTION

Material

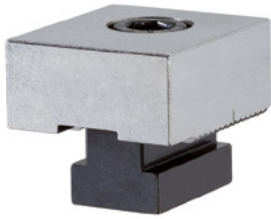
- Tool steel, hardened

DRAWING



ORDER INFORMATION

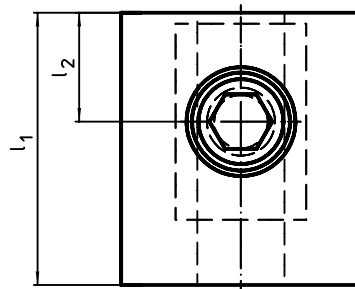
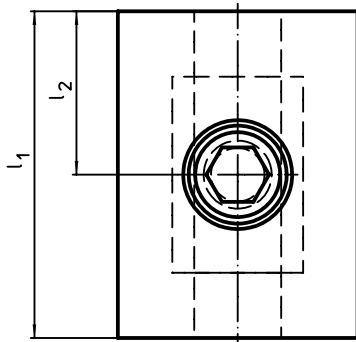
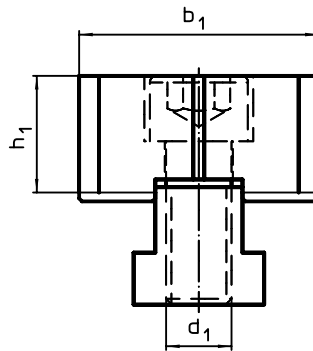
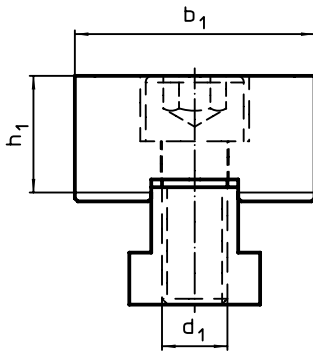
d ₁	d ₂	l ₁	Dimensions				h ₁	[g]	Art. No.
			l ₂	l ₃	b ₁	[mm]			
vertical prisms on both sides – picture 1									
M12	10 – 70	60	–	19,4	44	21,4	490	1586.040	
vertical prism, plain – picture 2									
M12	10 – 70	50	20	19,4	44	21,4	450	1586.041	

**PRODUCT DESCRIPTION**

The chucks can be machined to the needed workpiece contour.

Material

- Tool steel

DRAWING

picture 1

picture 2

ORDER INFORMATION

d ₁	l ₁	Dimensions			h ₁	[g]	Art. No.
		l ₂	b ₁	[mm]			
soft, on both sides – picture 1							
M12	60	30	44	21,4	550	1586.050	
soft, two-sided / one side short – picture 2							
M12	50	20	44	21,4	460	1586.051	

Stops • ribbed
EH 1586.



PRODUCT DESCRIPTION

Material

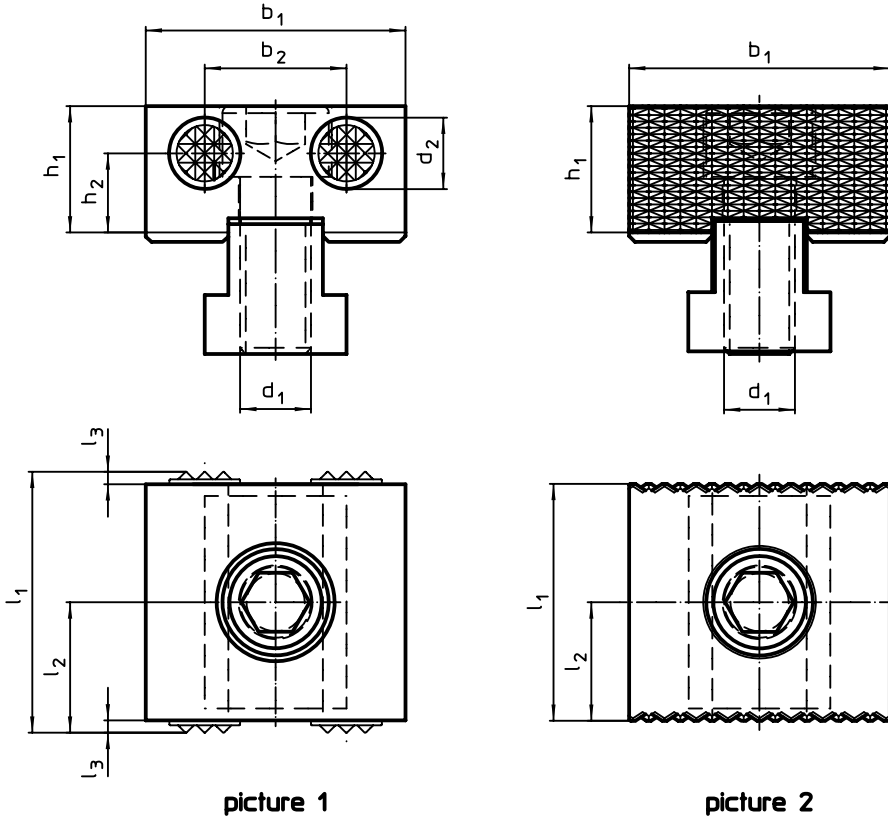
Inserts

- Hard metal

Body

- Tool steel, hardened

DRAWING



picture 1

picture 2

ORDER INFORMATION

d ₁	d ₂	l ₁	l ₂	Dimensions			b ₁	b ₂	h ₁	h ₂	[g]	Art. No.
				l ₃	[mm]							
ribbed on both sides – picture 1												
M12	12	44	22	2			44	24	21,4	13,4	390	1586.060
ribbed over the entire surface, on both sides – picture 2												
M12	–	40	20	–			44	–	21,4	–	392	1586.062



PRODUCT DESCRIPTION

Material

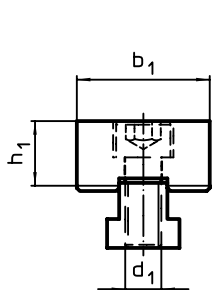
Inserts

- Hard metal

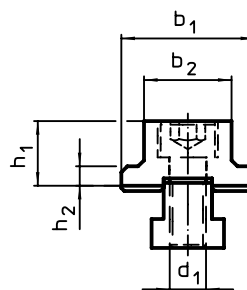
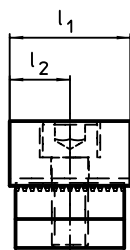
Body

- Tool steel, hardened

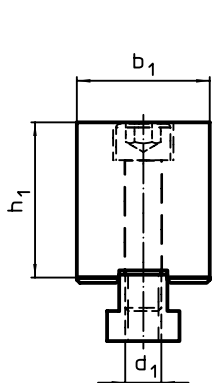
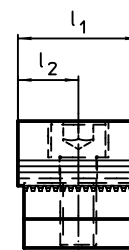
DRAWING



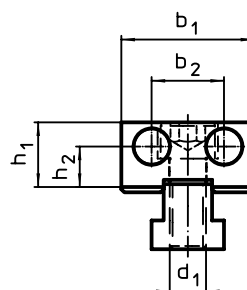
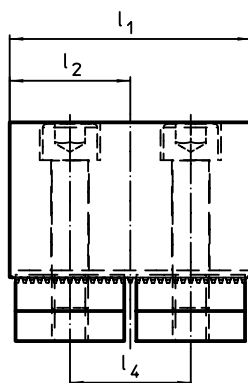
picture 1



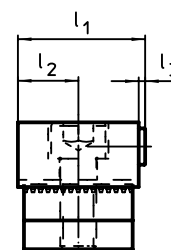
picture 2



picture 3



picture 4



ORDER INFORMATION

Dimensions											Art. No.
d ₁	d ₂	l ₁	l ₂	l ₃	l ₄	b ₁	b ₂	h ₁	h ₂	[g]	
plain, on both sides – picture 1											
M12	-	40	20	-	-	44	-	21,4	-	400	1586.070
plain, two-sided / width shortened – picture 2											
M12	-	40	20	-	-	44	29	21,4	6,4	340	1586.071
plain, two-sided / high version – picture 3											
M12	-	80	40	-	40	44	-	51,4	-	1600	1586.072
ribbed and plain – picture 4											
M12	12	42	20	2	-	44	24	21,4	13,4	390	1586.073

Stops • with mounting thread
EH 1586.



PRODUCT DESCRIPTION

Material

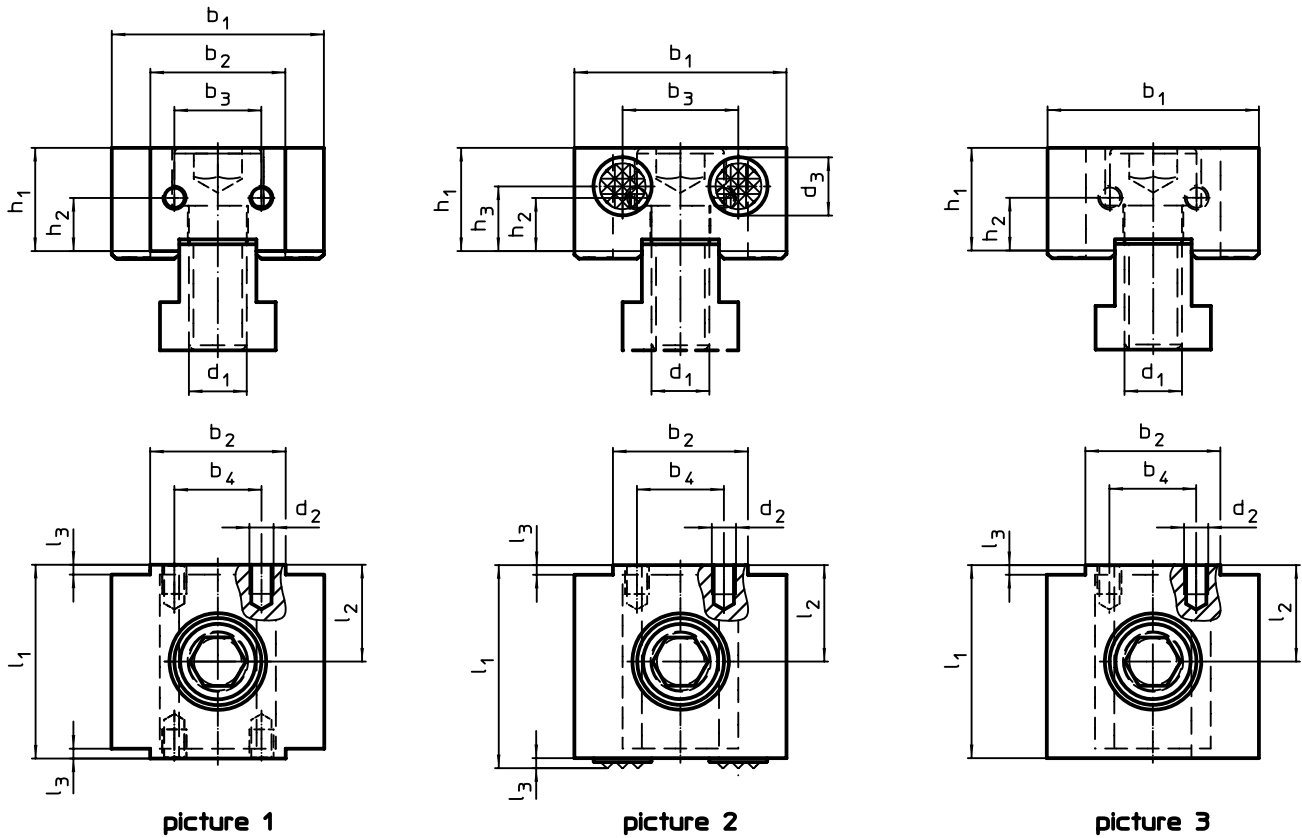
Inserts

- Hard metal


Body

- Tool steel, hardened

DRAWING

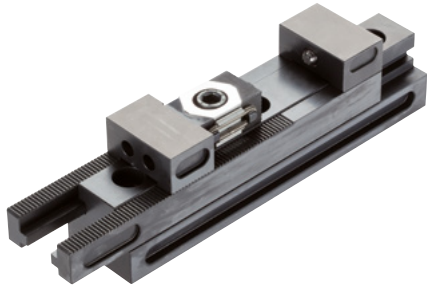


ORDER INFORMATION

Dimensions														Art. No.
d ₁	d ₂	d ₃	l ₁	l ₂	l ₃	b ₁	b ₂	b ₃	b ₄	h ₁	h ₂	h ₃		
mounting thread on both sides – picture 1														
M12	M5	–	40	20	2	44	28	18	18	21,4	11	11,0	400	1586.080
ribbed and mounting thread – picture 2														
M12	M5	12	42	20	2	44	28	24	18	21,4	11	13,4	400	1586.081
plain and mounting thread – picture 3														
M12	M5	–	40	20	2	44	28	–	18	21,4	11	–	400	1586.082

Combination Clamping Bars

EH 1586.



PRODUCT DESCRIPTION

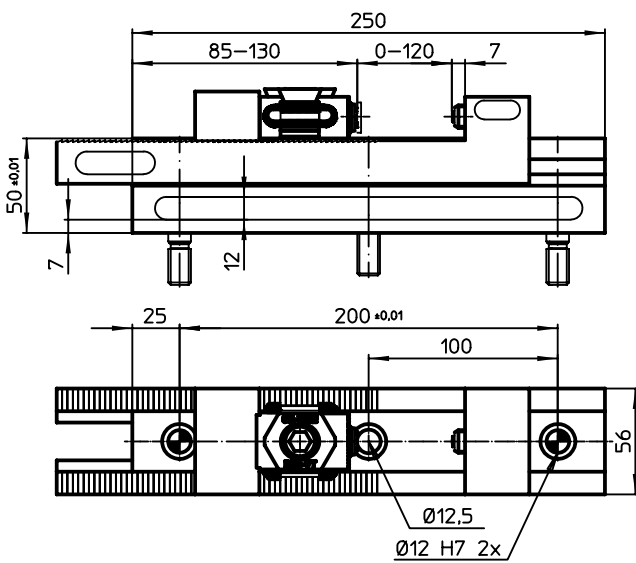
The combination clamping bar offers 3 ways to clamp/support the workpiece:

- Floating mode
Floating mode is used to clamp and support additional clamping points on components.
- Centric mode
The jaws of the clamping bar move in sync. The centre axis of the workpiece remains unchanged even if the outer diameters are modified.
- Machine vice mode
When this mode is selected, one of the jaws is locked in place on the clamping bar. The second jaw remains movable.

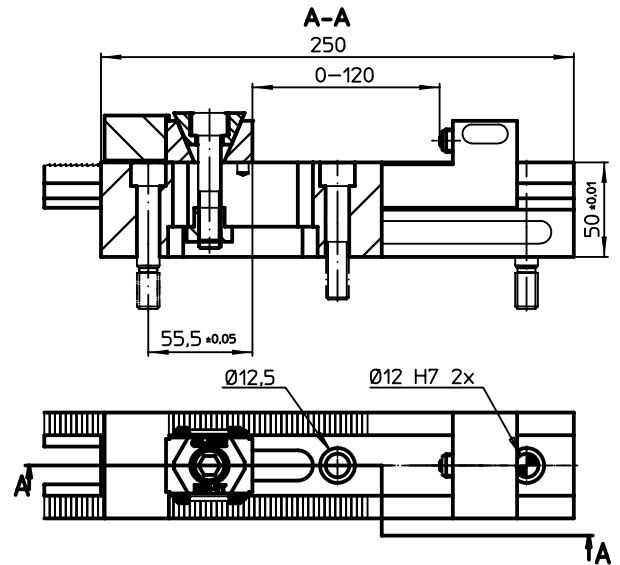
Material

- Tool steel, hardened

DRAWING




floating mode





machine vice mode

ORDER INFORMATION

	Art. No.
[g]	
5360	1586.400

ACCESSORIES

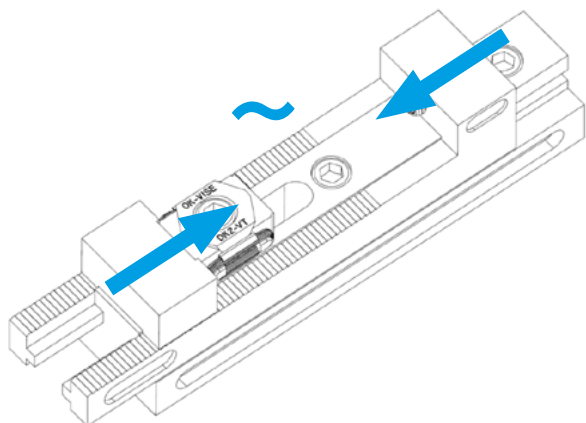
	Number locating screws M12 x 45	Number cap screws M12 x 45	 [g]	Art. No.
fixing screws for clamping bars				
	2	1	203	1586.401

Combination Clamping Bars

1586.400

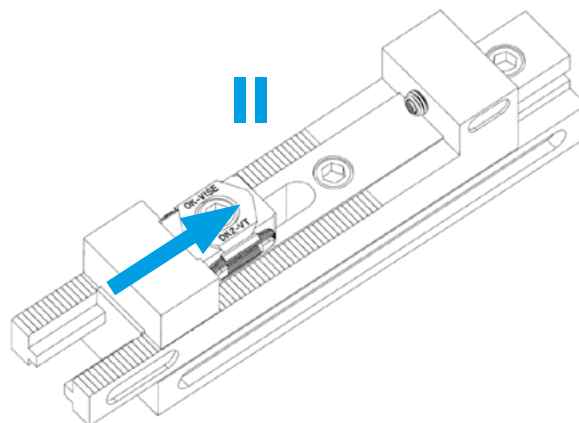
FUNCTIONS

The combination clamping bar offers 3 different functions by means of which the workpiece can be clamped/supported.



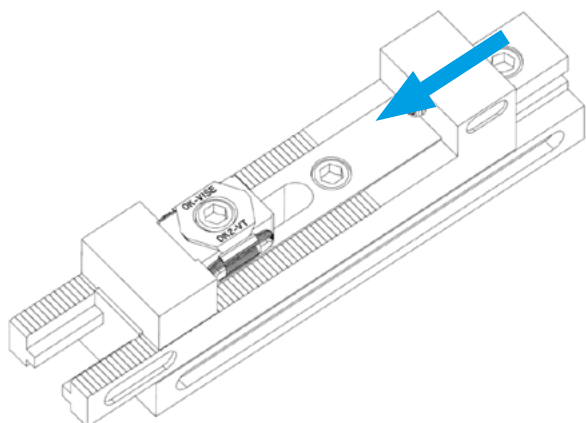
FLOATING MODE

- Floating mode is used to clamp and support additional clamping points on components.
- The fixture adapts to the position of the workpiece.



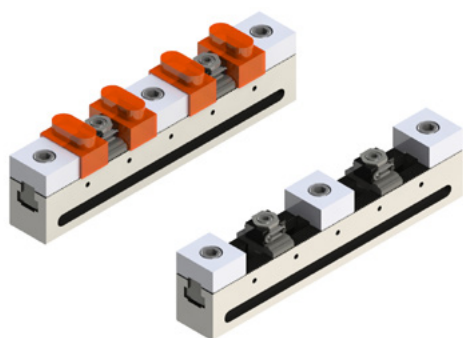
CENTRIC MODE

- The jaws of the clamping bar move in sync. The centre axis of the workpiece remains unchanged even if the outer diameters are modified.



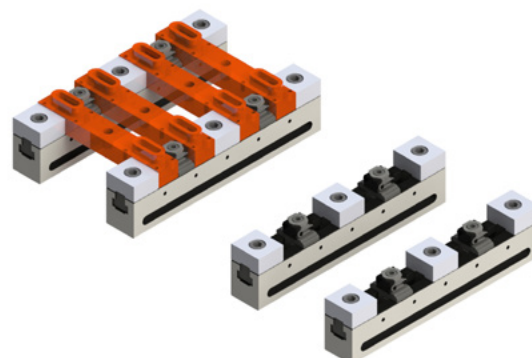
MACHINE VICE MODE

- When this mode is selected, one of the jaws is locked in place on the clamping bar. The second jaw remains movable.



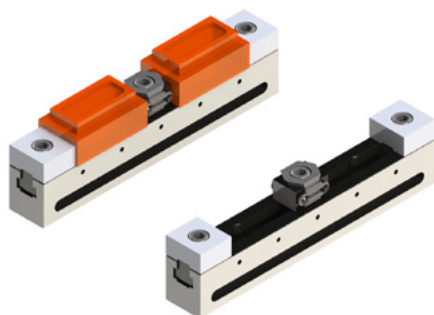
Flexible 3-sided machining.
You can machine up to 4 workpieces at once. Art. No. 1586.410

Units	Designation	Art. No.
1	Clamping bar	1585.300
1	Fixing screws	1585.301
3	Stop, flat, two-sided	1586.070
2	Taper clamping unit, M8 clamping jaw flat, two-sided	23250.0502



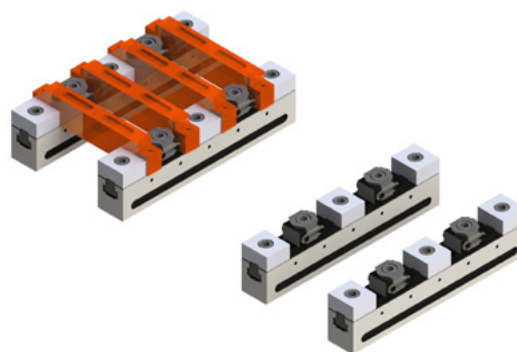
Two ranges of 1586.410. Particularly well suited for machining long workpieces. Art. No. 1586.411

Units	Designation	Art. No.
2	Clamping bar	1585.300
2	Fixing screws	1585.301
6	Stop, flat, two-sided	1586.070
4	Taper clamping unit, M8 clamping jaw flat, two-sided	23250.0502



Flexible 3-sided machining. 1-2 workpieces can be machined at the same time. Art. No. 1586.412

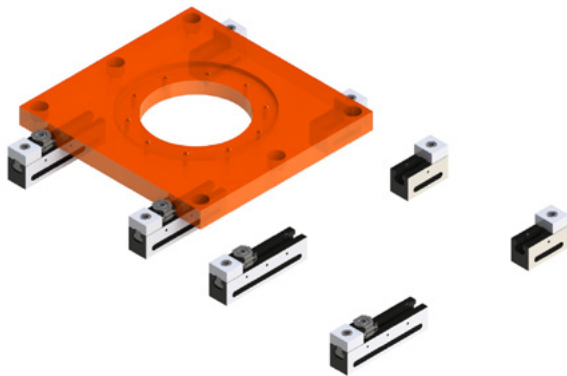
Units	Designation	Art. No.
1	Clamping bar	1585.300
1	Fixing screws	1585.301
2	Stop, flat, two-sided	1586.070
1	Taper clamping unit, M12 clamping jaw flat, two-sided	23250.0511



Flexible 3-sided machining. Particularly well suited for machining long workpieces. Art. No. 1586.413

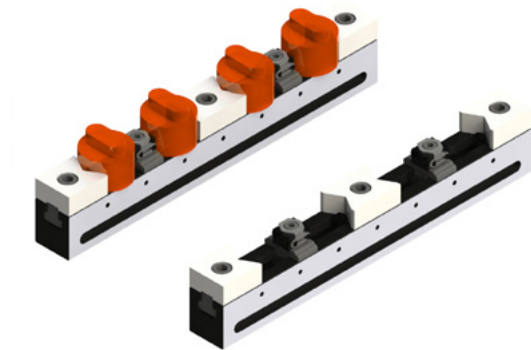
Units	Designation	Art. No.
2	Clamping bar	1585.300
2	Fixing screws	1585.301
6	Stop, flat, two-sided	1586.070
4	Taper clamping unit, M12 clamping jaw flat, two-sided	23250.0511

STANDARD RANGES



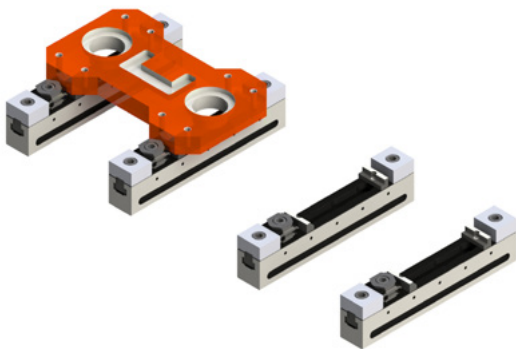
For machining large workpieces. Art. No. 1586.414

Units	Designation	Art. No.
2	Clamping bar	1585.100
2	Fixing screws	1585.101
2	Clamping bar	1585.200
2	Fixing screws	1585.201
4	Stop, flat, two-sided	1586.070
2	Taper clamping unit, M8 clamping jaw flat, two-sided	23250.0511



For machining cylindrical workpieces. 4 workpieces can be machined at the same time. Art. No. 1586.415

Units	Designation	Art. No.
1	Clamping bar	1585.400
1	Fixing screws	1585.401
1	Stop, V-blocks vertical, two-sided	1586.040
2	Stop, 1-sided, V-blocks vertical and flat	1586.041
2	Taper clamping unit, M8 clamping jaw flat, two-sided	23250.0502



For machining large workpieces. Including supports with a height of 15 mm. Art. No. 1586.416

Units	Designation	Art. No.
2	Clamping bar	1585.300
2	Fixing screws	1585.301
4	Stop, flat, two-sided	1586.070
4	Support for clamping bar	1586.200
2	Taper clamping unit, M12 clamping jaw flat, two-sided	23250.0511

NOTES

A large grid of small squares, intended for taking notes. The grid consists of approximately 30 columns and 40 rows of small, light gray squares.