

# HOME OF CLAMPING



**2023/2024**  
SINGLE AND MULTIPLE  
CLAMPING SYSTEM

## 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.

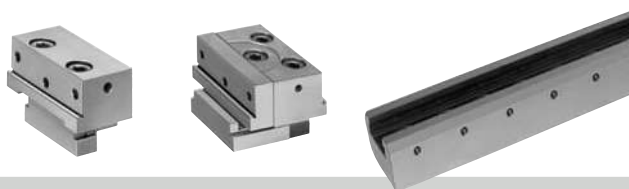
**COLLET - MECHANICAL AND HYDRAULIC  
COLLET ATTACHMENT FOR ZERO-POINT CLAMPING MODULES**

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**MULTIPLE CLAMPING SYSTEM NO. 6371**

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**PNEUMATIC VICE**

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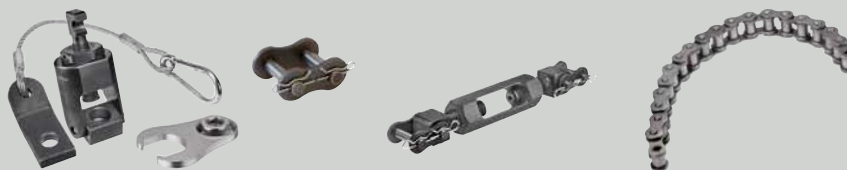
**MULTIPLE CLAMPING SYSTEM NO. 6376**

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**CHAIN CLAMPING SET**

49 - 56



Subject to technical alterations.

## No. 6375M

### Mechanical collet - base element

Base element made of tempered steel, plasma-nitrided and burnished.



Order no.	Size	Clamping stroke Ø [mm]	Tightening torque Md max. [Nm]	SW	dia. D	H	Weight [g]
567121	10	0,3	30	10	81	40	1259
567122	20	0,3	40	13	117	56	3633

#### Design:

The mechanism of the body is protected against dirt and cooling water. Surrounding clamping rim for fastening onto the machine table and flat surfaces for seating in the machine vice. Provided on the underside is the holder for the AMF zero-point system size 10 and size 20 as well as grooves for positioning on AMF zero-point clamping modules for indexing. The base element is used for seating the collet attachments for inside and outside clamping.

#### Advantage:

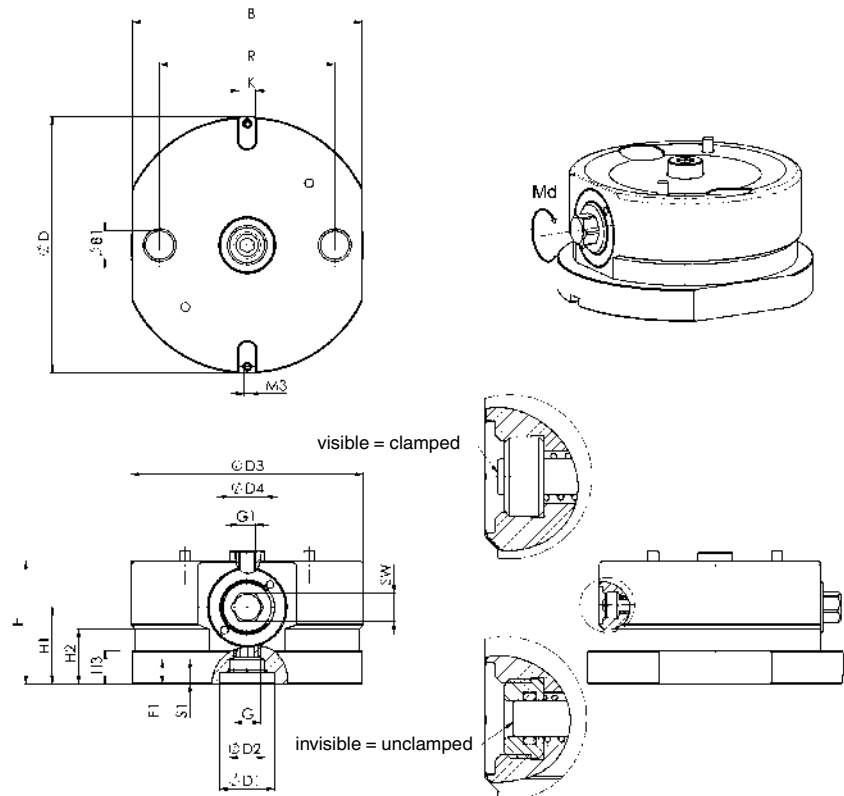
- The lateral actuation makes it possible to clamp workpieces with blind holes and through-holes
- Control display clamped/released by means of dowel pin on the base element
- Flexibility through a base element for outside or inside clamping

#### Note:

The collet attachments 6375ZA and 6375ZI must be fastened using the fastening kits 6375BA (outside clamping) or 6375BI (inside clamping).

#### Dimensions:

Order no.	Size	B	B1	dia. D1	dia. D2	dia. D3	dia. D4	E1	G	G1	H1	H2	H3	K	R	S1
567121	10	72	8,4	15	-	74	11	-	M8	M6	26	17	12	8	50	4,5
567122	20	105	13,0	25	16	106	16	11	M12	M8	35	25	15	8	80	5,5





## No. 6375ZI

### Collet attachment inside clamping

Collet attachment made of high-strength aluminium, hard anodised. With circlip made of tempered steel, burnished.

**NEW!**



Order no.	Size	dia. D	dia. D1	dia. D2	dia. D3	H	H1	H2	H3	H4	Clamping stroke Ø [mm]	Weight [g]
567125	10	70	32,7	11,2	65	41,5	10	7	14,5	9,5	0,3	327
567126	20	99	44,7	16,0	90	46,5	10	10	14,5	9,5	0,3	779

### Design:

Collet attachments are always supplied with circlip.

### Application:

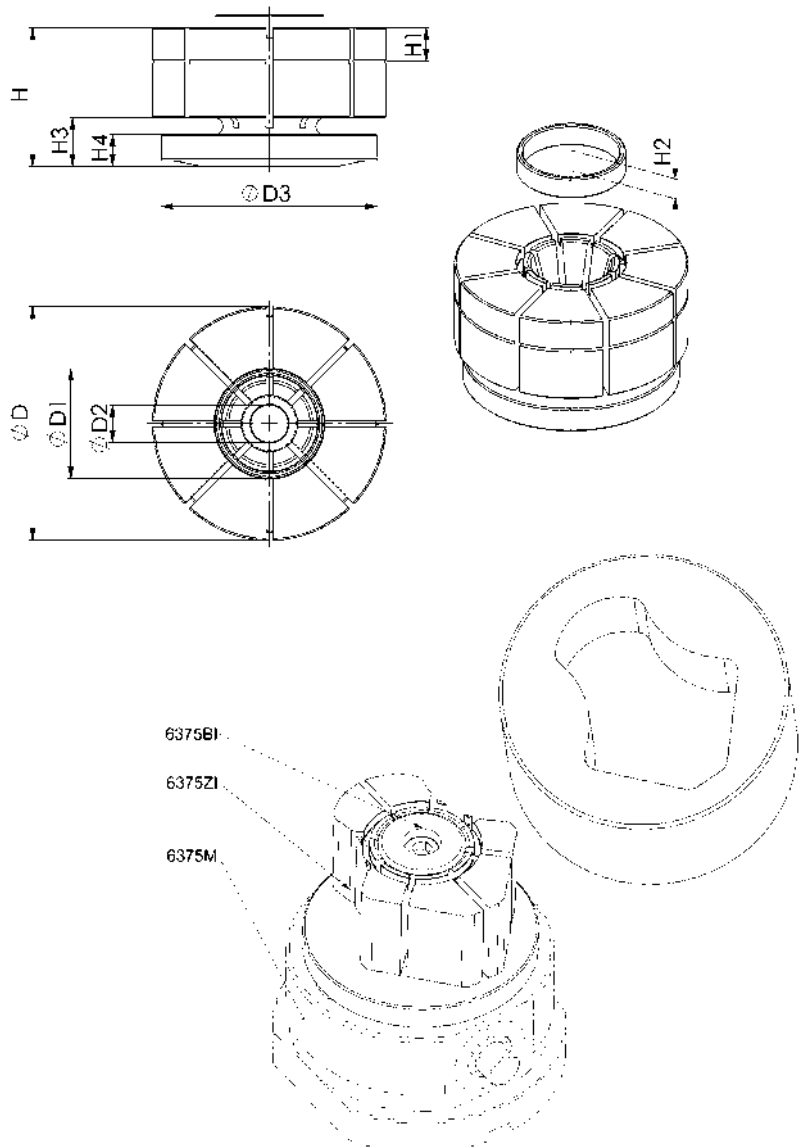
The collet attachment is fastened using fastening kit 6375BI (observe torque specifications) on the base element 6375M. To secure the workpiece contour, the collet attachment must be clamped with the circlip. Then the workpiece contour is milled into the collet attachment with a minimum clamping depth of 10 mm. Then the circlip is removed, and the workpiece can be clamped. To secure new workpiece contours, the collet attachment can be milled off up to a diameter (D1).

### Advantage:

- Clamping of blind holes and through-holes
- Free-form clamping
- Clamping of delicate and thin-walled workpieces
- The workpiece is clamped without distortion due to the radially even clamping force imposed on it
- Multiple insertion of different workpiece contours possible

### Note:

The collet attachment must always be clamped with the workpiece or circlip. To remove the vertical play between the collet attachment and base element, light pretensioning must be applied by actuating the clamping stud after the workpiece is inserted.



Subject to technical alterations.

## No. 6375ZA

### Collet attachment outside clamping

Collet attachment made of high-strength aluminium, hard anodised or polyamide.

With locking bolt made of tempered steel, burnished.

Order no.	Size	dia. D	dia. D1	dia. D2	H	H1	H2	Material	Clamping stroke Ø [mm]	Weight [g]
567123	10	70	61	17,7	30	15	6	EN AW 7075	0,3	274
567124	20	99	90	22,7	50	25	10	EN AW 7075	0,3	935
550278	20	99	90	22,7	50	25	10	Polyamid	1,0	360

### Design:

Collet attachments are always supplied with locking bolt.

### Application:

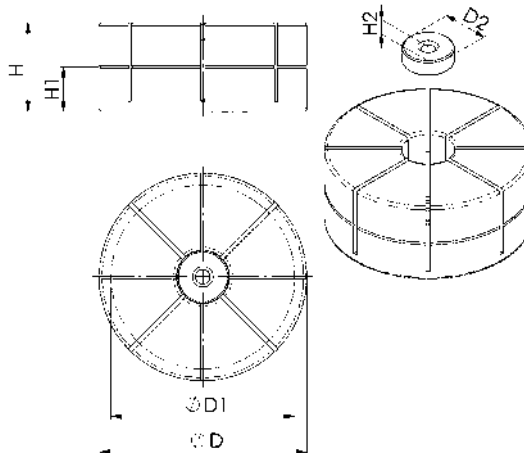
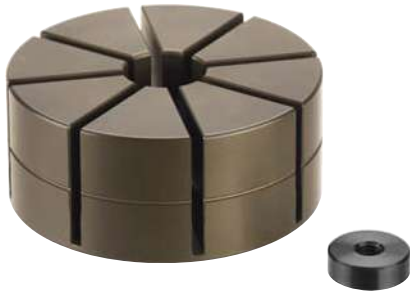
The collet attachment is fastened using fastening kit 6375BA (observe torque specifications) on the base element 6375M. To secure the workpiece contour, the collet attachment must be clamped with the locking bolt. Then the workpiece contour is milled into the collet attachment with a minimum clamping depth of 2 mm. Then the locking bolt is removed, and the workpiece can be clamped. The collet attachment can be milled off to a height of H1, allowing new workpiece contours to be introduced. The maximum workpiece diameter is specified in the table with D1.

### Advantage:

- Clamping of delicate and thin-walled workpieces
- Free-form clamping
- The workpiece is clamped without distortion due to the radially even clamping force imposed on it
- Multiple insertion of different workpiece contours possible

### Note:

The collet attachment must always be clamped with the workpiece or locking bolt. To remove the vertical play between the collet attachment and base element, light pretensioning must be applied by actuating the clamping stud after the workpiece is inserted.



## No. 6375ZA

### Collet attachment outside clamping

Collet attachment made of high-strength aluminium, hard anodised.

With locking bolt made of tempered steel, burnished.



Order no.	Size	dia. D	dia. D1	dia. D2	H	H1	H2	H3	Material	Clamping stroke Ø	Weight
										[mm]	[g]
428656	20	149	140	23	50	25	10	10	EN AW 7075	0,3	880

### Design:

Collet attachments are always supplied with locking bolt.

### Application:

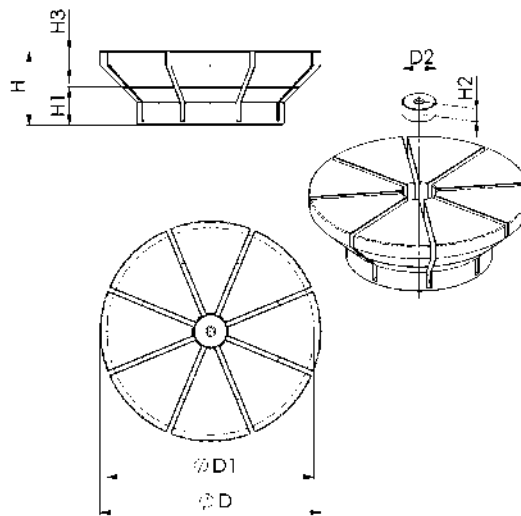
The collet attachment is fastened using fastening kit 6375BA (observe torque specifications) on the base element 6375M. To secure the workpiece contour, the collet attachment must be clamped with the locking bolt. Then the workpiece contour is milled into the collet attachment with a minimum clamping depth of 2 mm. Then the locking bolt is removed, and the workpiece can be clamped. The collet attachment can be milled off to a height of H1, allowing new workpiece contours to be introduced. The maximum workpiece diameter is specified in the table with D1.

### Advantage:

- Clamping of delicate and thin-walled workpieces
- Free-form clamping
- The workpiece is clamped without distortion due to the radially even clamping force imposed on it
- Multiple insertion of different workpiece contours possible

### Note:

The collet attachment must always be clamped with the workpiece or locking bolt. To remove the vertical play between the collet attachment and base element, light pretensioning must be applied by actuating the clamping stud after the workpiece is inserted.



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.

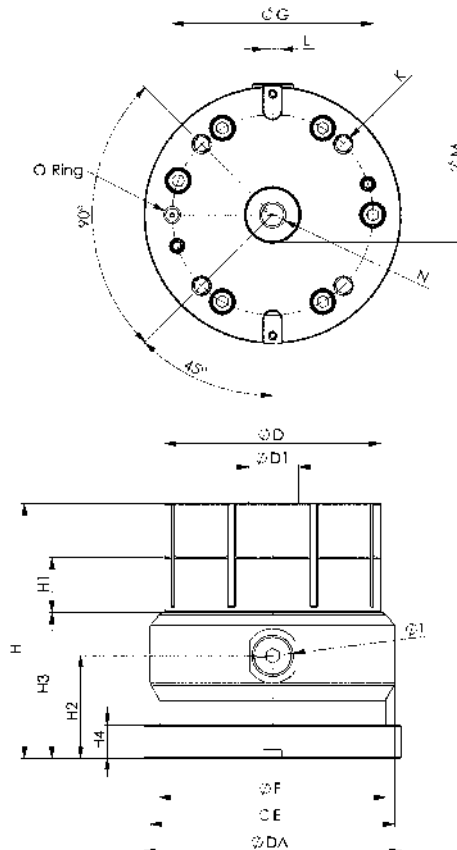
### Note:

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.

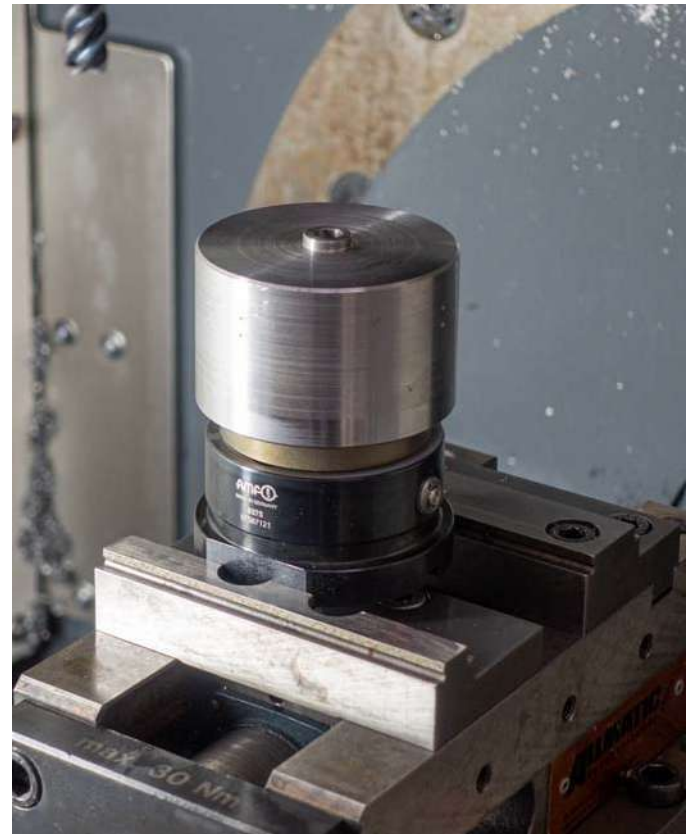
### Dimensions:

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



Subject to technical alterations.





## No. 6375BI

### Fastening kit for collet attachment inside clamping

With tension bolt made of tempered steel, plasma-nitrided and burnished and cylinder screw ISO4762, strength class 12.9.

**NEW!**



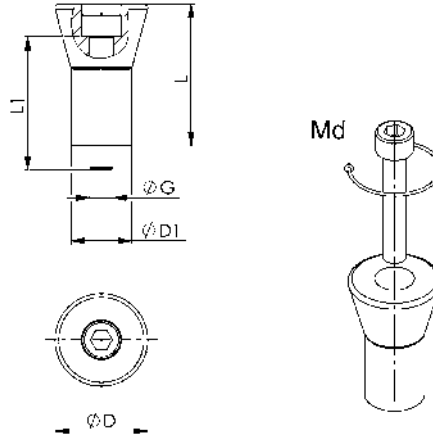
Order no.	Size	dia. D [mm]	dia. D1 [mm]	G [mm]	Md [Nm]	L [mm]	L1 [mm]	Weight [g]
567129	10	25	16	M6	14	37	35	73
567130	20	25	19	M8	25	42	40	93

#### Application:

For fastening the collet attachments to the inside clamping of workpieces.

#### Note:

The fastening kit must be tightened with the specified torque.



## No. 6375BA

### Fastening kit for collet attachment outside clamping

With disc made of tempered steel and flat-head screw ISO10642.

**NEW!**



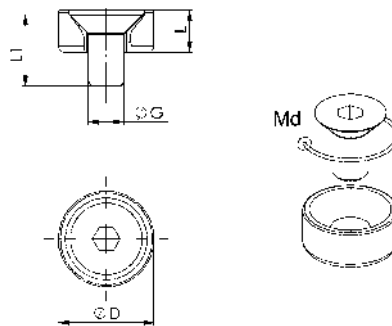
Order no.	Size	dia. D [mm]	G [mm]	Md [Nm]	L [mm]	L1 [mm]	Weight [g]
567127	10	16	M6	8	7	12	11
567128	20	21	M8	10	7	16	20

#### Application:

For fastening the collet attachments to the outside clamping of workpieces.

#### Note:

The fastening kit must be tightened with the specified torque.

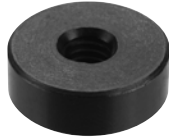


## Nr. 6375SBA

### Safety bolt for collet attachment - outside clamping

Tempered steel, burnished.

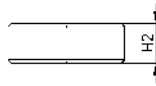
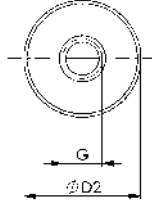
**NEW!**



Order no.	Size	dia. D2 [mm]	G [mm]	H2 [mm]	Weight [g]
568511	10	17,7	M6	6	10,4
568512	20	22,7	M6	10	30

#### Application:

To attach the workpiece contour, the collet attachment for outside clamping must be clamped with the safety bolt.



## Nr. 6375SRI

### Circlip for collet attachment - inside clamping

Tempered steel, burnished.

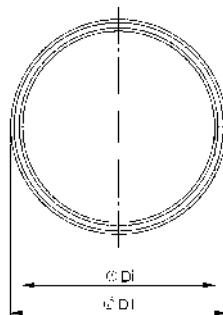
**NEW!**



Order no.	Size	dia. D1 [mm]	ØDi [mm]	H2 [mm]	Weight [g]
568513	10	32,7	29,1	7	9,2
568514	20	44,7	35,2	10	44,5

#### Application:

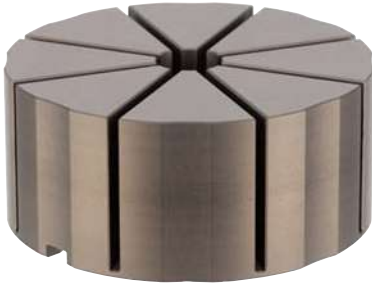
To attach the workpiece contour, the collet attachment for inside clamping must be clamped with the circlip.



## No. 6370ZSZ-112

### Collet attachment for clamping module KH20 and BH20, hydr.

Material: high-strength aluminium.



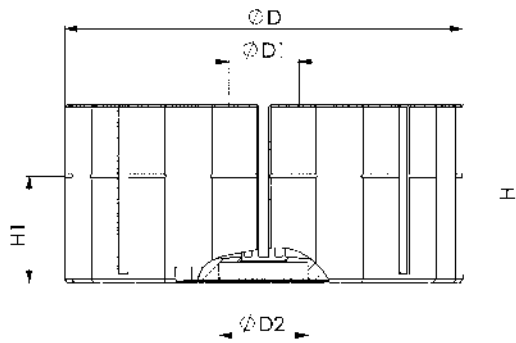
Order no.	dia. D	dia. D1	ØD2 0/+0.01	Clamping stroke Ø [mm]	H	H1	Weight [g]
550286	112	20	25	0,5	50	30	1133

#### Design:

The collet attachment with a diameter of 112 mm is suitable for the AMF zero-point hydraulic clamping modules KH20 (Order no. 428425) and BH20 (Order no. 534412) with indexing. The collet is made from anodised, high-strength aluminium.

#### Application:

The collet attachment is placed on the AMF Zero Point clamping system size KH20 or BH20 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	20	190

#### Design:

- The mounting set includes:
- 1 pull-stud size 20, design: sword
  - 1 captive screw size 20
  - 1 lock nut M12
  - 2 indexing notches, 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 20.



**Collet attachment for clamping module KH20 and BH20, hydr.**  
6370ZSZ-112

**Mounting kit for collet attachment**  
6370ZSB

**Assembly element K20, hydraulic, with indexing**  
6210IH



Subject to technical alterations.



Subject to technical alterations.



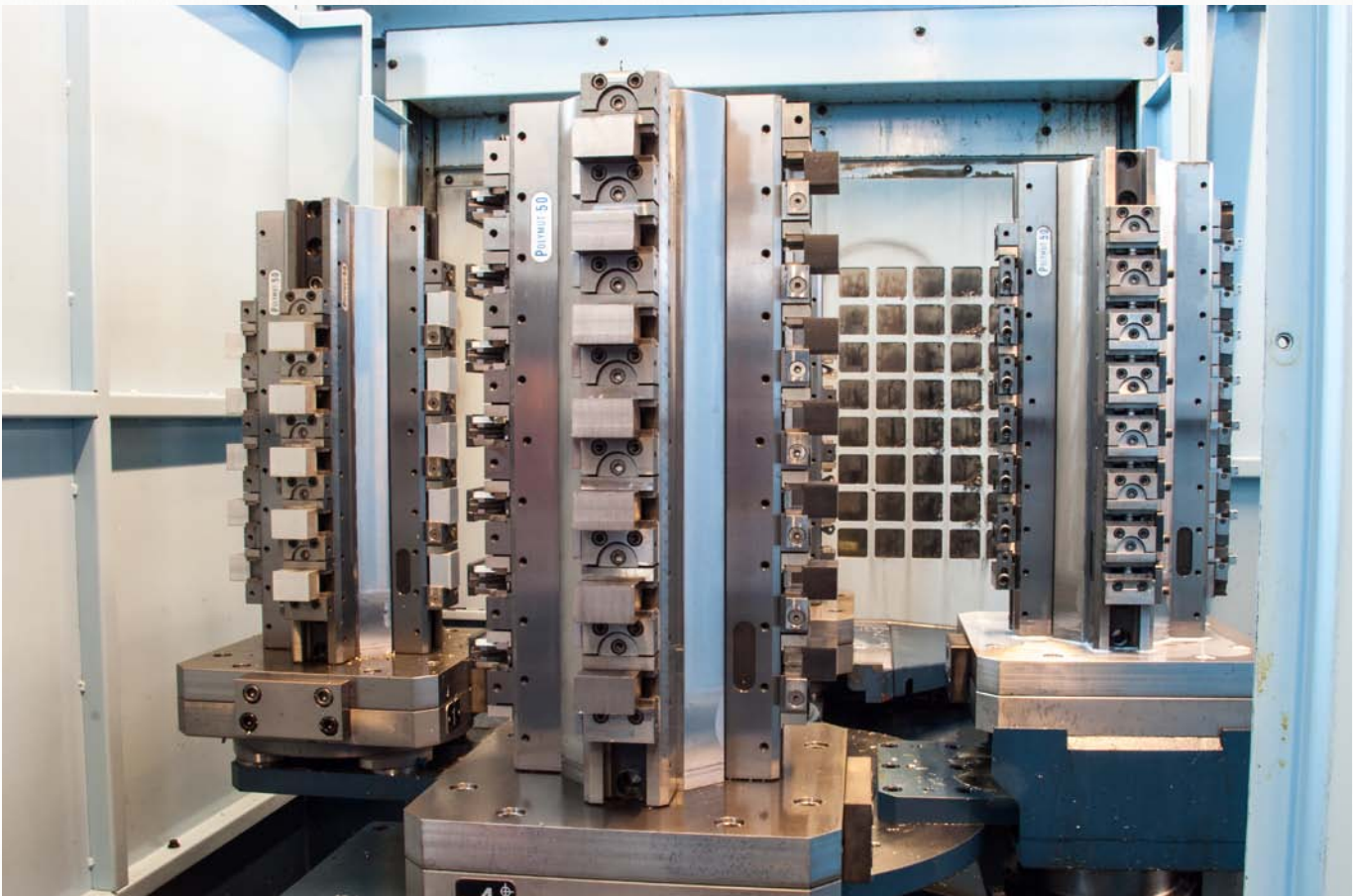


- + Outstanding price-performance ratio
- + Drastically reduced tooling time
- + Immediate improvement of productivity
- + Repeat accuracy < 5um
- + Stainless steel
- + Form fit

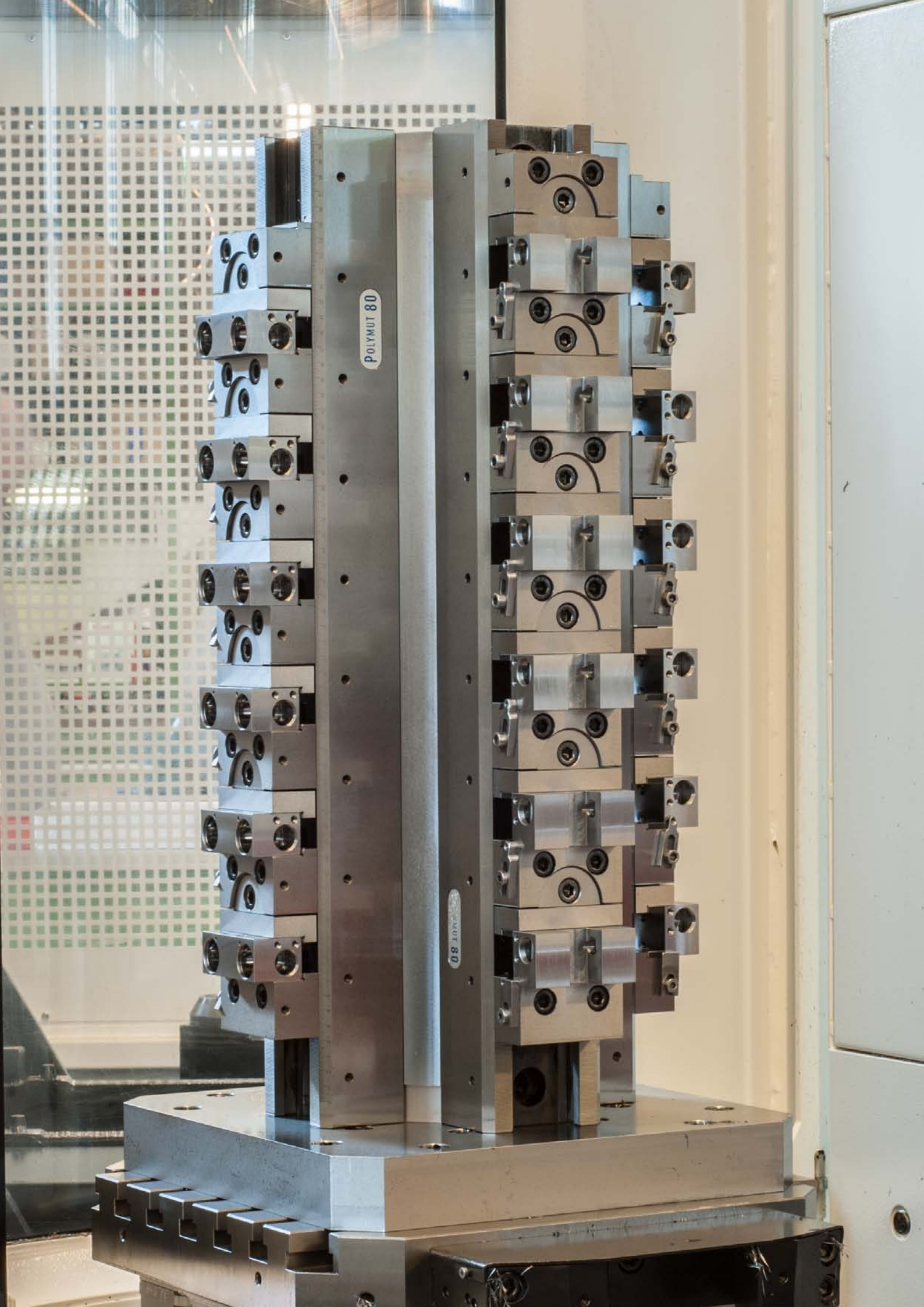


Subject to technical alterations.







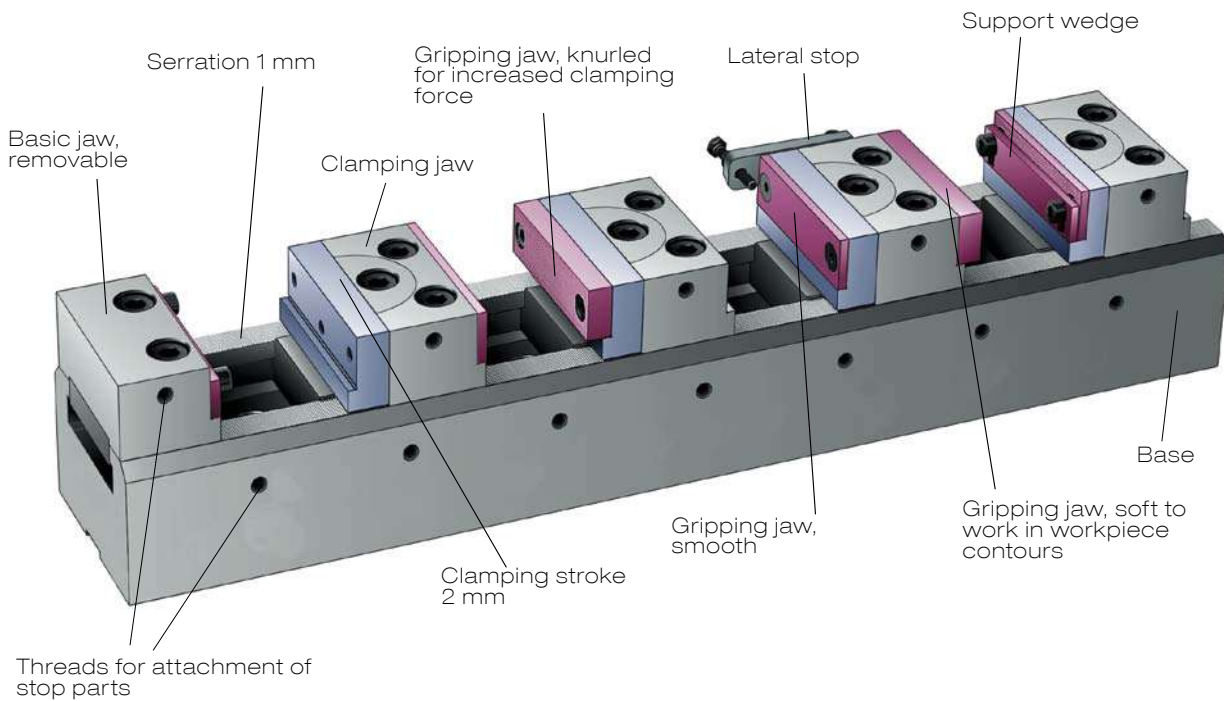


POLYMUT 80

POLYMUT 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, <b>max. 25 Nm</b>	2 x M6, <b>max. 20 Nm</b>
80	2 x M10, <b>max. 30 Nm</b>	2 x M10, <b>max. 30 Nm</b>

## 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:

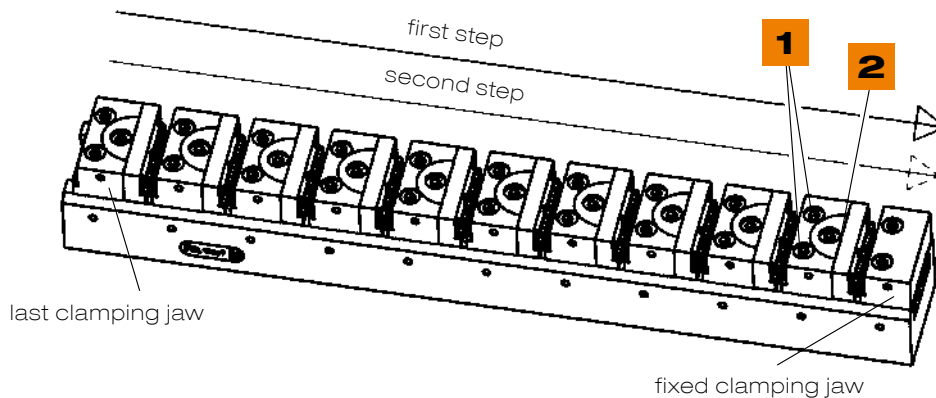
Then tighten the clamping bolt with a torque wrench (pay attention to the diagrams shown below).  
Also always start at the last clamping jaw.

### NOTE:

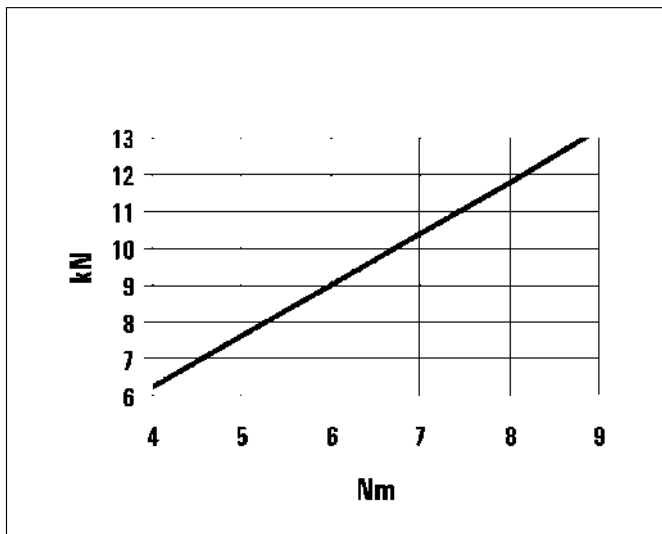
Recommended lubricant for the clamping screws of the jaws and the cone: **Molykote TP42**

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

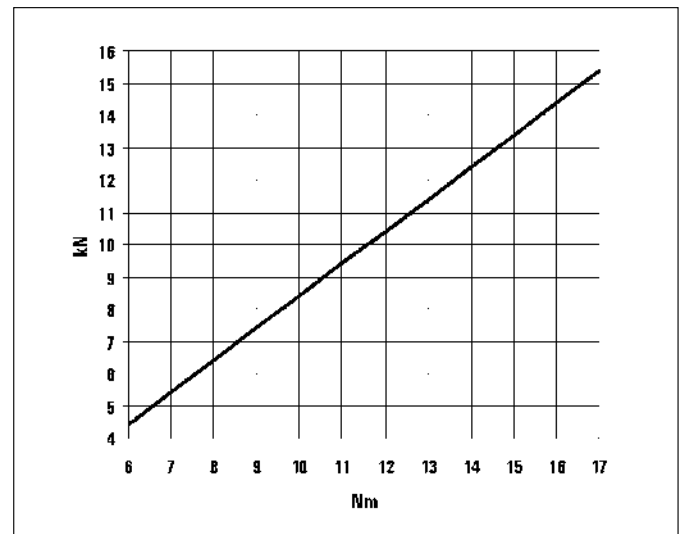
1. For fitting diameter 16F7 with thread M12 = Order No. 78006
2. For fitting diameter 22F7 with thread M16 = Order No. 78238



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

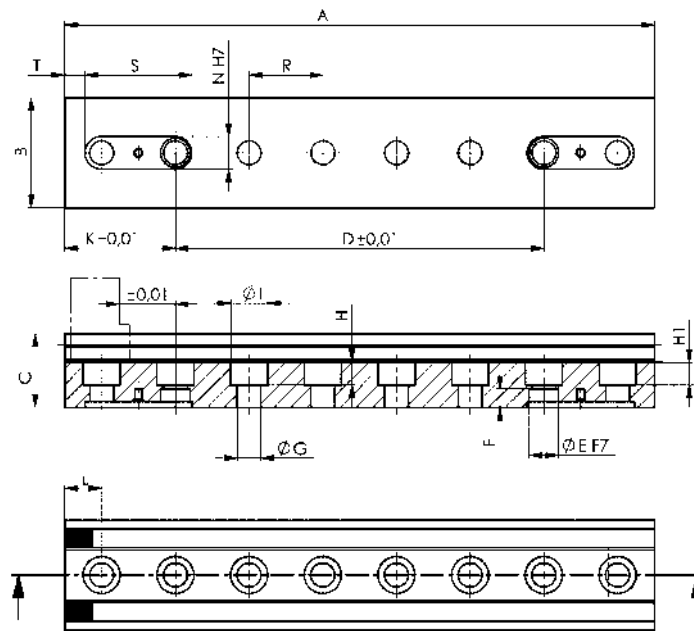
Jaw width 80 mm.

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. EF7	F	dia. G	H	H1	dia. I	K	L	NH7	R	S	T
304873	50-250-040	250	60	40	120	16	10	13	12,5	12,5	19	65	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	360	16	10	13	12,5	12,5	19	70	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	125	45	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. EF7	F	dia. G	H	H1	dia. I	K	L	NH7	R	S	T
304774	80-350-040	350	90	60	200	16	13	13	12,5	12,5	19	75	35	18	40	58	26
304824	80-500-040	500	90	60	360	16	13	13	12,5	12,5	19	70	30	18	40	58	21
304790	80-600-040	600	90	60	400	16	13	13	12,5	12,5	19	100	20	18	40	58	51
304840	80-650-040	650	90	60	400	16	13	13	12,5	12,5	19	125	45	18	40	58	76
304816	80-700-040	700	90	60	400	16	13	13	12,5	12,5	19	150	30	18	40	58	101

Order no.	Size	A	B	C	D	dia. EF7	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	350	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

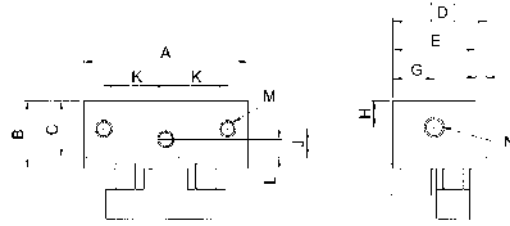
## No. 6371

### 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

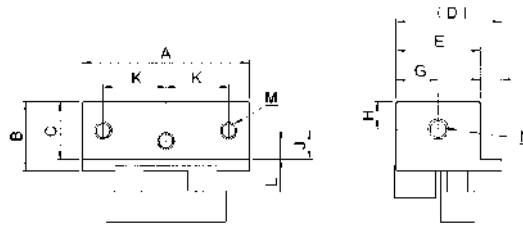
## No. 6371

### 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	10	11,0	31,5	6,0	3xM6	2xM6

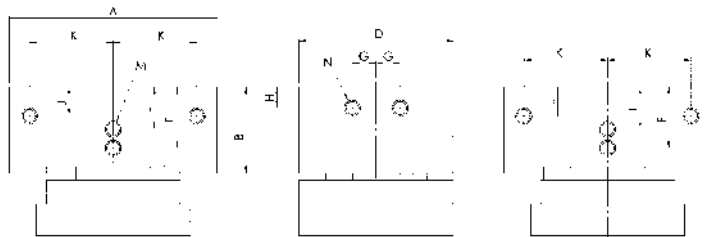
## No. 6371

### 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	20,3	32	-	0	8	8,5	18,5	11,5	6xM5	2xM6
304956	80107-80	78	32,5	50	23	9	10	11,0	31,5	16,0	8xM6	4xM6

Subject to technical alterations.

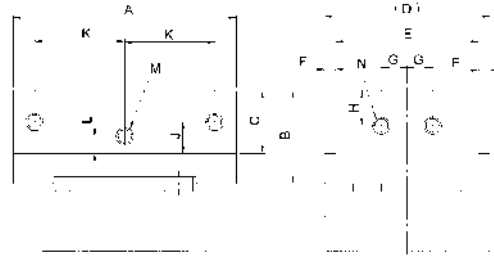
## No. 6371

### 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

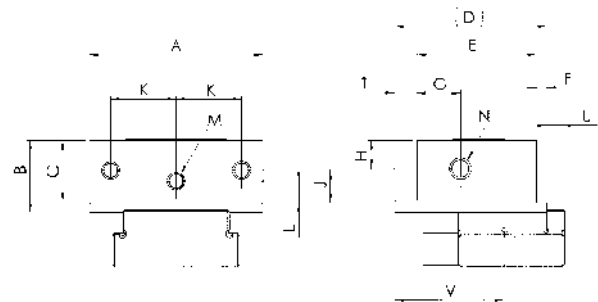
## No. 6371

### 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

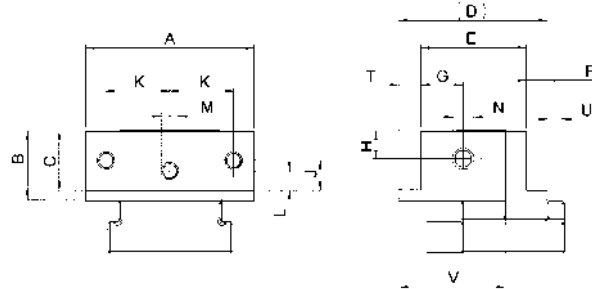
Subject to technical alterations.

## 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:

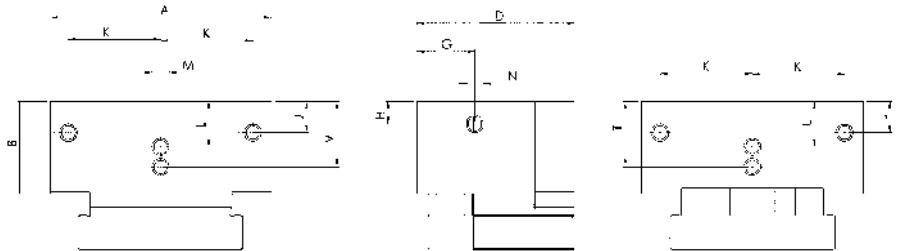
Order no.	Size	A	B	C	D	E	F	G	H	J	K	L	M	N	T	U	V
300863	4109-50	49	20,0	17	43	30,7	6	12,4	8	8,5	18,5	5,5	6xM5	2xM6	6,3	5	31
300889	4119-80	78	32,2	22	64	48,0	8	19,0	8	11,0	31,5	6,0	6xM6	2xM6	8,0	7	46

## 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	13,2	8	8,5	18,5	11,5	7xM5	2xM6	-	17,5
304998	80101-80	78	32,5	55,5	20,5	10	11,0	31,5	16,0	8xM6	2xM6	23	23,0

Subject to technical alterations.

## No. 6371

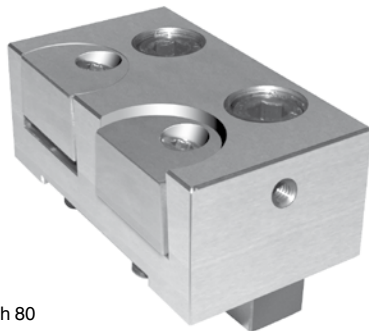
### Clamping jaw, with crescent

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

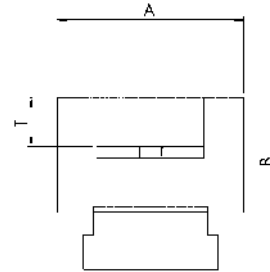
Order no.	Size	for jaw width	Clamping force [kN]	Clamping stroke [mm]	Weight [g]
305011	50110-50	50	12	1,4	280
305037	80110-80	80	15	1,4	1000



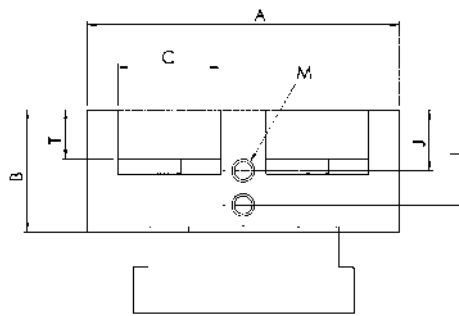
jaw width 50



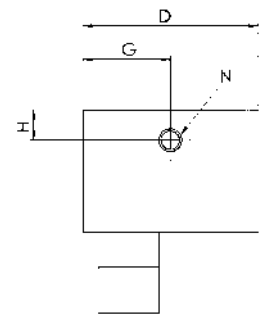
jaw width 80



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



Subject to technical alterations.

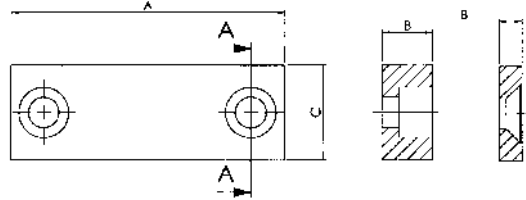
## No. 6371

### 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



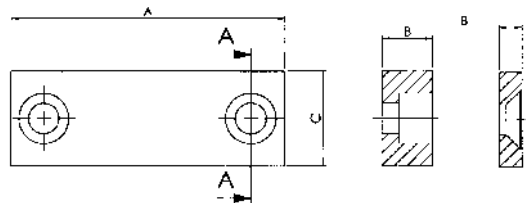
## No. 6371

### 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



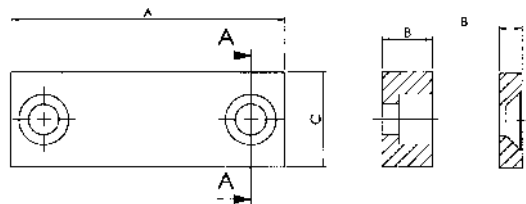
## No. 6371

### Gripping jaw, serrated

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



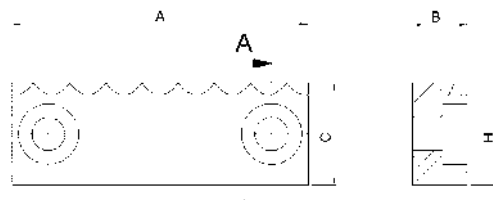
## No. 6371

### 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 x 20	49	9	17	15	70
305094	100-80-12	80	M6 x 20	78	12	22	19	150

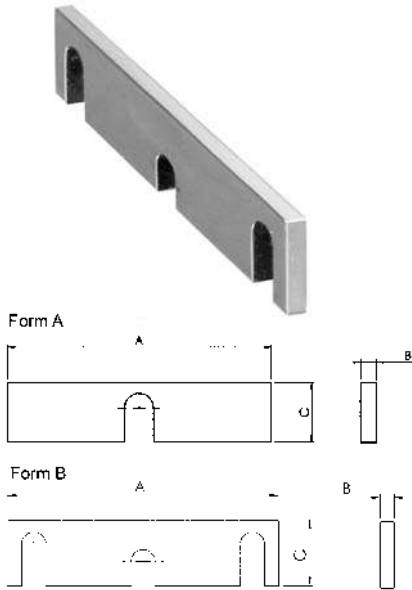


Subject to technical alterations.



## 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	17	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

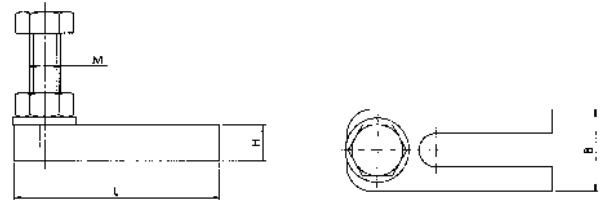
## No. 6371

### 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



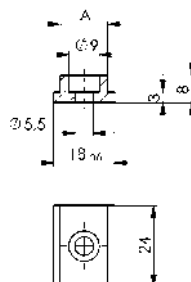
Order no.	Size	for jaw width	Weight [g]
300939	4221-50	50	19
300954	4390-80	80	43

## No. 6371

### T-nut



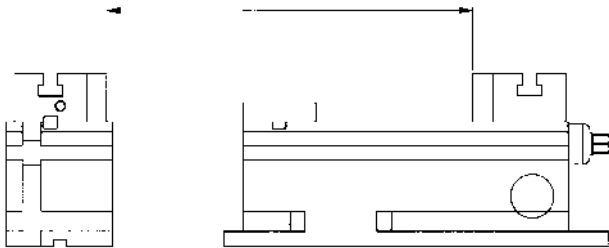
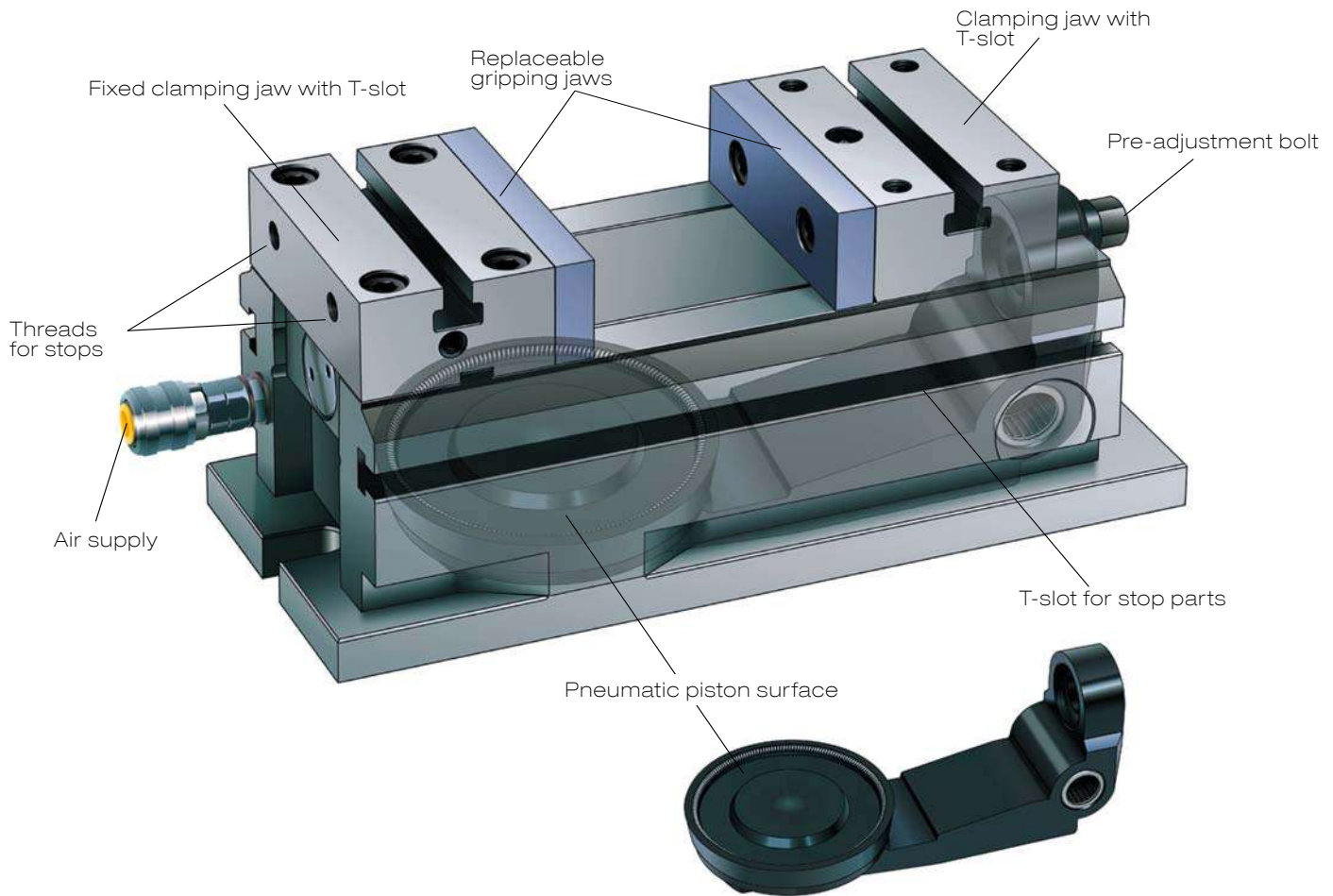
Order no.	Size	A	Weight [g]
301010	9010-10	10	16
301036	9012-12	12	17
301051	9014-14	14	18
301077	9018-18	18	23



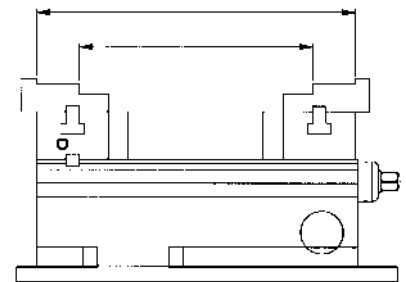
Subject to technical alterations.

## 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  $\pm 0.01$  mm.
- > With 4 slots, locators, gauges and special jaws can be easily attached.



Vice with modular carrier



Vice with stepped gripping jaw

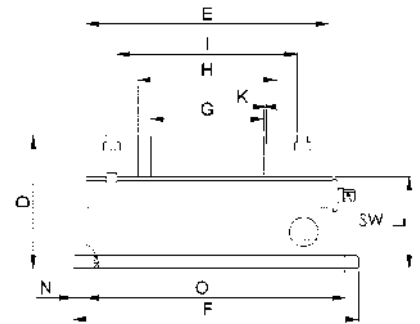
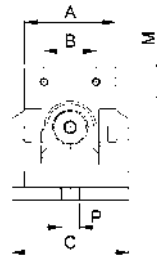
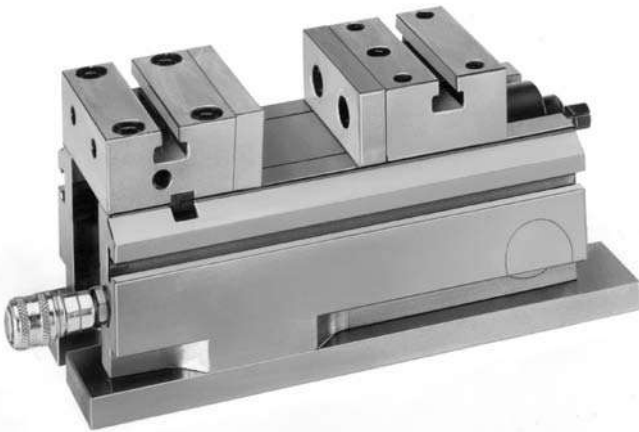
## No. 6372

### 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	2,0	70	M6	10,0	200	14	8
301101	44	112	128	241	288	103	133	177	4,0	92	M8	20,0	248	18	14
301127	46	128	145	260	317	86	116	178	4,0	105	M10	20,0	277	18	14
301143	60	140	145	295	340	112	147	211	3,2	105	M10	20,0	300	18	17
301168	65	160	155	315	370	127	163	229	3,5	110	M10	20,0	330	18	17
301184	80	196	160	368	403	164	200	272	4,0	115	M10	18,5	366	18	17
301200	100	236	195	475	480	235	275	361	4,5	135	M12	20,0	440	18	17



Subject to technical alterations.

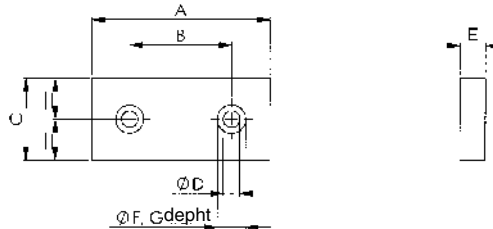
## No. 6372

### Gripping jaw, smooth

Hardened 60 HRC.



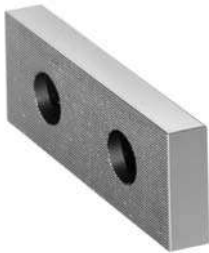
Order no.	Size	A	B	C	dia. D	E	dia. F	G	Weight [g]
301176	4048-E070	70	40	32	7,0	10	11	6,5	232
301192	4041-E090	90	44	36	9,0	15	14	9,0	352
301218	4042-E100	100	46	40	11,0	15	17	11,0	423
301234	4043-E115	115	60	40	11,0	15	17	10,5	493
301259	4044-E130	130	65	45	11,0	18	17	11,0	771
301275	4045-E160	160	80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



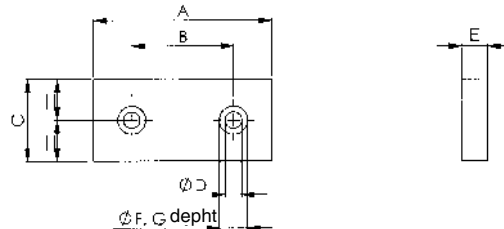
## No. 6372

### Gripping jaw, serrated

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	10,5	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



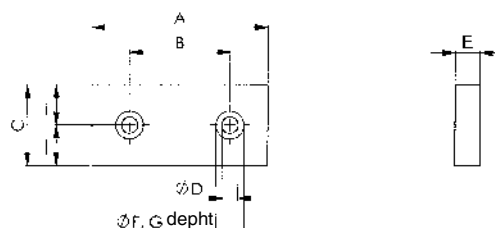
## No. 6372

### 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	9,0	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	10,5	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.

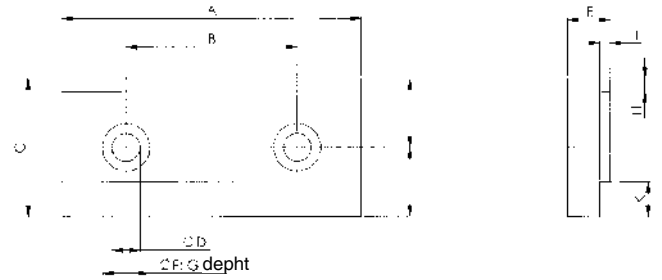
## No. 6372

### 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	18	19	13,0	6	4	16	1661



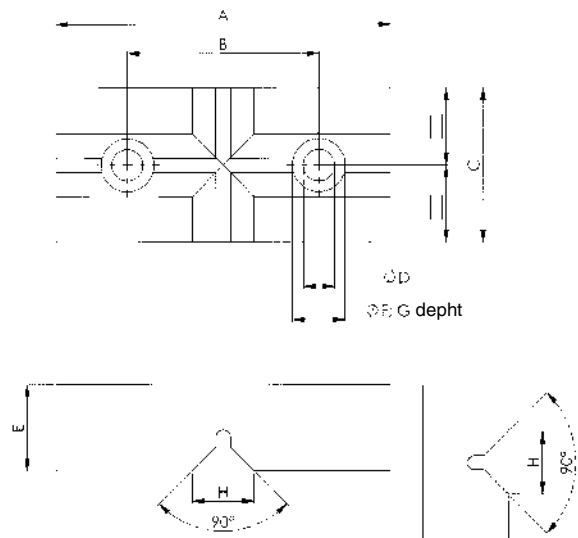
## No. 6372

### Gripping jaw, V-block

Hardened 60 HRC.



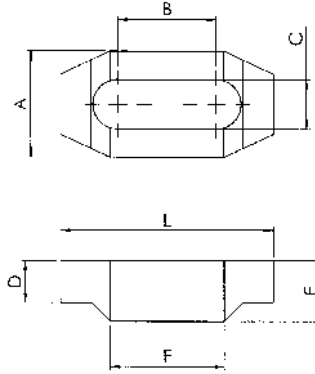
Order no.	Size	A	B	C ±0.01	dia. D	E ±0.01	F	G	H	Weight [g]
301515	4054-E070	70	40	32	7,0	18	11,0	14	13,3	262
301531	4013-E090	90	44	36	9,0	26	14,0	20	20,3	532
301556	4014-E100	100	46	40	10,5	28	17,0	22	20,3	708
301572	4015-E115	115	60	40	11,5	28	17,5	22	20,3	822
301598	4016-E130	130	65	45	11,0	28	17,0	22	20,3	1079
301614	4017-E160	160	80	45	11,5	28	17,5	21	24,3	1296
301630	4018-E200	200	100	60	13,0	28	19,0	22	23,8	2260



## No. 6372

### Double-ended clamp

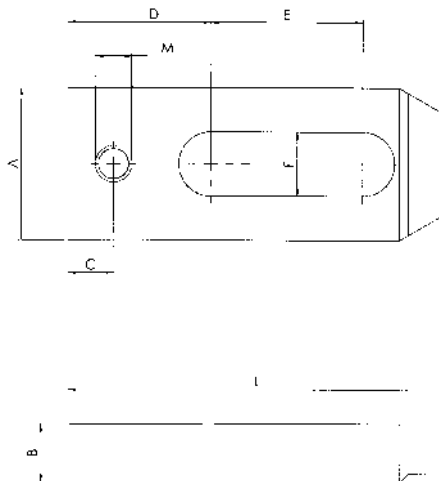
Order no.	Size	A	B	C	D	E	F	L	Weight [g]
301804	5003-E070-E090	28	26	13	11	16	30	56	135
301796	5001-E100-E200	38	30	17	16	18	34	60	226



## No. 6372

### Straight clamp

Order no.	Size	A	B	C	D	E	F	G	L	M	Weight [g]
301846	5006-E070-E090	26	16	12	33	25	13	11	87	12	278
301820	5002-E100-E200	40	19	13	40	33	17	16	98	12	524

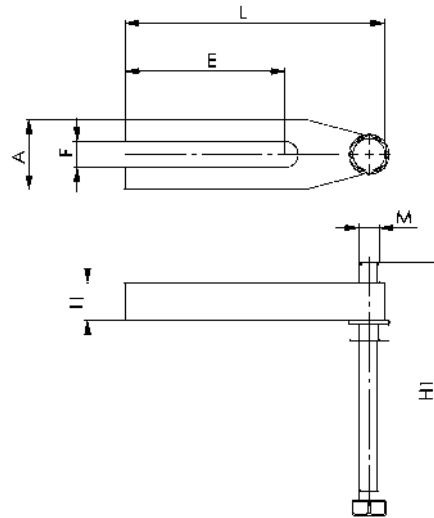




## No. 6372

### Stop

Order no.	Size	A	C	E	F	H	H1	L	M	Weight [g]
301861	5005	35	8	80	13	15	126	130	M10	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	6680
429050	50x400	50	25	13	80	10	26	400	M12	5,5	50	150	9050
429076	80x400	80	25	13	80	10	26	400	M12	5,5	50	150	16480
429092	50x500	50	25	13	80	10	26	500	M12	5,5	50	200	11430
429118	80x500	80	25	13	80	10	26	500	M12	5,5	50	200	20780
429134	80x600	80	25	13	80	10	26	600	M12	5,5	50	250	24950

### 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 pull-stud size 20.

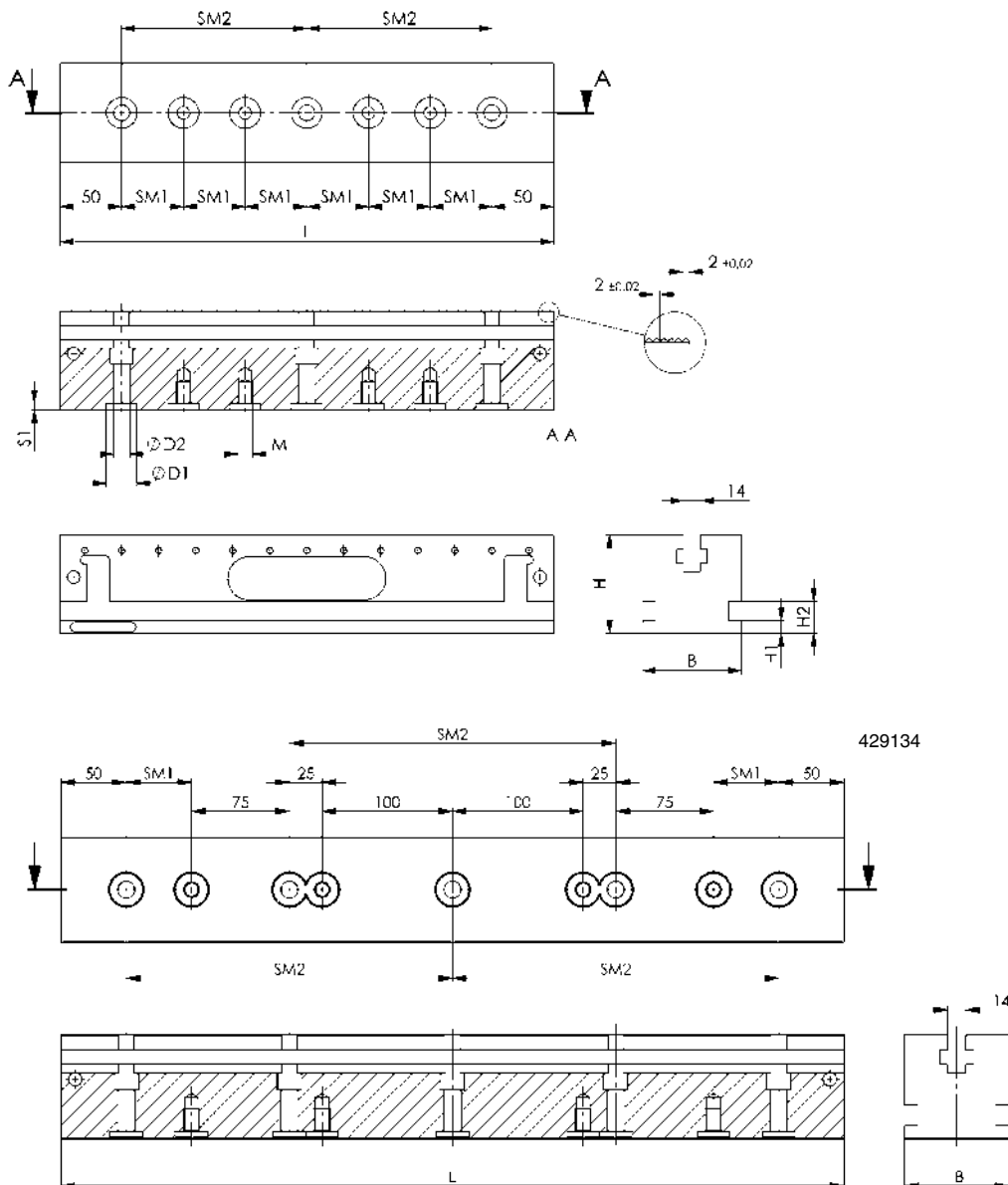
Other mounting holes, for example pull-stud size 10 or size 40, can be supplied any time on request. Positioning steps on the clamping rail grating is possible at intervals of 2 mm.

### 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.



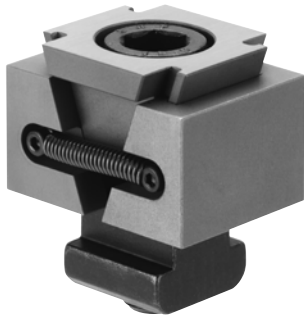
Subject to technical alterations.



## No. 6376K

### Wedge clamp, smooth

With fastening bolt and T-nut.



Order no.	Size	A min.	A max.	B	H min.	H max.	L	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429506	30	43,5	51,0	30	22	29,5	44	65	30	300
429522	40	43,5	51,0	40	22	29,5	44	65	30	380
429548	50	43,5	51,0	50	22	29,5	44	65	30	450
429563	72	46,5	57,5	72	29	39,0	44	65	30	865

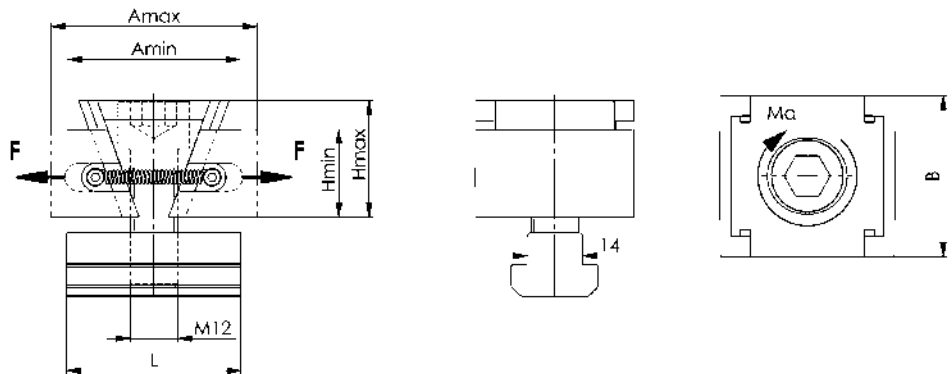
#### Design:

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

With fastening bolt and T-nut.



Order no.	Size	A min.	A max.	B	H min.	H max.	L	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429589	30	43,5	51,0	30	22	29,5	44	65	30	300
429605	40	43,5	51,0	40	22	29,5	44	65	30	378
429621	50	43,5	51,0	50	22	29,5	44	65	30	448
429647	72	46,5	57,5	72	29	39,0	44	65	30	855

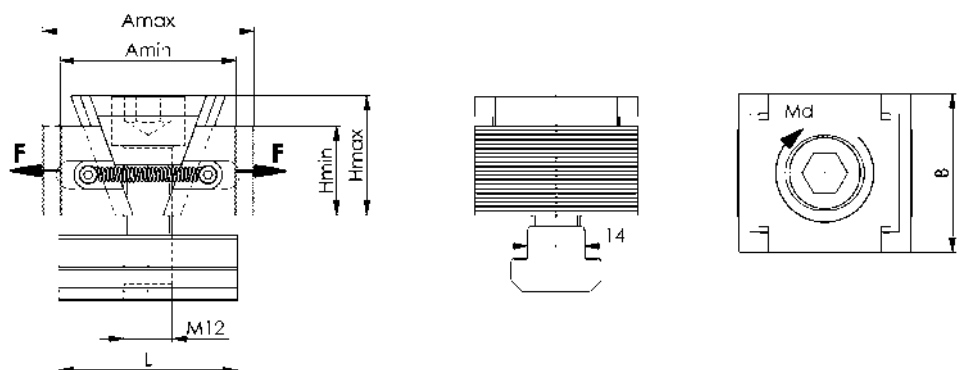
#### Design:

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.



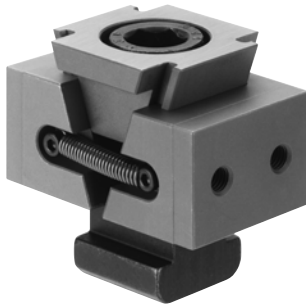
Subject to technical alterations.



## No. 6376KW

### Wedge clamp with measurement

With fastening bolt and T-nut.



Order no.	Size	A min. *	A max. *	B	B1	G	H min.	H max.	H1	L	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429662	30	53,5	61,5	30	15	M5	22	29,5	11,0	44	65	30	350
429688	40	53,5	61,5	40	20	M5	22	29,5	11,0	44	65	30	490
429704	50	53,5	61,5	50	25	M5	22	29,5	11,0	44	65	30	535
429373	72	56,5	68,0	72	36	M6	29	39,0	14,5	44	65	30	1020

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

### Design:

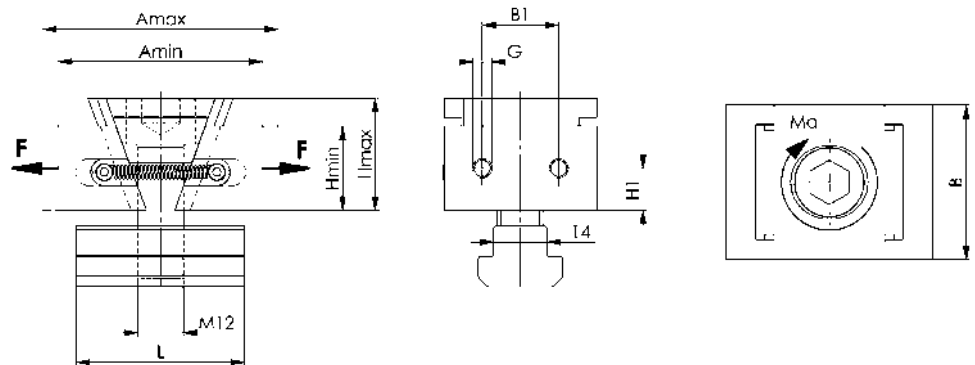
Material: case-hardened steel 21MnCr5

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.

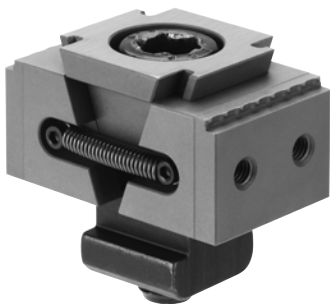


## No. 6376KK

### Wedge clamp

With claw jaws, 2 mm lower clamping step.

With fastening bolt and T-nut.



Order no.	Size	A min.	A max.	B	B1	G	H min.	H max.	H1	H3	L	Md max. [Nm]	Clamping force F [kN]	Weight [g]
429399	30	50	57,5	30	15	M5	22	29,0	11,0	20	44	65	30	350
429415	40	50	57,5	40	20	M5	22	29,0	11,0	20	44	65	30	440
429431	50	50	57,5	50	25	M5	22	29,0	11,0	20	44	65	30	530
429456	72	53	64,0	72	36	M6	29	38,5	14,5	27	44	65	30	1015

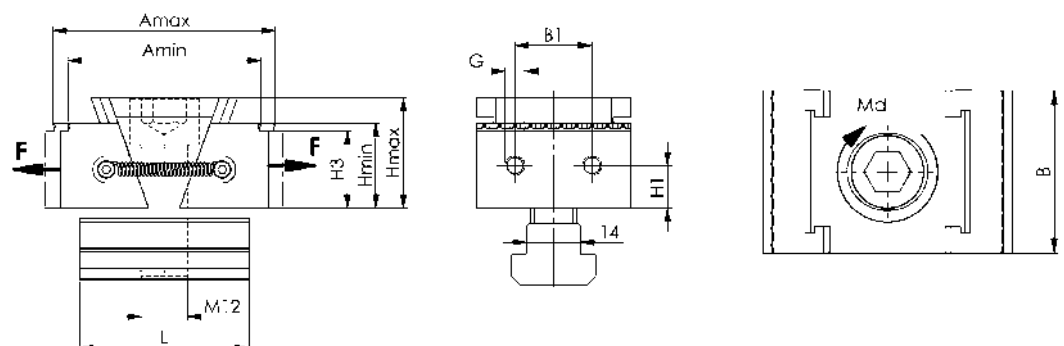
### Design:

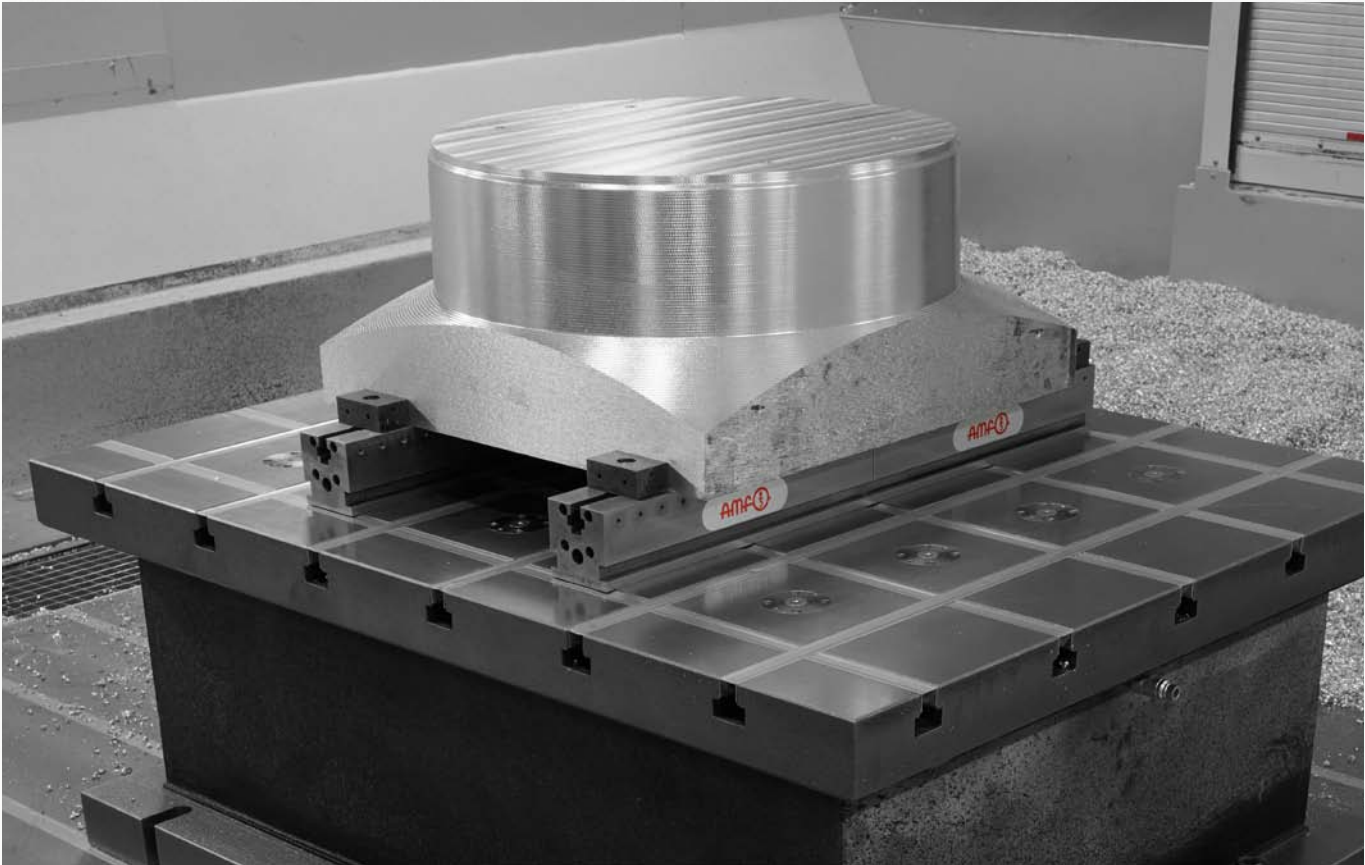
Material: case-hardened steel 21MnCr5

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

### Application:

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





## No. 6376B

### Fixed clamping jaw, smooth

With fastening bolt and T-nut.



Order no.	Size	A	B	B1	G	H	H1	H2	L	Weight [g]
429274	30	42	30	15	M5	22,4	11,4	14,4	22	260
429290	40	42	40	20	M5	22,4	11,4	14,4	22	325
429316	50	42	50	25	M5	22,4	11,4	14,4	22	400
429332	72	42	72	36	M6	29,4	14,9	21,4	44	760

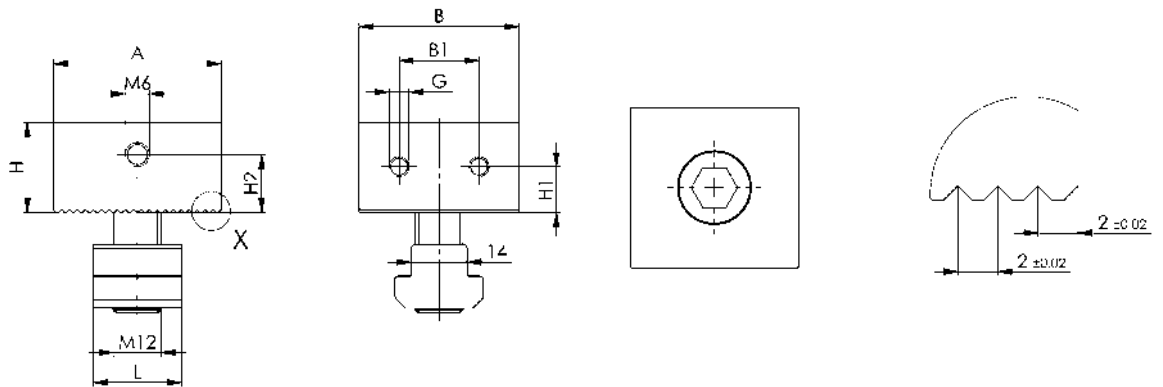
### Design:

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

With fastening bolt and T-nut.



Order no.	Size	A	B	H	H2	L	Weight [g]
429357	30	42	30	22,4	14,4	22	260
429365	40	42	40	22,4	14,4	22	330
429381	50	42	50	22,4	14,4	22	400
429407	72	42	72	29,4	21,4	44	760

### Design:

Material: case-hardened steel 21MnCr5

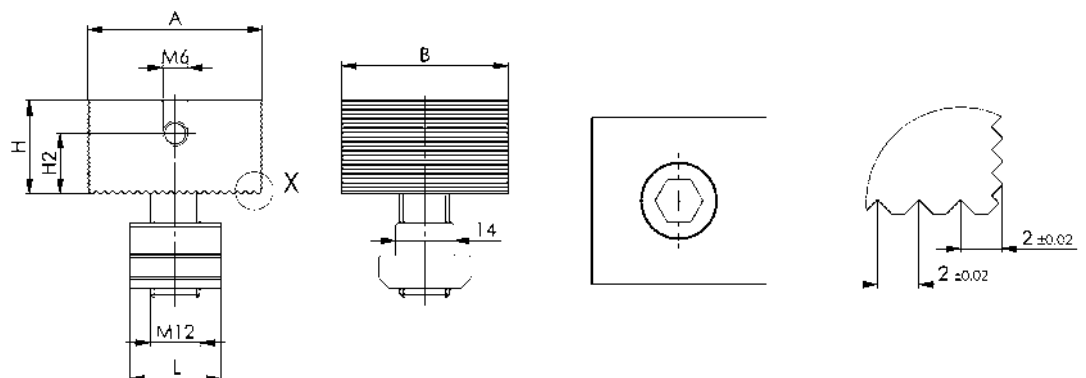
Highly tempered and case hardened to 52 HRC.

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 lower clamping step.  
With fastening bolt and T-nut.



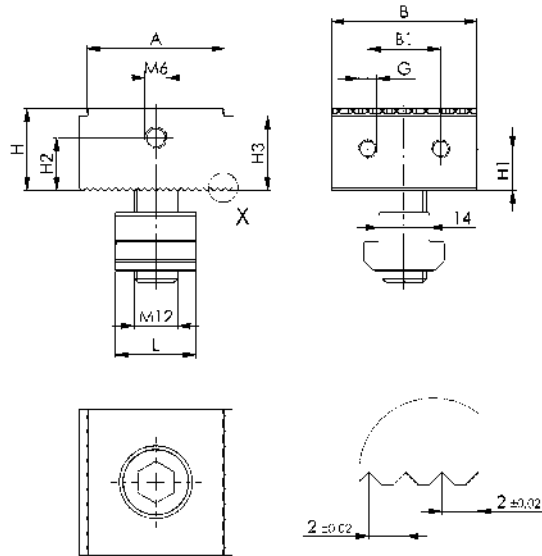
Order no.	Size	A	B	B1	G	H	H1	H2	H3	L	Weight [g]
429423	30	38	30	15	M5	22,4	11,4	14,4	20,4	22	250
429449	40	38	40	20	M5	22,4	11,4	14,4	20,4	22	320
429464	50	38	50	25	M5	22,4	11,4	14,4	20,4	22	392
429480	72	38	72	36	M6	29,4	14,9	21,4	27,4	44	752

### 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 jaws

Complete with fastening bolts.



Order no.	A	B	D	H	H1	L1	L2	Weight [g]
429696	11	50	6	22	25	15	25	36
429712	22	72	7	29	32	21	36	152

### Design:

Aluminium

### Application:

Aluminium front jaws for cutting customised contours.

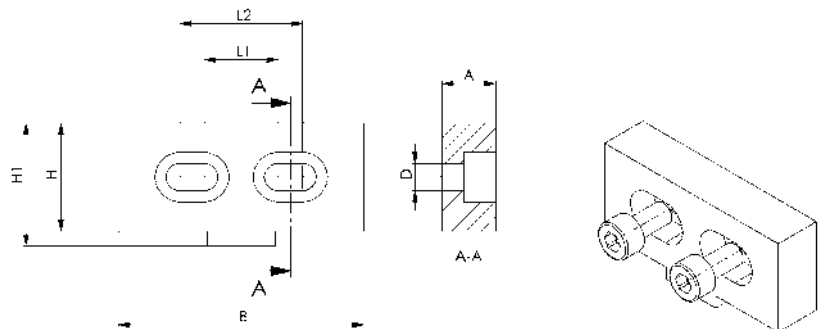
Suitable for:

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

### Stop, flexible

With fastening bolt M6 and adjusting screw M6.

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

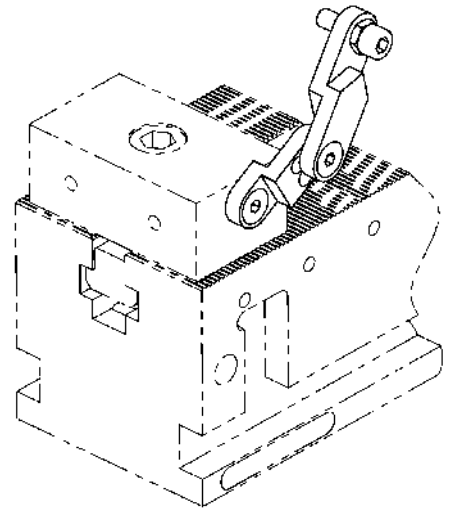
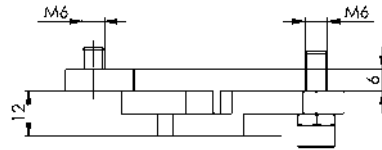
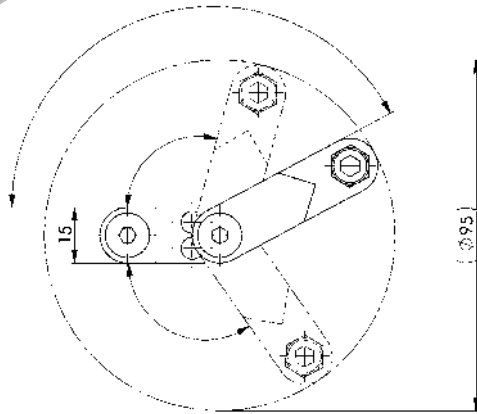
#### Design:

Aluminium

#### Application:

Lateral stop for positioning workpieces.

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



## No. 6376Z

### Stop, fixed

With fastening bolt and disc.

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

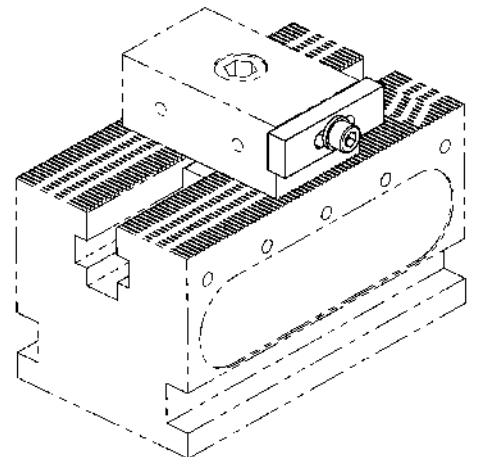
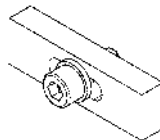
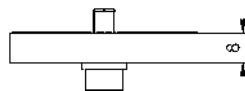
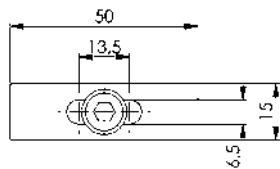
#### Design:

Aluminium

#### Application:

Lateral stop for positioning workpieces.

Stop is screwed to the fixed jaw and can be moved.



## No. 6376Z

### Clamping jaws

4 clamping jaws per packaging unit.  
With fastening bolts and nuts for T-slots.



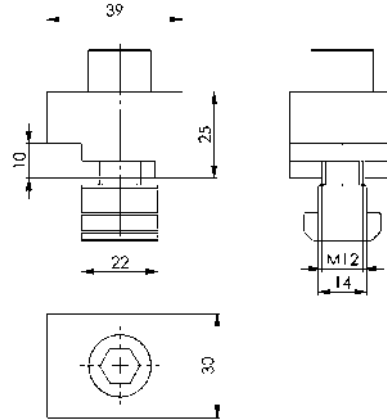
Order no.	For clamping rail	Weight [g]
429258	6376G	1010

#### Design:

Tempered steel, burnished.

#### Application:

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



## No. 6376Z

### Positioning socket



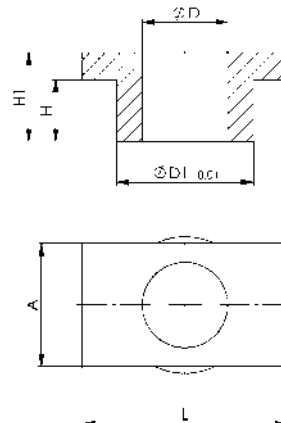
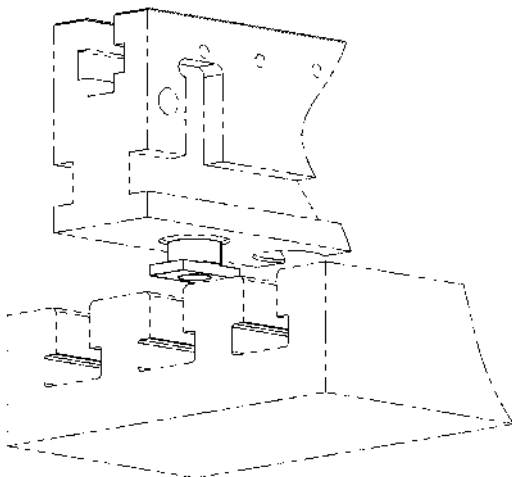
Order no.	A	dia. D	dia. D1	H	H1	L	Weight [g]
429233	18	12,5	20	9	13	30	26
429217	14	12,5	20	9	13	30	23

#### Design:

Tempered steel, burnished.

#### Application:

Positioning socket for simplified orientation of the clamping rail with width 50 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.

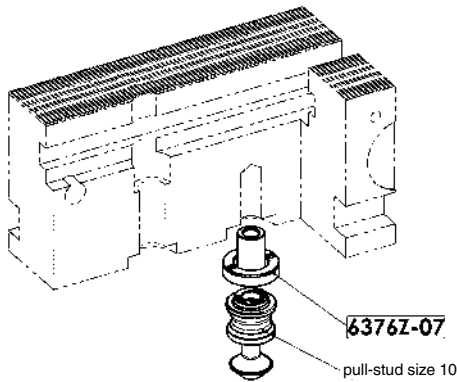


Subject to technical alterations.

## No. 6376Z

### Adapter set for pull-stud size 10

With adapter sleeve and positioning socket.



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

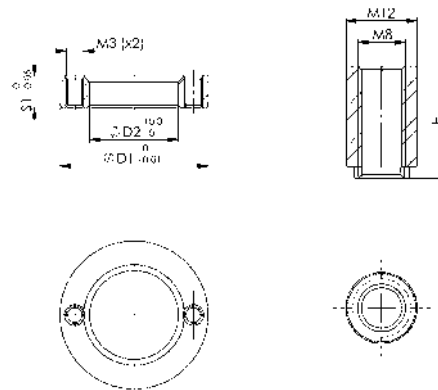
#### Design:

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:

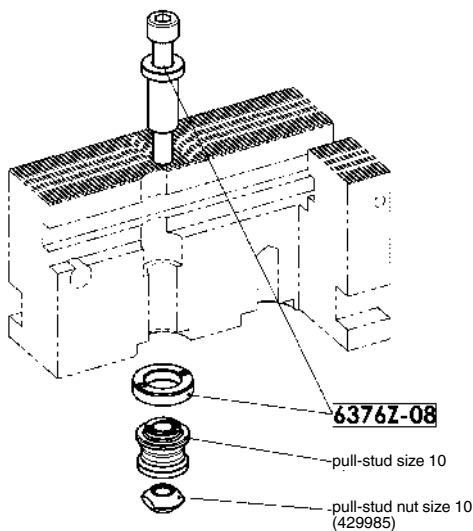
Adapter kit for reducing the locating bore from pull-stud size 20 to size 10.



## No. 6376Z

### Adapter set for pull-stud size 10

With cylinder screw, adapter sleeve and positioning socket.



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:

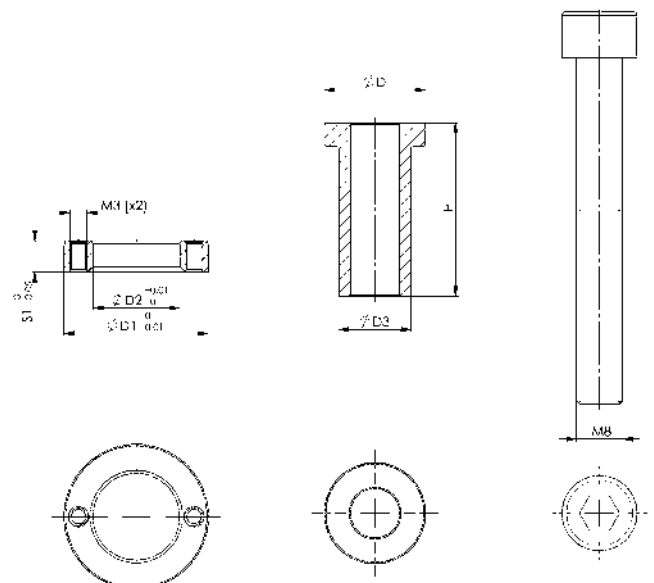
For through-bores in the clamping rail, see Item No. 6376G.

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 kit for reducing the locating bore from pull-stud size 20 to size 10.



Subject to technical alterations.

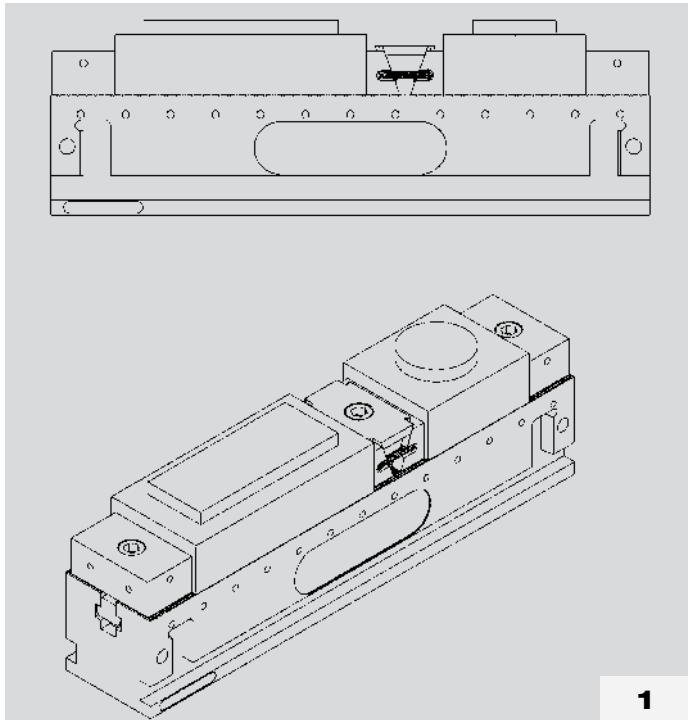


Subject to technical alterations.

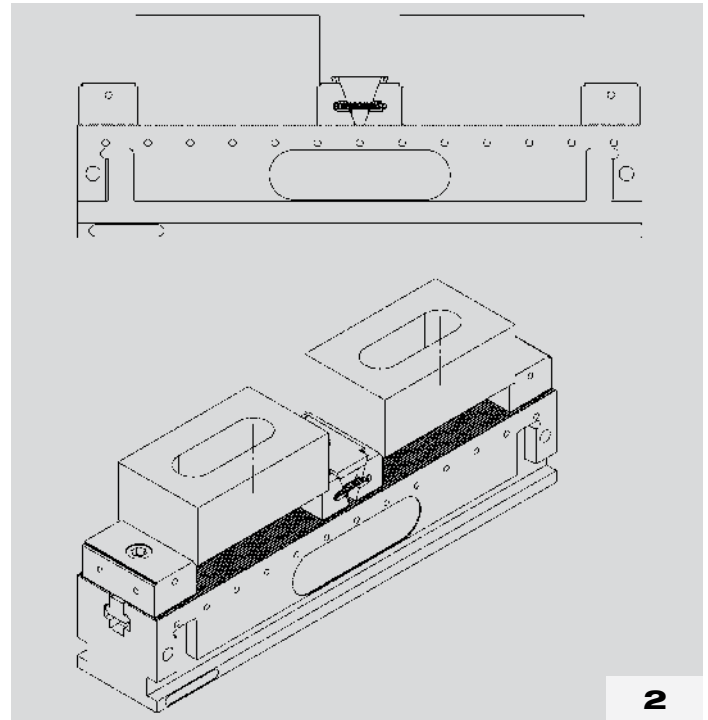


## Application examples

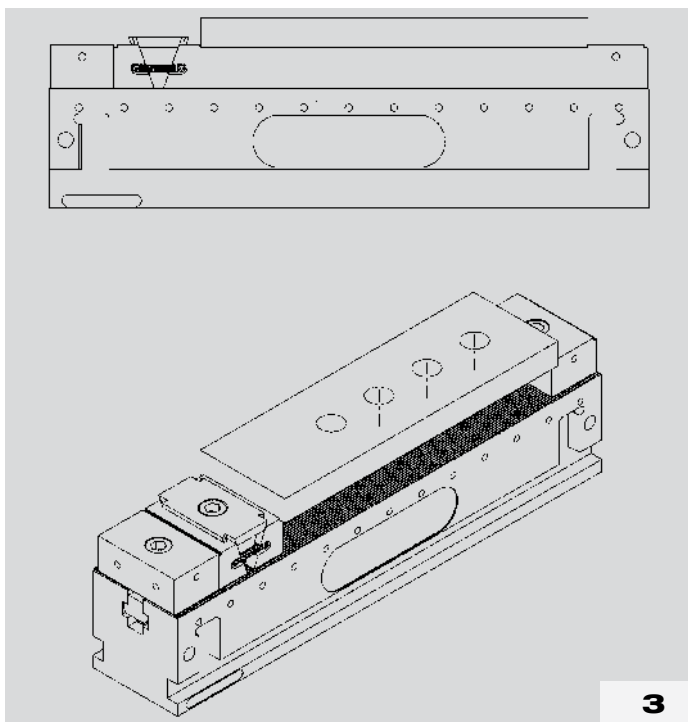
- > **1** clamping of workpieces with smooth clamping jaws
- > **2** clamping of workpieces with claw jaws
- > **3** clamping of a workpiece with claw jaws
- > **4** clamping of dissimilar workpieces with claw jaws



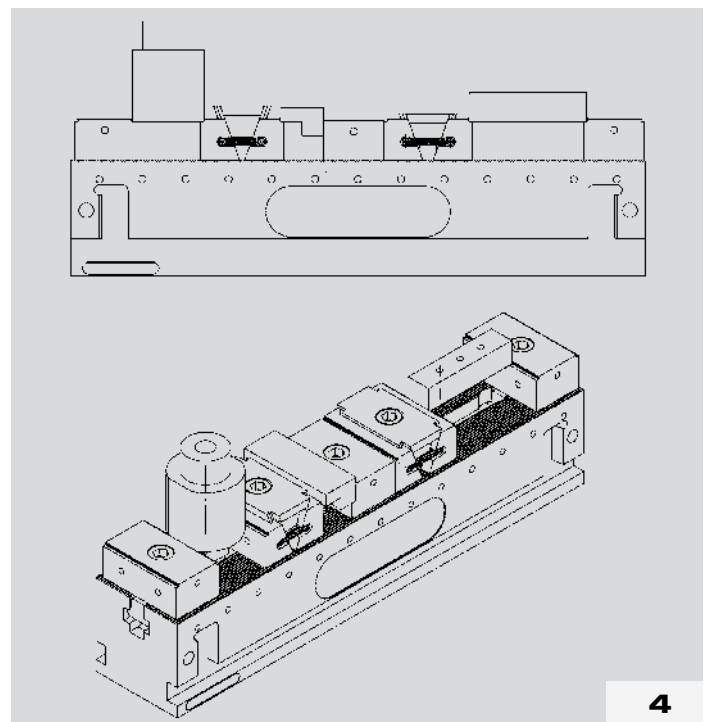
**1**



**2**



**3**



**4**

## No. 6376A

### 5-axis clamp design

Serration top and bottom  
With fastening bolt and T-nut.

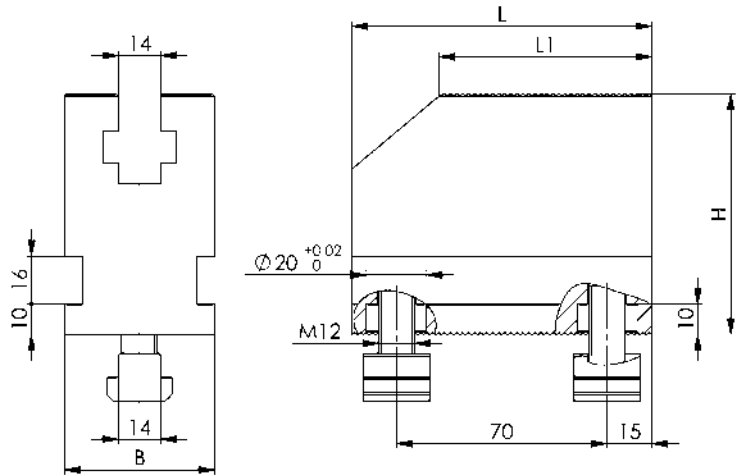
Order no.	Size	B	H	L	L1	Weight [g]
429472	50x100	50	80	100	71	2480
429498	80x100	80	80	100	71	4080

### 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.

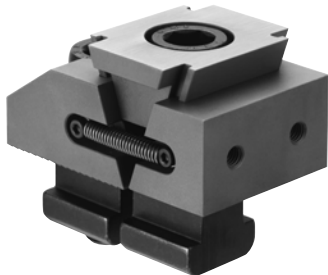


Subject to technical alterations.

## No. 6376KA

### Wedge clamp with fixed jaw, smooth

For 5-axis clamp.  
With fastening bolt and T-nut.



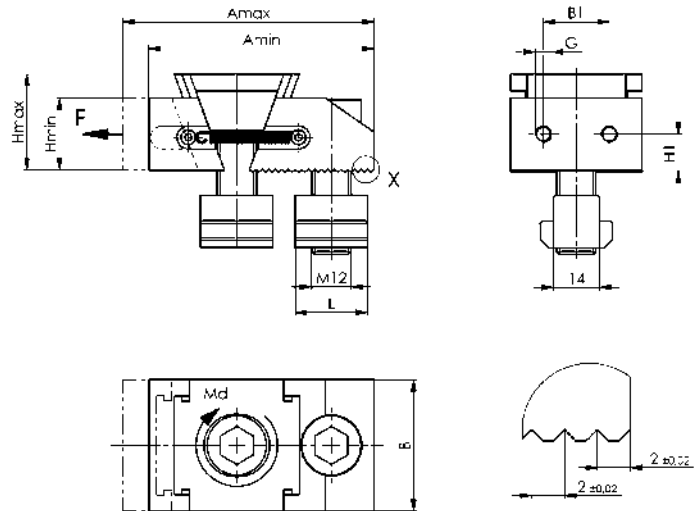
Order no.	Size	A min.	A max.	B	B1	G	H min.	H max.	H1	L	Md max.	Clamping force F	Weight
												[Nm]	[kN]
429514	40	68,5	76,5	40	20	M5	22	29,5	11,0	22	65	30	525
429530	72	65,0	76,0	72	36	M6	29	39,5	14,5	22	65	30	1085

#### 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, claw jaws

For 5-axis clamp, 2 mm lower clamping step.  
With fastening bolt and T-nut.



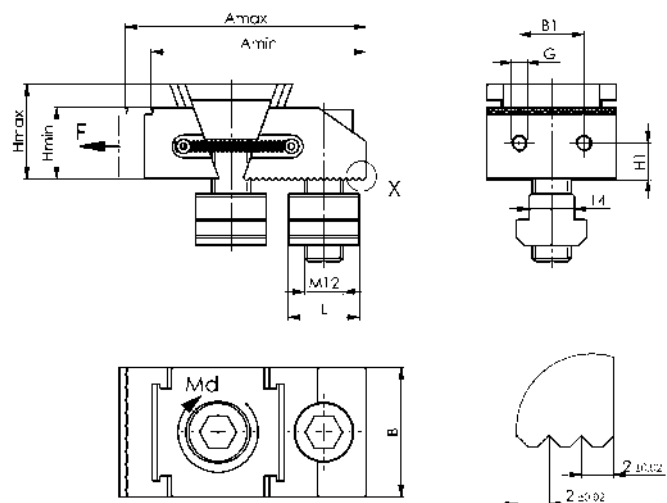
Order no.	Size	A min.	A max.	B	B1	G	H min.	H max.	H1	L	Md max.	Clamping force F	Weight
												[Nm]	[kN]
429613	40	66,5	74,5	40	20	M5	22	29,5	11,0	22	65	30	525
429639	72	63,0	74,0	72	36	M6	29	39,5	14,5	22	65	30	1085

#### 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. 6376BA

### Fixed clamping jaw, smooth

For 5-axis clamp.  
With fastening bolt and T-nut.



Order no.	Size	A	B	B1	G	H	H1	H2	L	Weight [g]
429555	40	42	40	20	M5	22,4	11,4	15,4	22	280
429571	72	42	72	36	M6	29,4	14,9	21,4	44	675

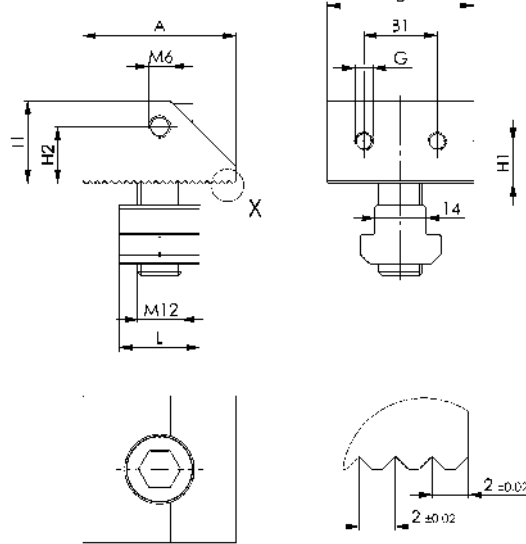
### Design:

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 with claw jaws

For 5-axis clamp, 2 mm lower clamping step.  
With fastening bolt and T-nut.



Order no.	Size	A	B	B1	G	H	H1	H2	H3	L	Weight [g]
429654	40	40	40	20	M5	22,4	11,4	15,4	20,4	22	278
429670	72	40	72	36	M6	29,4	14,9	21,4	27,4	44	668

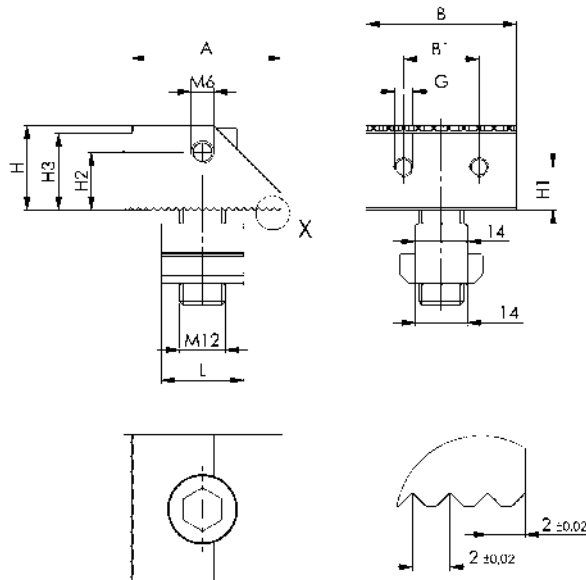
### Design:

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.



## No. 6540

### Chain clamping set

Hook end and counterholder made of tempered steel, burnished.  
Chain made of tempered steel.

Please order fastening for T-slots 6541 separately.

Consisting of:

- hook end
- protection set for clamp chain
- counterholder
- 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 cotter pins for connection
- 6 plastic protective elements
- open ring spanner 685Md



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

### Application:

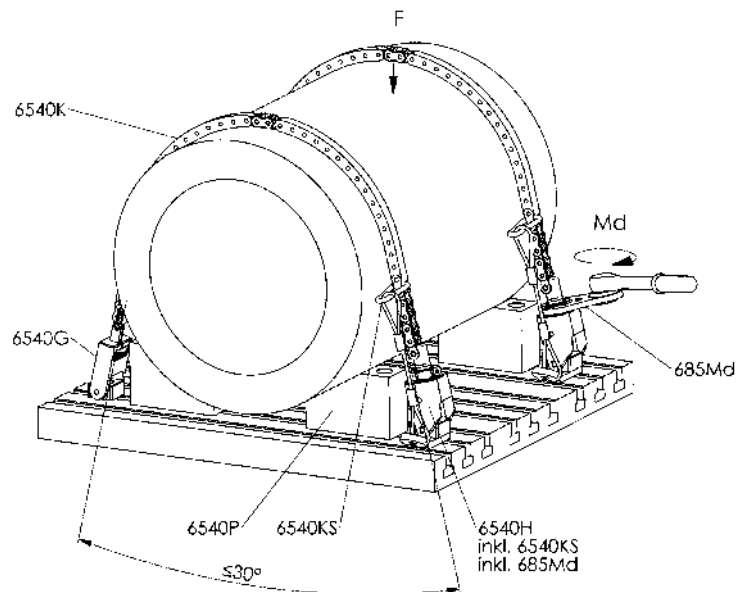
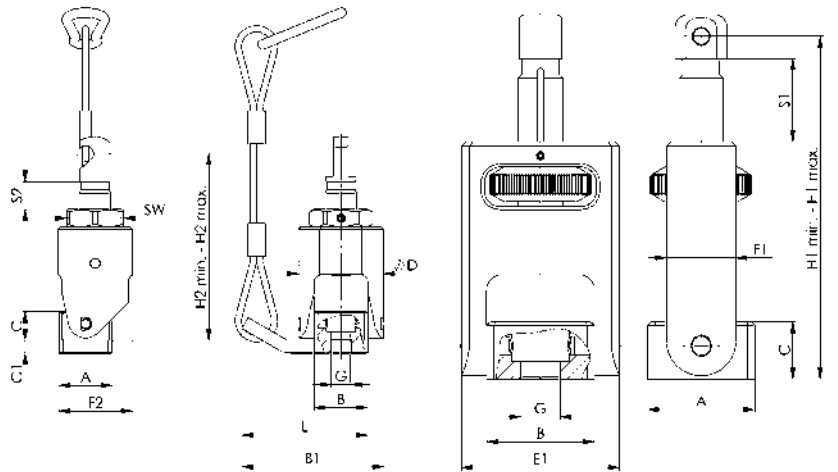
Mainly used for clamping cylindrical parts, such as valve bodies, flanges, pump housings, pistons etc. this device can be used both on machine tables and on clamping pallets. Initial selection of the chain length and setting clamping force is carried out at the take-up unit by turning the knurled nut. 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:

Installation exclusively with the AMF fastening kit 6541 for hook ends and the protection set 6540K.  
For larger clamping tasks, the hook ends, counter catches and clamp chains of size 20 and 24 can be used.



CAD



### Dimensions:

Order no.	A	B	B1	C	C1	dia. D	E1	F1	F2	H1 min.	H1 max.	H2 min.	H2 max.	Clamping stroke S1	Clamping stroke S2	L	SW
87601	34	34	90	18	8	54	50	21	47	83	108	100	118	25	18	80	36
87627	37	44	120	25	10	70	64	29	62	110	146	122	153	36	31	107	46

Subject to technical alterations.

## No. 6540H

### Hook end, mechanical

Tempered steel, burnished.

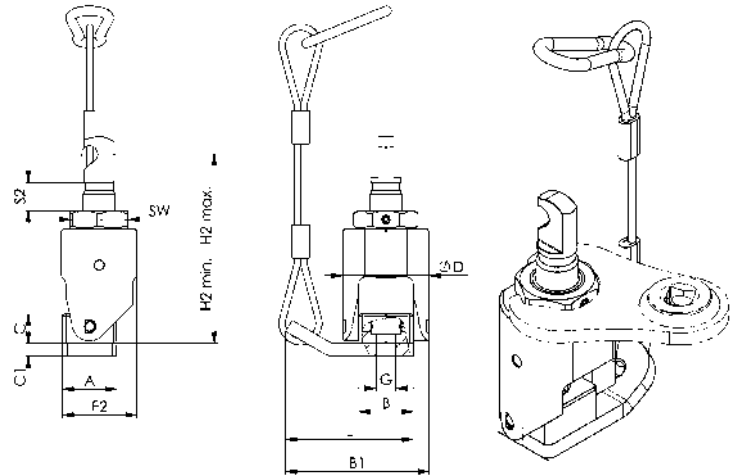
Including protection set 6540KS and corresponding ring spanner 685Md.



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

### Note:

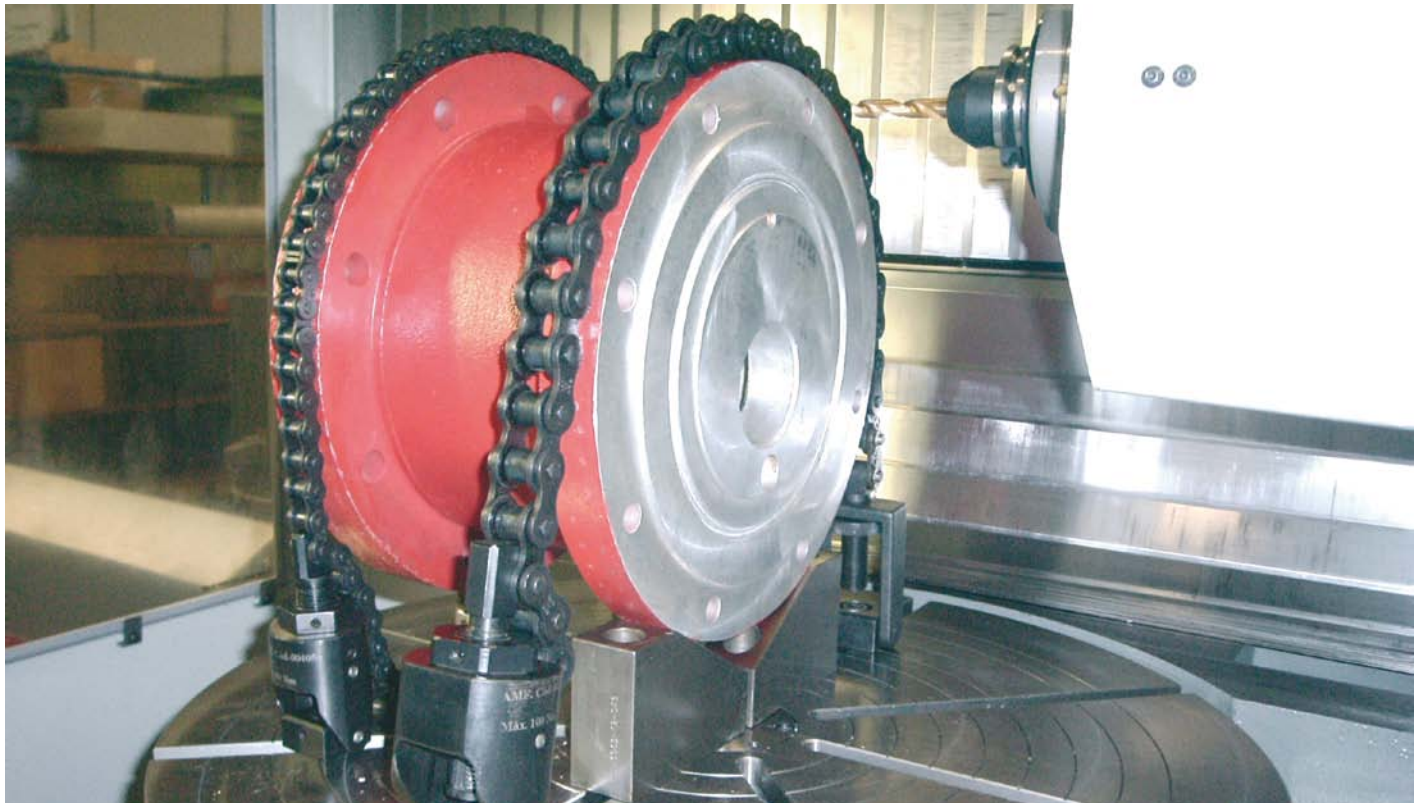
Installation exclusively with the AMF fastening kit 6541 for hook ends and the protection set 6540K.



### Dimensions:

Order no.	Size	A	B	B1	C	C1	dia. D	F2	H2 min.	H2 max.	L	Clamping stroke S2
374934	12	34	34	90	18	8	54	47	100	118	80	18
374959	16	37	44	120	25	10	70	62	122	153	107	31
376517	20	58	64	151	41	10	98	86	195	250	134	55
376533	24	58	64	151	41	10	98	86	199	260	134	61

CAD

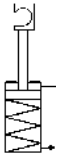


Subject to technical alterations.

## No. 6926Z

### Hook ends, hydraulic

max. operating pressure 400 bar.



Order no.	Article no.	Slot	G	Stroke H [mm]	R	max. possible clamping force [kN]	Weight [g]
325373	6926Z-12	14, 16, 18	M12	20	G1/4	13	1430
325399	6926Z-16	18, 20, 22, 24	M16	30	G1/4	39	3650
326959	6926ZL-16	18, 20, 22, 24	M16	40	G1/4	39	3950

### Design:

Cylinder barrel from steel, burnished. Piston and piston rod case hardened and ground. Wiper at piston rod. Piston rod with internal thread. Oil supply via threaded port.

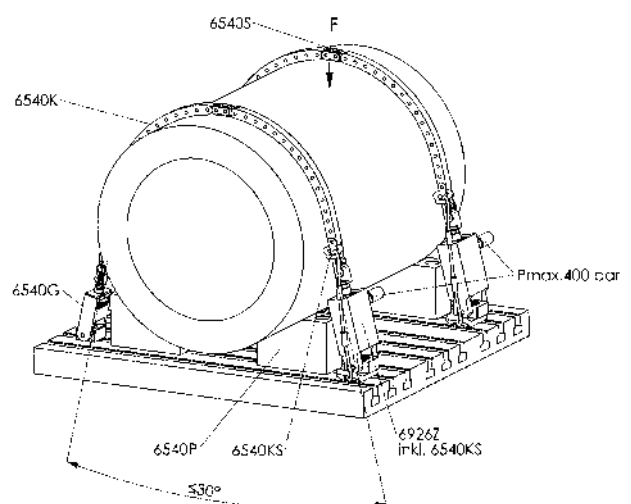
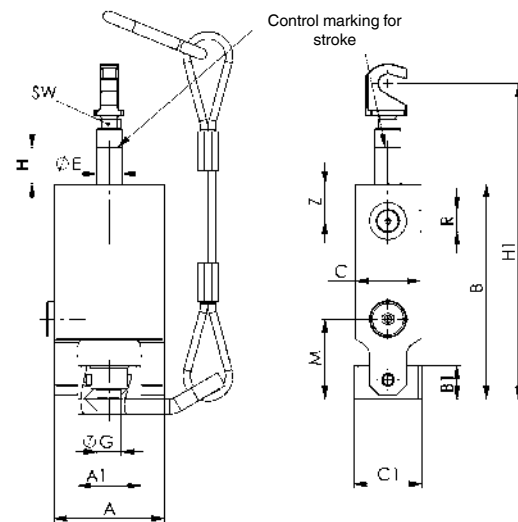
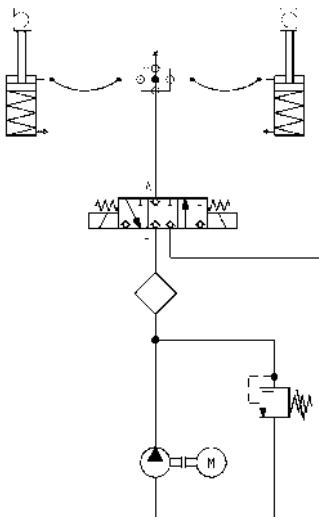
### Application:

For tensioning primarily cylindrical parts - on both the machine table and clamping plates. The chain length and clamping force are preset on the counter catch using knurled nuts. The hook end is then placed under hydraulic pressure to tension the chain. The control marking on the piston rod marks the max. stroke and shows how far the hydraulic cylinder has been run out.

### Advantage:

Even pressure distribution reduces workpiece deformation.

### Hydraulic diagram:



### Dimensions:

Order no.	Article no.	A	A1	B	B1	C	C1	dia. E	H1	M	SW	Z
325373	6926Z-12	60	34	116,5	18	35	37	14	151,5 - 171,5	43,5	10	20
325399	6926Z-16	75	44	154,0	25	55	37	20	188,0 - 218,0	54,0	17	25
326959	6926ZL-16	75	44	164,0	25	55	37	20	198,0 - 238,0	54,0	17	25



Subject to technical alterations.

## No. 6540G

### Counter catch

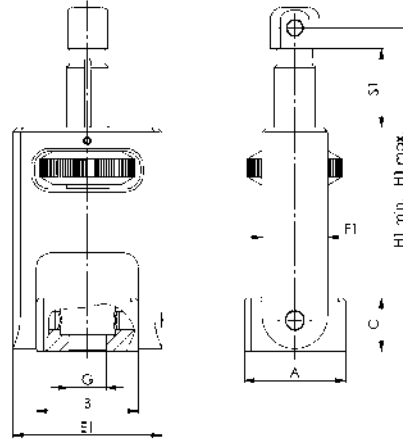
Tempered steel, burnished.



Order no.	Size	Slot	Screw G [mm]	S1 Stroke [mm]	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

### Note:

Installation exclusively with the AMF fastening kit 6541 for counterholders.



### Dimensions:

Order no.	Size	A	B	C	E1	F1	H1 min.	H1 max.
374710	12	34	34	18	50	22	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

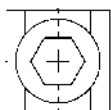
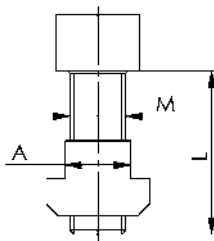
CAD



## No. 6541

### Fastening kit for hook end and counterholder

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



CAD



Order no.	A	L 6540H [mm]	L 6540G [mm]	M	Weight [g]
84251	14	-	25	M12	78
376483	14	35 *	-	M12	84
84269	16	-	30	M12	95
376509	16	40 *	-	M12	113
84277	18	-	35	M12	131
376525	18	40 *	-	M12	136
84285	18	-	35	M16	168
376541	18	45 *	-	M16	184
84293	20	-	40	M16	216
376566	20	50 *	-	M16	231
84343	22	-	45	M16	290
376582	22	55 *	-	M16	305
84350	24	-	45	M16	374
376608	24	55 *	-	M16	389
NEW! 568518	22	-	55	M20	376
NEW! 568523	22	65 *	-	M20	401
NEW! 568519	24	-	55	M20	456
NEW! 568524	24	70 *	-	M20	493
NEW! 568520	28	-	65	M20	601
NEW! 568525	28	75 *	-	M20	625
NEW! 568521	28	-	60	M24	689
NEW! 568526	28	70 *	-	M24	725
NEW! 568522	36	-	70	M24	1100
NEW! 568527	36	80 *	-	M24	1125

\* For use of the protection set no. 6540KS

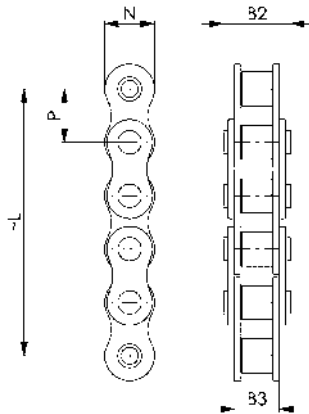
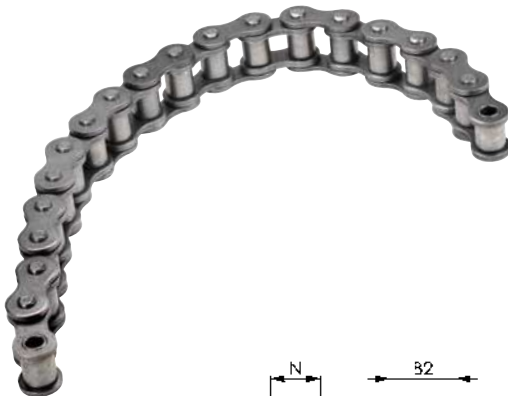
Subject to technical alterations.



## 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]	A [mm]	dia. D [mm]	H [mm]	L [mm]	Weight [g]
376111	12	15	34	13	8	80	280
376129	16	40	37	17	10	107	350
376491	20	75	58	21	10	134	1313
376558	24	120	58	25	10	134	1313

### Application:

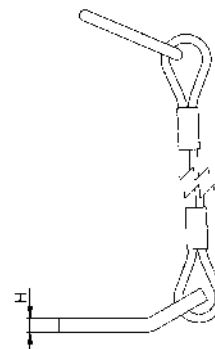
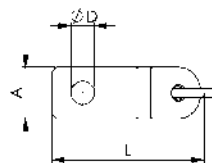
To use the clamp chain safely, the protection set is simply screwed below the hook end or the counterholder. Then, using the supplied connecting link, the protection set is fastened above the hook end. This prevents the clamp chain from snapping uncontrolledly if the hook end breaks.

### 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. 6540P

### Angle block, 120°

Tempered and burnished.



CAD



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:

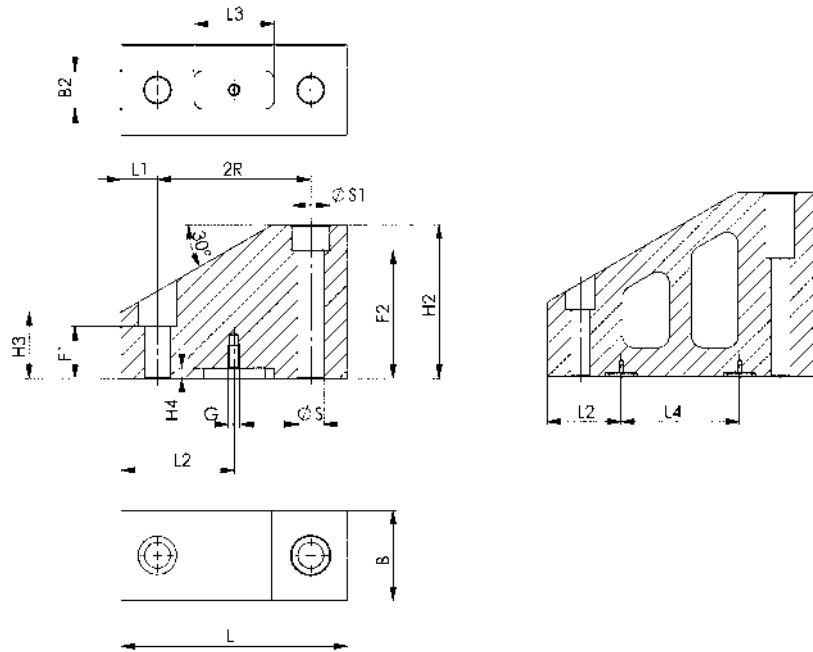
Optimised use of the clamp chain thanks to flexible positioning of the clamping prisms in the machine table groove.

#### 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.



## 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. 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.

## No. 6540V

### Connecting links with spring cotter pin



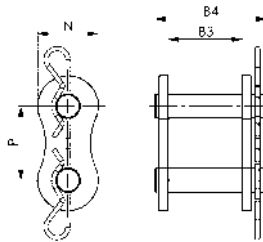
Order no.	Size	B3	B4	N	P	max. possible clamping force [kN]	Weight [g]
374819	12	13	22	14	15,875	15	15
374827	16	25	39	21	25,400	40	67
376780	20	29	44	26	31,750	75	113
376806	24	38	59	33	38,100	120	274

#### Application:

The connecting links are used for joining two chains together.

#### Advantage:

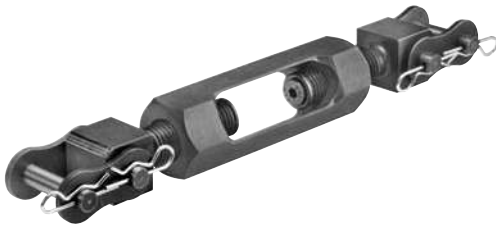
Chains simple and quick to combine and replace.



## No. 6540VS

### Turnbuckle included pre-installed locking links

Tempered steel, burnished.



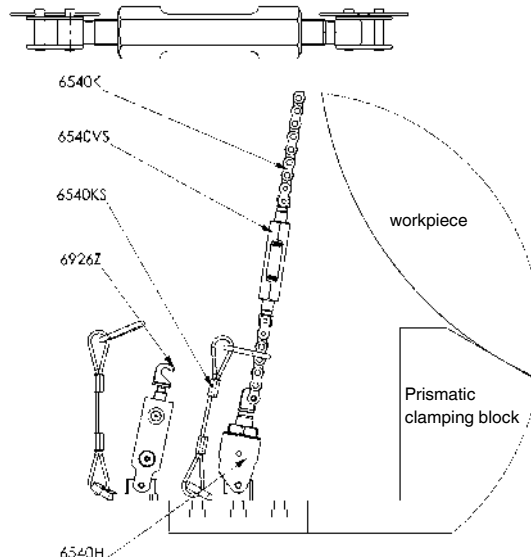
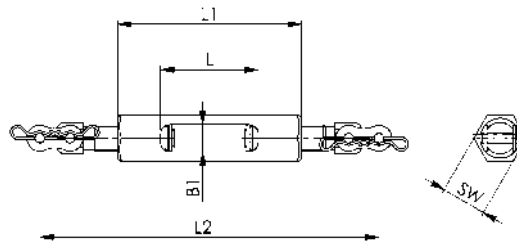
Order no.	Size	L	L1	L2	B1	SW	max. possible clamping force [kN]	Weight [g]
376459	12	52	97	143 - 178	14	24	15	240
376616	16	65	126	202 - 253	20	30	40	720
551514	20	92	180	270 - 333	31	50	75	2222
551515	24	92	180	291 - 360	31	50	120	3517

#### 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. 685Md

### Open ring spanner with torque-wrench fitting

Fits hook end 6540H.  
 (AMF chain clamping set 6540)  
 For hexagon clamping nuts.  
 Drive 1/2" square socket with ball-engagement groove.  
 Special steel, hardened and **zinc-plated**.



**NEW!**

Order no.	SW	L	S	SW1 [inch]	T	T1	Weight [g]
52514	36	101	60	1/2	7	16	255
52522	46	107	60	1/2	8	16	330
568022	65	160	100	1/2	10	16	800

### Advantage:

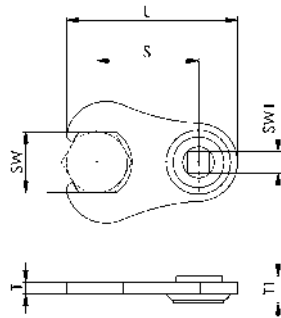
Ideally adapted for the controlled actuation of the hook end 6540 of the chain clamping set.

### Note:

The set value for the torque wrench is dependant on insertion dimension „S“.  
 The operating manual of your torque wrench contains the necessary specifications and calculation formulas.

Max. permissible tightening torque (Md max.) for use with the AMF chain clamping set 6540:

- 6540-12 - SW 36mm: 45 Nm
- 6540-16 - SW 46mm: 90 Nm
- 6540-20 - SW 65mm: 190 Nm
- 6540-24 - SW 65mm: 300 Nm



Subject to technical alterations.

## ... BY ITEM NO.

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No. 6370ZSZ-112	12	No. 6375ZI	5	No. 6376KG	36	No. 6540K	53	Nr. 6375SRI	11
No. 6371	22-27	No. 6376A	46	No. 6376KK	37	No. 6540KS	53		
No. 6371G-50	20	No. 6376B	39	No. 6376KKA	47	No. 6540P	54		
No. 6371G-80	20	No. 6376BA	48	No. 6376KW	37	No. 6540S	54		
No. 6372	29-33	No. 6376BG	39	No. 6376VB	40	No. 6540V	55		
No. 6375BA	10	No. 6376BK	40	No. 6376Z	41-43	No. 6540VS	55		
No. 6375BI	10	No. 6376BKA	48	No. 6540	49	No. 6541	52		
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## ... BY ORDER NO.

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265835	23	301200	29	304923	20	376657	52	429639	47
266569	26	301218	30	304931	22	376673	53	429647	36
266577	27	301234	30	304949	20	376699	53	429654	48
266585	26	301259	30	304956	22	376715	53	429662	37
266593	27	301275	30	304964	20	376723	53	429670	48
266601	26	301291	30	304972	24	376749	53	429688	37
266619	27	301317	30	304998	24	376764	53	429696	40
266627	27	301333	30	305011	25	376780	55	429704	37
266635	27	301358	30	305037	25	376806	55	429712	40
266643	27	301374	30	305086	26	376822	54	430207	43
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These Terms of Payment apply for companies, legal entities governed by public law and public law special funds. Our goods and services are supplied exclusively on the basis of the following conditions. Any deviating purchasing conditions of the customer not expressly recognised by us will not become part of the contract through acceptance of the order. By placing the order and accepting the goods we deliver, the customer confirms its consent to our terms and conditions.

## 1. Offer and contractual conclusion

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 20 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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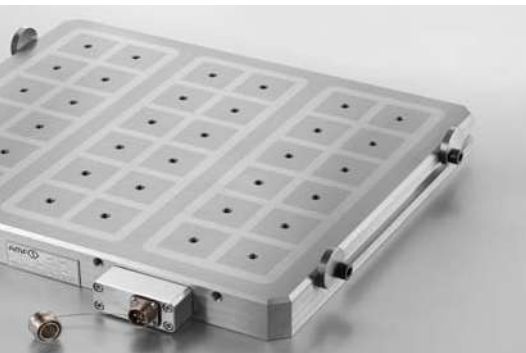
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