

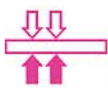
Double clamping system DS 125



The double-clamping system DS 125 is an ideal component for efficient multiple clamping in flexible production. With tower or series arrangements, cost effective and secure clamping applications are possible. Even the use of just one double clamping system, also in fixtures, is advantageous.

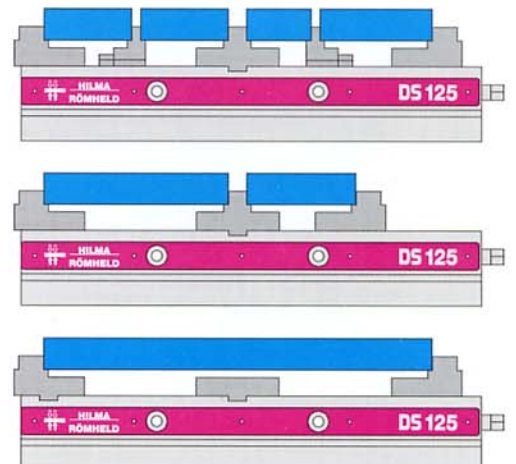
User-friendly design with one-side spindle operation and third-hand function: this allows equally or differently sized workpieces to be successively inserted / taken out of both clamping positions.

- ◆ In combination with standard and special jaws for prismatic or extruded workpieces, for castings and forgings, the clamping system is an economically efficient alternative: the expenses for workpiece-specific clamping systems can be considerably reduced or even avoided
- ◆ High stability and long service life; user-friendly conception
- ◆ Maximum use of working area; fixed overall length
- ◆ Spindle area well protected, no exposed openings, optimum discharge of swarf and coolant
- ◆ Available in two different overall lengths
- ◆ High clamping force up to 40 kN per clamping point; absolutely reliable function. Sensitive or powerful clamping with preselectable clamping force using a torque wrench
- ◆ Rapid adaptation to a new workpiece by easy change of the jaws which are either fastened by screws or kept in place by permanent magnets and guide pin (Quick Insert System Q.I.S.)
- ◆ Suitable for horizontal and vertical use; ideal for reversible clamping devices
- ◆ Variants proposed for customer-specific positioning and fastening



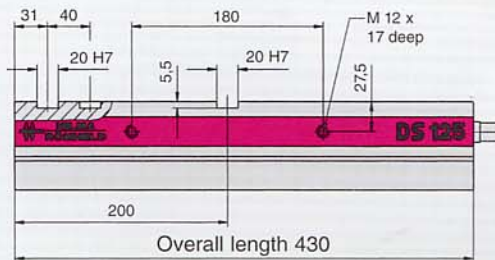
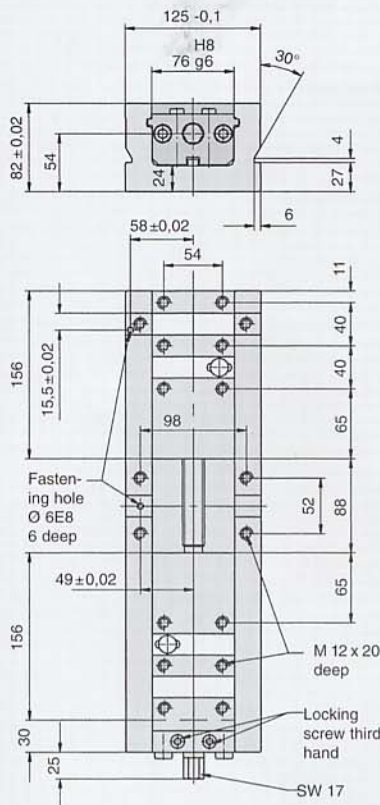
- 1 Reversible step jaw, mobile
- 2 Slot for step jaw, fixed (large clamping range)
- 3 Base and slide in all-steel design
- 4 Threaded holes for workpiece stop on both sides
- 5 Closely spaced clamping points = reduced travel
- 6 Central step jaw
- 7 Guideways hardened and ground
- 8 Clamping edge for clamping claws
- 9 Adjustment of third-hand function
- 10 Mechanical spindle for approach, clamping and unclamping

Double clamping system DS 125 for flexible clamping of up to 4 equally or differently sized workpieces



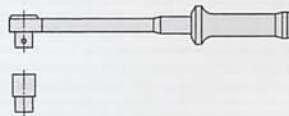
Technical data

Ref. no. 9.3666.0101, overall length 430 mm



Clamping force / torque	40 kN / 115 Nm
Clamping stroke per slide	44 mm
Mass without clamping jaws	29 kg
Ref. no. standard version	9.3666.0101
Ref. no. for variants proposed for customer-specific positioning and fastening, see page 8	

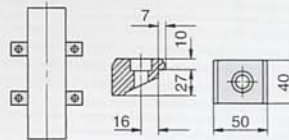
Torque wrench



20-100 Nm with ratchet and square 1/2" with ball lock

Ref. no.
9.3792.6610 Torque
1.3124.0017 Socket wrench SW 17

Set of clamping jaws



consisting of 4 clamping jaws
DIN 912

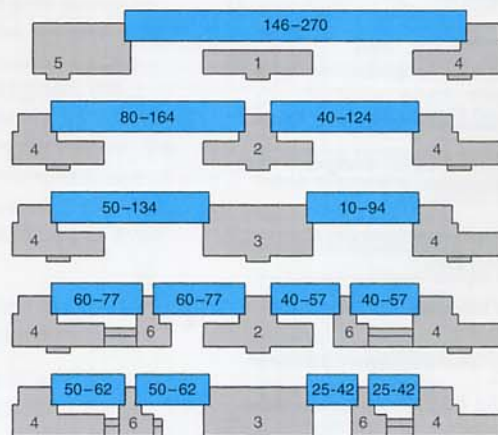
Ref. no.
9.3777.3011 (M 12 x 45 T-slot 14)
9.3777.3021 (M 16 x 50 T-slot 18)

Using the standard jaws, up to 4 equally or differently sized workpieces can be clamped.

Larger spans (186 to 350 mm) can be achieved with the fixed reversible step jaw.
Ref. no. 9.3791.6311

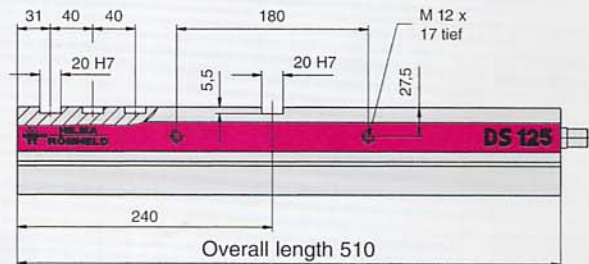
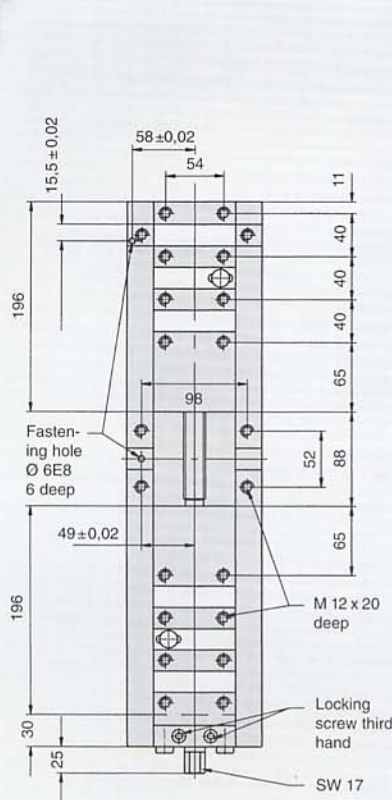
Item	Ref. no.	Designation
1	9.3791.6140	Guide plate
2	9.3791.6111	Central step jaw 22 mm
3	9.3791.6121	Central step jaw 82 mm
4	9.3791.6211	Step jaw, reversible
5	9.3791.6341	Step jaw, fixed
6	9.3791.6541	Central jaw, floating

For jaw dimensions, see page 6



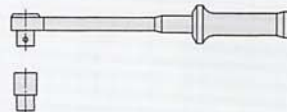
Technical data

Ref. no. 9.3666.0201, overall length 510 mm



Clamping force / torque	40 kN / 115 Nm
Clamping stroke per slide	44 mm
Mass without clamping jaws	34 kg
Ref. no. standard version	9.3666.0201
Ref. no. for variants proposed for customer-specific positioning and fastening, see page 8	

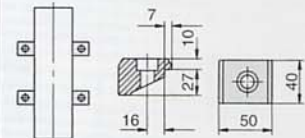
Torque wrench



20-100 Nm with ratchet and square
1/2" with ball lock

Ref. no.
9.3792.6610 Torque
1.3124.0017 Socket wrench SW 17

Set of clamping claws



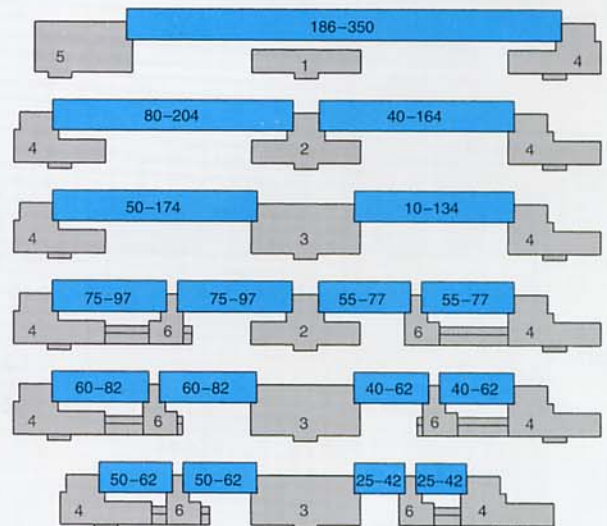
consisting of 4 clamping claws
DIN 912

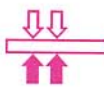
Ref. no.
9.3777.3011 (M 12 x 45 T-slot 14)
9.3777.3021 (M 16 x 50 T-slot 18)

Using the standard jaws, up to 4 equally or differently sized workpieces can be clamped.

Larger spans (226 to 430 mm) can be achieved with the fixed reversible step jaw.
Ref. no. 9.3791.6311

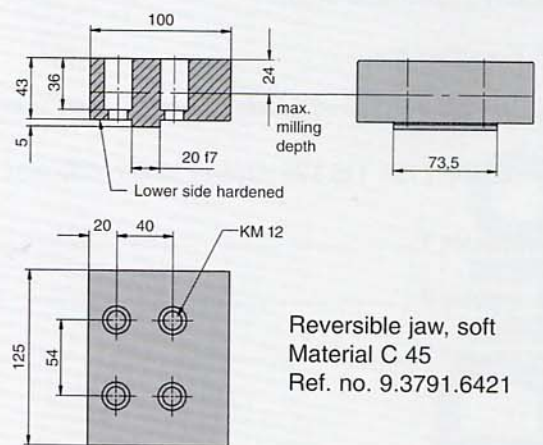
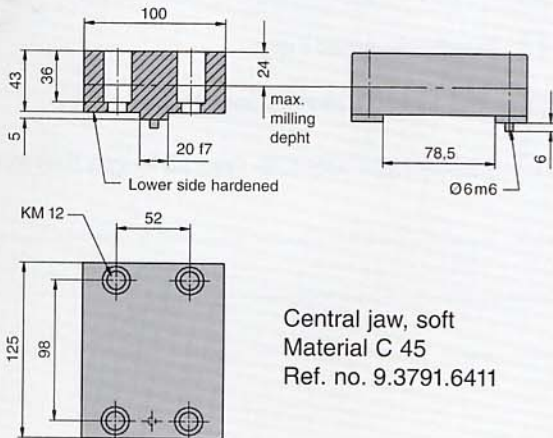
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For jaw dimensions, see page 6		





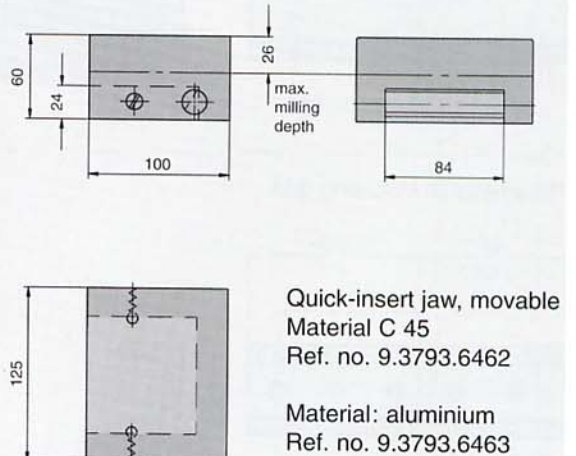
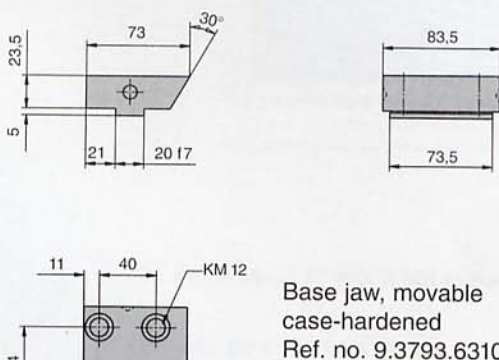
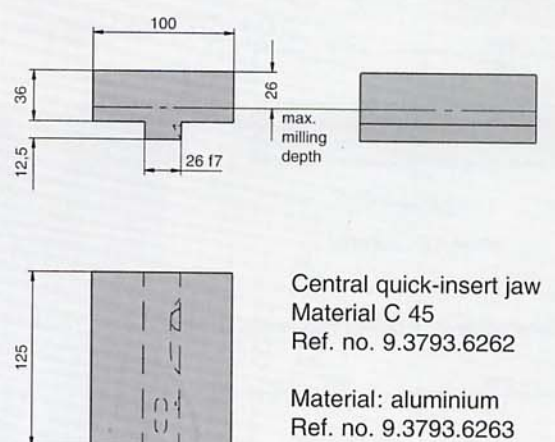
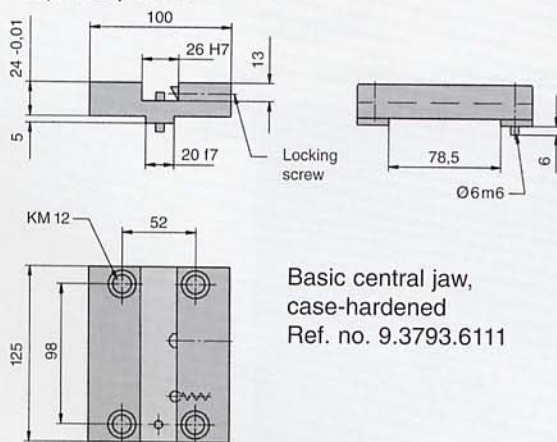
Dimensions of standard clamping jaws / turbo quick-insert jaws

Standard clamping jaws, soft for milling workpiece contours, steps, stops etc.
Supplied with fastening screws.



Turbo quick-insert jaws: Jaw change in a jiffy, without screws.

Quick-insert jaws soft, made from steel C 45 or high-tensile aluminium for milling workpiece contours, steps, stops etc.



Specific variants Positioning and fastening

Specific requirements concerning positioning and fastening can be complied with by adopting our variants as shown hereafter. Please determine the parameters 1 to 3 and specify them in your enquiry / purchase order.

Enquiry / qty. Purchase order / qty.

Please mark the desired double clamping system with a cross and enter the desired parameters.

9.3666.7101 DS 125 Overall length 430 mm 9.3666.7201 DS 125 Overall length 510 mm

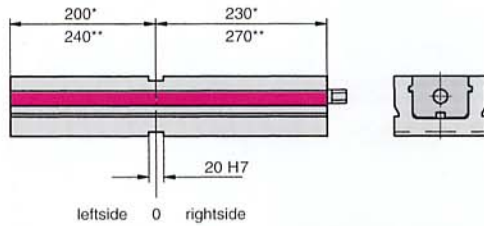
Parameter 1 _____

Parameter 2 _____

Parameter 3 _____

Date _____ Stamp _____ Signature _____

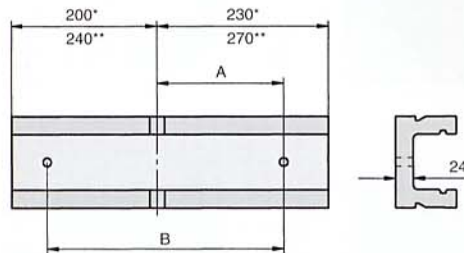
Parameter 1: Keyway across length H7 in the base



Examples: 20 H7 leftside 50±0,02
20 H7 0±0,02
20 H7 rightside 100±0,02

* = 9.3666.7101 Overall length 430 mm
** = 9.3666.7201 Overall length 510 mm

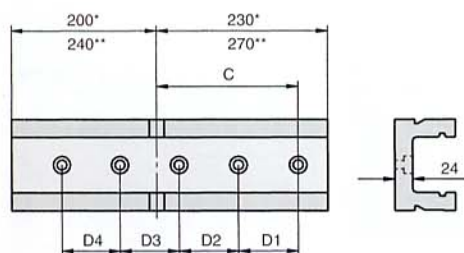
Parameter 2: Positioning holes Ø 12 H7 or Ø 16 H7



Examples: Ø 12 H7, A = 100±0,02, B = 200±0,02
Ø 16 H7, A = 150±0,02, B = 300±0,02

* = 9.3666.7101 Overall length 430 mm
** = 9.3666.7201 Overall length 510 mm

Parameter 3: Mounting grid



Countersink KM 12 DIN 74 or KM 16 DIN 74

Examples: KM 12 DIN 74, C = 150, D1 = 100,
D2 = 50, D3 = 50, D4 = 100

* = 9.3666.7101 Overall length 430 mm
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