

BENEFITS

- » quick adaption
- » modular clamping system for various combinations
- » use with standard clamping systems



Easy-clamping base M



Easy-clamping base L



Easy-clamping base XL

QUICK, FLEXIBLE AND COPLANAR

The unique Easy-clamping base serves as a quick clamping station for a variety of vices and extensions blocks.

Fixing, adjusting and removing to machine tables with t-slots is done in a few seconds by turning just a single screw.



MATCHING EASY-CLAMPING BASE

BRILLANT	M	L	XL
200			
220			
230/250			
255/265			
275			
285			
2000		*	

* only conditionally recommended

MACHINE TABLE

All recent ATM machine tables are standardly equipped with t-slots (retrofitting possible).



Change of preassembled Easy-clamping bases



Flexible by rotating and clamping elements

OPERATION

The flexible modular system of combining rotating and clamping with standard clamping elements saves from difficult and painstaking mounting of clamping tools into t-slots. Therefore the Easy-clamping system is a great benefit for your everyday work.



BRILLANT	220	230	250
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**EASY-CLAMPING BASE M**

Order No.: Z2236008
 » for machine tables with T-slots
 » incl. clamping key

WxHxD	15x80x200 mm
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**DIRECT ADAPTION**

- » fast lock vice 50
 - » fast lock vice 60
 - » fast lock vice 80*
 - » clamping system X-Clamp 3858
- *not suitable for Brillant 220*

MATCHING MODULES

- » rotatable plate (base for headpieces and rotatable modules)
- » head piece 1 (base for vacuum- and duo sample holder)
- » head piece 2 (base for fast lock vice 50)
- » head piece 3 (intermediate module for rotating plates)
- » head piece 4 (base for fast lock vice 60)

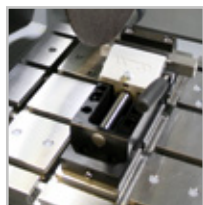
BRILLANT	200	230	250	255	265	275	285	2000*
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** only conditionally recommended*

**EASY-CLAMPING BASE L**

Order No.: Z2236011
 » for machine tables with T-slots
 » incl. clamping key

WxHxD	20x80x245mm
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**DIRECT ADAPTION**

- » fast lock vice 60
- » fast lock vice 80
- » adapter for universal vices:
 V-block plate,
 system height adapter,
 guide bar with sliding carriage and
 V-groove block

MATCHING MODULES

- » rotatable plate (base for headpieces and rotatable modules)
- » head piece 1 (base for vacuum- and duo sample holder)
- » head piece 2 (base for fast lock vice 50)
- » head piece 3 (intermediate module for rotating plates)
- » head piece 4 (base for fast lock vice 60)

BRILLANT	275	285	2000
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**EASY-CLAMPING BASE XL**

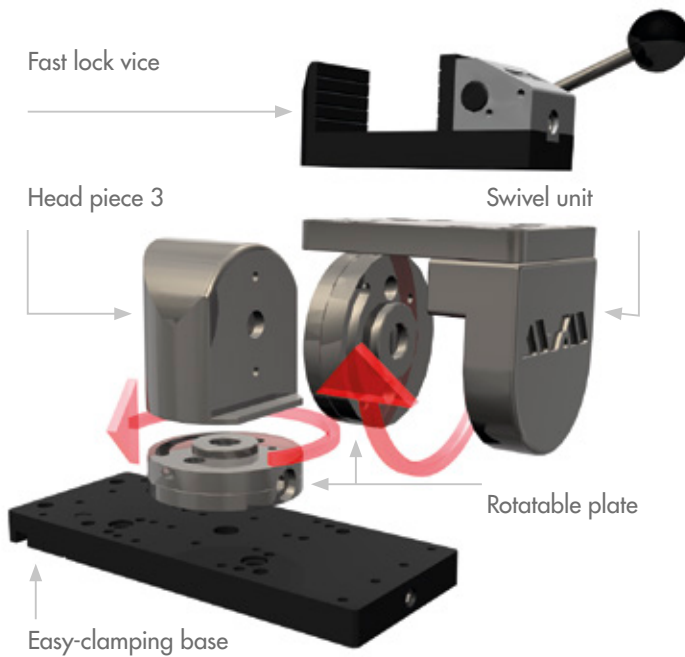
Order No.: Z2236026
 » for machine tables with T-slots
 » incl. clamping key

WxHxD	20x100x400 mm
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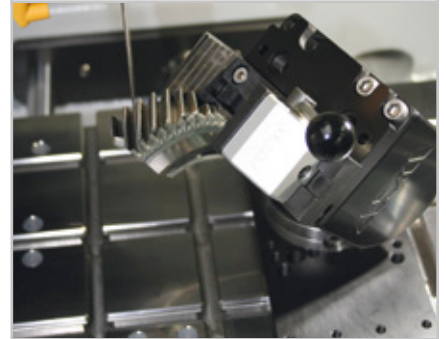
DIRECT ADAPTION

- » guide bar with sliding carriage 400 set
 (base for universal vice Mono 132 and chain clamping vice)
- » universal power clamp 100/380



**ROTATABLE PLATE**

The rotatable plate is an intermediate module for angle adjustment with 15°-increments and a precision of 1/2°. The fitting head piece is easily to adapt to the clamping element by a quick holding fixture.



Extension of the pivotal dimension by several rotatable plates

SWIVELING, ROTATING, CLAMPING

Various Easy-clamping modules are a great benefit for your everyday work. The proved fast lock vices combined with the Easy-clamping modules serve as a quick clamping station for a variety of vices and extensions blocks.

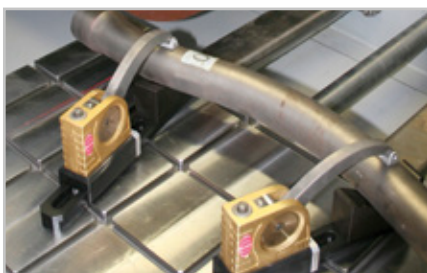
Changing of configured clamping vices with Easy-clamping bases is as fast than ever.



Product video: <https://www.youtube.com - enter ,atm, easy/>.

CLAMPING MODULES XL

Clamping of large components in large machines requires a very firm clamping tool. Therefore, the modules for the Easy-clamping system XL are a particularly strong. They can be built up only with power clamp 100/380 and the guide bar for universal vice Mono 132 and chain clamping vice.



Guide bar with universal vice



Guide bar with chain clamping vice



Universal power clamp 100/380



MODULES FOR EASY-CLAMPING BASE M AND L
ROTATABLE PLATE


Order No.: Z2236005

- » quick holding fixture for quick and easy changing the head piece
- » incl. clamping key

Angle precision	1/2°
Increments	15°

MATCHING MODULES


- » Head piece 1 (base for vacuum- und Duo-sample holder)
- » Head piece 2 (base for fast lock vice 50)
- » Head piece 3 (intermediate module for rotatable plates)
- » Head piece 4 (base for fast lock vice 60)
- » Swiveling prism 60 and 100


*Vacuum-
sample holder*

Duo-sample holder
HEAD PIECE 1

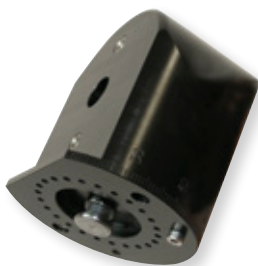
Order No.: Z2236006

- » base for vacuum-/Duo-sample holder


Fast lock vice 50
HEAD PIECE 2

Order No.: Z2236007

- » base for fast lock vice 50 and customized solutions


*Swivel unit with
fast lock vice 50*
HEAD PIECE 3

Order No.: Z2236016

- » intermediate module with angle 90° for adapting an additional rotatable plate
- » with additional rotatable plate adaption for swiveling unit with fast lock vice 50 and 60

**HEAD PIECE 4**


Order No.: Z2236025

» base for fast lock vice 60 and customized solutions



Swiveling prism 60



Swiveling prism 100

SWIVELING PRISM

» for cylindrical samples \varnothing 4-20 mm

» swivel range adjustable 0-90°

Swiveling prism 60

Order No.: Z2236021

Swiveling prism 100

Order No.: Z2236023

CLAMPING ELEMENT FOR HEADPIECE 1 | ROTATABLE PLATE**VACUUM SAMPLE HOLDER**


Order No.: Z2236002

» for thin section and unclampable samples

For microscope slide 28 x 48 mm

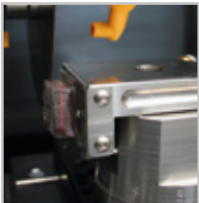
Vacuum pump

230 V/50 Hz (1Ph/N/PE)

110 V/60 Hz (1Ph/N/PE)

Order No.: Z1304600

Order No.: Z1304634

**CLAMPING ELEMENT FOR HEADPIECE 1 | ROTATABLE PLATE****DUO SAMPLE HOLDER**

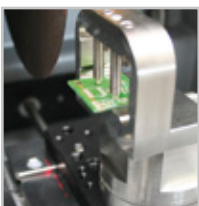

Order No.: Z2236003

» for thin section and target preparations

» clampable with quick holding fixture to parallel-grinding unit of Rubin 540

» 4 ball head screws

Max. sample size 30 x 55 mm



Cutting and grinding with just one mounting

Swivel unit for
fast lock vice 50Swivel unit for
fast lock vice 60**CLAMPING ELEMENT FOR HEADPIECE 3 | 2 ROTATABLE PLATES****SWIVEL UNIT VICE****Base for fast lock vice 50**

Order No.: Z2236017

Base for fast lock vice 60

Order No.: Z2236018

MODULES FOR EASY-CLAMPING BASE L**SYSTEM-HEIGHT ADAPTER 50**

Order No.: Z1304631

- » multiple mountable
- » base for fast lock vice 80
- » extension with V-block plate 40 for universal vices
- » incl. set of center bolts

Construction height 50 mm



Mounting example

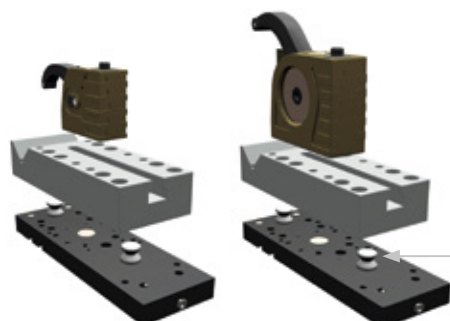
V-BLOCK PLATE 40

Order No.: Z1304624

- » base for universal vices
- » for Easy-clamping base L (please order set of center bolts)
- » also usable without Easy-clamping base, incl. fasteners

Construction height 40 mm

T-slot 12 mm

Universal vice
PiccoloUniversal vice
Mono

center bolts

ACCESSORIES**SET OF CENTER BOLTS**

Order No.: Z2236013

- » for mounting to Easy-clamping base or height-adapter





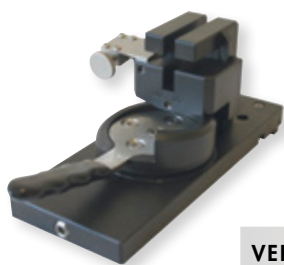
without Universal vice

**GUIDE BAR WITH SLIDING
CARRIAGE AND V-GROOVE BLOCK**

L

Order No.: Z1350001

- » base for Universal vices Mono
- » for clamping crankshafts, camshafts
- » bar 280 mm, with sliding carriage, V-groove block
- » incl. fasteners for T-slot 12 mm


VERTICAL VICE SINGLE

Order No.: Z2236009

- » with Easy-clamping base M

Order No.: Z2236019

- » with Easy-clamping base L


VERTICAL VICE

M L

- » for clamping of delicate, thin specimens
- » integrated Easy-clamping base M or L
- » incl. adjustable stop


VERTICAL VICE DOUBLE

- » detached segment is still clamped after cutting

Order No.: Z2236010

- » with Easy-clamping base M

Order No.: Z2236020

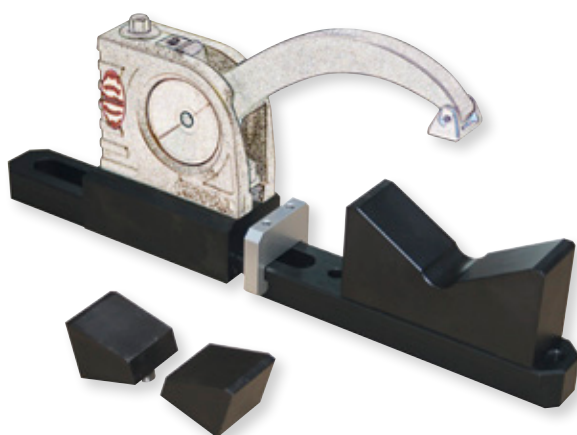
- » with Easy-clamping base L

BRILLANT

275

285

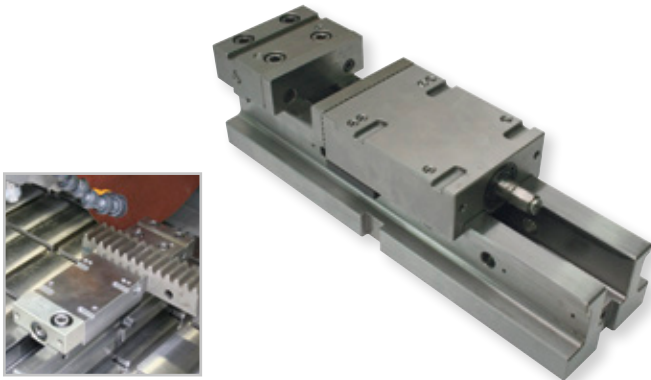
2000


GUIDE BAR 400 SET

XL

Order No.: Z1350024

- » base for Universal vices Mono, Duo, chain clamping unit
- » for clamping crankshafts, camshafts
- » bar 400 mm, standard sliding carriage
- » 1x V-groove block 120°
- » 2x slanted resting blocks
- » incl. fasteners for T-slot 12 mm

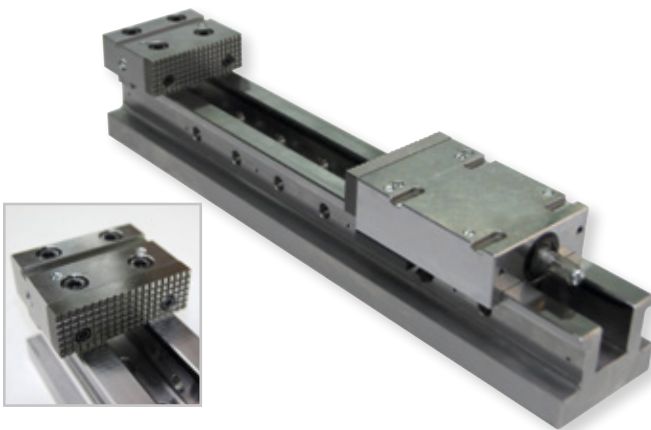
**UNIVERSAL-POWER CLAMPING SYSTEM 100/380**

XL

Order N.: Z2234015

- » integrated mechanical-hydraulic power
- » with standard clamping jaws plane/grooved, h 34 mm
- » incl. fasteners for T-slot nuts 12 mm and hand crank

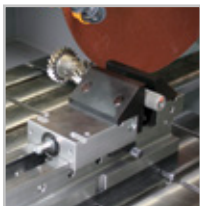
Clamping width	0 – 205 mm
Max. clamp force	25 kN
Weight	18.5 kg
WxHxD	100x104x466 mm

**UNIVERSAL-POWER CLAMPING SYSTEM 100/540**

Order N.: Z2234016

- » integrated mechanical-hydraulic power
- » incl. fasteners for T-slot nuts 12 mm

Clamping width	0 – 365 mm
Max. clamp force	25 kN
Weight	26.3 kg
WxHxD	100x104x625 mm

**V-Groove jaw**

Order N.: Z2234018

- » horizontal V-groove
- » combinable with flat jaw h 80 mm
- » incl. fixing screws



WxH	100x80 mm
for clamping round material	Ø 10 – 100 mm

**Angle drive**

Order N.: Z2234019

- » crank with top operation

**Flat jaw/h 80 mm**

Order N.: Z2234017

- » grooved tightening surface
- » for clamping parallel specimens
- » combinable with V-groove jaw
- » incl. fixing screws

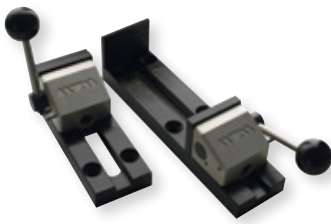


WxH	100x80 mm
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BRILLANT

220



FAST LOCK VICE 50

» with manual force amplification

Jaws WxH	35x25 mm
Incl. accessories	Nutbreite 8 mm

Clamping range 50 mm

Order No.: Z2270002

» lever left

Order No.: Z2270000

» lever right

Clamping range 100 mm

Order No.: Z2270003

» lever left

Order No.: Z2270001

» lever right

M direct adaption
head piece 2
swifel unit

L head piece 2
swifel unit

V-groove jaw

Order No.: 02270011

round materials Ø 1-35 mm

BRILLANT

220

230

250

255

265



FAST LOCK VICE 60

» with force memory system
» horizontal fixation of round materials

Jaws WxH	60x32 mm
HxD	54x195 mm

Clamping range 120 mm

Order No.: Z2235002

» lever left

Order No.: Z2235001

» lever right

M direct adaption
head piece 4
swifel unit

L direct adaption
head piece 4
swifel unit

V-groove jaw

Order No.: 02235013

round materials Ø 2-35 mm

BRILLANT	200	230	250	255	265	275	285	2000
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FAST LOCK VICE 80

- » with force memory system
- » horizontal fixation of round materials

Jaws WxH	80x35 mm
HxD	71x203 mm

HxD	71x253 mm
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Clamping range 100 mm


- Order No.: Z2231001
» lever left

Clamping range 150 mm

- Order No.: Z2231002
» lever left

- Order No.: Z2231003
» lever right

- Order No.: Z2231004
» lever right

-  **M** direct adaption
L direct adaption
height adapt. 50



HxD	71x353 mm
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- » for Brillant 255, 265, 275, 285, 2000

Clamping range 250 mm

- Order No.: Z2231020
» lever left

- Order No.: Z2231021
» lever right

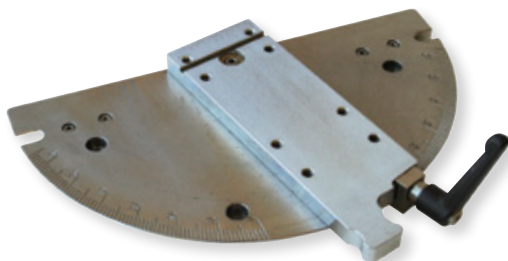
**V-groove jaw**

Order No.: 02231016



round materials Ø 2-40 mm

BRILLANT	265	275	285	2000
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**Rotating plate 2x 60°**

Order No.: Z1304560



- » manual rotation of clamping tool
- » manual horizontal move on machine table

Clamping range	100 mm
Swivel range	+/- 60°

**CROSS VICE**

- » especially suitable for samples which contract during cutting process by material tension: the samples are pulled apart by the transversely exciting jaws
- » for parallel clamping of round and rectangular samples, particular for longitudinal cutting through hardened materials
- » excentric clamping arrangement allows rapid changing of samples



BRILLANT	200	230	250	255	265
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**CROSS VICE 50/100**

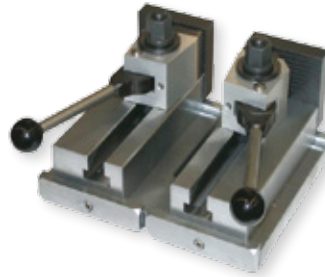
Order No.: Z1340010

» counter holder adjustable

WxH	50 x 50 mm
Round materials	Ø max. 60 mm
Clamping range	max. 100 mm
Incl. accessories	T-slot 12 mm

BRILLANT	255*	265	275	285	2000
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* on request

**CROSS VICE 80/100**

Order No.: Z1340000

» counter holder adjustable

WxH	80 x 50 mm
Round materials	Ø max. 90 mm
Clamping range	max. 100 mm
Incl. accessories	T-slot 12 mm

BRILLANT	275	285	2000
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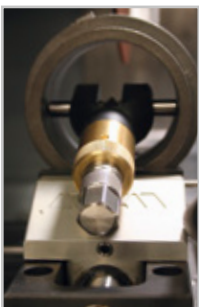
**CROSS VICE 80/150**

Order No.: Z1340001

» counter holder adjustable

WxH	80 x 50 mm
Round materials	Ø max. 90 mm
Clamping range	max. 150 mm
Incl. accessories	Nutbreite 12 mm

BRILLANT	255	265	275	285	2000
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**EXPANSION CLAMPING DEVICE**

Order No.: Z1304636

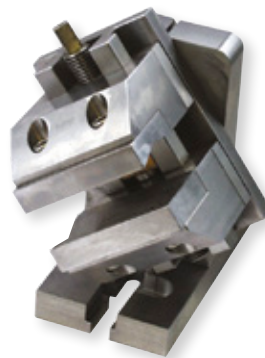
» to release material tension of cylindrical, hollow workpieces

Inner sample-Ø	55 – 120 mm
Adjustment*	ca. 10 mm

* extendable by exchange of cylindrical pins



BRILLANT	230	250	255	265	275	285	2000
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**ANGLE VICE 60**

Order No.: Z1304001

» vertically centered, stainless

» 2x plain jaws

Sample-Ø	max. 60 mm
V-groove jaw	
Clamping range	55 mm
Rotatable	270°
Incl. accessories	T-slot 12 mm

V-groove jaw

Order No.: 01304008



Round materials Ø 10-60 mm

BRILLANT	255	265	275	285	2000
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**ANGLE VICE 80**

Order No.: Z1302000

» vertically centered, stainless

» 2x plain jaws

Sample-Ø	max. 60 mm
V-groove jaw	
Clamping range	70 mm
Rotatable	270°
Incl. accessories	T-slot 12 mm

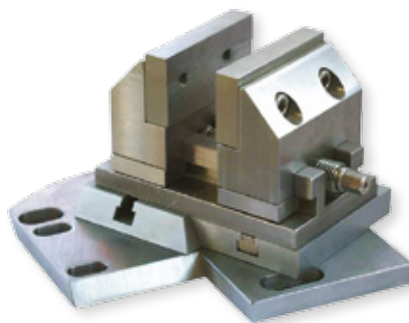
V-groove jaw

Order No.: 01302016



Round materials Ø 10-60 mm

BRILLANT	230	250	255	265	275	285	2000
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**ROTATING VICE 60**

Order No.: Z1304002

» vertically centered, stainless

» 2x plain jaws

Sample-Ø	max. 60 mm
V-groove jaw	
Clamping range	max. 55 mm
Sample-Ø	Ø 60 mm
Swivel range	90°
Incl. accessories	T-slot 12 mm

V-groove jaw

Order No.: 01304008



Round materials Ø 10-60 mm

BRILLANT	255	265	275	285	2000
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UNIVERSAL POWER CLAMPING SYSTEM LC 90



Order No.: Z2234001

- » easy and safe clamping of various workpieces
- » various clamping jaws available
- » up to 28 kN tension with modest effort through mechanical power transmission
- » adjustable clamping force (11 settings)
- » incl. fasteners for t-slot nuts 12 mm and hand crank

ACCESSORIES

CLAMPING JAWS



Carrier jaws LC 90

Order No.: Z2234003

- » 1 pair, base for V-groove jaw and flat jaw 100
- » easy fastening with just one screw
- » made of high-strength aluminium with ceramic coating



V-groove jaw 100

Order No.: Z2234004

- » 1 piece, combinable with flat jaw 100
- » rotatable jaw (case-hardened steel)
- » jaw size (WxH) 100 x 70 mm
- » two horizontal V-grooves
- » for clamping round material between \varnothing 10 and 100 mm
- » incl. fixing screw

Flat jaw 100

Order No.: Z2234005

- » 1 piece, combinable with flat jaw 100
- » rotatable jaw (case-hardened steel)
- » jaw size (WxH) 100 x 70 mm
- » flat tightening surface
- » for clamping parallel specimens
- » incl. fixing screw

QUICK-CHANGING DEVICE

Order No.: Z2234009

- » 1 pair
- » quick and easy connection of modules by using pull-down-studs
- » for fixation of

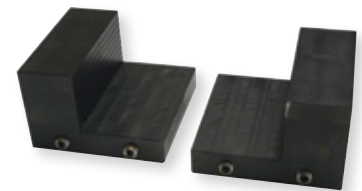
step jaw 100
clamping system X-Clamp 100
customized clamping solutions



STEP JAW 100

Order No.: Z2234008

- » 1 pair
- » clamping of parallel workpieces
- » application of clamping force via basic module LC 90
- » 180° rotatable
- » use only with quick changing device



CLAMPING SYSTEM X-CLAMP 100



Order No.: Z2234002

- » 1 pair
- » individual and safe clamping of various specimen shapes and sizes with spring suspended stainless steel plungers
- » perfect form fit with minimal effort
- » time-saving
- » use only with quick-changing device
- » incl. torque wrench and fixing screws



**BASE 90°**

Order No.: Z2234006

- » for installing the basic module LC 90 in side position 90°
- » incl. fixing material for T-slot nut DIN 650 12 mm

SUPPORT MODULE

Order No.: Z1350023

- » 1 piece
- » for supporting long workpieces
- » reducing of vibrations
- » spring suspended plungers fit tightly to the specimen
- » fixation of plungers
- » supplementary fixation of workpiece from above possible with universal vice
- » quick and easy connection of modules by using pull-down studs

**CUSTOMIZED CLAMPING JAWS**

- » ATM-service: send us your drawing (DXF or DWG-file) or fotos of your workpiece. We will design your individually optimized clamping vice.



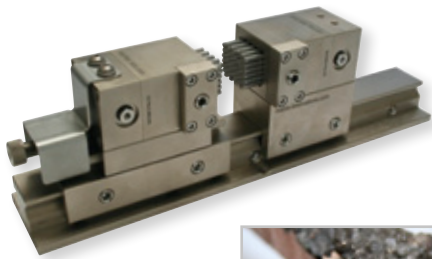
BRILLANT

200

220

230

250



BASIC MODULE

CLAMPING SYSTEM X-CLAMP 3858



M direct adapt.

Order No.: Z2234010

- » individual and safe clamping of various smaller specimen shapes and sizes with spring suspended stainless steel plungers
- » perfect form fit with minimal effort
- » time-saving
- » incl. torque wrench

Plunger area WxH 23x20 mm

Plunger stroke 12 mm

Max. clamping width 118 mm

ACCESSORIES

BASE FOR CLAMPING SYSTEM X-CLAMP 3858



- » incl. fixing material

Order No.: Z2234012

- » for fixation with T-slot nut 8 mm

Order No.: Z2234011

- » for fixation with T-slot nut 12 mm



BRILLANT	200	220	230	250
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L height adapter 50
V-block plate 40

UNIVERSAL VICE PICCOLO 54

Order No.: Z1350008

» incl. handle

Working radius	54 mm
Clamping height	- 15 - 58 mm
Clamping force	6,5 kN
Fixing screws	M 8 x 25
T-slot nut stainless	M 8 x 12

UNIVERSAL VICE PICCOLO 100

Order No.: Z1350012

» incl. handle

Working radius	100 mm
Clamping height	- 40 - 90 mm
Clamping force	4,2 kN
Fixing screw	M 8 x 25
T-slot nut stainless	M 8 x 12

SUITCASE SET

UNIVERSAL VICE PICCOLO 54

Order No.: Z1350010

- » 2x universal vice Piccolo 54
- » 2x height adapter Piccolo
- » 1x handle Piccolo
- » 1x clamping arm extension
- » 3x standard clamping shoe
- » 1x piece clamping shoe traverse bridge
- » 1x clamping shoe longitudinal bridge
- » 1x clamping shoe traverse V-shoe
- » 1x clamping shoe longitudinal V-shoe
- » 4x T-slot nuts stainless M 8 x 12
- » 4x fixing screws M 8 x 25



BRILLANT	200	230	250	255	265	275	285	2000
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L height adapter 50
guide bar
V-block plate 40

UNIVERSAL VICE MONO 61

Order No.: Z1350002

» incl. handle

Working radius	61 mm
Clamping height	- 8 - 102 mm
Clamping force	12 kN
Fixing screw	M 10 x 32
T-slot nut stainless	M 10 x 12

UNIVERSAL VICE MONO 132

Order No.: Z1350011

» incl. handle

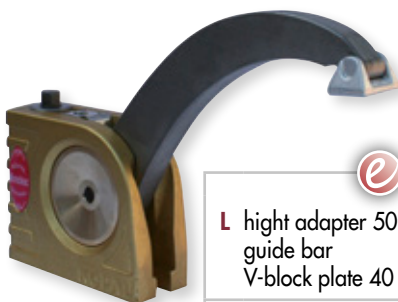
Working radius	132 mm
Clamping height	- 43 - 155 mm
Clamping force	8 kN
Fixing screw	M 10 x 32
T-slot nut stainless	M 10 x 12

SUITCASE SET

UNIVERSAL VICE MONO 61

Order No.: Z1350004

- » 2x universal vice Mono 61
- » 2x height adapter Mono
- » 1x handle Mono
- » 1x clamping arm extension
- » 3x standard clamping shoe
- » 1x clamping shoe traverse bridge
- » 1x clamping shoe longitudinal bridge
- » 1x clamping shoe traverse V-shoe
- » 1x clamping shoe longitudinal V-shoe
- » 4x T-slot nuts stainless M 8 x 12
- » 4x fixing screws M 8 x 25



L height adapter 50
guide bar
V-block plate 40

XL guide bar 400



BRILLANT	200	230	250	255	265	275	285	2000
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 XL guide bar 400

UNIVERSAL VICE DUO

Order No.: Z1350005
 » for clamping and lifting
 » with 2 changeable clamping arms
 » incl. handle

Working radius	46 - 91 mm
Clamping height	0 - 129 mm
Lifting height	4 - 142 mm
Clamping force	11 kN
Fixing screw	M 10 x 32
T-slot nut stainless	M 10 x 12

BRILLANT	200	230	250	255	265	275	285	2000
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 XL guide bar 400

CHAIN CLAMPING VICE

Order No.: Z1350006
 » for clamping of big parts
 » 1x universal vice Mono
 » 1x chain (length 1m)
 » 1x hooking block for chain
 » incl. handle

Clamping force	16 kN
Fixing screw	M 10 x 32
Fixing screw	M 10 x 25 DIN 912
2x T-slot nut stainless	M 10 x 12

ACCESSORIES

CLAMPING SHOES



» for all universal vices
Longitudinal V-shoe
 Order No.: 92005796

Traverse V-shoe
 Order No.: 92005797

Longitudinal bridge
 Order No.: 92005799

Traverse bridge
 Order No.: 92005800

Standard clamping shoe
 Order No.: 92005798



ACCESSORIES

FIXATION

Fixing screw
 » for universal vice Piccolo
 M 6 x 25 Order No.: Z1304591
 M 8 x 25 Order No.: 95003169
 M 10 x 25 Order No.: 95003170

» for universal vice Mono, Duo,
 chain clamping system
 M 10 x 32 Order No.: 95003168

T-slot nut stainless*
 M 6 x 8 Order No.: 91001157
 M 8 x 10 Order No.: 91001161
 M 8 x 12 Order No.: 91001159
 M 10 x 12 Order No.: 91001158

*other sizes on request



ACCESSORIES

HEIGHT ADAPTER PICCOLO



Order No.: Z1350007

Construction height	60 mm
Fixing screw	M 8 x 25
T-slot nut, stainless	M 8 x 12



ACCESSORIES

HEIGHT ADAPTER MONO



Order No.: Z1350003

Construction height	74 mm
Fixing screw	M 10 x 32
T-slot nut, stainless	M 10 x 12



ACCESSORIES

CLAMPING ARM EXTENSION



Order No.: 95003172
» for Piccolo 54 and Mono 61

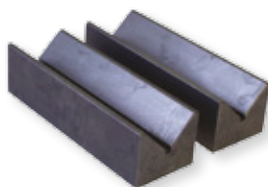
Extension	90 mm
Clamping shoe	Standard

*without universal vice*

PAIR OF V-BLOCKS

Order No.: 92005805

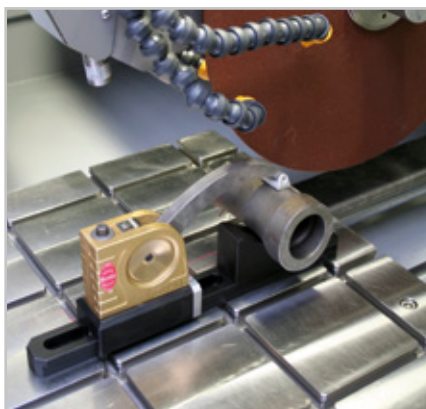
Angle	90°
for samples	Ø 5 - 50 mm
D x W	50 x 150 mm

ADAPTABLE TO
UNIVERSAL VICE MONO:

» see at Easy-clamping modules for
Easy-clamping base L

*V-block plate 40**Guide bar with sliding carriage and
V-groove block*

» see at Easy-clamping modules for
Easy-clamping base XL
» direct adaption: Brillant 275, 285
and 2000

*Guide bar 400 set*

CUSTOMIZED CLAMPING TOOLS

Different types of tasks and conditions constitute diverse demands on clamping tools and cutting equipment. The construction of our machines gives us the opportunity to design and manufacture custom-made solutions for special dimensions. ATM has already successfully developed special clamping tools for complicated cutting movements or geometries.

