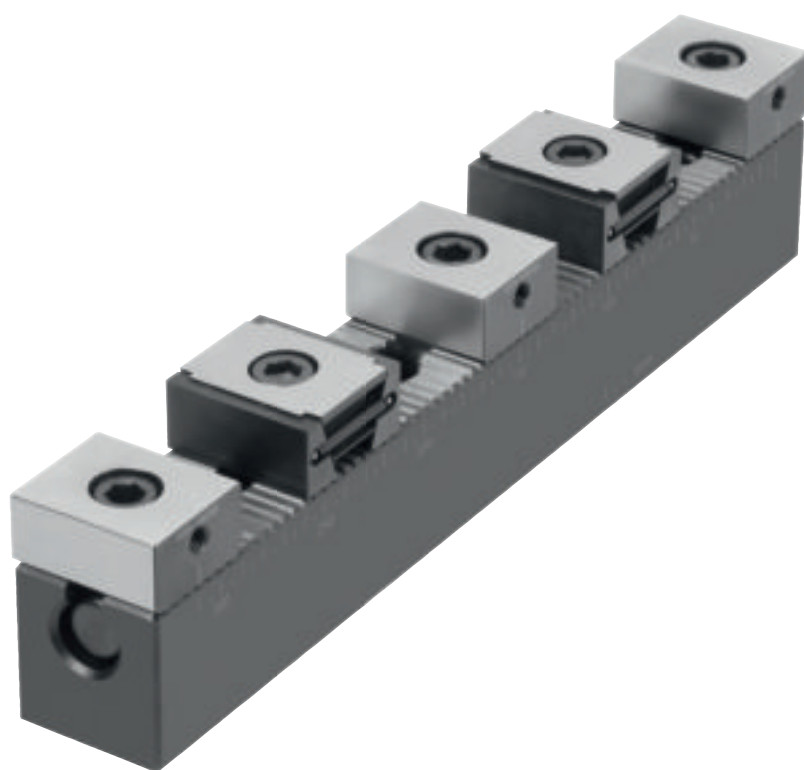


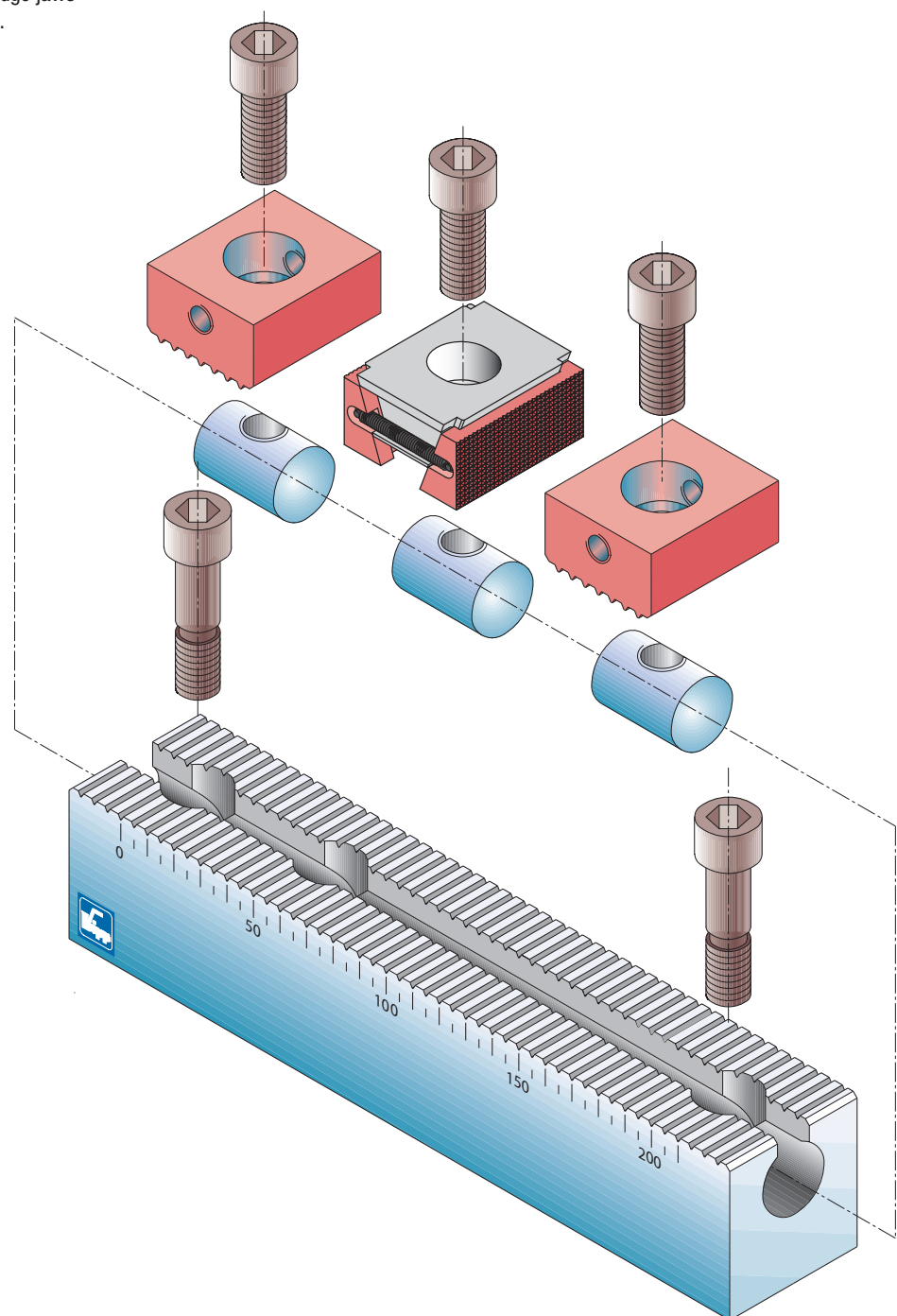
## Multi-clamping system



# Multi-clamping system



The multi-clamping system is used to clamp diverse workpieces on a base plate or directly on a machine table. The various elements of the multi-clamping system (base rails, stops and wedge clamps) allow workpieces of varied sizes to be held without difficulty. The serrations on the base rail guarantee a secure and exact fastening of the stops. The working area of a machine can be more effectively used by mounting a number of base rails along and across the work surface. The wedge clamps allow two workpieces to be held simultaneously from one clamping point. The transverse wedge design works in the vertical and horizontal plane, guaranteeing a secure hold in all directions. As the clamp is tightened the wedge jaws expand pressing the workpiece against the stops.

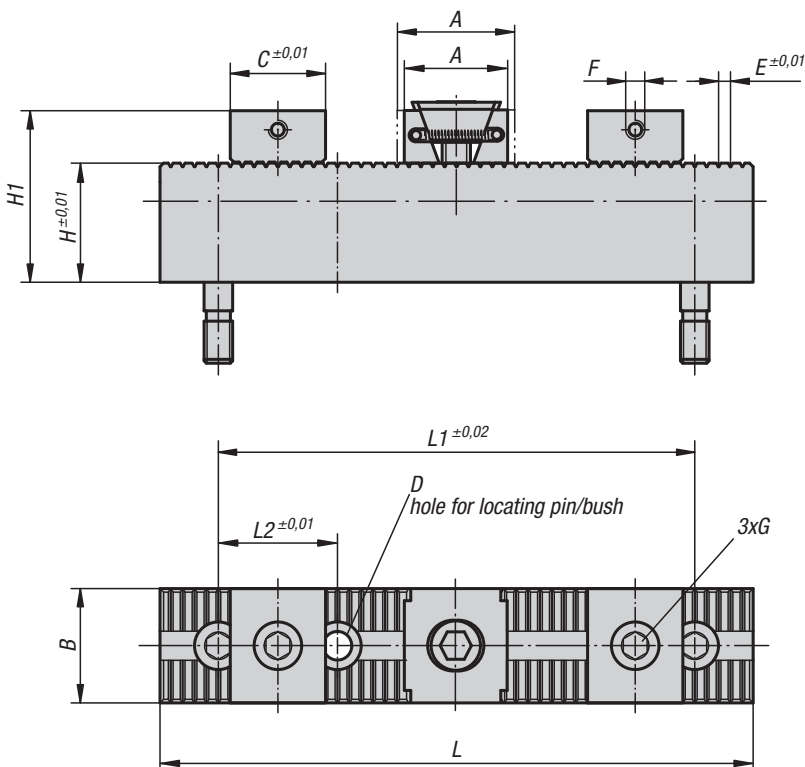
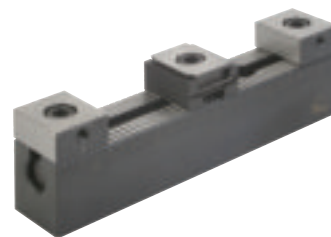


## Example of a multi-clamping system



## Multi-clamping system

hard stops



### Material:

Base rail, stops and wedge clamp carbon steel.

### Version:

Serrations case hardened and ground.

Stops tempered.

Clamping jaws hardened and black oxidised.

### Sample order:

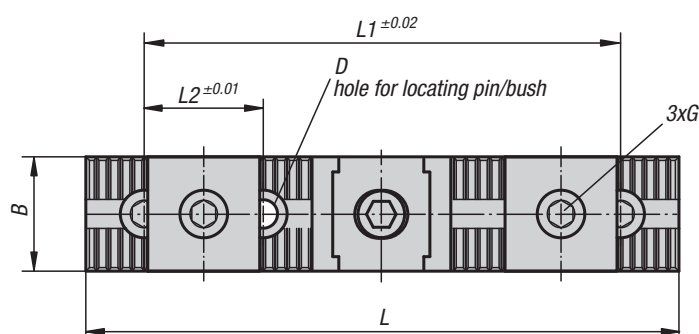
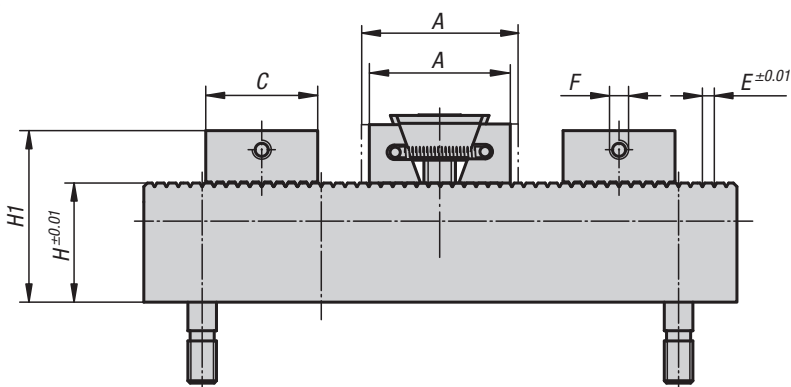
K0902.12

### KIPP Multi-clamping system hard stops

| Order No. | A<br>min. | A<br>max. | B  | C  | D     | E   | F  | G<br>cap screw<br>DIN 912 | H  | H1 | L   | L1  | L2 | Clamping<br>force ca.<br>kN | weight<br>kg |
|-----------|-----------|-----------|----|----|-------|-----|----|---------------------------|----|----|-----|-----|----|-----------------------------|--------------|
| K0902.08  | 30,5      | 33,5      | 24 | 25 | 12 H6 | 2,5 | M5 | M8x25                     | 40 | 55 | 199 | 150 | 50 | 15                          | 1.35         |
| K0902.12  | 44        | 49,5      | 48 | 40 | 12 F7 | 5   | M8 | M12x30                    | 50 | 72 | 249 | 200 | 50 | 30                          | 4.961        |
| K0902.16  | 55        | 62        | 48 | 40 | 16 F7 | 5   | M8 | M16x40                    | 63 | 92 | 249 | 200 | 50 | 50                          | 6.016        |

## Multi-clamping system

soft stops



### Material:

Base rail, stops and wedge clamp carbon steel.

### Version:

Serrations case hardened and ground.

Clamping jaws hardened and black oxidised.

### Sample order:

K0903.12

### Note:

Depending on the size the clamping jaws have 3 mm (K0903.08) or 5 mm (K0903.12, K0903.16) machining allowance per jaw.

## KIPP Multi-clamping system, soft stops

| Order No. | A<br>min. | A<br>max. | B  | C  | D     | E   | F  | G<br>cap screw<br>DIN 912 | H  | H1 | L   | L1  | L2 | Clamping<br>force ca.<br>kN | weight<br>kg |
|-----------|-----------|-----------|----|----|-------|-----|----|---------------------------|----|----|-----|-----|----|-----------------------------|--------------|
| K0903.08  | 36,5      | 39,5      | 24 | 31 | 12 H6 | 2,5 | M5 | M8x25                     | 40 | 55 | 199 | 150 | 50 | 11                          | 1.397        |
| K0903.12  | 54        | 59,5      | 48 | 50 | 12 F7 | 5   | M8 | M12x30                    | 50 | 72 | 249 | 200 | 50 | 23                          | 4.9          |
| K0903.16  | 65        | 72        | 48 | 50 | 16 F7 | 5   | M8 | M16x40                    | 63 | 92 | 249 | 200 | 50 | 38                          | 6.522        |

# Wedge clamps

jaw face smooth or serrated



## Material:

Wedge and jaw segments carbon steel.

## Version:

Wedge and jaw segments hardened, black.

## Sample order:

K0039.2208

## Note:

The functioning principle make the wedge clamps ideal for series clamping. The wedge form can exert high clamping forces.

These wedge clamps can be mounted in grid holes or T-slots. Tightening the socket screw moves the wedge down and the jaws out pressing the workpieces against the fixtures fixed stops. The wedge has a slightly elongated hole allowing for movement to compensate for tolerances.

Spread width:

M8 =  $\pm 0.5$  mm

M10 =  $\pm 1.0$  mm

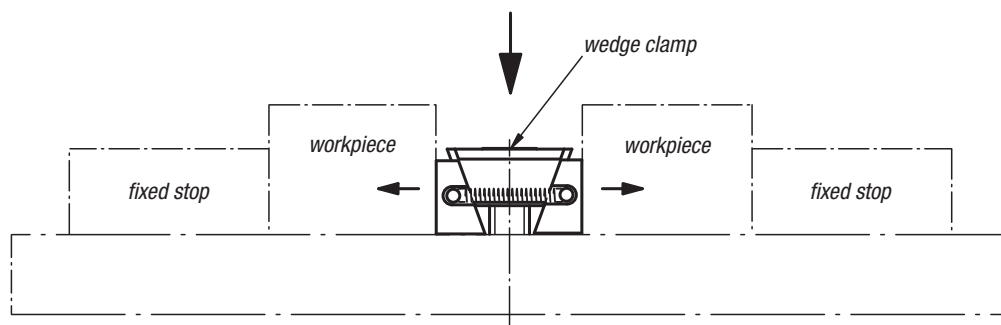
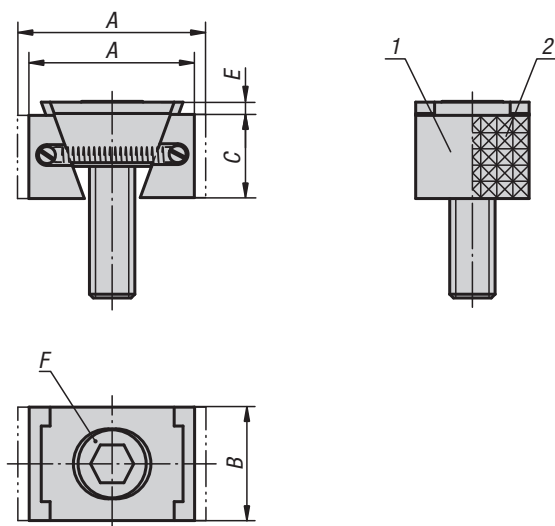
M12 =  $\pm 1.0$  mm

M16 =  $\pm 1.5$  mm

## Drawing reference:

1) Jaw face smooth

2) Jaw face serrated



## KIPP Wedge clamps, narrow version

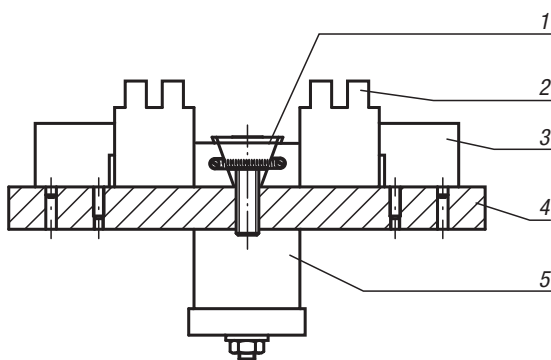
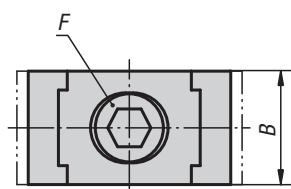
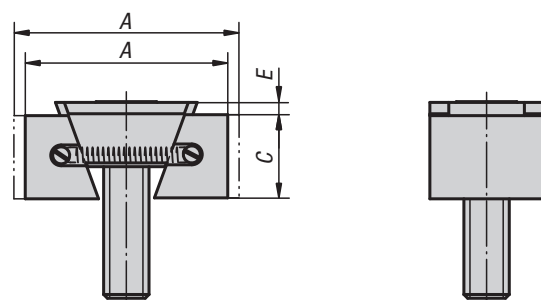
| Order No.<br>smooth | Order No.<br>serrated | A<br>min. | A<br>max. | B  | C  | E   | F<br>DIN 6912<br>cap screw | Clamping<br>force<br>kN | Tightening<br>torque<br>Nm |
|---------------------|-----------------------|-----------|-----------|----|----|-----|----------------------------|-------------------------|----------------------------|
| K0039.1108          | K0039.2108            | 30,5      | 33,5      | 24 | 15 | 2   | M8x25                      | 15                      | 25                         |
| K0039.1110          | K0039.2110            | 32        | 37        | 28 | 19 | 3,5 | M10x25                     | 20                      | 49                         |
| K0039.1112          | K0039.2112            | 44        | 49,5      | 30 | 22 | 3,5 | M12x40                     | 30                      | 85                         |
| K0039.1116          | K0039.2116            | 55        | 62        | 40 | 29 | 4   | M16x60                     | 50                      | 210                        |

## KIPP Wedge clamps, wide version

| Order No.<br>smooth | Order No.<br>serrated | A<br>min. | A<br>max. | B  | C  | E   | F<br>DIN 6912<br>cap screw | Clamping<br>force<br>kN | Tightening<br>torque<br>Nm |
|---------------------|-----------------------|-----------|-----------|----|----|-----|----------------------------|-------------------------|----------------------------|
| K0039.1208          | K0039.2208            | 30,5      | 33,5      | 30 | 15 | 2   | M8x25                      | 15                      | 25                         |
| K0039.1210          | K0039.2210            | 32        | 37        | 38 | 19 | 3,5 | M10x25                     | 20                      | 49                         |
| K0039.1212          | K0039.2212            | 44        | 49,5      | 48 | 22 | 3,5 | M12x40                     | 30                      | 85                         |
| K0039.1216          | K0039.2216            | 55        | 62        | 48 | 29 | 4   | M16x60                     | 50                      | 210                        |

# Wedge clamps

machinable



## Material:

Wedge and jaw segments carbon steel.

## Version:

Wedge and jaw segments hardened, black.

## Sample order:

K0649.3110

## Note:

These wedge clamps have extra long jaws. This extra material allows the jaws to be machined to suit the form of the workpiece.

The functioning principle makes the wedge clamps ideal for series clamping. The wedge form can exert high clamping forces.

These wedge clamps can be mounted in grid holes or T-slots. Tightening the socket screw moves the wedge down and the jaws out, pressing the workpieces against the fixtures' fixed stops.

The wedge has a slightly elongated hole allowing for movement to compensate for tolerances.

## Spread width:

M8 =  $\pm 0.5$  mm

M10 =  $\pm 1.0$  mm

M12 =  $\pm 1.0$  mm

M16 =  $\pm 1.5$  mm

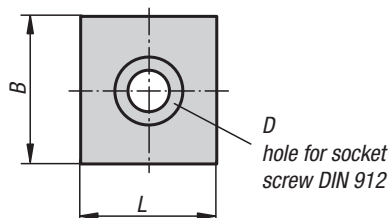
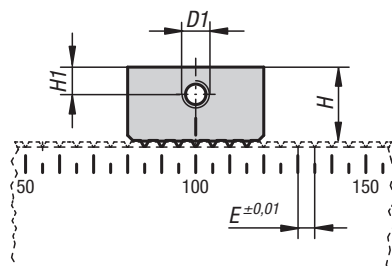
## Drawing reference:

- 1) wedge clamps
- 2) workpiece
- 3) fixed stop
- 4) base plate
- 5) hydraulic/pneumatic cylinder

## KIPP Wedge clamps machinable

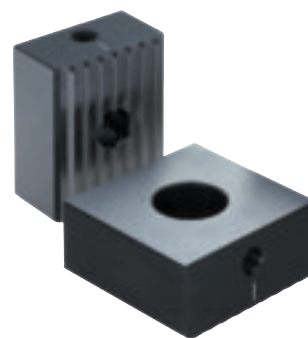
| Order No.  | Version | A<br>min. | A<br>max. | B  | C  | E   | F<br>DIN 6912<br>cap screw | Clamping<br>force<br>kN | Tightening<br>torque<br>Nm |
|------------|---------|-----------|-----------|----|----|-----|----------------------------|-------------------------|----------------------------|
| K0649.3108 | narrow  | 36,5      | 39,5      | 24 | 15 | 2   | M8x25                      | 11                      | 19                         |
| K0649.3110 | narrow  | 42        | 47        | 28 | 19 | 3,5 | M10x25                     | 15                      | 37                         |
| K0649.3112 | narrow  | 54        | 59,5      | 30 | 22 | 3,5 | M12x40                     | 23                      | 65                         |
| K0649.3116 | narrow  | 65        | 72        | 40 | 29 | 4   | M16x60                     | 38                      | 160                        |
| K0649.3208 | wide    | 36,5      | 39,5      | 30 | 15 | 2   | M8x25                      | 11                      | 19                         |
| K0649.3210 | wide    | 42        | 47        | 38 | 19 | 3,5 | M10x25                     | 15                      | 37                         |
| K0649.3212 | wide    | 54        | 59,5      | 48 | 22 | 3,5 | M12x40                     | 23                      | 65                         |
| K0649.3216 | wide    | 65        | 72        | 48 | 29 | 4   | M16x60                     | 38                      | 160                        |

## Stops



### KIPP Stops

| Order No.     | Version | B  | D      | D1 | E   | H  | H1   | L        |
|---------------|---------|----|--------|----|-----|----|------|----------|
| K0905.5000802 | hard    | 24 | M8x25  | M5 | 2,5 | 15 | 6    | 25 ±0,01 |
| K0905.5001202 | hard    | 48 | M12x30 | M8 | 5   | 22 | 8    | 40 ±0,01 |
| K0905.5001602 | hard    | 48 | M16x40 | M8 | 5   | 29 | 12,5 | 40 ±0,01 |
| K0905.5100802 | soft    | 24 | M8x25  | M5 | 2,5 | 15 | 6    | 31 ±0,1  |
| K0905.5101202 | soft    | 48 | M12x30 | M8 | 5   | 22 | 8    | 50 ±0,1  |
| K0905.5101602 | soft    | 48 | M16x40 | M8 | 5   | 29 | 12,5 | 50 ±0,1  |



#### Material:

Carbon steel 1.0503.

#### Version:

Hard stop:

Tempered to 1200-1400 N/mm<sup>2</sup>, black oxidised.

Serrations and stop faces ground, bright.

Soft stop:

Hardness HRC 30, black oxidised. Serrations case hardened and ground, bright.

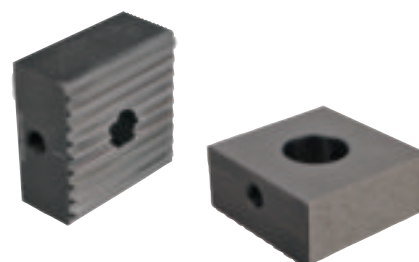
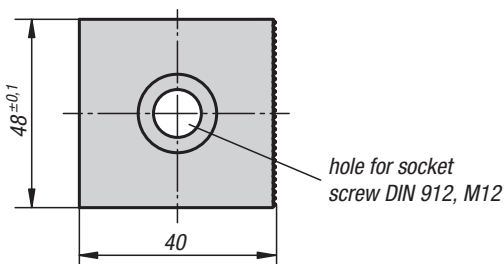
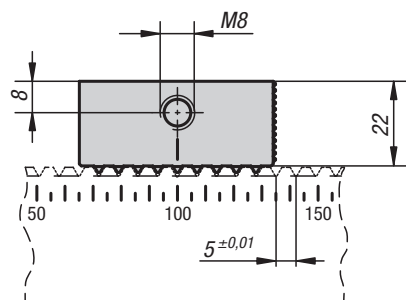
#### Sample order:

K0905.5000802

# K0905

## Stop

carbide-coated and serrated



#### Material:

Carbon steel 1.0503.

#### Version:

Hard stop.

Hardened to 58 ±2 HRC.

Serrations ground, bright.

#### Sample order:

K0905.5201202

#### Note:

One stop face is serrated, the other side is carbide-coated.

### KIPP Stop, carbide-coated and serrated

| Order No.     | Dimensions  |
|---------------|-------------|
| K0905.5201202 | see drawing |

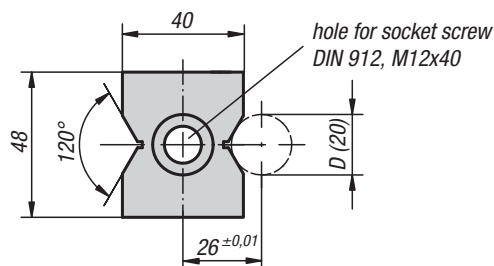
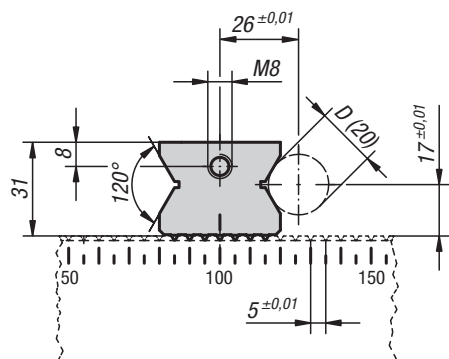
## Stop prism



**Material:**  
Carbon steel 1.0503.

**Version:**  
Prism tempered to 1200-1400 N/mm<sup>2</sup>, black oxidised.  
Serrations and prism ground, bright.

**Sample order:**  
K0906.5001265



### KIPP Stop prism

| Order No.     | D<br>min. - max. |
|---------------|------------------|
| K0906.5001265 | 5 - 33           |

# K0907

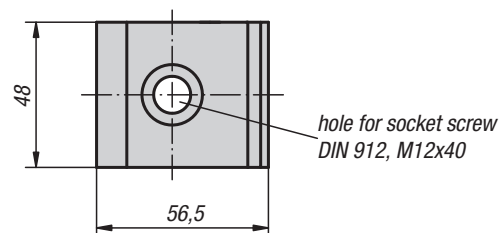
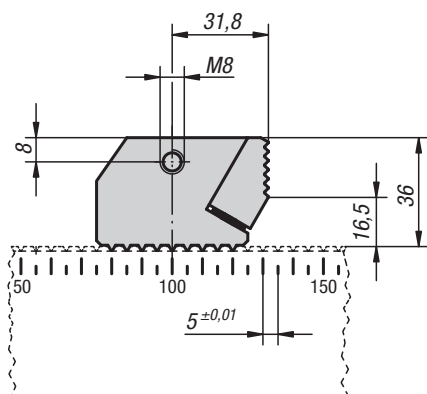
## Stop with positive down force



**Material:**  
Stop and jaw carbon steel 1.0503

**Version:**  
Stop and jaw tempered to 1200-1400 N/mm<sup>2</sup>, black oxidised.  
Serrations ground, bright.

**Sample order:**  
K0907.5001273

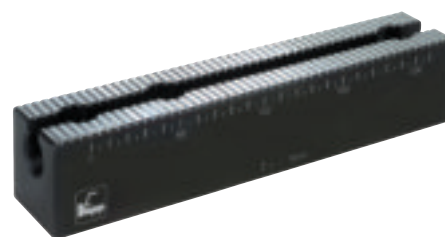


### KIPP Stop with positive down force

| Order No.     | Dimensions  |
|---------------|-------------|
| K0907.5001273 | see drawing |



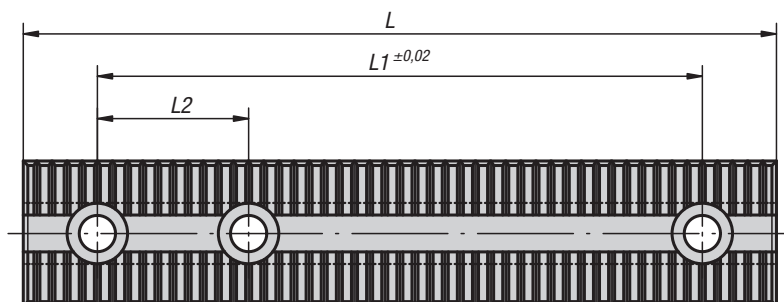
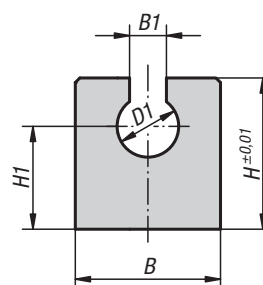
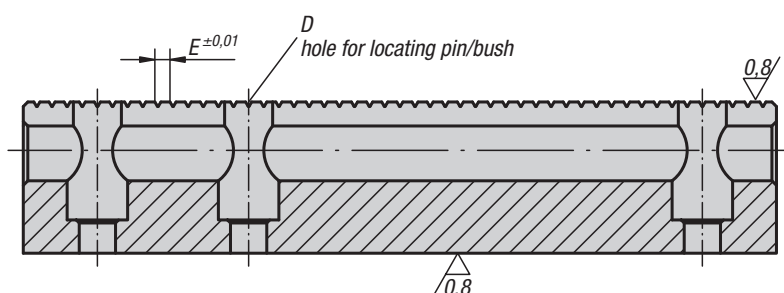
## Base rails



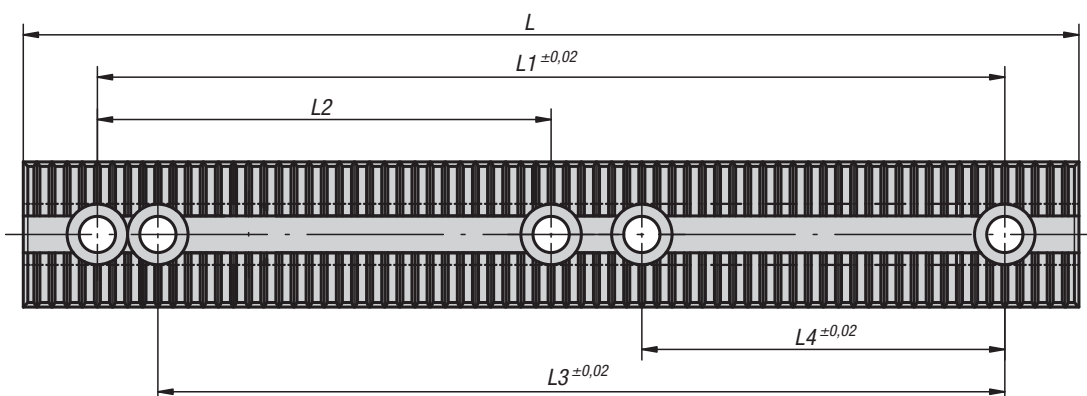
**Material:**  
Carbon steel 1.0503.

**Version:**  
Black oxidised.  
Serrations case hardened and ground.

**Sample order:**  
K0904.5000801



K0904.5021201



### KIPP Base rails

| Order No.     | B  | B1   | D     | D1   | E   | H  | H1 | L   | L1  | L2         | L3  | L4  | weight<br>kg |
|---------------|----|------|-------|------|-----|----|----|-----|-----|------------|-----|-----|--------------|
| K0904.5000801 | 24 | 8,2  | 12 H6 | 14,2 | 2,5 | 40 | 25 | 199 | 150 | 50 ± 0,01  | -   | -   | 1.1          |
| K0904.5001201 | 48 | 12,2 | 12 F7 | 20,2 | 5   | 50 | 34 | 249 | 200 | 50 ± 0,01  | -   | -   | 3.7          |
| K0904.5021201 | 48 | 12,2 | 12 F7 | 20,2 | 5   | 50 | 34 | 349 | 300 | 150 ± 0,02 | 280 | 120 | 5            |
| K0904.5001601 | 48 | 16,2 | 16 F7 | 24,2 | 5   | 63 | 43 | 249 | 200 | 50 ± 0,01  | -   | -   | 4.4          |

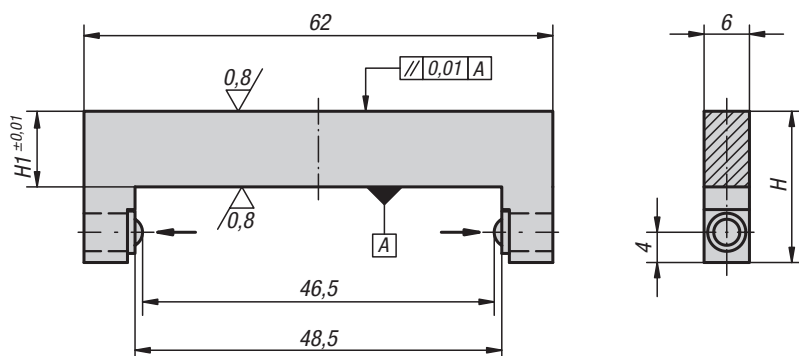
## Seating ledges



**Material:**  
Steel.

**Version:**  
Ledges hardened, black oxidised.  
Contact faces ground, bright.

**Sample order:**  
K0908.5001295



### KIPP Seating ledges

| Order No.     | H  | H1 |
|---------------|----|----|
| K0908.5001295 | 20 | 10 |
| K0908.5001298 | 27 | 17 |

# K0909

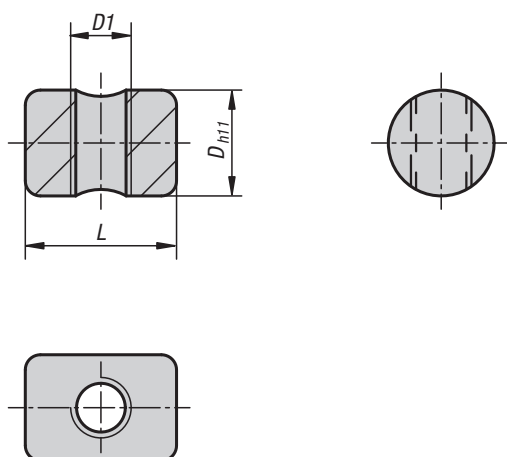
## Keyway nuts round



**Material:**  
Steel.

**Version:**  
Black oxidised.

**Sample order:**  
K0909.0802



### KIPP Keyway nuts round

| Order No.  | D  | D1  | L  |
|------------|----|-----|----|
| K0909.0802 | 14 | M8  | 20 |
| K0909.1202 | 20 | M12 | 30 |
| K0909.1602 | 24 | M16 | 35 |



