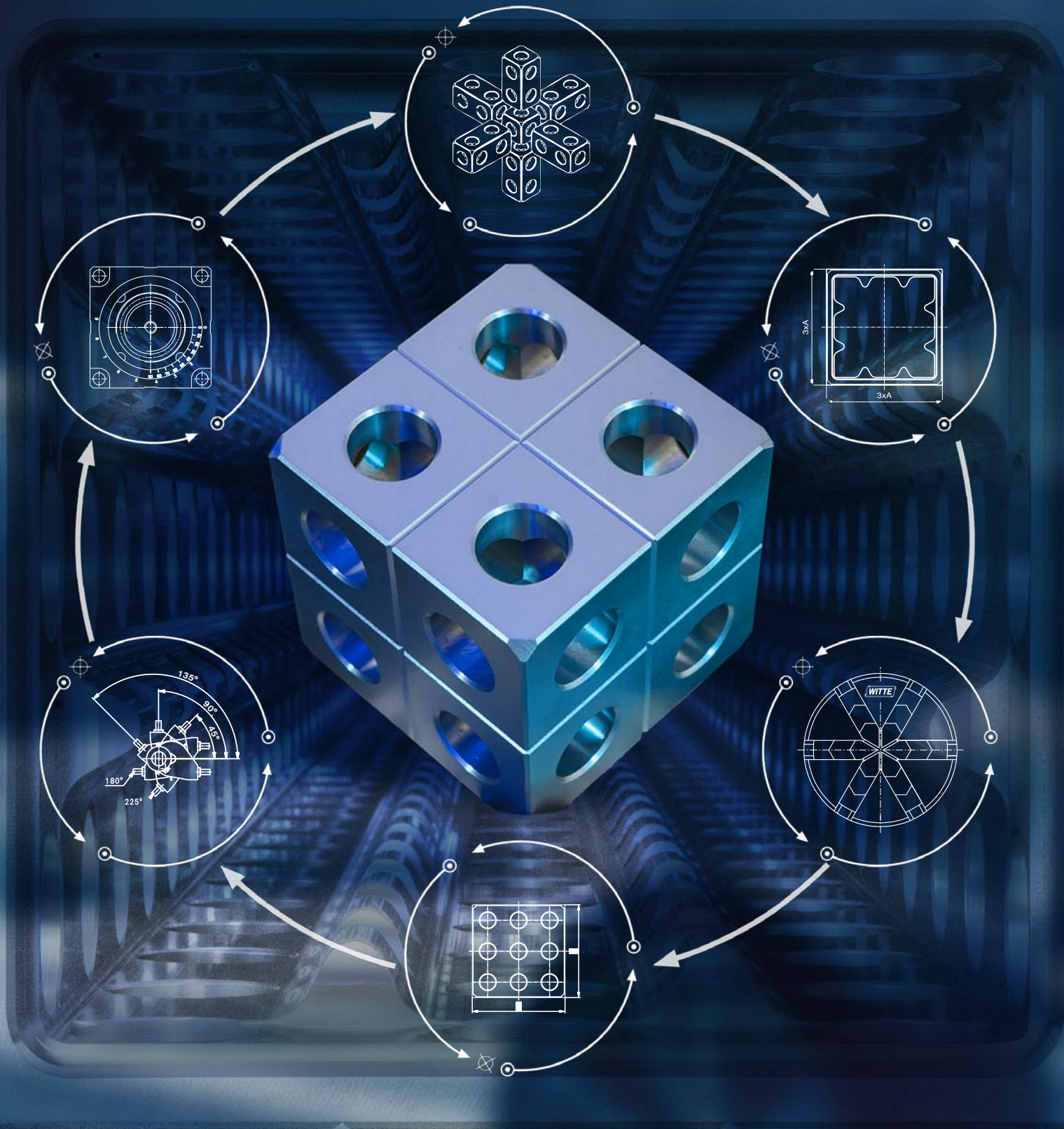


# ALUFIX

Modular Clamping System



Main catalogue 2021 – Witte Barskamp GmbH & Co. KG



# Witte Barskamp KG: Fixed on precision



**F**ounded in 1969 as a production partner for high-precision components in the aerospace industry, Witte is today one of the leading international developers and manufacturers of modular fixturing, positioning and measuring devices as well as feeder systems. With the ALUFIX modular fixturing system and the versatile vacuum clamping systems, Witte is considered the global market leader.

Branches and representative offices in Singapore, Mexico, USA and Brazil as well as an extensive dealer network ensure the worldwide availability of Witte products and services.

Almost all major companies in the automotive and aerospace industries rely on products and application solutions from Witte. In addition, there is a wide range of applications in all industries in which dimensional quality monitoring, economic efficiency and precision play decisive roles.

In the last 50 years, Witte has acquired over 250 patents, utility models and word marks, 70 of which are still valid today. Many of them for ALUFIX - the quality reference for modular clamping system

## Contents

Page	Chapter
6	Base plates and Bars
28	Struts and Angle brackets
30	Quick change couplings
32	Adjustment elements
52	TopPos
68	V blocks and Delta blocks
74	Screw-jacks and Top sections
86	Clamping elements
102	Connection elements
120	Tools
122	Basic sets
138	Vacuum foot and Software
142	Fixture building
160	Index

## Legend

Unless otherwise defined, all dimensions are given in millimeters and weights in grams.

ALUFIX elements are made of high-tensile aluminum EN AW 7075, "Eco" versions are made from EN AW 6083.

The surface is anodized, the standard color is "natural", versions in black are alternative.

Other colors on request.

ALUFIX preferred range marking



Green: Item is available immediately.

C: Classic version

E: Eco version

C·E: Classic or Eco

■: Color "natural"

■: FColor "black"

**C** Example: Item is available immediately in the Classic, natural anodized version.

**E** Example: Article is available immediately in the Eco, black anodized version.

# Modular precision and systematic flexibility

ALUFIX from Witte is the worldwide proven clamping and fixturing system for reproducible workpiece fixtures in dimensional measurement and manufacturing technology.

Made from high-tensile aluminum (ALUFIX Classic: EN AW 7075, ALUFIX Eco: EN AW 6083), it guarantees the best material quality, durability and resilience.

## Reproducible and retoolable

Fixtures implemented using ALUFIX can be reliably assembled. Consistent implementation of the modular system allows unlimited, long-term multiple use of practically all standard elements built into devices.

## System sizes and designs

ALUFIX is available in four system sizes:

- for holding and optical measurement of small parts,
- for fixtures for small to medium size parts,
- for medium-sized to large fixtures for assemblies, meisterbocks etc.
- as well as for the support of large and heavy parts.

In addition to the ALUFIX Classic version made of high-tensile aluminum, Witte's ALUFIX Eco is a particularly economical variant of the system made of medium-tensile aluminum for normal use and moderate part change intervals.

All basic elements of the clamping and fixing system are also available anodized black.

They are specially designed for use with optical scanning systems.

All ALUFIX system elements follow a uniform concept, are unreservedly downward compatible and at the same time secure the basis for future expansion.



### 100% Compatibility

- overall system upwards and downwards compatible
- all system sizes can be combined with one another
- no weight and size limits
- existing systems and clamping aids can be integrated

### 100% Continuity

- ALUFIX has existed for more than 35 years
- the basic design idea has always been maintained
- future expansion will also follow this principle

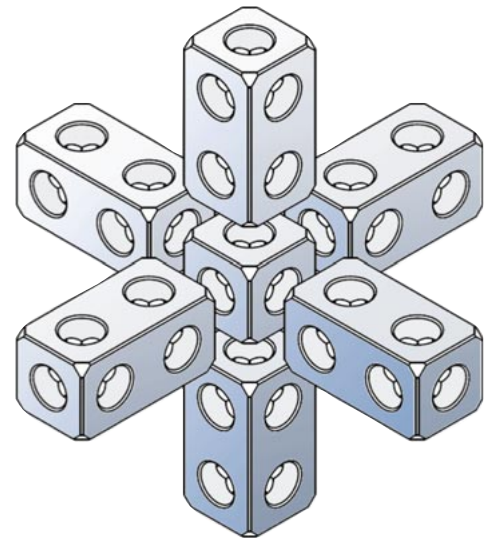
### 100% Availability

- over 90 percent of the components are in stock
- dispatch within 24 hours
- Witte's own, flexible production with high depth of manufacturing
- worldwide service network

### Features and benefits

- highest precision through fine machining of components on all sides
- made of high-strength aluminum EN AW 7075 (ALUFIX Classic)
- extremely light and highly resilient
- high stability with extremely low weight
- corrosion-resistant and maintenance-free
- wear-resistant thanks to anodized coating on all sides
- system sizes can be combined
- available in four system sizes
- low space requirement due to well-thought-out variety of components
- no weight and size limits of workpieces to be mounted
- completely reproducible
- long-term multiple use thanks to reusable components
- no special assembly tools required
- parts library for all CAD systems
- free user training at Witte

# The ALUFIX principle: ingenious from the base up



Six sides, eight corners, twelve edges: the starting shape and basic element of the ALUFIX system geometry is the cube. All other element configurations are created by multiplying this basic shape - with through bores on all surfaces creating connection options on all sides. Each hole is suitable for both positioning and fixing.

The ALUFIX element geometry ensures that the grid is precisely maintained in all directions and across any number of joins.

## Creation of the ALUFIX element geometry



- starting point



- through bore on all surfaces



- chamfers on all edges



- bevels on all corners



- sectional view

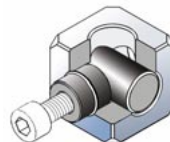
## Connection technology



- sleeve for positioning



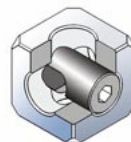
- crosspiece nut to screw in



- sleeve, nut and screw



- twin bolt for positioning



- lock to secure



- lock and twin bolt

# The ALUFIX application and system diversity

## ALUFIX elements are used for

- measuring fixtures
- holding fixtures
- checking gauges
- assembly and welding fixtures
- meisterbocks
- support structures for cubings and gauges

## As well as

- in prototype building
- in model making
- in design development as support for clay models

### Versions

**ALUFIX Classic**  
Made of high-tensile aluminum for the highest demands on load, stability, durability and accuracy.

**ALUFIX Eco**  
Made of medium-tensile aluminum as an inexpensive alternative for normal use and moderate part change intervals.

## System sizes

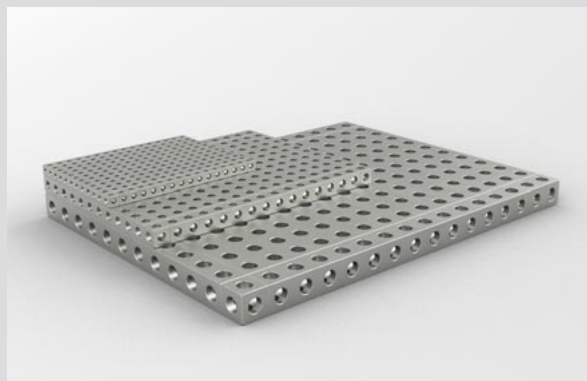
- AF 16 for holding and optical measurement of small parts
- AF 25 for fixtures for small to medium size single parts
- AF 40 for medium-sized to large fixtures for assemblies, meisterbocks etc.
- AF 50 for the support of large and heavy parts

## Element groups

- Basic elements
  - plates, structure plates, plate areas
  - bars, struts, angle brackets
- Adjustment elements
  - slides, rocker, jacks, rotary plates
- Contact elements
  - spheres, cones, prisms, contour blocks
- Clamping elements
  - hold-down springs, toggle clamps, clamps, keyless chucks, vises, magnets
- Connection elements
  - couplings, quick connectors, screw connectors

# Alufix base plates

## The proven base for multiple fixtures



### The dimensions: precise variety

ALUFIX base plates are available in Witte system sizes 16, 25 and 40. Standard dimensions and base plates from the preferred range can be found on the following pages. Information on other dimensions is available on request.

### Aluminum material: Strong and light

ALUFIX base plates are milled from high-tensile aluminum alloys.

#### Materials:

- EN AW 7075 for ALUFIX Classic base plates
- EN AW 6083 for ALUFIX grid base plates Eco

ALUFIX elements can be anodized in different colors.

The color "natural" is standard, "black" is available as an alternative - for Classic add "-1" to the article number, for Eco add "1" when ordering.

Other colors on request.

ALUFIX base plates are mainly used for small and medium sized fixtures. The plates are rigid, precise and offer the greatest freedom in assembly, as the entire surface can be used - in contrast to frame type fixtures construction made of profiles, which are suitable for larger structures. ALUFIX base plates are available in two versions:

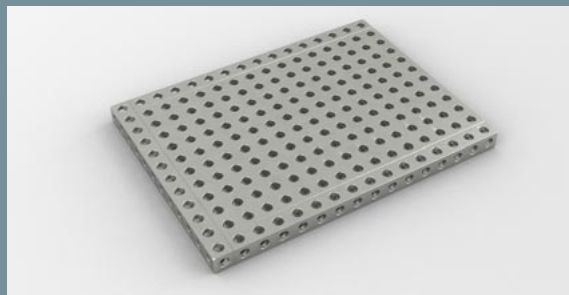
#### ALUFIX Classic base plates

with mounting holes on all 6 sides.

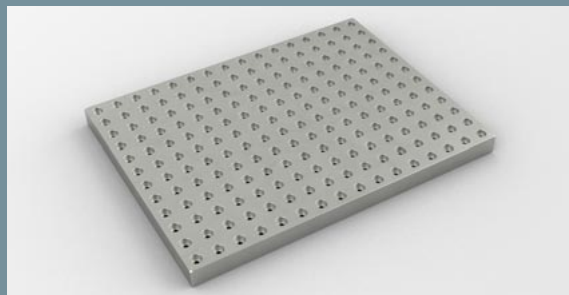
#### ALUFIX grid base plates

with mounting holes only on the surface, in Eco design.

#### ALUFIX Classic base plate:



#### ALUFIX grid base plates Eco:





## ALUFIX Classic Base plates

**AF 16 Classic,**  
Grid (A) 16, hole-diameter 8 mm

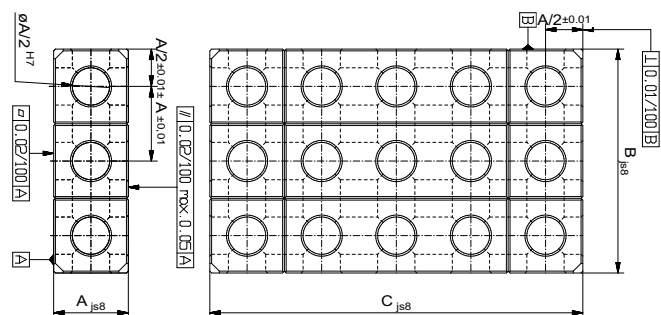
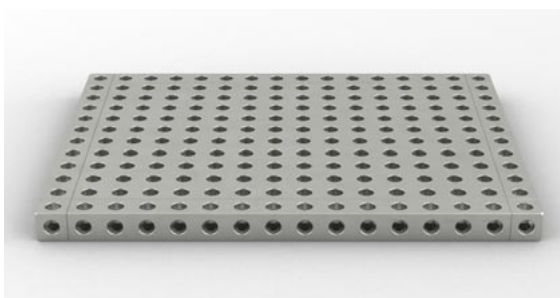
Nr.	A	B	C	h
22093	16	32	32	27
<b>C</b> 22094	16	32	48	40
<b>C</b> 22095	16	32	64	53
<b>C</b> 22096	16	32	80	100
<b>C</b> 22932	16	32	96	80
22931	16	32	112	93
<b>C</b> 20652	16	32	160	131
20653	16	32	320	300
22930	16	64	96	160
21566	16	64	112	187
22929	16	64	128	214
21567	16	80	112	234
22928	16	80	128	267
21568	16	80	144	305
22926	16	80	160	335
<b>C</b> 21569	16	96	96	242
21570	16	96	112	282
21571	16	96	128	325
21572	16	96	144	375
21573	16	96	160	240
22924	16	96	176	447
22907	16	96	192	482
21574	16	112	240	703
21575	16	128	128	431
21576	16	128	144	475
21577	16	128	256	862
21579	16	160	192	804
21578	16	160	320	1.400
21580	16	192	256	1.298
21581	16	192	320	1.611
20112	16	240	240	1.510
22097	16	320	320	1.350
28076	16	384	384	3.812

**AF 25 Classic,**  
Grid (A) 25, hole-diameter 12,5 mm

Nr.	A	B	C	h
<b>C</b> 21703	25	50	50	100
<b>C</b> 21704	25	50	75	150
<b>C</b> 21705	25	50	100	200
<b>C</b> 21706	25	50	125	250
<b>C</b> 22957	25	50	150	302
<b>C</b> 22959	25	50	200	403
<b>C</b> 22885	25	50	250	503
21707	25	50	500	1.009
21488	25	100	125	506
28032	25	100	150	600
21347	25	100	175	708
21496	25	125	125	630
21348	25	125	175	888
21349	25	125	225	1.135
21350	25	150	150	908
21351	25	150	175	1.048
21352	25	150	200	1.211
21353	25	150	225	1.348
21354	25	150	250	1.523
21355	25	175	375	2.606
21356	25	200	200	1.617
21357	25	200	225	1.826
28033	25	200	300	2.590
21358	25	200	400	3.246
<b>C</b> 21360	25	250	300	3.035
21359	25	250	500	5.061
<b>C</b> 21361	25	300	400	4.860
21362	25	300	500	6.068
22911	25	400	500	8.200
22915	25	400	600	9.900
22913	25	500	500	10.250
22919	25	600	600	14.900
22921	25	600	800	19.900
20280	25	600	1000	24.700

**AF 40 Classic,**  
Grid (A) 40, hole-diameter 20 mm

Nr.	A	B	C	h
<b>C</b> 21698	40	80	80	410
<b>C</b> 21699	40	80	120	619
21700	40	80	160	825
<b>C</b> 21701	40	80	200	1.031
22909	40	80	240	1.239
22910	40	80	280	1.440
22906	40	80	320	1.647
21702	40	80	800	4.125
<b>C</b> 22862	40	160	200	2.027
22861	40	160	240	2.486
21257	40	160	280	2.900
22860	40	200	200	2.568
22842	40	200	240	3.092
21258	40	200	280	3.600
22843	40	200	320	4.123
21259	40	200	360	4.638
22851	40	200	400	5.153
21260	40	240	240	3.670
21261	40	240	280	4.291
21262	40	240	320	4.904
21263	40	240	360	5.517
21264	40	240	400	6.133
22839	40	280	320	5.800
22900	40	280	360	6.500
21265	40	280	600	10.900
21266	40	320	320	6.539
21267	40	320	360	7.356
21268	40	320	640	13.078
21269	40	400	480	12.500
21303	40	400	800	21.000
21270	40	480	640	20.200
21271	40	480	800	24.800
28079	40	800	800	41.000



**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"



Application example: Fixture for a cylinder block on an ALUFIX Classic base plate

## ALUFIX grid base plates Eco

### ALUFIX 25 Eco

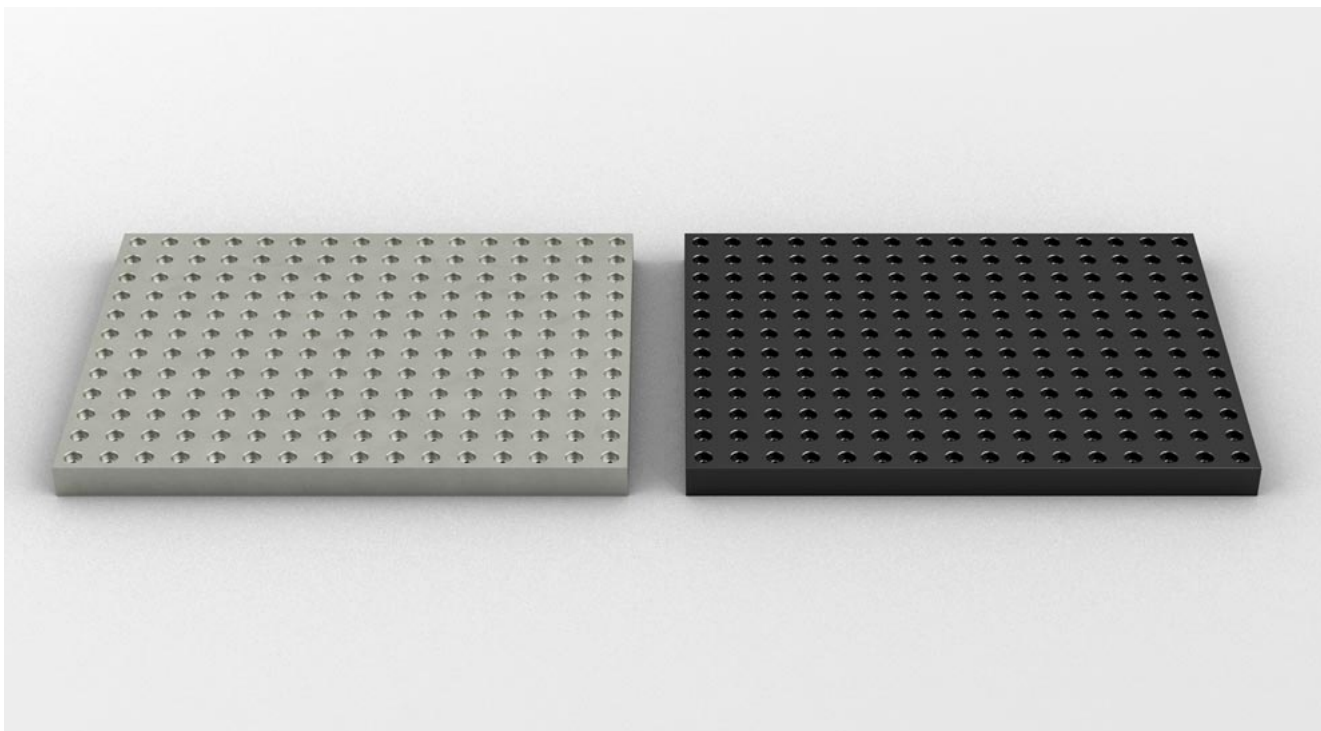
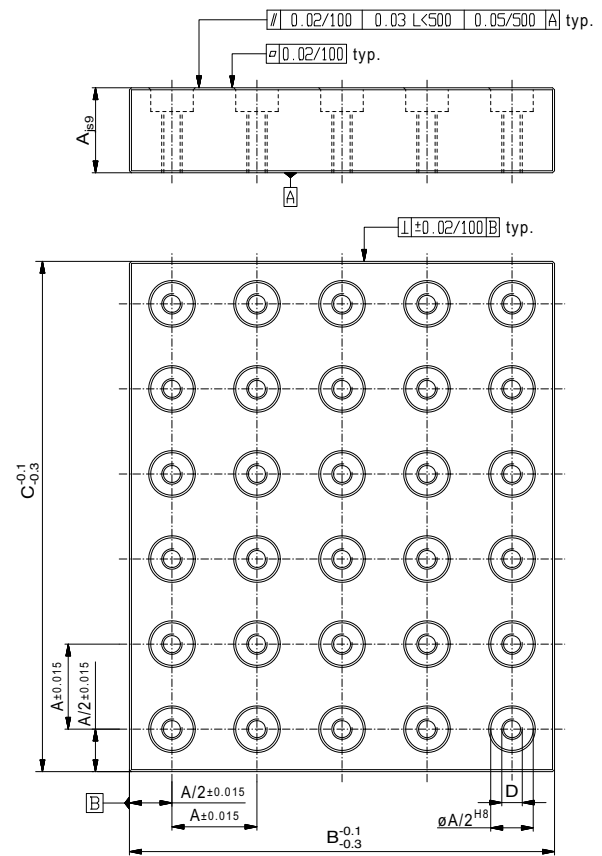
Grid(A) 25, hole-diameter 12,5 mm

Nr.	A	B	C	D	g
20387-E	25	200	400	M6	5.400
20388-E	25	250	500	M6	8.438
20403-E	25	300	400	M6	8.100
20386-E	25	300	600	M6	11.250
22923-E	25	400	500	M6	13.500
22925-E	25	400	600	M6	16.200
20439-E	25	500	500	M6	16.875
20381-E	25	500	1000	M6	33.750
20382-E	25	600	600	M6	24.300
20384-E	25	600	800	M6	32.400

### ALUFIX 40 Eco

Grid(A) 40, hole diameter 20 mm

Nr.	A	B	C	D	g
20650-E	40	320	640	M10	22.118
20651-E	40	400	800	M10	34.560
20710-E	40	480	640	M10	33.177
20711-E	40	480	960	M10	49.766
20713-E	40	640	800	M10	55.296
20714-E	40	640	960	M10	66.355
20715-E	40	800	800	M10	69.120
20808-E	40	800	1600	M10	138.240
20809-E	40	960	960	M10	99.533
20810-E	40	960	1280	M10	132.710



ALUFIX grid base plates Eco can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "1" to the article number when ordering. Other colors on request.

## ALUFIX Precision Grid Base Plates

- Witte Alufix base plates provide a versatile and absolute precise base for repeatable measurements of clamped workpieces and fixtures.
- Individually configured to best fit your measurement volume, your measurement system or your fixture size.
- Designed to accommodate various and changing clamping configurations.
- Universally compatible to all Alufix modular system components as well as other non-Witte systems\*

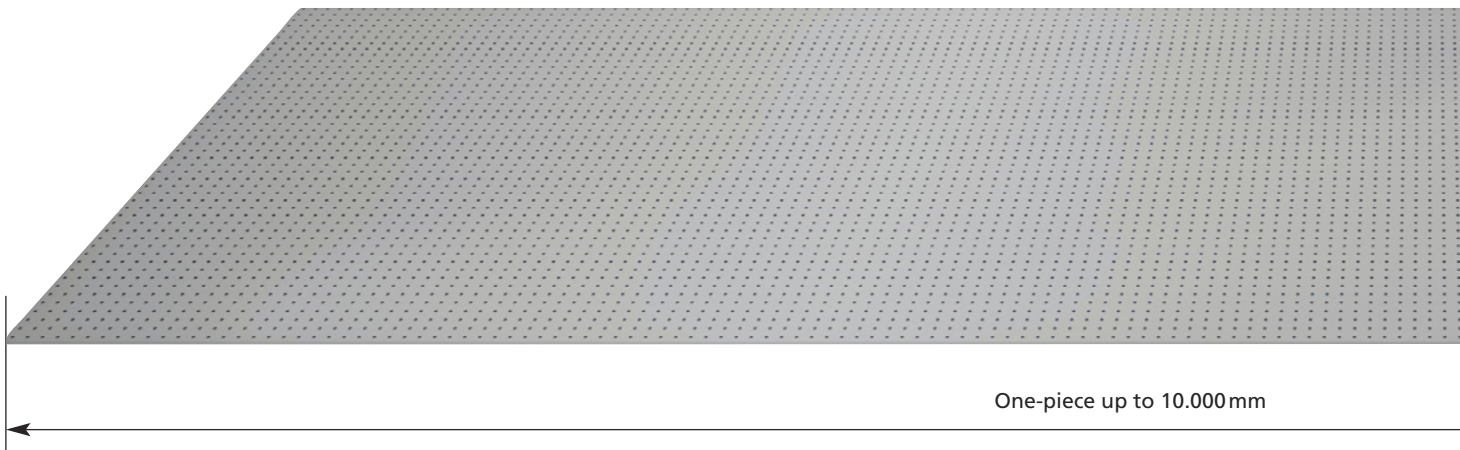
\*considering a non-Witte system having the same or smaller thread size and precision bore diameter.

### Universal design, individual solution

Witte precision grid base plates are designed to be used on CMM tables. With according size options, mounting through holes and designated eye bolt threads for safe lifting and handling. The plates provided are efficiently suitable for all common CMM tables and optical measurement systems as well as fixtures even as the standard pre-configured versions.

Individual user specific requests range in combination of different grid spacing, plate thickness, length and width, surface treatment and plate surface type.

Whether used as a large universal grid base plate or base of a small part holding fixture: Alufix grid base plates provide the needed precision and stability for your reliable and perfect measurement result. At all conditions, with the flexibility ensured. Proven over a thousand times...



#### Grid spacing

- var. Per customer request
- 200
- 100
- 50
- 25

#### Grid holes

- Precision hole and thread as a bushing
- Precision hole as a bushing, thread in plate material
- Precision hole and thread in plate material
- Precision hole as exchangeable bushing

#### Version

- One-piece
- Multi-piece

#### Handling

- Hoist rings / eye bolts  
From 600 x800 mm
- Handle  
Up to 600 x800 mm
- Fork lift pockets

**Perfect pre-configured::**

- Dimensions from 200x400 mm to 2.5x10 m
- Plate thickness options 20 / 25 / 30 mm
- Grid spacing 50 / 100 mm
- High precision bores with thread
- Plate mounting through holes
- Surface treatment black or clear anodizing
- Boltable handles or eye bolts (from plate size 600 x 800 mm)
- Plant quality certificate
- Delivery time approx. 6 weeks

**Available special options:**

- Feet, with or without frame
- Individual grid spacing and bushings
- Special surface treatment – hard anodized (extra thick coating)
- traceable test report

**Uniquely versatile: size variable high-precision bores**

The innovative solution of having size variable high-precision bores makes the Witte grid base plates the **most flexible and versatile bases of their kind.**

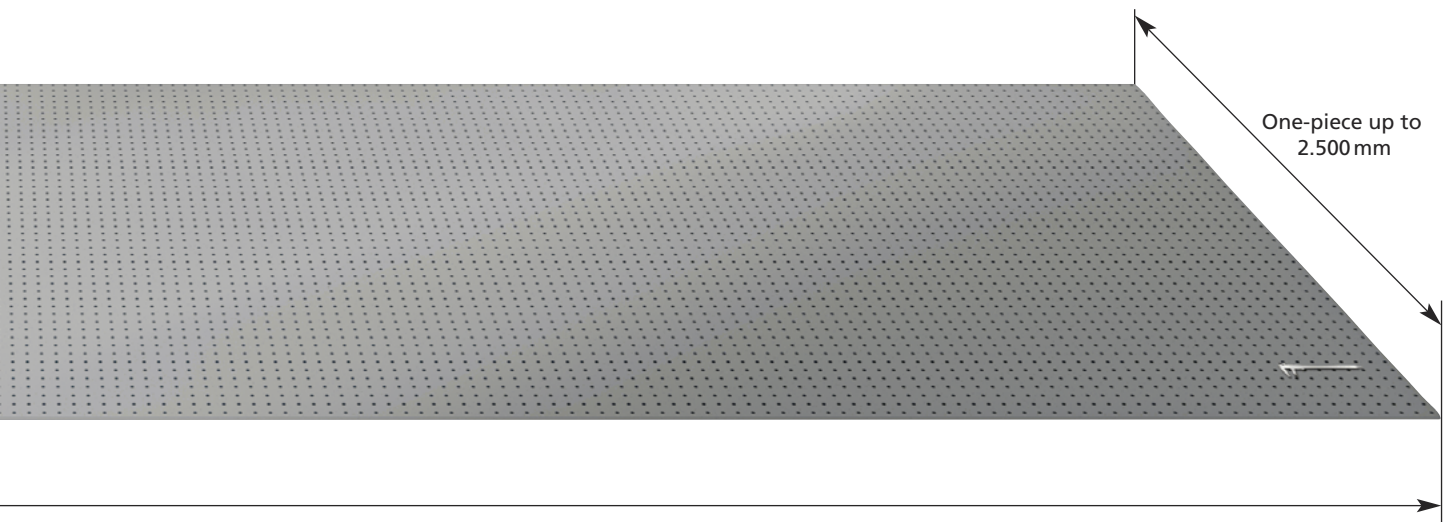


Previously not available: Size variable bushing inserts with precision bore and thread.

The precision bores in the top surface of the plate offer a unique optional benefit: **boltable inner-diameter and thread reducing bushings.**

This enables the option to have a large and changing variety and also user-specific, but most importantly precisely repeatable, clamping configuration.

Irrelevant of the hole diameter and clamping system used.



**Surface-treatment**



Clear or black anodizing



Hard anodized (extra thick coating)

**Plate surface**



Even to floor



Resting on



On feet

**Labels**



Letter and number grid markings



Individual customer request

**Documentation**



Plant certificate



Traceable test report

= Standard/pre-configured

= Option/Individual

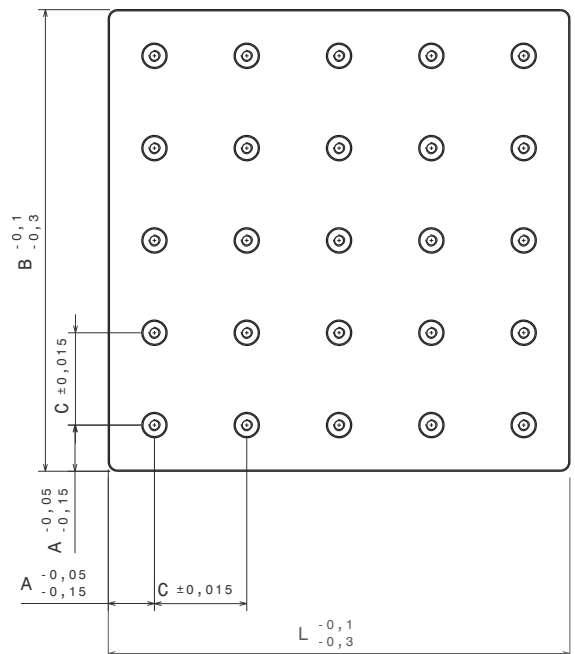
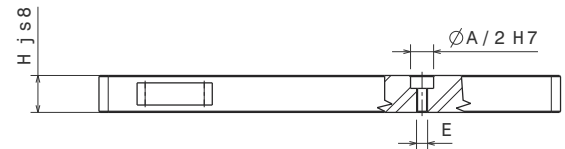
## ALUFIX Precision Grid Base Plates

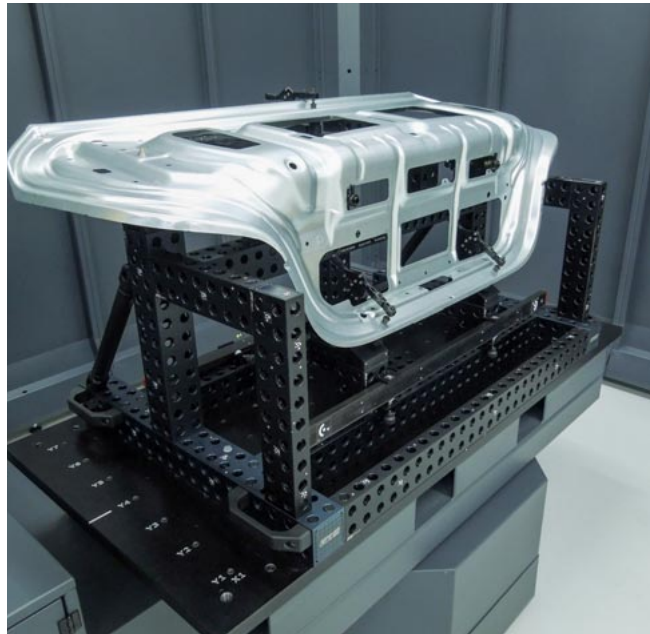
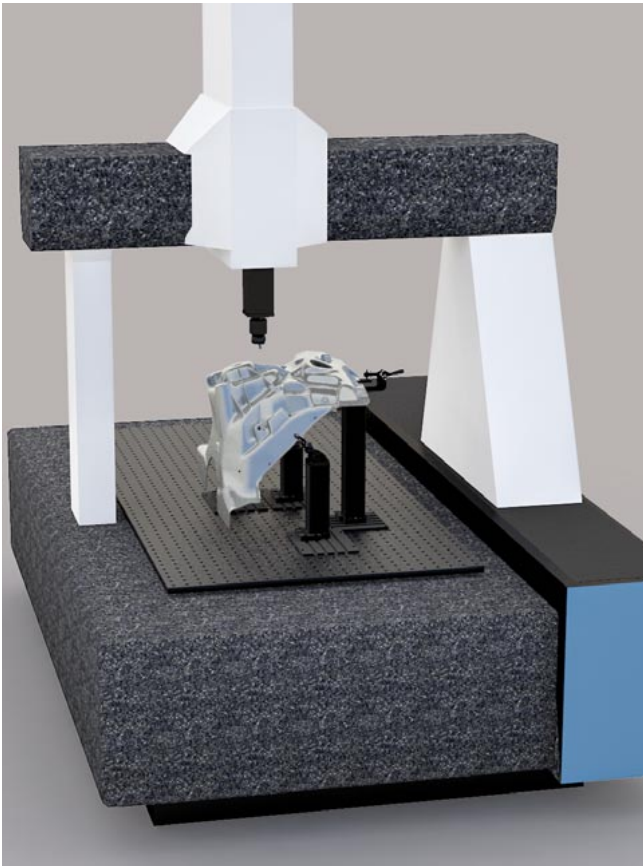
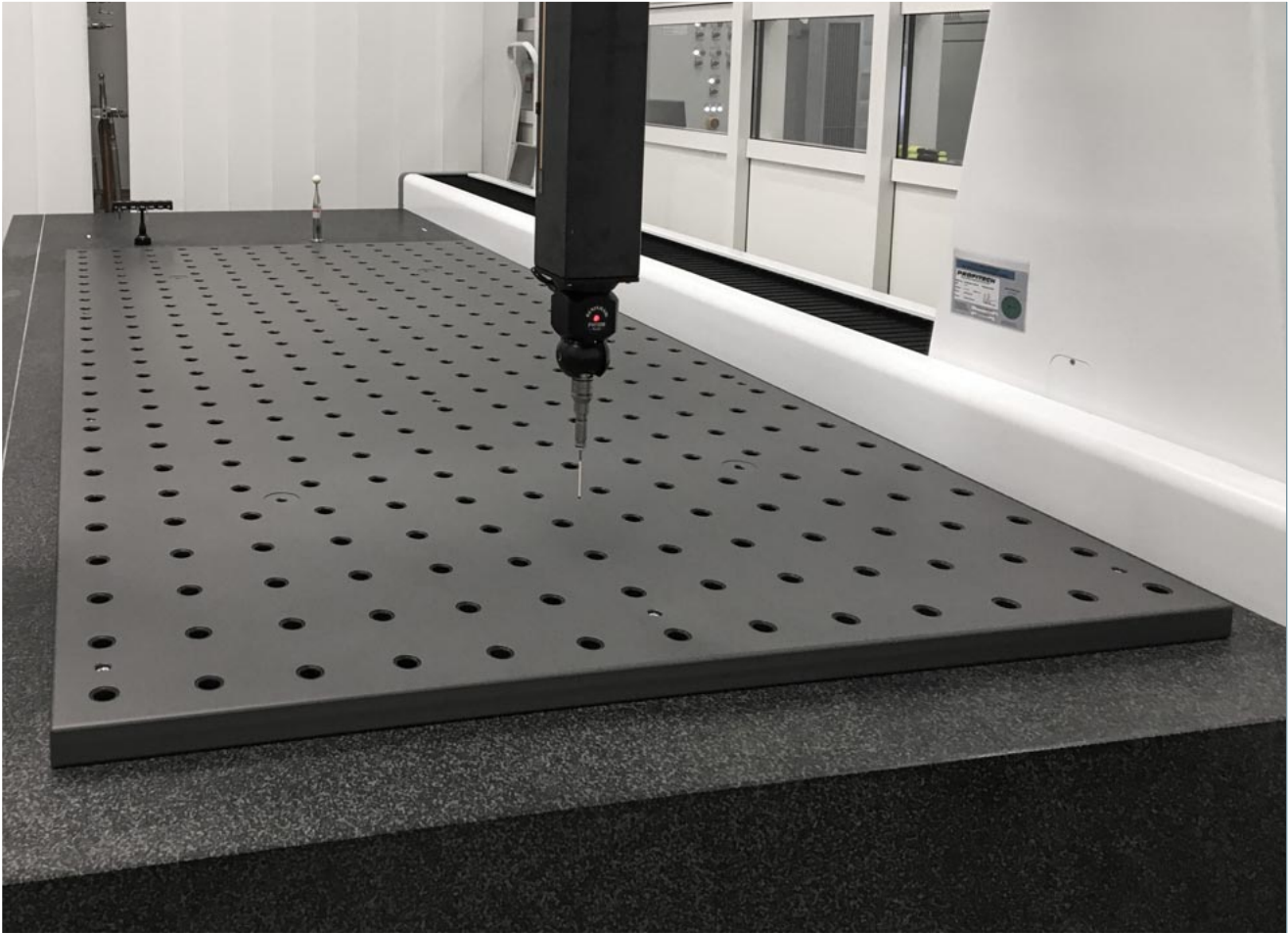
### ALUFIX 25 Precision Grid Base Plates Grid (C): 50, Thread (E): M6, Witte-system (A): 25

Nr.	B	L	H
124367	200	400	20
124500	250	250	20
124368	250	500	20
124501	300	400	20
124369	300	600	20
124502	400	500	20
124503	400	600	20
124504	500	500	20
124370	600	600	20
124505	600	800	20
124371	500	1000	25
124506	700	700	25
124507	700	800	25
124508	700	900	25
124509	700	1000	25
124510	900	1200	25
124511	900	1300	25
124512	900	1600	25
124513	1000	1200	25
124514	1000	1600	25
124515	1200	1800	25
124516	1200	2400	25
124517	1200	3000	25
124518	1200	4200	25
124519	1600	2400	25
124520	1600	3000	25
124521	1600	4200	25
124522	2000	2400	25
124364	2000	3000	25
124523	2000	4200	25
124524	2100	3200	25
124525	2100	4400	25

### ALUFIX 40 Precision Grid Base Plates Grid (C): 100, Thread (E): M10, Witte-system (A): 40

Nr.	B	L	H
124377	500	1000	30
124378	600	600	30
124379	600	800	30
124380	700	700	30
124381	700	800	30
124382	700	900	30
124383	700	1000	30
124384	900	1200	30
124385	900	1300	30
124386	900	1600	30
124387	1000	1200	30
124388	1000	1600	30
124389	1200	1800	30
124390	1200	2400	30
124391	1200	3000	30
124392	1200	4200	30
124393	1600	2400	30
124394	1600	3000	30
124395	1600	4200	30
124396	2000	2400	30
124397	2000	3000	30
124398	2000	4200	30
124399	2100	3200	30
124400	2100	4400	30





# ALUFIX Bars

## Link between base and contact point

### ALUFIX Bar Classic :



### ALUFIX Bar Light Classic:



### ALUFIX Bar Light Eco:



### The dimensions: precise variety

ALUFIX Classic bars are available in Witte system sizes 16, 25 and 40.

Standard dimensions and bars from the preferred range can be found on the following pages, we will gladly provide information on other dimensions on request.

ALUFIX Light bars are available in Witte system sizes 25, 40 and 50.

Standard dimensions and bars from the preferred range can be found on the following pages, we will gladly provide information on other dimensions on request.

There are two kinds of ALUFIX bars:

#### ALUFIX Bar Classic

Alufix full bars are suitable for building small to medium size fixtures as a link between base and workpiece contact point. They can be connected on all 6 sides using quick or screw connection technology and are extremely flexible for all kinds of applications. The sizes listed are standard, other dimensions on request.

#### ALUFIX Bar Light Classic

For larger structures and as a basis for frame type fixtures. The use of a specially developed extruded profile in combination with milling processes ensures stability, accuracy and low weight.

The ALUFIX Light Bars are also available in the Eco version.

### Aluminum material: Strong and light

ALUFIX bars are milled from high-tensile aluminum alloys.

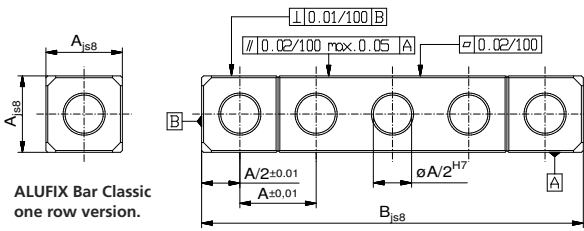
#### Materials:

- EN AW 7075 for ALUFIX Bars Classic
- EN AW 7075 for ALUFIX Bars Light Classic
- EN AW 6083 ALUFIX Bars Light Eco

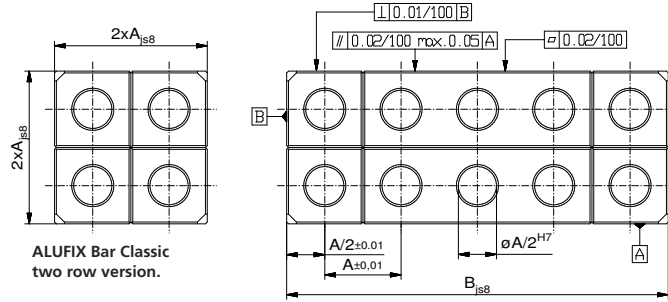
ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - for Classic add "-1" to the article number, for Eco add "1" when ordering. Other colors on request.



## ALUFIX Full Bars Classic



ALUFIX Bar Classic one row version.



ALUFIX Bar Classic two row version.

### AF16 Classic

One row bars, 16x16 mm  
Grid (A) 16, hole diameter 8 mm

Nr.	B	g
21582	16	7
<b>C</b> 21583	32	14
<b>C</b> 21584	48	21
<b>C</b> 21585	64	27
<b>C</b> 21586	80	33
<b>C</b> 20654	96	39
20801	128	53
<b>C</b> 20799	160	66
21587	320	140

### AF16 Classic

Two row bars, 32x32 mm  
Raster (A) 16, hole diameter 8 mm

Nr.	B	g
21588	32	53
21589	48	79
21590	64	108
21591	80	131
23892	96	160
20812	112	200
20848	128	230
20849	160	268
21592	320	537

### AF25 Classic

One row bars, 25x25 mm  
Grid (A) 25, hole diameter 12,5 mm

Nr.	B	g
<b>C</b> 21372	25	25
<b>C</b> 21373	50	51
<b>C</b> 21374	75	76
<b>C</b> 21375	100	102
<b>C</b> 21376	125	127
<b>C</b> 22961	150	152
<b>C</b> 22963	200	204
<b>C</b> 22882	250	255
21377	500	510

### AF25 Classic

Two row bars, 50x50 mm  
Grid (A) 25, hole diameter 12,5 mm

Nr.	B	g
<b>C</b> 21378	50	204
<b>C</b> 21379	75	308
<b>C</b> 21380	100	410
<b>C</b> 21381	125	510
<b>C</b> 22965	150	610
22967	200	819
22883	250	1.025
21382	500	2.020
22634	1000	4.030

### AF40 Classic

One row bars, 40x40 mm  
Grid (A) 40, hole diameter 20 mm

Nr.	B	g
21273	40	104
<b>C</b> 21274	80	208
21279	120	404
<b>C</b> 21275	160	419
21276	200	523
20813	240	628
20815	320	1.098
20814	400	1.046
21304	800	2.947

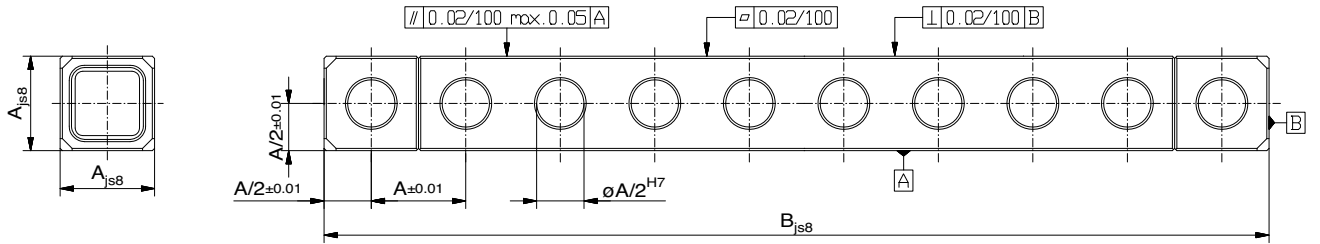
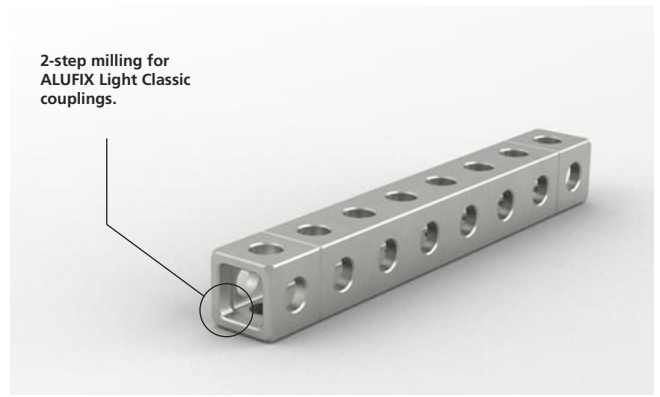
### AF40 Classic

Two row bars, 80x80 mm  
Grid (A) 40, hole diameter 20 mm

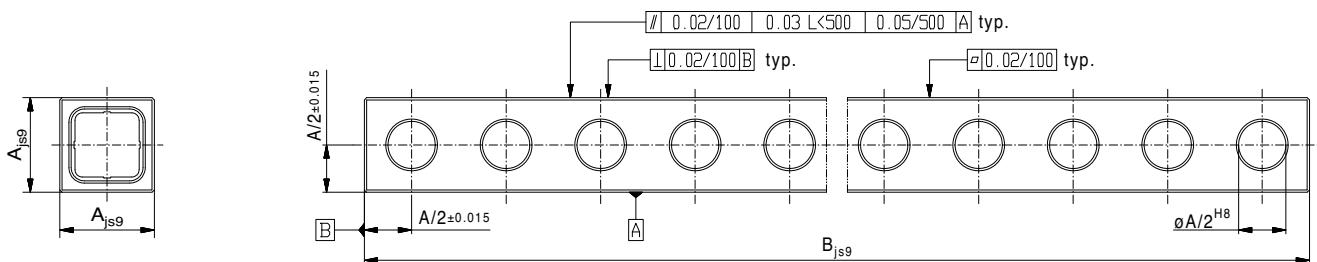
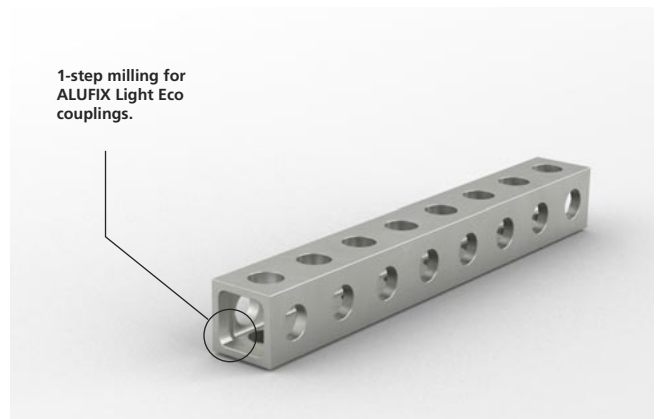
Nr.	B	g
<b>C</b> 21298	80	840
21299	120	1.257
21300	160	1.682
<b>C</b> 21301	200	2.080
20817	240	2.511
20818	280	2.900
20434	320	3.357
20435	400	4.150
21302	800	8.411

**C·E** ALUFIX preferred range  
Green: Item is available immediately.  
C: Classic version, E: Eco version, CE: Classic or Eco  
■: color "natural", ■: color "black"

## ALUFIX Bar Light Classic one row



## ALUFIX Bar Light Eco one row



**AF25 Light Classic/ Eco**

Bars one row, 25x25 mm

Grid (A) 25, hole diameter 12,5 mm

	Nr.(Eco)	B	g
E	24340(-E)	50	34
E	25013(-E)	100	69
E	25374(-E)	150	103
	24336(-E)	200	138
	22946(-E)	250	172
	24337(-E)	300	206
	25012(-E)	350	241
	23283(-E)	400	275
	25890(-E)	450	310
	22947(-E)	500	344
	25894(-E)	550	378
	21333(-E)	600	413
	24338(-E)	650	447
	24339(-E)	700	482
	21709(-E)	750	516
	24189(-E)	800	550
	27470(-E)	850	585
	25895(-E)	900	619
	27473(-E)	950	654
	22948(-E)	1000	688
	27605(-E)	1050	722
	24190(-E)	1100	757
	33282(-E)	1150	791
	24191(-E)	1200	826
	21749(-E)	1250	860
	24188(-E)	1300	895
	33283(-E)	1350	929
	24187(-E)	1400	963
	31855(-E)	1450	998
	21189(-E)	1500	1.032
	33284(-E)	1600	1.101
	33285(-E)	1700	1.170
	24395(-E)	1800	1.238
	33286(-E)	1900	1.307
	23334(-E)	2000	1.376

**AF40 Light Classic/ Eco**

Bars one row, 40x40 mm

Grid (A) 40, hole diameter 20 mm

	Nr.(Eco)	B	g
	25039(-E)	120	221
	25377(-E)	160	294
	26505(-E)	200	368
	25378(-E)	240	441
	27342(-E)	280	514
	25379(-E)	320	588
	27183(-E)	360	661
	23549(-E)	400	735
	24945(-E)	440	809
	25945(-E)	480	882
	25951(-E)	520	956
	26611(-E)	560	1.029
	27444(-E)	600	1.103
	33296(-E)	640	1.176
	26612(-E)	680	1.250
	28465(-E)	720	1.323
	32702(-E)	760	1.397
	23550(-E)	800	1.470
	26610(-E)	840	1.544
	26613(-E)	880	1.617
	26685(-E)	920	1.691
	27445(-E)	960	1.764
	24495(-E)	1000	1.838
	26686(-E)	1080	1.985
	27559(-E)	1160	2.132
	23551(-E)	1200	2.206
	24453(-E)	1400	2.570
	23552(-E)	1600	2.941
	25033(-E)	1800	3.308
	23553(-E)	2000	3.676
	23554(-E)	2400	4.411
	23555(-E)	2800	5.146

**AF50 Light Eco**

Bars one row, 50x50 mm

Grid (A) 50, hole diameter 25 mm

	Nr.	B	g
	28149-E	50	165
	28150-E	100	330
	28151-E	150	445
	28152-E	200	660
	28153-E	250	825
	28154-E	300	990
	28156-E	350	1.155
	28155-E	400	1.320
	28157-E	450	1.485
	26933-E	500	1.650
	28615-E	600	1.990
	28495-E	700	2.310
	33297-E	800	2.240
	32654-E	900	2.985
	26935-E	1000	3.328
	28939-E	1100	3.630
	33298-E	1200	3.960
	27693-E	1300	4.290
	33299-E	1400	4.648
	26937-E	1500	4.950
	28618-E	1600	5.335
	33300-E	1700	5.638
	30012-E	1800	5.940
	33301-E	1900	6.313
	26939-E	2000	6.600
	26941-E	2500	8.100
	26943-E	3000	9.800



ALUFIX preferred range

Green: Item is available immediately.

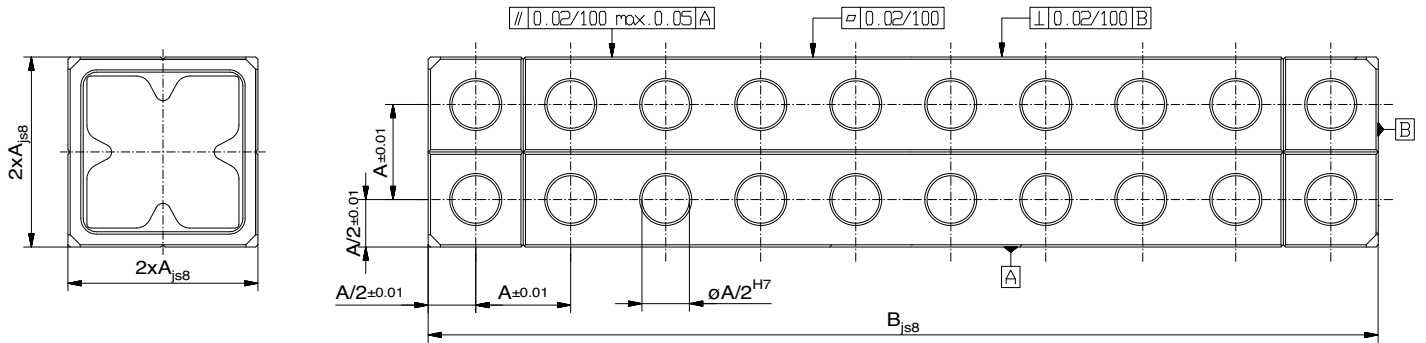
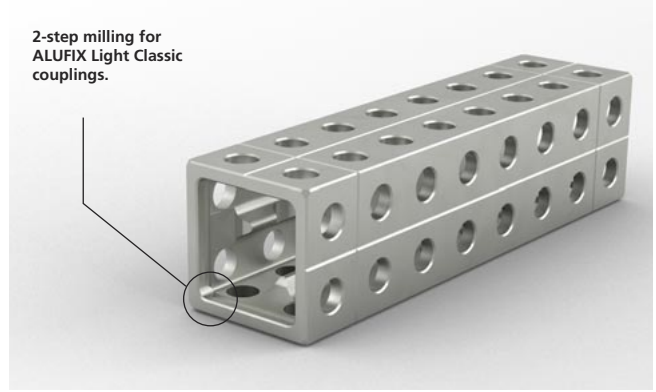
C: Classic version, E: Eco version, CE: Classic or Eco

■: color "natural", ■: color "black"

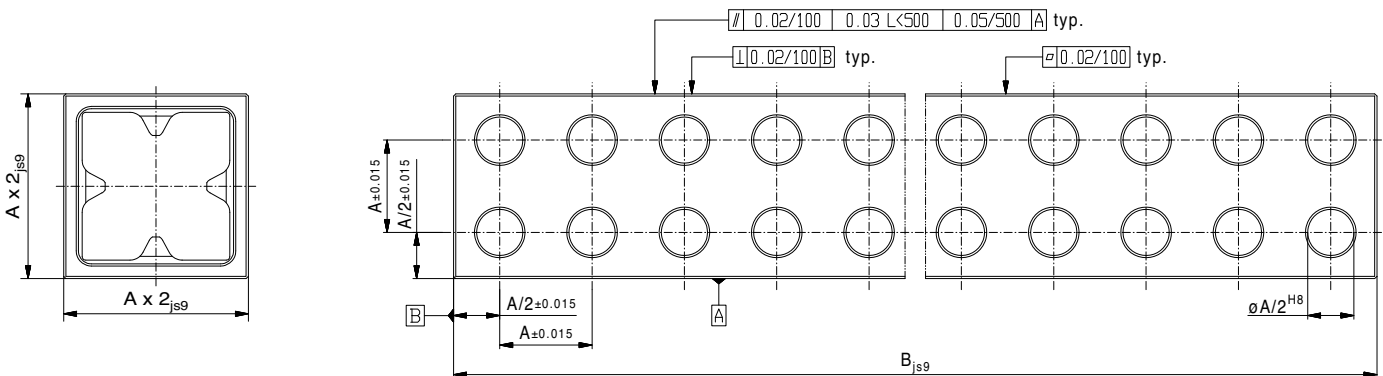
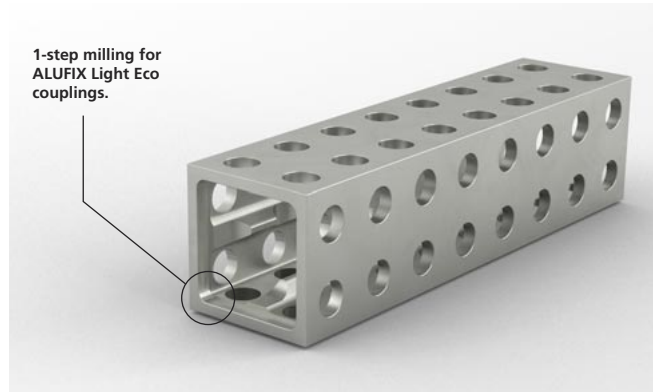
ALUFIX elements can be anodized in different colors.

The color "natural" is standard, "black" is available as an alternative - for Classic add "-1" to the article number, for Eco add "1" when ordering. Other colors on request.

## ALUFIX Bars Light Classic two row



## ALUFIX Bars Light Eco two row



**AF25 Light Classic/ Eco**

Bars two row, 50x50 mm

Grid (A) 25, hole diameter 12,5 mm

	Nr.(Eco)	B	h
E	26617(-E)	50	108
E	25375(-E)	100	215
E	20426(-E)	150	323
E	20427(-E)	200	430
E	22949(-E)	250	538
E	20254(-E)	300	645
E	24246(-E)	350	753
E	20256(-E)	400	860
	24248(-E)	450	968
E	22950(-E)	500	1.075
	24249(-E)	550	1.183
	24250(-E)	600	1.290
	24247(-E)	650	1.398
	24251(-E)	700	1.505
	21824(-E)	750	1.613
	28353(-E)	800	1.720
	26842(-E)	850	1.828
	24319(-E)	900	1.935
	26841(-E)	950	2.043
	22951(-E)	1000	2.150
	27632(-E)	1050	2.258
	27633(-E)	1100	2.365
	26849(-E)	1150	2.437
	25025(-E)	1200	2.580
	21825(-E)	1250	2.688
	27914(-E)	1300	2.795
	28354(-E)	1350	2.903
	27915(-E)	1400	3.010
	24813(-E)	1450	3.118
	22952(-E)	1500	3.225
	27891(-E)	1600	3.440
	33287(-E)	1700	3.655
	33288(-E)	1800	3.870
	33289(-E)	1900	4.085
	21226(-E)	2000	4.300

**AF40 Light Classic/ Eco**

Bars two row, 80x80 mm

Grid (A) 40, hole diameter 20 mm

	Nr.(Eco)	B	h
E	24393(-E)	80	407
E	24940(-E)	120	610
E	23937(-E)	160	813
E	23938(-E)	200	1.017
E	24392(-E)	240	1.220
	24825(-E)	280	1.423
E	24641(-E)	320	1.627
E	24809(-E)	360	1.830
E	23559(-E)	400	2.033
	25922(-E)	440	2.237
E	24390(-E)	480	2.440
	24808(-E)	520	2.643
	24389(-E)	560	2.846
	24451(-E)	600	3.050
	24391(-E)	640	3.253
	24454(-E)	680	3.456
	24388(-E)	720	3.660
	24826(-E)	760	3.863
	23560(-E)	800	4.066
	24629(-E)	840	4.270
	26609(-E)	880	4.473
	25095(-E)	920	4.676
	25877(-E)	960	4.880
	24624(-E)	1000	5.083
	24807(-E)	1080	5.490
	24943(-E)	1120	5.693
	23561(-E)	1200	6.100
	25317(-E)	1240	6.303
	24806(-E)	1280	6.506
	26003(-E)	1320	6.710
	25094(-E)	1400	7.116
	24630(-E)	1520	7.726
	23562(-E)	1600	8.133
	27202(-E)	1680	8.539
	25629(-E)	1760	8.946
	29781(-E)	1840	9.353
	24946(-E)	1920	9.759
	23563(-E)	2000	10.166

**AF50 Light Eco**

Bars two row, 100x100 mm

Grid (A) 50, hole diameter 25 mm

	Nr.	B	h
	27569-E	100	839
	28122-E	150	1.258
	26735-E	200	1.678
	27504-E	250	2.097
	26821-E	300	2.516
	27607-E	350	2.936
	26786-E	400	3.355
	26820-E	450	3.775
	26787-E	500	4.194
	26788-E	600	5.033
	26818-E	700	5.872
	27505-E	800	6.710
	26789-E	900	7.549
	26957-E	1000	8.388
	27610-E	1100	9.227
	27920-E	1200	10.066
	27611-E	1300	10.904
	27919-E	1400	11.743
	26959-E	1500	12.582
	27923-E	1600	13.421
	30752-E	1700	14.260
	27460-E	1800	15.098
	30959-E	1900	15.937
	26961-E	2000	16.767



ALUFIX preferred range

Green: Item is available immediately.

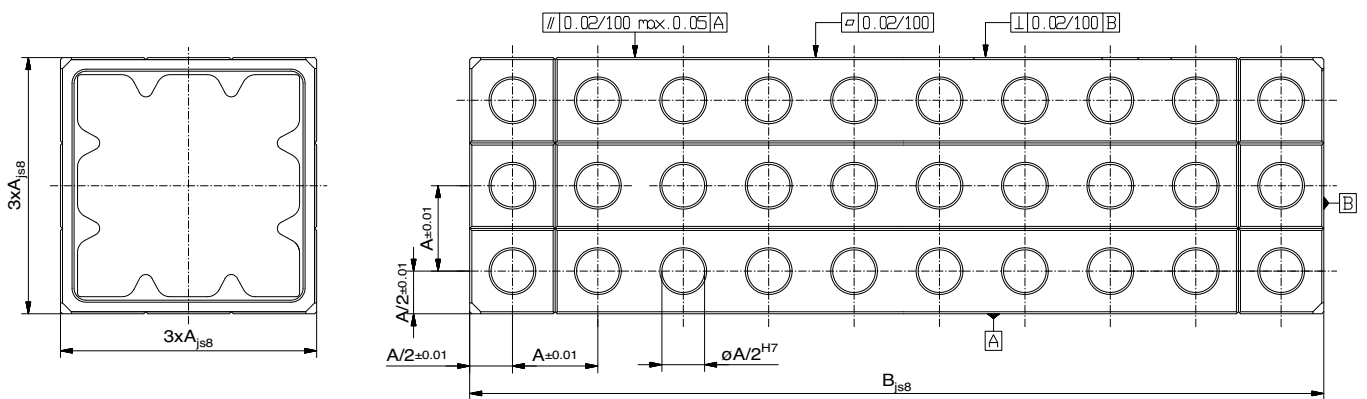
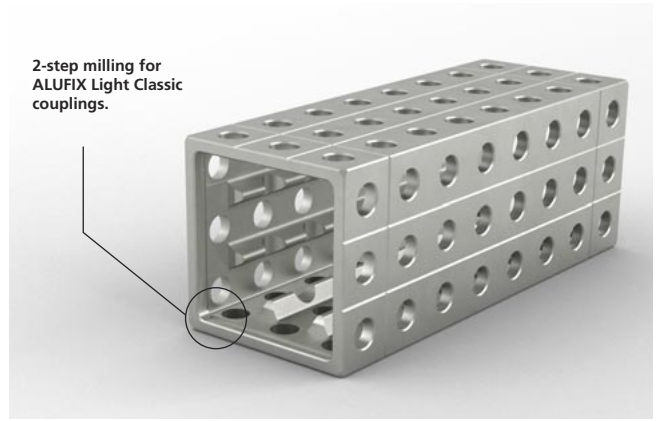
C: Classic version, E: Eco version, CE: Classic or Eco

■: color "natural", ■: color "black"

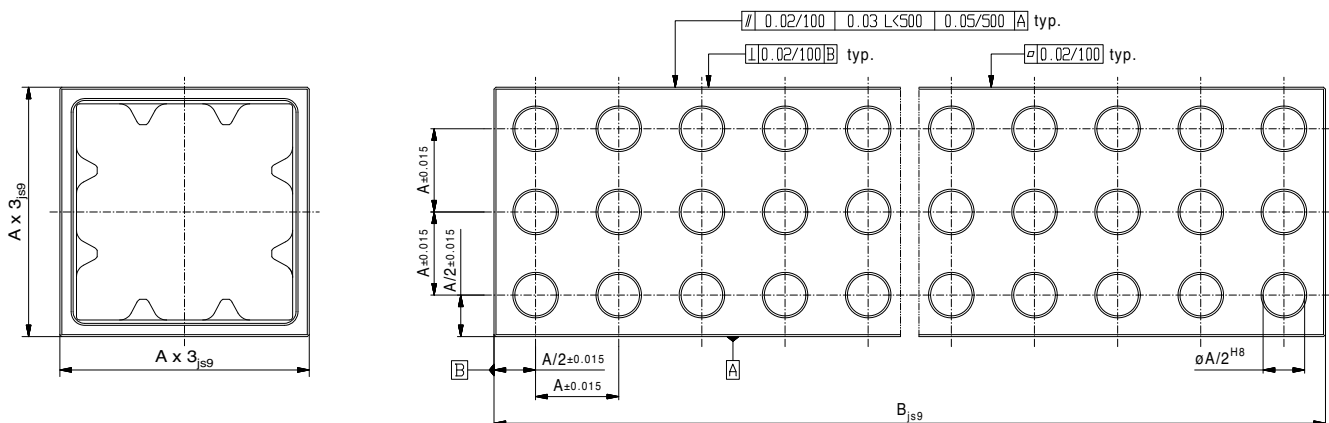
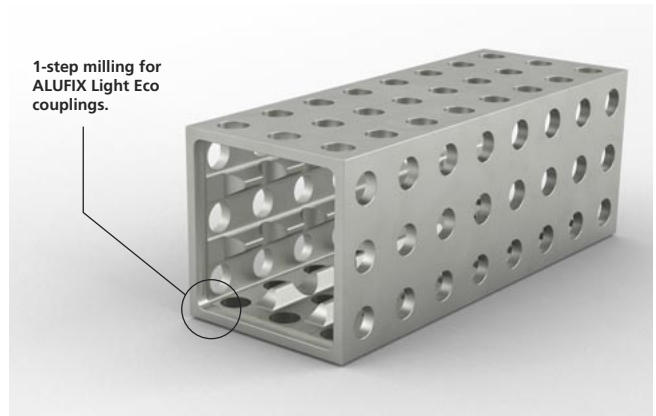
ALUFIX elements can be anodized in different colors.

The color "natural" is standard, "black" is available as an alternative - for Classic add "-1" to the article number, for Eco add "1" when ordering. Other colors on request.

## ALUFIX Bars Light Classic three row



## ALUFIX Bars Light Eco three row



**AF40 Light Classic/ Eco**

Bars three row, 120x120mm

Grid (A) 40, hole diameter 20 mm

Nr.(Eco)	B	g
24950(-E)	160	1.404
25123(-E)	200	1.755
24951(-E)	240	2.106
24827(-E)	280	2.457
24952(-E)	320	2.808
25122(-E)	360	3.159
23574(-E)	400	3.510
25735(-E)	440	3.861
24931(-E)	480	4.212
26008(-E)	520	4.563
25121(-E)	560	4.914
25124(-E)	600	5.265
25736(-E)	640	5.616
27458(-E)	680	5.967
24930(-E)	720	6.318
24828(-E)	760	6.669
23575(-E)	800	7.020
25029(-E)	840	7.371
25843(-E)	880	7.722
27597(-E)	920	8.073
24929(-E)	960	8.424
27435(-E)	1000	8.775
25028(-E)	1080	9.477
27169(-E)	1160	10.179
23576(-E)	1200	10.530
27601(-E)	1280	11.232
26892(-E)	1360	11.934
24953(-E)	1400	12.285
24829(-E)	1480	12.987
25310(-E)	1560	13.689
23577(-E)	1600	14.040
25950(-E)	1680	14.742
29918(-E)	1760	15.444
25737(-E)	1800	15.795
27538(-E)	1880	16.497
23578(-E)	2000	17.550

**AF50 Light Eco**

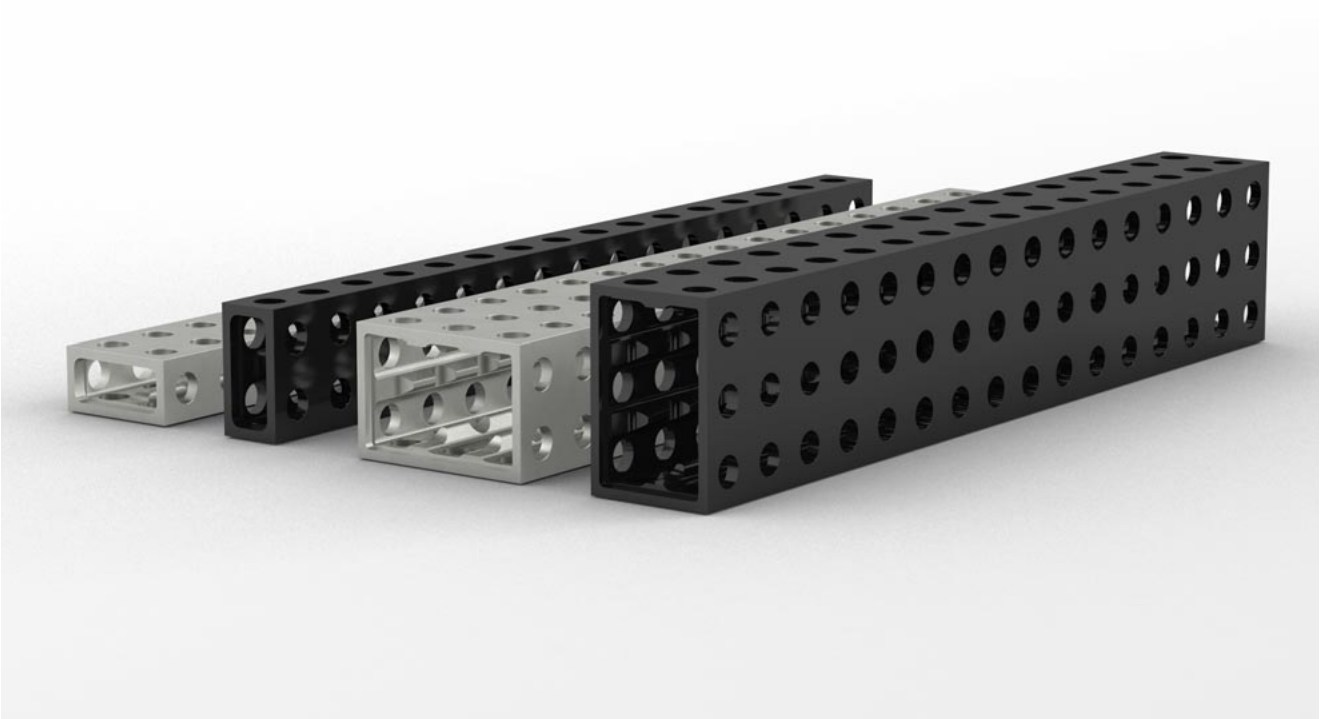
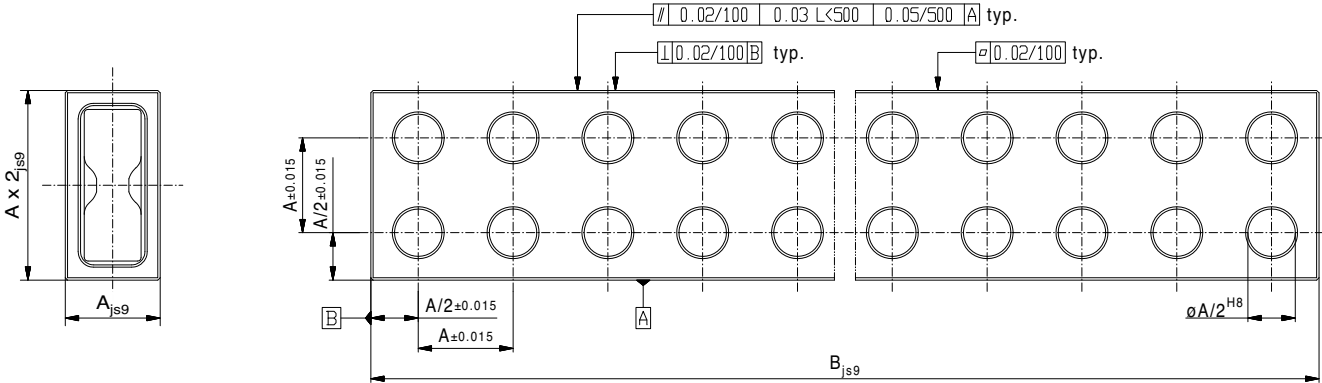
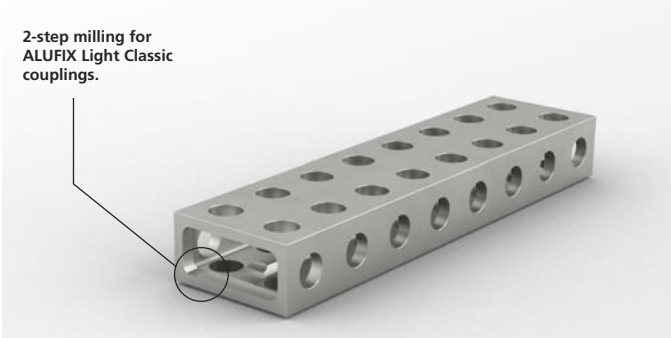
Bars three row, 150x150mm

Grid (A) 50, hole diameter 25 mm

Nr.	B	g
28123-E	100	1.389
28124-E	150	2.083
28125-E	200	2.777
27521-E	250	3.472
26817-E	300	4.166
28126-E	350	4.860
28127-E	400	5.554
27854-E	450	6.249
26978-E	500	6.943
33302-E	600	8.332
27522-E	700	9.720
29366-E	800	11.109
27853-E	900	12.497
26979-E	1000	13.886
33303-E	1100	15.275
33304-E	1200	16.663
29805-E	1300	18.052
29699-E	1400	19.440
26981-E	1500	20.829
33305-E	1600	22.218
28557-E	1700	23.606
27606-E	1800	24.995
33306-E	1900	26.383
26983-E	2000	27.772

ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative -  
for Classic add "-1" to the article number, for Eco add "1" when ordering.  
Other colors on request.

ALUFIX Bars  
Light Eco rectangular  
1x2 rows



ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.



**AF25 Light Eco**

Bars rectangular 25x50 mm

Grid (A) 25, hole diameter 12,5 mm

	Nr.(Eco)	B	g
E	55090-E	50	68
E	55091-E	100	136
E	55092-E	150	204
E	55093-E	200	272
E	55094-E	250	340
	55095-E	300	408
	55096-E	350	476
	55097-E	400	544
	55098-E	450	612
	55099-E	500	680
	55100-E	550	748
	55101-E	600	816
	55102-E	650	884
	55103-E	700	952
	55104-E	750	1.020
	55105-E	800	1.088
	55106-E	850	1.156
	55107-E	900	1.224
	55108-E	950	1.292
	55109-E	1000	1.360
	55110-E	1050	1.428
	55111-E	1100	1.496
	55112-E	1150	1.564
	55113-E	1200	1.632
	55114-E	1250	1.700
	55115-E	1300	1.768
	55116-E	1350	1.836
	55117-E	1400	1.904
	55118-E	1450	1.972
	55119-E	1500	2.040
	55120-E	1550	2.108
	55121-E	1600	2.176
	55122-E	1650	2.244
	55123-E	1700	2.312
	55124-E	1750	2.380
	55125-E	1800	2.448
	55126-E	1850	2.516
	55127-E	1900	2.584
	55129-E	2000	2.720

**AF40 Light Eco**

Bars rectangular 40x80 mm

Grid (A) 40, hole diameter 20 mm

	Nr.(Eco)	B	g
E	57400-E	80	286
E	57401-E	120	428
E	57402-E	160	571
E	57403-E	200	714
E	57404-E	240	857
E	57405-E	280	1.000
E	57406-E	320	1.142
	57407-E	360	1.285
E	57408-E	400	1.428
	57409-E	440	1.571
E	57410-E	480	1.714
	57411-E	520	1.856
	57412-E	560	1.999
	57413-E	600	2.142
	57414-E	640	2.285
	57415-E	680	2.428
	57416-E	720	2.570
	57417-E	760	2.713
	57418-E	800	2.856
	57419-E	840	2.999
	57420-E	880	3.142
	57421-E	920	3.284
	57422-E	960	3.427
	57423-E	1000	3.570
	57424-E	1040	3.713
	57425-E	1080	3.856
	57426-E	1120	3.998
	57427-E	1160	4.141
	57428-E	1200	4.284
	57429-E	1240	4.427
	57430-E	1280	4.570
	57431-E	1320	4.712
	57432-E	1360	4.855
	57433-E	1400	4.998
	57434-E	1440	5.141
	57435-E	1480	5.284
	57436-E	1520	5.426
	57437-E	1560	5.569
	57438-E	1600	5.712

	Nr.(Eco)	B	g
	57439-E	1640	5.855
	57440-E	1680	5.998
	57441-E	1720	6.140
	57442-E	1760	6.283
	57443-E	1800	6.426
	57444-E	1840	6.569
	57445-E	1880	6.712
	57446-E	1920	6.854
	57447-E	1960	6.997
	57448-E	2000	7.140
	57449-E	2040	7.283
	57450-E	2080	7.426
	57451-E	2120	7.568
	57452-E	2160	7.711
	57453-E	2200	7.854
	57454-E	2240	7.997
	57455-E	2280	8.140
	57456-E	2320	8.282
	57457-E	2360	8.425
	57458-E	2400	8.568
	57459-E	2440	8.711
	57460-E	2480	8.854
	57461-E	2520	8.996
	57462-E	2560	9.139
	57463-E	2600	9.282
	57464-E	2640	9.425
	57465-E	2680	9.568
	57466-E	2720	9.710
	57467-E	2760	9.853
	57468-E	2800	9.996
	57469-E	2840	10.139
	57470-E	2880	10.282
	57471-E	2920	10.424
	57472-E	2960	10.567
	57473-E	3000	10.710



ALUFIX preferred range

Green: Item is available immediately.

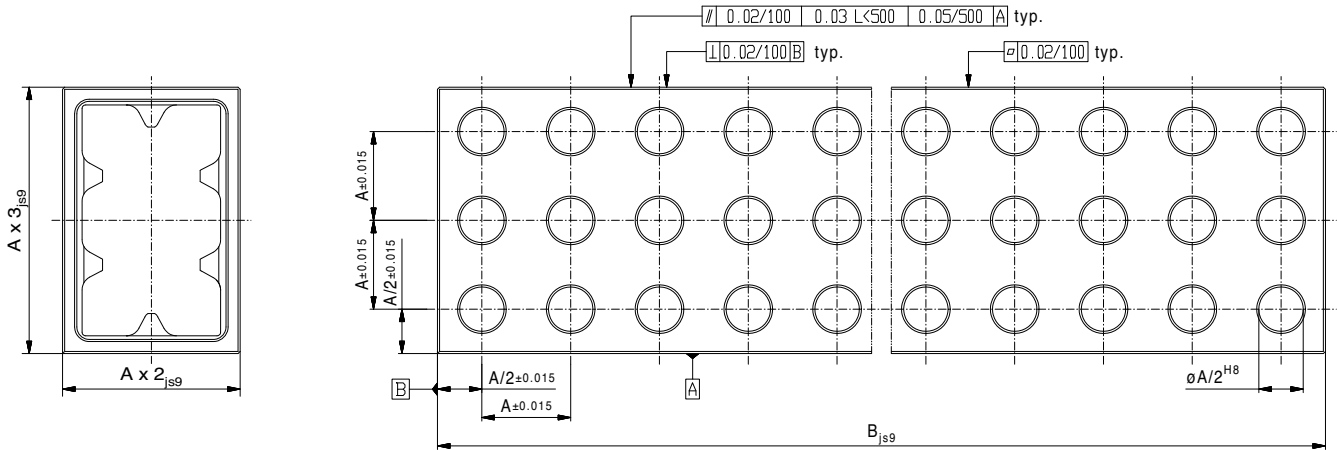
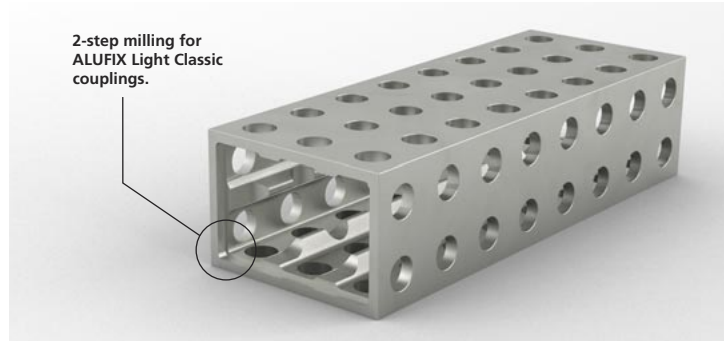
C: Classic version, E: Eco version, CE: Classic or Eco

■: color "natural", ■: color "black"

ALUFIX elements can be anodized in different colors.

The color "natural" is standard, "black" is available as an alternative - for Classic add "-1" to the article number, for Eco add "1" when ordering. Other colors on request.

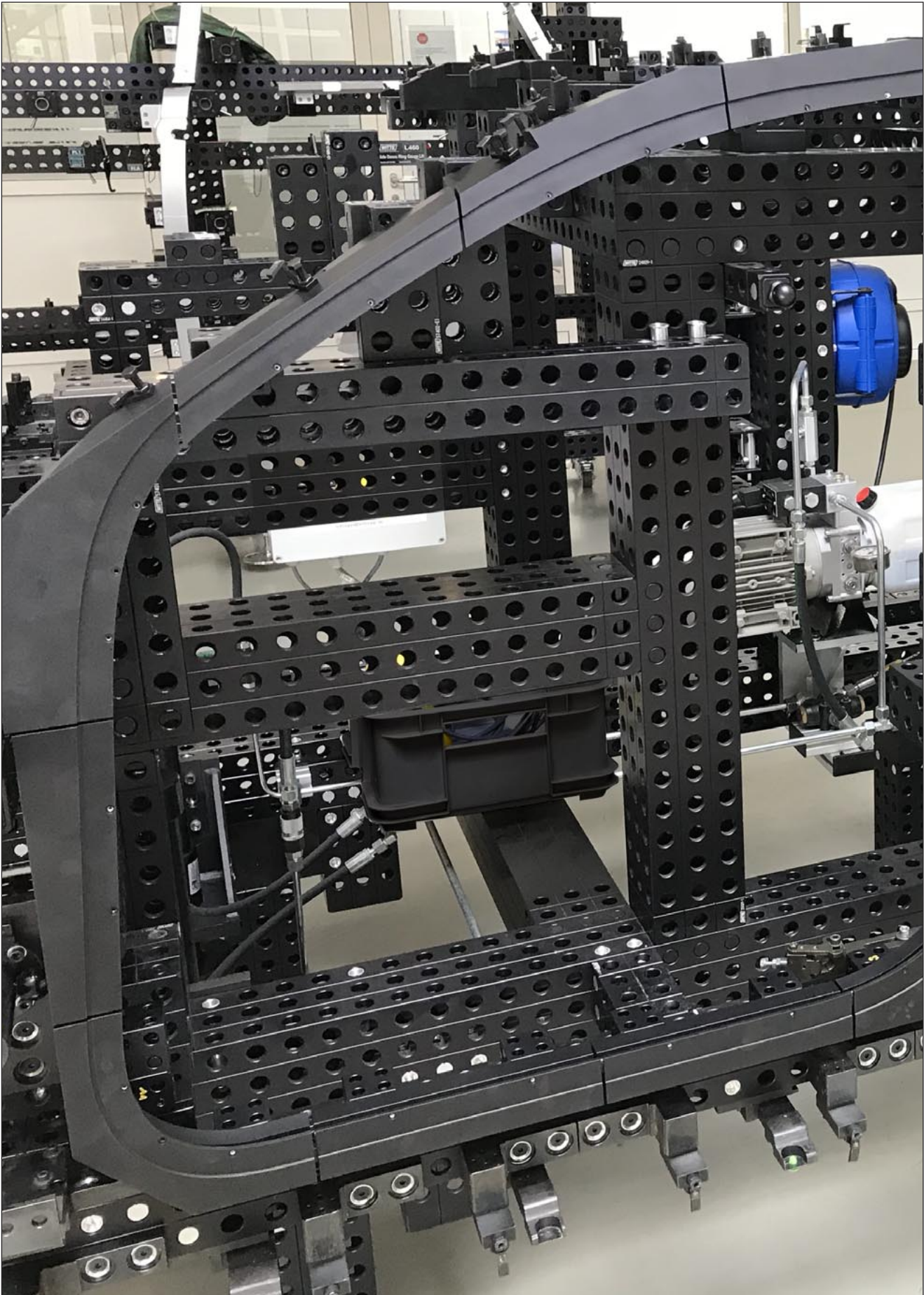
**ALUFIX Bars**  
**Light Eco rectangular**  
**2x3 rows**



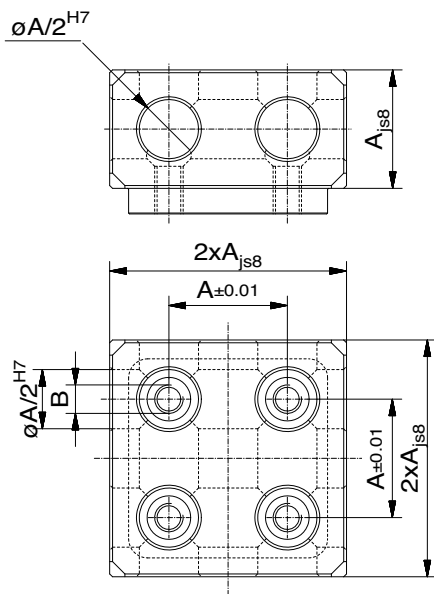
**AF40 Light Eco**  
 Bars rectangular 80x120 mm,  
 Grid (A) 40, hole diameter 20 mm

Nr.	B	$\frac{B}{A}$
122285-E	160	1.000
122286-E	200	1.250
122287-E	240	1.500
122289-E	320	2.000
122290-E	360	2.250
122291-E	400	2.500
122296-E	600	3.750
122301-E	800	5.000
122306-E	1000	6.250
122311-E	1200	7.500
122321-E	1600	10.000
122331-E	2000	12.500
122341-E	2400	15.000
122354-E	3000	18.750
122369-E	3600	22.500
122379-E	4000	25.000
122578-E	4800	30.000

ALUFIX elements can be anodized in different colors.  
 The color "natural" is standard, "black" is available as an alternative -  
 then simply add "1" to the article number when ordering.  
 Other colors on request.



ALUFIX bars can be connected to each other on all six sides, so complex devices can also be implemented in the grid system.



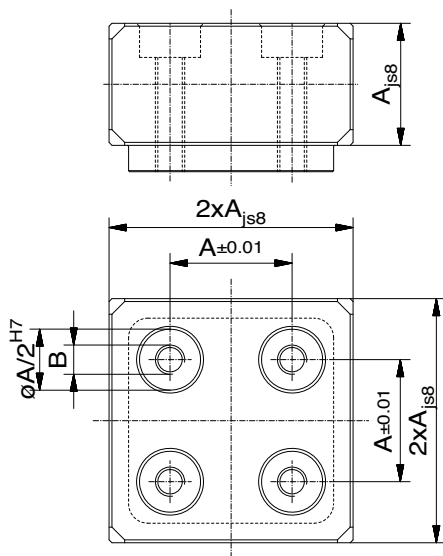
**Coupling plate Classic/Eco universal for Light bars**

Nr.	AF	A	B	⌀
332856	25	25	M6	134
332857	40	40	M10	550
332858	50	50	M12	940

Recommended for face end connections of quick change couplings and guiding, roller slides



**Coupling plate for Light bars**



Nr.	AF	A	B	⌀
333626	25	25	M6	141
333627	40	40	M10	578
333628	50	50	M12	987



ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.

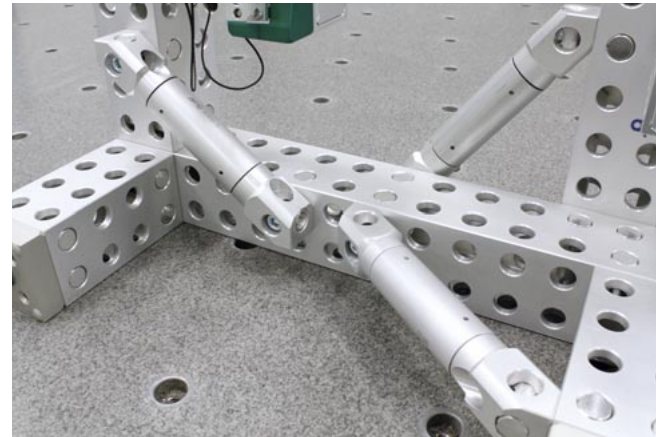
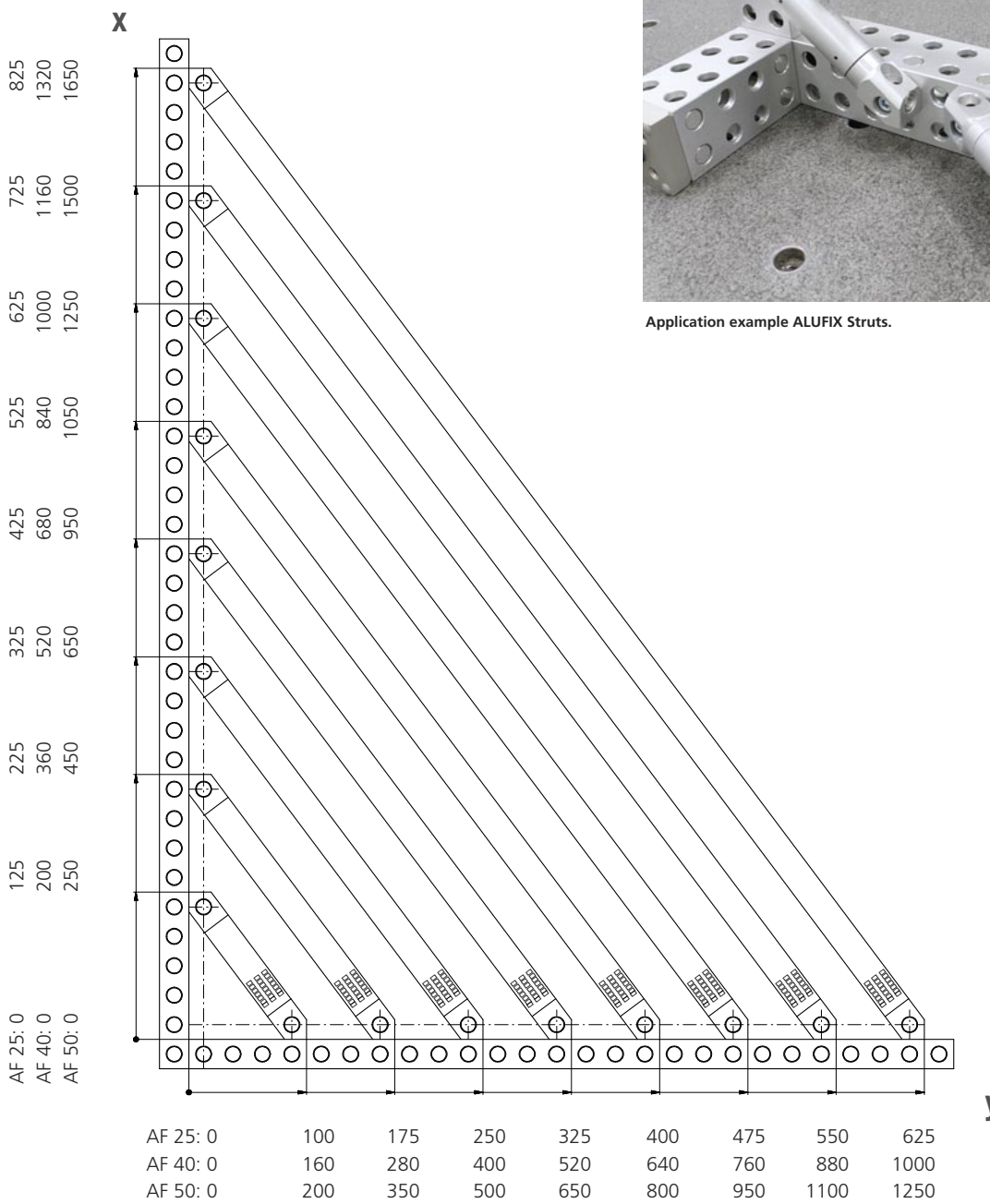


Application example: Fixture for a truck cabin with Alufix Light Classic bars

# ALUFIX Struts

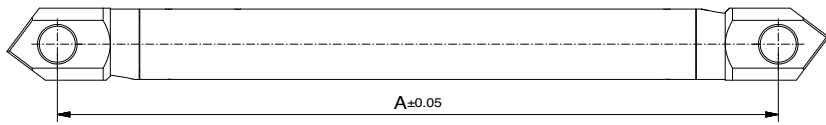
For increased stability through triangular bracing

## x-y-coordinates for struts AF25 / AF40 / AF50



Application example ALUFIX Struts.

**Struts**  
for Classic and Eco



**AF25 Classic**  
Struts, 25x25  
Grid 25, hole diameter 12,5 mm

**AF40 Classic**  
Struts, 40x40  
Grid 40, hole diameter 20 mm

**AF50 Classic**  
Struts, 50x50  
Grid 50, hole diameter 25 mm

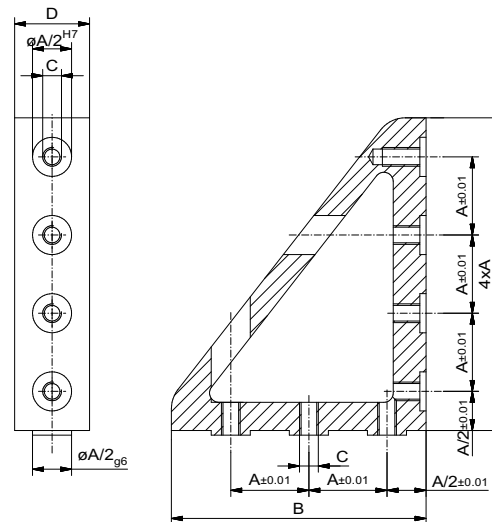
Nr.	A	AF	⌀
81443	125	25	168
81444	250	25	285
81445	375	25	402
81327	500	25	518
81328	625	25	641
81329	750	25	752
81330	875	25	872
81331	1000	25	979

Nr.	A	AF	⌀
81446	200	40	700
81447	400	40	1.226
81448	600	40	1.400
81407	800	40	2.258
81408	1000	40	2.240
81409	1200	40	3.161
81410	1400	40	3.470
81411	1600	40	4.170

Nr.	A	AF	⌀
82403	250	50	1.424
82404	500	50	2.534
82405	750	50	3.637
82406	1000	50	5.696
82407	1250	50	7.120
82408	1500	50	8.544
82409	1750	50	9.968
82410	2000	50	11.392

**Profile angle brackets**  
for Classic and Eco

Nr.	A (AF)	B	C	D	⌀
120511-E	25	81,5	M6	24	194
120514-E	25	121,5	M6	24	319
120512-E	40	81,5	M10	39	315
120515-E	40	121,5	M10	39	518
120513-E	50	81,5	M12	49	396
120516-E	50	122,5	M12	49	651



Profile angle brackets are also available in special lengths of up to 3000mm.

For profile angle brackets, suitable sleeves (without collar, short) are shown on page 108.

Profile angle brackets are also available on request in special widths



**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"

# ALUFIX

## Quick Change Couplings

### For easy exchange of contact points

Quick change couplings comprise of a top and bottom section, which are aligned accurately together via ball seats. Locking is done with a quick lock via a lever.

The total height is exactly in Alufix grid.

Hinges connect top and bottom sections if required and provide a foldback function. The modular design enables combination possibilities as shown on the right.

#### Aluminum material: Strong and light

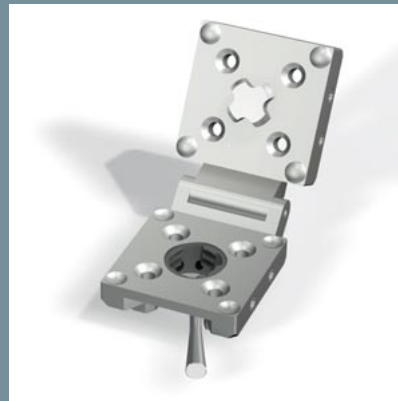
ALUFIX Quick change couplings are milled from high-tensile aluminum alloy.

Material:  
• EN AW 7075

ALUFIX elements can be anodized in different colors.

The color "natural" is standard, "black" is available as an alternative - for Classic add "-1" to the article number, for Eco add "1" when ordering.

Other colors on request.



Quick change coupling for folding back, hinge is mounted at the rear.



Quick change coupling to fold sideways to the left, hinge is mounted on the left.



Quick change coupling to fold sideways to the right, hinge is mounted on the right.



Quick change coupling with two folding options. One hinge on the left and one at the rear.



Quick change coupling with three folding options. One hinge on the left, one on the right and one at the rear.



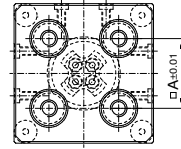
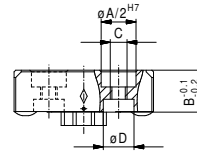
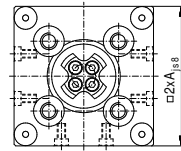
Quick change coupling, Top and bottom sections separately, standard version.



**Quick change coupling top section with hinge bores, complete**

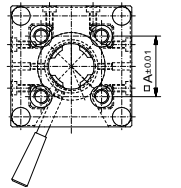
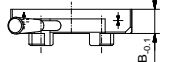
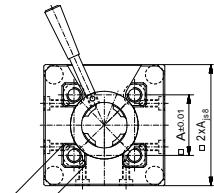
	Nr.	A (AF)	B	C	D	
	282471	25	15	M6	11	101
	282472	40	24	M10	18	415
	282473	50	30	M12	20	810
	283320	40/25	24	M6	11	415
	283330	50/25	30	M6	11	810

Quick change coupling for keyless chuck page 91.



**Quick change coupling bottom section with hinge bores, complete**

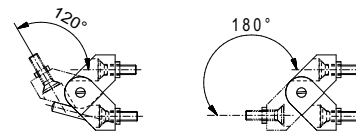
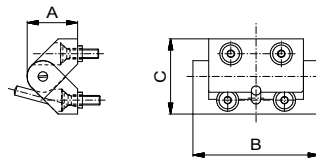
	Nr.	A (AF)	B	
	282474	25	10	75
	282475	40	16	305
	282476	50	20	550



**Hinge for quick change coupling, complete**

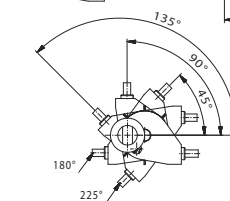
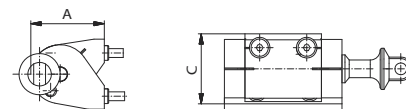
	Nr.	AF	B	C	D	
	282386	25	16	40	23,8	18
	282387	40	25,6	64	38	91
	282388	50	32	80	47,6	140

Cylindrical pin limits opening angle to 120°



**Hinge for quick change coupling, complete with pin**

	Nr.	AF	B	C	
	286856	25	25	40	8
	286857	40	36,6	64	174
	286858	50	43	80	160



**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
: color "natural", : color "black"

# ALUFIX

## Adjustment elements

**Accurate offset positioning in every axis where required**



### Application example:

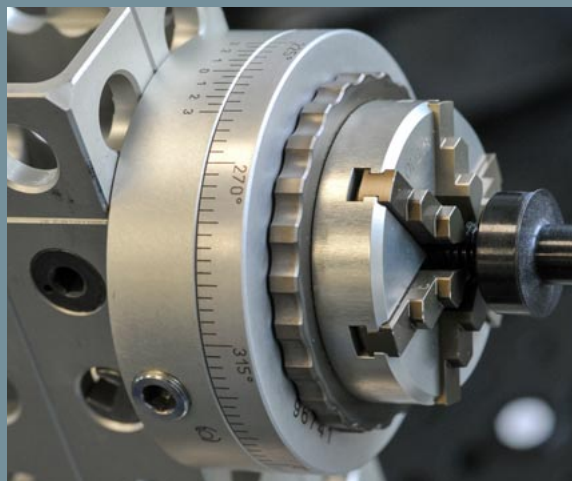
The angle of the center point is guaranteed by a specially machined contour block. The position in x, y and z is defined by the shimblock, the upper part of which is adjusted with shims in steps of 0.05 mm. Finally, the Shimblock is locked in order to achieve a permanent and stable position.

Adjusting elements enable contact points to be accurately aligned to a workpiece independent of the system grid.

Individual contact points or entire assemblies can be positioned exactly to the desired coordinates.

Rotating, swivelling, tilting, linear displacement: There are special adjustment elements for every task, which can be combined with one another as ALUFIX system components..

### Application example with rotary plate



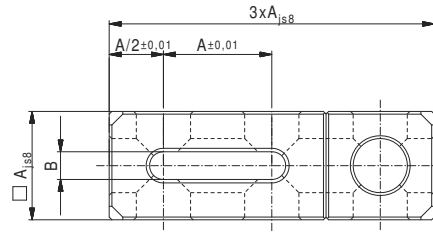
The rotary plate enables defined rotation of the elements attached to it - accurate and reproducible thanks to locking screws and scales with verniers.

The adjustment takes place, depending on the selected model, in steps or infinitely.

In the picture above, the workpiece is mounted with a 6-jaw keyless chuck.

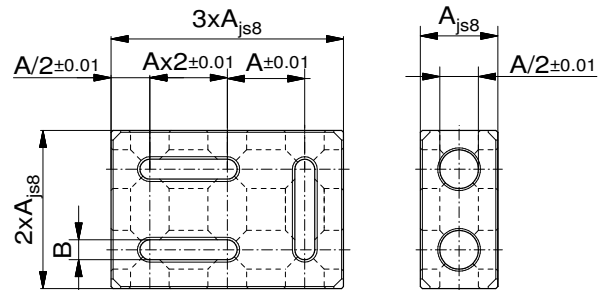
### Bar 1D for quick connectors for offset positioning in 1 axis

Nr.	A (AF)	B	$\bar{L}$
20114	16	4,1	20
<b>C</b> 23233	25	6,8	80
<b>C</b> 23279	40	10,8	320
28040	50	13,7	625



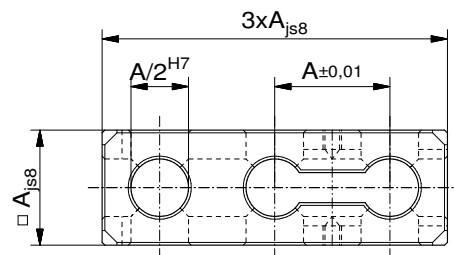
### Base plate 2D for quick connectors for offset positioning in 2 axis

Nr.	A (AF)	B	$\bar{L}$
20397	16	4,1	40
<b>C</b> 23232	25	6,8	160
<b>C</b> 23280	40	10,8	1.090
28342	50	13,7	1.266



### Bar 1D for screw connectors for offset positioning in 1 axis

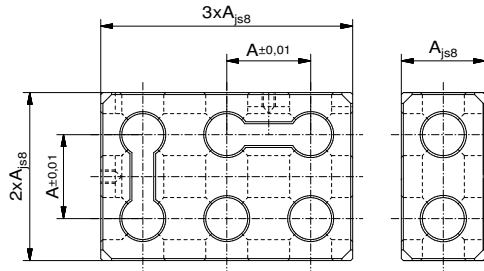
Nr.	A (AF)	$\bar{L}$
81021	25	81
81022	40	347
82764	50	800



Connecting elements for adjustable bars and base plates are on page 109 / 111.  
Other versions on request.

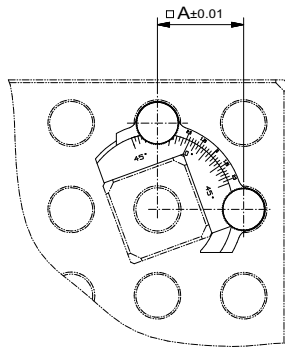
**C·E** ALUFIX preferred range  
Green: Item is available immediately.  
C: Classic version, E: Eco version, CE: Classic or Eco  
■: color "natural", ■: color "black"

ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative -  
for Classic add "-1" to the article number, for Eco add "1" when ordering.  
Other colors on request.



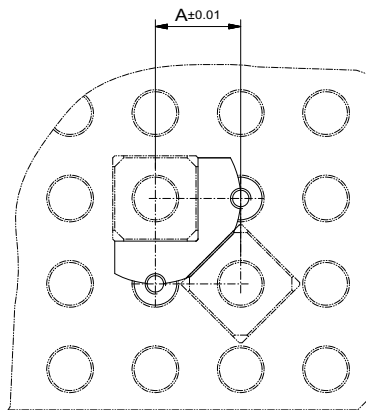
**Base plate 2D for screw connectors**  
for offset positioning in 2 axis

Nr.	A (AF)	
81023	25	162
81024	40	707
82765	50	1.400



**Heel block 45°-90°**  
adjustable angle with scale and nonius

Nr.	A (AF)	
81607	16	4
81390	25	13
81577	40	53
82768	50	69



**Heel block 45°/90°**  
fixed set up angle 45° or 90°

Nr.	A (AF)	
23667	16	3
21426	25	10
21190	40	42
28042	50	54



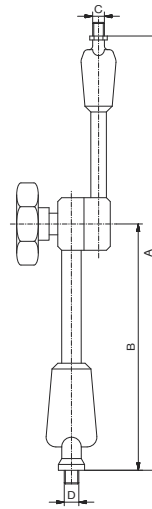
ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering.  
Other colors on request.

**Swivel arm AF25**

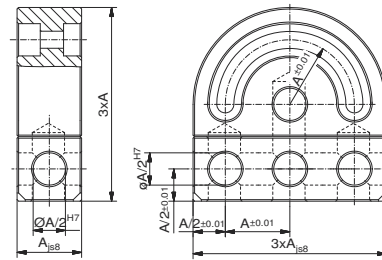
with joint and central hydraulic clamp function

Nr.	A	B	C	D	max. load	
85411	130	70	M6	M6	30 N	135
82121	205	115	M6	M8	40 N	282
82122	285	175	M6	M8	70 N	687

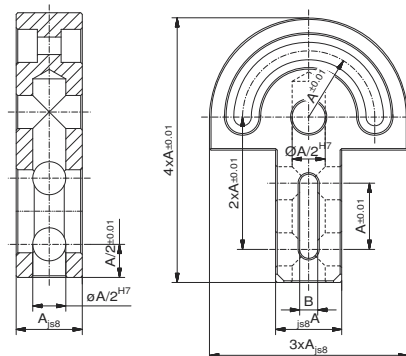
Connection elements for swivel arms on page 112.

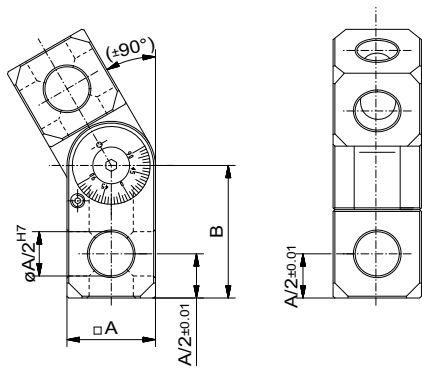
**Swivel plate**swivel range  $\pm 90^\circ$ , pivot point in grid

Nr.	A (AF)	
24578	16	56
24318	25	216
24579	40	891
28041	50	1.700

**Swivel plate with slot**swivel range  $\pm 90^\circ$ , pivot point independent of grid

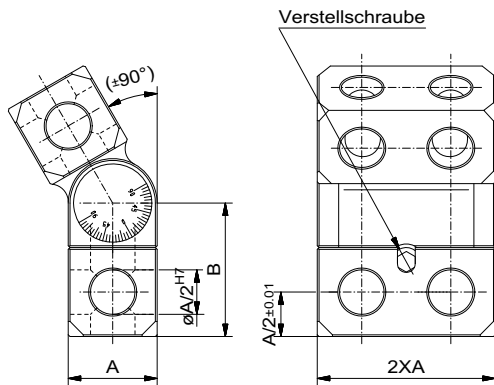
Nr.	A (AF)	B	
30667	25	6,8	195





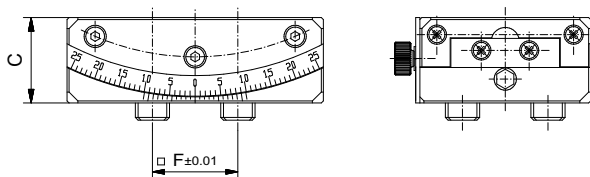
**Knuckle**  
adjustable range  $\pm 90^\circ$ , with fine scale  
and clamp function

Nr.	A (AF)	B	⊗
81668	16	24	28
81326	25	37,5	108
81462	40	60	446
82767	50	75	860



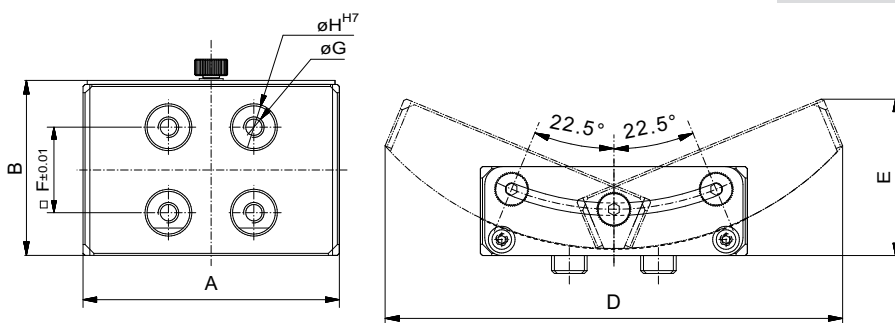
**Double Knuckle**  
adjustable range  $\pm 90^\circ$ , with fine scale  
and clamp function

Nr.	A (AF)	B	⊗
81811	16	24	65
81028	25	37,5	242
81812	40	60	1.004
82621	50	75	2.442




**Rocker**  
with infinite adjustment and clamp function

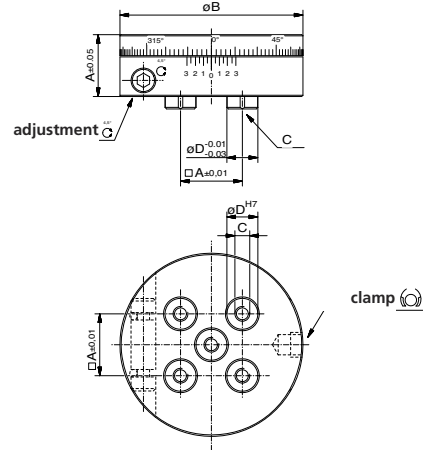
Nr.	A	B	C	D	E	F (AF)	G	H	⊗
82972	75	51	25	128,5	44	25	M6	12,5	242
283778	120	82	40	206	70	40	M8	20	900




ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative -  
then simply add "-1" to the article number when ordering.  
Other colors on request.

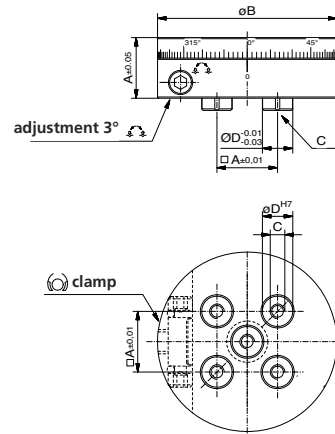
### Rotary plate with infinite adjustment and clamp function

Nr.	A	B	C	D	
96741	25	74	M6	12,5	340
280183	40	120	M10	20	770



### Rotary plate with ratchet adjustment in 3° steps and clamp function

Nr.	A	B	C	D	
96742	25	74	M6	12,5	340
283780	40	120	M10	20	770

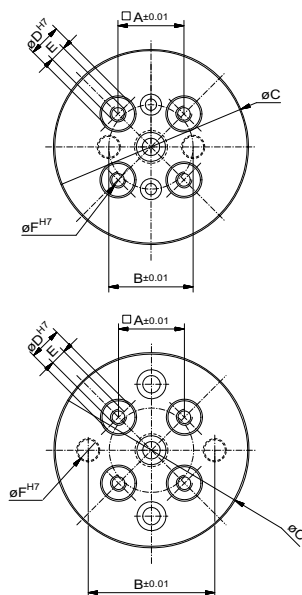


### Adapter plate for keyless chuck D50

Nr.	A	B	C	D	E	F	
56162	25	32	74	12,5	M6	8	123

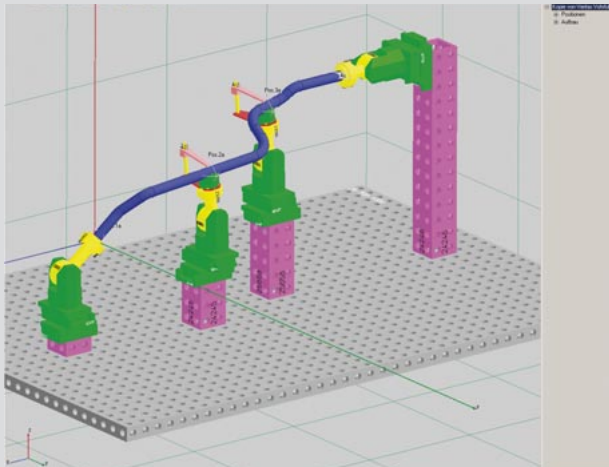
### for keyless chuck D80

Nr.	A	B	C	D	E	F	
56161	25	48	74	12,5	M6	8	123



Adapter plates also available including suitable connection elements  
 $\phi 50$  – 97893  
 $\phi 80$  – 97892

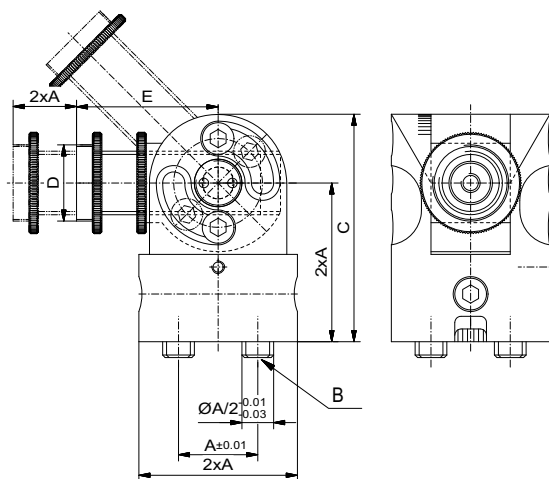
### ALUFIX rotary swing unit



Measuring fixture for hose.  
The positions and angles required are easily calculated with the help of Alufix Expert software (page 140).  
Fixtures like this are implemented very quickly.



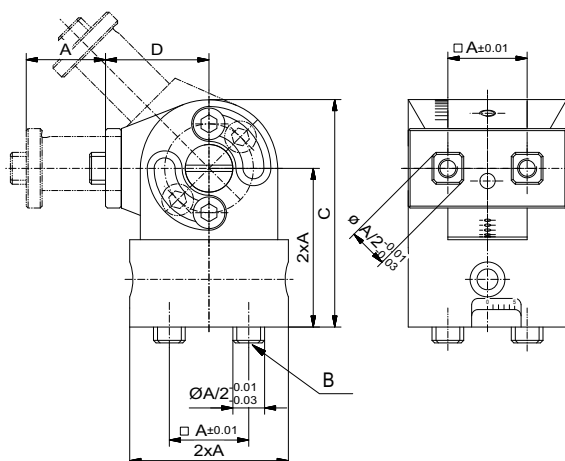
Application example:  
With the rotary swing unit, the tip of a center can be adjusted to any defined point of an imaginary hemisphere.  
Using a cross roller slide under the unit the center point of this hemisphere can be finely adjusted in x and y.  
The quick-change coupling mounted between bar and cross slide enables easy removal or exchange.



#### Rotary swing unit with thread

Nr.	A (AF)	B	C	D	E	⊗
93063	25	M6	72	M24x1	44,6	342
99794	40	M10	115	M32x1	69	750

Rotary swing unit 99794 for Alufix 40 with worm gear for fine adjustment in both rotating axes



#### Rotary swing unit with fine adjustable nubbed column

Nr.	A (AF)	B	C	D	⊗
93660	25	M6	72	32,6	370
99807	40	M10	115	50	750

Rotary swing unit 99807 for Alufix 40 with worm gear for fine adjustment in both rotating axes





## ALUFIX Jacks

Alufix jacks or columns are for height adjustment of fixture elements.

Depending on the version, load capacities of up to 1000 daN can be achieved with precise setting using a scale and vernier.



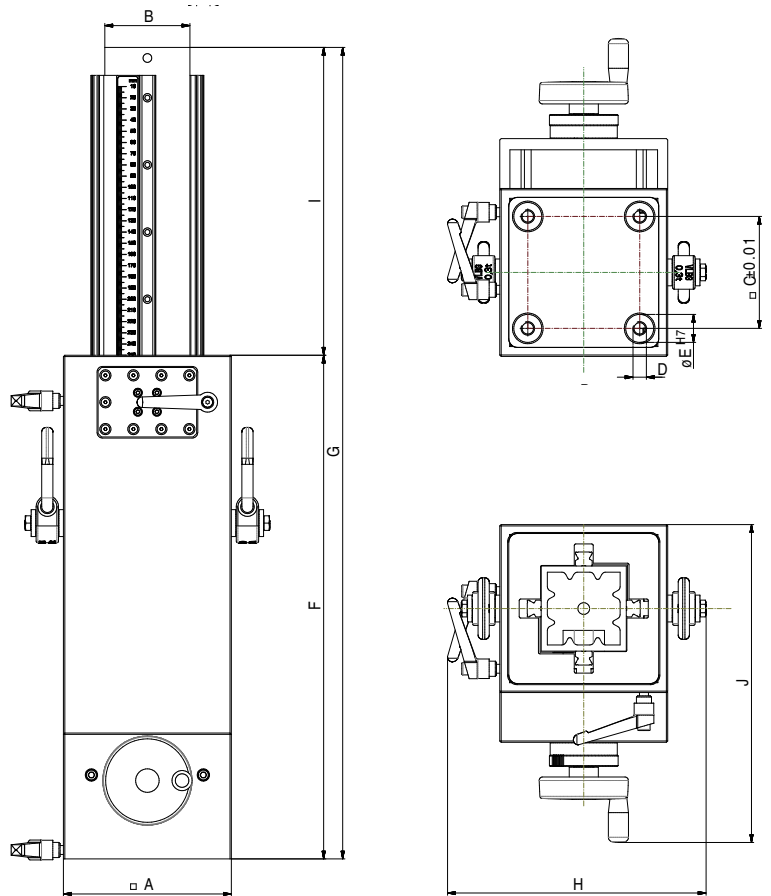
Application example on the right: Jacks mounted with cross roller slides, both in heavy duty design, for positioning hook clamps in three axes. All mounted on foot plates with grid for positioning on base plate or measuring surface.



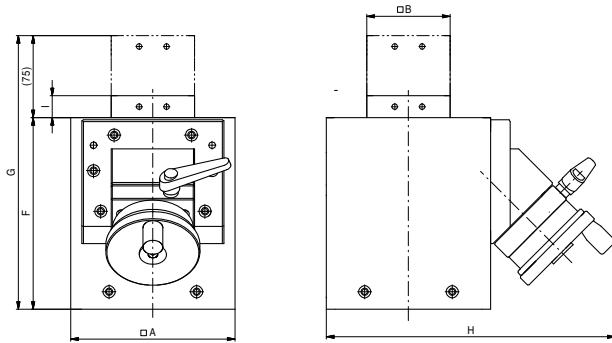
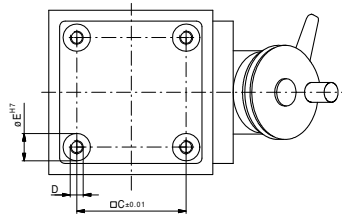
### Jack 1000, Heavy Duty Height adjustable using crank handle Load capacity 1000daN

Nr.	A	B	C	D	E	F	G	H	I	J	
98230	150	76	100	M12	25	450	700	250	250	288	21.000

Footplates and top blocks für jacks on pages 41-43



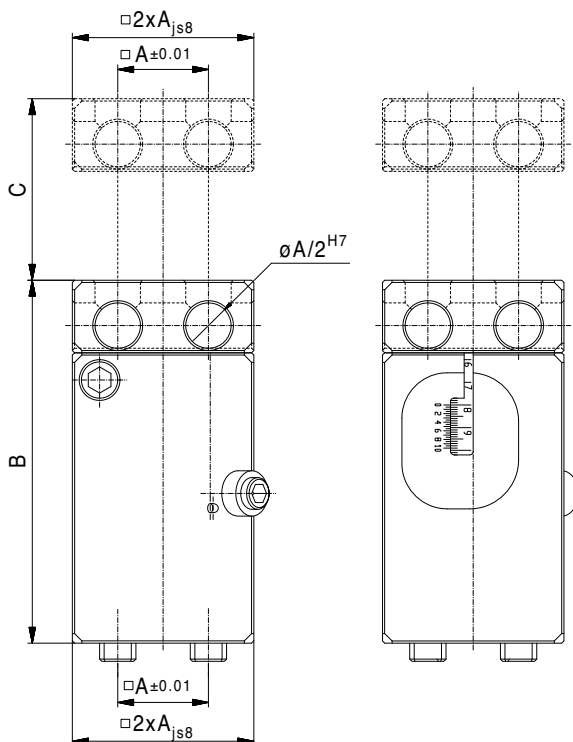
**Jack 500**  
 Height adjustable using crank handle  
 Load capacity 500 daN



Nr.	A	B	C	D	E	F	G	H	I	
92949	150	76	100	M12	25	175	250	265	20	10.115



**Rack gear jack**  
 with fine adjustment



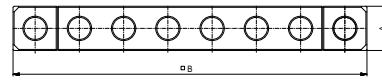
Nr.	A (AF)	B	C	max. daN ↓	
82939	25	75	25	30	486
90538	40	160	80	45	2.660
82821	50	200	100	60	5.523



ALUFIX elements can be anodized in different colors.  
 The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering.  
 Other colors on request.

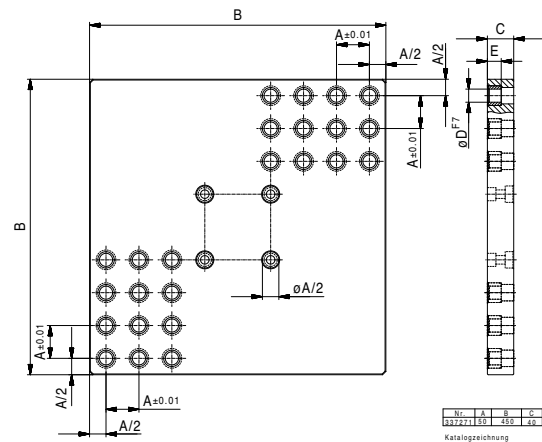
**Base plate for jack**  
Grid AF25, including connectors

Nr.	A	B	
98221	50	400	13.050



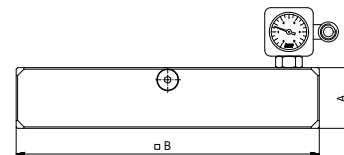
**Base plate for jack**

Nr.	A	B	C	D	E	
337271	50	450	40	∅20F7	21	21.500

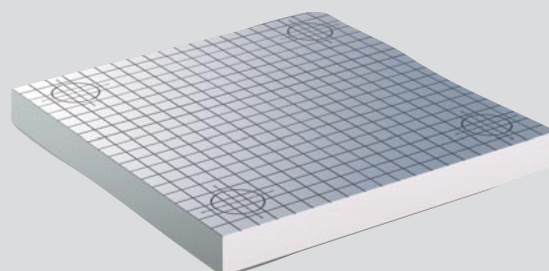


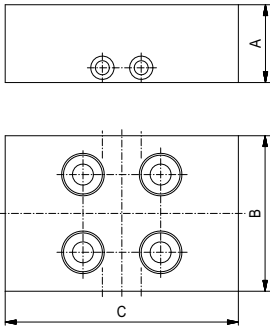
**Base plate for jack**  
with hovercraft and magnetic function,  
including connectors

Nr.	A	B	
281196	67	300	18.000



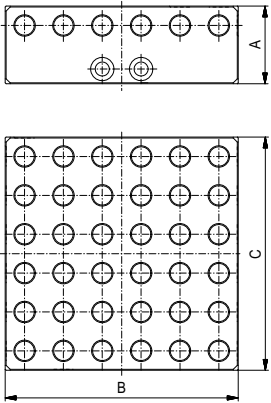
Individually manufactured  
base plates on request.





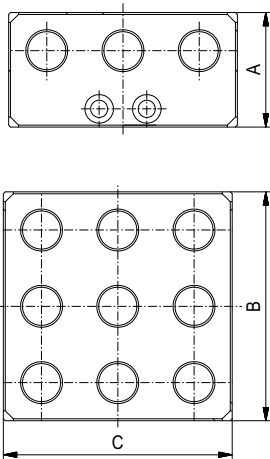
**Top block for Jack**  
with AF50 holes and connectors

Nr.	A	B	C	
98217	50	100	150	1.924



**Top block for Jack**  
with AF25 grid and connectors

Nr.	A	B	C	
98218	50	150	150	1.823



**Top block for Jack**  
with AF40 grid and connectors

Nr.	A	B	C	
98219	60	120	120	2.150



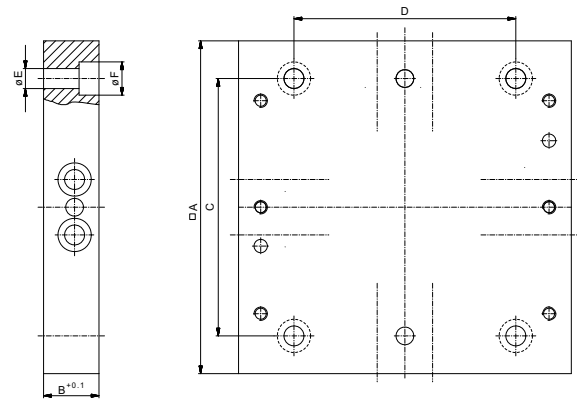
ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering.  
Other colors on request.

**Top block**  
for jack 92949

Nr.	A	B	C	D	E	F	
289486	150	25	116	100	9	15	1.200

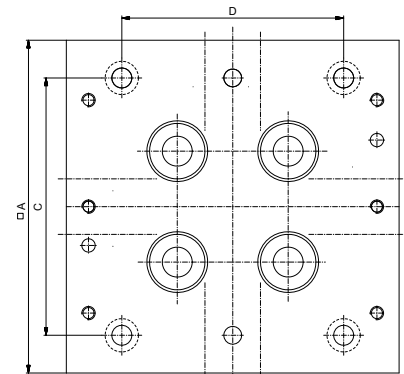
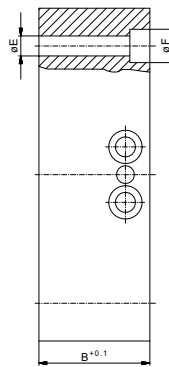


Top blocks are not drilled but can be supplied with customized grid on request




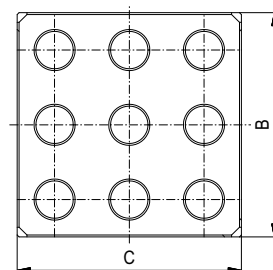
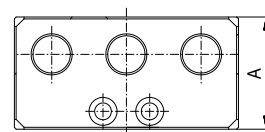
**Top block**  
for jack 92949 with AF50 holes

Nr.	A	B	C	D	E	F	
289487	150	50	116	100	9	15	2.100



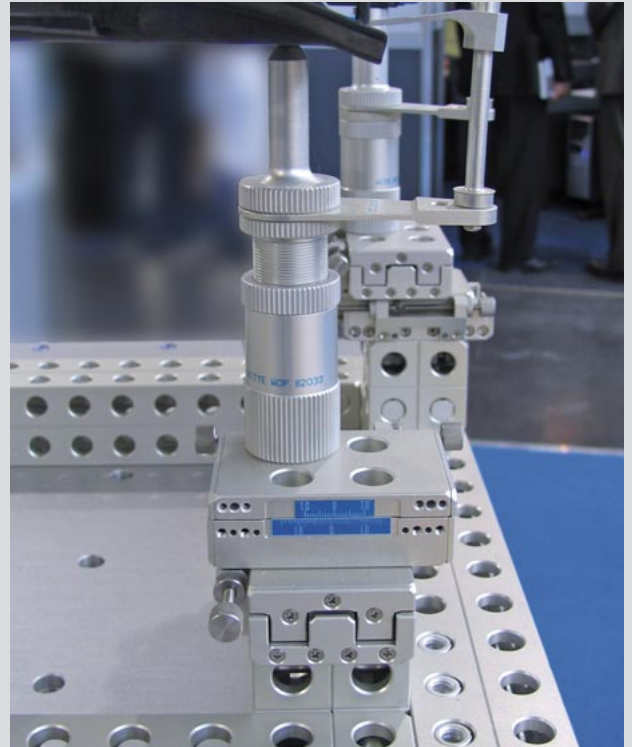
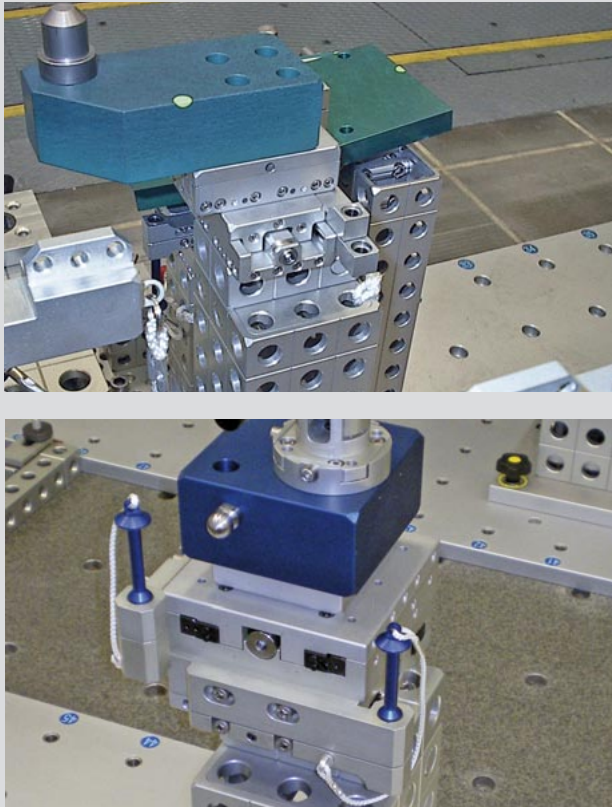
**Top block for Jack**  
with AF50 grid and connectors

Nr.	A	B	C	
98220	75	150	150	4.100

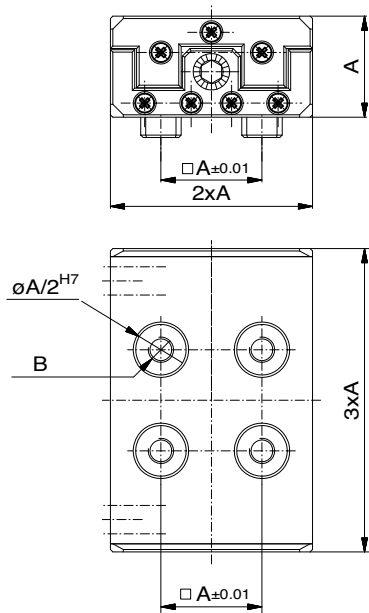


All Top Blocks can be used on Jack 1000 and Jack 500.

### Roller and guiding slides



Above: The cross roller slide enables infinite adjustment of the center in the x and y axes - precise and reproducible using stop screws and scales with vernier.



### Roller slide linear adjustment in 1 axis with lead screw

Nr.	A (AF)	B	max. N ↓	Shift	⊕
82453	16	M4	200	±9	89
82172	25	M6	500	±13,5	242
82173	40	M10	1500	±22	970
82398	50	M12	2500	±27	1.910



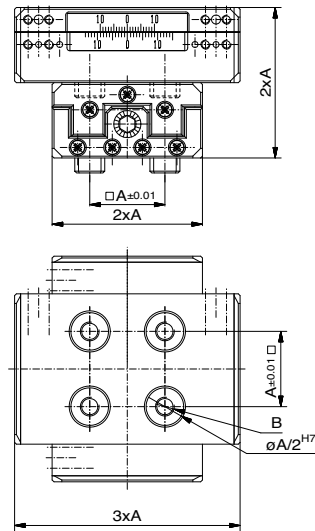
ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.

**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"

**Cross roller slide**

linear adjustment in 2 axes with lead screw

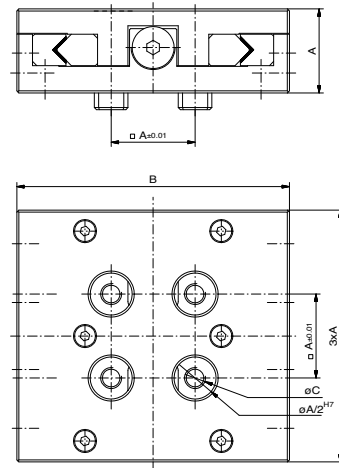
Nr.	A (AF)	B	max. N ↓	Shift	
82461	16	M4	200	±9	178
82462	25	M6	500	± 13,5	484
82463	40	M10	1500	±22	1.940
82399	50	M12	2500	±27	3.820



**Roller slide heavy duty**

linear adjustment in 1 axis with lead screw

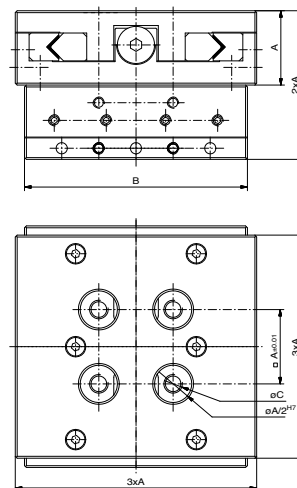
Nr.	A(AF)	B	C	Shift	max. N ↓	
280495	25	79	M6	+/- 13	1500	450
280496	40	130	M10	+/- 21	4500	2.000
280497	50	158	M12	+/- 26	7500	3.500

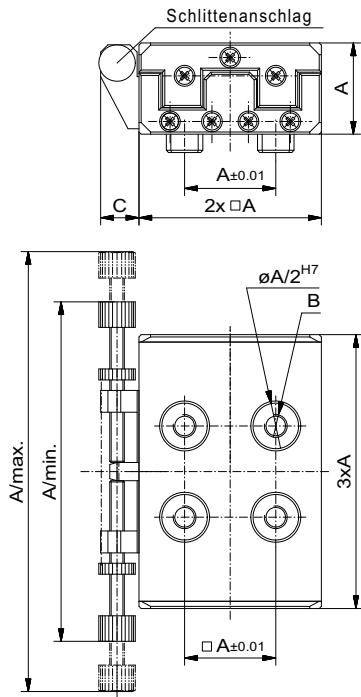


**Cross roller slide heavy duty**

linear adjustment in 2 axes with lead screw

Nr.	A(AF)	B	C	Shift	max. N ↓	
280498	25	79	M6	+/- 13	1500	900
280499	40	130	M10	+/- 21	4500	4.000
280500	50	158	M12	+/- 26	7500	7.000

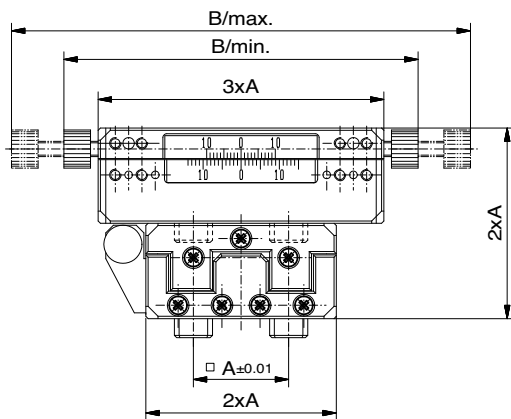




## Guiding slide

linear adjustment in 1 axis, floating, with stop screw

Nr.	A(AF)	B	C	Shift	A/min	A/max	max. N ↓	Ⓜ
82015	16	M4	7	± 8,5	59	77	200	70
<b>C</b> 82002	25	M6	10,5	± 13,5	93	120,5	500	250
<b>C</b> 82016	40	M10	16,8	± 22	146,8	192	1500	1.024
82441	50	M12	21	± 26,5	168	242	2500	6.000



## Cross guiding slide

linear adjustment in 2 axes, floating, with stop screw


Nr.	A(AF)	Shift	B/min	B/max	max. N ↓	Ⓜ
82436	16	± 8,5	59	77	200	150
<b>C</b> 82437	25	± 13,5	93	120,5	500	520
<b>C</b> 82438	40	± 22	146,8	192	1500	2.100
82439	50	± 26,5	168	242	2500	12.500

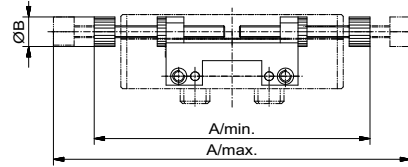


ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.








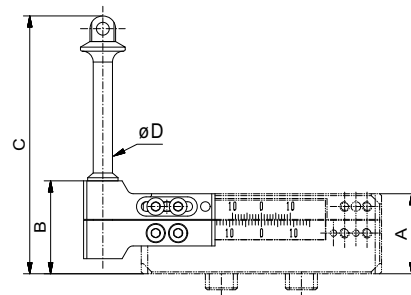
### Slide stop for guiding or roller slides

Nr.	A (AF)	A/min.	A/max.	B	
82411	16	59	77	6,4	98
82412	25	93	120,5	10	115
82413	40	146,8	192	16	131
82414	50	186	242	19	140



### Positioning guide and pin to fix heavy duty (HD) roller? slides in „0“ position

Nr.	A (AF)	B	C	øD	Typ	
83120	16	18,5	52,5	4,5	links	-
84323	16	18,5	52,5	4,5	rechts	-
 82711	25	29	80,5	6	links	50
 84321	25	29	80,5	6	rechts	50
 82833	40	47	119	8	links	180
 84320	40	47	119	8	rechts	180
83083	50	58	135	12	links	294
84322	50	58	135	12	rechts	294



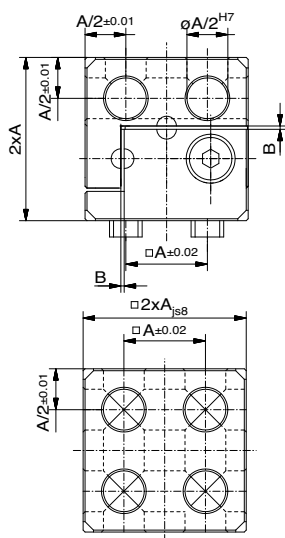
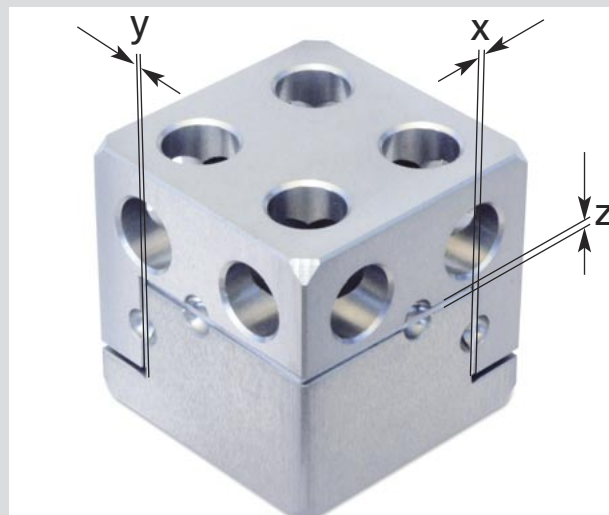
**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"

### ALUFIX shim blocks

Adjustment in x,y,z takes place by inserting or removing shim foils or shims. After adjustment settings are fixed using pins.

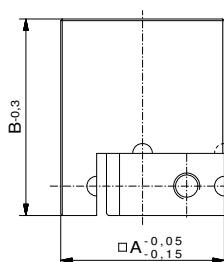
Values shown in the chart for range of adjustment are maximal values for one axis. Values in brackets show adjustment range when using more than one axis simultaneously.

ALUFIX shim blocks are available in a mirrored version on request.



**3D Shim block AF**  
for fine adjustment in 3 axes x,y,z, using shim foils (page 62).

Nr.	A (AF)	Shift B	Ⓜ
89177	25	x,y,z: +/- 1,0 (0,7)	270
89178	40	x,y,z: +/- 1,5 (1,1)	700
89179	50	x,y,z: +/- 2,0 (1,4)	2.200



**Contour block for 3D shim block**  
Preforms without surface protection,  
Alufix 25 / 40 / 50

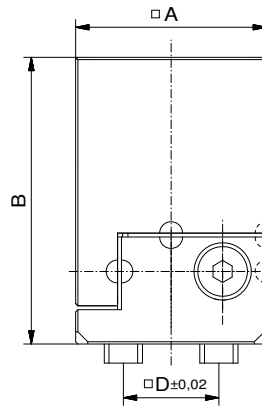
Nr.	AF	A x A x B	Ⓜ
34768	25	50x50x65	356
34769	25	50x50x90	536
34770	25	75x75x65	866
34771	40	80x80x104	1.879
34772	40	80x80x144	2.227
34773	40	120x120x104	4.871
34774	50	100x100x130	2.926
34775	50	100x100x180	5.833
34776	50	150x150x130	6.900

**C·E** ALUFIX preferred range  
Green: Item is available immediately.  
C: Classic version, E: Eco version, CE: Classic or Eco  
■: color "natural", ■: color "black"

**3D Shim block with integrated contour block**  
for fine adjustment in 3 axes x,y,z using shim foils  
(page 50).

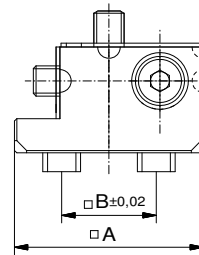
Nr.	A (AF)	Type	A x A x B	Shift	$\mu\text{m}$
91834	25	left	50x50x70	x,y,z: +/- 1,0 (0,7)	473
91835	40	left	80x80x120	x,y,z: +/- 1,6 (1,1)	2.074
91836	50	left	100x100x150	x,y,z: +/- 2,0 (1,4)	4.275
280766	25	right	50x50x70	x,y,z: +/- 1,0 (0,7)	473
280767	40	right	80x80x120	x,y,z: +/- 1,6 (1,1)	2.074
280768	50	right	100x100x150	x,y,z: +/- 2,0 (1,4)	4.275

Contour block without surface protection.



**3D Shim block base, side mounting**  
complete with shims and screws

Nr.	B (AF)	Type	A x A	$\mu\text{m}$
92165	25	left	50x50	203
92166	40	left	80x80	778
92167	50	left	100x100	1.485
98546	25	right	50x50	203
280672	40	right	80x80	778
280769	50	right	100x100	1.485



The angle of the center point is guaranteed by a specially machined contour block. The position in x, y and z is defined by the shimblock, the upper part of which is adjusted with shims in steps of 0.05 mm. Finally, the Shimblock is locked in order to achieve a permanent and stable position.

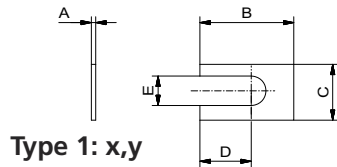
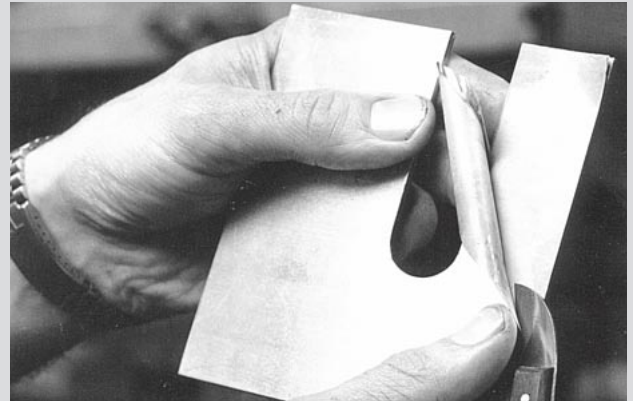
## ALUFIX shim foil

Peelable shim foil in various thicknesses  
 These shim foils are used in conjunction with fixed shims to adjust shim blocks.

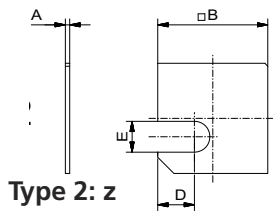
Shims comprise of 0,05mm thick laminated alu-foils. The easy process of peeling with a knife reduces the foil to the required thickness.

The advantages:

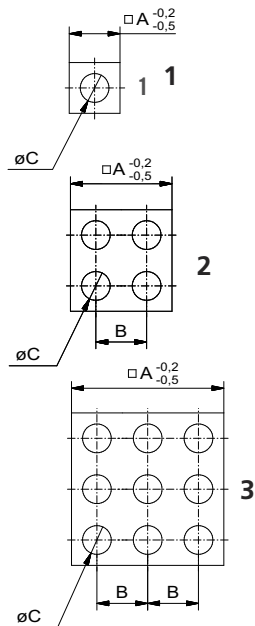
- Tolerances are evened out, making remachining jobs such as milling, grinding etc. unnecessary
- Reduces setting up times
- Reduces amount of machining required



Type 1: x,y



Type 2: z



**Shimfoil type 1 or 2**  
 peelable, in 0,05 mm layers,  
 for setting of shim blocks

Nr.	AF	Type	A	B	C	D	E	$\varnothing$
33013	25	2	1,0	37,5	-	12,5	10	1,5
33014	25	1	1,0	32	19	20,5	10	2,5
33261	40	2	1,6	60,5	-	20,5	20	6
33260	40	1	1,6	50	30	30	14	9
33632	50	2	2,0	75	-	25	25	12
33633	50	1	2,0	60	38	35	18	19

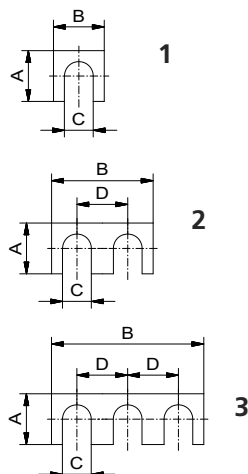
**Shimfoil closed**  
 peelable, 2 mm thick, in 0,05 mm layers

Nr.	AF	Type	A	B	C	$\varnothing$
27716	16	1	15	16	8,5	1
27717	16	2	31	16	8,5	4
27718	16	3	47	16	8,5	1
27719	25	1	24	25	13	5
27720	25	2	49	25	13	10
27721	25	3	74	25	13	20
27722	40	1	39	40	20,5	6
27723	40	2	79	40	20,5	26
27724	40	3	119	40	20,5	60
29315	50	1	49	50	25,2	10
29316	50	2	99	50	25,5	41
29317	50	3	149	50	25,5	95

**Shimfoil open**

peelable, 2 mm thick, in 0,05 mm layers

Nr.	AF	Type	A	B	C	D	$\frac{g}{h}$
25526	16	1	15	15	8,5	-	1
25527	16	2	15	31	8,5	16	1
25528	16	3	15	47	8,5	16	2
25529	25	1	24	24	13	-	2
25530	25	2	24	49	13	25	4
25531	25	3	24	74	13	25	10
25535	25	2	49	49	13	25	8
25532	40	1	39	39	20,5	-	8
25533	40	2	39	79	20,5	40	10
25534	40	3	39	119	20,5	40	16
27963	50	1	49	49	25,5	-	8
27964	50	2	49	99	25,5	50	16
27965	50	3	49	149	25,5	50	25

**Shim (with fixed thickness)**

for setting of shim blocks in x,y axis

**AF25, Type 1**

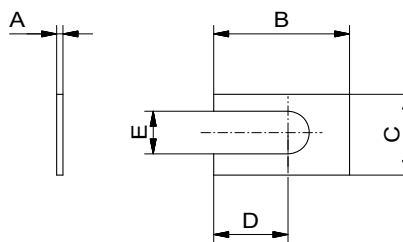
B=32, C=19, D=20,5, E=10

Nr.	A
128005	0,05
122010	0,1
122020	0,2
122030	0,3
122040	0,4
122050	0,5
122070	0,7
122080	0,8
122100	1,0
122150	1,5
122200	2,0

**AF40, Type 1**

B=50, C=30, D=30, E=14

Nr.	A
124005	0,05
124010	0,1
124020	0,2
124030	0,3
124040	0,4
124050	0,5
124070	0,7
124080	0,8
124100	1,0
124150	1,5
124200	2,0

**Shim (with fixed thickness)**

for setting of shim blocks in z axis

**AF 25, Type 2**

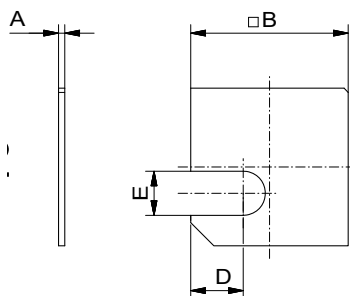
B=37,5 C=37,5 D=12,5 E=10

Nr.	A
129005	0,05
123010	0,1
123020	0,2
123030	0,3
123040	0,4
123050	0,5
123070	0,7
123080	0,8
123100	1,0
123150	1,5
123200	2,0

**AF 40, Type 2**

B=60,5 C=60,5 D=20,5 E=20

Nr.	A
125005	0,05
125010	0,1
125020	0,2
125030	0,3
125040	0,4
125050	0,5
125070	0,7
125080	0,8
125100	1,0
125150	1,5
125200	2,0



# TopPos Modular System

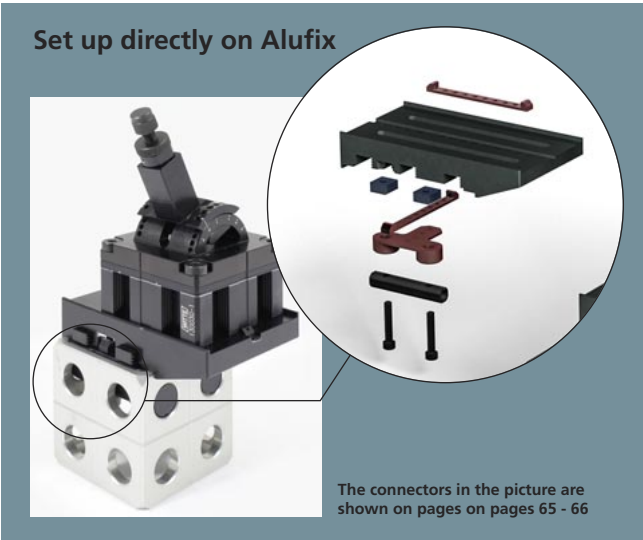
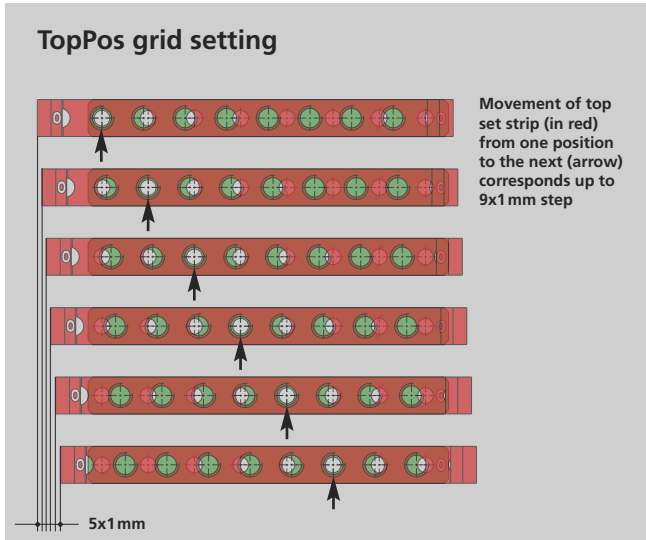
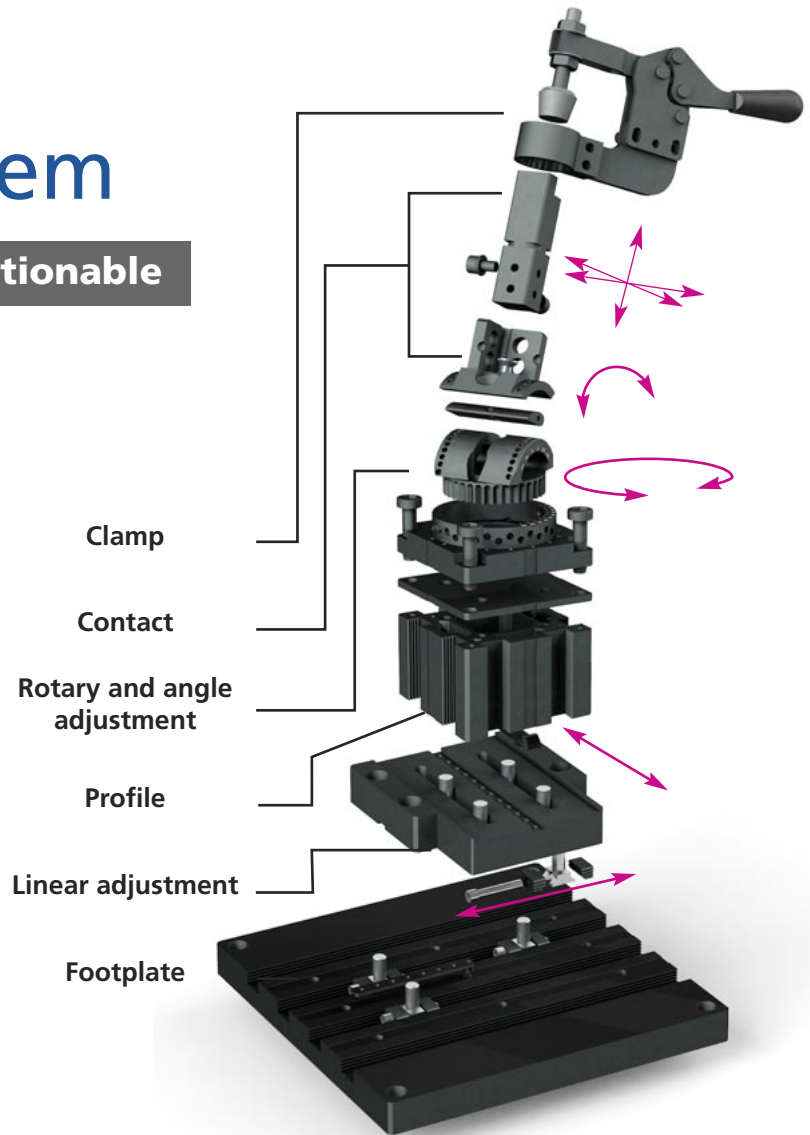
**Repeatable and freely positionable**

Novel positioning system for work-piece contact points.

Accurate and repeatable without dedicated, machined contours.

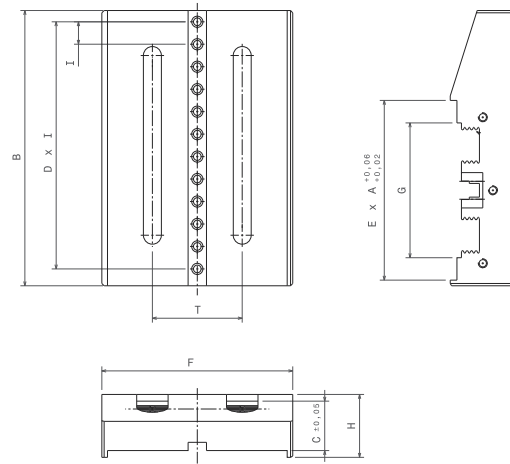
100% catalogue items for fast fixture building and adaptation.

- New design with TopPos elements:
- Replaces up to 90% of individual contour blocks with a few standard elements
- Positioning in grid of 1mm or 0,5° respectively = max. 0,5mm/0,25° deviation (optional 0,5mm grid possible)
- Precise alignment with 0,05mm shims, +/- 2mm range
- Linear components have 10mm, rotary components have 10° steps
- Actual grid achieved by a combination using differential steps (plus or minus 1)
- Profile size 80x80 (50x50 on request)
- Repeatable, reuseable



**Adapter cross plate ALUFIX**  
use with ALUFIX 40 bar and TopPos profile

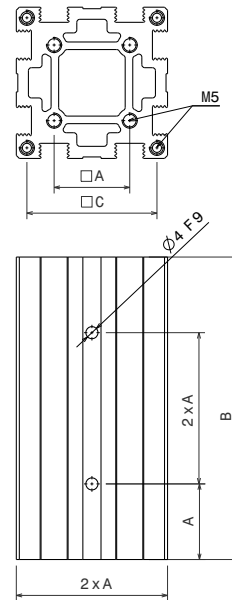
Nr.	A	B	C	D	E	F	G	H	I	T	
135003-1	40	122,5	22	10	2	85	60	28	10	40	398
135004-1	40	162,5	22	15	3	85	100	28	10	40	502



**Profiles**

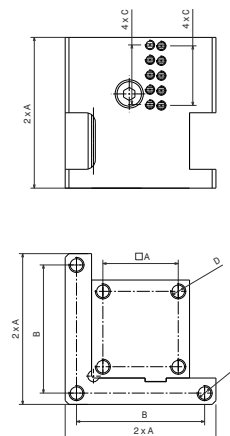
Nr.	A	B	C	
130010-1	40	10	68	70
130020-1	40	20	68	140
130030-1	40	30	68	210

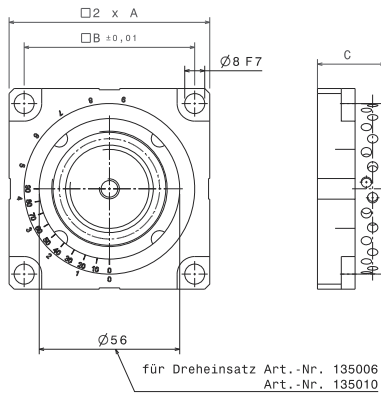
- Cross section 80x80
- Serrated slots, advantage: Rigid profile due to low slot depth
- 4 core holes for M8 spaced at 40mm
- 4 outer core holes for M6/M8 for face end connection
- Material EN-6005
- Other lengths on request



**Lift-Element**

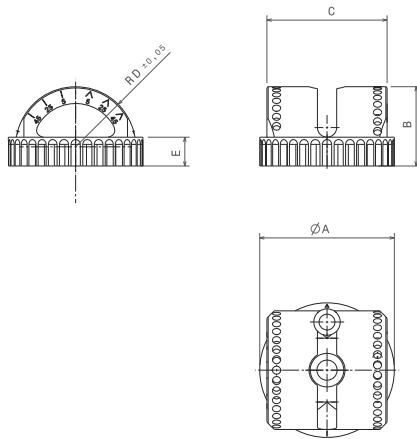
Nr.	A	B	C	D	
293664-1	40	68	7,9	M8	-





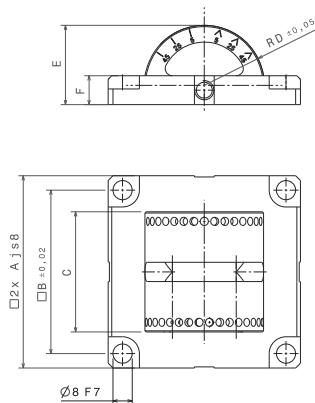
Base for Swivel turn insert

Nr.	A	B	C	
135005-1	40	68	27	-



Rotating insert for Swivel turn unit

Nr.	A	B	C	D	E	
135006-1	56	33	50	25	12	114



Face adapter for Swivel tops

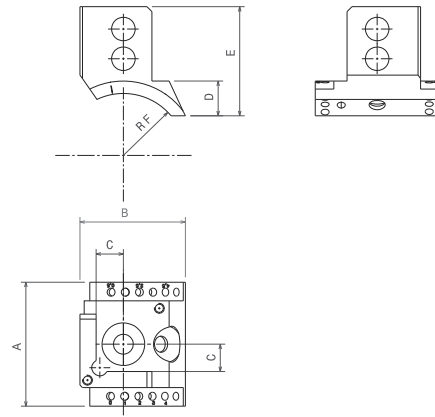
Nr.	A	B	C	D	E	F	
135009-1	40	68	50	25	33	12	-






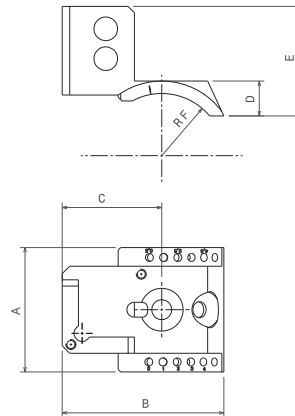
**Swivel top with shim angle**  
for Swivel turn unit

Nr.	A	B	C	D	E	F	
135008-1	50	42,5	12	14	44	25	48




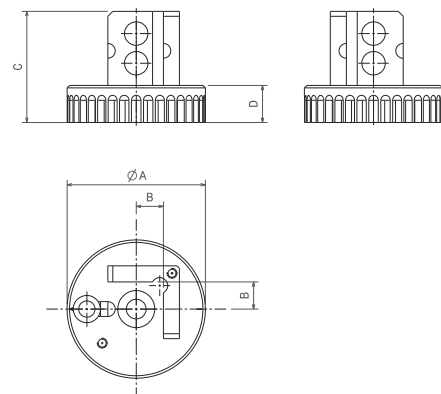
**Swivel top with offset shim angle**  
for Swivel turn unit

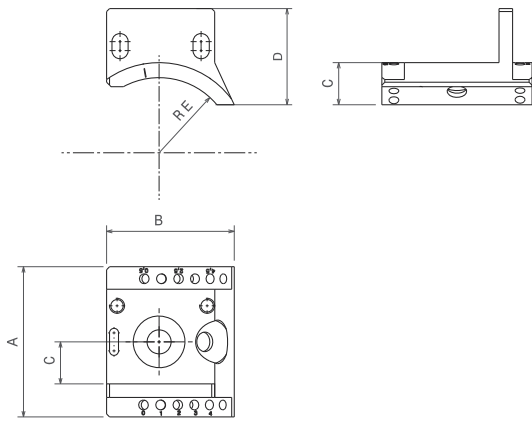
Nr.	A	B	C	D	E	F	
135084-1	50	65	40	14	44	25	58



**Rotating insert**  
with shim angle

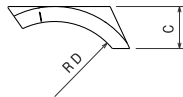
Nr.	A	B	C	D	
135010-1	56	12	45	15	110





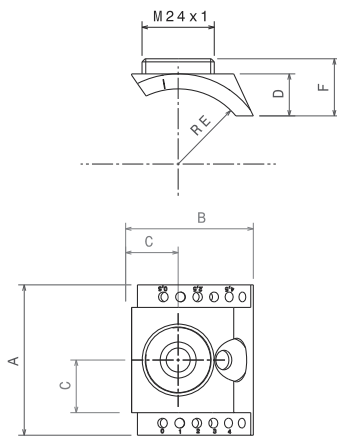
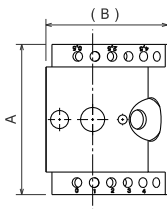
**Swivel top**  
for shim block horizontal

Nr.	A	B	C	D	E	Type	g
135019-1	50	42,5	14	32	25	left	38
135058-1	50	42,5	14	32	25	right	38



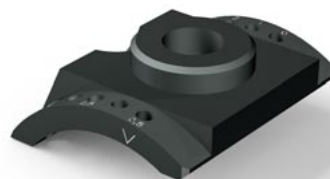
**Swivel top**  
for combined contact

Nr.	A	B	C	D	g
135134-1	50	40,53	14	25	28



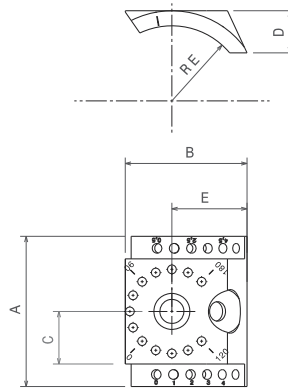
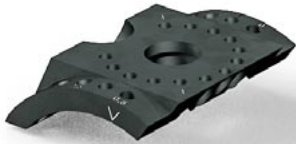
**Swivel top**  
with stud M24

Nr.	A	B	C	D	E	F	g
135069-1	50	42,5	17,5	14	25	19	32



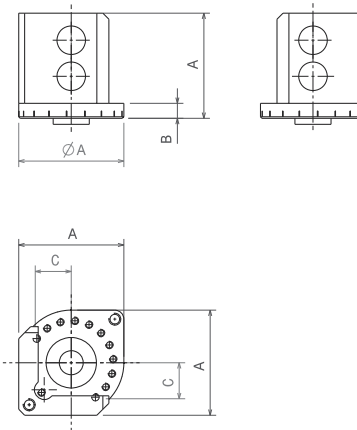
**Swivel top**  
for Rotary shim block

Nr.	A	B	C	D	E	
135063-1	50	40,5	17,5	14	25	28



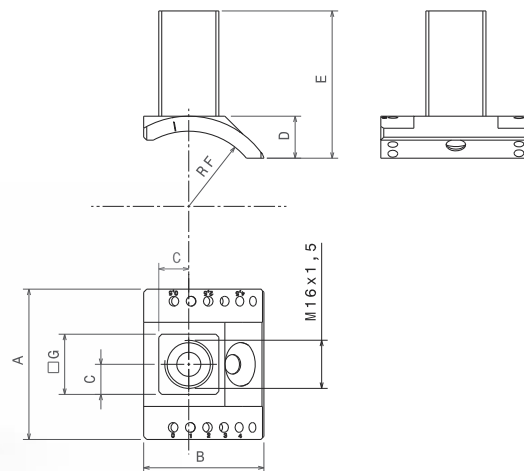
**Rotary shim block**  
for Swivel top 135063

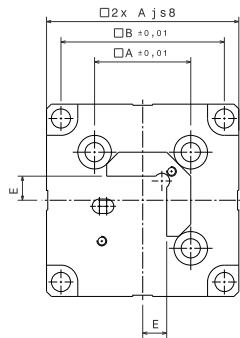
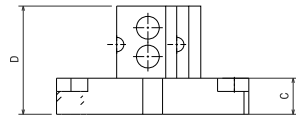
Nr.	A	B	C	
135064-1	35	5	12	32



**Swivel top**  
for Meisterbock screw

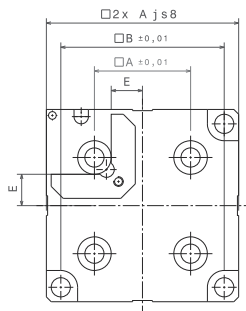
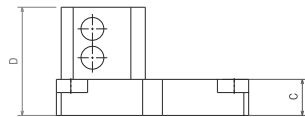
Nr.	A	B	C	D	E	F	G	
135007-1	50	40	10	14	49	25	20	44





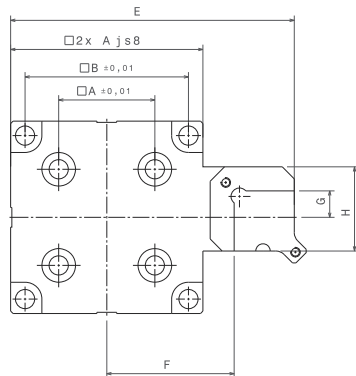
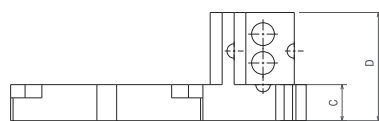
**Face adapter with shim angle centric**

Nr.	A	B	C	D	E	
135012-1	40	68	15	45	10	272



**Face adapter with shim angle excentric**

Nr.	A	B	C	D	E	
135011-1	40	68	15	45	13	278




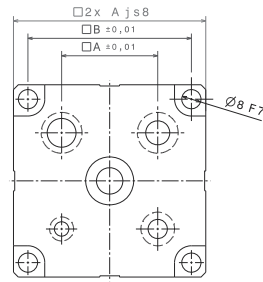
**Face adapter with shim angle offset**

Nr.	A	B	C	D	E	F	G	H	
135054-1	40	68	15	45	118	53	17	35	332




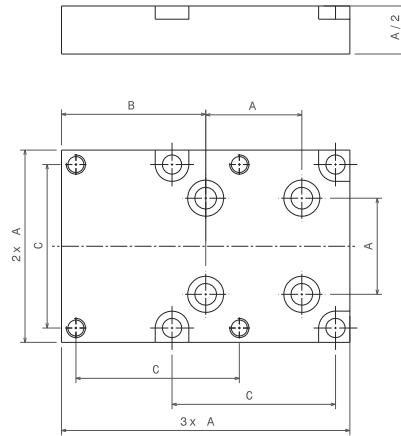
**Face adapter  
for centering pin**

Nr.	A	B	C	
135013-1	40	68	15	222




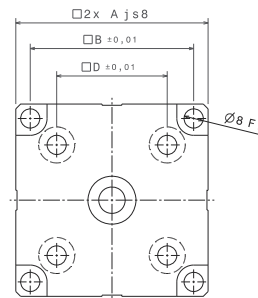
**Offset plate  
for ALUFIX 40**

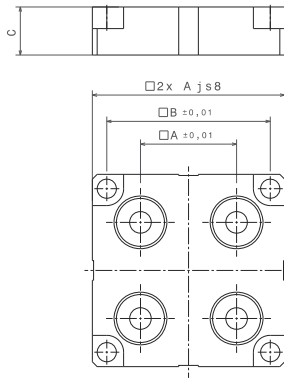
Nr.	A	B	C	
135076-1	40	68	15	222



**Face adapter  
for hook clamps**

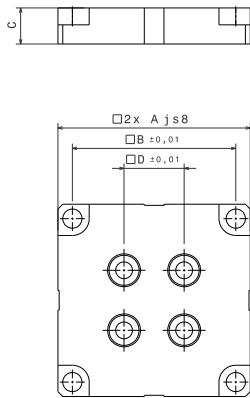
Nr.	A	B	C	D	
135050-1	40	68	15	46	222





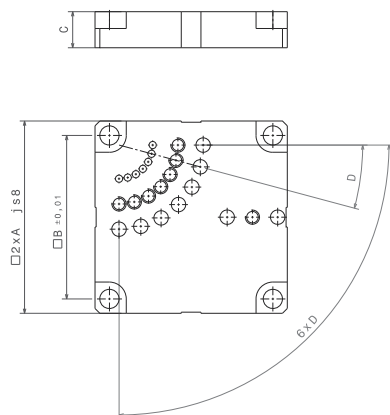
Face adapter  
for ALUFIX 40

Nr.	A	B	C	
135015-1	40	68	20	284



Face adapter  
for ALUFIX 25

Nr.	A	B	C	D	
135016-1	40	68	15	25	234



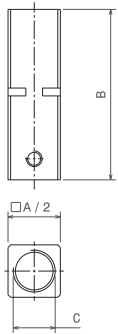
Face adapter  
for combined contact

Nr.	A	B	C	D	
135133-1	40	68	15	15	220




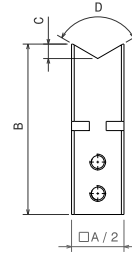
### Shim block for Meisterbock screw

Nr.	A	B	C	
135049-1	40	65	M16 x 1,5	66



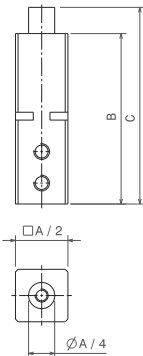
### Shim block with V

Nr.	A	B	C	D	
135122-1	40	65	5,5	120°	75



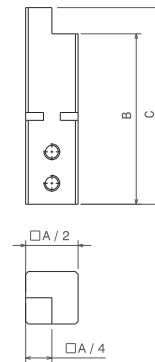
### Shim block ø10, centric

Nr.	A	B	C	
135068-1	40	65	75	68




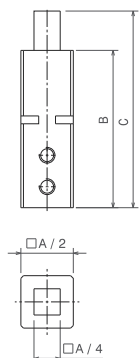
### Shim block 10 x 10, excentric

Nr.	A	B	C	
135024-1	40	65	75	70



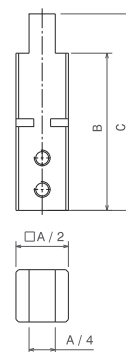
### Shim block 10 X 10, centric

Nr.	A	B	C	
135067-1	40	60	75	70



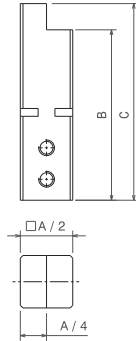
### Shim block 10 X 20, centric

Nr.	A	B	C	
135066-1	40	60	75	74



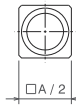
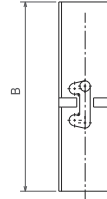
**Shim block**  
10x20 excentric

Nr.	A	B	C	
135025-1	40	65	M16 x 1,5	66




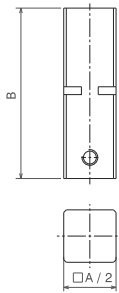
**Shim block**  
for retractable pin

Nr.	A	B	
135108-1	40	72	48




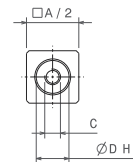
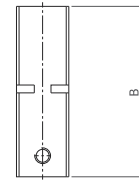
**Shim block**  
20x20

Nr.	A	B	C	
135023-1	40	65	75	68




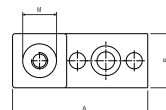
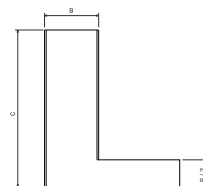
**Shim block**  
with ALUFIX 25 hole

Nr.	A	B	C	D	
135046-1	40	65	5,5	120°	75




**Combined contact**  
with ALUFIX 25 hole

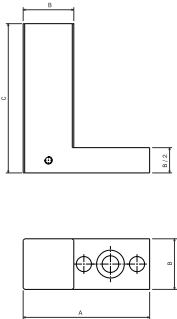
Nr.	A	B	C	M	
300308-1	40	60	75	AF 25	74





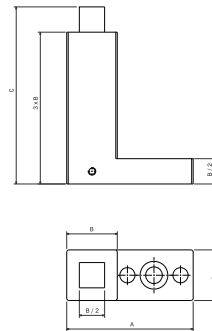
### Combined contact 20x20

Nr.	A	B	C	
300306-1	50	20	70	85



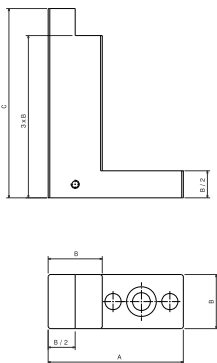
### Combined contact 10x10 centric

Nr.	A	B	C	
135149-1	50	20	70	80



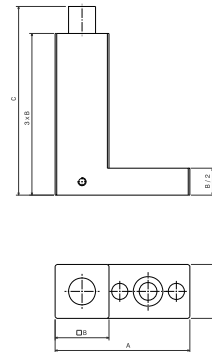
### Combined contact 10x20 excentric

Nr.	A	B	C	
135148-1	50	20	70	80




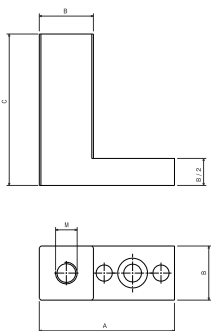
### Combined contact D 10 centric

Nr.	A	B	C	
135147-1	50	20	70	80




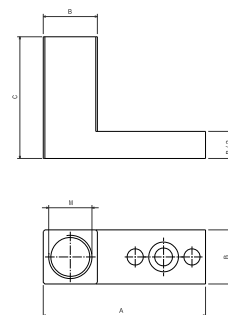
### Combined contact for Meisterbock screw

Nr.	A	B	C	M	
300303-1	50	20	56	M8x1	82

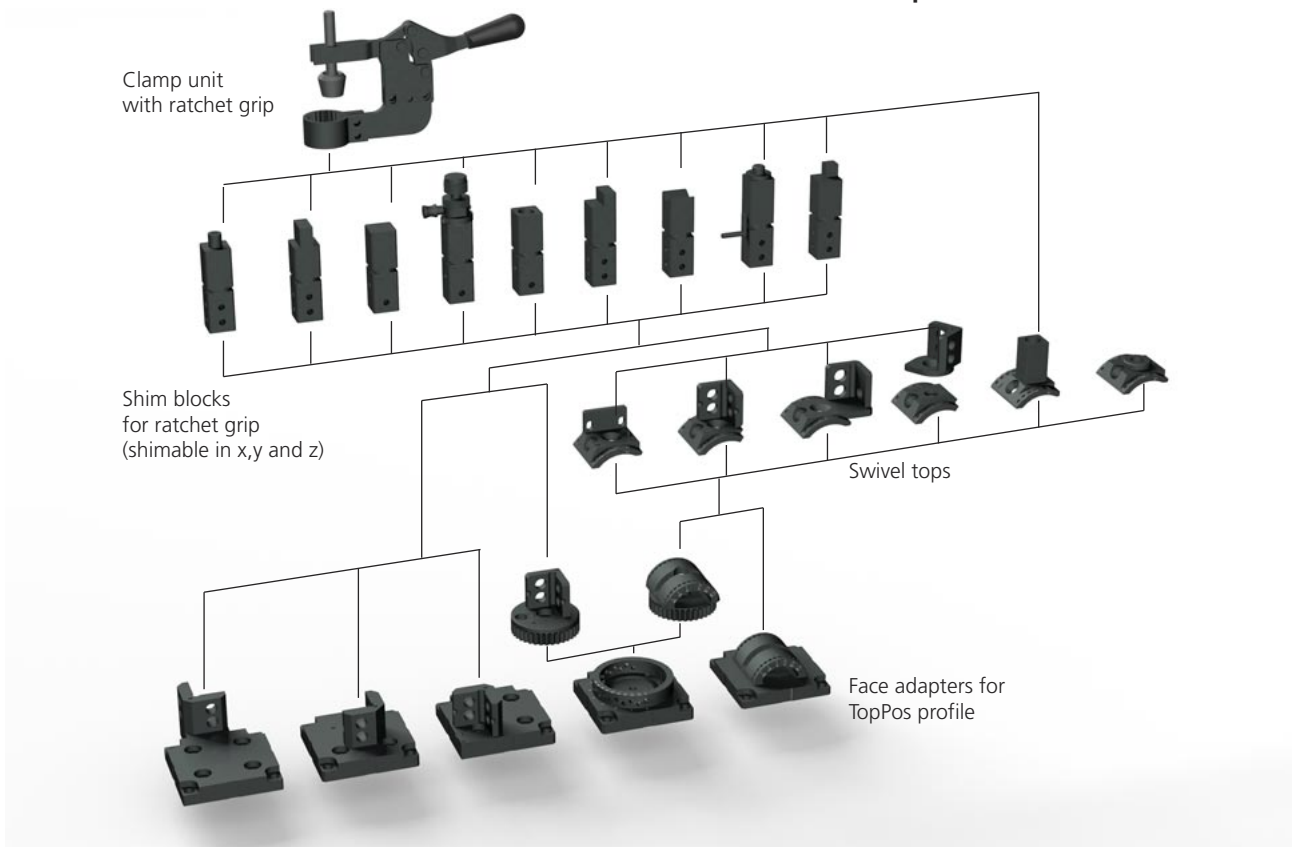


### Combined contact for Meisterbock screw

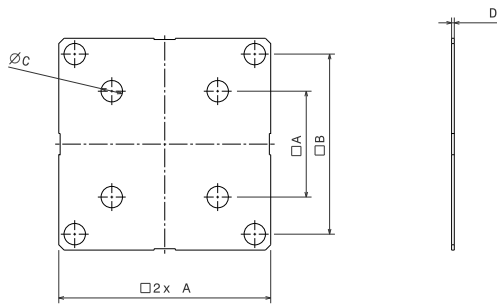
Nr.	A	B	C	M	
300304-1	50	20	45	M16x1,5	65



Variations for contact points



Spacer plate for TopPos profiles



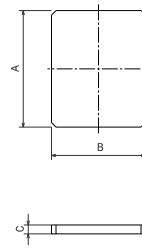
Nr.	A	B	C	D	$\varnothing c$
135059-1	40	68	8,1	1	16
135060-1	40	68	8,1	2	30
135061-1	40	68	8,1	4	60
135062-1	40	68	8,1	7	110



**Spacer base**

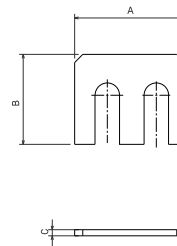
with fixed thickness, for TopPos Shimblock

Nr.	A	B	C	$\frac{g}{mm}$
135086	26	21	0,05	1
135087	26	21	0,1	1,1
135088	26	21	0,2	2,2
135089	26	21	0,3	3,3
135090	26	21	0,4	4,4
135091	26	21	0,5	5,5
135092	26	21	0,7	7,7
135093	26	21	0,8	8,8
135094	26	21	1,0	11
135095	26	21	1,5	16,5
135096	26	21	2,0	22

**Spacer side**

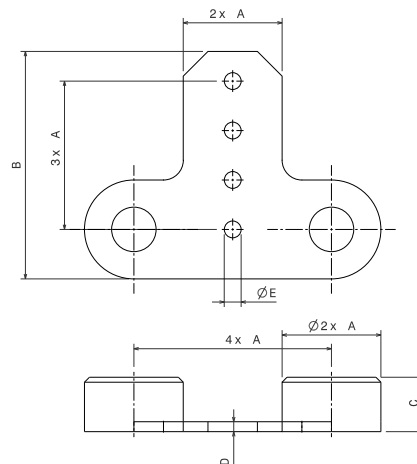
with fixed thickness, for TopPos Shimblock

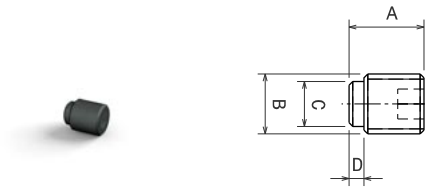
Nr.	A	B	C	$\frac{g}{mm}$
135097	24	22	0,05	1
135098	24	22	0,1	1,1
135099	24	22	0,2	2,2
135100	24	22	0,3	3,3
135101	24	22	0,4	4,4
135102	24	22	0,5	5,5
135103	24	22	0,7	7,7
135104	24	22	0,8	8,8
135105	24	22	1,0	11
135106	24	22	1,5	16,5

**Set strip for ALUFIX 40**

for mounting on ALUFIX grid, spacing=10mm

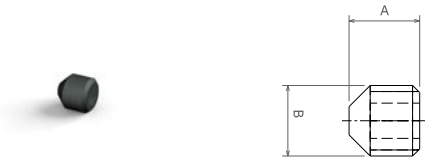
Nr.	A	B	C	D	E	$\frac{g}{mm}$
135028-1	10	46	11	2	3,4	10





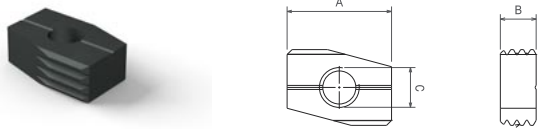
**Threaded pin**  
DIN 915, for positioning in grid strips

Nr.	A	B	C	D	g
17924-S1	8	M5	3,5	2,75	1



**Threaded pin**  
DIN 914, for rotating inserts

Nr.	A	B	g
10798-S1	5	M5	1



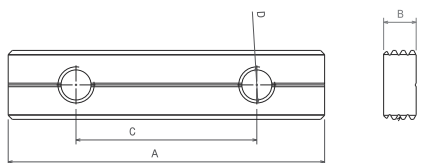
**Slot nut**  
rhomboid

Nr.	A	B	C	g
135030-1	21	7,2	M8	4



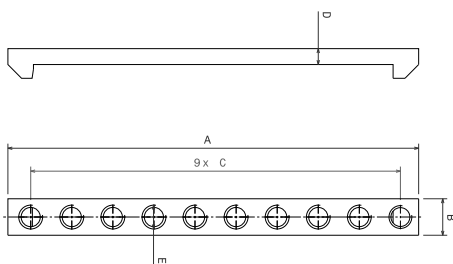
**Slot nut**  
single

Nr.	A	B	C	g
135029-1	20	7,2	M8	4



**Slot nut**  
double

Nr.	A	B	C	D	g
135031-1	70	7,2	40	M8	18




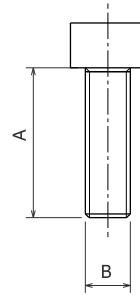
**Set strip**  
80 mm, spacing =9mm

Nr.	A	B	C	D	E	g
135027-1	90	8	9	3,5	M5	6




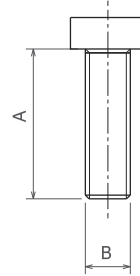
### Socket head screw DIN 912

Nr.	A	B	
10526-S1	30	M4	3
11377-S1	10	M6	2
10630-S1	16	M6	3
10494-S1	20	M6	4




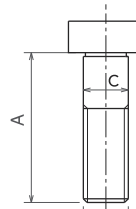
### Socket head screw DIN 7984

Nr.	A	B	
13021-S1	12	M8	5
11359-S1	20	M8	8
10004-S1	25	M8	10




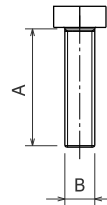
### Fitting screw similar DIN 7984

Nr.	A	B	C	
135113-1	30	M8	8 <sup>h7</sup>	12
135114-1	25	M8	8 <sup>h7</sup>	10




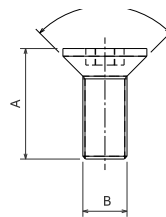
### Hex screw DIN 933

Nr.	A	B	
12875-S1	16	M4	2



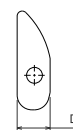
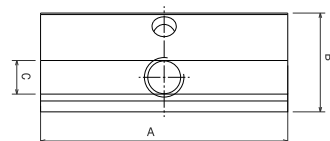
### Countersunk screw DIN 7991

Nr.	A	B	
12371-S1	16	M6	2
10576-S1	20	M8	3



### Crosspiece double for Swivel turn unit

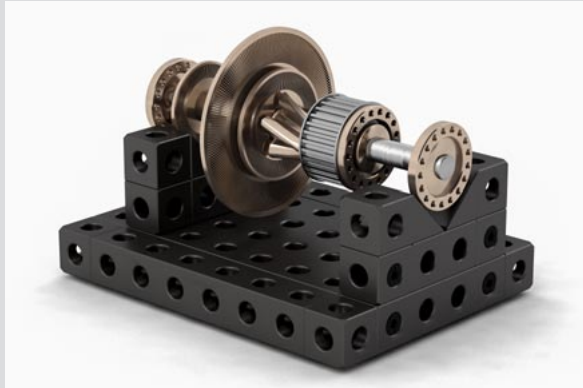
Nr.	A	B	C	D	
135039-1	50	20	6,8	6,7	14



# ALUFIX Classic

## V pieces and delta blocks

These elements are used primarily for mounting cylindrical parts



Application example for V 90°



Application example for delta block 120°



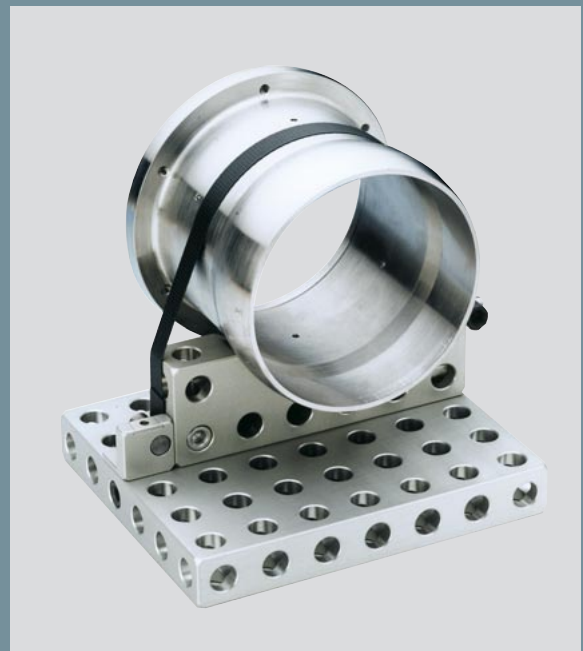
Application example for rotated delta blocks 90°

Knife Vs for small parts, Vs with various angles and in different versions for large part diameters

2 delta blocks mounted next to each other also create a V, and by spacing them can be used more flexibly and also for large diameters.

By rotating them 90° it is also possible to mount conical or wedge shaped parts.

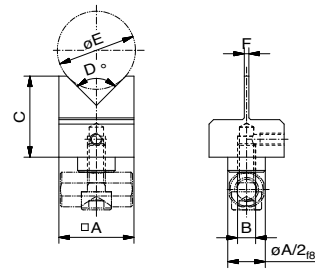
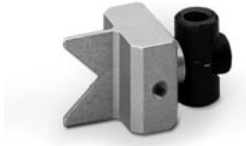
### Application example for V with winder tape



The tape is used with Vs or delta blocks together with winders and deflectors (page 100)

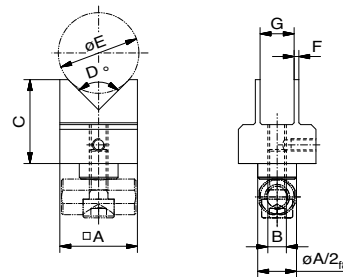
### V piece 90° single

Nr.	A(AF)	B	C	D	E	F	G
80923	16	M4	17,5	90°	max. $\varnothing$ 17	1	9
82230	25	M6	27	90°	max. $\varnothing$ 26	1,5	32



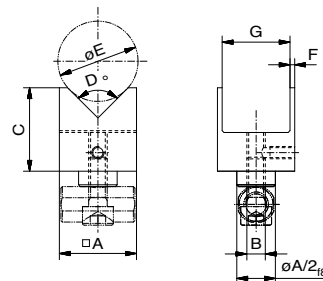
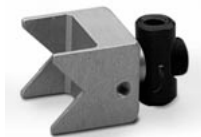
### V piece 90° double, V narrow

Nr.	A(AF)	B	C	D	E	F	G	G
80921	16	M4	17,5	90°	max. $\varnothing$ 17	1	7	10
82232	25	M6	27	90°	max. $\varnothing$ 26	1,5	11	35



### V piece 90° double, V wide

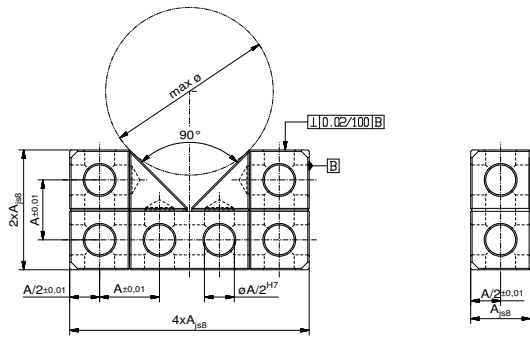
Nr.	A(AF)	B	C	D	E	F	G	G
80922	16	M4	17,5	90°	max. $\varnothing$ 17	1	14	10
82231	25	M6	27	90°	max. $\varnothing$ 26	1,5	22	35



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Other colors on request.

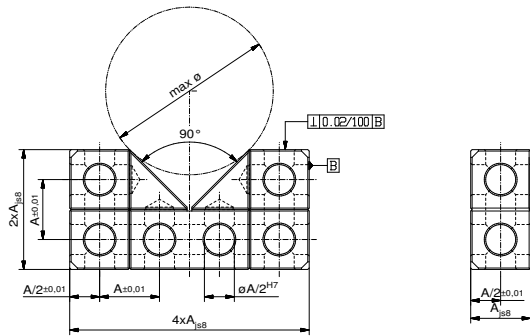


V piece:  
Application with optional  
stop see page 84.



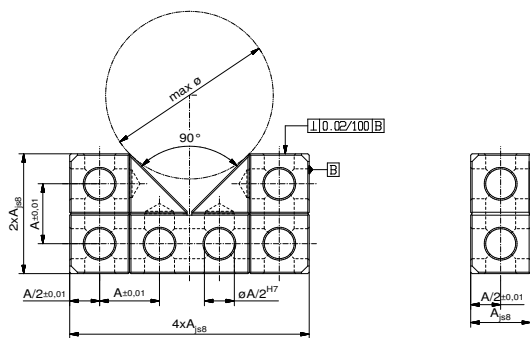
V block 90°  
standard version

Nr.	A (AF)	max. ø	g
21991	16	45	51
<b>C</b> 21992	25	70	185
<b>C</b> 21272	40	113	189
28173	50	142	1.362



V block 90°  
with hard metal surface

Nr.	A (AF)	max. ø	g
80975	25	70	251
81511	40	113	1.115
82785	50	142	1.326



V block 90°  
with magnetic surface

Nr.	A (AF)	max. ø	g
81508	25	70	203
81513	40	113	1.115
82784	50	142	1.326



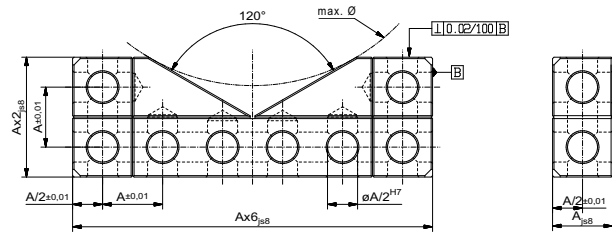
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C: Classic version, E: Eco version, CE: Classic or Eco  
■: color "natural", ■: color "black"



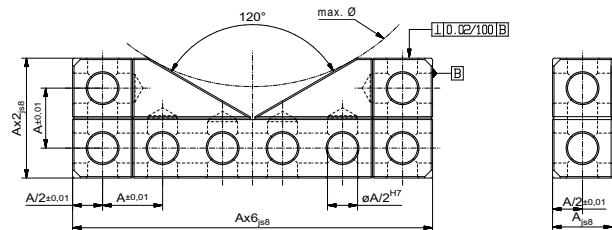
### V block 120° standard version

Nr.	A (AF)	max. $\phi$	$\frac{g}{g}$
21988	16	110	78
21987	25	170	299
21277	40	275	1.218
28175	50	345	2.395



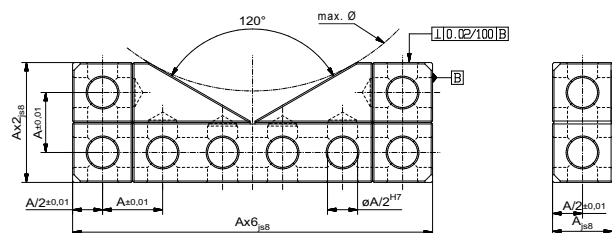
### V block 120° with hard metal surface

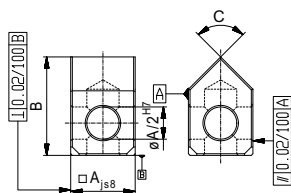
Nr.	A (AF)	max. $\phi$	$\frac{g}{g}$
80976	25	170	382
81512	40	275	1.577
82786	50	345	2.350



### V block 120° with magnetic surface

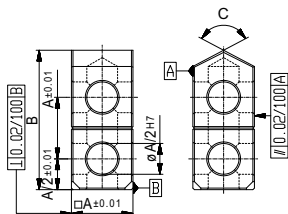
Nr.	A (AF)	max. $\phi$	$\frac{g}{g}$
81509	25	170	316
81514	40	275	1.577
82787	50	345	2.350





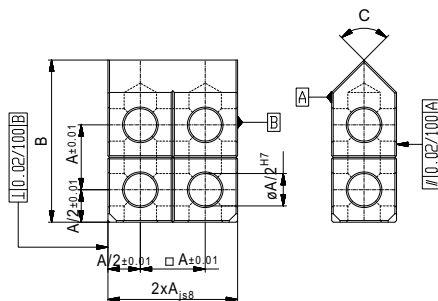
**Delta block form 1**  
90° or 120°

Nr.	A (AF)	B	C	g
22234	16	24	90°	10
22235	25	37,5	90°	35
22236	40	60	90°	145
28043	50	75	90°	173
22240	16	20	120°	8
22241	25	31,25	120°	31
22242	40	50	120°	126
28046	50	62,5	120°	173



**Delta block form 2**  
90° or 120°

Nr.	A (AF)	B	C	g
22176	16	40	90°	16
<b>C</b> 22177	25	62,5	90°	61
22178	40	100	90°	253
28044	50	125	90°	750
22252	16	36	120°	15
22253	25	56,25	120°	57
22254	40	90	120°	234
28047	50	112,5	120°	453



**Delta block form 3**  
90° or 120°

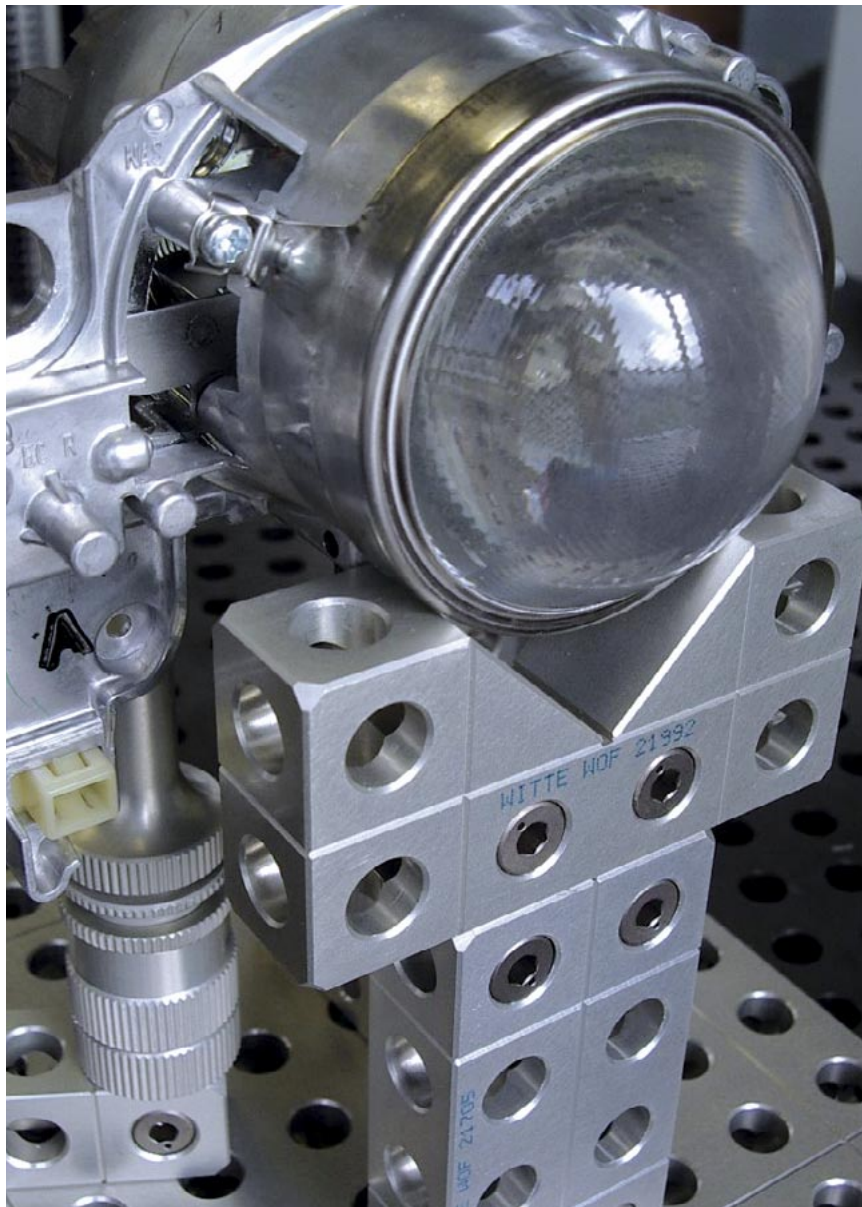
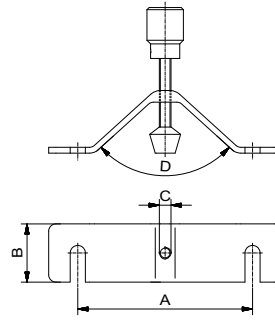
Nr.	A (AF)	B	C	g
22173	16	40	90°	18
<b>C</b> 22174	25	62,5	90°	123
22175	40	100	90°	506
28045	50	125	90°	981
22255	16	36	120°	30
22256	25	56,25	120°	114
22257	40	90	120°	468
28048	50	112,5	120°	1.173

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 ■: color "natural", ■: color "black"

### Clamp bracket for V-block

Nr.	System	A	B	C	D	$\alpha$
288281	AF 16	48	16	M4	90°	70
288282	AF 16	80	16	M4	120°	90
285344	AF 25	75	25	M6	90°	80
285345	AF 25	125	25	M6	120°	100
285346	AF 40	120	40	M8	90°	210
285347	AF 40	200	40	M8	120°	270

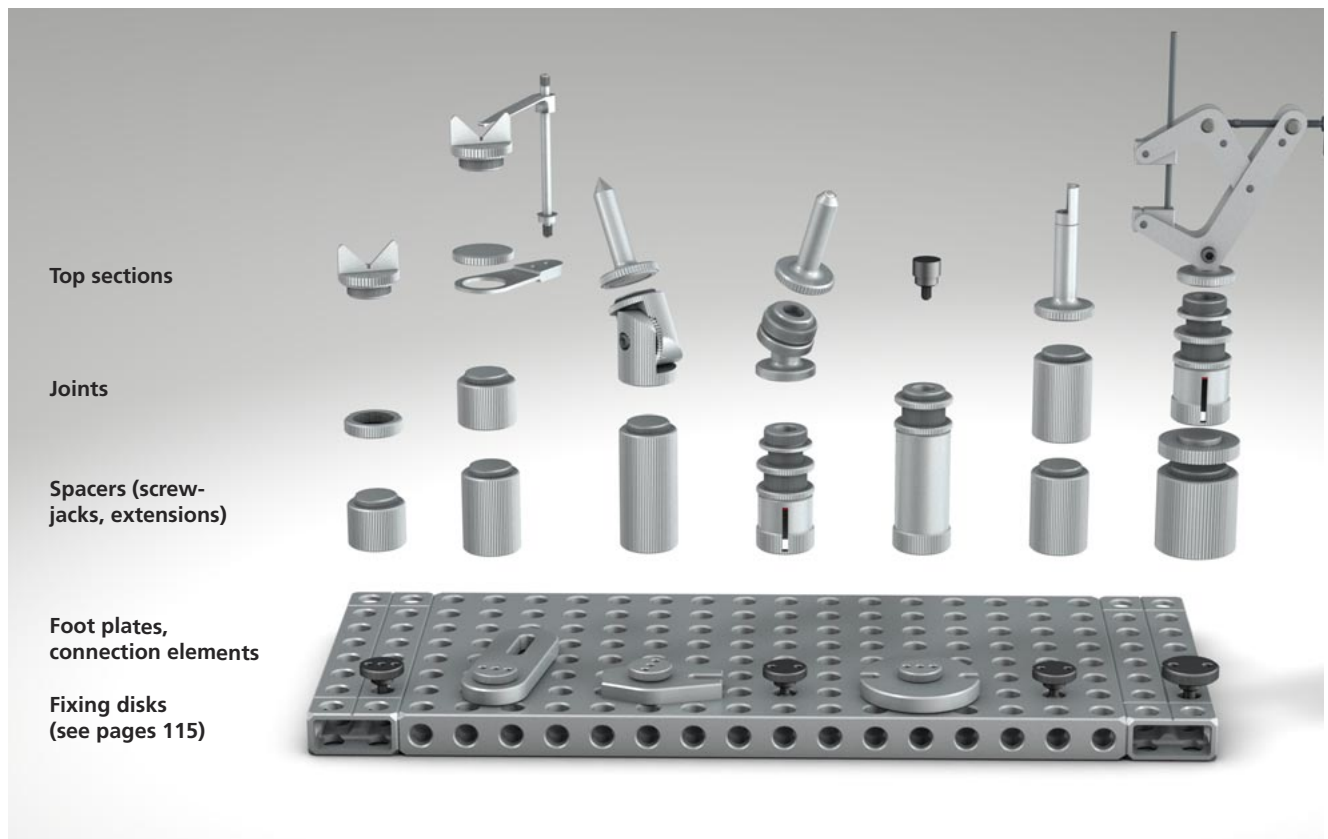


Application example for V 90°.

# ALUFIX Classic

## Screw jacks and top sections

### Connection variety between part, frame and base plate



ALUFIX top sections provide the contact point between a part and an ALUFIX frame or base plate.

Using footplates, screw jacks, extensions and joints offset, variable and reliable positioning of numerous top section elements is achievable.

#### Material and surface characteristics for top sections

Fixed and spring loaded centres, true line studs, rotating top sections:  
High tensile aluminium  
Hard slide coated


Centres with ball:

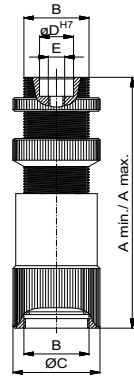
- Base in high tensile aluminium,
- balls hardened and polished

Remaining top sections:


- High tensile aluminium, anodized

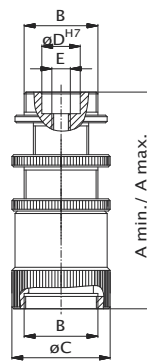
### Screw-jack with precision thread and check nut

Nr.	A/min	A/max	B	C	D	E	
90614	38	50	M24x1	32	8	M4	65
<b>C</b> 82139	38	50	M24x1	32	12,5	M6	65
<b>C</b> 82033	70	105	M24x1	32	12,5	M6	120
82085	110	170	M32x1	42	20	M10	330




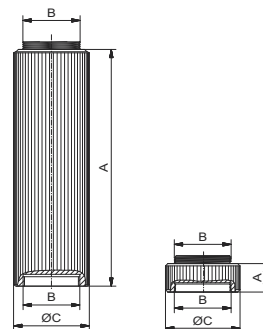
### Screw-jack with anti-turn lock D32 and D42

Nr.	A/min	A/max	B	C	D	E	
285201	50	70	M24x1	32	12,5	M6	78
285202	70	105	M24x1	32	12,5	M6	120
285203	105	170	M32x1	42	20	M10	310



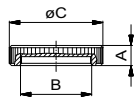
### Screw-jack extension

Nr.	A	B	C	
<b>C</b> 20628	6	M24x1	32	12
<b>C</b> 23286	12	M24x1	32	25
<b>C</b> 123461	15	M24x1	32	32
22856	100	M24x1	32	210
123462	15	M32x1	42	34
21658	100	M32x1	42	225



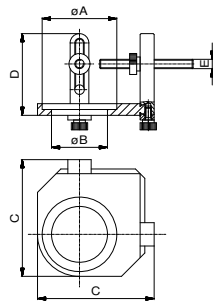
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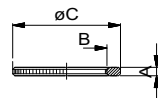
**Cap for screw-jack**  
aluminium or plastic

	Nr.	Material	A	B	C	
<b>C</b>	21667	Alu	6,5	M24x1	32	10
	21669	Alu	8,5	M32x1	42	18
	21666	POM	6,5	M24x1	32	4
	21668	POM	8,5	M32x1	42	9



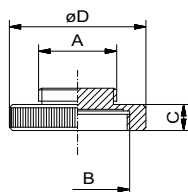
**xy-Stop**  
for screw-jack

	Nr.	A	B	C	D	E	
	285204	32	24	50	35	M4	32
	285205	42	32	65	46	M5	68



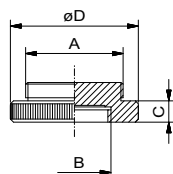
**Ring for screw jack**  
for use with top sections

	Nr.	A	B	C	
	25683	2,5	M24x1	32	2



**Cross over**  
male/female

	Nr.	A	B	C	D	
	21659	M24x1	M32x1	8	42	21



**Cross over**  
male/female

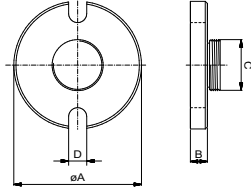
	Nr.	A	B	C	D	
	21227	M32x1	M24x1	7	42	32

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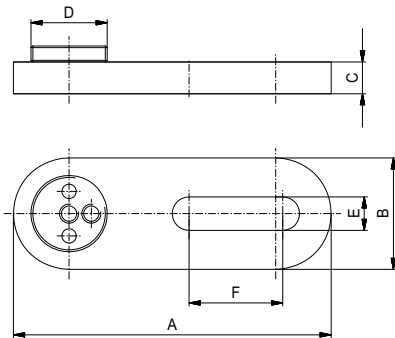
### Universal plate for connection independant of grid

Nr.	A	B	C	D	$\frac{G}{g}$
21670	60	8	M24x1	8,5	65
21671	75	8	M32x1	8,5	106



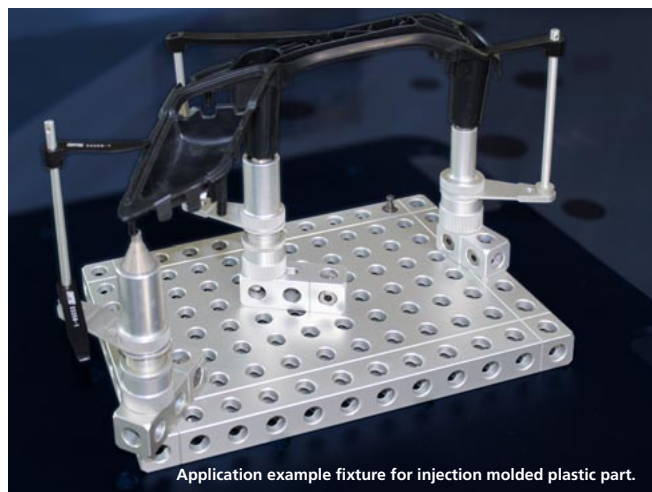
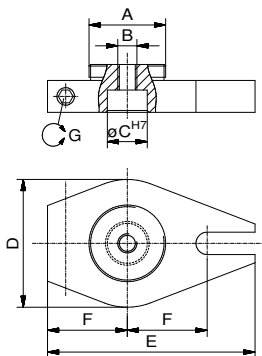
### Clamping plate

Nr.	A	B	C	D	E	F	$\frac{G}{g}$
85232	100	35	10	M24x1	10,5	29,5	85

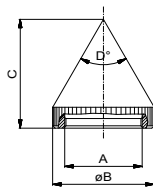


### Footplate with pivot pin

Nr.	A	B	C	D	E	F	G	$\frac{G}{g}$
285208	M24x1	M6	12,5	40	65	25	6°	50
285209	M32x1	M10	20	65	105	40	4°	131

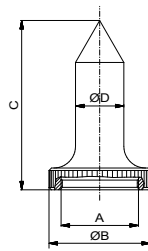


Application example fixture for injection molded plastic part.



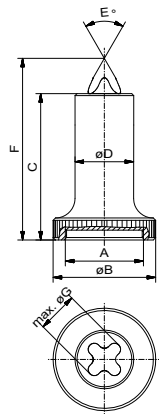
**Center short**

Nr.	A	B	C	D	$\frac{g}{g}$
21644	M24x1	32	35	60	30
21645	M32x1	42	45	60	66



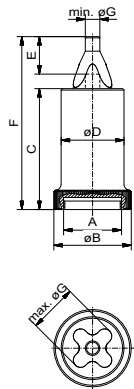
**Center long**

Nr.	A	B	C	D	$\frac{g}{g}$
23638	M12x0,5	16	27,5	8	4
<b>C</b> 21646	M24x1	32	50	12,5	25
21648	M24x1	32	75	12,5	33
21647	M32x1	42	70	20	67
21649	M32x1	42	120	20	106



**Auto-center spring loaded, star shaped**

Nr.	A	B	C	D	E	F	min. ø	max. ø	$\frac{g}{g}$
95532	M24x1	32	50	18	60	61	1	12,5	40



**Auto-center spring loaded, star shaped, with cylindrical pin**

Nr.	A	B	C	D	E	F	min. ø	max. ø	$\frac{g}{g}$
94543	M24x1	32	50	26	15,5	71,5	6	20	120
95531	M32x1	42	50	36	15,5	71,5	16	28	130

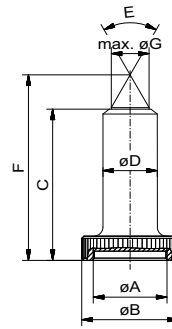
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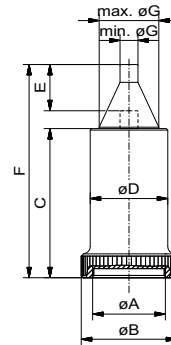
### Autocenter spring loaded

Nr.	A	B	C	D	E	F	min. $\phi$	max. $\phi$	$\frac{g}{g}$
<b>C</b> 81212	M24x1	32	50	18	60	61	1	12,5	40



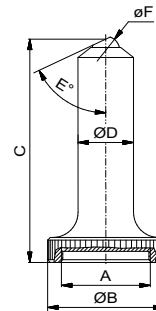
### Autocenter spring loaded, with cylindrical pin

Nr.	A	B	C	D	E	F	min. $\phi$	max. $\phi$	$\frac{g}{g}$
82252	M24x1	32	50	26	15,5	71,5	6	20	60



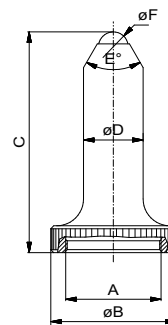
### True line stud

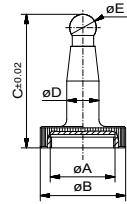
Nr.	A	B	C	D	E	F	$\frac{g}{g}$
<b>C</b> 80590	M24x1	32	32,6	15	65	10	30
<b>C</b> 80661	M24x1	32	77,6	15	65	10	45
80591	M32x1	42	37,6	20	65	10	36
80666	M32x1	42	122,6	20	65	10	83



### Center with ball

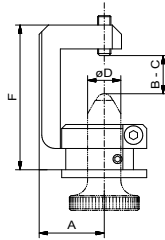
Nr.	A	B	C	D	E	F	$\frac{g}{g}$
90545	M24x1	32	34	15	60	10	27
<b>C</b> 80584	M24x1	32	52	12,5	60	6	21
<b>C</b> 80585	M24x1	32	53	12,5	60	8	22
80586	M32x1	42	72	20	60	6	60
80587	M32x1	42	73	20	60	8	57
80588	M32x1	42	74	20	60	10	63
80589	M32x1	42	75	20	60	12	60





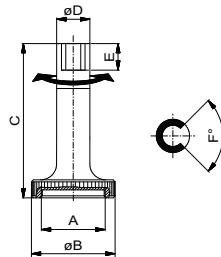
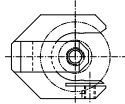
**Centering element  
with reference ball**

Nr.	A	B	C	D	E	
82142	M24x1	32	50	12	10	27



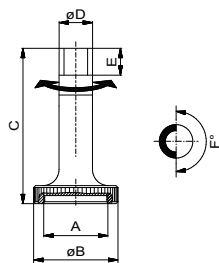
**C clamp  
adjustable, without center with ball**

Nr.	A	B	C	D	F	
81111	28	0	15	12,5	52	123



**Stop and support 90°  
swivel top, fixing screw**

Nr.	A	B	C	D	E	F	
81113	M24x1	32	58	12,5	10	90	26



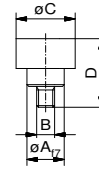
**Stop and support 180°  
swivel top, fixing screw**

Nr.	A	B	C	D	E	F	
81112	M24x1	32	58	12,5	10	180	27

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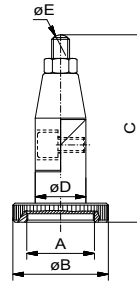
### Support pin for screw jack

Nr.	System	A	B	C	D	
428146	25	12,5	M6	19,8	23	31



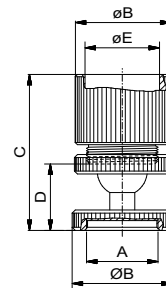
### Center with ball and joint

Nr.	A	B	C	D	E	
82174	M24x1	32	57-67	17	6	37




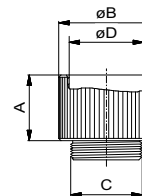
### Magnetic holder with ball joint

Nr.	A	B	C	D	E	
80941	M24x1	32	52,3	22,2	25	85



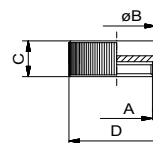
### Magnetic holder without ball joint

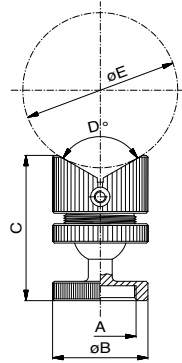
Nr.	A	B	C	D	
80948	22	32	M24x1	25	60



### Moulding cap for use with compound resin

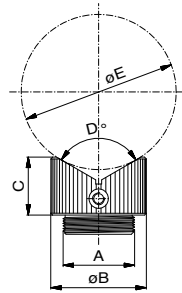
Nr.	A	B	C	D	
22005	M24x1	26	12	32	11





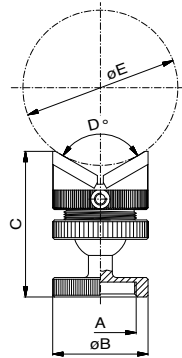
V block 120°  
with ball joint

Nr.	A	B	C	D	E	
<b>C</b> 80733	M24x1	32	49	120	max. 52	58



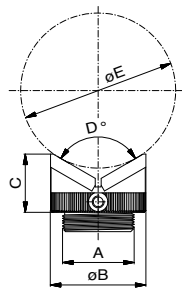
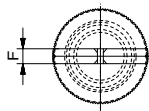
V block 120°  
without ball joint

Nr.	A	B	C	D	E	
22286	M24x1	32	19,4	120	max. 52	34



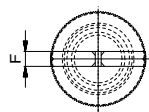
Knife V 120°  
with ball joint

Nr.	A	B	C	D	E	F	
80927	M24x1	32	49	120	max. 56	5	42



Knife V 120°  
without ball joint


Nr.	A	B	C	D	E	F	
22631	M24x1	32	19,5	120	max. 56	5	19

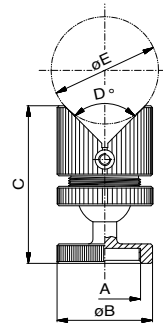


ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.

**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"

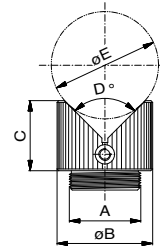
### V block 90° with ball joint

Nr.	A	B	C	D	E	
80725	M24x1	32	53	90	max. 36	61




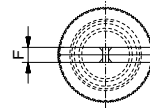
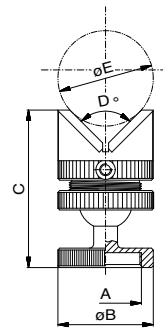
### V block 90° without ball joint

Nr.	A	B	C	D	E	
22285	M24x1	32	23,5	90	max. 36	30



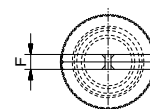
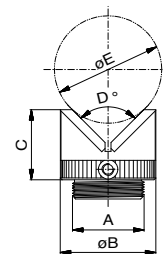
### Knife V 90° with ball joint

Nr.	A	B	C	D	E	F	
80926	M24x1	32	53	90	max. 32	5	42



### Knife V 90° without ball joint

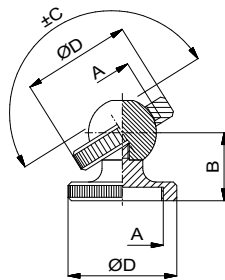
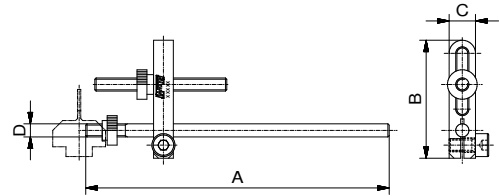
Nr.	A	B	C	D	E	F	
22555	M24x1	32	23,5	90	max. 32	5	19





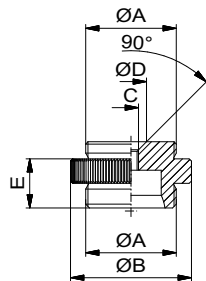
**Stop M4  
for V-piece**

Nr.	A	B	C	D	Ø
285200	92	36	8	M4	12



**Ball joint**

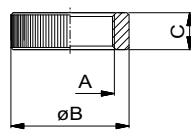
Nr.	A	B	C	D	Ø
80947	M24x1	22	55°	32	24
81588	M12x0,5	10	55°	16	6



**Crossover  
male/male, for ball joint**

Nr.	A	B	C	D	E	Ø
22647	M24x1	32	M4	8,2	13	21
24241	M12x0,5	16	-	-	5	12

M4 thread can be connected with studs from FX range as location pin



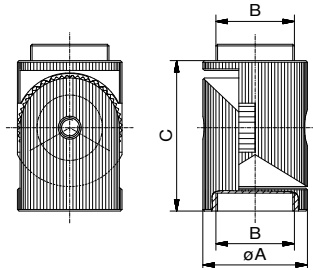
**Spacer  
M24x1**

Nr.	A	B	C	Ø
22644	M24x1	ø32	10	10

ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.

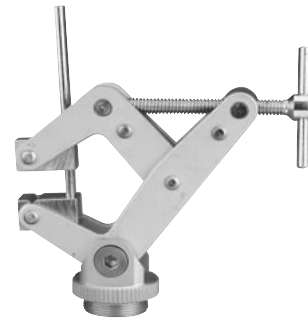
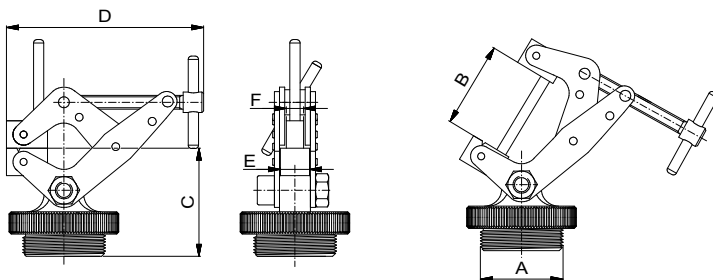
### Joint for Screw-jacks with knurled serrations grid 6° or 4°

Nr.	A	B	C	Grid	$\frac{B}{C}$
285206	32	M24x1	40	4°	94
285207	42	M32x1	60	6°	232



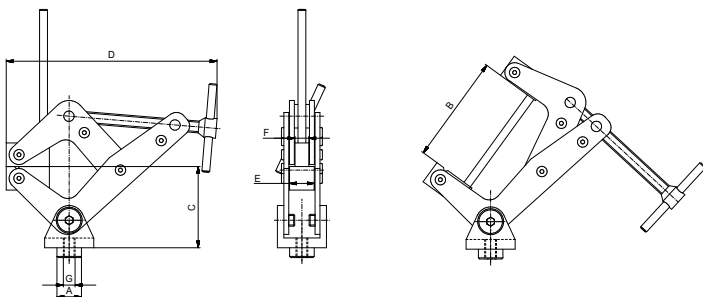
### Screw clamp with joint, connection thread M24x1

Nr.	A	B	C	D	E	F	$\frac{B}{C}$
80949	M24x1	25	32	57,5	8,5	5	51
81270	M24x1	55	47,5	105	12,6	7	152



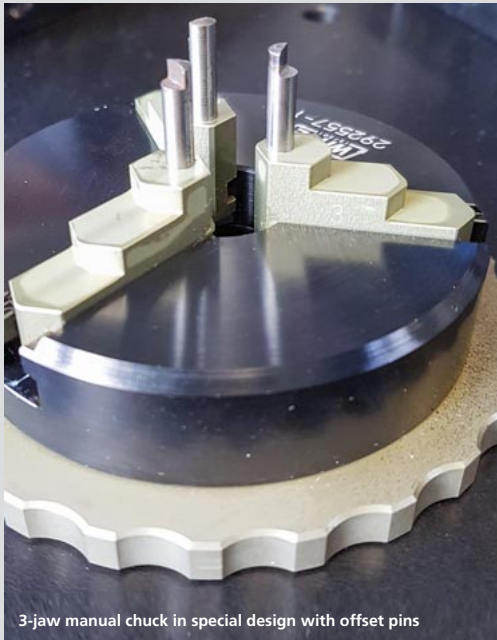
### Screw clamp with joint, ALUFIX 25

Nr.	A	B	C	D	E	F	G	$\frac{B}{C}$
80924	12,5	55	41,3	105	12,6	7	M6	147



# ALUFIX Classic Clamping elements

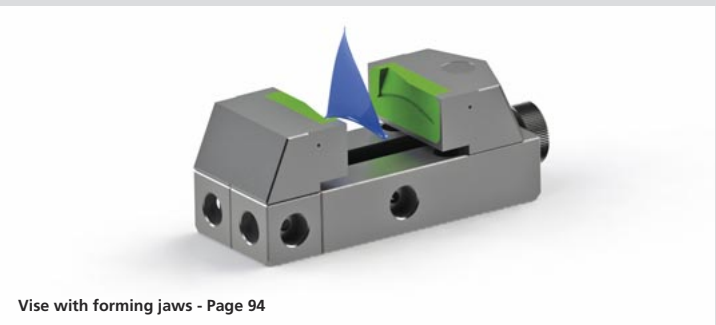
Secure workpiece clamping and accurate contact to support and contact surfaces



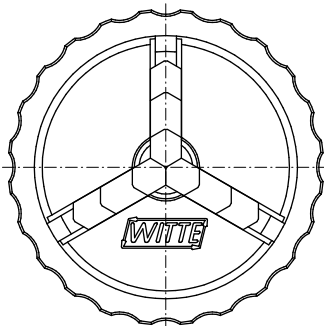
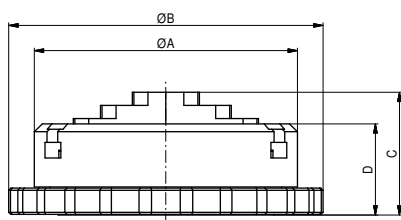
3-jaw manual chuck in special design with offset pins



Application example Universal Vise (page 95)



Vise with forming jaws - Page 94



### 3 Jaw Keyless Chuck for measuring applications

	Nr.	A	B	C	D	⊞
C	82220	50	60	23,4	17,3	95
C	82080	80	96	35	25	368
C	82125	125	146	53,1	38,4	1.330
	82200	200	236	79,1	55,3	4.940

Concentricity base to part:  
Repeatable accuracy max. 0,1mm, absolute accuracy 0,3mm



ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.

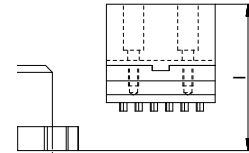
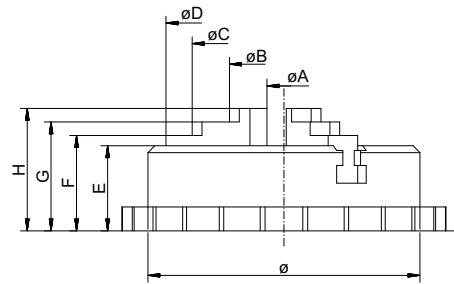
**C·E** ALUFIX preferred range  
Green: Item is available immediately.  
C: Classic version, E: Eco version, CE: Classic or Eco  
■: color "natural", ■: color "black"



## Further Dimensions

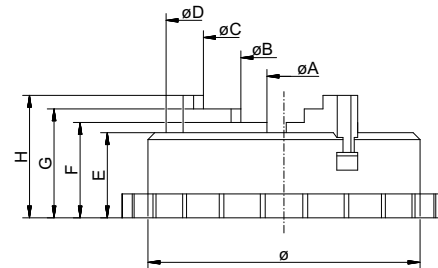
## 3 jaw keyless chuck

$\phi$	A	B	C	D	E	F	G	H	I
50	1-34	13-46	27-60	41-74	17,3	18,4	21	23,4	30,3
80	1-46	21-66	43-88	65-108	25,3	27	31	35	44,8
125	1,5-72	38-108	72-142	106-176	38,4	41,1	47,1	53,1	69
200	2-116	58-172	112-226	166-280	55,3	63,1	71,1	79,1	103,3

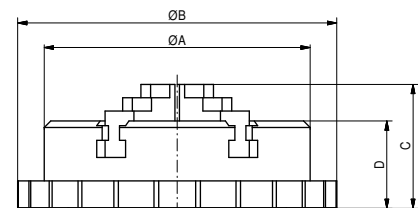


## 3 jaw keyless chuck with reversed jaws

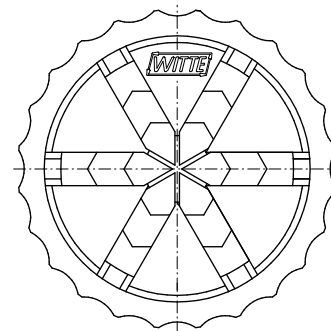
$\phi$	A	B	C	D	E	F	G	H	I
50	1-34	13-46	27-60	41-74	17,3	18,4	21	23,4	30,3
80	1-46	21-66	43-88	65-108	25,3	27	31	35	44,8
125	1,5-72	38-108	72-142	106-176	38,4	41,1	47,1	53,1	69
200	2-116	58-172	112-226	166-280	55,3	63,1	71,1	79,1	103,3

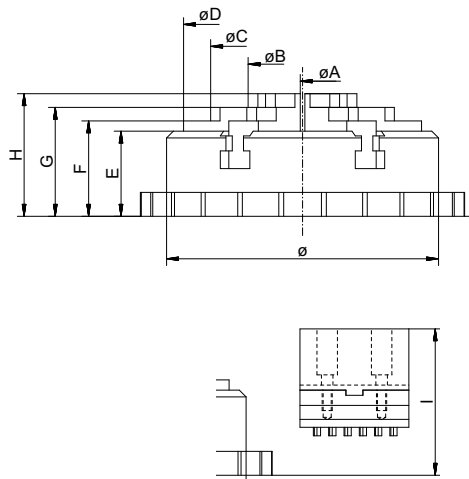
6 Jaw Keyless Chuck  
for measuring applications

Nr.	A	B	C	D	$\phi$
82340	50	60	23,4	17,3	97
82090	80	96	35	25,3	380
82135	125	146	53,1	38,4	1.385
82210	200	236	79,1	55,3	5.120



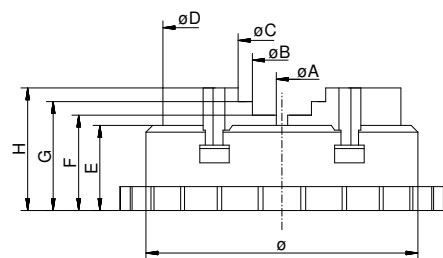
Concentricity base to part:  
Repeatable accuracy max. 0,1mm, absolute accuracy 0,3mm





**Further Dimensions**  
6 jaw keyless chuck

ø	A	B	C	D	E	F	G	H	I
50	1,5-29	18-45	30-57	42-69	17,3	18,4	21	23,4	30,3
80	2-44	27-69	47-89	66-108	25,3	27	31	35	44,8
125	3-71	44-112	76-144	108-176	38,4	41,1	47,1	53,1	69
200	5-113	59-167	113-221	169-277	55,3	63,1	71,1	79,1	103,3



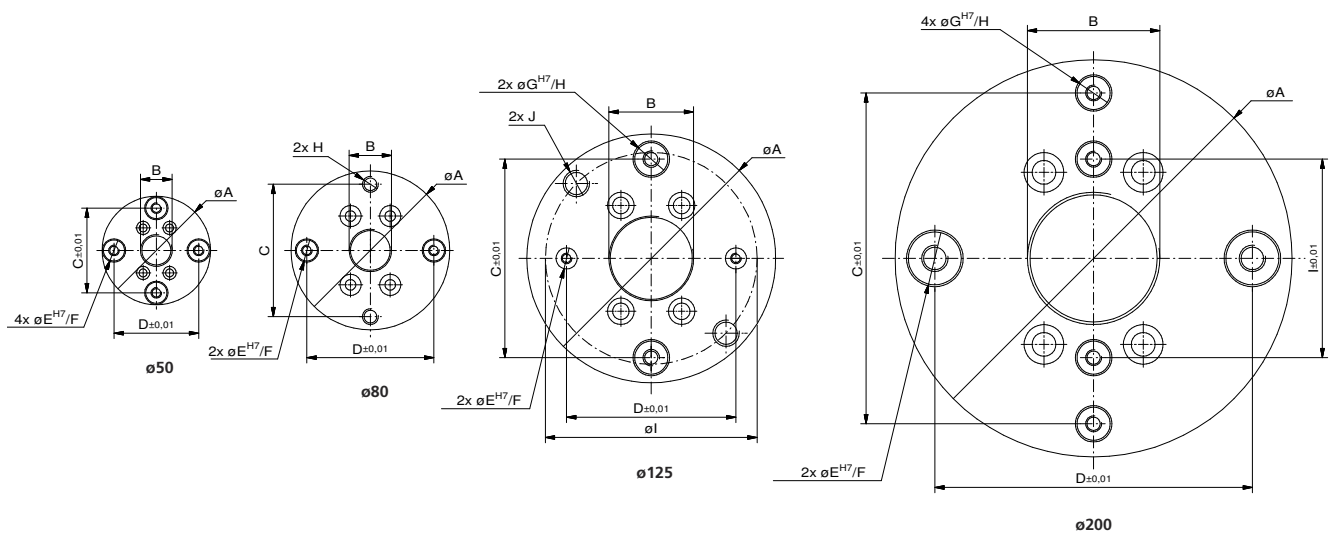
**6 jaw keyless chuck with reversed jaws**

ø	A	B	C	D	E	F	G	H	I
50	10-30	22-42	34-54	50-70	17,3	18,4	21	23,4	30,3
80	18-43	36-61	56-81	81-106	25,3	27	31	35	44,8
125	27-68	59-100	91-132	131-172	38,4	41,1	47,1	53,1	69
200	43-110	99-166	153-220	207-274	55,3	63,1	71,1	79,1	103,3

**Further Dimensions**  
3 and 6 jaw keyless chucks, view from underneath

ø	A	B	C	D	E	F	G	H	I	J	AF
50	41	M12x0,5	32	32	8	M4	-	-	-	-	16
80	60	M 16x1	50	48	8	M4	-	M6	-	-	16/25
125	94	M32x1	75	64	8	M4	12,5	M6	80	M10	16/25/40
200	150	M50x1,5	125	120	20	M10	12,5	M6	75	-	25/40

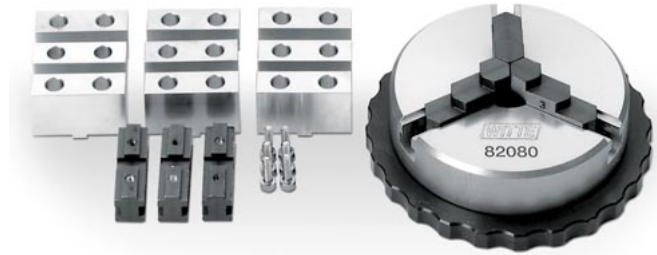
Fixing disks for mounting keyless chucks are shown on page 115.



**Basic Set 3 jaw Keyless chuck**

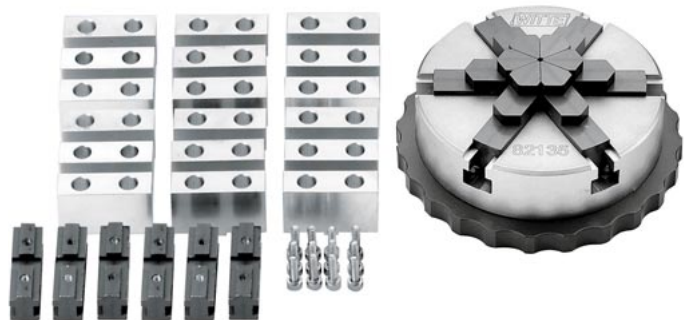
19-pcs., 1 x chuck with reversible jaws,  
1 x Base jaw set, 9 x Top jaws, 6 x Screws

Nr.	∅	comprising of:	g
82373	50	1x82220, 1x82351, 9x26288, 6x11434	138
82376	80	1x82080, 1x82356, 9x26289, 6x11435	523
82378	125	1x82125, 1x82360, 9x26290, 6x10437	1.946
82380	200	1x82200, 1x82364, 9x26291, 6x10631	7.300

**Basic Set 6 jaw Keyless chuck**

37-pcs., 1 x chuck with reversible jaws,  
1 x Base jaw set, 18 x Top jaws, 12 x Screws

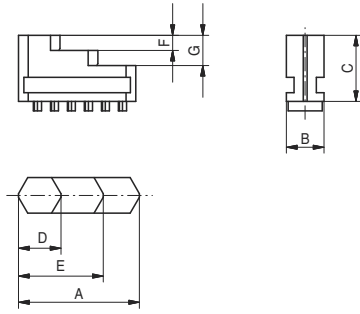
Nr.	∅	comprising of:	g
82374	50	1x82340, 1x82354, 18x26288, 12x11434	173
82377	80	1x82090, 1x82358, 18x26289, 12x11435	690
82379	125	1x82135, 1x82362, 18x26290, 12x10437	2.595
82381	200	1x82210, 1x82366, 18x26291, 12x10631	9.830



ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative -  
then simply add "-1" to the article number when ordering.  
Other colors on request.



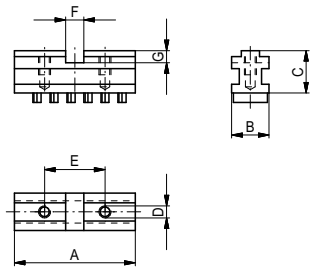
Application example  
25 3-jaw keyless chucks  
in a measuring fixture



### Reversible jaws set for 3 jaw chuck

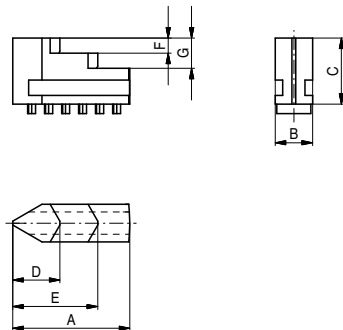
Nr.	for $\varnothing$	A	B	C	D	E	F	G	$\varnothing$
82350	50	20	5,9	10,7	7	14	2,5	5	10
82355	80	32	9,9	17,5	11	22	4,0	8	30
82359	125	52	15,9	27,1	17	34	6,0	12	20
82363	200	82	24,9	44,1	27	54	8,0	16	370

Also fit in 6 jaw chucks.



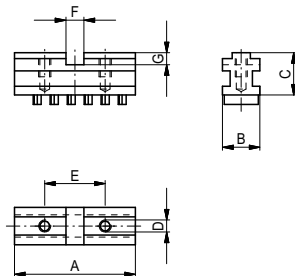
### Base jaws set for 3 jaw chuck

Nr.	for $\varnothing$	A	B	C	D	E	F	G	$\varnothing$
82351	50	20	5,9	6,6	M2	10	3	2	10
82356	80	32	9,9	10,9	M3	16	5	3	20
82360	125	52	15,9	17,5	M5	24	8	5	160
82364	200	82	24,9	28,5	M8	40	12	8	380



### Reversible jaws set for 6 jaw chuck

Nr.	for $\varnothing$	A	B	C	D	E	F	G	$\varnothing$
82353	50	20	5,9	10,7	8	14	2,5	5	20
82357	80	32	9,9	17,5	12,5	22,5	4	8	60
82361	125	52	15,9	27,1	20	36	6	12	240
82365	200	82	24,9	44	27	54	8	16	1.000



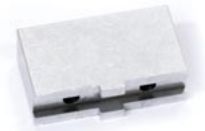
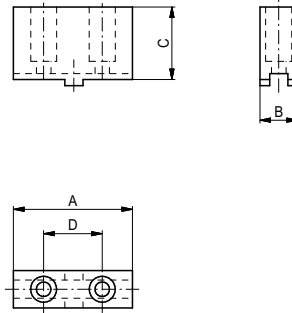
### Base jaws set for 6 jaw chuck

Nr.	for $\varnothing$	A	B	C	D	E	F	G	$\varnothing$
82354	50	20	5,9	6,6	M2	10	3	2	18
82358	80	32	9,9	10,9	M3	16	5	3	50
82362	125	52	15,9	17,5	M5	24	8	5	190
82366	200	82	24,9	27,5	M8	40	12	8	750

**Top jaws single**

to use on base jaws, for 3 and 6 jaw keyless chucks

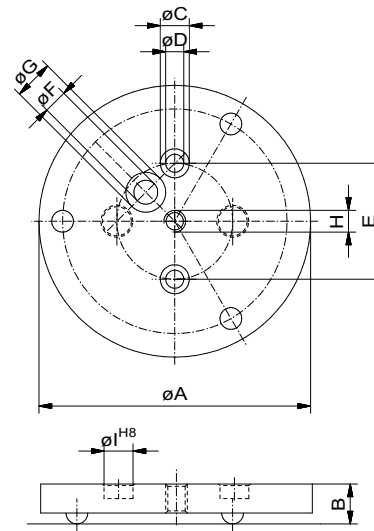
Nr.	for $\phi$	A	B	C	D	Material	$\frac{G}{H}$
26288	50	20	5,9	12	10	EN AW-7075	3
26288-10	50	20	5,9	12	10	POM	2
26289	80	32	9,9	18	16	EN AW-7075	13
26289-10	80	32	9,9	18	16	POM	10
26290	125	52	15,9	28	24	EN AW-7075	50
26290-10	125	52	15,9	28	24	POM	43
26291	200	82	24,9	44	40	EN AW-7075	150
26291-10	200	82	24,9	44	40	POM	139



**Center plate**

for 3 and 6 jaw keyless chucks

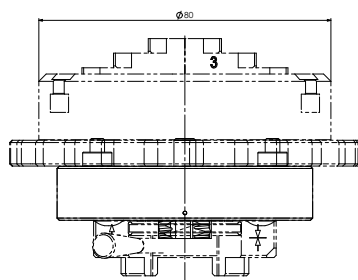
Nr.	for $\phi$	A	B	C	D	E	F	G	H	I	$\frac{G}{H}$
82371	50	75	11	8	5	32	6,6	11	M6	8	100
82159	80	120	13	11	6,6	50	-	-	-	8	317
82344	125	187	18	11	6,6	75	-	-	-	8	493
82345	200	300	28	18	11	120	-	-	-	12,5	528



**Quick change coupling**

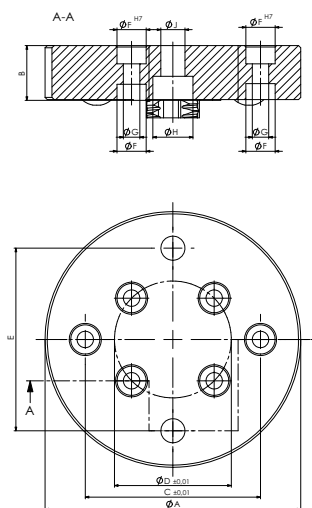
for keyless chucks  $\phi$  50 mm and  $\phi$  80 mm

Nr.	$\phi$ A	B	C	$\phi$ D	E	$\phi$ F	$\phi$ G	$\phi$ H	$\phi$ J	$\frac{G}{H}$
291548	70	15	48	32	50	8	4,5	11	6,6	168

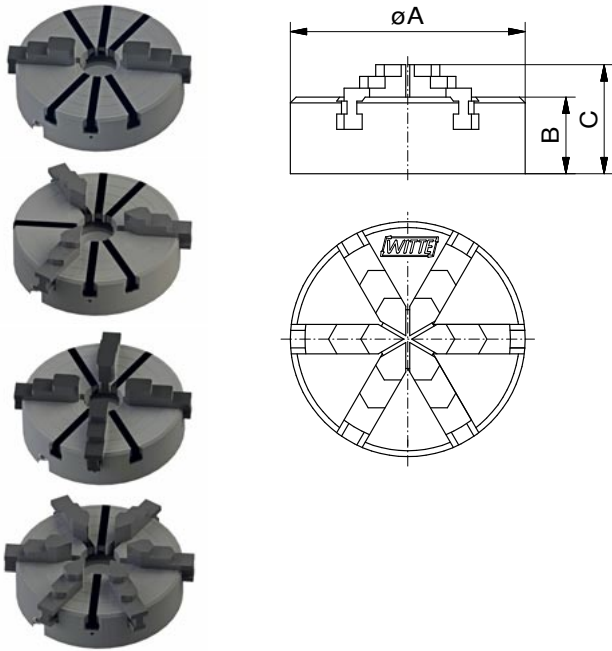


The required connection elements are included in supply.

Picture shows coupling with connection elements, plus quick change coupling bottom section (282474 on page 31) and keyless chuck Dia 80 (82080 on page 86) not included in supply.

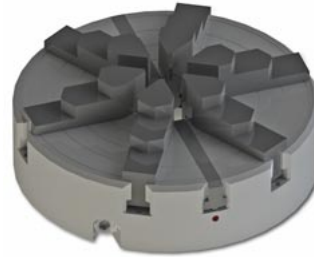


ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.

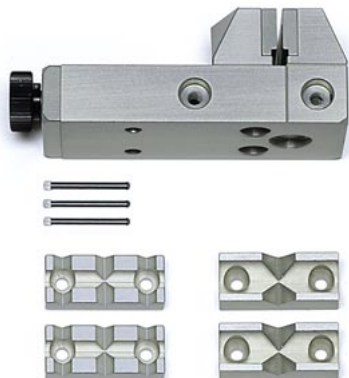


**Keyless chuck**  
for 2,3,4,6 jaws,  $\varnothing 125$ , anodized natural

Nr.	A	B	C	
285291	125	33	50	1300



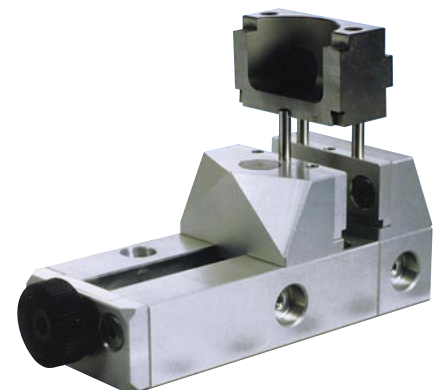
6 stepped standard jaws are included in supply.  
Base and special jaws are available on request.  
Base same as chuck  $\varnothing 125$ : 82125, 82135.  
Suitable Center plate: No. 287192.



**Vise set**  
10-pcs., comprising of:

Nr.	System	Vise	Flat jaw	Pins	V-jaw	V-jaw
		1x	Alu 2x	3x	small 2x	big 2x
81790	16	81784	24580	24604	24586	24598
81791	25	81785	24581	24605	24587	24599
81792	25	81786	24582	24605	24588	24600
81793	25	81787	24583	24605	24589	24601
81794	40	81788	24584	24606	24590	24602
81795	40	81789	24585	24606	24591	24603

Jaws also available per piece  
Flat and V jaws are also available in polymer  
(POM black).



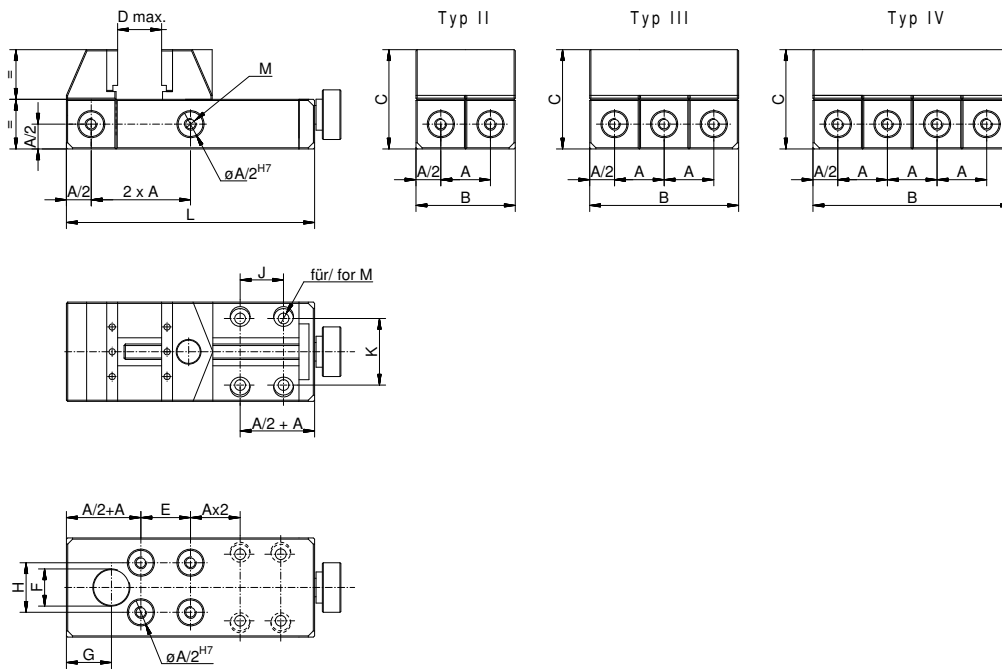
ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative -  
then simply add "-1" to the article number when ordering.  
Other colors on request.

**Parallel-vise  
without pins**

Nr.	AF	Typ	L	B	C	D	E	F	G	H	J	K	M	$\bar{g}$
81784	16	II	80	32	32	40	-	M12x0,5	14,5	16	-	16	M4	135
<b>C</b> 81785	25	II	125	50	50	65	-	M24x1	23	25	-	25	M6	750
81786	25	III	150	75	50	90	25	M24x1	37,5	50	-	50	M6	905
81787	25	IV	175	100	50	115	25	M24x1	62,5	50	-	50	M6	1.410
81788	40	III	320	120	80	225	40	M32x1	100	80	-	80	M10	4.620
81789	40	IV	360	160	80	265	40	M32x1	100	80	80	80	M10	6.150



Fixing Disks for connection  
are shown on page 115.

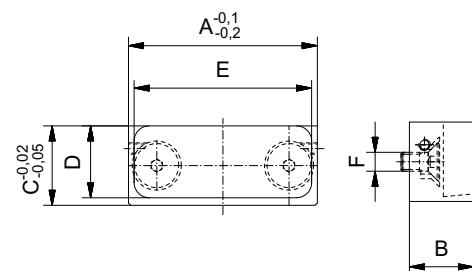


**Forming jaw  
with bushes, for compound resin (page 94)**

Nr.	System	A	B	C	D	E	F	$\bar{g}$
81831	AF 16	32	10	13,5	12	29	M3	10
81832	AF 25	50	17	21	19	47	M5	30
81833	AF 25	75	17	21	18,5	71	M5	40
81834	AF 25	100	17	21	18,5	96	M5	60
81835	AF 40	120	34	33,5	30	112	M8	170
81836	AF 40	160	34	33,5	30	152	M8	226



Supply includes:  
1 forming jaw,  
2 bushes,  
2 Threaded pins,  
2 countersunk screws.



**C·E** ALUFIX preferred range  
Green: Item is available immediately.  
C: Classic version, E: Eco version, CE: Classic or Eco  
■: color "natural", ■: color "black"



### Plasticine compound resin

Knead blue and yellow components in ratio 1:1, blend well until colour throughout is green.

Apply within 15 minutes. The resin hardens to full strength within 3 hours.

### Technical details:

Tensile strength 300 kg/cm<sup>2</sup>

Compression strength: 800 kg/cm<sup>2</sup>

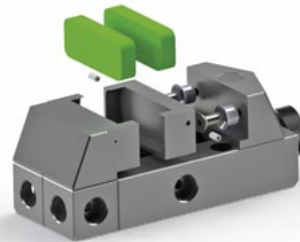
Heat resistance upto +200°C



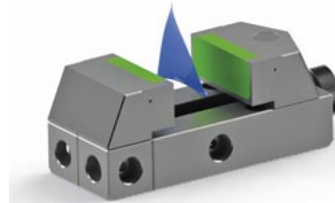
Application example for compound resin in standard moulding cap.

### Compound resin for moulding workpieces

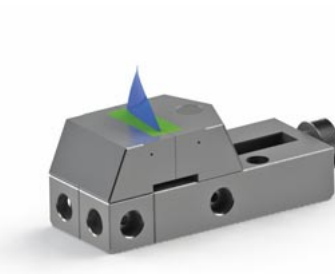
Nr.	Contents g	g
80692	100	120
80685	400	460



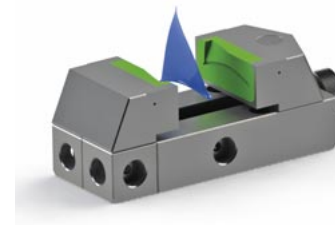
Attaching the forming jaws with plasticine compound



Positioning of workpiece



The forming jaws with the compound resin are pressed together.



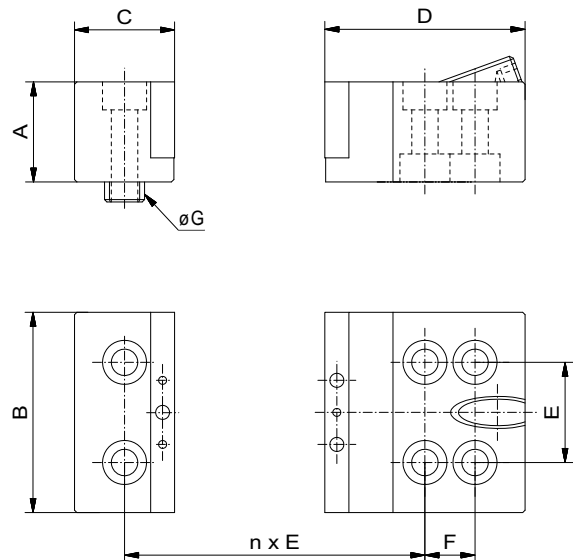
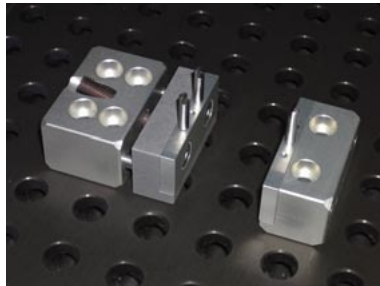
The compound resin adjusts to the contours of the workpiece



**Universal Vice**

2 pcs., without basic unit for mounting on base plates or grid base plates, Shift ±12,5 mm

Nr.	System	A	B	C	D	E	F	G	
93498	AF25	25	50	25	40	25	12,5	12,5	296
289488	AF40	40	80	40	64	40	20	20	878



**Pin cushion**

with rubberized pins

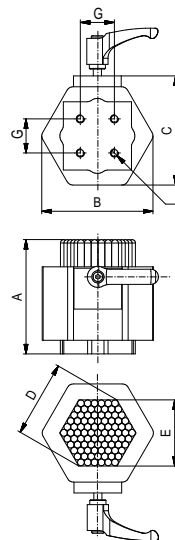
Nr.	A	B	C	D	E	F	G	max. N	
91940	84	81,5	80	55	48,5	6	25	150	1.400
98101	84	52	55	35	31	6	25	80	1.100



Easy to move pins adjust to shape of workpiece.

Then by using a locking device the resulting imprint is secured into place.

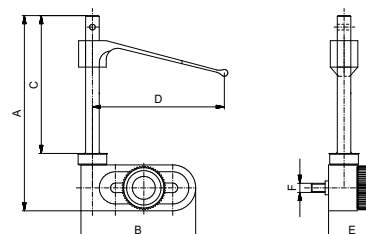
This enables repeatable clamping of workpieces, that can be secured with hold down springs and studs.



**Hold-down column clamp**

for pin cushion, in set (2 pieces) with hold down columns and springs

Nr.	A	B	C	D	E	F	
91941	85	50	60	57,5	20,5	M4	80



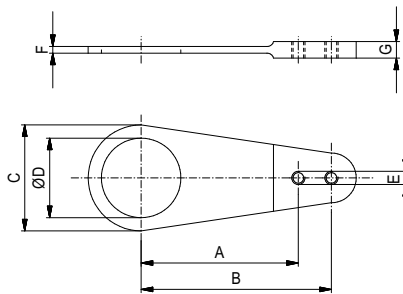
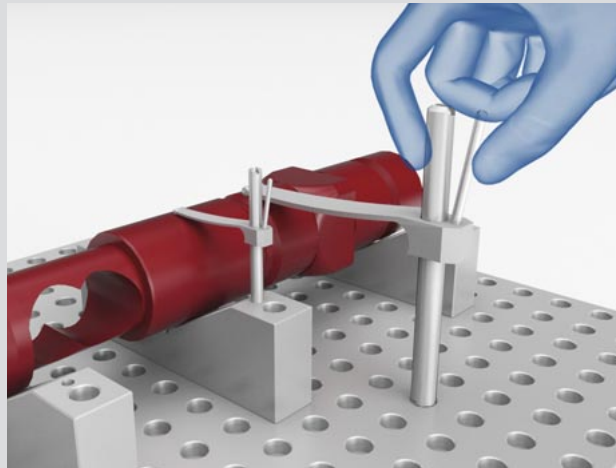
ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.

## Hold down springs

With hold-down springs, workpieces are clamped in fixtures.

With light pressure from above on the spring it is tensioned and locked.

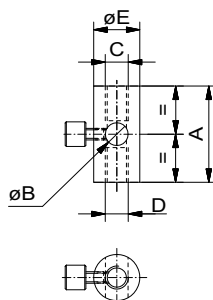
Hold-down springs with release pins (below) offer an easy method to loosen the spring.



Mounted between screw jacks (page 71) and top sections (page 74)

## Traverse holder with heel for hold-down stud

Nr.	A	B	C	D	E	F	G	H
22267	47,5	57,5	32	24	M4	2	5	11
22268	47,5	57,5	32	24	M6	2	5	11



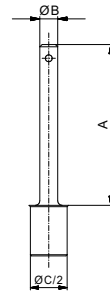
Application example for cross connector with hold down column.

## Cross connector for hold-down stud

Nr.	A (AF)	B	C	D	E	H
287053	16	ø3,9	M6	M4	ø12	3
287054	25	ø5,9	M6	M6	ø12	6
287055	40	ø9,8	M6	M10	ø20	28
287056	50	ø11,9	M10	M12	ø20	55

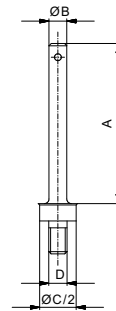
### Hold down stud self locking

Nr.	A	B	C	$\frac{g}{g}$
20338	35	3,9	16	3
<b>C</b> 22259	55	5,9	16	5
22260	60	5,9	25	9



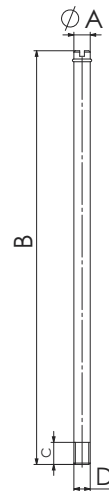
### Hold down stud with thread

Nr.	A	B	C	D	$\frac{g}{g}$
20339	35	3,9	16	M4	3
22262	55	5,9	16	M4	5
<b>C</b> 22263	60	5,9	25	M6	8
24885	125	5,9	25	M6	15
20100	130	9,8	40	M10	38
30126	120	11,9	50	M12	56



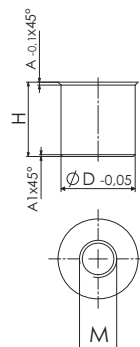
### Hold down stud with O ring

Nr.	System	A	B	C	D	$\frac{g}{g}$
292834	AF25	5,9	150	8	M6	-
292836	AF40	9,9	150	13	M10	-
292838	AF50	11,9	150	16	M12	-



### Sleeve for Hold down stud with O ring

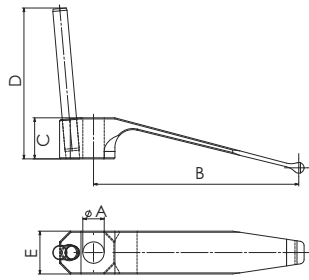
Nr.	System	M	øD	H	A	A1	$\frac{g}{g}$
451659	AF25	M6	12,45	13	0,5	0,5	-
451662	AF40	M10	19,95	20	0,8	0,8	-
451665	AF50	M12	24,95	25	1	1	-



**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black" ALUFIX-Vorzugsreihe

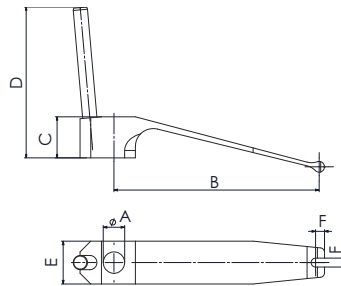
ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering.

Other colors on request.



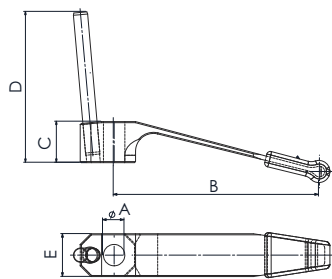
**Hold down spring  
with release pin**

Nr.	System	A	B	C	D	E	
292835	AF25	6	57,5	11,5	42,3	12	-
292837	AF40	10	91,9	19,2	63,9	19,2	-
292839	AF50	12	115	23	86,6	24	-



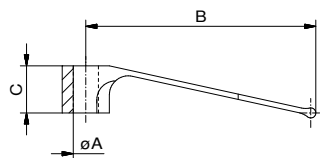
**Hold down spring  
with release pin and slot end**

Nr.	System	A	B	C	D	E	F	
292880	AF25	6	57,5	11,5	42,3	12	2,5	-
292881	AF40	10	91,9	19,2	63,9	19,2	4	-
292882	AF50	12	115	23	86,6	24	5	-



**Hold down spring  
with release pin and plastic cap**

Nr.	System	A	B	C	D	E	
292861	AF25	6	57,5	11,5	42,3	12	-
293678	AF40	10	91,9	19,2	63,9	19,2	-
293679	AF50	12	115	23	86,6	24	-



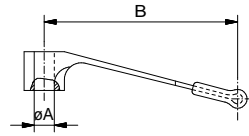
**Hold down spring  
self locking on hold down stud**

Nr.	System	A	B	C	Clamp force	
20244	AF 16	4	36	7,5	8 N	1
20290	AF25/16	6	36	7,5	12 N	1
22258	AF25/16	6	59	11,5	24,5 N	6
24499	AF25	6	105	11,5	12 N	30
22355	AF40	10	94	19,2	49 N	60
28058	AF50	12	118	23	59 N	50

**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"

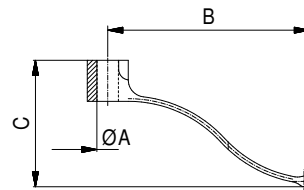
### Hold down spring with plastic cap silicone free for sensitive surfaces

Nr.	System	A	B	
93442	AF25/16	6	103,5	9
93443	AF25/16	6	57,5	6



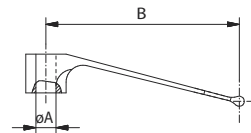
### Hold down spring for low clamping

Nr.	System	A	B	C	Clamp force	
34634	AF16	4	36,5	23,5	8 N	2
34764	AF16	6	36,5	23,5	12 N	1
34765	AF25	6	59	37	24,5 N	3
34766	AF40	10	94,5	59,5	49 N	27
34767	AF50	12	118	74	59 N	50



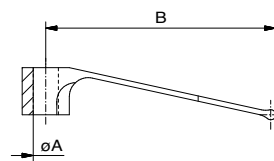
### Hold down spring with ball point

Nr.	System	A	B	
284708	AF16	4	36	2

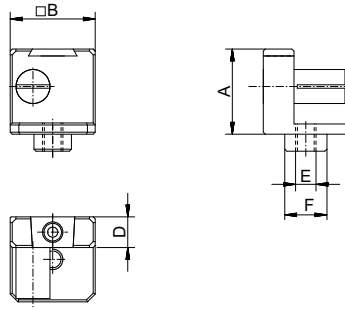


### Hold down spring in plastic

Nr.	System	A	B	
53976	AF25/16	6	63,5	4
53977	AF25/16	6	109,5	6

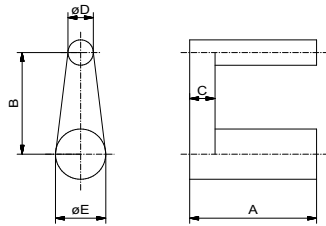


ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative -  
then simply add "-1" to the article number when ordering.  
Other colors on request.



**Winder**

Nr.	System	A	B	AF	D	E	F	⌀
80742	AF16	16	16	16	6	M4	8	11
80743	AF25	25	25	25	9	M6	12,5	34
80744	AF40	40	40	40	14	M8	20	169



**Deflector**

Nr.	System	A	B	C	D	E	⌀
22274	AF16	19	16	3	4	7,9	4
22275	AF25	31	25	6	6	12,4	16
22276	AF40	50	40	10	10	19,8	66

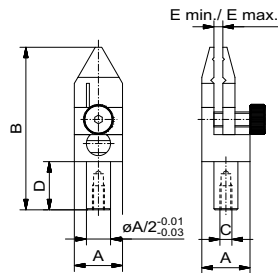


**Winder tape**  
in plastic, 12mm wide

Nr.	System	Length (m)
00041	AF16/25/40	5

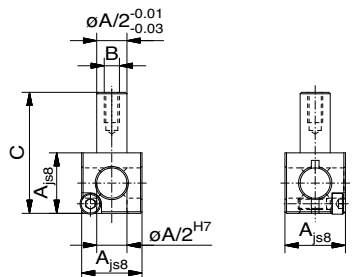


Exchangeable jaws in other versions available on request.



**Parallel clamp**  
with exchangeable jaws

Nr.	A	B	C	D	E min.	E max.	⌀
284585	10	34	M2,5	10	0	5	16
284476	16	54	M4	16	0	8	20
284134	25	65	M6	5	0	12,5	80

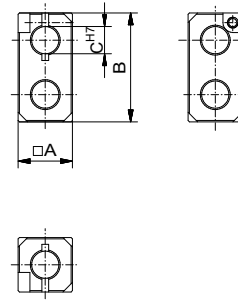


**Clampholder**  
with stud

Nr.	A	B	C	⌀
285043	16	M4	32	8
288283	25	M6	30	30

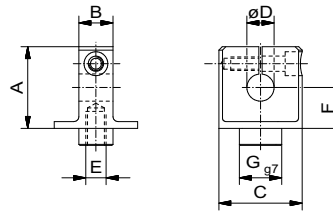
Dial indicator holder ALUFIX 16

Nr.	System	A	B	C	$\frac{g}{mm}$
80128	AF 16	16	32	8	14



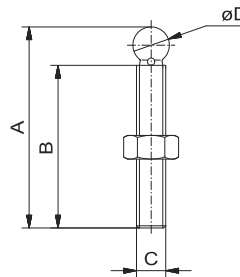
Dial indicator holder

Nr.	System	A	B	C	D	E	F	G	$\frac{g}{mm}$
80755	AF25	24	10	24,5	8	6	12	12,5	10
80756	AF40	24	11,9	39,5	8	8	12	20	77



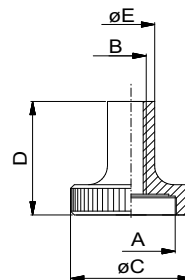
Ball point

Nr.	A	B	C	D	$\frac{g}{mm}$
93518	55	38	M8x1	10	20



Support for ball point

Nr.	A	B	C	D	E	$\frac{g}{mm}$
55032	M24x1	M8x1	32	30	12,5	76

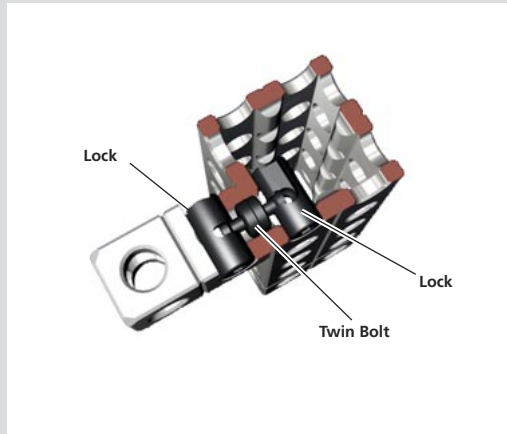


ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.

## ALUFIX Classic Connection elements

A variety of elements allows combination of Alufix components whenever two opposite holes, or a hole and a nub are to be connected.

This works also between different system sizes using reducer sleeves.

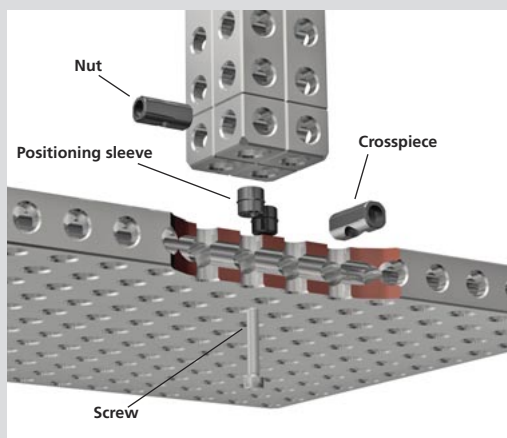


### Quick connection

For fast, constantly changing fixtures we recommend using quick connection elements.

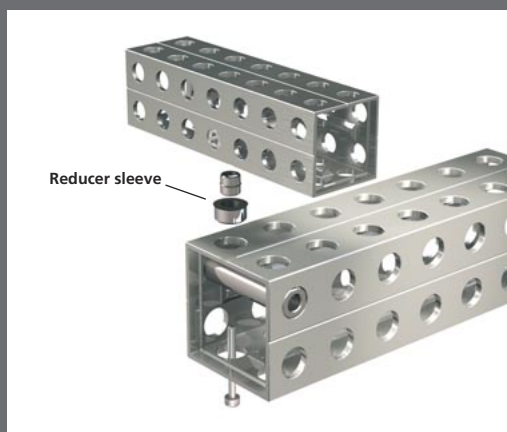
A twin bolt is positioned between Alufix elements to be connected. An excentric slot on the lock slides round and grips the head of a twin bolt resulting in a tight connection.

Recommended torque must be adhered to otherwise head of twin bolt may be damaged.



### Screw connection

For lasting tight connections the screw connection has proved to be the best.



### Connecting different system sizes

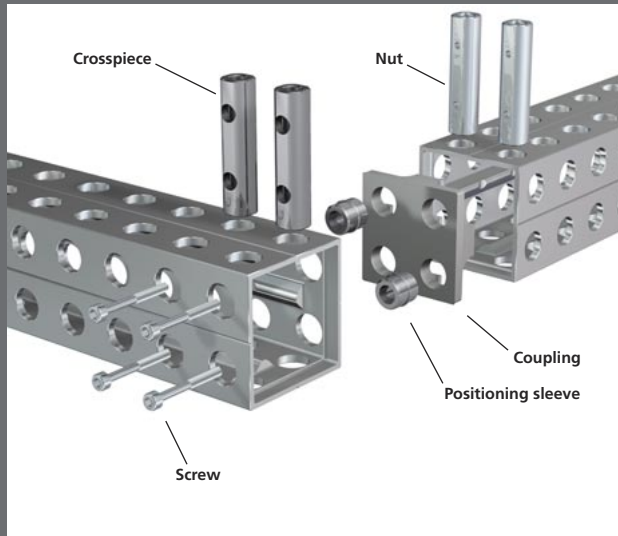
Alufix elements in different system sizes are connected using

- Reducer sleeves
- Reducer bolts



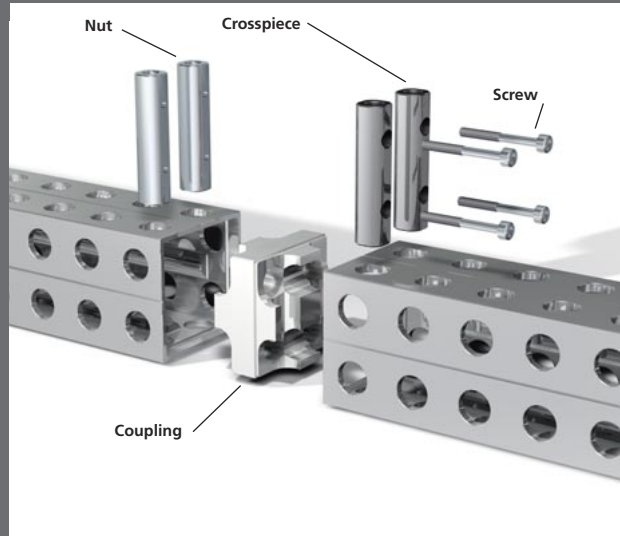


Connecting with couplings



**Single coupling with screw connection** is used in face ends of Light bars for accurate positioning of further elements.

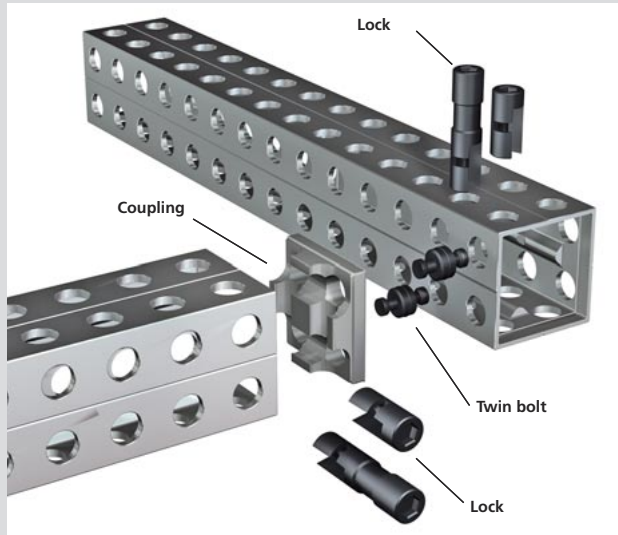
Picture shows assembly using screw connectors



**Double coupling with screw connection** is used for centering two Light bars end to end.

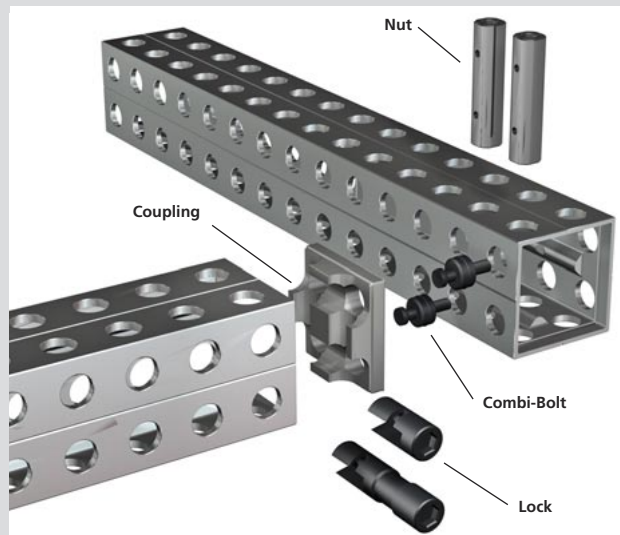
Picture shows assembly using screw connectors, quick connectors are also possible.

Connecting with couplings



**Single coupling with quick connection** is used in face ends of Light bars for accurate positioning of further elements.

Picture shows assembly using quick connectors



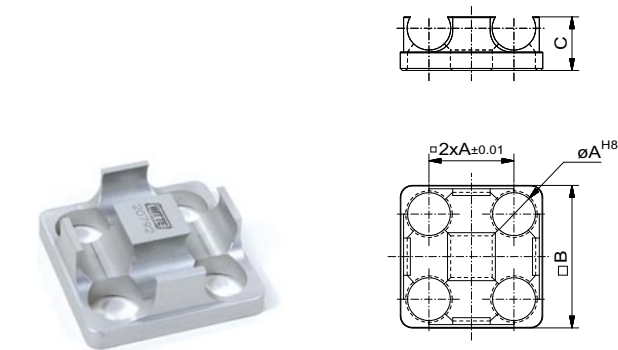
**Single coupling with screw/quick connection (combi bolt)** is used for centering two Light bars end to end.

Picture shows assembly using screw and quick connectors.



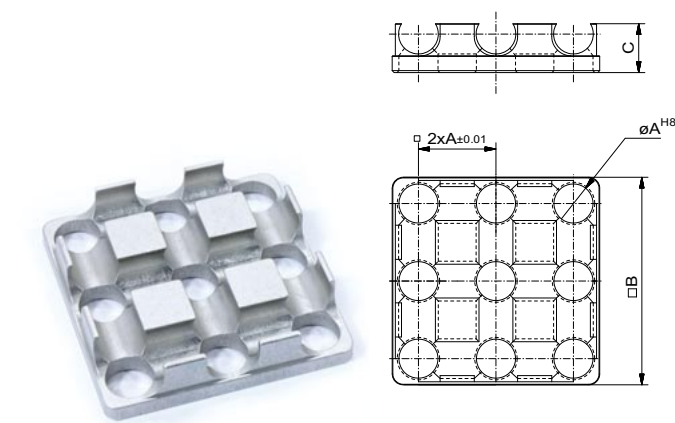
**Coupling, single**  
for 1 row Bar Light Classic

	Nr.	System	A	B	C	
<b>C</b>	23315	AF 25	12,5	19	5,4	4
	20794	AF 40	20	32	8,4	16
	26930	AF 50	25	32	10,9	29



**Coupling, single**  
for 2 row Bar Light Classic

	Nr.	System	A	B	C	
<b>C</b>	23325	AF 25	12,5	42	16	26
<b>C</b>	20792	AF 40	20	68	25	120
	26727	AF 50	25	84	32	228



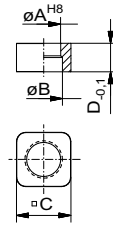
**Coupling, single**  
for 3 row Bar Light Classic

	Nr.	System	A	B	C	
	23613	AF 40	20	108	25	333

**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"

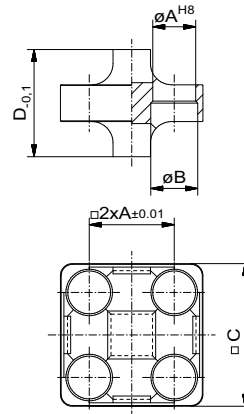
**Coupling, double**  
for 1 row Bar Light Classic

Nr.	System	A	B	C	D	
23320	AF 25	12,5	13,8	19	10,8	8
20793	AF 40	20	22	32	16,8	31
26931	AF 50	25	27,4	32	21,8	38



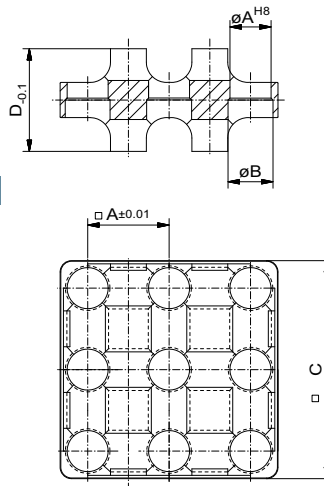
**Coupling, double**  
for 2 row Bar Light Classic

Nr.	System	A	B	C	D	
23330	AF 25	12,5	13,8	42	31,5	53
20791	AF 40	20	22	68	50,4	240
26850	AF 50	25	27,4	84	64	465

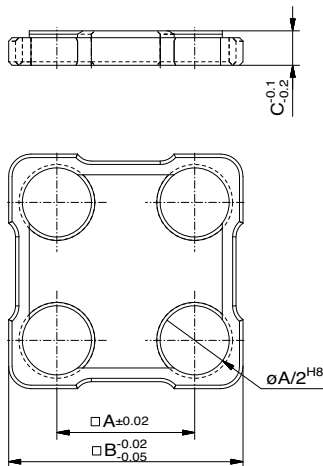


**Coupling, double**  
for 3 row Bar Light Classic

Nr.	System	A	B	C	D	
23616	AF 40	20	22	108	50,4	682



ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering.  
Other colors on request.



Single couplings for face connections.  
These couplings are used with screw connectors.

**Coupling, single**  
for 1 row Bar Light Eco

	Nr.	System	A	B	C	
<b>E</b>	23315-E	AF 25	25	19	5	4
	20794-E	AF 40	40	32	8	16
	26930-E	AF 50	50	32	10	29

**Coupling, single**  
for 2 row Bar Light Eco

	Nr.	System	A	B	C	
<b>E</b>	55134-E	AF 25	25	17x42	5	10
<b>E</b>	57211-E	AF 40	20	32x68	8	50

**Coupling, single**  
for 1x2 row Bar Light Eco

	Nr.	System	A	B	C	
<b>E</b>	23325-E	AF 25	25	42	6,25	26
<b>E</b>	20792-E	AF 40	40	68	10	120
	26727-E	AF 50	50	84	12,5	228

**Coupling, single**  
for 2x3 row Bar Light Eco

	Nr.	System	A	B	C	$\phi D$	
	122443-E	AF 40	40	68x108	10	11	125

**Coupling, single**  
for 3 row Bar Light Eco

	Nr.	System	A	B	C	
	23613-E	AF 40	40	108	10	333
	26853-E	AF 50	50	134	12,5	670

**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"

### Coupling, double for 1 row Bar Light Eco

Nr.	System	A	B	C	øD	Gr.
23320-E	AF 25	25	19	10	6,6	8
20793-E	AF 40	40	32	16	11	31
26931-E	AF 50	50	32	20	13,5	38

### Coupling, double for 2 row Bar Light Eco

Nr.	System	A	B	C	øD	Gr.
55316-E	AF 25	25	17x42	10	6,6	40
57212-E	AF 40	40	32x68	20	11	110

### Coupling, double for 1x2 row Bar Light Eco

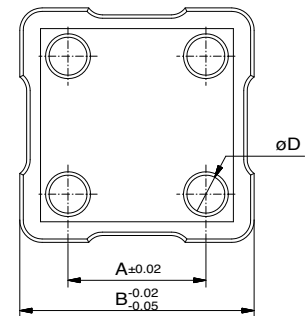
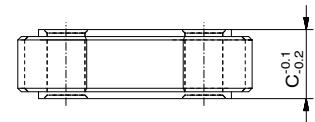
Nr.	System	A	B	C	øD	Gr.
23330-E	AF 25	25	42	10	6,6	53
20791-E	AF 40	40	68	20	11	240
26850-E	AF 50	50	84	25	13,5	465

### Coupling, double for 2x3 row Bar Light Eco

Nr.	System	A	B	C	øD	Gr.
122400-E	AF 40	40	68x108	20	11	315

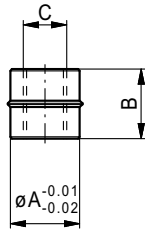
### Coupling, double for 3 row Bar Light Eco

Nr.	System	A	B	C	øD	Gr.
23616-E	AF 40	40	108	20	11	682
26851-E	AF 50	50	134	25	13,5	1.394



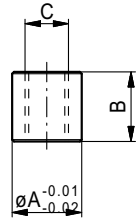
Double couplings for bar-bar connections. These couplings are used with screw connectors.

ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.



**Positioning sleeve with collar**

Nr.	System	A	B	C	$\varnothing$
21600	AF 16	8	8	M5	1
21385	AF25	12,5	12	M8	4
21235	AF40	20	18	M14x1,5	9
26732	AF50	25	23	M18x1,5	16

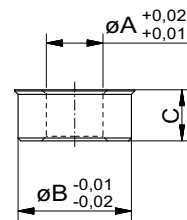


**Positioning sleeve without collar**

Nr.	System	A	B	C	$\varnothing$
21599	AF 16	8	8	M5	1
21386	AF25	12,5	12	M8	2
21278	AF40	20	18	M14x1,5	9
26733	AF50	25	23	M18 x1,5	16

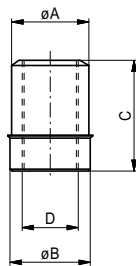
**plain, short**

Nr.	System	A	B	C	$\varnothing$
21386-E	AF 25	12,5	7	M8	1
21278-E	AF 40	20	11	M14x1,5	6
26733-E	AF 50	25	13,5	M18x1,5	9



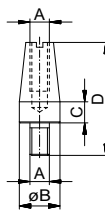
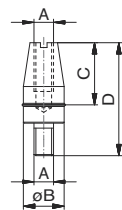
**Reducer sleeve with collar**

Nr.	System	A	B	C	$\varnothing$
21990	AF 25/16	8	12,5	6	1
22129	AF40/16	8	20	9	3
21236	AF40/25	12,5	20	9	5
26925	AF50/25	12,5	25	11	10



**Reducer sleeve with collar**

Nr.	System	A	B	C	D	$\varnothing$
20684	AF 25	12	12,5	18	M8	4
28260	AF 25	12,5	16	18	M8	9
22934	AF 25	12,5	22	22	M6	24
55904	AF 25	12,5	14	22	M8	42



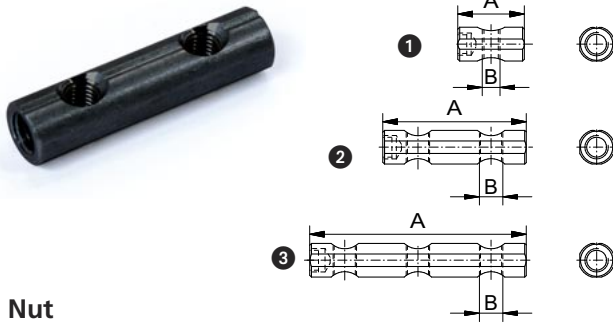
**Locating pin**

Nr.	System	A	B	C	D	$\varnothing$
25914	AF 25	M6	12,5	19,5	35,5	10
22865	AF 25	M6	12,5	6,5	30	10

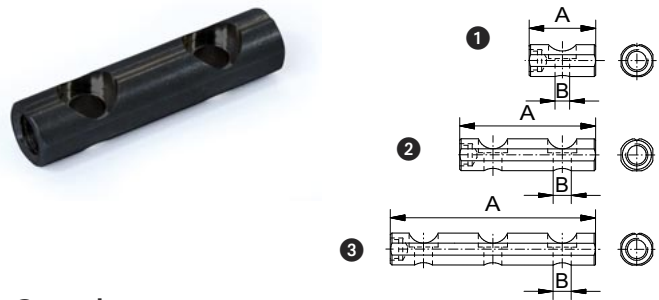
# 25914:  
Version with collar

# 22865:  
Version without collar

**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"



**Nut**  
for screw connection



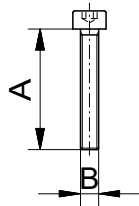
**Crosspiece**  
für for screw connection

Eco		Classic				
Nr.	#	Nr.	System	B	A	g
<b>AF16</b>						
52868-1	<b>1</b>	80620(-1)	16	M3	16	2
<b>C-E</b> 52869-1	<b>1</b>	80621(-1)	16	M4	16	2
52870-1	<b>1</b>	52870-1	16	M5	16	2
<b>AF25</b>						
52871-1	<b>1</b>	80533(-1)	25	M4	25	5
52872-1	<b>1</b>	80532(-1)	25	M5	25	5
<b>C-E</b> 52276-1	<b>1</b>	80531(-1)	25	M6	25	5
52873-1	<b>1</b>	82815(-1)	25	M8	25	5
52874-1	<b>2</b>	81602(-1)	25	M4	50	10
52875-1	<b>2</b>	81162(-1)	25	M5	50	10
<b>C-E</b> 52071-1	<b>2</b>	81168(-1)	25	M6	50	10
<b>AF40</b>						
52877-1	<b>1</b>	80448(-1)	40	M6	40	24
52878-1	<b>1</b>	80449(-1)	40	M8	40	24
<b>C-E</b> 31550-1	<b>1</b>	80450(-1)	40	M10	40	24
52879-1	<b>1</b>	80451(-1)	40	M12	40	24
52880-1	<b>2</b>	81603(-1)	40	M6	80	51
52881-1	<b>2</b>	82806(-1)	40	M8	80	51
<b>C-E</b> 31552-1	<b>2</b>	81363(-1)	40	M10	80	51
52882-1	<b>2</b>	82807(-1)	40	M12	80	51
52883-1	<b>3</b>	82011(-1)	40	M6	120	74
52884-1	<b>3</b>	81921(-1)	40	M8	120	74
<b>C-E</b> 31554-1	<b>3</b>	81873(-1)	40	M10	120	74
52885-1	<b>3</b>	82808(-1)	40	M12	120	74
<b>AF50</b>						
52886-1	<b>1</b>	82814(-1)	50	M6	50	50
<b>C-E</b> 52887-1	<b>1</b>	82813(-1)	50	M12	50	50
52888-1	<b>2</b>	82811(-1)	50	M6	100	100
<b>C-E</b> 31991-1	<b>2</b>	82472(-1)	50	M12	100	100
52889-1	<b>3</b>	82812(-1)	50	M6	150	150
<b>C-E</b> 52075-1	<b>3</b>	82471(-1)	50	M12	150	150

Eco		Classic				
Nr.	#	Nr.	System	B	A	g
<b>AF16</b>						
52890-1	<b>1</b>	21596-1	16	3,3	16	2
<b>C-E</b> 52891-1	<b>1</b>	21597(-1)	16	4,3	16	2
<b>AF25</b>						
52892-1	<b>1</b>	21395(-1)	25	4,3	25	5
52893-1	<b>1</b>	21394(-1)	25	5,3	25	5
<b>C-E</b> 52277-1	<b>1</b>	21393(-1)	25	6,4	25	5
52894-1	<b>2</b>	23785(-1)	25	4,3	50	10
52895-1	<b>2</b>	22954(-1)	25	5,3	50	10
52073-1	<b>2</b>	22997(-1)	25	6,4	50	10
<b>AF40</b>						
52898-1	<b>1</b>	21229(-1)	40	6,4	40	24
52899-1	<b>1</b>	21230(-1)	40	8,5	40	24
<b>C-E</b> 31549-1	<b>1</b>	21231(-1)	40	10,5	40	24
52900-1	<b>1</b>	21232(-1)	40	13	40	24
52901-1	<b>2</b>	23786(-1)	40	6,4	80	51
52902-1	<b>2</b>	25119(-1)	40	8,5	80	51
<b>C-E</b> 31551-1	<b>2</b>	20796(-1)	40	10,5	80	51
52903-1	<b>3</b>	25471(-1)	40	6,4	120	74
52904-1	<b>3</b>	28215(-1)	40	8,5	120	74
<b>C-E</b> 31553-1	<b>3</b>	24891(-1)	40	10,5	120	74
<b>AF50</b>						
52905-1	<b>1</b>	27115(-1)	50	6,4	50	50
<b>C-E</b> 52906-1	<b>1</b>	26730(-1)	50	13	50	50
52907-1	<b>2</b>	28217(-1)	50	6,4	100	100
<b>C-E</b> 52908-1	<b>2</b>	26731(-1)	50	13	100	100
52909-1	<b>3</b>	28218(-1)	50	6,4	150	150
<b>C-E</b> 52076-1	<b>3</b>	26827(-1)	50	13	150	150

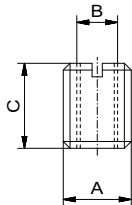
Classic version: Ideal for modular fixturing for fast easy handling  
 Eco version: Ideal for dedicated fixtures, without wear-reducing helicoil inserts and without threaded hole for positioning rod

Standard thread sizes are printed in bold print



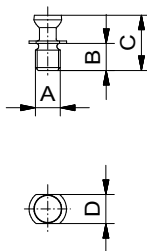
**Hex socket head screw**  
DIN 912 V2A

Nr.	System	A	B	⌀
10706-S1	AF16	20	M3	1
10707-S1	AF16	20	M4	2
10526-S1	AF25	30	M4	3
10525-S1	AF25	30	M5	3
10524-S1	AF25	30	M6	8
10475-S1	AF40	50	M6	12
10476-S1	AF40	50	M8	24
10477-S1	AF40	50	M10	38
10478-S1	AF40	50	M12	53
10867-S1	AF50	70	M12	68



**Reducer bush**

Nr.	A	B	C	⌀
26721	M4	M2	5	1
21859	3/8"	M6	13	1
26045	M6	M4	9	1
21514	M8	M4	10	3
23905	M8	M5	10	2
21865	M8	M6	10	2
21477	M10	M4	12,5	5
23906	M10	M5	12,5	4
21866	M10	M6	12,5	7
21867	M10	M8	12,5	10
20584	M12	M4	15	9
22283	M12	M5	15	8
21868	M12	M6	15	7
21869	M12	M8	15	6
21870	M12	M10	15	4
23600	M16	M12	24	13




**Combi bolt**  
shortened, for elements with nubs

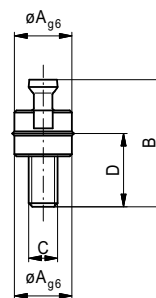
Nr.	System	A	B	C	D	⌀
20341	AF16	M4	4,5	8,9	SW5	1
21500	AF25	M6	6,5	13,3	SW7	2
20347	AF40	M10	10,5	20,8	SW11	10
26855	AF50	M12	12	25,9	SW14	16

**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"




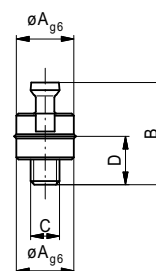
## Combi bolt


Nr.	System	A	B	C	D	
23249	AF 16	8	17,7	M4	10,2	3
23225	AF 25	12,5	28	M6	16	12
23259	AF 40	20	44	M10	25,5	64
27543	AF 50	25	55,1	M12	32	98

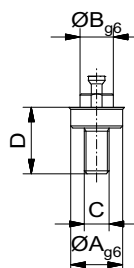



## Combi bolt shortened

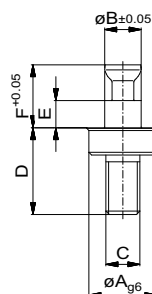
Nr.	System	A	B	C	D	
25742	AF 16	8	14,2	M4	6,7	1
25743	AF 25	12,5	22,4	M6	10,5	10
25744	AF 40	20	23,5	M10	17	61
28176	AF 50	25	44	M12	21	94

Combi reducer bolt  
for connecting different system sizes

Nr.	System	A	B	C	D	
23620	AF 25/AF 16	12,5	8	M6	16	10
23621	AF 40/AF 25	20	12,5	M10	25,5	33
54400	AF 50/AF 25	25	12,5	M12	32	60
28056	AF 50/AF 40	25	20	M12	32	120

Combi bolt  
AF40, for 1D bar and 2D base plate

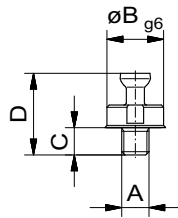
Nr.	System	A	B	C	D	E	F	
25948	AF 25	12,5	6,7	M6	16	5	11,8	24
120510	AF 40	20	10,7	M10	25,5	8	18,5	38



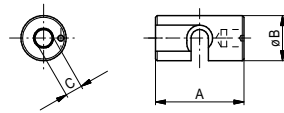
Other versions on request

**Combi bolt**

for grid plate without fitted bore and keyless chuck



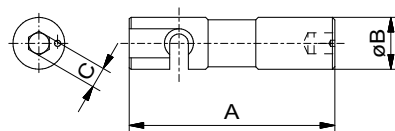
Nr.	System	A	B	C	D	Ø
25746	AF 16	M4	8	3,5	11	2
25654	AF 25	M6	12,5	6	18	10
54587	AF 25	1/4"-20	12,5	12	24	10
54589	AF 25	3/8"-16	12,5	12	24	12
51843	AF 25	M8	12,5	6	18	12
54588	AF 25	M8	12,5	12	24	15
25747	AF 40	M10	20	808	27,3	40
27821	AF 50	M12	25	11	34,1	80
34763	AF 50	M12	25	20	43,1	90



**Lock ALUFIX**

standard lock for quick connection

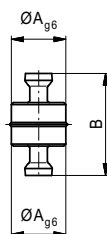
Nr.	System	A	B	C	Ø
23250	AF 16	16	8	SW3	4
23240	AF 25	25	12,5	SW5	13
23260	AF 40	40	20	SW8	58
26856	AF 50	50	25	SW 10	116



**Lock Alufix Light**

for quick connection of Alufix Light bars

Nr.	System	A	B	C	Ø
23246	AF 25	50	12,5	SW3	36
20385	AF 40	80	20	SW5	130
26801	AF 50	100	25	SW 10	300
27930	AF 50	150	25	SW 10	489



**Twin bolt**


for quick connection

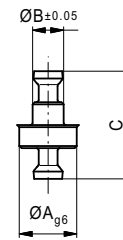
Nr.	System	A	B	Ø
23247	AF 16	8	15	3
23223	AF 25	12,5	24	12
23257	AF 40	20	37	48
26854	AF 50	25	47	94

**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"


**Twin bolt**

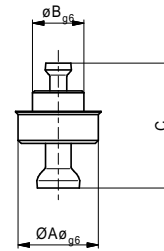
for bar 1D and base plate 2D

Nr.	System	A	B	C	
23248	AF 16	8	4	15	2
23228	AF 25	12,5	6,7	24	8
23258	AF 40	20	10,7	37	34
28208	AF 50	25	13,7	47	70


**Reducer bolt**

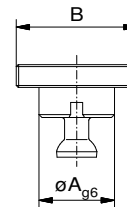
for quick connection

Nr.	System	A	B	C	
20328	AF 25/AF 16	12,5	8	19,5	8
23452	AF 40/AF 25	20	12,5	30,5	30
28209	AF 50/AF 40	25	20	41,6	38
30580	AF 50/AF 25	25	12,5	35	33


**Bolt disk with stud**

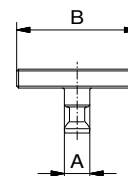
for quick connection of screw jacks, vises or top sections onto base plates or bars

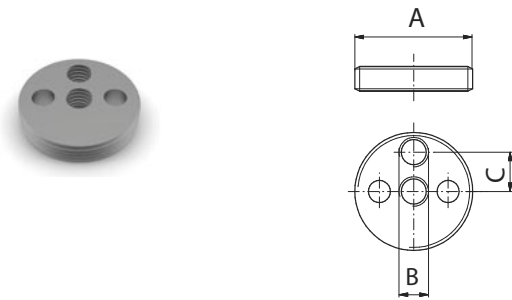
Nr.	System	A	B	
23646	AF 16	8	M12x0,5	5
23252	AF 16	8	M24x1	16
120027	AF 25	12,5	M12x0,5	AF
23239	AF 25	12,5	M24x1	22
23238	AF 25	12,5	M32x1	39
23262	AF 40	20	M24x1	38
23264	AF 40	20	M32x1	58
26926	AF 50	25	M32x1	60

**Bolt disk 1D/2D**

for quick connection of screw jacks or top sections to base plates 2D or bars 1D with long slots

Nr.	System	A	B	
23647	AF 16	4,3	M12x0,5	5
23253	AF 16	4,3	M24x1	15
23241	AF 25	6,7	M24x1	17
23244	AF 25	6,7	M32x1	36
23263	AF 40	10,7	M24x1	24
23265	AF 40	10,7	M32x1	43

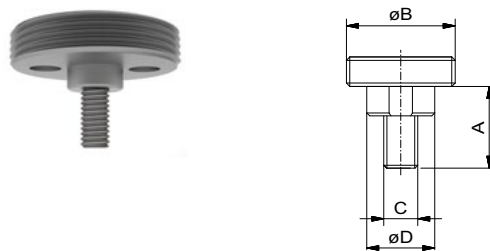




**Disc**  
for set up independent of grid

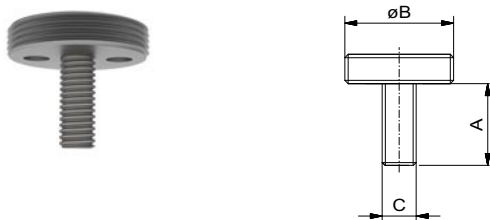
Nr.	A	B	C	
21679	M24x1	M6	7	5
21711	M32x1	M6	9	11

**Fixing disk**  
with stud shoulder



Nr.	System	A	B	C	D	
81587	AF 16	7	M12x0,5	M4	8	5
80748	AF 16	10	M24x1	M4	8	7
80600	AF 25	15	M24x1	M6	12,5	10
80601	AF 25	19	M32x1	M6	12,5	17
82822	AF 40	19	M24x1	M10	20	28
80602	AF 40	24	M24x1	M12	20	30
92900	AF 40	24	M32x1	M10	20	32
80603	AF 40	25	M32x1	M12	20	34
82827	AF 50	30	M32x1	M12	25	45

**Fixing disc**  
for set up independent of grid

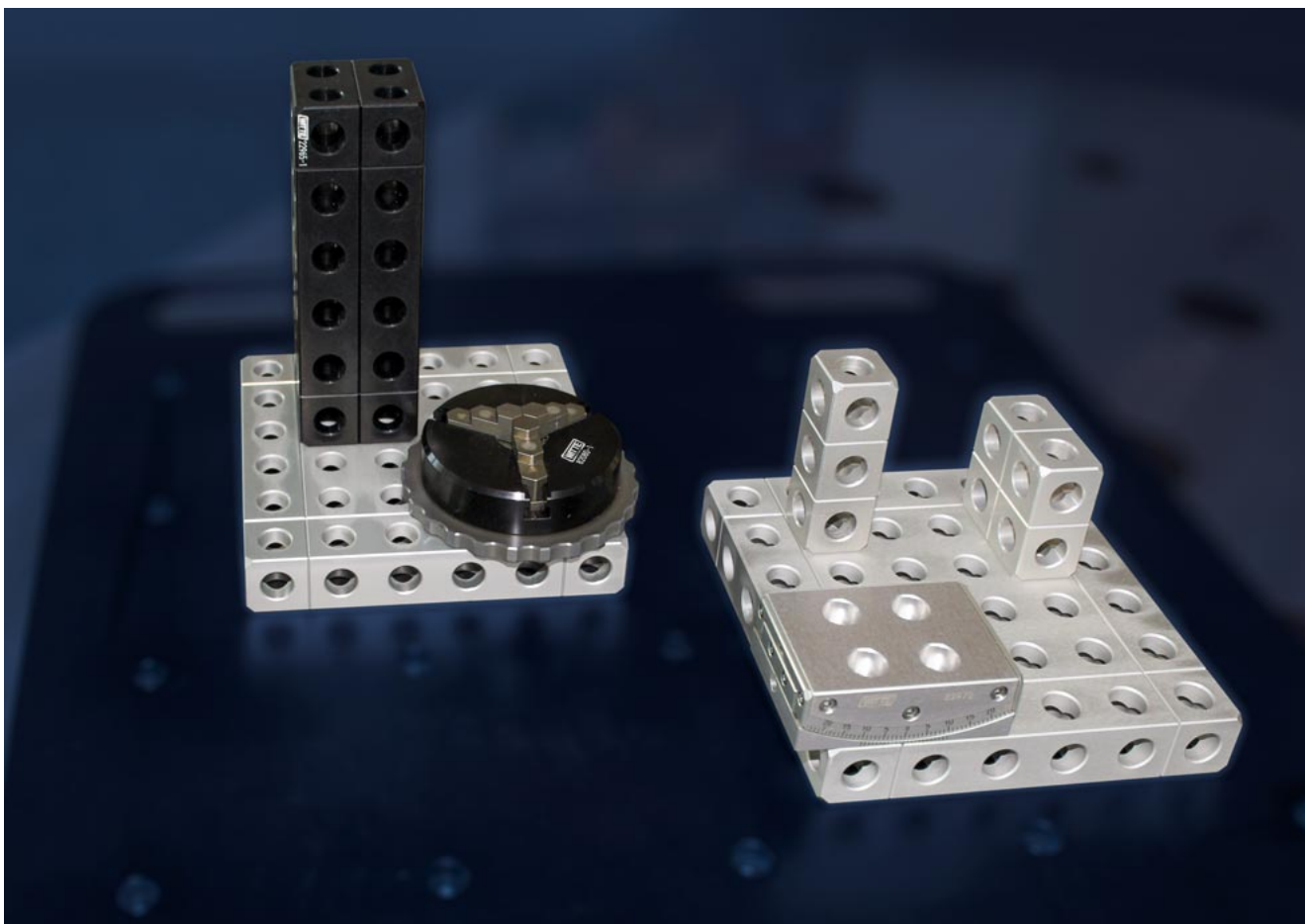
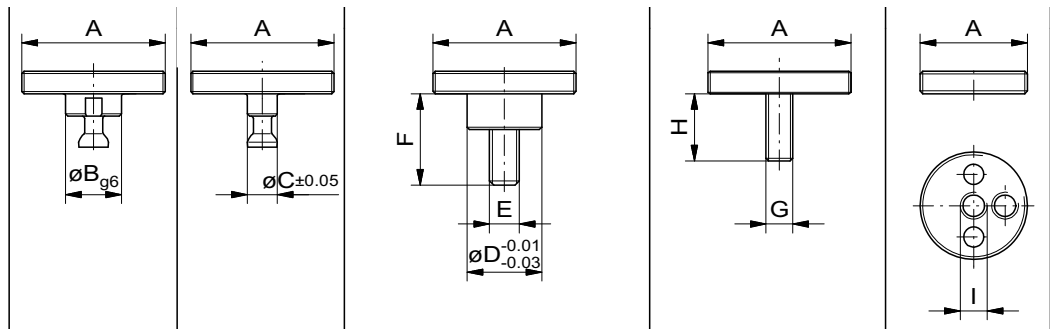


Nr.	System	A	B	C	
81589	AF 16	7,3	M12x0,5	M4	5
81489	AF 16	10,2	M24x1	M4	10
80597	AF 25	15,3	M24x1	M6	8
95905	AF 25	7,7	M24x1	1/4" - 20	10
95906	AF 25	15	M24x1	M8	12
95907	AF 25	7,7	M24x1	3/8" - 16	11
80598	AF 25	19,6	M32x1	M6	15
82770	AF 40	26,2	M24x1	M10	10
82771	AF 40	25,7	M32x1	M10	20
82772	AF 50	30	M24x1	M12	15
82773	AF 50	32	M32x1	M12	25

**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"

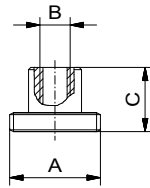
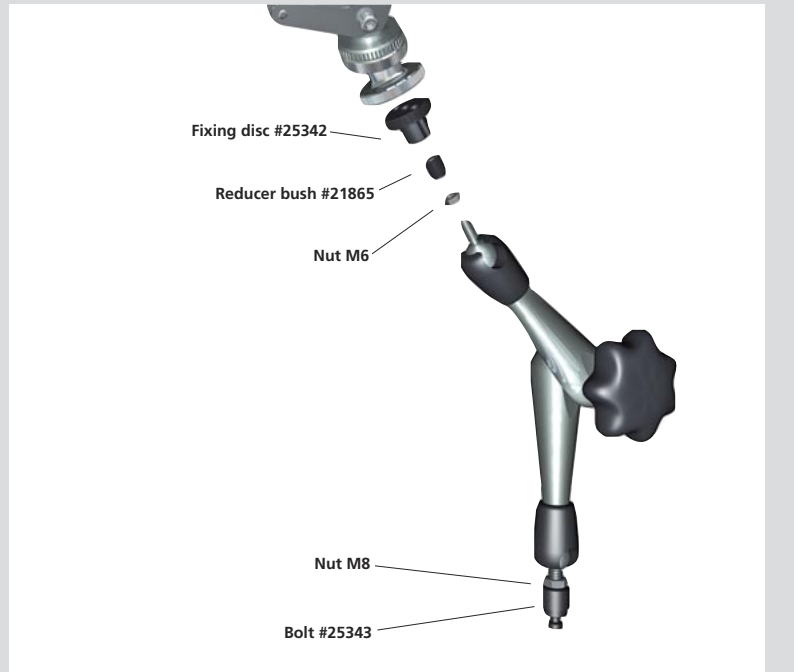
Overview connecting disks for keyless chucks

ø	A	System	#	B	#	C	#	D	E	F	#	G	H	#	I
50	M12x0,5	AF16	23646	8	23647	4,3	81587	8	M4	7	81589	M4	8	52111	M4
50	M12x0,5	AF25	29580	12,5											
80	M16x1,0	AF16	52102	8	52106	4,3	93434	8	M4	7	93438	M4	7	55977	M4
80	M16x1,0	AF25	52103	12,5	52107	6,7	93435	12,5	M6	15	93439	M6	15	21711	M6
125	M32x1,0	AF25	23238	12,5	23244	6,7	80601	12,5	M6	19	80598	M6	15	21711	M6
125	M32x1,0	AF40	23264	20	23265	10,7	92900	20	M10	24	82771	M10	24	52114	M10
125	M32x1,0	AF50	26926	25	52108	13,6	82827	25	M12	25	82773	M12	29	52115	M12
200	M50x1,5	AF40	52104	20	52109	10,7	93436	20	M10	24	93440	M10	22	52116	M10
200	M50x1,5	AF50	52105	25	52110	13,6	93437	25	M12	25	93441	M12	27	52117	M12



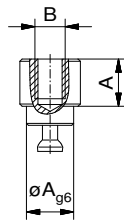
Anwendungsbeispiel: Kleine Vormontagen mit Handspannfutter und Wippe.

Connection elements  
for swivel arm with joint:



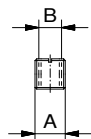
**Fixing disk**  
for swivel arm

Nr.	A	B	C	
25342	M24x1	M8	17	10



**Bolt**  
for swivel arm

Nr.	System	A	B	
25343	AF25	12,5	M8	21



**Reducer bush**  
for swivel arm

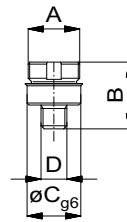
Nr.	A	B	
21865	M8	M6	1

Swivel arm on page 35.

## Connection elements for keyless chucks and rotary plates

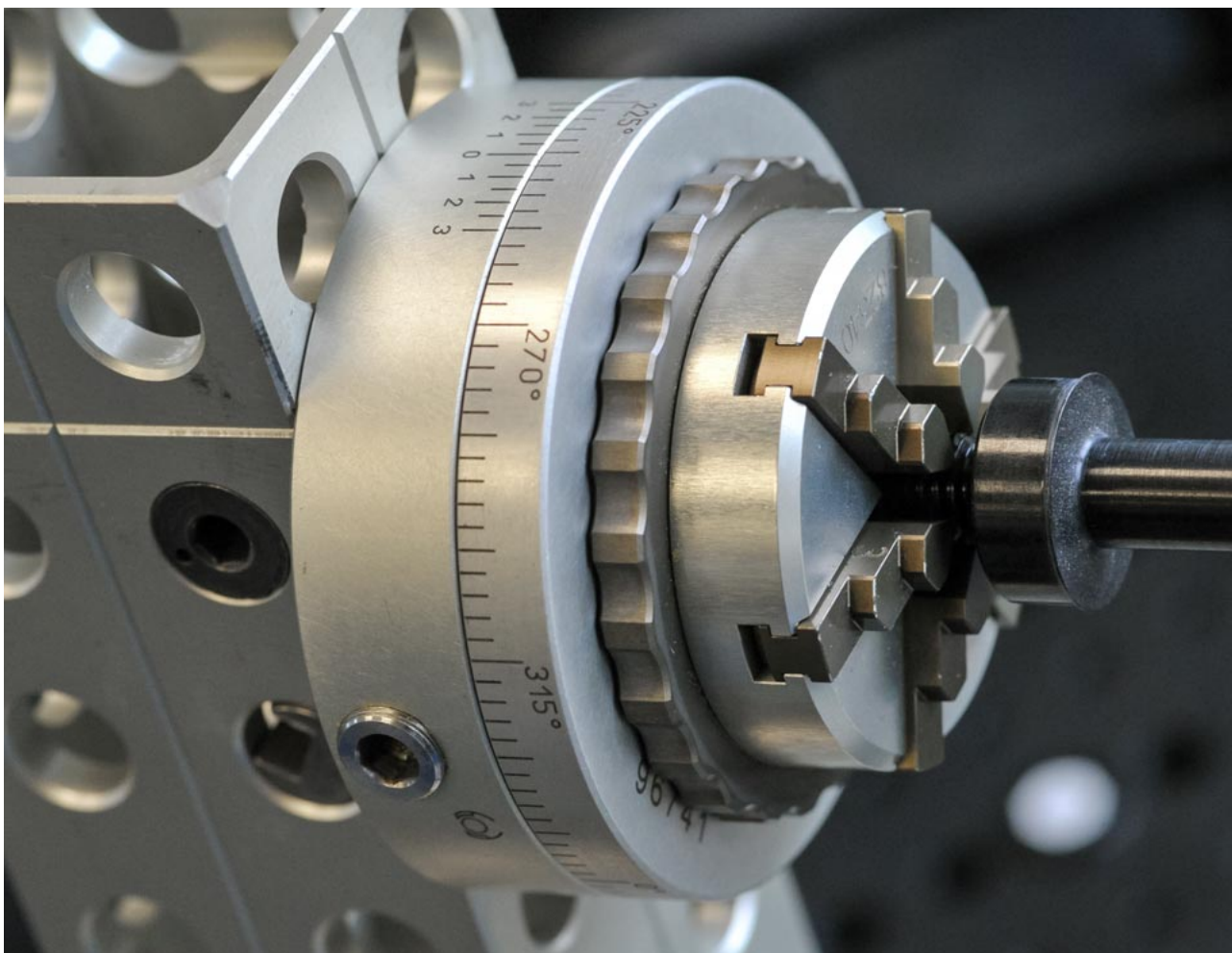
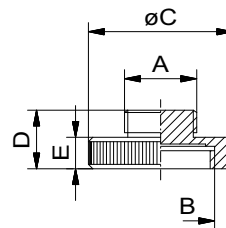
**Fixing disk**  
for keyless chuck / screw-jack

Nr.	A	B	C	D	g
56118	M12x0,5	15,5	12,5	M6	19
56163	M16x1	15,5	12,5	M6	30

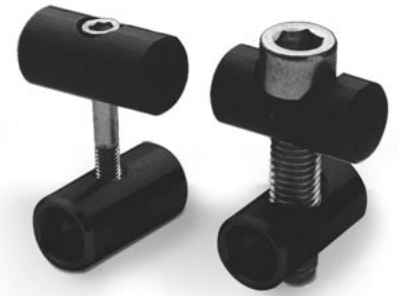
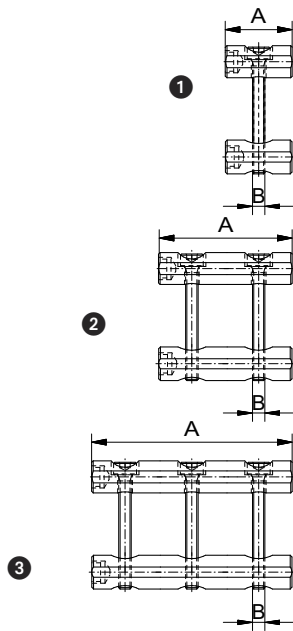


**Fixing disk**  
for keyless chuck / screw-jack

Nr.	für HSF	A	B	C	D	E	g
30084	ø 50	M12x0,5	M24x1	32	13	7	12
30085	ø 80	M16x1	M24x1	32	13	7	15



Application example fixture for rotary plate.



Connecting set  
for screw connection

Eco		Classic				
Nr.	#	Nr.	System	B	A	⊗
AF16						
94051-1	1	80697(-1)	16	M3	16	4
94052-1	1	80698(-1)	16	M4	16	14
AF25						
94053-1	1	80699(-1)	25	M4	25	14
94054-1	1	80700(-1)	25	M5	25	15
94055-1	1	80701(-1)	25	M6	25	20
94056-1	2	81598(-1)	25	M4	50	28
94057-1	2	82233(-1)	25	M6	50	30
AF40						
94060-1	1	80702(-1)	40	M6	40	60
94061-1	1	80703(-1)	40	M8	40	66
94062-1	1	80704(-1)	40	M10	40	85
94063-1	1	80705(-1)	40	M12	40	93
94064-1	2	81599(-1)	40	M6	80	120
94065-1	2	81520(-1)	40	M10	80	176
94066-1	3	82009(-1)	40	M6	120	180
94067-1	3	81896(-1)	40	M10	120	358
AF50						
94068-1	1	82488(-1)	50	M6	50	75
94069-1	1	82518(-1)	50	M12	50	120
94070-1	2	82489(-1)	50	M6	100	150
94071-1	2	82469(-1)	50	M12	100	230
94072-1	3	82490(-1)	50	M6	150	230
94073-1	3	82470(-1)	50	M12	150	350



Picture shows a screw connector with positioning sleeves which fit into Alufix bores.

Classic version: Ideal for modular fixturing for fast easy handling.  
Eco version: Ideal for dedicated fixtures, without wear reducing helicoil inserts, and without threaded hole for positioning rod.

Standard thread sizes are printed in bold print.





**Quick connection set, AF 16, small**  
# 82672, (36-pcs.), 160g  
comprising of:

Nr.	Pcs.	Name
23250	20	Lock, short
23247	10	Twin bolt
23249	3	Combi bolt
23252	3	Bolt disk

**Quick connection set, AF25, small**  
# 82673, (36-pcs.), 1000g  
comprising of:

Nr.	Pcs.	Name
23240	20	Lock, short
23223	10	Twin bolt
23225	3	Combi bolt
23239	3	Bolt disk

**Quick connection set, AF40, small**  
# 82674, (36-pcs), 2500g  
comprising of:

Nr.	Pcs.	Name
23260	20	Lock, short
23257	10	Twin bolt
23259	3	Combi bolt
23264	3	Bolt disk



**Quick connection set, AF25, large**  
# 81285, (70-pcs.), 1274g  
comprising of:

Nr.	Pcs.	Name
23240	30	Lock, short
23246	10	Lock, long
23223	20	Twin bolt
23228	3	Bolt for bar 1D
23239	3	Bolt disk
23330	2	Coupling, double
23325	2	Coupling, single

**Quick connection set, AF40, large**  
# 81516, (70-pcs.), 5020g  
comprising of:

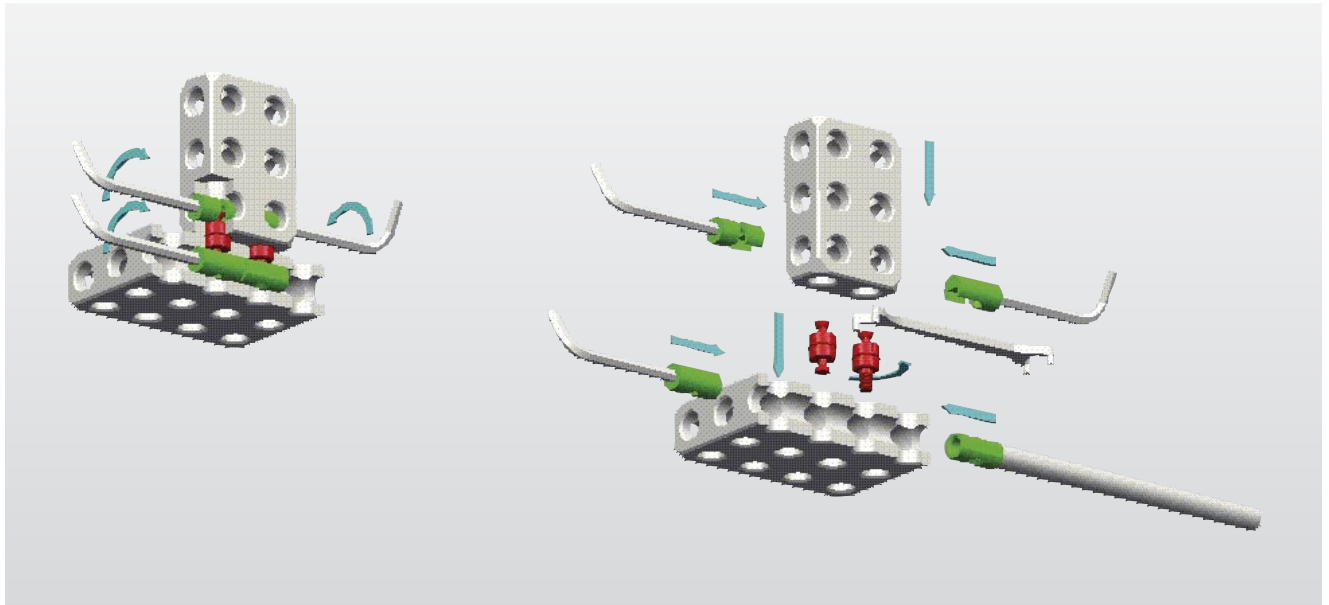
Nr.	Pcs.	Name
23260	30	Lock, short
20385	10	Lock, long
23257	20	Twin bolt
23258	3	Bolt for bar 1D
23262	3	Bolt disk
20791	2	Coupling, double
20792	2	Coupling, single

**Quick connection set, AF50, large**  
# 82801, (70-tlg.), 9600g  
comprising of:

Nr.	Pcs.	Name
26856	30	Lock, short
26801	10	Lock, long
26854	20	Twin bolt
28208	3	Bolt for bar 1D
26926	3	Bolt disk
26850	2	Coupling, double
26727	2	Coupling, single

# ALUFIX Tools

High quality components – ideal for use with ALUFIX



Adjust torque  
with hex key



**Torque wrench**  
with adjustable torque incl. hex key  
and 3, 4 and 5 mm bits

Nr.	System	Maximum torque
82840	AF 16	3N/m
98022	AF 25	5N/m

In order to guarantee function of the quick connectors,  
recommended torque should not be exceeded.



**Torque wrench**  
with pre-set torque

Nr.	System	Maximum torque
82099	AF 40	25 N/m
82789	AF 50	30 N/m

In order to guarantee function of the quick connectors,  
recommended torque should not be exceeded.

**#81492 Tools**

ALUFIX 16 (5-pcs.), comprising of:

Nr.	Pcs.	Name
80622	1	Positioning rod
81175	1	Extended hex key WAF3
54902	1	Combi tool AF 16
81118	2	Key for knurled profiles 32/42

**#81493 Tools**

ALUFIX 25 (10-pcs.), comprising of:

Nr.	Pcs.	Name
80534	1	Positioning rod
80520	1	Handle 112,5
80521	2	Extension 150
10523	1	Hex insert bit WAF3
10522	1	Hex insert bit WAF4
10521	1	Hex insert bit WAF5
21820	1	Pin spanner 14/17
81118	2	Key for knurled profiles 32/42

**#81494 Tools**

ALUFIX 40 (10-pcs.), comprising of:

Nr.	Pcs.	Name
80535	1	Positioning rod
80439	1	Handle 112,5
80435	1	Extension 200
80437	1	Extension 300
10484	1	Hex insert bit WAF6
10485	1	Hex insert bit WAF8
10486	1	Hex insert bit WAF10
21820	1	Pin spanner 14/17
81118	2	Key for knurled profiles 32/42

**#82263 Tools**

ALUFIX 50 (10-pcs.), comprising of:

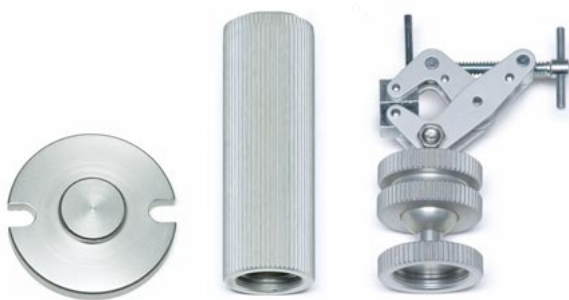
Nr.	Pcs.	Name
82551	1	Positioning rod
80439	1	Handle 112,5
80435	1	Extension 200
80437	1	Extension 300
10484	1	Hex insert bit WAF6
10485	1	Hex insert bit WAF8
10486	1	Hex insert bit WAF10
27931	1	Pin spanner 17/23
81118	2	Key for knurled profiles 32/42

The components in tool sets are also available as single items.

# ALUFIX

## Basic Kits

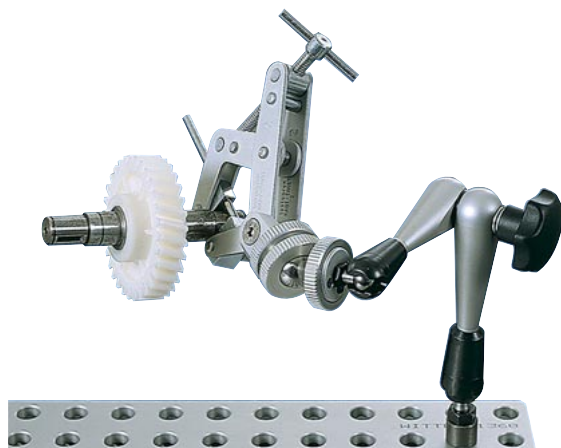
Starter-Kits, optimal selection of basic modular elements and accessories



### STARTER KIT A

**#83131 Screw clamp**  
with ball joint, foot plate and extension, 371g

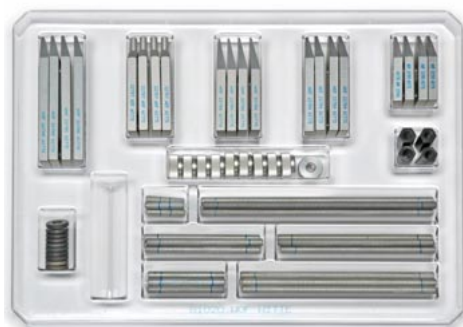
- max clamping width 25 mm
- extension 100 mm



### STARTER KIT B

**#83132 Screw clamp**  
with ball joint, swivel arm and screw clamp, 936g

- max clamping width 50 mm
- arm length 280 mm (2x140)
- hydraulic central clamping
- workpiece can be fixed in any position



### STARTER KIT C

**#81020 Clamping element set**  
M6, 69 Pcs., 650g

Comprising:

- 20 clamps in different shapes and lengths from 45 to 85mm
- 24 threaded rods M6 in 6 lengths from 25 to 150mm
- 4 coupling nuts, 10 knurled nuts and 10 washers

**C·E** ALUFIX-Vorzugsreihe  
Grüne Kennzeichnung: Artikel ist sofort lieferbar.  
C: Ausführung Classic, E: Ausführung Eco, C-E: Classic oder Eco  
■: Farbe "Natur", ■: Farbe "Schwarz"

## STARTER KIT D

**#83134 Hold down spring**  
and hold down stud with M6 thread, 40g

Comprising:

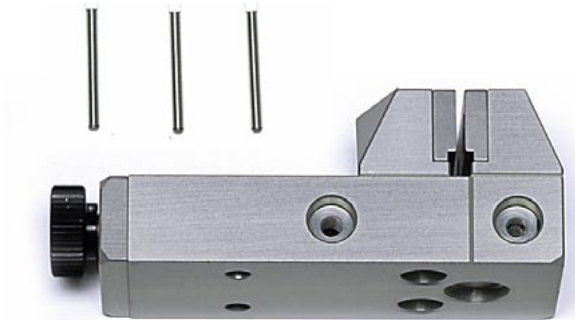
- Hold down spring L=60mm
- Hold down stud L=60mm (other length on request)
- One reducer sleeve each with thread M8, M10 und M12



## STARTER KIT E

**#83135 Vise**  
with pins, jaw width 50 mm, 810g

- high tensile aluminium
- exchangeable jaws
- clamping width 65 mm



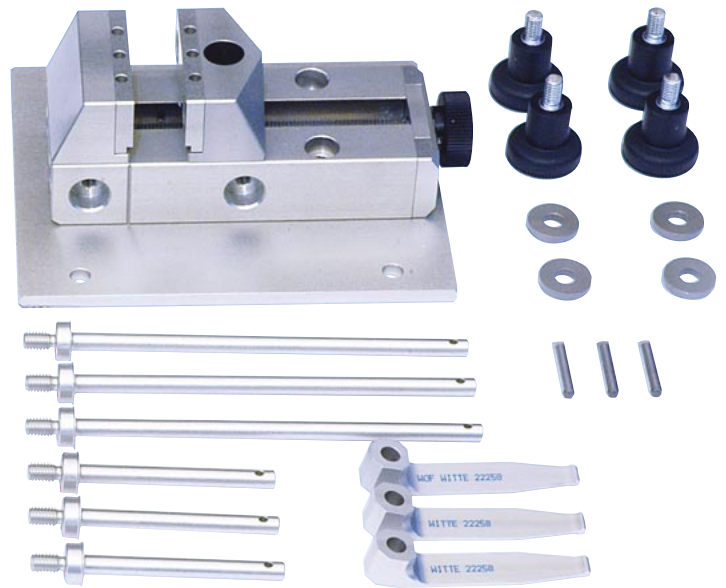
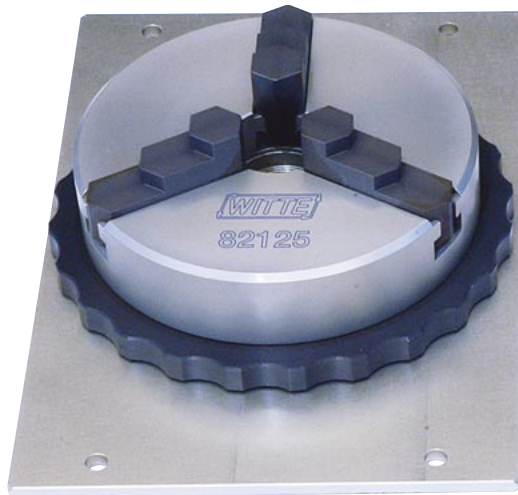
## STARTER KIT F

**#82080 Keyless chuck**  
with reversible jaws, D80, 368g

- high tensile aluminium
- centric clamping
- diameter 80mm



ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative -  
then simply add "-1" to the article number when ordering.  
Other colors on request.



#### STARTER KIT G

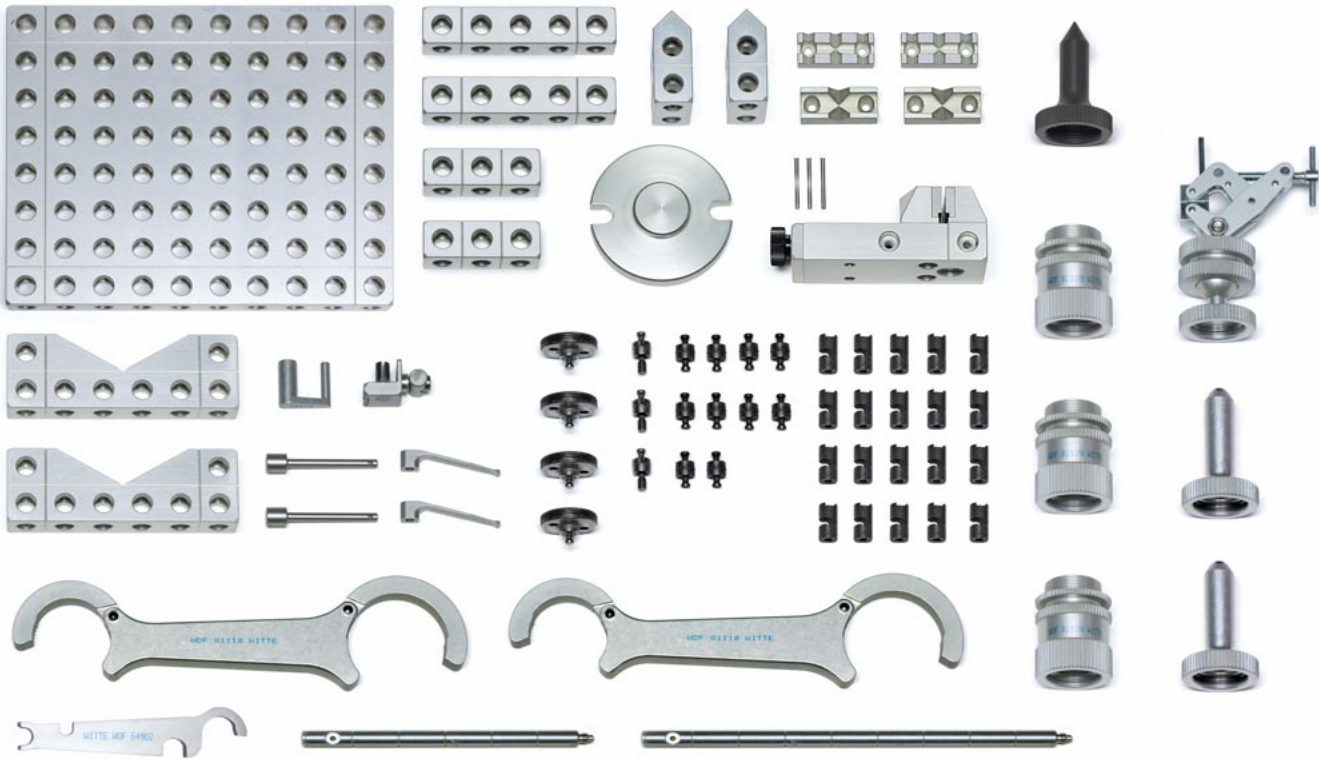
#### #96092 Basic Set

Clamp accessory kit for measuring machines  
(23-pcs), 9,8 kg

Nr.	Qty.	Name
96106	1	Keyless chuck $\varnothing$ 125, 3 jaws
96107	1	Vise 50 AF25
24605	3	Pin for vise AF25
22258	3	Hod down spring
54766	3	Hold down stud AF25
54767	3	Hold down stud AF25
13086	4	Screw with knurled grip
21286	4	Washer $\varnothing$ 6,4
96315	1	Storage box with inlay

Keyless chuck and vise mounted on aluminium plate



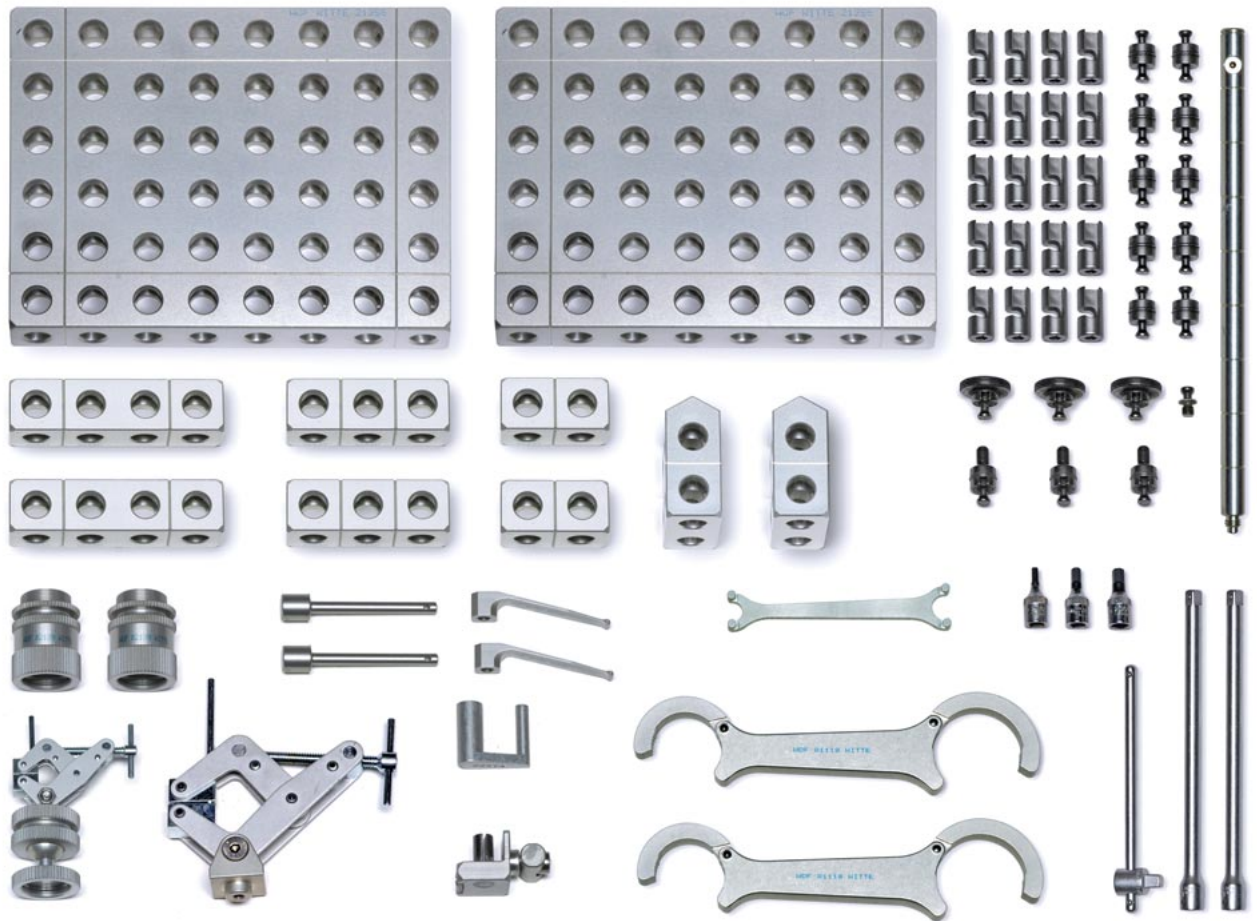


### #90271 Basic Set Alufix 16, medium (75-pcs), 2,3 kg

Nr.	Qty.	Name
21573	1	Base plate 16x96x160
21586	2	Bar 16x16x80
21584	2	Bar 16x16x48
22173	2	V Block 90°
82672	1	Quick connector set (36-pcs)
81492	1	Tools (5-pcs)
82139	3	Screw-jack h38-50
23252	1	Bolt disk with stud
21670	1	Universal plate

Nr.	Qty.	Name
21646	1	Center, long
80584	2	Center with ball
21988	2	V piece 120°
80925	1	Screw clamp w ball joint
80742	1	Winder
22274	1	Deflector
20244	2	Hold down spring
20338	2	Hold down stud
81790	1	Vise set with flat and V jaws (10-pcs)

ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering.  
Other colors on request.

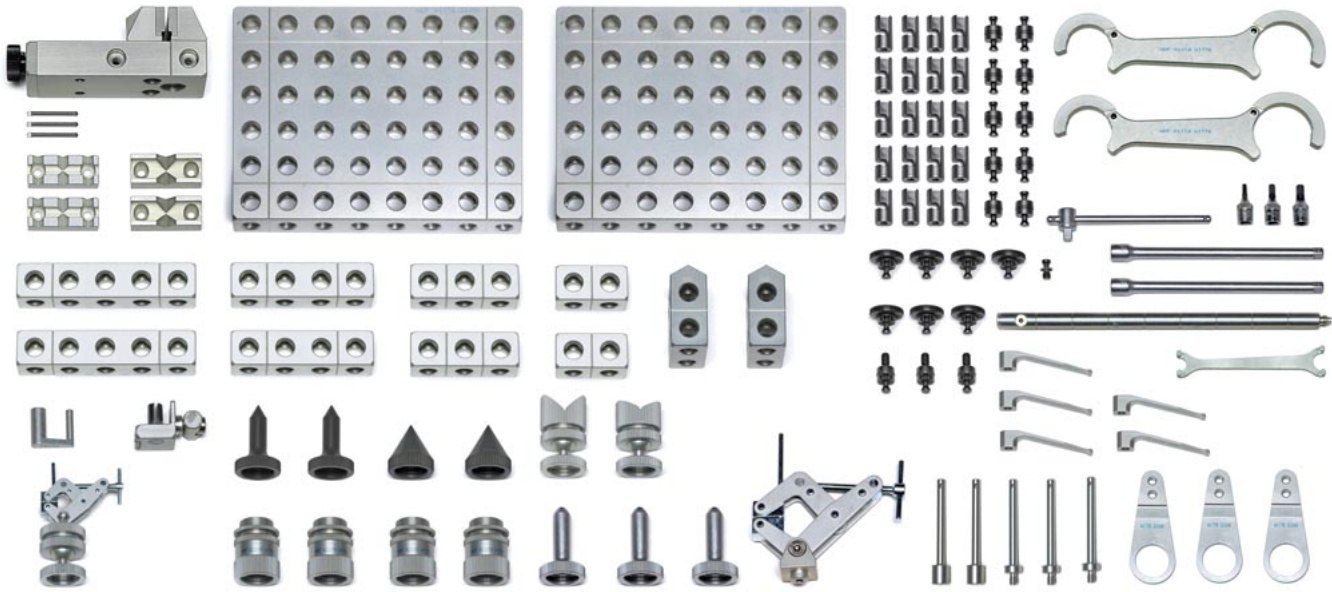


**#90274 Basic Set 1**  
Alufix 25 (67-pcs), 4,5 kg

Nr.	Qty.	Name
21352	2	Base plate 25x150x200
21373	2	Bar 25x25x50
21374	2	Bar 25x25x75
21375	2	Bar 25x25x100
22256	2	Delta block 120° Form 3
82673	1	Quick connector set (36 pcs)
21500	1	Bolt, shortened for thread
81493	1	Tools (10 pcs)

Nr.	Qty.	Name
82139	2	Screw-jack h38-50
80925	1	Screw clamp with ball joint
80924	1	Screw clamp with joint
22258	2	Hold down spring
22260	2	Hold down stud
80743	1	Winder
22275	1	Deflector



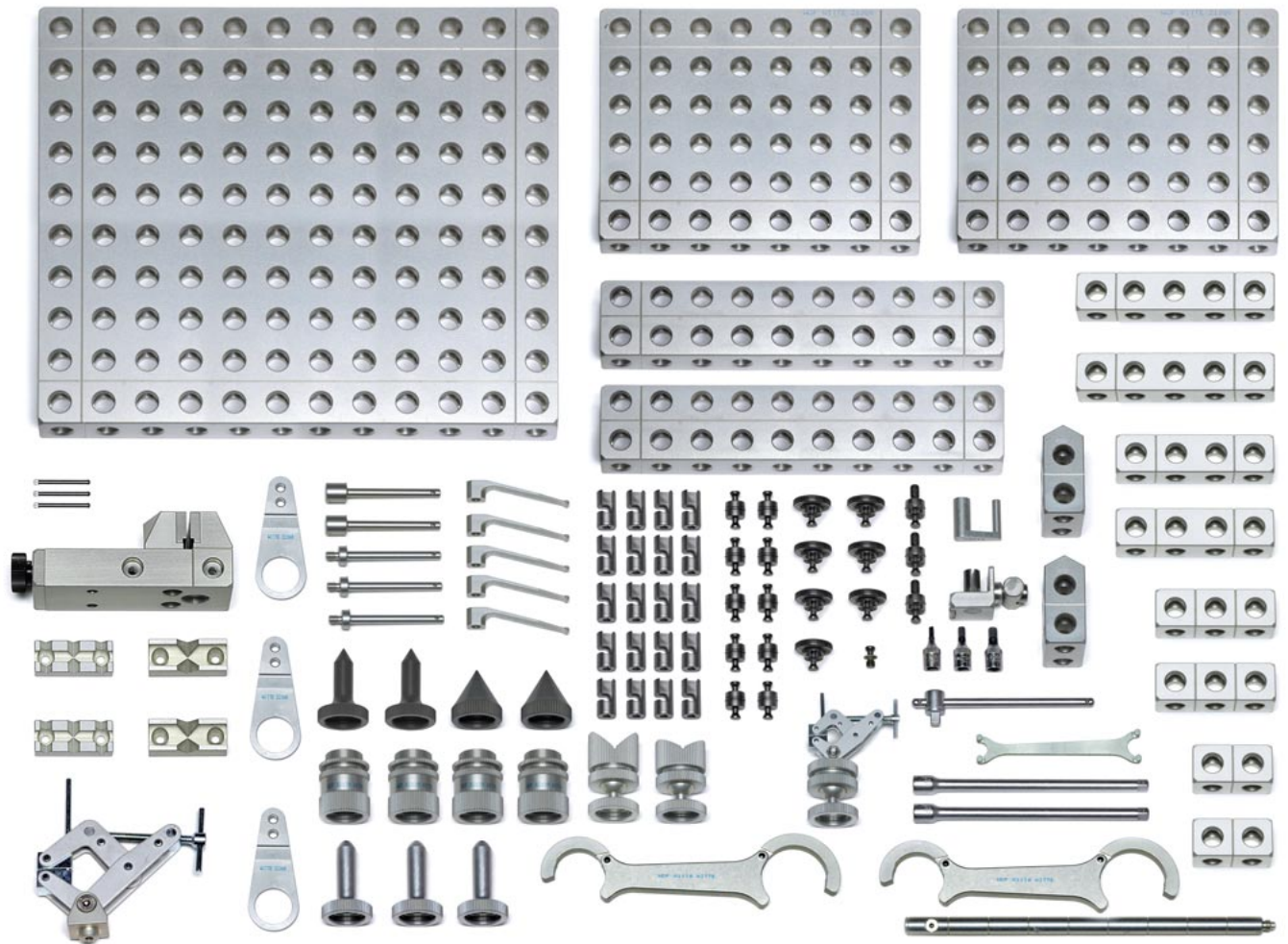


**#90275 Basic Set 2**  
Alufix 25 (103-pcs), 5,9 kg

Nr.	Qty.	Name
21352	2	Base plate 25x150x200
21373	2	Bar 25x25x50
21374	2	Bar 25x25x75
21375	2	Bar 25x25x100
21376	2	Bar 25x25x125
22256	2	Delta block 120° Form 3
82673	1	Quick connector set (36 pcs)
21500	1	Bolt, shortened for thread
81493	1	Tools (10 pcs)
82139	4	Screw-jack h38-50
23239	4	Bolt disk with stud
80924	1	Screw clamp with joint
21644	2	Center

Nr.	Qty.	Name
21646	2	Center
80584	3	Center with ball
80733	1	V piece 120° with ball joint
80725	1	V piece 90° with ball joint
80925	1	Screw clamp with ball joint
81791	1	Vise Set 50mm (10 pcs)
22258	5	Hold down spring
22260	2	Hold down stud
22263	3	Hold down stud
22268	3	Traverse holder with heel
80743	1	Winder
22275	1	Deflector

ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative -  
then simply add "-1" to the article number when ordering.  
Other colors on request.

**#90276 Basic Set 3**

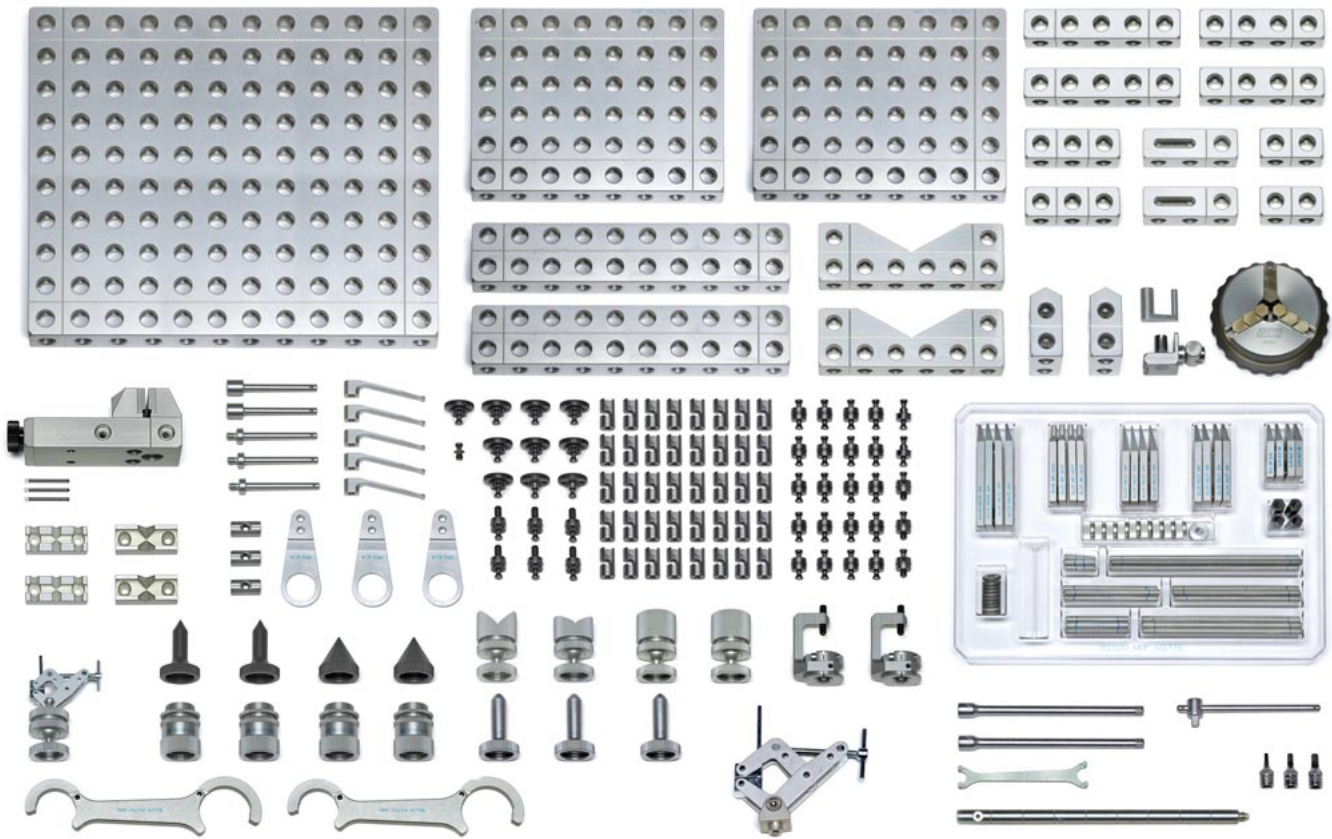
Alufix 25 (105-pcs), 12,6 kg

Nr.	Qty.	Name
21360	1	Base plate 25x250x300
22885	2	Base plate 25x50x250
21352	2	Base plate 25x150x200
21373	2	Bar 25x25x50
21374	2	Bar 25x25x75
21375	2	Bar 25x25x100
21376	2	Bar 25x25x125
22256	2	Delta block 120° Form 3
82673	1	Quick connector set (36 pcs)
21500	1	Bolt, shortened for thread
81493	1	Tools (10 pcs)
82139	4	Screw-jack h38-50
23239	1	Bolt disk
80925	2	Screw clamp with ball joint

Nr.	Qty.	Name
21644	2	Center, short
21646	2	Center, long
80733	1	V piece 120° with ball joint
80725	1	V piece 90° with ball joint
81791	1	Vise Set 50mm (10 pcs)
22258	5	Hold down spring
22260	2	Hold down stud
22263	3	Hold down stud
22268	3	Traverse holder with heel
80743	1	Winder
22275	1	Deflector
80924	1	Screw clamp with joint
80584	3	Center with Ball D6/M24
12584	1	Storage case



Aluminium case #12584,  
without inlays,  
version may be different to case shown,  
included in supply free of charge



**#90277 Basic Set 4**  
Alufix 25 (228-pcs), 15,5kg

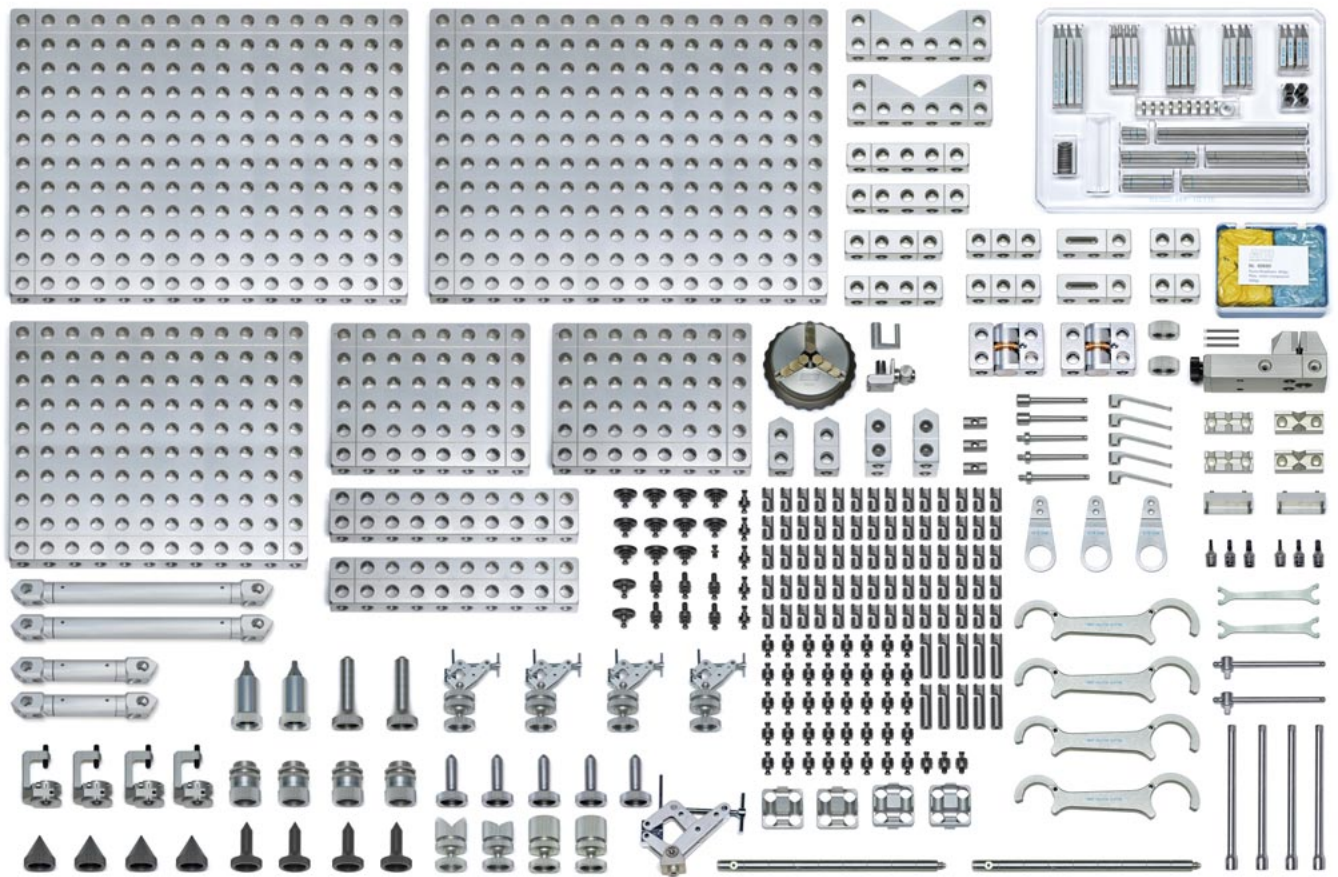
Nr.	Qty.	Name
21360	1	Base plate 25x250x300
21352	2	Base plate 25x150x200
22885	2	Base plate 25x50x250
21376	2	Bar 25x25x125
21375	2	Bar 25x25x100
21374	2	Bar 25x25x75
21373	2	Bar 25x25x50
23233	2	Bar 1D
21987	2	V block 120°
22256	2	Delta block 120° Form 3
82673	2	Quick connector set (36-pcs)
21500	1	Bolt, shortened for thread
25654	3	Bolt f. grid plate + keyless chuck
23228	2	Twin bolt for bar 1D/2D
23241	2	Bolt disk
80531	3	Crosspiece nut
81493	1	Tools (10-pcs)
82139	4	Screw-jack h38-50
23239	1	Bolt disk

Nr.	Qty.	Name
21644	2	Center, short
21646	2	Center, long
80584	3	Center with ball
80941	2	Magnetic holder with ball joint
80733	1	V piece 120° with ball joint
80725	1	V piece 90° with ball joint
81111	2	C clamp adjustable
80925	1	Screw clamp with ball joint
81791	1	Vise Set 50mm (10-pcs)
82080	1	3 jaw keyless chuck compl. ø80
22258	5	Hold down spring
22260	2	Hold down stud
22263	3	Hold down stud
22268	3	Traverse holder with heel
80743	1	Winder
22275	1	Deflector
80924	1	Screw clamp with joint
81020	1	Clamp Set 9 M6S (69-pcs)
12584	1	Storage case



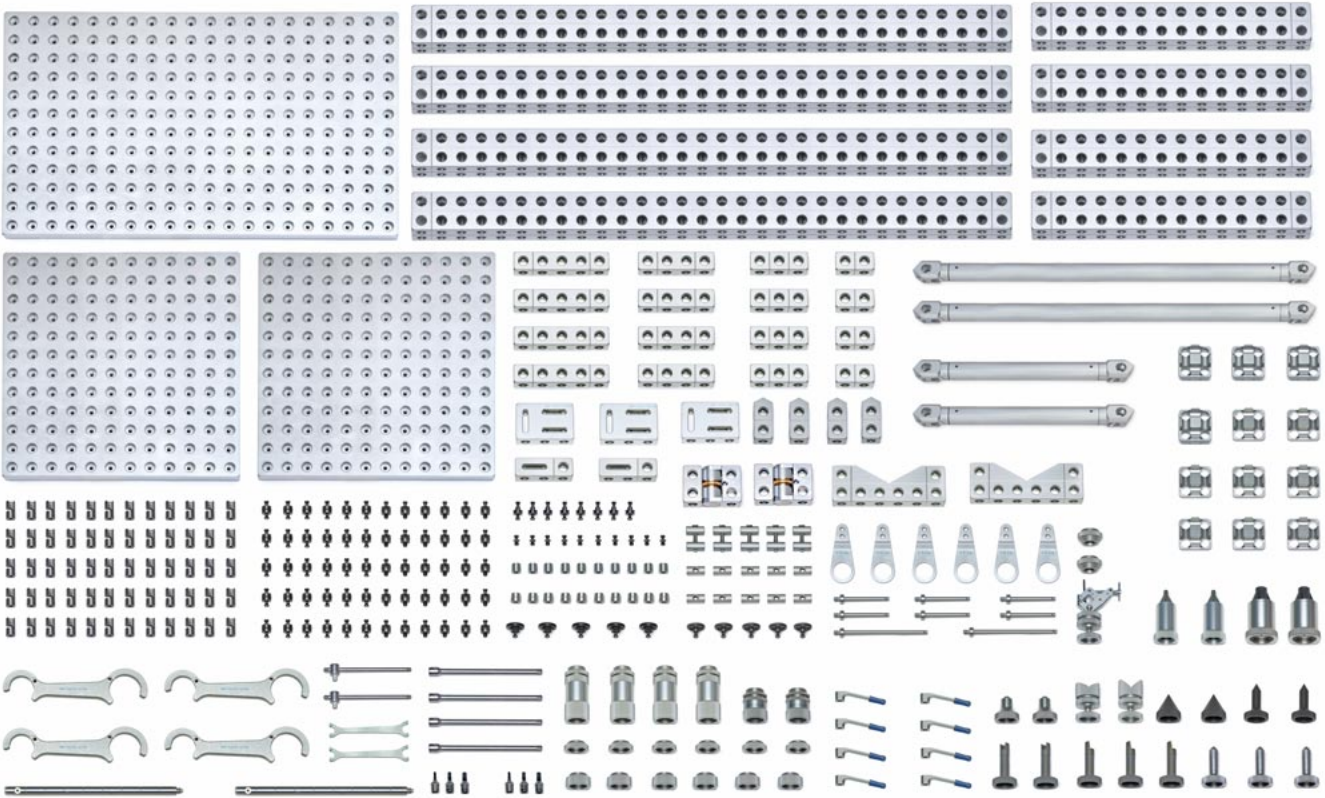
Aluminium case #12584, without inlays, version may be different to case shown, included in supply free of charge

ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.

**#90278 Basic Set 5**

Alufix 25 (344-pcs), 49,8 kg

Nr.	Qty.	Name	Nr.	Qty.	Name
21361	2	Base plate 25x300x400	21644	4	Center, short
21360	1	Base plate 25x250x300	21646	4	Center, long
21352	2	Base plate 25x150x200	80584	5	Center with ball
22885	2	Base plate 25x50x250	80733	1	V piece 120° with ball joint
21376	2	Bar 25x25x125	80725	1	V piece 90° with ball joint
21375	2	Bar 25x25x100	80661	2	True line stud
21374	2	Bar 25x25x75	80941	2	Magnetic holder with ball joint
21373	2	Bar 25x25x50	81212	2	Autocenter
81443	2	Strut 25x25x125	81111	4	C clamp adjustable
81444	2	Strut 25x25x250	80925	4	Screw clamp with ball joint
23233	2	Bar 1D	22005	2	Moulding cap
81028	2	Double knuckle	81791	1	Vise Set 50mm (10 pcs)
21987	2	V block 120°	80685	1	Compound resin 400g
22256	2	Delta block 120° Form 3	81832	2	Forming jaw with bushes (3 pcs)
22253	2	Delta block 120° Form 2	82080	1	3 jaw keyless chuck compl. ø80
81285	1	Quick connector set (70-pcs)	22258	5	Hold down spring
82673	2	Quick connector set (36-pcs)	22260	2	Hold down stud
80531	3	Crosspiece nut	22263	3	Hold down stud
23228	2	Bolt for bar 1D/2D	22268	3	Traverse holder for stud
25654	3	Bolt f. grid plate + keyless chuck	80743	1	Winder
21500	1	Bolt, shortened for thread	22275	1	Deflector
81493	2	Tools (10-pcs)	80924	1	Screw clamp with joint
82139	4	Screw-jack h38-50	80604	2	Base for screw clamp
23239	1	Bolt disk	81020	1	Clamp Set 9 M6S (69 pcs)
23241	2	Bolt disk	12584	1	Storage case



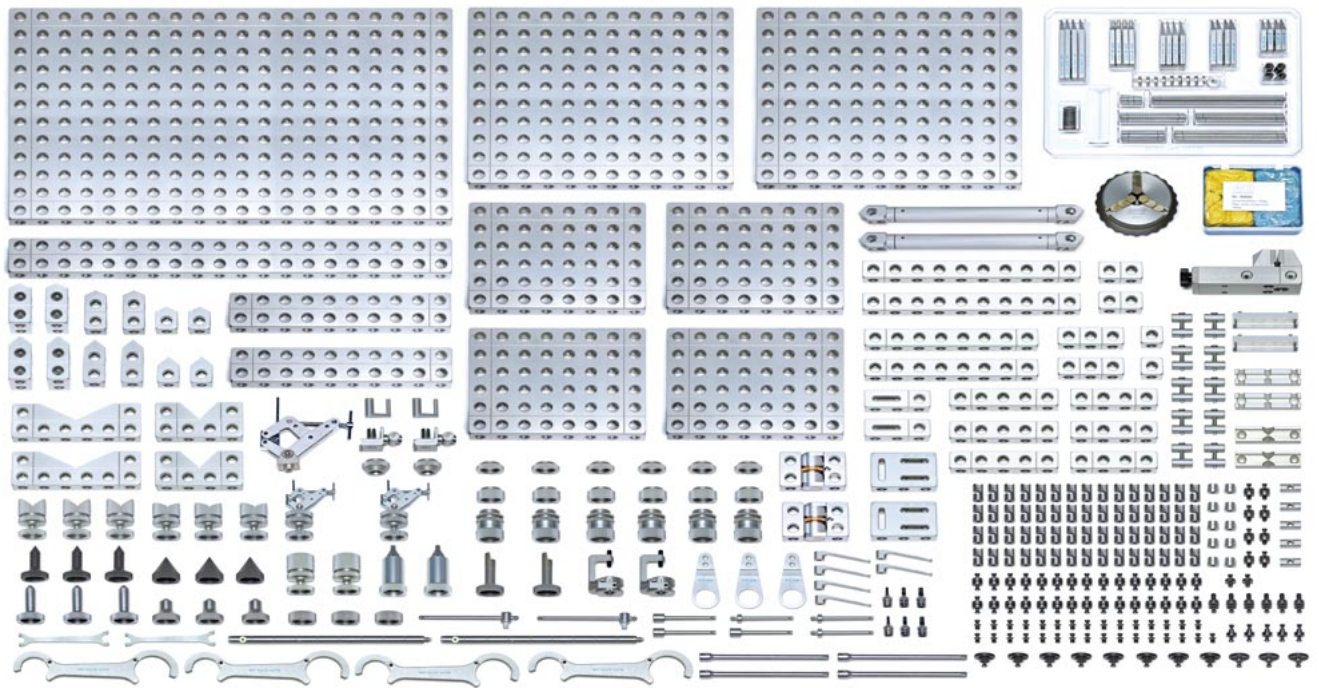
Supply includes  
3 cross guiding slides with slide stop  
#82437 (not shown above)



**#98156 Basic Set 6**  
Alufix 25 (332-pcs), 49,8 kg

Nr.	Qty.	Name
33502	1	Base plate 25x300x500 AF25
56492	2	Base plate 25x300x300 AF25
21373	4	Bar 25x25x50 AF25
21374	4	Bar 25x25x75 AF25
21375	4	Bar 25x25x100 AF25
21376	4	Bar 25x25x125 AF25
21824	4	Bar 50x50x750 Light AF25
24246	4	Bar 50x50x350 Light AF25
23325	8	Coupling 50x50 single AF25
23330	4	Coupling 50x50 double AF25
23233	2	Bar 25x25x75 1D AF25
23232	3	Base plate 2D 25x50x75 AF25
81028	2	Double knuckle AF25
82437	3	Cross guiding slide, AF25 with stop
81444	2	Strut 250 AF25
81327	2	Strut 500 AF25
21987	2	V-Block 120° 25x50x150 AF25
22253	4	Deltablock 120° Form2 AF25
23240	60	Lock SW5 AF25
23223	30	Twin bolt AF25
25743	30	Combi bolt shortened AF25
21500	10	Bolt shortened AF25
23228	8	Twin bolt AF25 for Bar 1D/2D
21386	10	Positioning sleeve ø12,5
81493	2	Tool AF25 (10pcs)
21385	10	Positioning sleeve ø12,5 AF25

Nr.	Qty.	Name
23241	5	Bolt disk ø6,7/M24 AF25
80701	10	Connector Set M6/25 AF25
82139	2	Screw-jack h=38/50 M24X1
82033	4	Screw-jack h=70/105 M24X1
20628	6	Screw-jack extension 6/M24x1
23286	6	Screw-jack extension 12/M24x1
23239	5	Bolt Disk with stud ø12,5/M24
21644	2	Center ø32/M24
21646	2	Center, ø12,5/M24 50 long
94543	2	Autocenter, star shaped, M24x1
95532	2	Autocenter, star shaped, M24x1
81112	3	Stop and support 180° AF25
81113	2	Stop and support 90° AF25
80531	10	Nut M6/25 AF25
80585	3	Center w. ball ø8/M24
80733	2	V Block 120° with ball joint
80590	2	True line stud ø15/M24/32,6
22647	2	Crossover male/male M24x1
93443	8	Hold down spring f.sens. surfaces
22263	6	Hold down stud M6 AF25
24885	2	Hold down stud M6 AF25 I125
22268	6	Traverse holder with heel 6/60
80743	1	Winder AF25
22275	1	Deflector AF25
80924	1	Screw clamp with ball joint



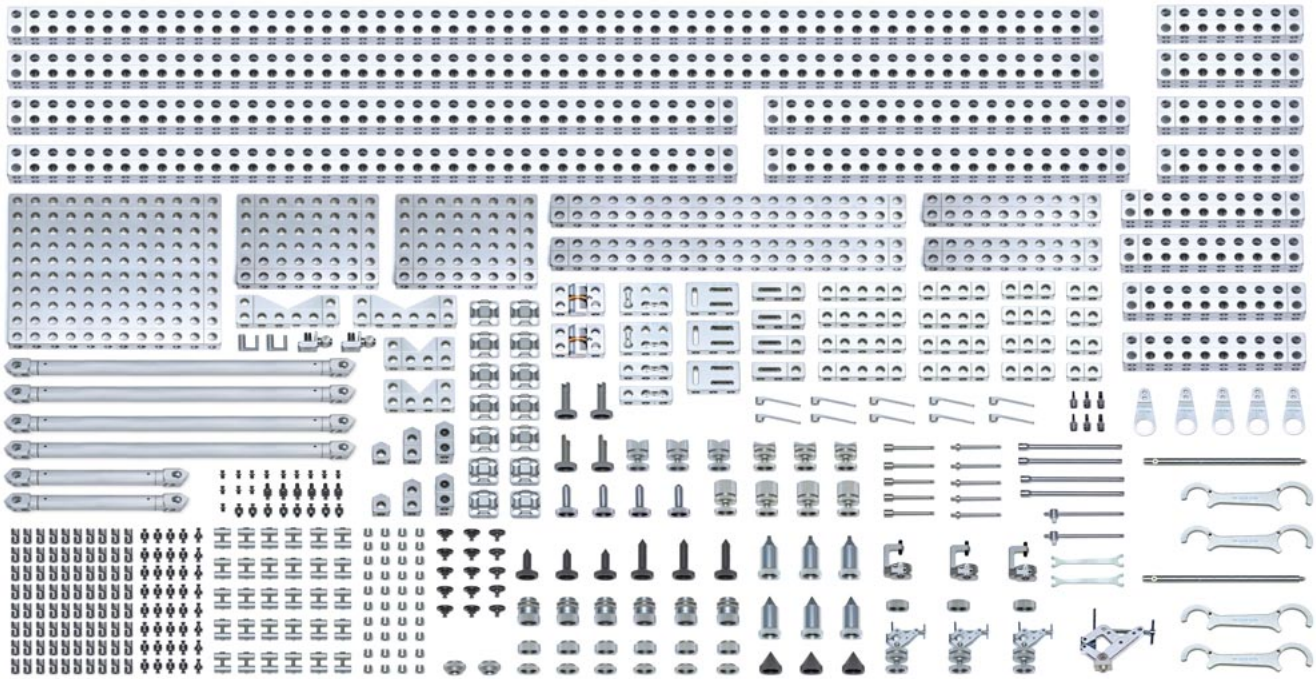
**#82689 Basic Set 7**  
Alufix 25 (416-pcs), 54 kg

Supply includes:  
2 cross roller slides #82462  
2 roller slides #82172  
(not shown above)



Nr.	Qty.	Name
22885	2	Base plate 25x50x250
21707	1	Base plate 25x50x500
21360	2	Base plate 25x250x300
21352	4	Base plate 25x150x200
21362	1	Base plate 25x300x500
21372	2	Bar 25x25x25
21373	2	Bar 25x25x50
21374	2	Bar 25x25x75
21375	3	Bar 25x25x100
21376	3	Bar 25x25x125
22963	2	Bar 25x25x200
22882	2	Bar 25x25x250
23233	2	Bar 1D
23232	2	Base plate 2D
81028	2	Double knuckle
82172	2	Roller slide
82462	2	Cross roller slide
81444	2	Strut 25x25x250
21992	2	V block 90°
21987	2	V block 120°
22235	2	Delta block 90° Form 1
22177	2	Delta block 90° Form 2
22174	2	Delta block 90° Form 3
22241	2	Delta block 120° Form 1
22253	2	Delta block 120° Form 2
22256	2	Delta block 120° Form 3
23240	60	Lock
23223	30	Twin bolt
21500	31	Bolt, shortened for thread
25654	2	Twin bolt for grid base plate
23225	6	Combi bolt
23228	5	Twin bolt for bar 1D
25743	8	Combi bolt shortened
81493	2	Tools (10 pcs)

Nr.	Qty.	Name
21385	10	Positioning sleeves
21869	6	Reducer bush
21714	5	Crosspiece nut
80701	10	Connecting set
82139	6	Screw-jack h38-50
20628	6	Screw-jack extension 6mm
23286	6	Screw-jack extension 12mm
23239	8	Bolt disk
23241	3	Bolt disk
21644	3	Center, short
21646	3	Center, long
80584	3	Center with ball
80733	3	V piece 120° with ball joint
80725	3	V block 90° with ball joint
80590	3	True line stud
80941	2	Magnetic holder with ball joint
81212	2	Auto-center
81112	2	Stop and support 180°
81111	2	C clamp adjustable
22644	3	Spacer
80925	2	Screw clamp with ball joint
22647	2	Cross over male/male
81792	1	Vise Set 75mm (10 pcs)
81833	2	Forming jaw with bushes (3 pcs)
80685	1	Compound resin 400g
82080	1	3 jaw keyless chuck compl. ø80
22258	6	Hold down spring
22260	3	Hold down stud
22263	3	Hold down stud
81020	1	Clamp set 9 M6S (69 Pcs.)
80924	1	Screw clamp 50 with joint
22268	3	Traverse holder with M6 heel
80743	2	Winder AF25
22275	2	Deflector AF25



**#90281 Basic Set 9**  
Alufix 25 (434-pcs), 51kg

Supply includes:  
2 cross roller slides #82462  
2 roller slides #82172  
(not shown above)



Nr.	Qty.	Name
21360	1	Base plate 25x250x300
21352	2	Base plate 25x150x200
22885	2	Base plate 25x50x250
21707	2	Base plate 25x50x500
21373	4	Bar 25x25x50
21374	4	Bar 25x25x75
21375	4	Bar 25x25x100
21376	4	Bar 25x25x125
22949	4	Bar Light 50x50x250
22950	4	Bar Light 50x50x500
22951	2	Bar Light 50x50x1000
22952	2	Bar Light 50x50x1500
23325	10	Coupling, single
23330	4	Coupling, double
23233	4	Bar 1D
81021	2	Bar with 1 offset unit
23232	3	Base plate 2D
81023	2	Base plate with 2 offset units
81028	2	Double knuckle
82172	2	Roller slide
82462	2	Cross roller slide
81444	2	Strut 25x25x250
81327	4	Strut 25x25x500
21992	2	V Block 90°
21987	2	Block 120°
22241	2	Delta block 120° Form 1
22253	2	Delta block 120° Form 2
22256	2	Delta block 120° Form 3
23240	80	Lock
23225	6	Kombi bolt M6
23228	10	Twin bolt for bar 1D
23223	40	Twin bolt
21500	10	Bolt, shortened for thread

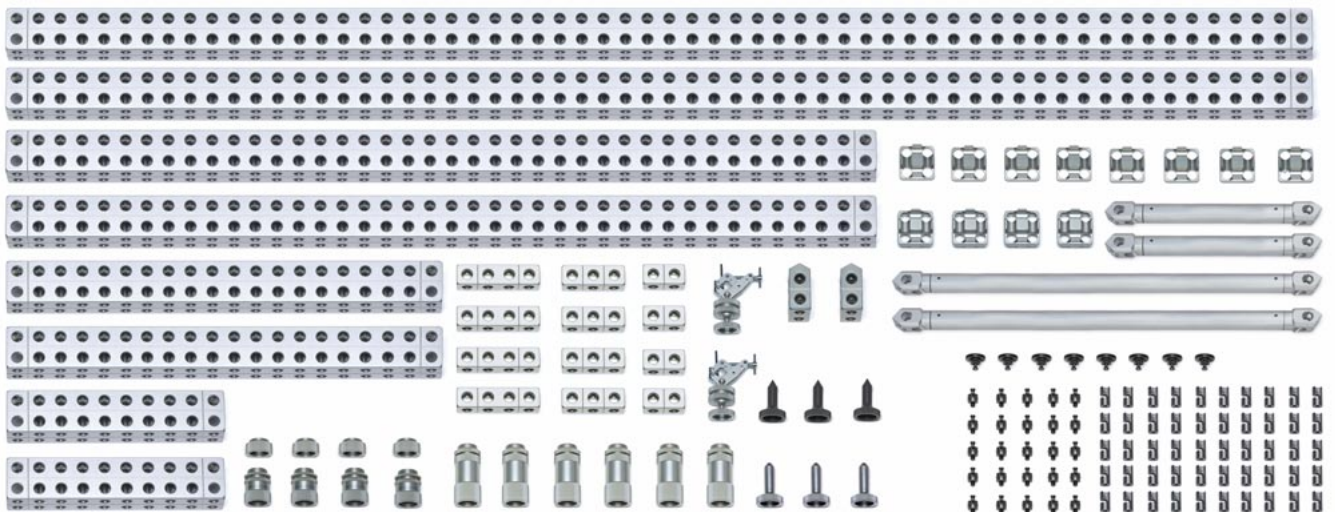
Nr.	Qty.	Name
25743	8	Combi bolt shortened
81493	2	Tools (10-pcs)
21385	40	Positioning sleeves
80701	30	Connection element M6
82139	6	Screw-jack h38-50
20628	6	Screw-jack extension 6mm
23286	6	Screw-jack extension 12mm
23239	10	Bolt disk
23241	5	Bolt disk
21644	3	Center, short
21646	3	Center, long 50
21648	2	Center, long 70
80584	4	Center with ball
80733	3	V Block 120° with ball joint
80927	3	Knife V 120° with ball joint
80941	4	Magnetic holder with ball joint
81212	3	Autocenter
82252	3	Autocenter
81112	2	Stop and support 180°
81113	2	Stop and support 90°
81111	3	C clamp adjustable
80925	3	Screw clamp with ball joint
22644	3	Spacer
22647	2	Cross over male/male
22258	10	Hold down spring
22260	5	Hold down stud
22263	5	Hold down stud
22268	5	Traverse holder for stud
80743	2	Winder
22275	2	Deflector
80924	1	Screw clamp with joint
80604	2	Base for toggle clamp



**#90283 Extension Set 1**  
Alufix 25 Light (97-pcs), 17 kg

Nr.	Stück	Name
20426	2	Bar Light 50x50x150
22949	2	Bar Light 50x50x250
22950	2	Bar Light 50x50x500
22951	2	Bar Light 50x50x1000
22952	2	Bar Light 50x50x1500

Nr.	Stück	Name
23330	4	Coupling, double
23325	8	Coupling, single
23240	50	Lock
23223	25	Twin bolt

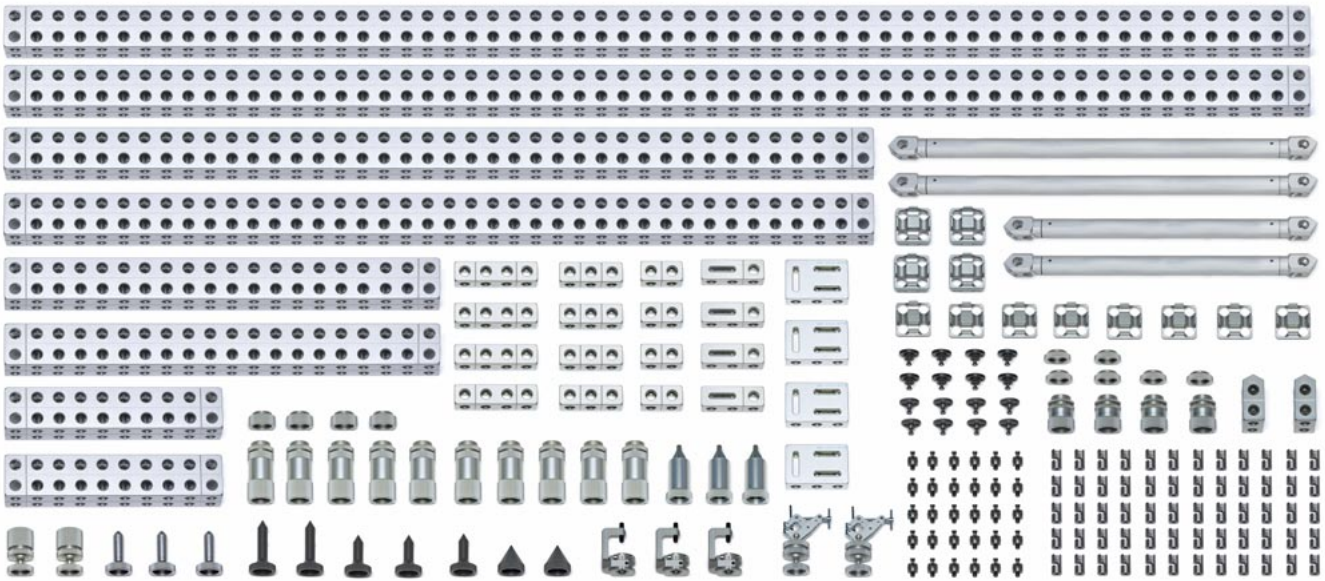


**#90284 Extension Set 2**  
Alufix 25 Light (143-pcs), 21 kg

Nr.	Qty.	Name
21373	4	Bar 25x25x50
21374	4	Bar 25x25x75
21375	4	Bar 25x25x100
22949	2	Bar Light 50x50x250
22950	2	Bar Light 50x50x500
22951	2	Bar Light 50x50x1000
22952	2	Bar Light 50x50x1500
23330	4	Coupling, double
23325	8	Coupling, single
81444	2	Strut 25x25x250
81327	2	Strut 25x25x500

Nr.	Qty.	Name
22256	2	Delta block 120° Form 3
23240	50	Lock
23223	25	Twin bolt
82139	4	Screw-jack h38-50
82033	6	Screw-jack h70-105
23286	4	Screw-jack extension 12mm
23239	8	Bolt disk
21646	3	Center
80584	3	Center with ball
80925	2	Screw clamp with ball joint





### #90285 Extension Set 3

Alufix 25 Light (209-pcs), 24,5 kg

Nr.	Qty.	Name
21373	4	Bar 25x25x50
21374	4	Bar 25x25x75
21375	4	Bar 25x25x100
22949	2	Bar Light 50x50x250
22950	2	Bar Light 50x50x500
22951	2	Bar Light 50x50x1000
22952	2	Bar Light 50x50x1500
23330	4	Coupling, double
23325	8	Coupling, single
23233	4	Bar 1D
23232	4	Base plate 2D
81028	2	Double knuckle
81445	2	Strut 25x25x375
81329	2	Strut 25x25x750
22256	2	Delta block 120° Form 3
23240	60	Lock

Nr.	Qty.	Name
23223	30	Twin bolt
23228	10	Twin bolt for bar 1D
82139	4	Screw-jack h38-50
82033	10	Screw-jack h70-105
20628	6	Screw-jack extension 6mm
23286	4	Screw-jack extension 12mm
23239	8	Bolt disk
23241	8	Bolt disk
21644	2	Center, short
21646	3	Center, long 50
21648	2	Center, long 70
80584	3	Center with ball
80941	4	Magnetic holder with ball joint
82252	2	Autocenter
81111	3	C clamp adjustable
80925	2	Screw clamp with ball joint

ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering.  
Other colors on request.



**Workstation, metal, lockable**  
with drawers, suitable for Basic Sets 6 and 7

Nr.	Width	Height	Depth	Kg.
282562	570	780	960	85

Storage of Alufix components in 6 clearly laid out, spacious and fully extendable drawers, also suitable for Alufix 40 Bars 80x80. Two top drawers are equipped with inlays for small components. Lower drawers equipped with non-slip mats.

Load capacity per drawer 75 kg.



**Workstation, metal, lockable**  
with drawers and storage compartment, suitable for Basic Set 9 and extension sets

Nr.	Width	Height	Depth	Kg.
282727	570	780	1030	88

Storage of Alufix components in 6 clearly laid out, spacious and fully extendable drawers, also suitable for Alufix 40 Bars 80x80. Additional storage compartment mounted at rear for safe storage of long bars and profiles 50x50.

Two top drawers are equipped with inlays for small components. Lower drawers equipped with non-slip mats.

Load capacity per drawer 75 kg

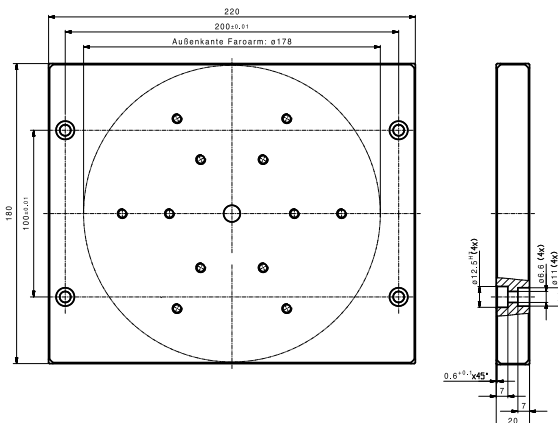


**Storage compartment for workstations**  
for storage of long bars 50x50

Nr.	Width	Height	Depth	Kg.
51753	480	660	68	-

Storage of long bars in 6 pockets.

Assembly on rear of workstation with M8 screws included in supply.



As accessory for mobile measuring units:

**Adapter plate for mobile measuring arms**

Nr. 91487

Incl. connection elements to mount on mobile measuring units. Further adapter plates available on request

### Mobile measuring and storage unit With gridded precision plate and drawers

Suitable as assembly platform and fixture base,  
with grid base plate 800x1200mm, grid 100mm,  
grid holes D12,5/M6.

Nr.	Wigth	Height	Depth	Load capacity	Kg.
284751	1200	930	800	170 Kg	130

- 4 drawers 50 mm
- 2 drawers 75 mm
- 1 drawer 100 mm
- 1 drawer 150 mm
- 4 swivel castors, 2 with brake
- Grid plate anodized black on request
- Grid plate with optional with other grid / sleeves



### Mobile measuring and storage unit With gridded precision plate and drawers

Height adjustable, also suitable as assembly  
platform and fixture base, with grid base plate  
800x1200mm, grid 100mm, grid holes D12,5/M6.

Nr.	Width	Height	Lift	Deptj	Load cap.	Kg.
284452	1200	930	180	800	170 Kg	140

- 4 drawers 50 mm
- 2 drawers 75 mm
- 1 drawer 100 mm
- 1 drawer 150 mm
- 4 swivel castors, 2 with brake
- Grid plate anodized black on request
- Grid plate with optional with other grid / sleeves



### Mobile measuring and storage unit XL With gridded precision plate and drawers

Suitable as assembly platform and fixture base,  
with grid base plate 1600x1200mm, grid 100mm,  
grid holes D12,5/M6.

Nr.	Width	Height	Depth	Laod cap.	Kg.
285101	1200	930	1600	300 Kg	250

- 8 drawers 50 mm
- 4 drawers 75 mm
- 2 drawer 100 mm
- 2 drawer 150 mm
- 6 swivel castors, 2 with brake
- Grid plate anodized black on request
- Grid plate with optional with other grid / sleeves





## Vacuum base

Item number: 282446B-1

This universally applicable vacuum plate forms the basis for mounting measuring arms. A battery-operated miniature pump creates a vacuum in seconds so that the plate is "sucked down".

Monitoring displays, control lights and pressure switches ensure a firm and secure stand. Adaptations on the top enable the quick and secure attachment of measuring arms of known brands.

The Witte Vacuum Base does not require any additional units. A vacuum pump, signaling devices, function and monitoring devices are integrated in the compact design.

This enables use in locations far away from any energy supply. A special double lipped seal also allows use on curved surfaces and expands the range of applications possible uses in many ways.

Pre-machined connection options for measuring arm adapters from various manufacturers enable the mounting of special adapter rings.

Dimensions: 260 x 80 mm

Weight: 3,7 Kgs

Clamping force:  
maximal 4200 Newton at sea level

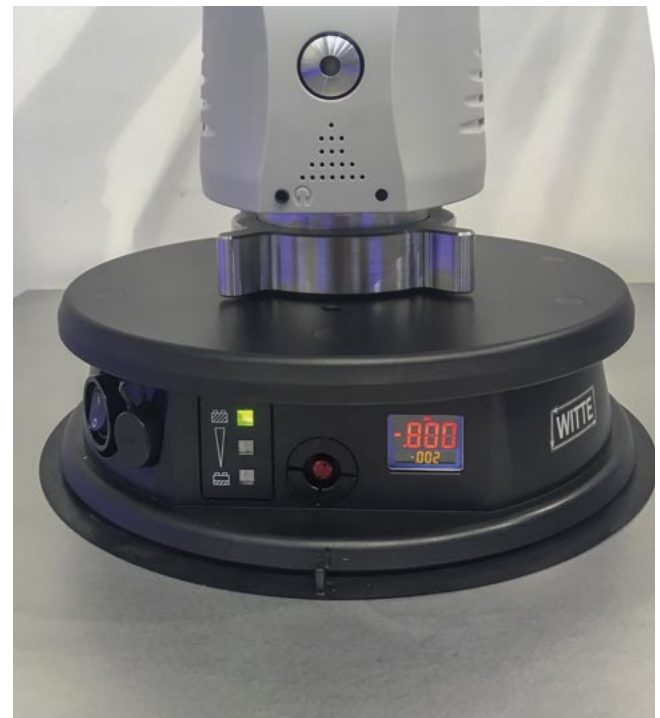
Battery Charger\*: 100 to 240 volt

Battery pack\* power: 12 volt  
Light diodes indicate energy supply.

Should the battery level drop below the safe operating level then a signal will warn the operator.

End vacuum is adjusted to 200 mbar which equals 80%.

(\*): Parts are included in delivery .



## FIXMES

### Alufix and TopPos parts library for CAD systems

Fixmes is an Alufix parts library on a geometric basis for designing and documenting fixtures. Using Alufix standard elements fixtures can be built in a fraction of the time required previously. By designing the fixture on-screen expensive idle-times of the measuring machine are avoided.

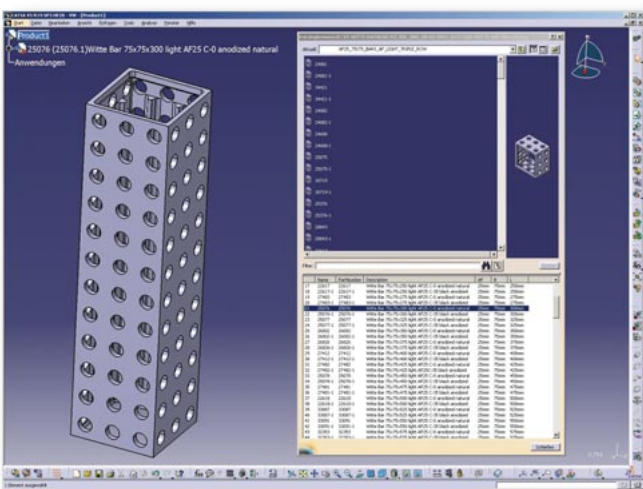
The principle: at the CAD workplace the user designs a desired fixture for workpiece machining or measuring using Alufix components. To do so he can use all parts available in the Fixmes library.. The selection is made according to one of the following features:

- Item No.
- Name
- Dimension

The parts of the fixture can be displayed as a wire model or solid. For a clearer image and an increase in speed individual planes or elements (holes) can be excluded. A printout of the finished fixture includes a parts list.

The advantages:

- Shorter design times
- Better prolonged use of measuring machine
- Timely preparation of fixture
- Documentation for later repeat assembly of fixture
- Short term changes can be carried out quickly
- No training necessary,
- CATIA or AutoCAD functions are utilised
- Also for off-line programming



**83677 Fixmes Library für Catia V5**  
Elements of Alufix modular fixturing system are stored as \*.catpart and \*.catproduct files.

In addition a CATIA catalogue with parameterized parts is available on request. Elements can be selected according to different criteria such as item number, description or dimensions.

**92562 Fixmes Library für Unigraphics NX5**  
Alufix elements stored with attachment \*.prt

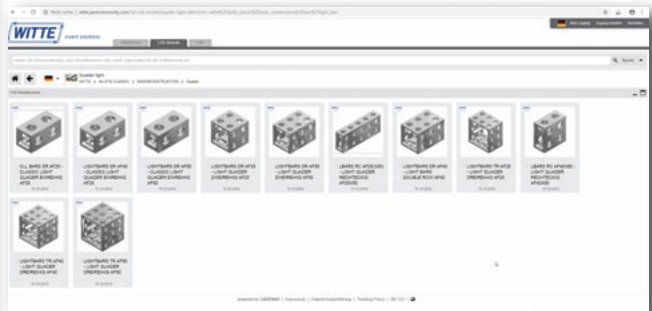
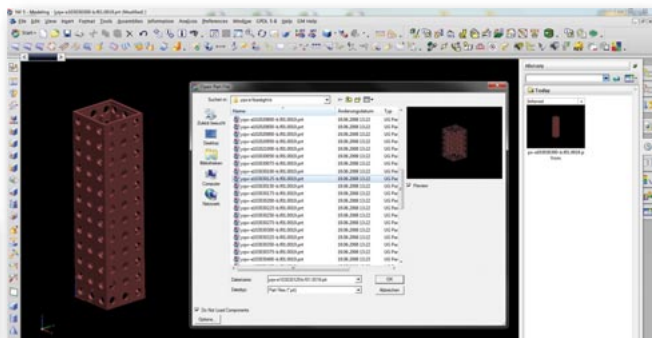
**83676 Fixmes Library for AutoCAD**  
Alufix elements stored with attachment \*.dwg

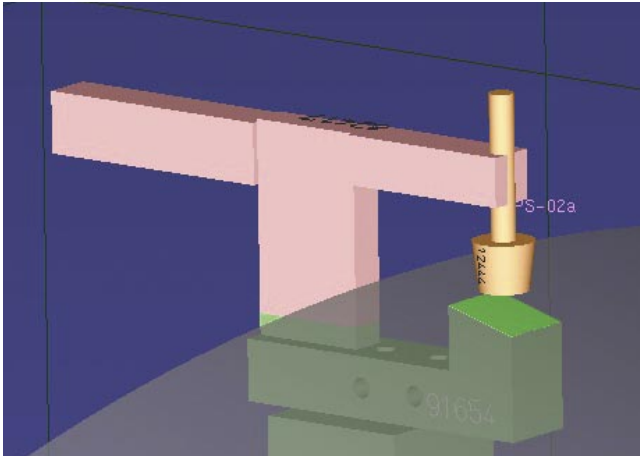
**82157 Fixmes Library IGES Format**  
Alufix elements stored with attachment \*.igs

**82662 Fixmes Library STEP Format**  
Alufix elements stored with attachment \*.stp.

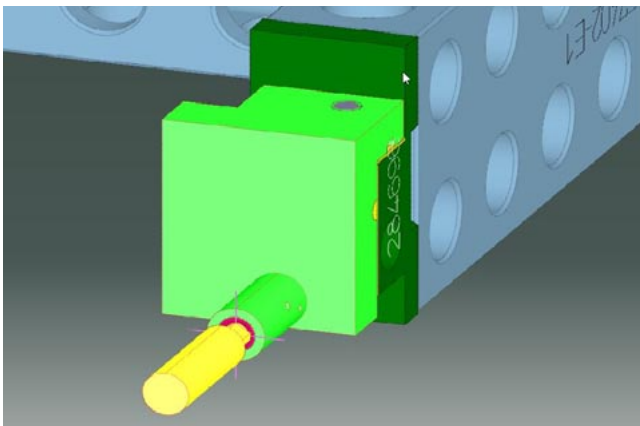
In addition we also offer a download service from internet under: [www.partserver.de](http://www.partserver.de)

After registration Alufix components can be downloaded free of charge in all native or universal formats under this address.





Surface cut for contour blocks



Individual contour block design

## ALUFIX Experte

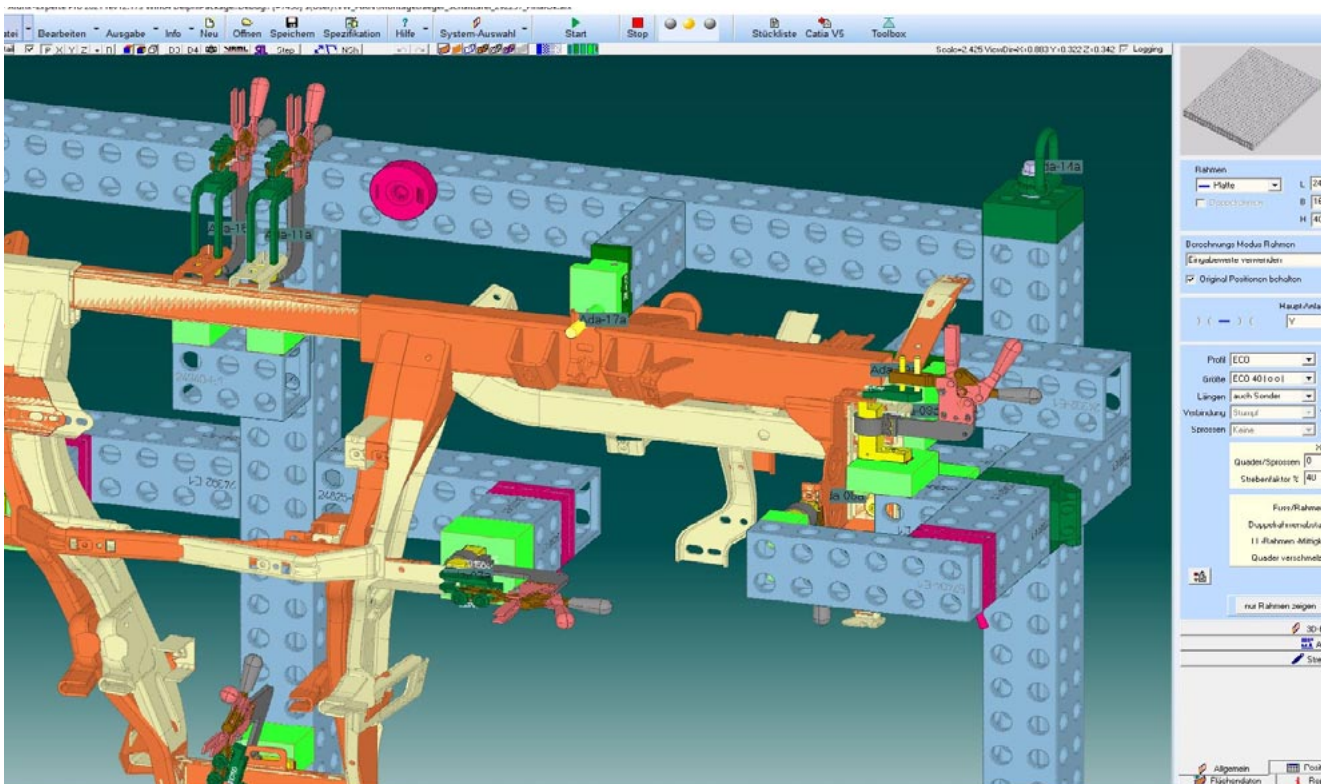
### 3D Design Software #85344

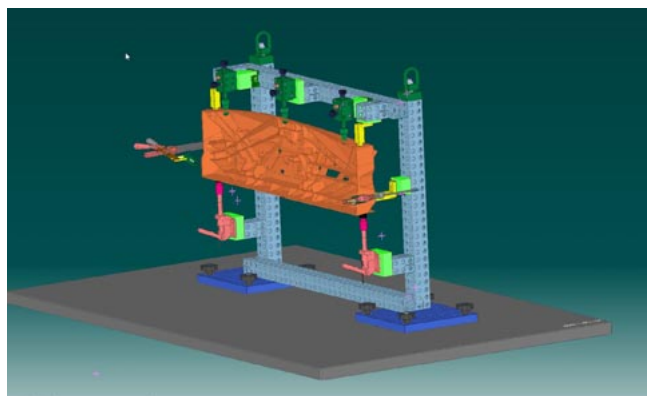
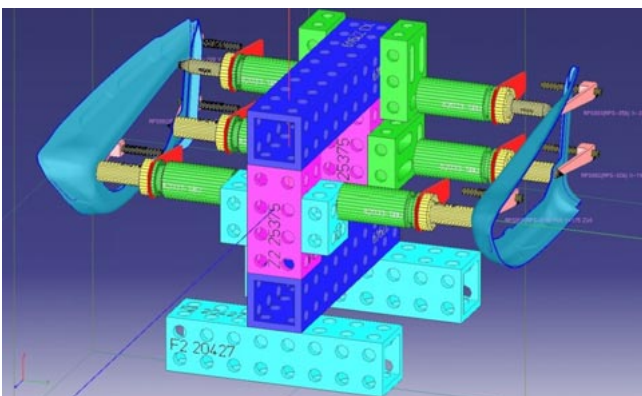
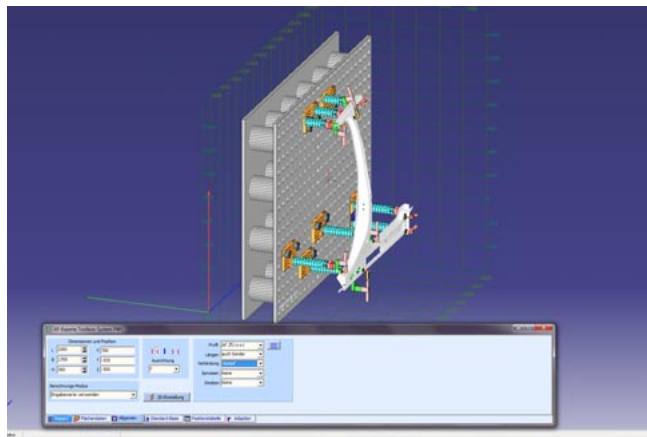
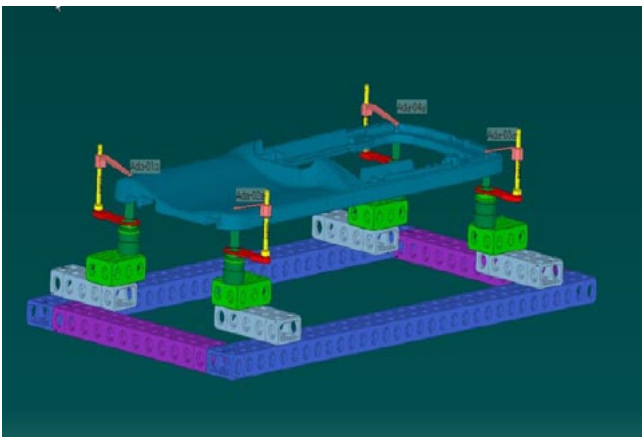
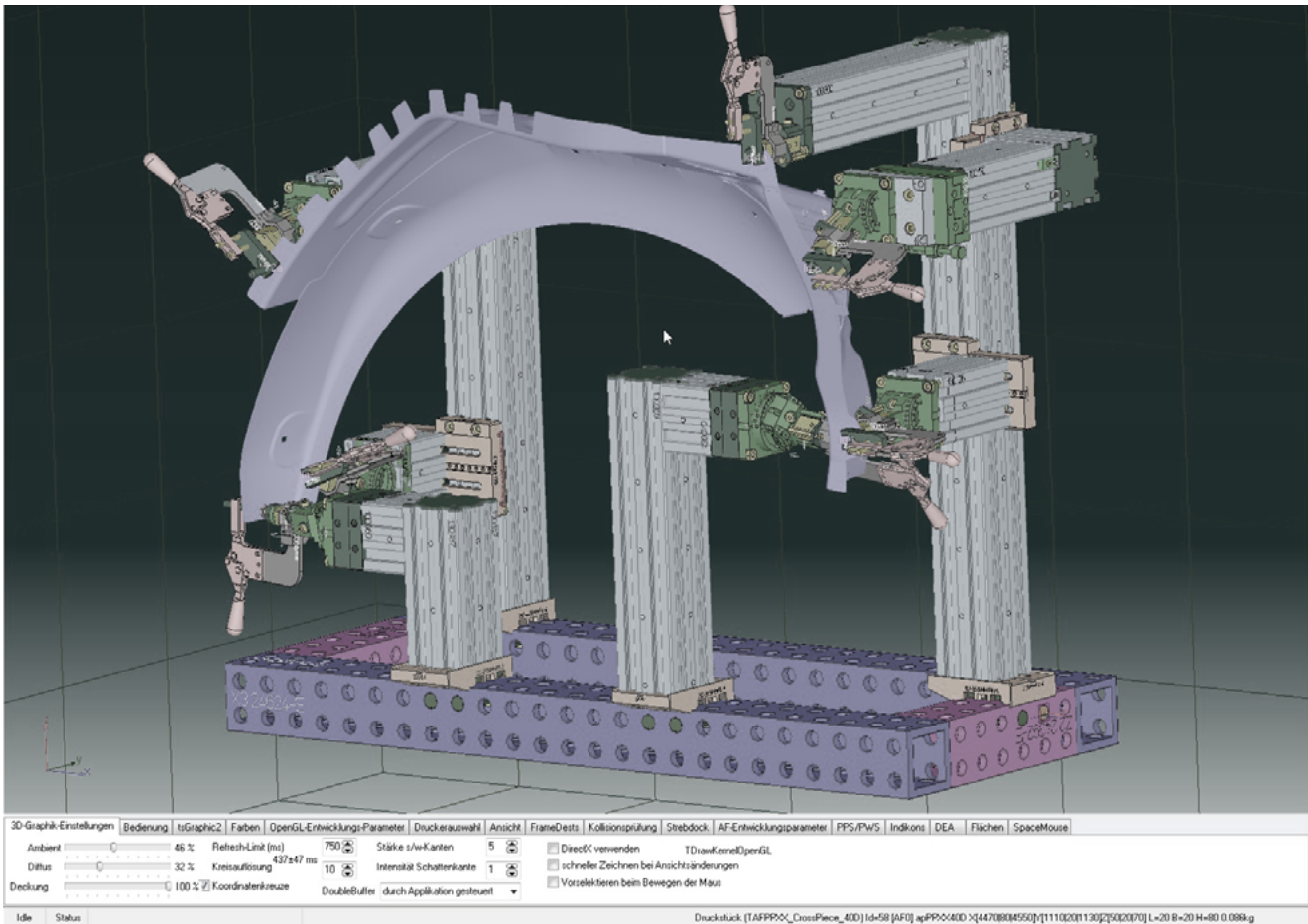
Alufix Expert software makes automatic designs for fixtures with corresponding partlists.

You choose the Alufix /TopPos system and define clamping points. The software calculates on the basis of this information complete solutions and variations of a fixture. Simply select the desired Alufix system, the basic type of build (frame or plate), the grid size and the position and function of clamping points.

On the basis of this input the software calculates complete solutions and variations. For checking purposes and measuring off of surface vectors additional part data in all established formats can be imported.

Pictures show some variations, which have been calculated by the software. The clearly structured, self-explaining software is easy to learn. Two separate but complementing help functions (Tool tips and Operation Manual) support users at all times. The design data is exported in either IGES, STL or VRML format (i.e. for offline programming of coordinate measuring machines), or can be transferred with a macro and the corresponding parts library in Catia V4/V5, Unigraphics or Auto-cad.






# Complementary range for fixture building

## Contents

Page	Chapter
143	Column variations
144	Column connection
146	Column connection PPS
148	Column connection PWS
150	Clamp units
151	Contour blocks
152	Hook clamps
156	Fold up and swivel Castors
158	Reference balls



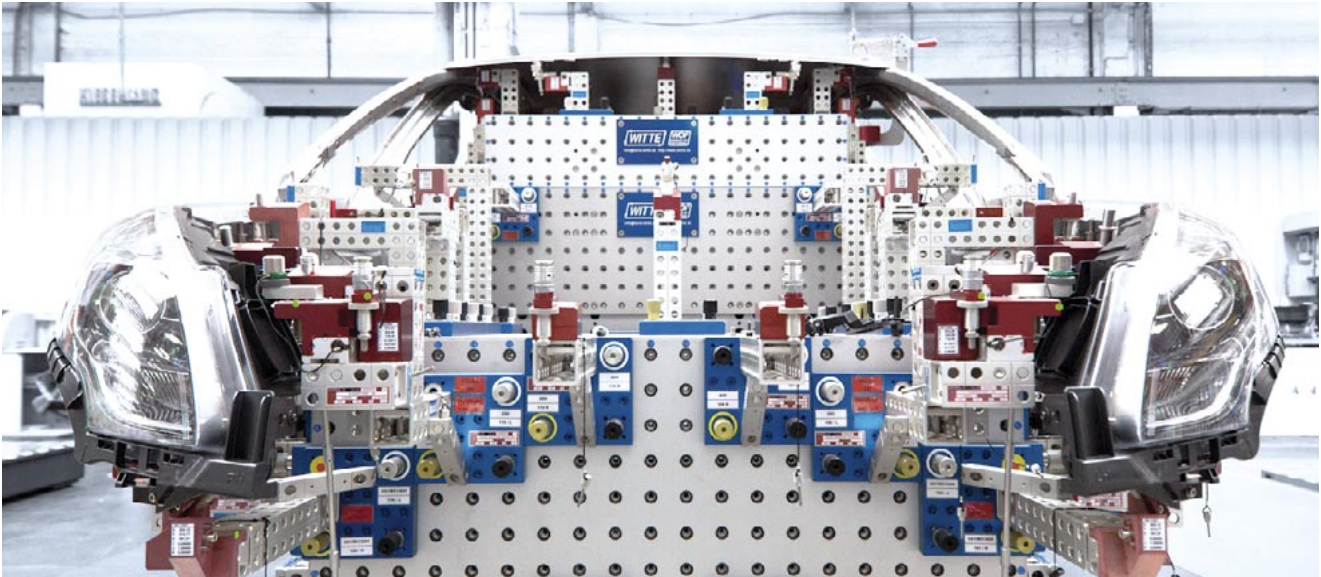
Structure plates from the Witte FixBase® range are ideally suited as a base for column type fixture design.

These extremely robust plates in sandwich style have been consistently further developed for years and are available with different grids, horizontal, vertical, mobile, rotatable and height-adjustable - right up to autonomous models with safety features.

Further information can be found in the Witte FixBase® brochure.







## Column variations

for use on grid base plates or structure plates

Combining a grid plate (conventional or structure type) with exchangeable columns offers following advantages:

Use of one base for user-defined assembly of various workpieces, different assembly degrees of parts (single parts, welded groups, assemblies) different derivatives, match metal function.

Considerably less storage space is required in comparison with complete fixtures.

Comprehensive accessories such as multi level trolleys, foldable, stationary or mobile storage stations and tables are available for storing column supports.

Advantages:

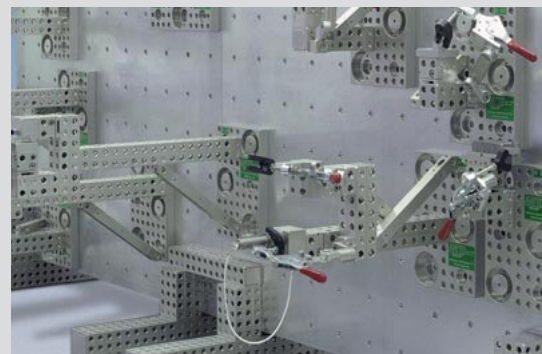
Multiple use of column supports is possible on different base plates or in different departments. Pre measuring of supports on small measuring equipment is possible.

Different types of connection: Fitted screws, PPS (centering bolt and bayonet lever), PWS (clutch bolt with centering pin).

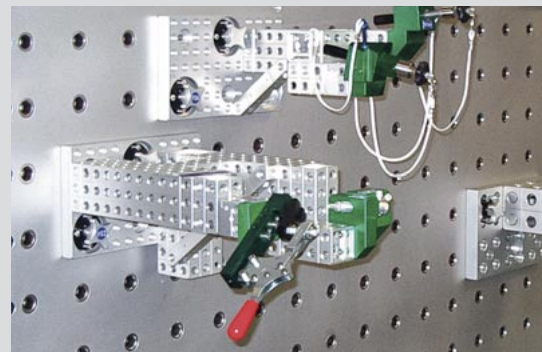
Optional footplates for Classic or Eco bars or simple footplates for Megalu columns are available.

The columns can be used for further functions or contact points by using folding or quick change couplings.

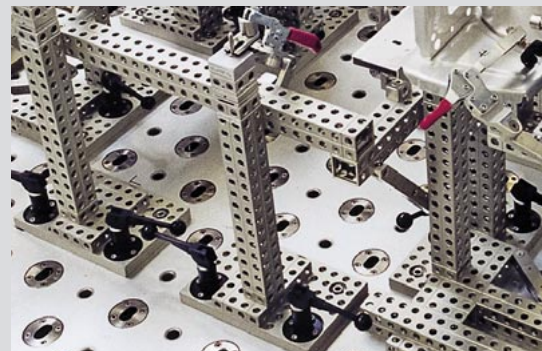
Extra long bars on columns are supported by angled struts or connected to each other using cross bars.



Columns mounted using fitted screw connection



Columns mounted using clutch bolt (PWS)



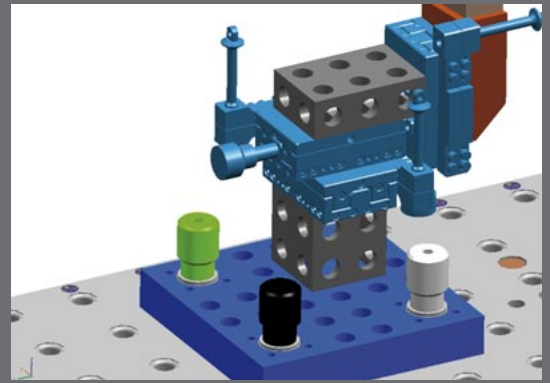
Columns mounted using bayonet clamps (PPS)

### Column connection

with fitting screws for basic grid holes

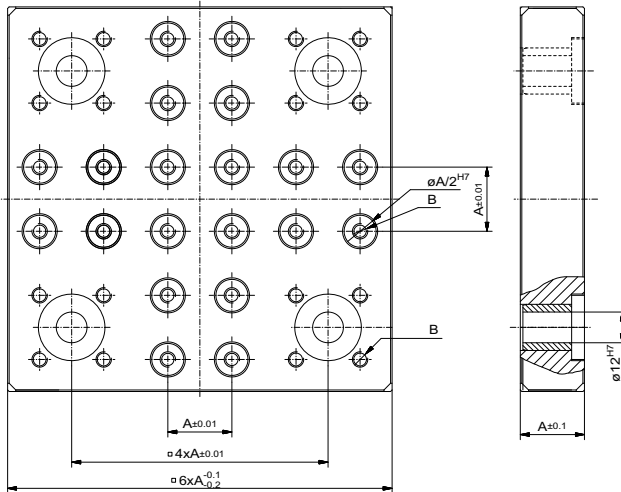
Simple and proven version.  
Two types of locators are available:

- Snug fit, floating (xy positioning)
- Without fit (only clamping)



### Footplate

150x150, AF 25/50

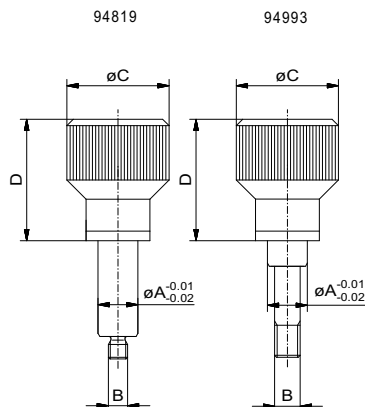


Nr.	A	B	C	⊗
289356	25	M6	ø12 H7	1.500



### Lock pin

Types I + II for footplate 304231



Nr.	A	B	C	D	Type	⊗
94819	12	M8	32	38	I	180
94993	10,5	M8	32	38	II	175

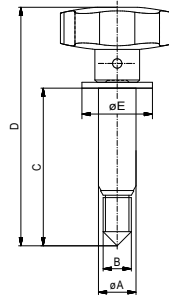


ALUFIX elements can be anodized in different colors.  
The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering.  
Other colors on request.

Plates are available in different dimensions and with different grids.  
Lock pins are available in different dimensions.

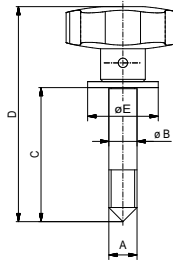
**Fitting screw**  
for plate or bracket with with positioning or  
excenter sleeves

Nr.	A	B	C	D	E		g
82342	ø16h6	M12	67	102	30		125
82225	ø16h6	M12	79,5	114	30		145
92488	ø15,98-0,02	M12	67	102	30		125
92489	ø15,98-0,02	M12	79,5	114	30		145

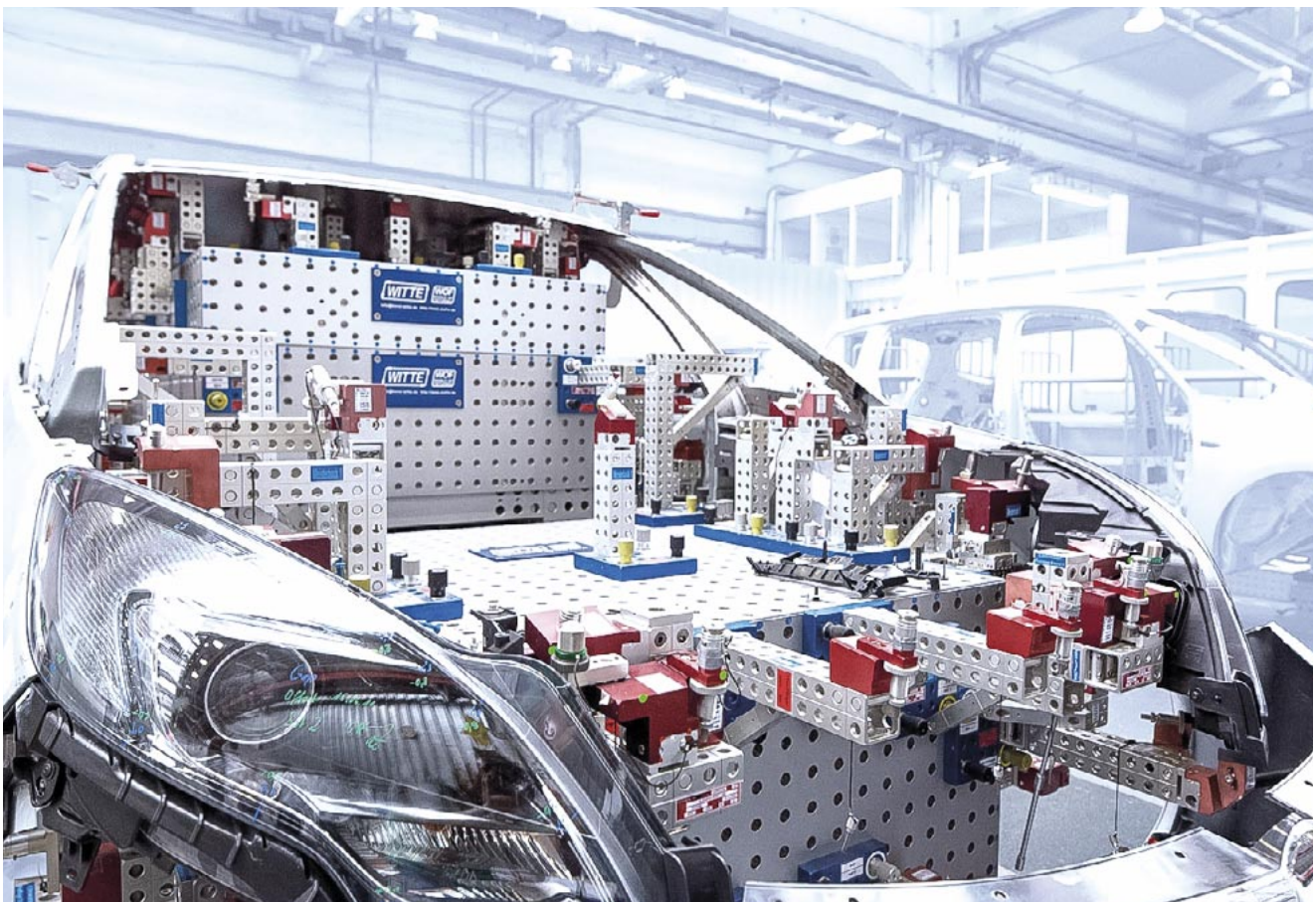


**Clamp screw**  
for plate or bracket with with positioning or  
excenter sleeves

Nr.	A	B	C	D	E		g
82343	M12	12	57	102	30		110
82341	M12	12	79,5	114	30		140



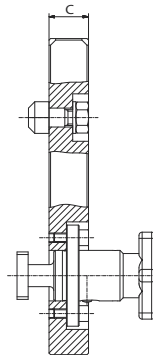
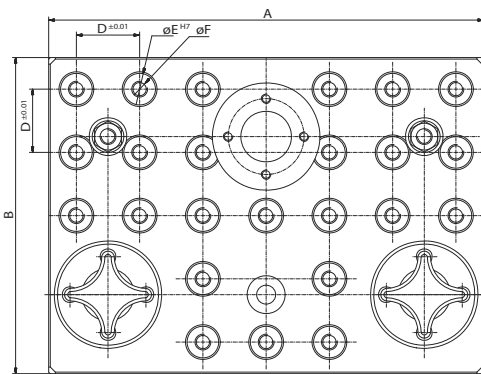
Other versions on request



### Column connection

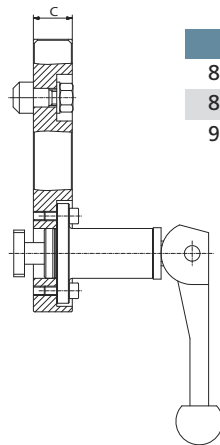
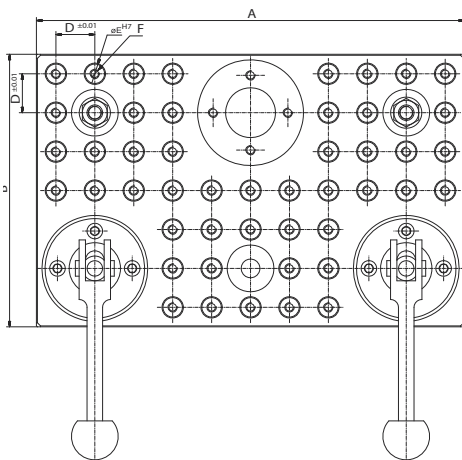
with Witte PPS quick clamp system

Separate positioning and fixation of footplates via centering pin and clamp units.



### Footplate for Witte PPS-System with star knob

Nr.	System	A	B	C	D	E	F	$\bar{g}$
93513	AF25	275	175	25	25	12,5	M6	3.300
93514	AF40	275	200	25	40	20	M10	3.740
93515	AF50	300	200	30	50	25	M12	5.100




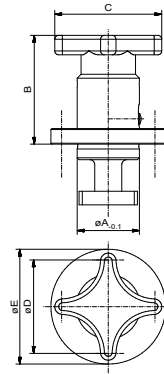
### Footplate for Witte PPS System with hand lever

Nr.	System	A	B	C	D	E	F	$\bar{g}$
84608	AF25	275	175	25	25	12,5	M6	3.950
84609	AF40	275	200	25	40	20	M10	4.400
91050	AF50	300	200	30	50	25	M12	5.560



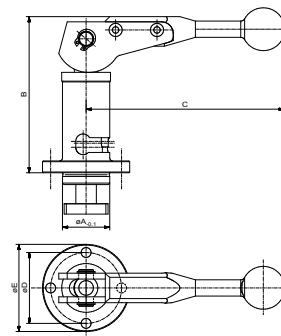
**Lock unit  
with star knob**

Nr.	A	B	C	D	E	
93444	32	56	55	48	59	280




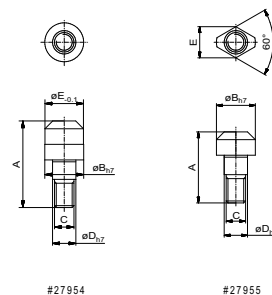
**Lock unit  
with hand lever**

Nr.	A	B	C	D	E	
82714	32	106	135	48	59	1.500



**Centering pin**

Nr.	A	B	C	D	E	
27954	44,5	20	M10	12	19,8	60
27955	36,5	20	M10	12	16	36



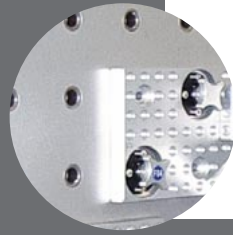
#27954

#27955

### Column connection

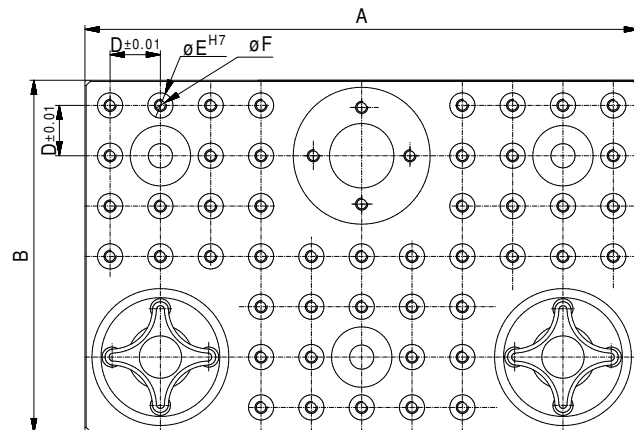
with Witte PWS quick clamp system

Expanding clutch bolt centers and clamps footplate on PWS grid or sandwich plate.

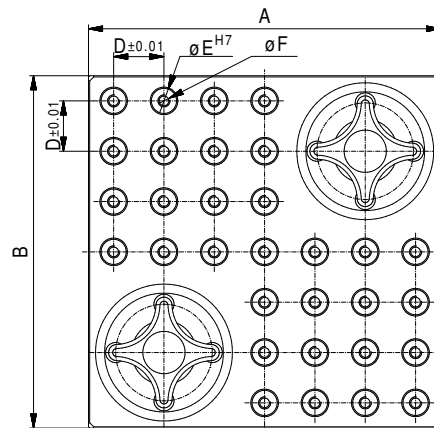
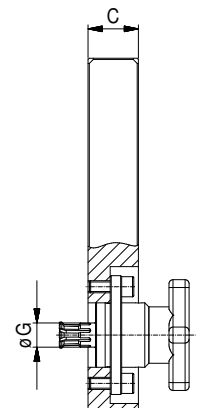


Footplate for Witte PWS System with expanding clutch bolt 45°

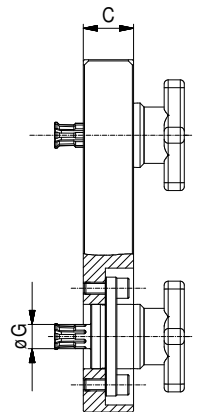
Nr.	Type	A	B	C	System/D	E	F	øG	h
93525	2	175	175	25	25	12,5	M6	12	2.280
93524	1	275	175	25	25	12,5	M6	12	3.050
92883	2	175	175	25	25	12,5	M6	20	2.370
92842	1	275	175	25	25	12,5	M6	20	3.080
92950	2	200	200	25	40	20	M10	20	3.200
92843	1	275	200	25	40	20	M10	20	3.540
92844	1	300	200	30	50	25	M12	20	4.840



Type 1




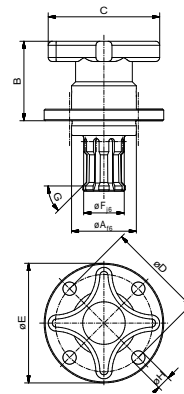
Type 2



ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.

### Expanding clutch bolt with star knob

Nr.	A	B	C	D	E	F	G	H	
93523	32	39	55	48	59	12	45°	6,7	280
92755	32	39	55	48	59	20	45°	6,7	320
96109	32	39	55	48	59	20	30°	6,7	320

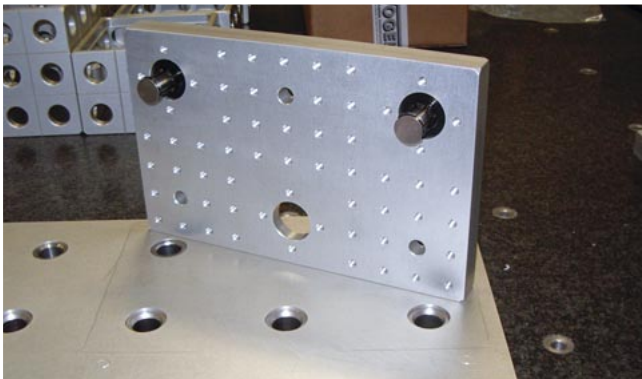


### Footplate without bolts or locks für Witte PWS-/PPS-System

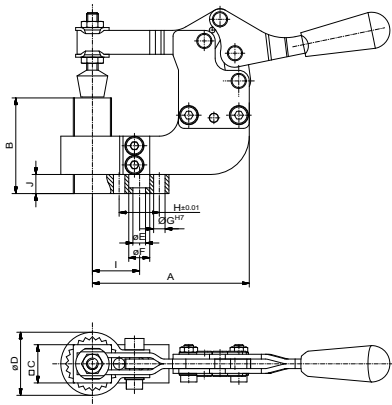
Nr.	System	Dorn- $\phi$	Type	Base for Nr.	
				PWS	PPS
27958	25	12 bzw. 20	1	93524 bzw. 92842	93513
51561	25	12 bzw. 20	2	93525 bzw. 92883	-
29375	40	20	1	92843	93514
51606	40	20	2	92950	-
33747	50	20	1	92844	93515



Drawing see page 148.

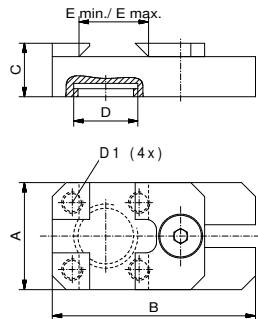


Underside of PWS footplate



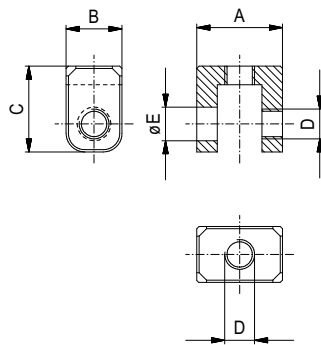
**Clamp unit with ratchet grip**  
spacing 15°, for toggle clamp 217 UBL, with surface contact 20

Nr.	A	B	C	D	E	F	G	H	I	J	Pressure fork.#	⊗	
282000	112	50	20	33	6,6	11	6	21	24,7	10	./.	⊗	200
282001	87	50	20	33	6,6	11	6	21	24,7	10	./.	⊗	200
282003	112	70	20	33	6,6	11	6	21	24,7	10	./.	⊗	220
282004	87	70	20	33	6,6	11	6	21	24,7	10	./.	⊗	220
282005	112	70	20	33	6,6	11	6	21	24,7	10	357582	⊗	240
282006	112	50	20	33	6,6	11	6	21	24,7	10	357582	⊗	240
282007	112	50	20	33	6,6	11	6	21	24,7	10	357578	⊗	250
282008	112	70	20	33	6,6	11	6	21	24,7	10	357578	⊗	250



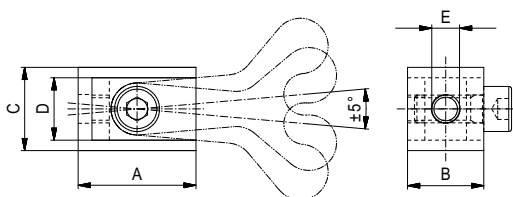
**Base**  
for toggle clamp M24x1

Nr.	A	B	C	D	D1	E min.	E max.	⊗
80604	40	76	20	M24x1	M8	26	44	133



**Foot for pressure fork**

Nr.	A	B	C	D	E	⊗
87590	23	15	23	M8	9	25



**Foot for pressure fork**  
limited angle


Nr.	A	B	C	D	E	⊗
89931	34	22	24	18	M8	50

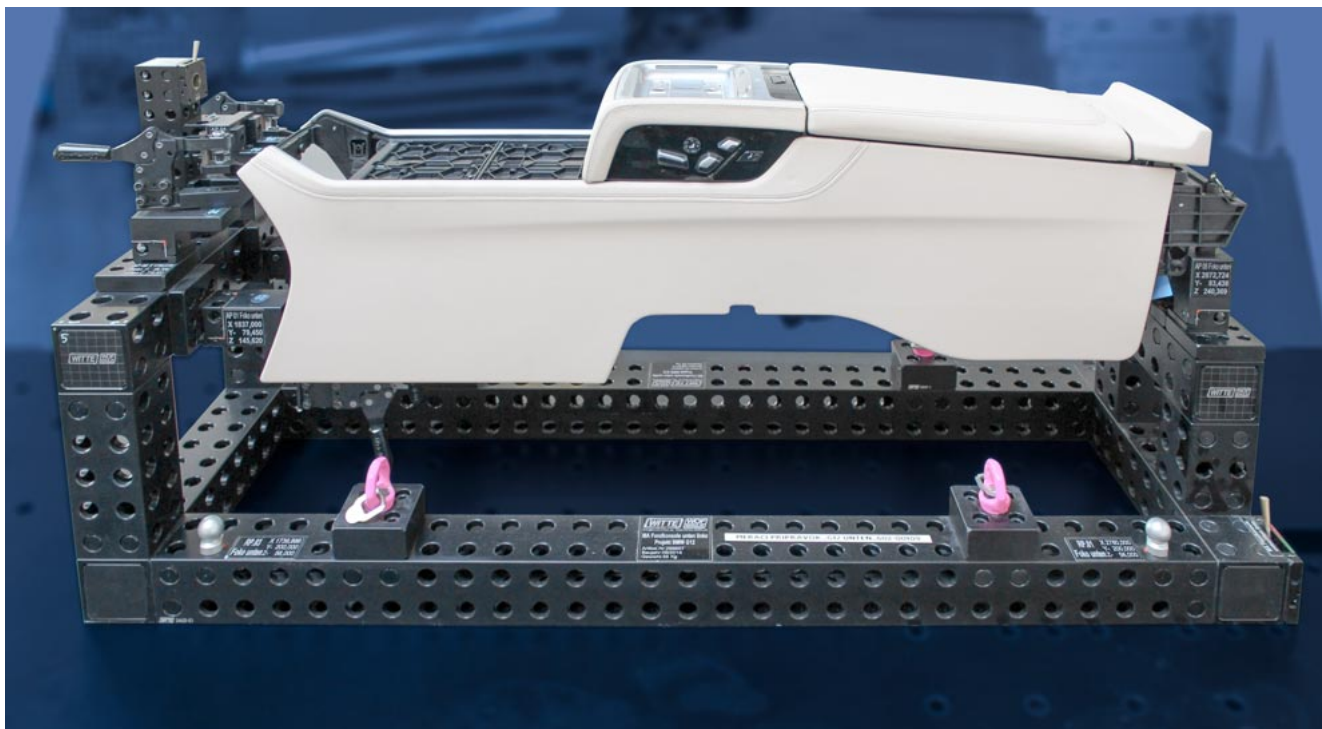
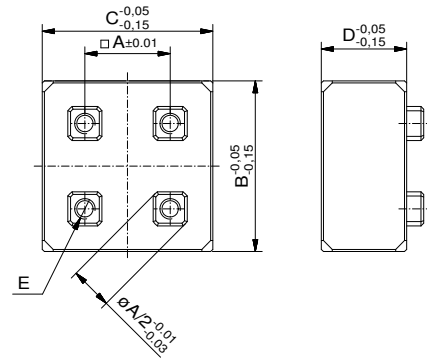




**Contour block**

Preforms without surface protection,  
Alufix 25 / 40 / 50

Nr.	A(AF)	B	C	D	E	
23366	25	25	25	25	M6	45
23367	25	25	50	25	M6	89
23368	25	50	50	25	M6	179
23617	25	50	75	25	M6	268
25312	25	25	50	50	M6	179
23369	25	50	50	50	M6	358
25314	25	50	75	50	M6	536
23618	25	100	100	50	M6	1.430
23630	40	40	40	40	M10	183
23631	40	40	80	40	M10	366
23632	40	80	80	40	M10	732
23633	40	80	120	40	M10	1.098
25313	40	40	80	80	M10	732
23634	40	80	80	80	M10	1.464
25315	40	80	120	80	M10	2.196
23635	40	160	160	80	M10	5.857
28049	50	50	50	50	M12	358
28050	50	50	100	50	M12	715
28051	50	100	100	50	M12	1.430
28052	50	100	150	50	M12	2.145
27537	50	50	100	100	M12	1.430
28053	50	100	100	100	M12	2.860
27367	50	100	150	100	M12	4.290
28054	50	200	200	100	M12	11.440



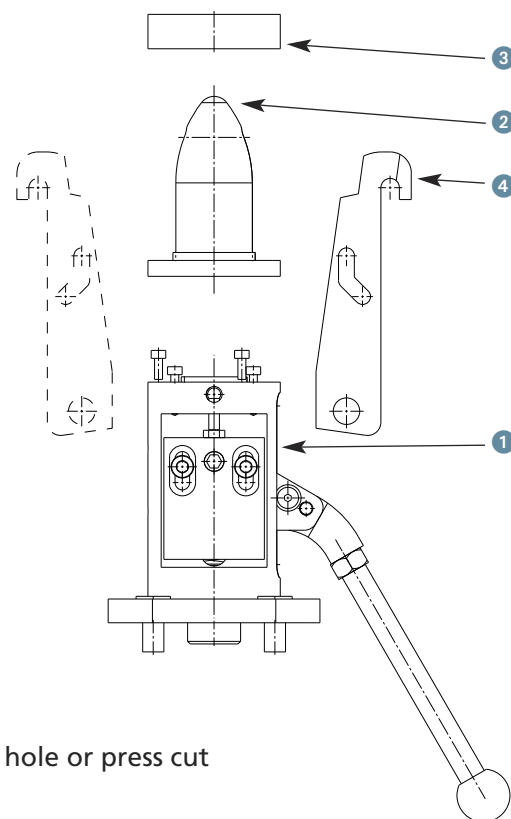
**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"

## ALUFIX Hook clamps

Hook clamps are used when workpieces are positioned using holes and simultaneously clamped.

Further they are suitable for clamping points, which are so far away from workpiece edges that they are unreachable using toggle clamps.

Operation is by hand, hydraulic or pneumatic.



### How to order:

Hook clamps are individually manufactured for every hole or press cut and comprise of four parts:

- ① Basic unit
- ② Top pin
- ③ Support ring
- ④ Hook (optional two hooks)

When ordering a hook clamp please attach a drawing or data of the support with details on centre pin diameter and the shape of the hole (round or slot).

Further we need details of clearance behind the hole, metal thickness, collar height and direction in which part has been stamped.

When ordering basic unit please also state required hook size

See also our inquiry form under

[www.witte-barskamp.de/Catalogues and Brochures/Additional information on Hook Clamps](http://www.witte-barskamp.de/Catalogues%20and%20Brochures/Additional%20information%20on%20Hook%20Clamps)

## Hook Clamp Compact

Example dia 30

A	B	C	D	E	F	G	H	I	⊗
30	50	110	9	159	80	112	20	M8	1156

### 1 Hook Clamp Basic Unit compact

Nr.	for pin dia	⊗
281408	15-39	669

### 2 Top pin compact / compact mini

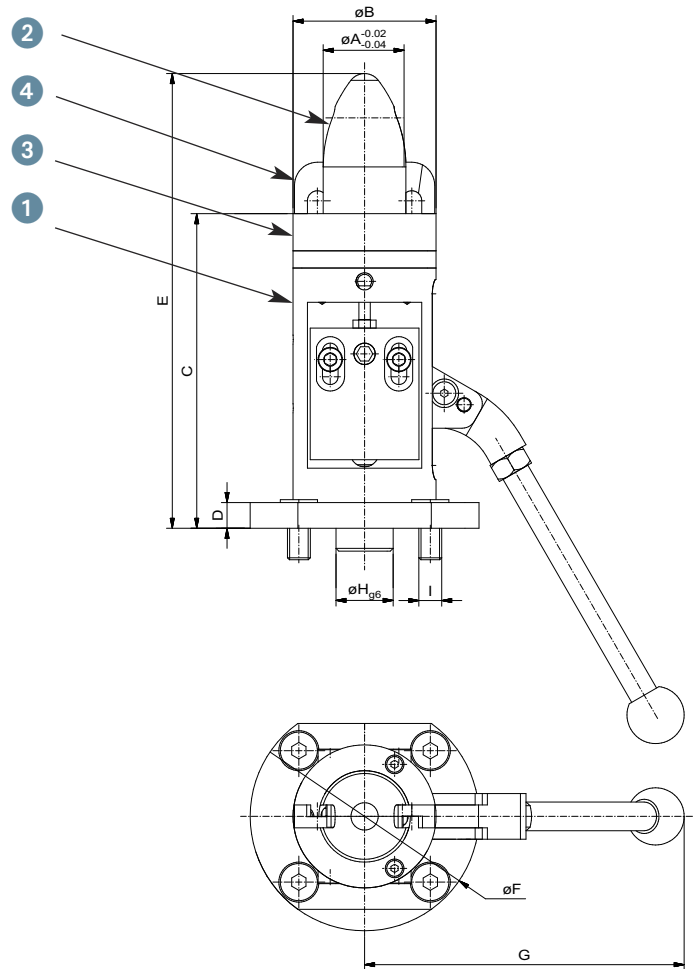
Nr.	pin dia	⊗
34389	15,0 <sup>-0,02mm</sup>	108
51512	20,0 <sup>-0,02mm</sup>	145
391436	25,0 <sup>-0,02mm</sup>	201
34388	30,0 <sup>-0,02mm</sup>	254
54120	40,0 <sup>-0,02mm</sup>	456

### 3 Support ring compact / compact mini

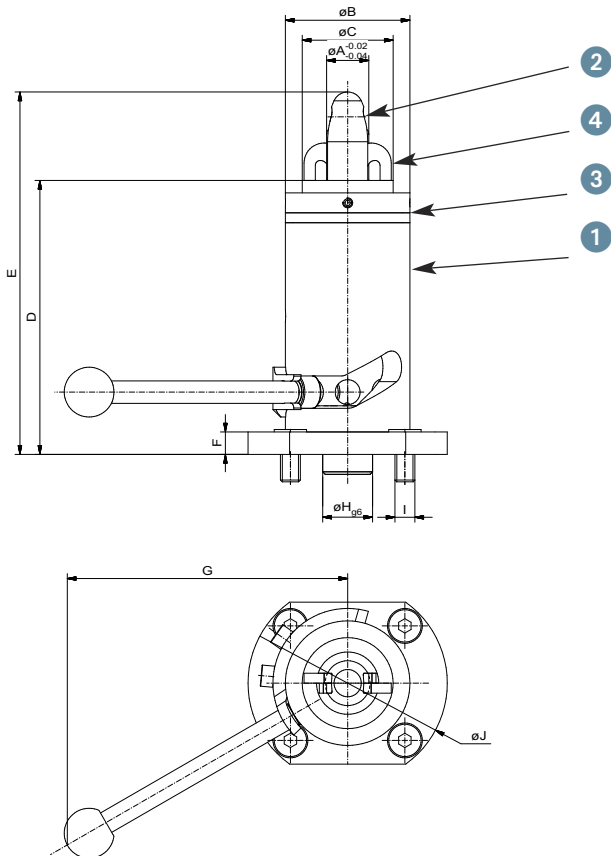
Nr.	Surface dia	⊗
53384	30 mm	106
56036	35 mm	112
26589	40 mm	128
390548	45 mm	106
26592	50 mm	110
33020	55 mm	152
397265	60 mm	182

### 4 Hook compact

Nr.	clamping width	⊗
30759	30 mm	80
394903	35 mm	88
28399	40 mm	94
30760	45 mm	100
28400	50 mm	122



Internal excenter lever, top pin and support ring are 100% compatible (outer dimensions same as existing hook clamps). Sideways activation possible via hex key.



**Hook Clamp compact flexible**

Example dia 30

A	B	C	D	E	F	G	H	I	J	Ⓜ
18	50	36,5	110	145,5	9	112	20	M8	80	991

**1 Hook Clamp Basic Unit compact flexible**

Nr.	Base height	Ⓜ
281886	110mm (low-standard)	700
281887	160mm (high)	1047

**2 Top pin compact flexible**

Nr.	pin dia	Ⓜ
306051	Ø18-0,02mm	159
306052	Ø20-0,02mm	169
309929	Ø25-0,02mm	199
306053	Ø30-0,02mm	245
304272	Ø40-0,02mm	410

**3 Ring compact / compact mini**

Nr.	surface dia	Ⓜ
311718	Ø30mm	88
311720	Ø35mm	98
306056	Ø40mm	104
311722	Ø45mm	101
306057	Ø50mm	116
311739	Ø55mm	100
304273	Ø60mm	145

**4 Hook compact flexibel**

Nr.	clamping width	Ⓜ
311717	30mm	26
306058	35mm	36
306059	40mm	38
306060	45mm	40
306061	50mm	46
311738	55mm	48
304274	60mm	50



Picture shows high base unit version #281887. Special lengths on request.

Tolerances in workpiece thickness of up to +/- 0,3mm are evened out. Fast adjustment according to workpiece thickness possible.

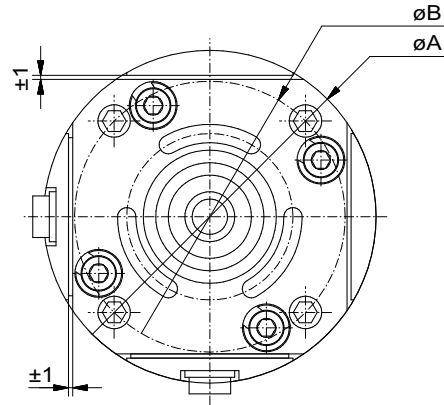
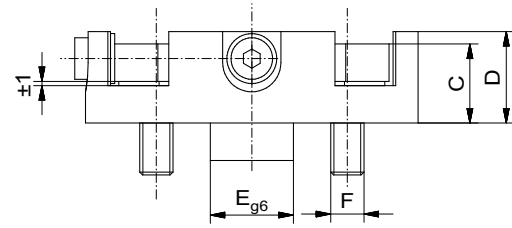
More space between operating lever and clamping surface = more freedom of movement and less part collision due to horizontal lever movement.

Hook alignment independent of lever orientation, infinite rotary movement 360°.

Support ring infinite rotary movement 360°

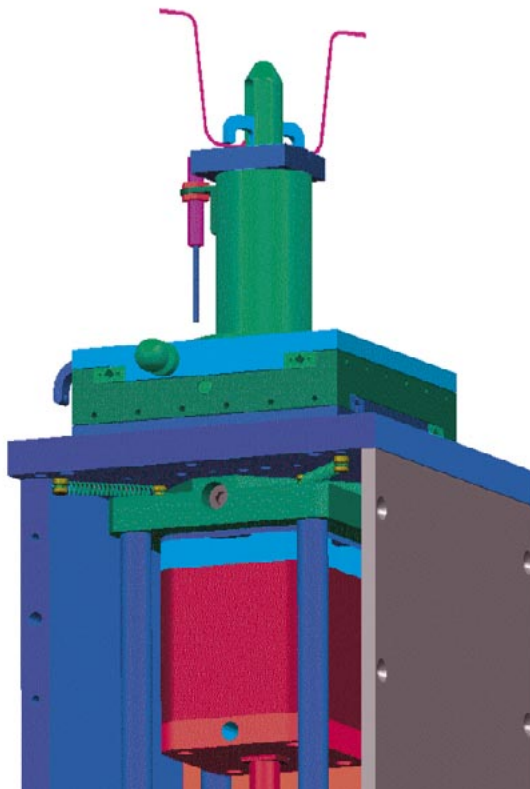
**Foot for hook clamps**  
xyz shimmable including shim foils

Nr.	A	B	C	D	E	F	g
281407	80	65	19	22	20	M8	286

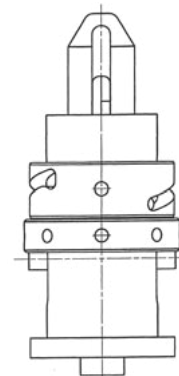


**Additional hook clamps**

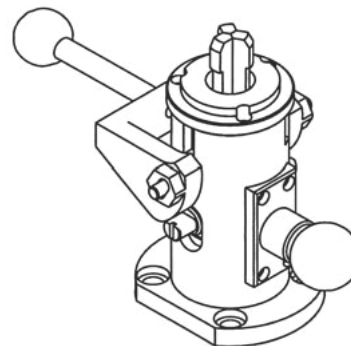
Previously supplied hook clamps are still available. Details and availability on request.



Pneumatisch betätigte Ausführung.  
Darstellung mit eingelegtem Werkstück.



Hook clamp with excenter movement and adjustment for workpiece thickness

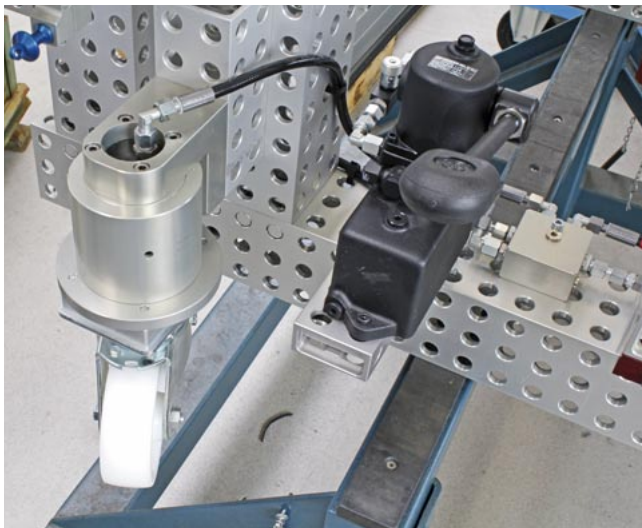
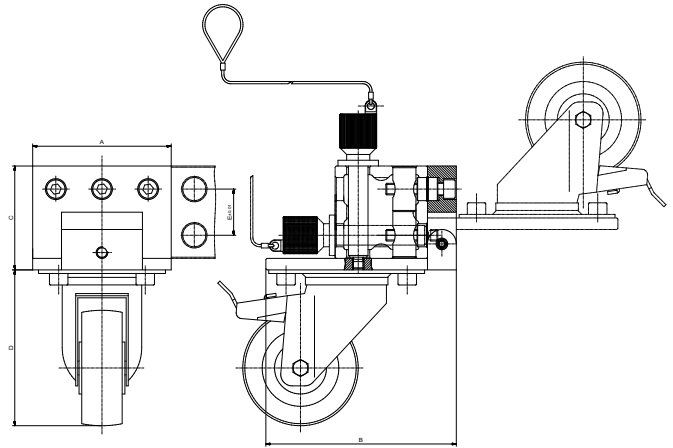


xyz hook clamp, self centering

**Castor, fold up single**



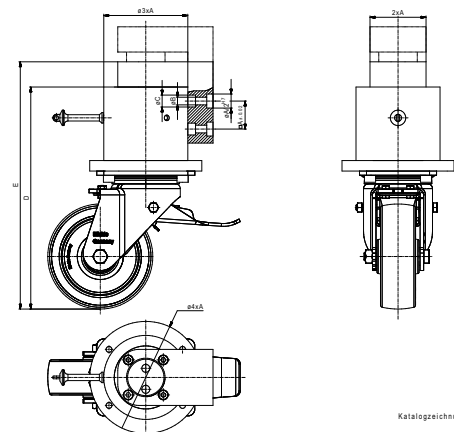
Nr.	System	Type	for Bar	A	B	C	D	E	⚖
93315	40	steerable	80x80	120	165	90	135	10	1.600
93399	40	fixed	80x80	120	165	90	135	10	1.600
92627	40	steerable	120x120	120	165	130	135	10	2.200
92628	40	fixed	120x120	120	165	130	135	10	2.200
92593	50	steerable	100x100	150	165	110	135	10	2.750
92594	50	fixed	100x100	150	165	110	135	10	2.750



**Castor Set**  
with hydraulic height adjustment, lift 50 mm.  
Set of four including pump.

Nr.	A	B	C	D	E	⚖
281955	40	11	17	317	353	20.000

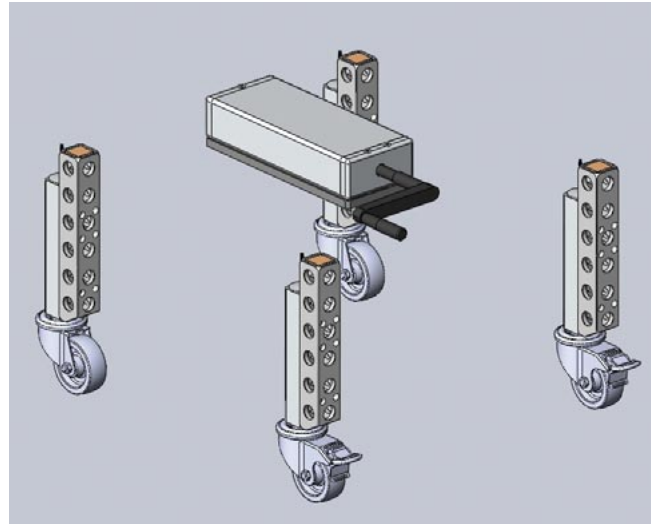
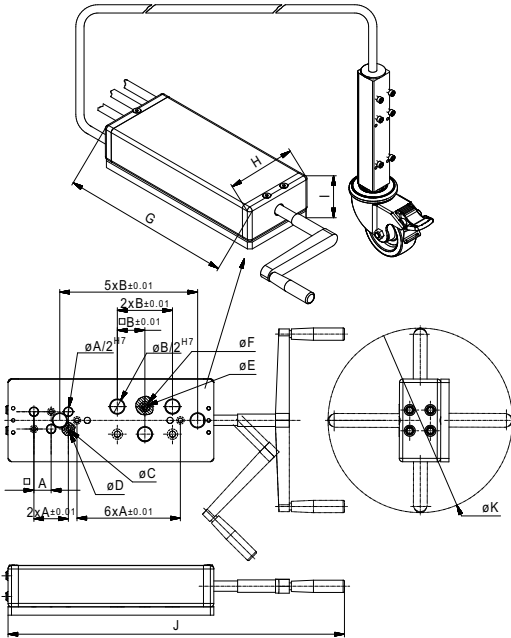
An hydraulic foot pump #16539 is included in supply. Connection material, which has to be configured for fixture, is available on request



Katalogzeichen

**Castor Set for AF 25 and AF40**  
 4 steerable castors with hydraulic height adjustment. Manually operated pump with crank handle

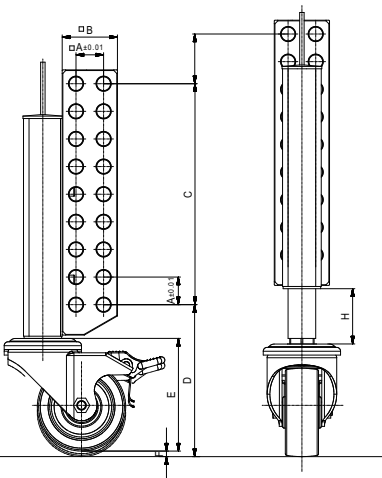
Nr.	A	B	C	D	E	F	G	H	I	J	K	kg
282479	25	40	6,6	11	9	15	299	120	73	488	270	13,8

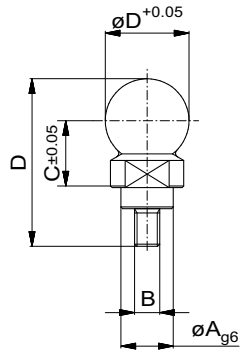


The castor set is for fixtures up to a weight of 350kg. Lift is max 150mm. 3m of pre-configured hydraulic connection material per castor is included with supply. Profiles shown below are recommended for connection.

**Profiles AF for castors**  
 for hydraulic height adjustment

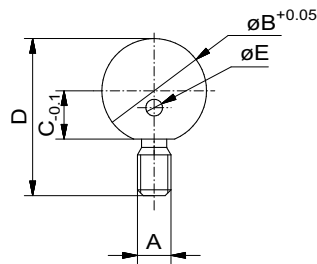
Nr.	A(AF)	B	C	D	E	F	H	Ø
310548	25	50	200	137	102	5	50	535
310549	40	40	200	140	102	5	50	445





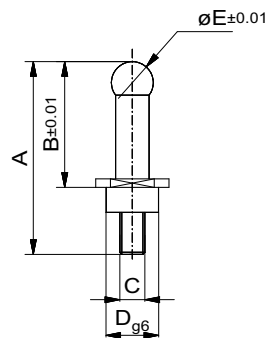
**Reference ball  
for Alufix bore**

Nr.	A	B	C	D	øD	Material	Ⓜ
28403(-1)	12,5	M6	16	39	18	Aluminum	15
<b>C</b> 33035(-1)	12,5	M6	16	39	18	Steel	90
33516(-1)	20	M10	24	59,5	27	Aluminum	80
33517(-1)	20	M10	24	59,5	27	Steel	150
83117(-1)	25	M12	32	60,5	36	Aluminum	140
84344	25	M12	32	60,5	36	Steel	340



**Reference ball  
with thread**

Nr.	A	B	C	D	E	Material	Ⓜ
34150	M8	25	11,5	37,5	4	Steel	64



**Reference ball**

Nr.	A	B	C	D	E	Material	Ⓜ
25130	46	30	M6	12,5	10	Steel	24

ALUFIX elements can be anodized in different colors. The color "natural" is standard, "black" is available as an alternative - then simply add "-1" to the article number when ordering. Other colors on request.

**C·E** ALUFIX preferred range  
 Green: Item is available immediately.  
 C: Classic version, E: Eco version, CE: Classic or Eco  
 ■: color "natural", ■: color "black"



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**Information:**

- Weights mentioned in the catalogue are non-committal and approximate, and can deviate considerably i.e. through technical changes.
- We reserve the right to make technical changes.
- Where differences between photos and parts lists exist, the parts lists are decisive.
- Due to fluctuations of copper content in aluminum - alloy colour deviations may occur during anodizing.
- All Alufix components are also available anodized black e.g. for use with optical measuring systems. Exceptions are standard hard anodized items such as pins, connection elements in steel etc. These items maintain their usual characteristics but can be changed on request.
- All details on our products in this catalogue, especially illustrations, drawings, dimensions and statements on performance are to be regarded as approximate average values.
- We reserve the right to change design, technical data, dimensions and weights.
- The indicated standards, similar technical regulations as well as technical details, descriptions and illustrations are valid at time of printing.
- Our general trading conditions are valid.
- Our quotations are decisive.

- 3 Jaw Keyless Chuck 86
- 3D Shim block AF 48
- 3D Shim block base, side mounting 49
- 3D Shim block with integrated contour block 49
- 6 Jaw Keyless Chuck 87
  
- Adapter cross plate ALUFIX 53
- Adapter plate 37, 136
- Adjustment elements 32
- ALUFIX Experte 140
- AutoCAD 139
- Autocenter 78, 79
  
- Ball joint 84
- Ball point 101
- Bar 1D for quick connectors 33
- Bar 1D for screw connectors 33
- Bar Light Classic one row 16
- Bar Light Eco one row 16
- Bars 14
- Bars Light Classic three row 20
- Bars Light Classic two row 18
- Bars Light Eco rectangular 1x2 rows 22
- Bars Light Eco rectangular 2x3 rows 24
- Bars Light Eco three row 20
- Bars Light Eco two row 18
- Base 150
- Base for Swivel turn insert 54
- Base jaws set 90
- Base plate 2D for quick connectors 33
- Base plate 2D for screw connectors 34
- Base plate for jack 41
- Base plates 6
- Basic Kits 122
- Basic Set 89, 124 - 136
- Basic Set 3 jaw Keyless chuck 89
- Basic Set 6 jaw Keyless chuck 89
- Bolt 116
- Bolt disk 113
- Bolt disk 1D/2D 113
- Bolt disk with stud 113
  
- C clamp 80
- Cap for screw-jack 76
- Castor Set 156, 157
- Castor, fold up 156
- Catia 139
- Center 78, 79, 81
- Center plate 91
  
- Centering element 80
- Centering pin 147
- Clamp accessory kit for measuring machines 124
- Clamp bracket 73
- Clamp screw 145
- Clamp unit with ratchet grip 150
- Clampholder 100
- Clamping element set 122
- Clamping elements 86
- Clamping plate 77
- Classic Base plates 7
- Column connection 144, 146, 148
- Column variations 143
- Combi bolt 110, 111, 112
- Combi reducer bolt 111
- Combi tool 121
- Combined contact 62, 63
- Compound resin 94
- Connecting different system sizes 102
- Connecting disk 115
- Connecting set 118
- Connecting with couplings 103
- Connection elements 102
- Contents 1, 142
- Contour block 151
- Contour block for 3D shim block 48
- Countersunk screw 67
- Coupling 104, 105, 106, 107
- Coupling plate 26
- Coupling, double 105, 107
- Coupling, single 104, 106
- Cross connector 96
- Cross guiding slide 46
- Cross over 76, 84
- Cross roller slide 45
- Cross roller slide heavy duty 45
- Crosspiece 67, 109
  
- Deflector 100
- Delta block form 1 72
- Delta block form 2 72
- Delta block form 3 72
- Dial indicator holder 101
- Disc 114
- Double Knuckle 36
  
- Expanding clutch bolt 149
- Experte 140
- Extension 121
- Extension Set 134, 135
  
- Face adapter 54, 59, 60
- Face adapter with shim angle 58
- Fitting screw 67, 145
- FixBase® 142
- Fixing disk 114, 116, 117
- FIXMES 139
- Fixture building 142
- Foot for hook clamps 155
- Foot for pressure fork 150
- Footplate 77, 144, 146, 148, 149
- Forming jaw 93
- Full Bars Classic 15
  
- Grid base plates Eco 9
- Guiding slide 46
  
- Handle 121
- Heel block 45°/90° 34
- Heel block 45°-90° 34
- Hex insert bit 121
- hex key 121
- Hex screw 67
- Hex socket head screw 110
- Hinge 31
- Hold down spring 98, 99, 123
- Hold down spring with plastic cap 99
- Hold down springs 96
- Hold down stud 97
- Hold-down column clamp 95
- Hook 154
- Hook Clamp Basic Unit 153, 154
- Hook Clamp Compact 153
- Hook Clamp compact flexible 154
- Hook clamps 152
  
- IGES 139
- Information 159
  
- Jack 1000, Heavy Duty 39
- Jack 500 40
- Jacks 39
- Joint for Screw-jacks 85
  
- Key for knurled profiles 121
- keyless chuck 117

- Keyless chuck 92, 123
- Knife V 120° 82
- Knife V 90° 83
- Knuckle 36
  
- Legend 1
- Lift-Element 53
- Locating pin 108
- Lock 112
- Lock pin 144
- Lock unit 147
  
- Magnetic holder 81
- Mobile measuring and storage unit 137
- Mobile measuring arm 136
- Moulding cap 81
  
- Nut 109
  
- Offset plate 59
- Overview connecting disks for keyless chucks 115
  
- Parallel clamp 100
- Parallel-vise 93
- Parts library for CAD systems 139
- Pin cushion 95
- Pin spanner 121
- Positioning guide and pin 47
- Positioning rod 121
- Positioning sleeve 108
- Precision Grid Base Plates 10, 12
- Profile angle brackets 29
- Profiles 53
- Profiles AF for castors 157
  
- Quick change coupling 30, 31, 91
- Quick change coupling bottom section 31
- Quick change coupling top section 31
- Quick connection 102
- Quick connection set 119
  
- Rack gear jack 40
- Reducer bolt 113
- Reducer bush 110, 116
- Reducer sleeve 108
  
- Reference ball 158
- Release pin 98
- Reversible jaws set 90
- Ring 154
- Ring for screw jack 76
- Rocker 36
- Roller and guiding slides 44
- Roller slide 44
- Roller slide heavy duty 45
- Rotary plate 37, 117
- Rotary shim block 57
- Rotary swing unit 38
- Rotating insert 54, 55
  
- Screw clamp 85, 122
- Screw connection 102
- Screw jacks and top sections 74
- Screw-jack 75
- Screw-jack extension 75
- Screw-jack with anti-turn lock 75
- Set strip 65, 66
- Shim (with fixed thickness) 51
- Shim block 48, 61, 62
- Shim foil 50, 51
- Sleeve 97, 108
- Slide stop 47
- Slot nut 66
- Socket head screw 67
- Spacer 84
- Spacer base 65
- Spacer plate 64
- Spacer side 65
- Starter-Kits 122
- STEP 139
- Stop and support 180° 80
- Stop and support 90° 80
- Stop M4 84
- Storage compartment 136
- Structure plates 142
- Struts 28, 29
- Support for ball point 101
- Support pin 81
- Support ring 153
- Swivel arm AF 25 35
- swivel arm with joint 116
- Swivel plate 35
- Swivel plate with slot 35
- Swivel top 56, 57
- Swivel top with offset shim angle 55
- Swivel top with shim angle 55
  
- The ALUFIX principle 4
- Threaded pin 66
- Tools 120
- Top block for Jack 42, 43
- Top jaws single 91
- Top pin 153, 154
- TopPos grid setting 52
- TopPos modular system 52
- Torque wrench 120
- Traverse holder with heel 96
- True line stud 79
- Twin bolt 112, 113
  
- Unigraphics NX5 139
- Universal plate 77
- Universal Vise 95
  
- V block 120° 71, 82
- V block 90° 70, 83
- V piece 90° 69
- V pieces and delta blocks 68
- Vacuum base 138
- Variations for contact points 64
- Vise 123
- Vise set 92
  
- Winder 100
- Winder tape 100
- Witte PPS quick clamp system 146
- Witte PWS quick clamp system 148
- Workstation 136
  
- x-y-coordinates for struts 28
- xy-Stop 76



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