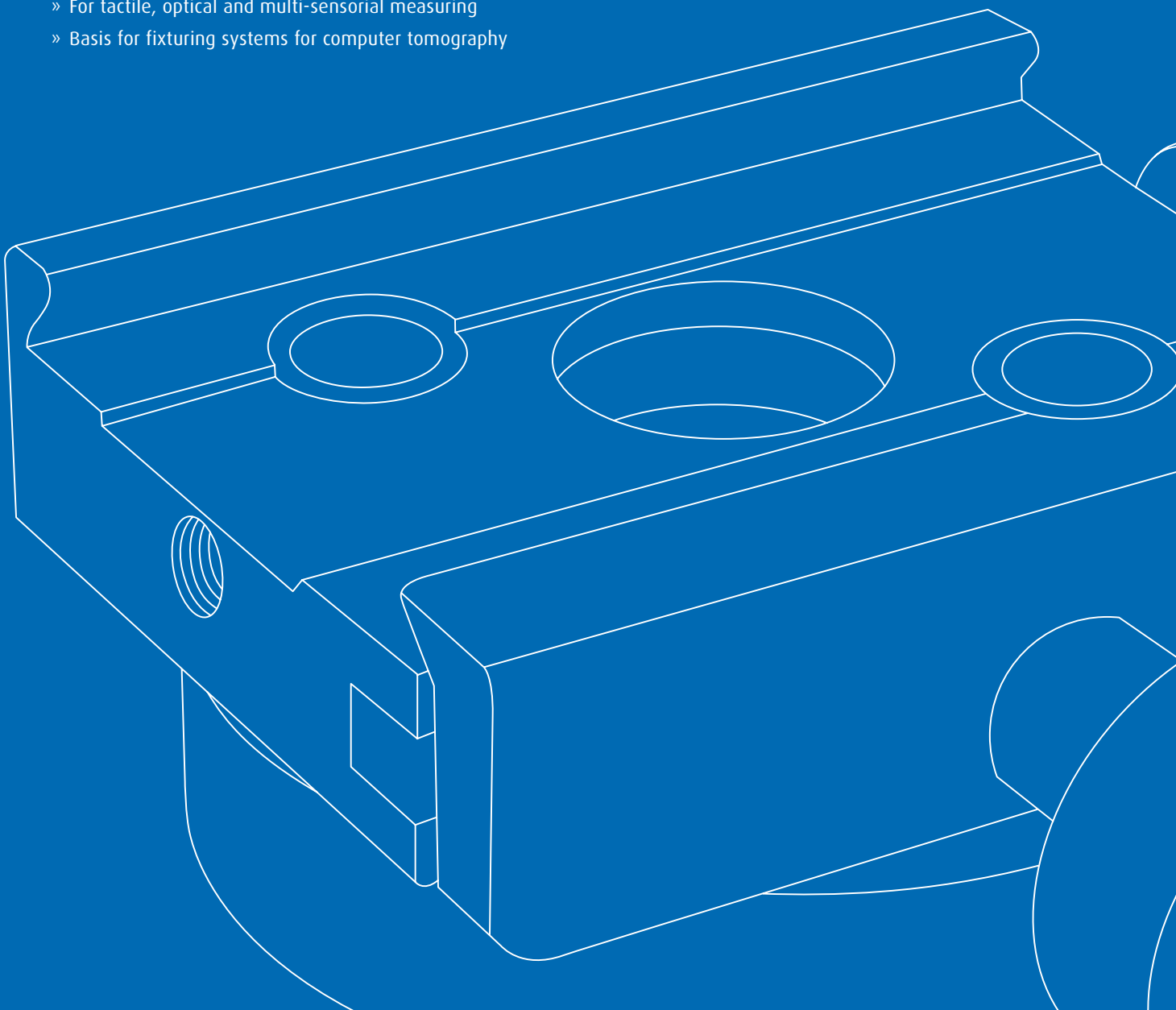


SWA39

Quick-change complete system for tactile and optical measuring

- » Quick-change complete system for zero-point fixture clamping
- » Basic elements for adaptation to metrology machines or inspection tables
- » Structural elements for free spatial positioning
- » Clamping elements for all categories in many types and sizes
- » With stops for accurate repositioning of test parts
- » With scales for exact reproduction of complete fixtures
- » For tactile, optical and multi-sensorial measuring
- » Basis for fixturing systems for computer tomography



Basic elements



Quick-action clamp with fastening screw

Page 22



Quick-action clamp with extension

Page 23



Quick-action clamp for mounting in a vice

Page 23



Quick-action clamp for Alufix

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Quick-action clamp for mounting in a vice

Page 24



Quick-action clamp with magnet

Page 25



Magnetic base

Page 25



Quick-action clamp, pneumatic glide foot

Page 26



Quick-action swivel clamp on a baseplate

Page 27

Structural elements



Adapter plates for customer machining

Page 28



Adapter plates with mounting thread

Page 28



Adapter plates with mounting holes

Page 29



Adapter plates with T-slot 6

Page 29



Quick-action clamp with fixed height extension

Page 30



Quick-action clamp with adjustable height extension

Page 30



Quick-action clamp rotated 90°

Page 31



Quick-action clamp 360° rotation

Page 31



Quick-action clamp with carriage guide or cross table

Page 32



Quick-action clamp fixed 45° or 90° angle element

Page 33



Quick-action clamp, swivel unit

Page 34



Quick-action clamp, swivel unit

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Quick-action clamp, rotary and swivel unit

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Swivel unit with universal joint

Page 36



Swivel unit with ball joint

Page 36



Swivel unit with geared head

Page 37

Clamping elements
+ accessories



15 mm precision vice

Page 38 [+](#)



25 mm precision vice

Page 40 [+](#)



35 mm precision vice

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50 mm precision vice

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50 mm precision centric vice

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50 mm precision vice

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80 mm precision vice

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100 mm precision vice

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125 mm precision vice

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Precision mini chuck

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ER 16 precision collet chuck

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Information to dk precision three-jaw chucks

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34 mm precision three-jaw chuck

Page 64 [+](#)



50 mm precision three-jaw chuck

Page 66 [+](#)



65 mm precision three-jaw chuck

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100 mm precision three-jaw chuck

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160 mm precision three-jaw chuck

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Rotary table with precision three-jaw chuck

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NADELFIX function and advantages

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NADELFIX 2.5

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NADELFIX 5 Mini

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NADELFIX 5 Midi

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NADELFIX 5 Maxi

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Small-parts clamp, smooth

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Small-parts clamp, jaw stepped one side

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Small-parts clamp with horizontal prism

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Small-parts clamp with top-face prism

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Small-parts clamp for internal clamping

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Stop unit for small-parts clamps

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Permanent magnet clamping mounts

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Magnetic clamping mounts, switchable

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Permanent magnet V-block

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Magnetic V-block, switchable

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Small V-block with spring finger

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V-block

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V-blocks pairs, adjustable on SWA 39 rail

Page 90 [+](#)



Pneumatic glide foot Airbase

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Vacuum clamping plates - round

Page 92 [+](#)



Vacuum clamping plate - square

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Clamping sets



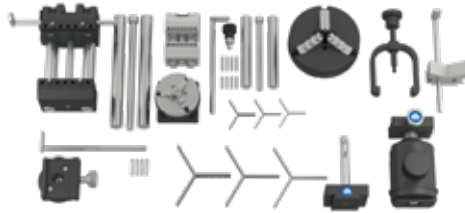
Set "A"

Page 94



Set "B"

Page 95



Set "C"

Page 96

Quick-change adaptation system for reproducible zero points

Unique, high-quality and reliable – dk SWA 39 modular system for fixating technology:

- A huge selection of basic, structural, adjustment and clamping elements with standardised interfaces
- Individual elements and entire fixtures can be changed quickly
- Positive fixating with a high reference accuracy as a base for zero-point fixture clamping
- Highest quality for maximum service life

Basic elements

- 1 Baseplate with tapped holes (page 158)



Other baseplates
(Pages 104–105)



- 2 Quick-action clamp with fastening screw (page 22)



Other quick-action clamps
(from page 23)



Structural elements

- 3 Quick-action clamp with height extension (page 30)



Other versions and adaptations
(pages 22–37)



- 4 Quick-action clamp angle element (page 33)





Clamping elements

- 5 Rotary table with precision three-jaw chuck (page 74)



Other clamping elements and accessories (pages 38-91)



FAST REASSEMBLY LIFELONG

The basic principle of all dk fixturing systems. The compatibility of the dk programs makes the utility value perfect.

The result:

- quick, simple, workpiece and process-oriented positioning and clamping
- rapid conversion to new workpieces and processes
- possibility of workpiece setups outside of the machine during measuring process
- disassemble and reassemble entirely new or exactly the same fixtures countless times
- an alternative to classic, inflexible, single-use fixture constructions

Quick-action clamp with fastening screw

Description

SWA 39 quick-action base clamp for mounting all structural, adjustment and clamping elements of the SWA 39 system. For direct fastening in tapped holes or T-slots. Mounted on a 12 mm high intermediate plate.

Material

Hard-coated aluminium/stainless steel.

Supplied with

Fasteners



Order No.	Fastening screw	Height
285204	M4	23.5
285205	M5	23.5
285206	M6	23.5
285208	M8	23.5
285210	M10	23.5
285212	M12	23.5
285300	Set for T-slot 6	23.5

SWA 39
M ...

Application example



Quick-action clamp with extension

Description

SWA 39 quick-action clamp for direct fastening in tapped holes.
Mounted on 50/100 mm extensions.

Material

Hard-coated aluminium.

Supplied with

Fastening screw.



Order No.	Fastening screw	Height
330506	M6	61.5
330508	M8	61.5
330510	M10	61.5
330512	M12	61.5
330606	M6	111.5
330608	M8	111.5
330610	M10	111.5
330612	M12	111.5

SWA 39
M ...

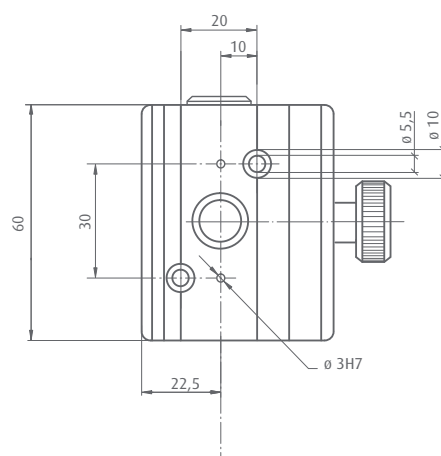
Quick-action clamp for special mounts

Description

SWA 39 quick-action clamp for screwing onto special mounts.

Material

Hard-coated aluminium.



Order No.	Height
273300	11.5

SWA 39
M ...

Quick-action clamp for Alufix

Description

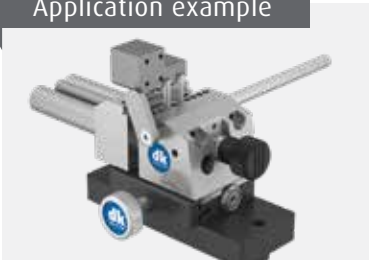
SWA 39 quick-action clamp for mounting on Alufix 16 or 25 system baseplates.

Material

Hard-coated aluminium.



Application example



Order No.	System	Length	Width	Height
274700	16	60	78	32
274710	25	66	78	32
274720	25/grid 50	116	78	32

Quick-action clamp for mounting in a vice

Description

SWA 39 quick-action clamp for mounting in any standard vice (min. jaw width 40 mm).

Material

Hard-coated aluminium/steel.



Order No.	Height
330800	52

SWA 39

Quick-action clamp with magnet

Description

SWA 39 quick-action clamp on permanent magnet with On-Off switch for mounting on steel plates. Vertical lift-off force 1000 N.

Material

Hard-coated aluminium/steel.



Order No.	Length	Width	Height	Lift-off force
313800	68	76	71.5	1000 N

SWA 39

Magnetic base

Description

Permanent magnet with On-Off switch and M 8 or M 10 tapped hole. Vertical lift-off force 800 N or 1000 N.

Material

Steel.

Application example



Order No.	Thread	Length	Width	Height	Lift-off force
251500	M10	68	53	60	1000 N
251400	M8	36	53	60	800 N

M 10

Quick-action clamp on a pneumatic glide foot

Description

Basic attachment for SWA 39 modular elements on smooth surfaces. Easy glide on an air cushion. Fix in place by vacuum. Connection modules with SWA 39 interface. Maximum load ca. 15 kg. Operating pressure 4.5 to 6 bar. Operate only with dry, oil-free air.

With port for vacuum generation in other elements that may be connected.
See pages 92 to 93.



Order No.	Length	Width	Height	Version	Weight
270200	300	200	56	With ext. vacuum port	3.3

SWA 39

Application example

SWA 39 pneumatic glide foot:

The pneumatic glide foot is the ideal basic attachment for smooth surfaces that have no mounting holes. The pneumatic foot glides on an air cushion and is secured by a vacuum. A clamping fixture can therefore be manoeuvred into, and locked in any point on the inspection table – no screws required. The SWA 39 interface on the products top face is ideal for quick, reliable and straightforward mounting of any module to swivel and fixate parts to be measured or tested.



Quick-action rotate and swivel clamp on a baseplate

Description

SWA 39 quick-action clamp mounted on baseplate.
With 90° swivel element.

Material

Hard-coated aluminium/stainless steel.



Application example

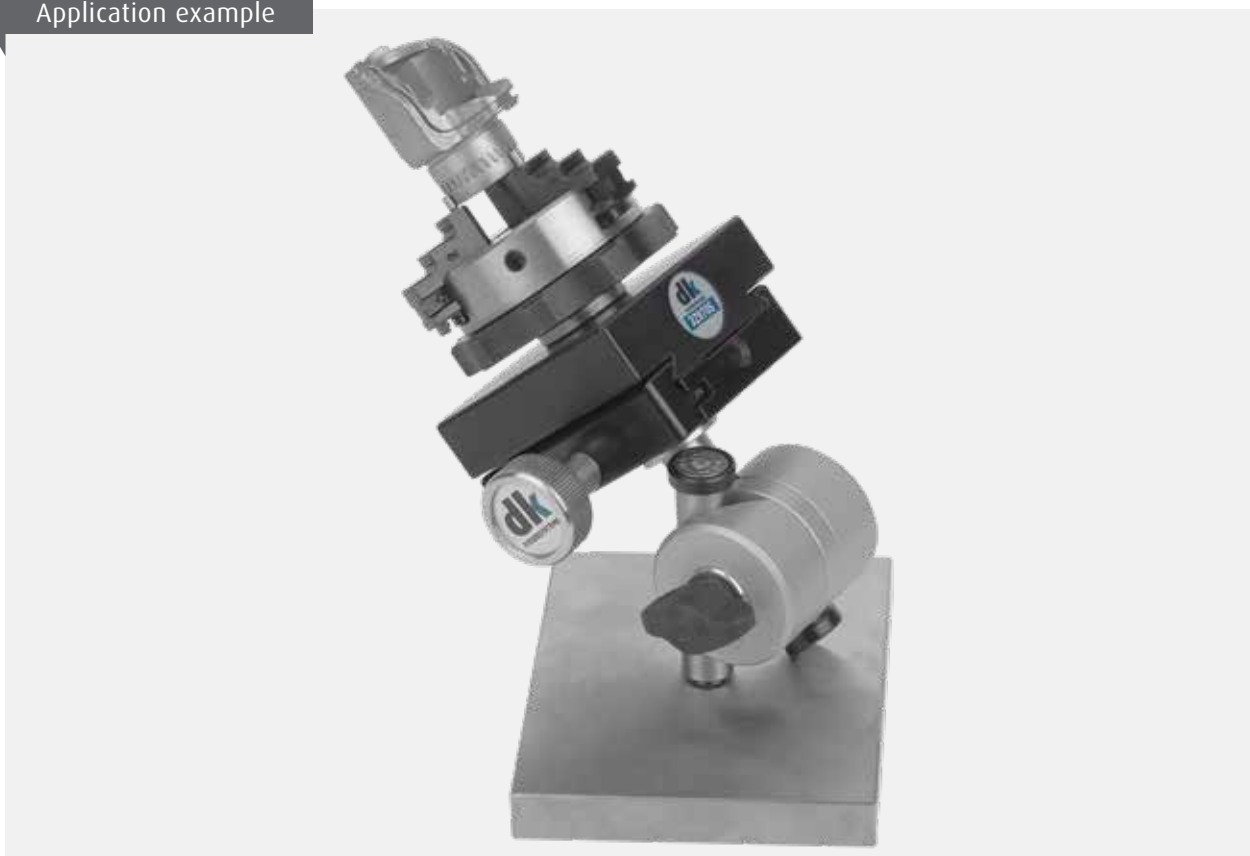


Order No.	Length	Width	Height*	Weight
270560	100	80	82	1.1

SWA 39

* Minimum height with horizontal quick-action clamp

Application example



Adapter plates for customer machining

Description

Baseplate with SWA 39 quick-change adapter. With standard or cross interface. The adapter with the standard interface can be installed in two positions on the quick-change mount, the cross interface four positions. Plate for machining by the user as required.

Material

Hard-coated aluminium.



Order No.	Version	Length	Width	Height	Fig.
273000	Standard interface	60	60	20	1
314500	Cross interface	60	60	20	

SWA 39

Adapter plates with central tapped hole

Description

Baseplate with SWA 39 quick-change adapter and central tapped hole.

Material

Hard-coated aluminium.



Application example



Order No.	Version	Length	Width	Height
273006	M6	60	60	20
273008	M8	60	60	20
273010	M 10	60	60	20
273012	M12	60	60	20

M ...
SWA 39

Adapter plates with tapped holes

Description

Baseplates with tapped holes. One central hole or four holes arranged in a square.

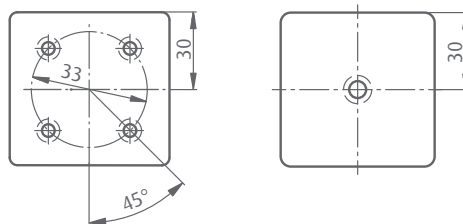
Material

Hard-coated aluminium.

Supplied with

4x M4 fastening screws or

1x M6 fastening screw.



Order No.	Version	Length	Width	Height	Fig.
397020	4x M4 holes with standard interface	60	60	20	1
397030	4x M4 holes with cross interface	60	60	20	
397040	1x M6 hole with standard interface	60	60	20	

M ...
SWA 39

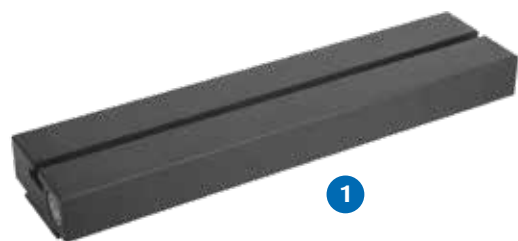
Adapter plates with T-slot 6

Description

Baseplate with T-slot 6 for mounting diverse modules, e.g. structural elements from the *SPANNFIX* range. With SWA 39 quick-change adapter for mounting on SWA 39 basic elements.

Material

Hard-coated aluminium.



Order No.	Length	Width	Height	Fig.
305000	140	60	24	
305100	250	60	24	1
305110	500	60	24	

T-Nut 6
SWA 39

Quick-action clamp with fixed height extension

Description

Extension modules with SWA 39 quick-change adapter.

Material

Hard-coated aluminium.

Application example



Order No.	Length	Width	Height
273600	60	80	61.5
273700	60	80	111.5

SWA 39

Quick-action clamp with adjustable height extension (fine adjustment)

Description

Extension modules, with threaded spindle for infinite fine adjustment, knurled screw and lock.

Mounted on an SWA 39 quick-change adapter.

Material

Hard-coated aluminium.



Order No.	Length	Width	Height
273800	60	80	60-80
273900	60	80	80-120

SWA 39

Quick-action clamp rotated 90°

Description

SWA 39 quick-action clamp for the mounting modules offset at 90°. Mounted on an SWA 39 quick-change adapter.

Material

Hard-coated aluminium.



Order No.	Length	Width	Height
314400	60	80	31.5

SWA 39

Quick-action clamp 360° rotation

Description

Quick-action clamp, rotates freely or indexed at 90°. Indexing function can be removed. Angular adjustment with a scale accurate to 2°. Knurled screw lock. Alternatively with fine adjustment. Mounted on an SWA 39 quick-change adapter.

Material

Hard-coated aluminium, stainless steel shaft.



Order No.	Rotation	Function	Length	Width	Height	Fig.
283450	360°/indexed every 90°	manual	60	80	52	1
283460	360°/ fine adjustment	Gear drive	60	90	72	2

SWA 39

Quick-action clamp with slide or cross table

Description

SWA 39 quick-action clamp with infinite, high-precision X or X/Y adjustment.
Mounted on an SWA 39 quick-change adapter.

Material

Hard-coated aluminium.



Order No.	Function	Travel	Length	Width	Height	Fig.
314460	Cross table X/Y	25	80	80	78	1
314450	Slide X	25	80	80	55	2

SWA 39

Application example



Quick-action clamp fixed 45° or 90° angle element

Description

Fixed 45° or 90° angle element for mounting positioning and clamping elements, with an SWA 39 quick-change clamp. With SWA 39 quick-change adapter.

Material

Hard-coated aluminium.



Order No.	Angle	Length	Width	Height	Fig.
283300	90°	60	90	60	1
283320	45°	60	90	70	2

SWA 39

Application example



Quick-action clamp on a pivot unit (quick adjustment)

Description

SWA 39 quick-action clamp, infinite or 45° indexed pivot through $\pm 90^\circ$. Scale with 5° divisions. Mounted on an SWA 39 quick-change adapter.

Material

Hard-coated aluminium.

Supplied with

Detachable stop for 0°, 45° and 90°.



Order No.	Pivot range	Length	Width	Height
314000	+90°/-90°	60	80	87

SWA 39

Quick-action clamp on a pivot unit (fine adjustment)

Description

SWA 39 quick-action clamp, infinite pivot through $+90^\circ/-55^\circ$. A worm gear drives the pivot. Scale for angular adjustment accurate to 2°. Mounted on an SWA 39 quick-change adapter.

Material

Hard-coated aluminium.



Order No.	Swivel range	Length	Width	Height
314010	+90°/-55°	85	80	97
314015	clamping set for pivot unit			

SWA 39

Quick-action rotary and pivot unit clamp

Description

SWA 39 quick-action pivot and rotating clamp Pivot range $+90^\circ / -55^\circ$. A worm gear drives the pivot. Infinite rotation through 360° or indexed every 90° . Indexing function can be removed. Angular adjustment with a scale accurate to 2° . Knurled screw lock. Mounted on an SWA 39 quick-change adapter.

Material

Hard-coated aluminium, stainless steel shaft. Steel worm.



Order No.	Rotation	Pivot	Length	Width	Height	Fig.
314020	360° /indexed every 90°	$+90^\circ/-55^\circ$	85	80	114	1
314030	360° /fine worm drive	$+90^\circ/-55^\circ$	85	80	114	2
314015	clamping set for pivot unit					

SWA 39

Application example



Swivel unit with universal joint

Description

SWA 39 quick-action clamp for quick and flexible spatial clamping of parts. Swivels up to 90°. Swivel element can be locked with a clamping screw. Mounted on an SWA 39 quick-change adapter.

Material

Hard-coated aluminium, stainless steel shaft.



Order No.	Length	Width	Height*	Weight
270570	60	60	90	0.52

SWA 39

* Minimum height with horizontal quick-action clamp

Swivel unit with ball joint

Description

Swivel unit for quick and flexible spatial clamping of parts. Rotates through 360°. Swivels up to 90°. Mounted on an SWA 39 quick-change adapter.

Material

Hard-coated aluminium.

Application example



Order No.	Length	Width	Height	Weight
270500	70	90	120	0.86

SWA 39

Swivel unit with geared head

Description

3D geared head for quick and flexible spatial positioning of parts. Both the entire swivel unit and the upper quick-action clamp can be rotated through 360°. Two separate goniometers and a pivot unit enable swivelling up to 90°. Mounted on an SWA 39 quick-change adapter. Scales in all axis enable for reproducible clamping without any problem.

Material

Body hard-coated aluminium.
Guides and drive brass/steel.



Order No.	Length	Width	Height*	Weight
270650	110	110	126	1.3

SWA 39

Application example



15 mm precision vice

Description

Miniature vice with prism jaws. With SWA 39, SWA 5 or M 4 connection. Brass or stainless steel versions available. M 4 hole centre distance is 42 mm.

Supplied with

Stainless steel (270921) and plastic exchange jaws.



Order No.	Version	Jaw width	Clamping width	Total height	Material	Fig.
270910	SWA 39	15	14.5	61	Brass	1
270915	SWA 39	15	14.5	61	Stainless steel	1
270900	SWA 5	15	14.5	27	Brass	2
270905	SWA 5	15	14.5	27	Stainless steel	2
270920	2x M4	15	14.5	15	Brass	3
270925	2x M4	15	14.5	15	Stainless steel	3

Accessories

+ Form jaw with prism

Order No.	Material	Jaw width	Supplied with	Description
270921	Stainless steel	15	1 set jaws one smooth and one prism jaw	With vertical and horizontal prisms



+ Stepped jaw

Order No.	Material	Jaw width	Contents	Description
270922	Stainless steel	15	1 jaw	Step height 1.5 mm Step depth 1.0 mm



Application examples



25 mm precision vice

Description

Miniature vice with prism jaws. With SWA 39, SWA 5 or M 4 connection. Aluminium and stainless steel versions available. M 4 hole centre distance is 62,5 mm.

Supplied with

Stainless steel (270971) and plastic exchange jaws.

Application example



SWA 39	SWA 5	M ...
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Order No.	Version	Jaw width	Clamping width	Total height	Material	Fig.
270960	SWA 39	25	24.5	53	Aluminium	1
270965	SWA 39	25	24.5	53	Stainless steel	1
270950	SWA 5	25	24.5	38	Aluminium	2
270955	SWA 5	25	24.5	38	Stainless steel	2
270970	2x M4	25	24.5	25	Aluminium	3
270975	2x M4	25	24.5	25	Stainless steel	3

Accessories

+ Form jaw with prism

Order No.	Material	Jaw width	Supplied with	Description
270971	Stainless steel	25	1 set jaws one smooth and one prism jaw	With vertical and horizontal prisms



+ Stepped jaw

Order No.	Material	Jaw width	Contents	Description
270972	Stainless steel	25	1 jaw	Step height 1.8 mm Step depth 1.3 mm



+ Stop

Order No.	Material	Length	Adjustment range
318250	Stainless steel/aluminium	75	50



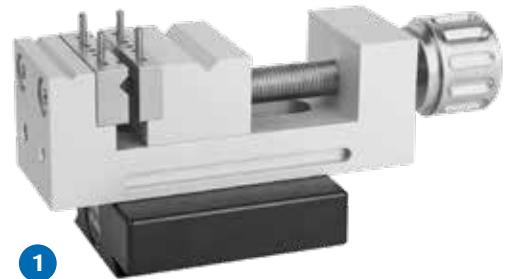
35 mm precision vice

Description

Miniature vice with prism jaws. With SWA 39 or M 5 connection. Aluminium and stainless steel versions available. Jaws with Ø2 mm holes for clamping pins. M5 hole centre distance is 83 mm.

Supplied with

Stainless steel (270861) and plastic exchange jaws and 4x Ø2 mm pins.



1



2

Application example



SWA 39

M ...

Order No.	Version	Jaw width	Clamping width	Total height	Material	Fig.
270850	SWA 39	35	34.5	55	Aluminium	1
270855	SWA 39	35	34.5	55	Stainless steel	1
270860	2x M5 / 4x M4	35	34.5	35	Aluminium	2
270865	2x M5 / 4x M4	35	34.5	35	Stainless steel	2

Accessories

+ Form jaw with prism

Order No.	Material	Jaw width	Supplied with	Description
270861	Stainless steel	35	1 set jaws one smooth and one prism jaw	With vertical and horizontal prisms



+ Stepped jaw

Order No.	Material	Jaw width	Contents	Description
270862	Stainless steel	35	1 jaw	Step height 2.0 mm Step depth 1.5 mm



+ Stop

Order No.	Material	Length	Adjustment range
318250	Stainless steel/ aluminium	75	50



50 mm pull down precision vice

Description

Positive down force vice with quick adjustment and adjustable stop. SWA 39 quick-change adapter integrated into the vice base. With stepped jaws and Ø4 mm holes for clamping pins. Optional stainless steel exchange jaws.

Material

Surface hardened steel.

Supplied with

Adjustable stop (318110), 4 pins for pin clamping and operating tools.



Order No.	Jaw width	Clamping width	Weight
270700	50	80	1.46

SWA 39

Accessories

+ Smooth jaws

Order No.	Material	Jaw width	Supplied with	Description
271200	Stainless steel	50	1 set exchangeable jaws and fastening screws	-



+ Form jaws with small prisms

Order No.	Material	Jaw width	Supplied with	Clamping diameter
271500	Stainless steel	50	1 set jaws one smooth and one prism jaw	recommended from 2.5 mm



+ Form jaws with large prisms

Order No.	Material	Jaw width	Supplied with	Clamping diameter
271900	Stainless steel	50	1 set jaws one smooth and one prism jaw	recommended from 6 mm



+ Clamping pins, stepped

Order No.	Contact face	Length	Contents	Description
282300	straight	24 x Ø4	Set of 4	for raised part positioning
282310	straight	35 x Ø4	Set of 4	
326500	120° prism	25 x Ø4	2 prism pairs	



+ Support discs with pins

Order No.	Version	Disc size	Contents	Description
338300	Adjustable	Ø16 x 9	Set of 4	For raised part positioning



+ Universal stop

Order No.	Material	Supplied with
277510	Steel	2 exchangeable stop points



+ Stop for vices

Order No.	Material	Length	Overhang	Description
318100	Steel	50	20	-
318200	Steel	50	40	
318110	Steel	150	20	
318210	Steel	150	40	



Application example



50 mm precision centric vice

Description

Centric vice with stepped jaws and adaptation options for a range of accessory elements. Pin holes for raised positioning of parts for access from all sides. Version with an SWA 39 quick-change adapter which can be mounted offset by 90°.

Material

Surface hardened steel and hard-coated aluminium.

Supplied with

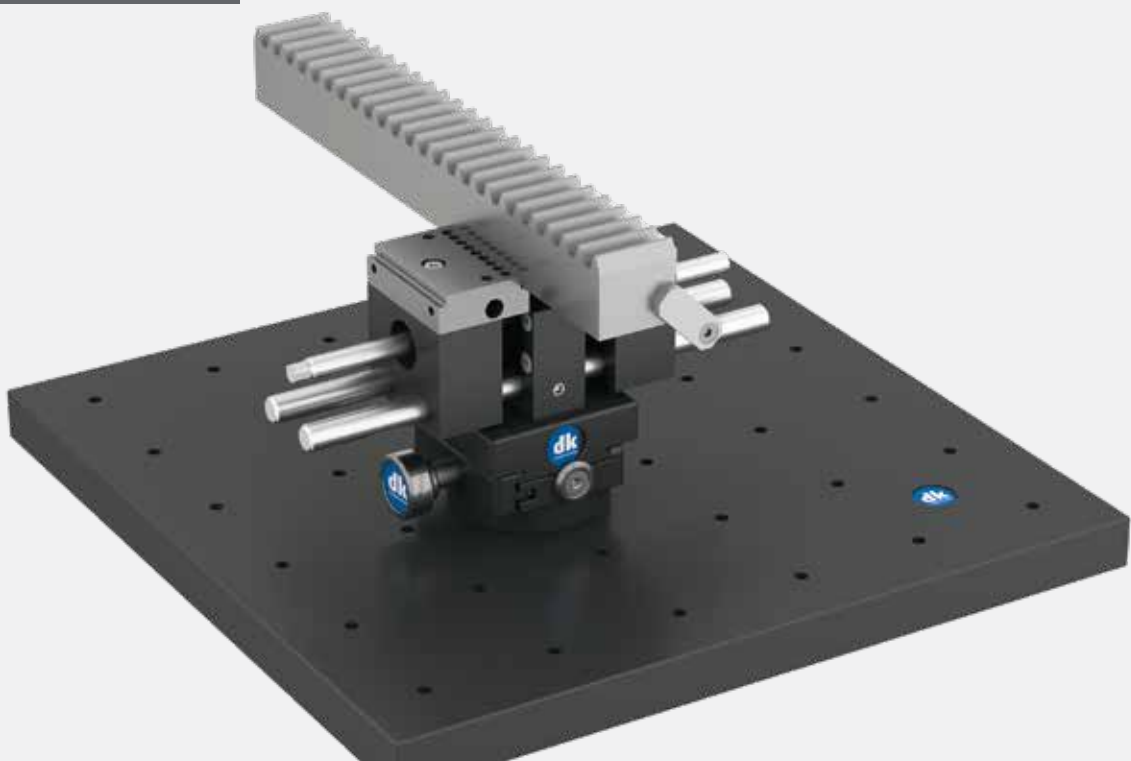
4 pins, adjustable stop and operating tools.



Order No.	Jaw width	Version	Clamping width
282150	50	SWA 39 (removable)	120 mm

SWA 39

Application example



Accessories

+ Smooth jaws

Order No.	Material	Jaw width	Contents	Description
282400	Stainless steel	50	1 set	-



+ Form jaws with prisms

Order No.	Material	Jaw width	Supplied with	Clamping diameter
282700	Stainless steel	50	1 set jaws one smooth and one prism jaw	recommended from 2 mm



+ Form jaws with prisms for end-face clamping

Order No.	Material	Jaw width	Contents	Clamping diameter
306610	Stainless steel	50	1 set	15-50 mm



+ Smooth jaws for small parts

Order No.	Material	Jaw width	Contents	Description
282410	Stainless steel	50	1 jaw	For clamping small parts



Application example



Accessories

+ Pin jaws

Order No.	Material	Jaw width	Contents	Description
282430	Stainless steel	50	1 set	for shorter clamping widths



+ Two-point contact prism jaws

Order No.	Material	Jaw width	Supplied with	Clamping diameter
306900	Hard-coated aluminium	5	1 prism jaw and 1 straight jaw	3–20 mm



+ Three-point contact prism jaws

Order No.	Material	Jaw width	Supplied with	Clamping diameter
306800	Hard-coated aluminium	5+16	1 double prism jaw and 1 straight jaw	Recommended up to 30 mm



+ Clamping pins, stepped

Order No.	Contact face	Length	Contents
282300	Straight	24 x Ø4	Set of 4 for raised part positioning 2 prism pairs
282310	Straight	35 x Ø4	
326500	120° prism	25 x Ø4	



+ Support discs with pins

Order No.	Version	Disc size	Contents	Description
338300	adjustable	Ø16 x 9	Set of 4	for raised part positioning



+ Universal stop

Order No.	Material	Supplied with
277510	Steel	2 exchangeable stop points

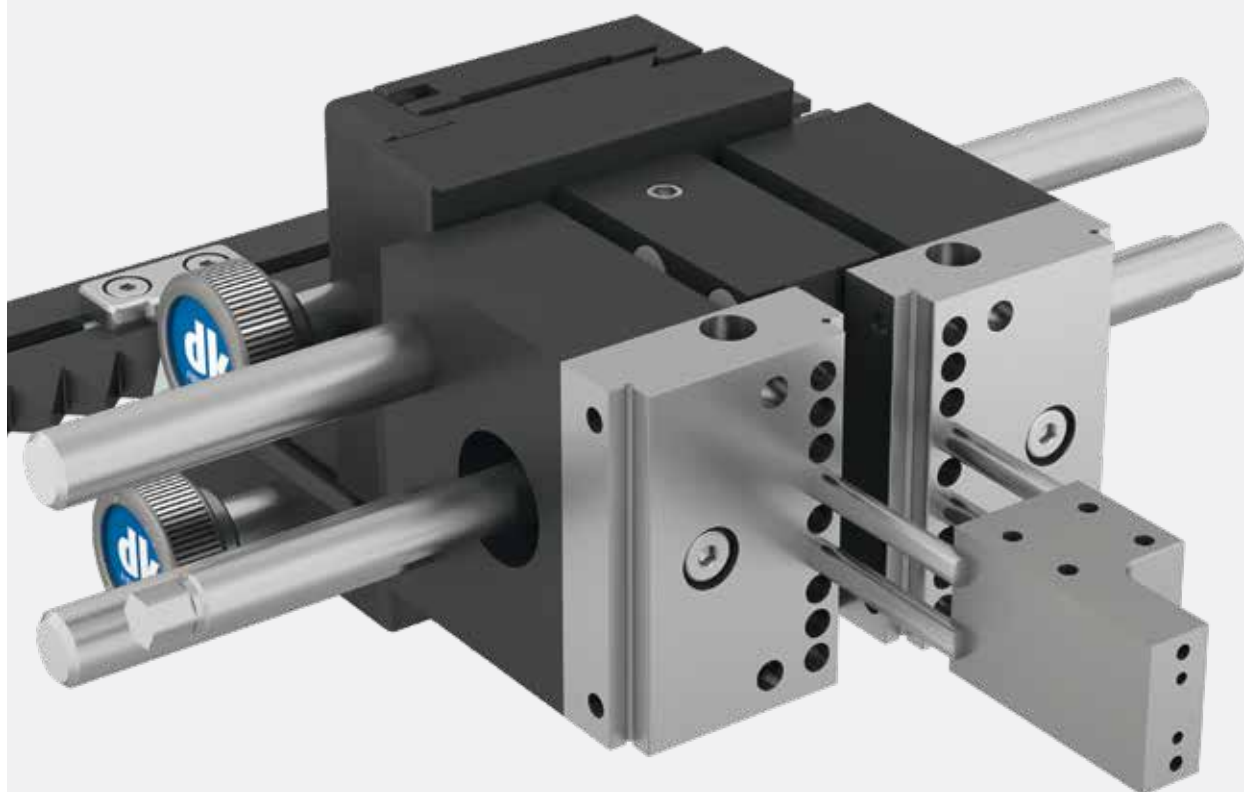


+ Stop for vices

Order No.	Material	Length	Overhang	Description
318100	Steel	50	20	-
318200	Steel	50	40	
318110	Steel	150	20	
318210	Steel	150	40	



Application example



50 mm precision vice

Description

Vice with exchangeable clamping width extension guide shafts. With stepped jaws and Ø4 mm holes for clamping pins.
 Versions with and without SWA 39 quick-change adapter and with and without accessories are available. The versions without quick-change adapter have 4 contact faces at right angles to each other.

Material

Surface hardened steel.

Supplied with

Versions with accessories include an adjustable stop (318110), a set of shafts for extending the clamping width to 75 mm, 4 pins and a magnetic push-in knurled knob (282101).

⚡ A quick-change adapter (397020) can be retrofitted on versions without SWA 39, see page 29.

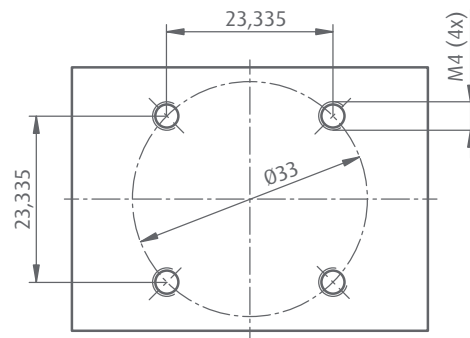
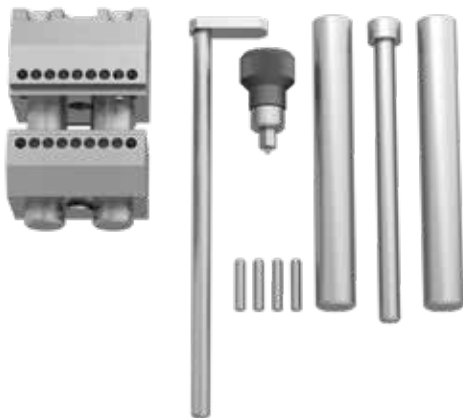


1



2

Vice with accessories.



SWA 39 M ...

Order No.	Jaw width	Version	Accessories	Clamping width	Weight	Fig.
282100	50	SWA 39	yes	35 / 75*	1.05	1
282105	50	SWA 39	no	35*	0.87	
282110	50	4 contact faces	yes	35 / 75*	1.01	
282115	50	4 contact faces	no	35*	0.82	2

* Can be extended up to 150 mm with extra shaft sets.

Accessories

+ Shaft set for clamping range extension

Order No.	Material	Jaw width	Supplied with	Description
282200	Surface hardened steel	-	2 sets of 2 shafts with a threaded spindle	Clamping width extension to 100 mm or 150 mm



+ Smooth jaws

Order No.	Material	Jaw width	Contents	Description
282400	Stainless steel	50	1 set	-



+ Form jaws with prism

Order No.	Material	Jaw width	Supplied with	Clamping diameter
282700	Stainless steel	50	1 set jaws one smooth and one prism jaw	recommended from 2 mm



+ Form jaws with prisms for end-face clamping

Order No.	Material	Jaw width	Contents	Clamping diameter
306610	Stainless steel	50	1 set	15-50 mm



+ Smooth jaws for small parts

Order No.	Material	Jaw width	Contents	Description
282410	Stainless steel	50	1 jaw	For clamping small parts in the stepped jaws



Application example



Accessories

+ Pin jaws

Order No.	Material	Jaw width	Contents	Description
282430	Stainless steel	50	1 set	For shorter clamping widths



+ Two-point contact prism jaws

Order No.	Material	Jaw width	Supplied with	Clamping diameter
306900	Hard-coated aluminium	5	1 prism jaw and 1 straight jaw	3–20 mm



+ Three-point contact prism jaws

Order No.	Material	Jaw width	Supplied with	Clamping diameter
306800	Hard-coated aluminium	5+16	1 double prism jaw and 1 straight jaw	recommended up to 30 mm



+ Clamping pins, stepped

Order No.	Contact face	Length	Contents	Description
282300	Straight	24 x Ø4	Set of 4	for raised part positioning
282310	Straight	35 x Ø4	Set of 4	
326500	120° prism	25 x Ø4	2 prism pairs	



+ Support discs with pins

Order No.	Version	Disc size	Contents	Description
338300	Adjustable	Ø16 x 9	Set of 4	for raised part positioning



+ Universal stop

Order No.	Material	Supplied with
277510	Steel	2 exchangeable stop points



+ Stop for vices

Order No.	Material	Length	Overhang	Description
318100	Steel	50	20	
318200	Steel	50	40	
318110	Steel	150	20	
318210	Steel	150	40	



+ Knurled knobs

Order No.	Version
282101	magnetic
282102	magnetic with adjustable torque, ca. 0.1–0.3 Nm



Application examples



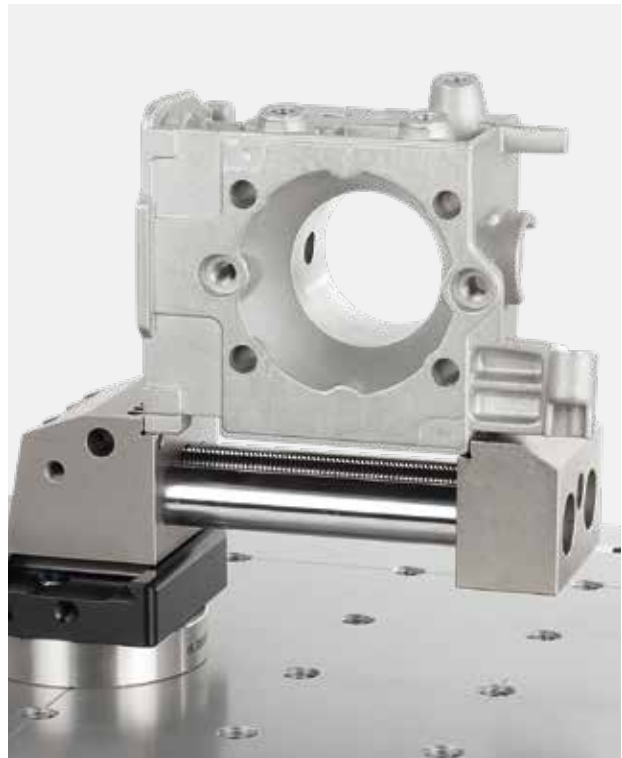
External clamping with pins for additional elevation for optimum accessibility to all faces.



Internal clamping with pins for additional elevation.



Precise repeatable clamping with adjustable stop.



Clamping width extended to 75 mm, 100 mm or 150 mm using accessories.

80 mm precision vice

Description

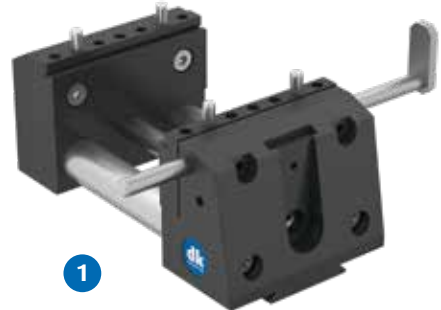
Vice with exchangeable clamping width extension guide shafts. SWA 39 quick-change adapter integrated in the vice base. For flexible fastening of the vice, version 308300 includes two additional SWA 39 quick-change adapters offset through 90°. With stepped jaws and Ø5 mm holes for clamping pins.

Material

Hard-coated aluminium with surface hardened steel jaws.

Supplied with

1 adjustable stop (318110), an extra set of shafts for extending the clamping width up to 130 mm, 4 clamping pins and operating tools.



Order No.	Jaw width	Clamping width	Fastening	Weight	Fig.
308200	80	80 / 130*	on the base	1.65	1
308300	80	80 / 130*	on the base or on two sides offset 90° to each other	1.7	

SWA 39

* Can be extended up to 200 mm with extra shaft sets.

Positioning options for 308300 with an SWA 39 interface on 3 different sides:

Application example



a) Standard



b) Sideways



c) Upright

+ Shaft set for clamping range extension

Order No.	Material	Jaw width	Supplied with	Description
307700	Surface hardened steel	-	1 set of 2 guide shafts and 1 threaded spindle	for clamping range extension up to 200 mm



+ Smooth jaws

Order No.	Material	Jaw width	Contents	Description
307000	Stainless steel	80	1 set	-



+ Form jaws with small prisms

Order No.	Material	Jaw width	Supplied with	Clamping diameter
307300	Stainless steel	80	1 set jaws one smooth and one prism jaw	recommended vertical and horizontal from 5 mm



+ Form jaws with prisms for end-face clamping

Order No.	Material	Jaw width	Contents	Clamping diameter
307601	Stainless steel	80	1 set	recommended from 20 to 85 mm



+ Two-point contact prism jaws

Order No.	Material	Jaw width	Supplied with	Clamping diameter
306915	Hard-coated aluminium	7.5	1 prism jaw and 1 straight jaw	8-50 mm



+ Three-point contact prism jaws

Order No.	Material	Jaw width	Supplied with	Clamping diameter
306810	Hard-coated aluminium	5+16	1 double prism jaw and 1 straight jaw	2-50 mm



+ Jaws with 2 rows of pins holes

Order No.	Material	Jaw width	Contents	Description
307610	Steel	80	1 set	for Ø5 mm pins



Accessories

+ Universal stop

Order No.	Material	Supplied with	Description
277510	Steel	With 2 exchangeable stop points	



+ Clamping pins, stepped

Order No.	Contact face	Length	Contents	Description
307800	Straight	26 x 05	Set of 4	for raised part
307810	Straight	36 x 05	Set of 4	positioning
326600	120° prism	30 x 05	2 prism pairs	
326610	120° prism	35 x 05	2 prism pairs	

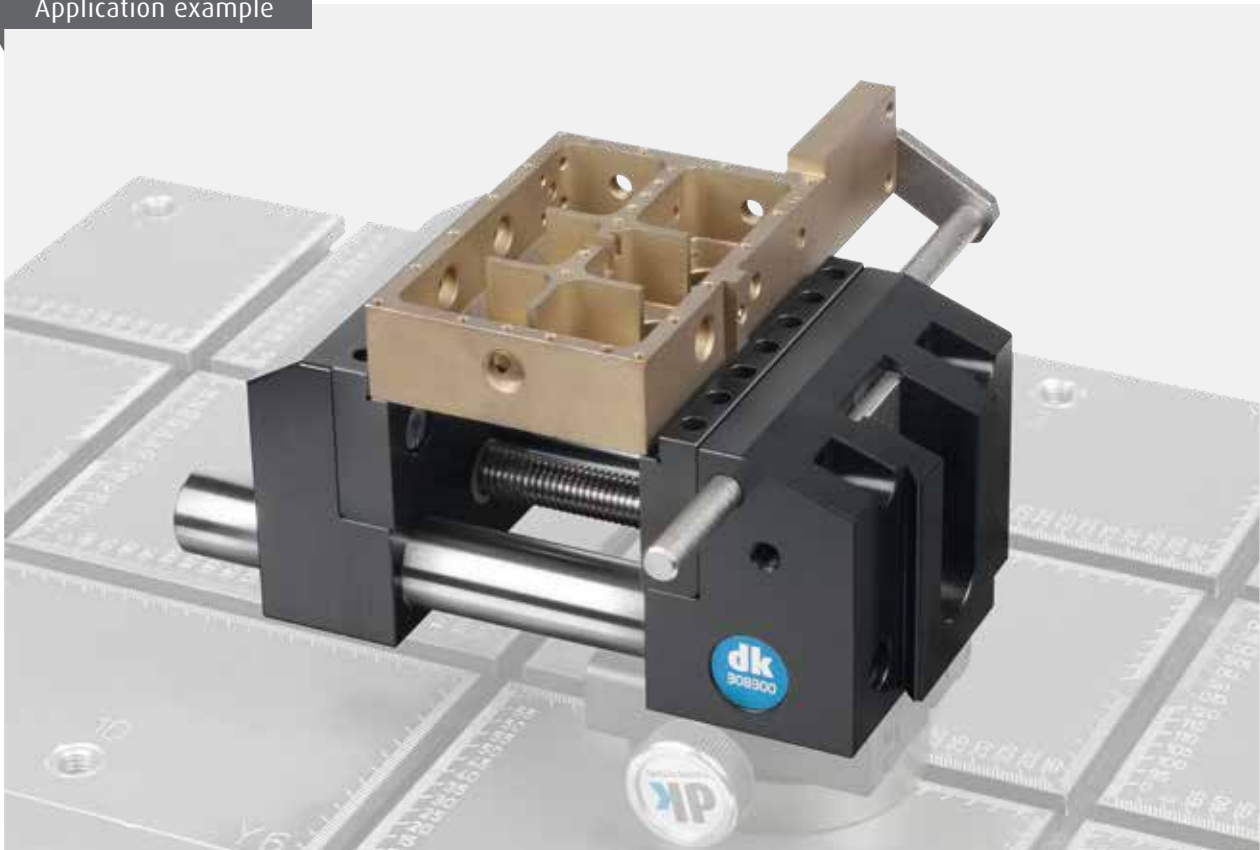


+ Stop for vices

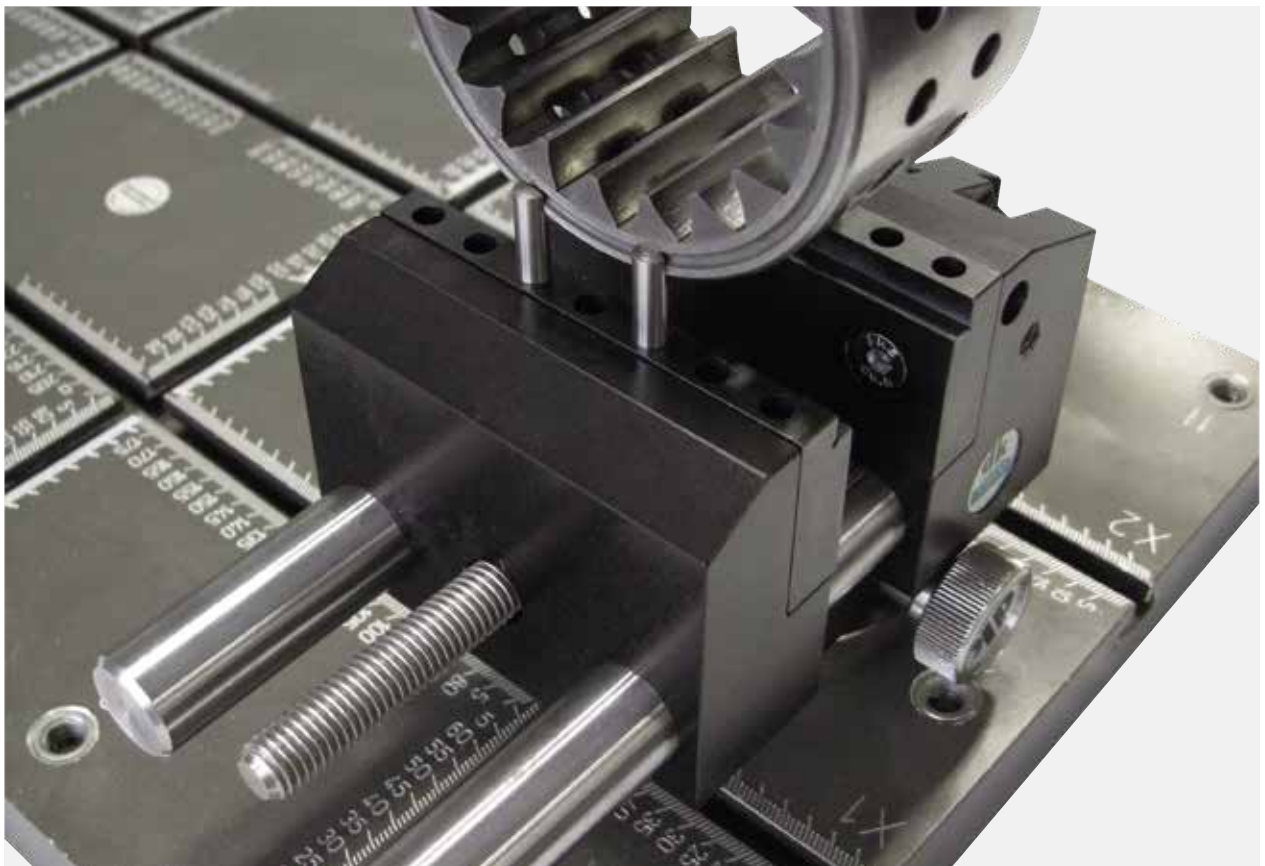
Order No.	Material	Length	Overhang	Description
318100	Steel	50	20	
318200	Steel	50	40	
318110	Steel	150	20	
318210	Steel	150	40	



Application example



Application example



100 mm precision vice

Description

Vice with exchangeable clamping width extension guide shafts. SWA 39 quick-change adapter integrated in the vice base. With stepped jaws and Ø5 mm holes for clamping pins.

Material

Hard-coated aluminium with surface hardened steel jaws.

Supplied with

1 adjustable stop (318110), an extra set of shafts for extending the clamping width up to 170 mm, 4 pins and operating tools.



Order No.	Jaw width	Clamping width	Weight
308500	100	80 / 170*	2.45

SWA 39

* Can be extended up to 220 mm with extra shaft sets.

Accessories

+ Shaft set for clamping range extension

Order No.	Material	Jaw width	Supplied with	Description
309600	Surface hardened steel	-	1 set of 2 guide shafts and 1 threaded spindle	for clamping range extension up to 220 mm



+ Smooth jaws

Order No.	Material	Jaw width	Contents	Description
308700	Stainless steel	100	1 set	-



+ Form jaws with small prisms

Order No.	Material	Jaw width	Supplied with	Clamping diameter
309000	Stainless steel	100	1 set jaws one smooth and one prism jaw	recommended vertical and horizontal from 5 mm



+ Form jaws with prisms for end-face clamping

Order No.	Material	Jaw width	Contents	Clamping diameter
309301	Stainless steel	100	1 set	recommended from 20 to 120 mm



+ Clamping pins, stepped

Order No.	Contact face	Length	Contents	Description
307800	Straight	26 x Ø5	Set of 4	for raised part positioning
307810	Straight	36 x Ø5	Set of 4	
326600	120° prism	30 x Ø5	2 prism pairs	
326610	120° prism	35 x Ø5	2 prism pairs	



+ Universal stop

Order No.	Material	Supplied with
277510	Steel	2 exchangeable stop points

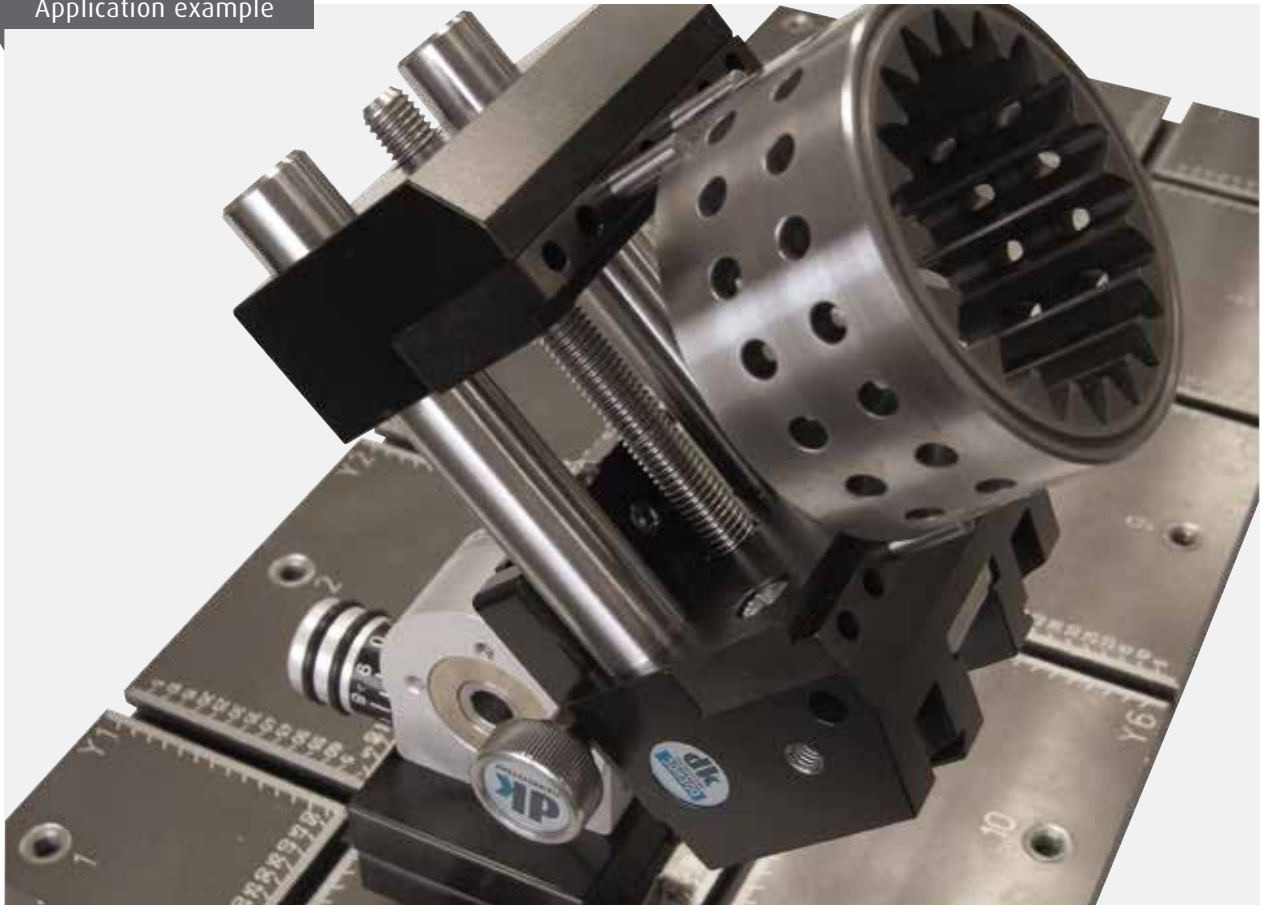


+ Stops for vices

Order No.	Material	Length	Overhang	Description
318100	Steel	50	20	
318200	Steel	50	40	
318110	Steel	150	20	
318210	Steel	150	40	



Application example



125 mm precision vice

Description

Vice with exchangeable clamping width extension guide shafts. SWA 39 quick-change adapter integrated in the vice base. With stepped jaws and $\varnothing 6$ mm holes for clamping pins.

Material

Hard-coated aluminium with surface hardened steel jaws.

Supplied with

1 adjustable stop (318110), an extra set of shafts for extending the clamping width up to 170 mm, 4 pins and operating tools.



Order No.	Jaw width	Clamping width	Weight
308600	125	80 / 170*	3.30

SWA 39

* Can be extended up to 220 mm with extra shaft sets.

Accessories

+ Shaft set for clamping range extension

Order No.	Material	Jaw width	Supplied with	Description
309600	Surface hardened steel	-	1 set of 2 guide shafts and 1 threaded spindle	For clamping range extension up to 220 mm



+ Smooth jaws

Order No.	Material	Jaw width	Contents	Description
308820	Stainless steel	125	1 set with fastening screws	-



+ Form jaws with small prisms

Order No.	Material	Jaw width	Supplied with	Clamping diameter
309400	Stainless steel	125	1 set jaws one smooth and one prism jaw	recommended vertical and horizontal from 5 mm



+ Form jaws with prisms for end-face clamping

Order No.	Material	Jaw width	Contents	Clamping diameter
309501	Stainless steel	125	1 set	25 to 180 mm



+ Clamping pins, stepped

Order No.	Contact face	Length	Contents	Description
307850	Straight	32 x Ø6	Set of 4	for raised part positioning
326650	120° prism	30 x Ø6	2 prism pairs	



+ Universal stop

Order No.	Material	Supplied with
277510	Steel	2 exchangeable stop points

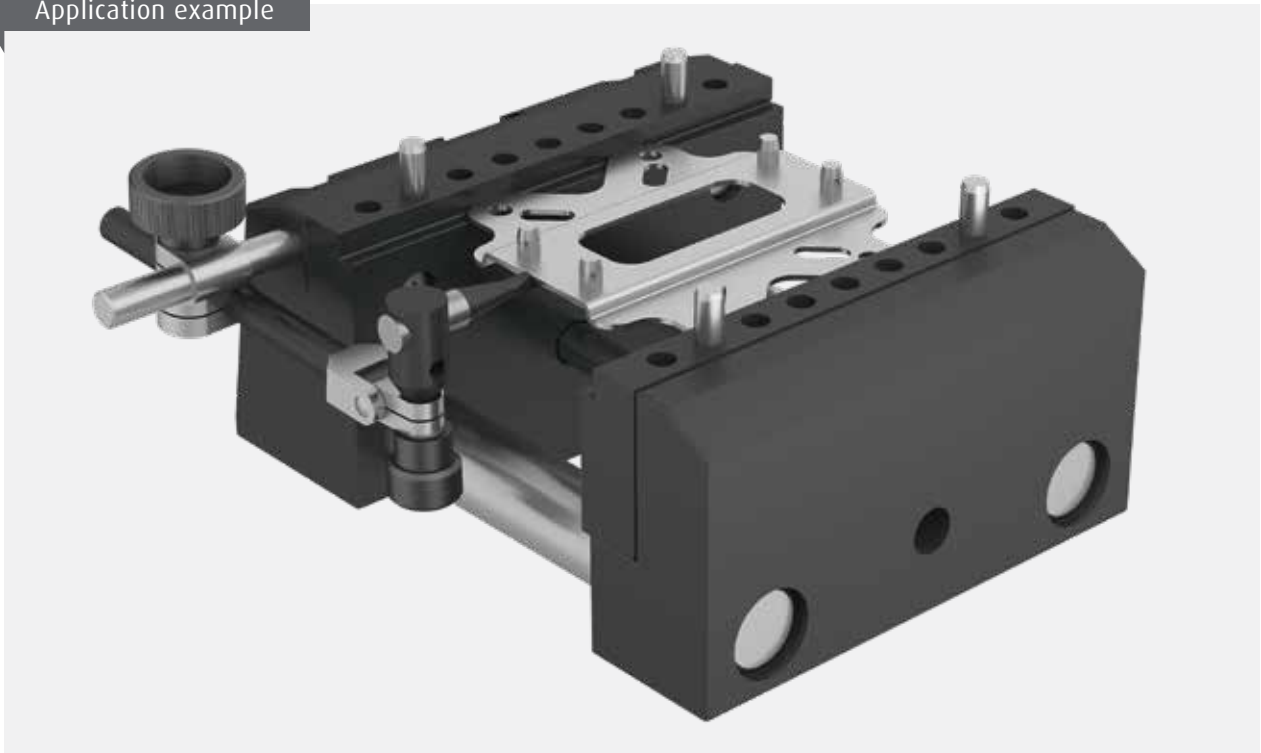


+ Stops for vices

Order No.	Material	Length	Overhang	Description
318100	Steel	50	20	
318200	Steel	50	40	
318110	Steel	150	20	
318210	Steel	150	40	



Application example



Precision mini chuck

Description

Precision mini chuck with externally offset clamping jaws. For internal and external clamping of rotationally symmetrical parts. Mounted on an SWA 39 or SWA 5 quick-change adapter.

Material

Hard-coated aluminium/steel.



SWA 39

SWA 5

Order No.	Connection	Int. clamping Ø	Ext. clamping Ø	Height	Diameter	Fig.
283700	SWA 39	0.2-3	3-5	59	24	
283900	SWA 39	0.5-5	5-9	79	32	1
283600	SWA 5	0.2-3	3-5	60	24	2
283800	SWA 5	0.5-5	5-9	80	32	

Application example



Precision collet chuck ER 16

Description

ER 16 collet chuck for 0.5–10 mm collets. With SWA 39 quick-change adapter.



Application example



Order No.	Version	Length	Width	Height	Weight
283480	ER 16	60	60	65	0.35

Accessories

+ Collets

Order No.	Material	Clamping Ø	Description
263400	Steel	0.5–1	collets suitable for collet chuck ER 16
263401		1–2	
263402		2–3	
263403		3–4	
263404		4–5	
263405		5–6	
263406		6–7	
263407		7–8	
263408		8–9	
263409		9–10	



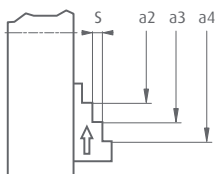
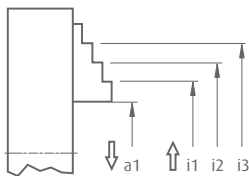
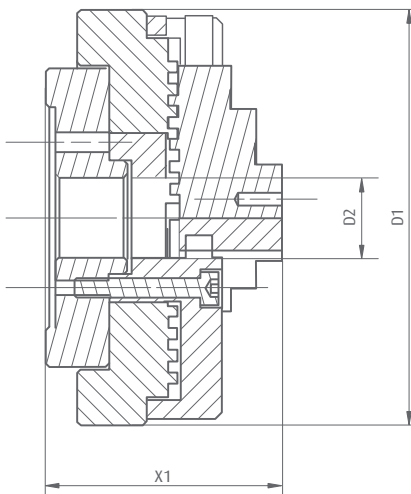
+ Complete set of collets

Order No.	Material	Clamping Ø	Description
263450	Steel	0.5–10	Complete set of collets 0.5–10 mm (parts 263400–263409) for ER 16 collet chuck

Description

General information about our dk precision three-jaw chucks

dk precision three-jaw manual chucks represent quality, precision and smooth operation. The compact design and use of aluminium for the 100 mm and 160 mm version bodies make the chucks easy and ergonomic to operate with metrology machines. The 34 mm to 100 mm sizes are fitted with reversible jaws, providing a wide clamping range for internal and external clamping. Exchange jaws are available as accessories with the 160 mm chuck. The diverse interfaces make the chucks compatible with the measurement fixating systems from dk.



Technical data

	34 mm	50 mm	65 mm	100 mm	160 mm
d1	35	52.5	65	106	162
d2	12	11	13	15	34
x1	18.5	37.5	37.5	47.5	80

Clamping range

	34 mm	50 mm	65 mm	100 mm	160 mm
i1	11-23	17-35	17-47	20-60	38-100
i2		35-53	35-65	40-80	90-160
i3				60-100	
a1	1-14	1-18	1-30	1-40	2.5-70
a2	20-32	18-36	18-48	28-66	42-120
a3		36-54	36-66	48-84	100-160
a4				68-102	
s	4.3	4	4	4.5	10

Interfaces

Interface	34 mm	50 mm	65 mm	100 mm	160 mm
SWA 39	329000	329705	329700	283220	330310
SWA 5	329010				
3 x M2	329030				
3 x M4		329720	329710		
4 x M6				283225	330315
Plate 30x30x8	329020				
MK 2		329725	329715		



SWA 39



3 x M4

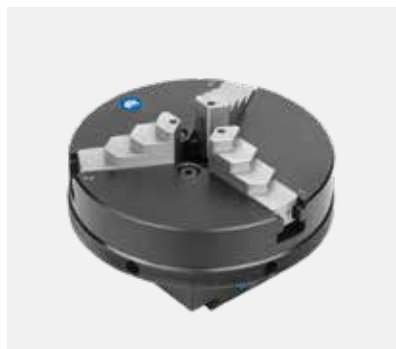


MK 2



SWA 5

Application examples



34 mm precision three-jaw chuck

Description

Hand operated three-jaw chuck with tool-free reversible jaws for internal and external clamping of rotationally symmetrical work-pieces.

Chuck precision without further attachments:

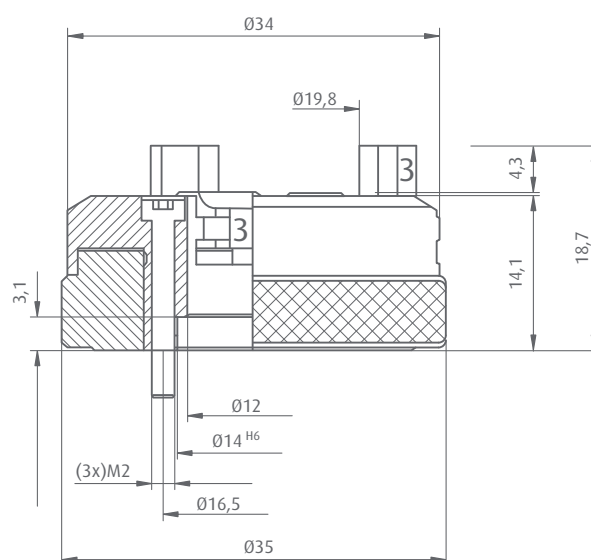
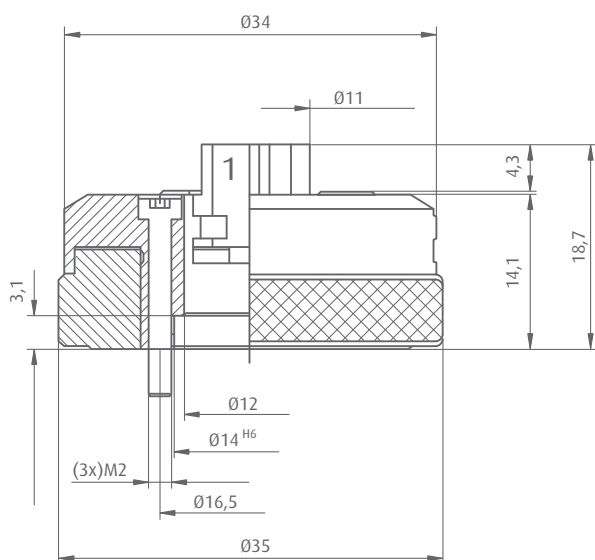
Radial run-out < 0.03 mm

Axial run-out < 0.01 mm

Repeat accuracy < 0.01 mm

With an SWA 39 quick-change adapter.

Also available with an SWA 5 quick-change adapter that can also be held on the 14 mm OD.



Order No.	Size	Connection	Height
329000	34	SWA 39	72
329010	34	SWA 5	38.5
329020	34	Plate 30x30x8	26.5
329030	34	3x M2 on D 16.5	18.5

Please note: Part 329030 can only be used in conjunction with customer-specific attachments!

Application example



50 mm precision three-jaw chuck

Description

Hand operated three-jaw chuck with tool-free reversible jaws for internal and external clamping of rotationally symmetrical workpieces. With pin holes and 2 sets of pins of different lengths for elevating parts for access from all sides.

Pin holes $\varnothing 2 \times 7$ mm deep.

Chuck precision without further attachments:

Radial runout < 0.03 mm

Axial run-out < 0.01 mm

Repeat accuracy < 0.01 mm

With an SWA 39 quick-change adapter.

Also available with fastening holes or MK 2 Morse taper.

Material

Steel and hard-coated aluminium.

Supplied with

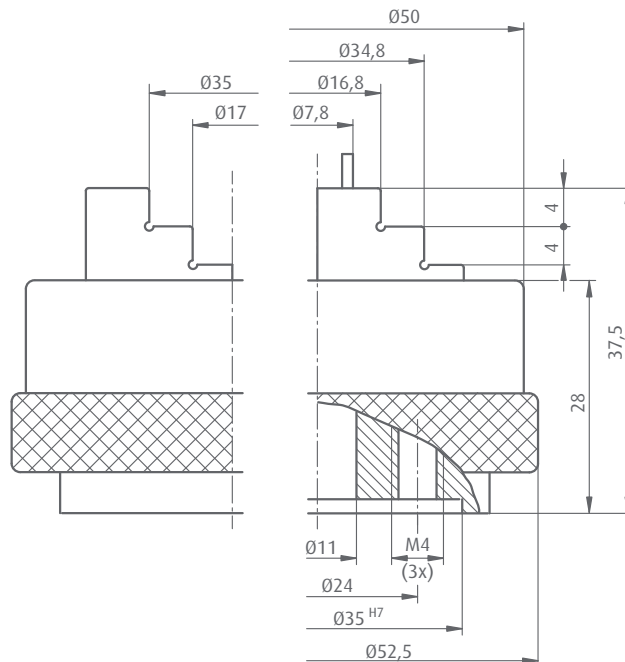
Operating tools and 2 sets of 3 pins 12 mm and 18 mm long.



2



3



Order No.	Size	Connection	Height	Fig.
329705	50	SWA 39	58	1
329720	50	3x M4	38	2
329725	50	MK 2*	46.5	3

* Other adapter types available on request.



+ Seating spacers for 3-jaw chucks

Description

A set of spacers used to limit the depth a workpiece is set in the jaws and ensure repeat setup accuracy.

Material

Engineering plastic.

Contents

3 spacers with different heights.



Order No.	Suitable for	Contents	Height 1	Height 2	Height 3
283250	50 mm and 65 mm 3 jaw chucks	Set of 3	3	5	7

+ Soft jaws for 3-jaw chucks

Description

A set of soft jaws for machining to suit specific applications.

Material

Bronze



Order No.	Suitable for	Contents
329730	50 mm and 65 mm 3-jaw chucks	Set of 3

Application example



65 mm precision three-jaw chuck

Description

Hand operated three-jaw chuck with tool-free reversible jaws for internal and external clamping of rotationally symmetrical workpieces. With pin holes and 2 sets of pins of different lengths for elevating parts for access from all sides.

Pin holes $\varnothing 2 \times 7$ mm deep.

Chuck precision without further attachments:

Radial runout < 0.03 mm

Axial run-out < 0.01 mm

Repeat accuracy < 0.01 mm

With an SWA 39 quick-change adapter.

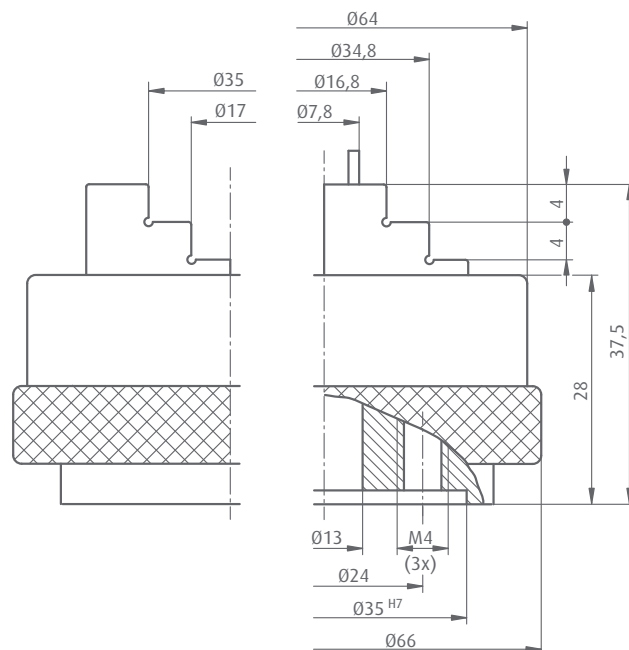
Also available with fastening holes or MK 2 Morse taper..

Material

Steel and hard-coated aluminium.

Supplied with

Operating tools and 2 sets of 3 pins 12 mm and 18 mm long.



Order No.	Size	Connection	Height	Fig.
329700	65	SWA 39	58	1
329710	65	3x M4	38	2
329715	65	MK 2*	46.5	3

* Other adapter types available on request.



+ Seating spacers for 3-jaw chucks

Description

A set of spacers used to limit the depth a workpiece is set in the jaws and ensure repeat setup accuracy.

Material

Engineering plastic.

Contents

3 spacers with different heights.



Order No.	Suitable for	Contents	Height 1	Height 2	Height 3
283250	50 mm and 65 mm 3-jaw chucks	Set of 3	3	5	7

+ Soft jaws for 3-jaw chucks

Description

A set of soft jaws for machining to suit specific applications.

Material

Bronze



Order No.	Suitable for	Contents
329730	50 mm and 65 mm 3-jaw chucks	Set of 3

Application example



100 mm precision three-jaw chuck

Description

Hand operated three-jaw chuck with tool-free reversible jaws for internal and external clamping of rotationally symmetrical workpieces. With $\varnothing 3 \times 8$ mm deep pin holes and 3 sets of pins of different lengths for elevating parts for access from all sides. Chuck precision without further attachments:
 Radial runout < 0.03 mm
 Axial run-out < 0.01 mm
 Repeat accuracy < 0.01 mm
 Aluminium housing for weight reduction.
 With an SWA 39 quick-change adapter.
 Also available with fastening holes.



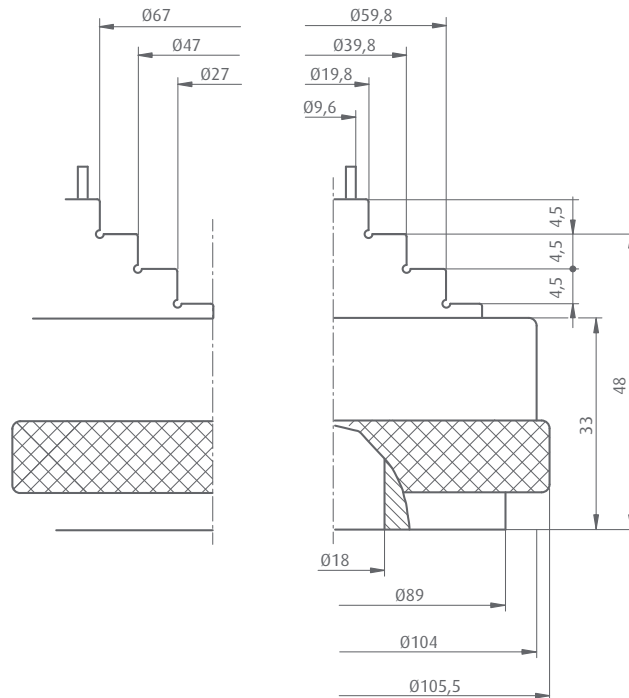
Material

Hard-coated aluminium. Hardened steel jaws.

Supplied with

Operating tools and 3 sets of pins 12 mm, 18 mm and 24 mm long.

↪ For hole dimensions for part 283225 see page 72.



Order No.	Size	Version	Height	Weight
283220	100	SWA 39	80	1.9
283225	100	4x M6	60	1.7



+ Seating spacers for 3-jaw chucks

Description

A set of spacers used to limit the depth a workpiece is set in the jaws and ensure repeat setup accuracy.

Material

Engineering plastic.

Contents

3 spacers with different heights.



Order No.	Suitable for	Contents	Height 1	Height 2	Height 3
283255	100 mm and 160 mm 3-jaw chucks	Set of 3	5	8	12

+ Soft jaws for 3-jaw chucks

Description

A set of soft jaws for machining to suit specific applications.

Material

Soft steel.



Order No.	Suitable for	Contents
283230	100 mm 3-jaw chuck	Set of 3

Application example



160 mm precision three-jaw chuck

Description

Hand operated three-jaw chuck with tool-free reversible jaws for internal and external clamping of rotationally symmetrical workpieces. With $\varnothing 4 \times 8$ mm deep pin holes and 2 sets of pins of different lengths for elevating parts for access from all sides.

With an SWA 39 quick-change adapter.
Also available with fastening holes.

Material

Hard-coated aluminium. Hardened steel jaws.

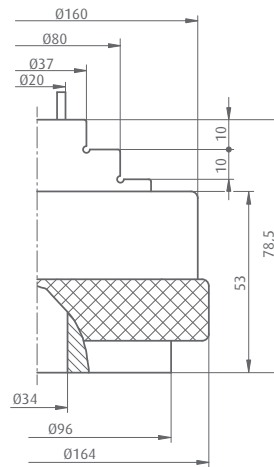
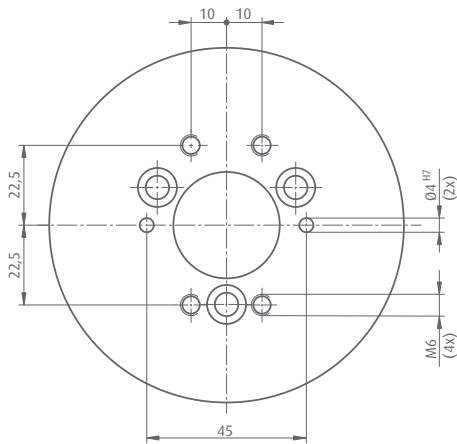
Supplied with

Operating tools and 2 sets of 3 pins 18 mm and 24 mm long.



Hole dimensions below are for 160 mm and 100 mm chucks.

Connections underneath



Order No.	Size	Version	Height	Weight
330310	160	SWA 39	102	4.9
330315	160	4x M6	82	4.7



Accessories

+ OD chuck jaws

Order No.	Material	Size	Contents	Description
330311	Steel	160	Set of 3 jaws	Hardened



+ Soft jaws

Order No.	Material	Size	Contents	Description
330312	Steel	160	Set of 3 jaws	Soft



+ Seating spacers for 3-jaw chucks

Description

A set of spacers used to limit the depth a workpiece is set in the jaws and ensure repeat setup accuracy.

Material

Engineering plastic.

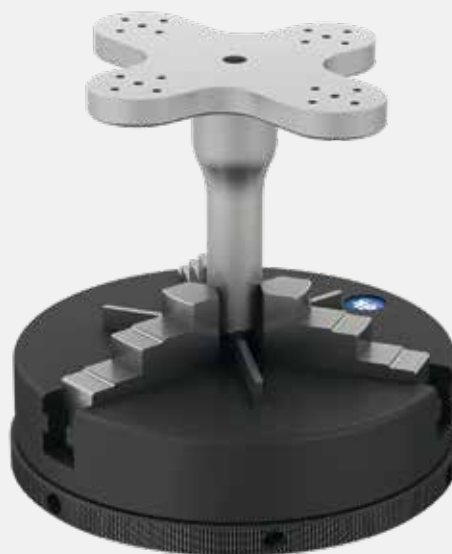
Contents

4 spacers with different heights.



Order No.	Suitable for	Contents	Height 1	Height 2	Height 3	Height 4
283260	160 mm chuck	Set of 4	5	8	12	18

Application example



Rotary table with precision three-jaw chuck

Description

Rotary mounted three-jaw manual chuck with high concentricity. For internal and external clamping of rotationally symmetrical parts. With $\varnothing 2 \times 7$ mm deep holes and 2 sets of pins of different lengths for elevating parts for access from all sides. Available with an SWA 39 quick-change adapter or base plate.

Material

Hard-coated aluminium. Hardened steel jaws.

Supplied with

Operating tools and 2 sets of pins 12 mm and 18 mm long.



Application example



Order No.	Size	Version	Radial runout	Height
267365	50	Base plate	+/- 0.025	71
267370	50	SWA 39	+/- 0.025	71
267355	65	Base plate	+/- 0.025	71
267360	65	SWA 39	+/- 0.025	71

SWA 39

M ...

Application example



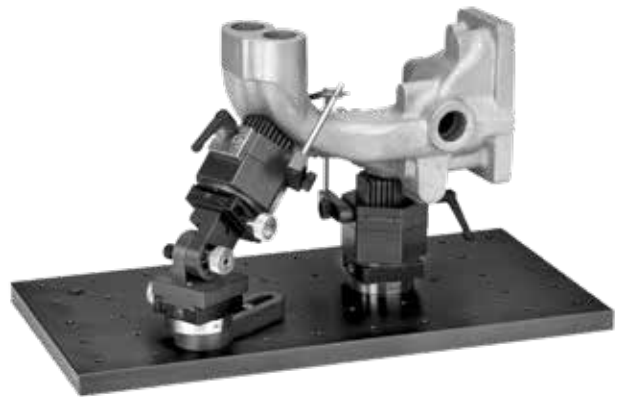
NADELFIX: fix-variable self-moulding from products

Function

Workpieces with complicated free-form geometries for which no conventional clamping equipment exists can be securely and reproducibly fixated and held with *NADELFIX*. Parts to be tested are pressed into a bed of individually sprung pins or needles which are then locked in place by a central clamp. This rapidly produced exact negative form of the test piece perfectly holds the part in place with minimum clamping force using e.g. a spring finger. There is no surface damage, as with normal vices, nor are there unreliable, improvised fixations.

Advantages

- Excellent suitability for free-form surfaces
- Secure and gentle hold through positive fit with minimum clamping force
- Time saving and cost effective due to rapid adjustment to variable workpiece geometries
- Universal clamping element rather than manufacturing and storing product-specific special fixtures
- Simple and tool-free operating principle
- Can be combined with other dk product ranges
- Modular system with a wide range of possible applications



NADELFIX 2.5

Description

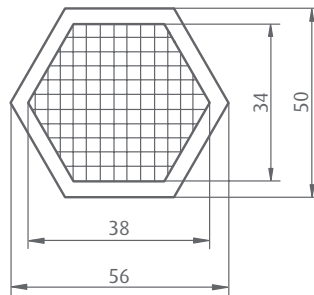
Ideal for clamping moulded parts.
With an SWA 39 quick-change mount.

Supplied with

A clamping fixture comprising rail (396120), column (269043) and spring finger (269038). Fasteners also included.



Application example



Order No.	Pin Ø	Support surface	Total height	Spring travel
396030	2.5	38 x 34	55	max. 10



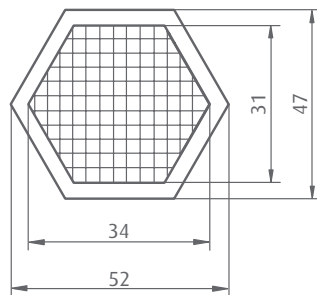
NADELFIX 5 Mini

Description

Ideal for clamping moulded parts.
Available with an SWA 39 quick-change mount or an SWA 8 quick-change mount for flexible use on articulated arms.

Supplied with

A clamping fixture, comprising rail (396110), column (368300) and spring finger (302800). Fasteners are included.



SWA 8 SWA 39

Order No.	Pin Ø	Support surface	Total height	Spring travel	Interface	Fig.
396000	5	34 x 31	90	max. 12	SWA 39	1
396005	5	34 x 31	80	max. 12	SWA 8	2

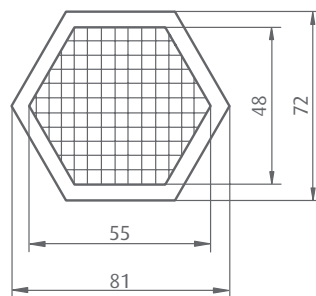
NADELFIX 5 Midi

Description

Ideal for clamping moulded parts.
With an SWA 39 quick-change mount.

Supplied with

A clamping fixture, comprising rail (396110), column (368300) and spring finger (302800). Fasteners are included.



SWA 39

Order No.	Pin Ø	Support surface	Total height	Spring travel
396010	5	55 x 48	80	max. 12

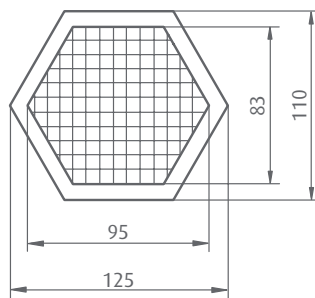
NADELFIX 5 Maxi

Description

Ideal for clamping moulded parts.
With an SWA 39 quick-change mount.

Supplied with

A clamping fixture, comprising rail (396100), column (368300) and spring finger (302800).
Fasteners are included.



Order No.	Pin Ø	Support surface	Total height	Spring travel
396020	5	95 x 83	90	max. 12

SWA 39

Application example



+ Attachment rails

Description

For flexible positioning of spring fingers on "NADELFIX".

Material

Hard-coated aluminium.



Order No.	Total length	Adjustment range	Thread
396120	50	34	M4
396110	60	33	M6

+ Columns for spring fingers

Description

Columns for mounting spring fingers.

Material

Stainless steel.



Order No.	Column Ø	Thread	Length
269042	4	M 4	30
269043	4	M 4	50
269044	4	M 4	75
368100	6	M 6	30
368200	6	M 6	50
368300	6	M 6	75
368400	6	M 6	100
368500	6	M 6	125

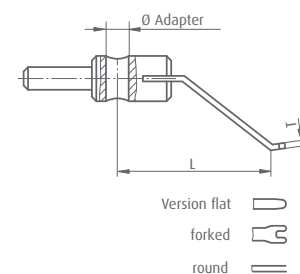
+ Spring fingers

Description

For quickly and easily holding test parts.

Material

Stainless steel.



Order No.	Adapter Ø	T	L	Version	Fig.
269037	4	0.4	30	Flat	
343700	4	0.8	30	Flat	1
269038	4	1.1	40	Round	
269039	4	1.1	60	Round	
302800	6	1	50	Flat	
302900	6	1	75	Flat	

Small-parts clamp, smooth

Description

Small-parts clamp with smooth jaws. Available with an SWA 39 quick-change adapter or with M 6 female thread.

Material

Hard-coated aluminium/steel.

Application example



1



2

Order No.	Version	Jaw width	Width (W)	Height	Fig.
275600	SWA 39	12	0.5-5	100	
276000	SWA 39	18	1.5-8	100	1
276200	SWA 39	25	3-10	120	
390200	M 6	12	0.5-5	80	
391600	M 6	18	1.5-8	80	2
276210	M 6	25	3-10	100	

SWA 39

SWA 6

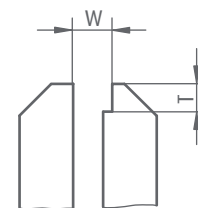
Small-parts clamp, stepped jaw one side

Description

Small-parts clamp with stepped jaw one side. Available with an SWA 39 quick-change adapter or with M 6 female thread.

Material

Hard-coated aluminium/steel.



Application example



Order No.	Version	Jaw width	Width (W)	Depth (T)	Height	Fig.
275700	SWA 39	12	1-5	2	100	
276100	SWA 39	18	2.5-8	2	100	1
276300	SWA 39	25	4-10	2	120	
390300	M 6	12	1-5	2	80	
391500	M 6	18	2.5-8	2	80	2
276310	M 6	25	4-10	2	100	

SWA 39

SWA 6

Small-parts clamp with horizontal prism

Description

Small-parts clamp with horizontal prism jaws. For clamping rotationally symmetrical parts. Available with an SWA 39 quick-change adapter or with M 6 female thread.

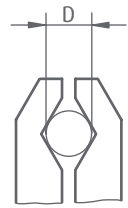
Application example



2



1



Order No.	Version	Clamping Ø (D)	Jaw width	Height	Fig.
275800	SWA 39	3.2-6	3.5	100	
275900	SWA 39	5-8.5	5	100	1
275810	M 6	3.2-6	3.5	80	
275910	M 6	5-8.5	5	80	2

SWA 39

SWA 6

Small-parts clamp with end-face prism

Description

Small-parts clamp with prismatic top face and stepped jaws for holding rotationally symmetrical parts. Mounted on an SWA 39 quick-change adapter or with an M6 female thread.

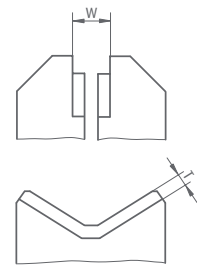
Application example



2



1



Order No.	Version	Clamping Ø	Width (W)	Depth (T)	Height	Fig.
277305	SWA 39	3-25	3-6	2	100	1
277320	SWA 39	5-35	4-10	2	100	
277300	SWA 39	6-55	4-12	3	120	
390010	M 6	3-25	3-6	2	80	2
277315	M 6	5-35	4-10	2	80	
277325	M 6	6-55	4-12	3	100	

SWA 39

M 6

Small-parts clamp for internal clamping

Description

Small-parts clamp for holding workpieces in the bore. The clamping diameter is stepped in 3 mm increments (276800 + 276805 first step = 4 mm).

Mounted on an SWA 39 quick-change adapter or with an M6 thread.



Order No.	Version	Clamping Ø	Step depth	Height	Fig.
276800	SWA 39	5-30	2	120	1
276805	M 6	5-30	2	100	2

SWA 39

M 6

Application example



Stop for small-parts clamps

Description

Stop for reproducible clamping of small parts on all types of small-parts clamps with SWA 39 adapter.

Supplied with

M6 connection screw, a flat point and Ø2 mm ball point (M2.5 screw on points).



Order No.

Overhang

277500

100

M 6

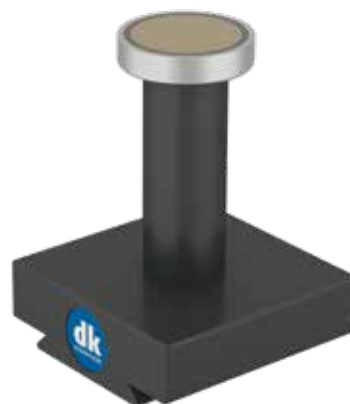
Application example



Permanent magnetic clamping fixture

Description

Permanent magnetic plate for the quick and easy holding of steel parts. Mounted on an SWA 39 quick-change adapter.



Order No.	Height	Magnet Ø	Magnetic force (N)	Weight
278000	80	32	350	0.29

SWA 39

Magnetic clamping fixture with on/off switch

Description

Permanent magnet with on/off switch for the quick and easy holding of steel parts. Mounted on an SWA 39 quick-change adapter.



Order No.	Height	Magnet Ø	Magnetic force (N)	Weight	Fig.
278200	70	50	85	0.86	1
278210	85	80	500	2.50	

SWA 39

Magnetic V-block, permanent

Description

Permanent magnetic 90° V-block for holding rotationally symmetrical parts. Mounted on an SWA 39 quick-change adapter.

Material

Hard-coated aluminium.



Order No.	Clamping range	Prism depth	Magnetic force (N)	Height
313700	Ø 15–35	16	15	100

SWA 39

Magnetic V-block with on/off switch

Description

Magnetic V-block with on/off switch for holding rotationally symmetrical parts. With mounting hole for adjustable length stop. Mounted on an SWA 39 quick-change adapter.

Material

Hard-coated aluminium/steel.

↳ See pages 43 and 46 for length stop.



Order No.	Clamping range	Prism depth	Magnetic force (N)	Height
278300	Ø 5–50	37	800	80
278310	Ø 5–50	67	1000	80

SWA 39

Small V-block with spring finger

Description

Small 120° V-block for holding rotationally symmetrical parts with spring fingers.

Mounted on an SWA 39 quick-change adapter.

Material

Aluminium/stainless steel.

Supplied with

Bracket (343800) and spring finger (343700).

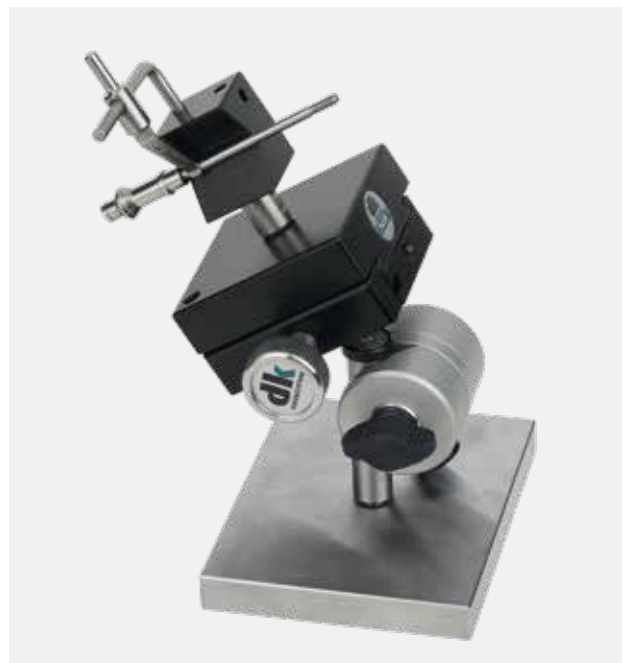


Order No.	Clamping range	Prism depth	Prism width	Connection	Height	Fig.
277410	Ø 2-25	10	30	SWA 39	65	1
277400	Ø 2-25	25	30	SWA 39	45	2
267900	Ø 2-25	25	30	SWA 5	25	3

SWA 39

SWA 5

Application examples



V-block

Description

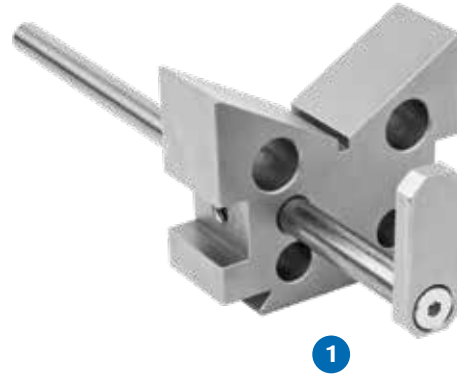
120° V-block for mounting rotationally symmetrical test parts. Adjustable length stop for reproducible clamping. With an SWA 39 quick-change adapter on the V-block base and SWA 8 connection option (272700 only). Also with lateral slots and tapped holes for mounting a tensioning strap fixture, U-clamp or spring finger.

Material

Hardened steel.

Supplied with

Adjustable length stop (318110).



Order No.	V-block length	V-block width	Prism	Fig.
272700	20	60	120°	1
272810	60	60	120°	

SWA 39

SWA 8

Application example



+ U-clamp

Description

For clamping rotationally symmetrical parts.

Material

Aluminium.



Order No.

272920

Clamping range

Ø 4–45 (for 120° V-block)

+ Spring finger with mount

Description

For quickly and easily holding parts.

Supplied with

Spring finger (302800),
Column (368300) and
Column holder (272910).



Order No.

272930

Clamping range

Ø 4–90 (for 120° V-block)

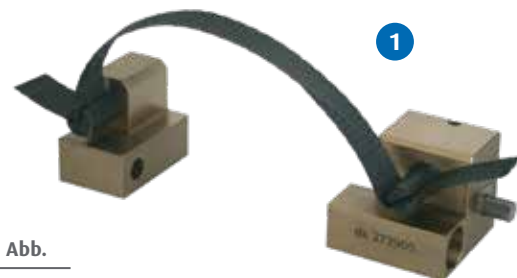
+ Tensioning strap fixture

Description

Ideal for clamping irregularly shaped parts.

Supplied with

M5 fastening screw, operating tools and 5m tensioning strap.



Order No.

272900

Clamping range

Ø 15–100

Description

Standard

Abb.

1

272850

Ø 15–100

Extra strong

272855

Adapter for mounting 272850 on T-slots 6

272902

Adjustable torque wrench

Pair of V-block halves on a T-slot 6

Description

V-blocks halves for T-slots. The clamping range is freely adjustable. With lateral slots and tapped holes for mounting a tensioning strap fixture or spring finger. Part 306500 with mounting hole for stops.

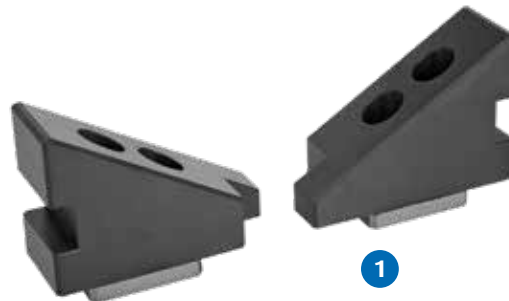
☞ See pages 43 and 46 for length stops (stop for vices).

Material

Hard-coated aluminium/steel.

Supplied with

Screws and slot keys



Order No.	Prism	Block length	Height	Fig.
305500	120°	18	42	1
305700	120°	25	42	
306500	120°	40	52	

T-Nut 6

Application example



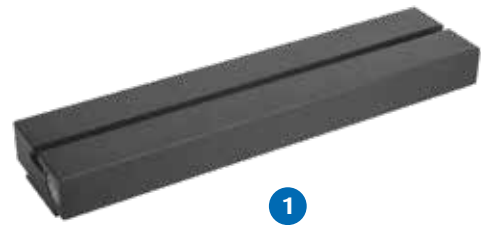
+ Adapter plates with T-slot 6

Description

Baseplate with T-slot 6 for mounting various modules e.g. structural elements from the *SPANNFIX* range. With an SWA 39 quick-change adapter for mounting on the SWA 39 basic elements.

Material

Hard-coated aluminium/steel.



Order No.	Length	Width	Height	Fig.
305000	140	60	24	
305100	250	60	24	1
305110	500	60	24	

T-Nut 6
SWA 39

+ Spring finger with mount

Description

For quickly and easily holding parts.

Supplied with

Adjustable spring finger (302810), column (368500) and column holder (272910).



Order No.	Clamping range
272940	Ø 40-120

🔗 See pages 130 and 133 for other spring fingers in *Spannfix PRO* range.

+ Tensioning strap fixture

Description

Ideal for clamping irregularly shaped parts.

Supplied with

M5 fastening screw, operating tools and 5m tensioning strap.



Order No.	Clamping range	Description
272900	From ca. Ø 40	Standard
272850	From ca. Ø 40	Extra strong
272902	Adjustable torque wrench	

Airbase pneumatic glide foot

Description

Basic attachment for SWA 39 modular elements on smooth surfaces. Easy glide on an air cushion. Fix in place by vacuum. Connection module with SWA 39 interface. Maximum load ca. 15 kg. Operating pressure 4.5 to 6 bar. Operate only with dry, oil-free air.

With port for vacuum generation in other elements that may be connected.



Order No.	Length	Width	Height	Weight
270200	300	200	110	3.3

SWA 39

Vacuum plate – round

Description

High-strength aluminium round vacuum plate. With seal grooves and stop for reproducible part setups. ON/OFF switch with rapid air venting. Mounted on an SWA 39 quick-change adapter.

Material

Aluminium.

Supplied with

Seal and connection hose (D 5).



Order No.	Max. vacuum area
294700	Ø 30

SWA 39

Vacuum plate – square

Description

High-strength aluminium vacuum plate. With seal grooves and stops for reproducible part setups. ON/OFF switch with rapid air venting. Mounted on an SWA 39 quick-change adapter.

Material

Aluminium.

Supplied with

Seal and connection hose (D 5).



Order No.

Max. vacuum area

294000

100 x 100

SWA 39

Application example



Clamping sets "A"

Description

Set "A" with basic, structural and key clamping elements. The precision vice and the chuck from the expanded set can both be mounted directly to the quick-action base as a kind of zero-point clamping fixture.

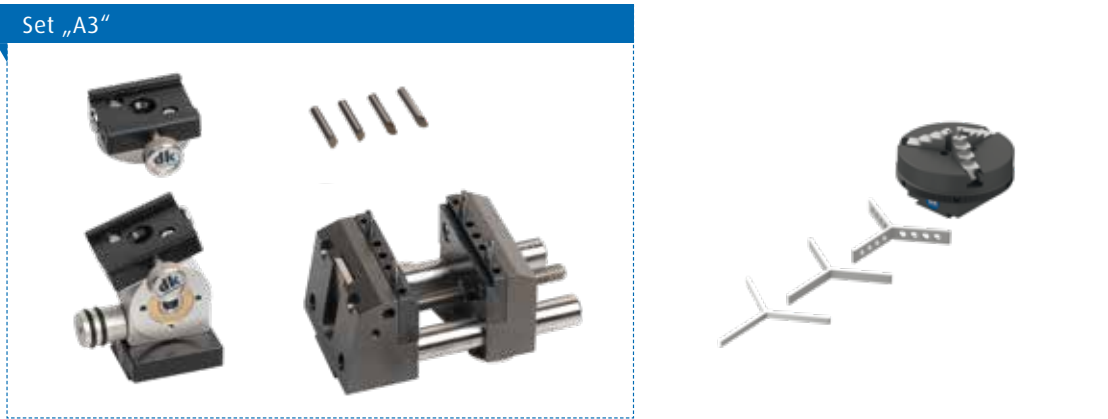
Alternatively, a swivel unit can be mounted in between enabling 3D spatial positioning of the clamping element and workpiece. This enables zero-point clamping with variable alignment, and scales ensure that positions can always be exactly reproduced for different workpieces.

Ordering information

When ordering, select the appropriate quick-action clamp or let us know the thread or T-slot size on your measuring equipment.

Set „A3+“

Set „A3“



Set versions

Order No.	Description
340530	Clamping set "A3"
340540	Clamping set "A3+"

Set contents

Order No.	Description	Set "A3"	Set "A3+"
308200	80 mm precision vice	1	1
307800	Pins with straight faces for vice jaws (set of 4)	1	1
326600	Pins with prism faces for vice jaws (set of 4)	1	1
283220	100 mm precision three-jaw chuck		1
314010	Quick-action clamp swivel unit	1	1
283255	Seating spacers to raise workpieces for 100 mm chuck, 5 mm, 8 mm and 12 mm high.		1
See below	Quick-action clamp	1	1

Order No.	Fastening
285206	M 6
285208	M 8
285210	M 10
285212	M 12
285300	T-slot

Clamping set "B"

Description

Set "B" with basic, structural and essential clamping elements. The precision vice with a range of accessories, chuck and small-parts clamp can be mounted directly to the quick-action basic clamp as a kind of zero-point clamping fixture. Alternatively, a rotary and swivel unit can be mounted in between enabling 3D spatial positioning of the clamping element and workpiece. This enables zero-point clamping with variable alignment, and scales ensure that positions can always be exactly reproduced for different workpieces.

Ordering information

When ordering, select the appropriate quick-action clamp or let us know the thread or T-slot size on your measuring equipment.



Set versions

Order No.	Description
340615	Clamping set "B"

Set contents

Order No.	Description	Quantity
282100	50 mm vice with accessories	1
329700	65 mm chuck	1
283250	Seating spacers to raise workpieces for 65 mm chuck, 3 mm, 5 mm and 7 mm high.	1
275600	Small-parts clamp, smooth	1
314020	Quick-action rotary and pivot unit clamp	1
See below	Quick-action clamp	
	Order No.	Fastening
	285206	M 6
	285208	M 8
	285210	M 10
	285212	M 12
	285300	T-slot

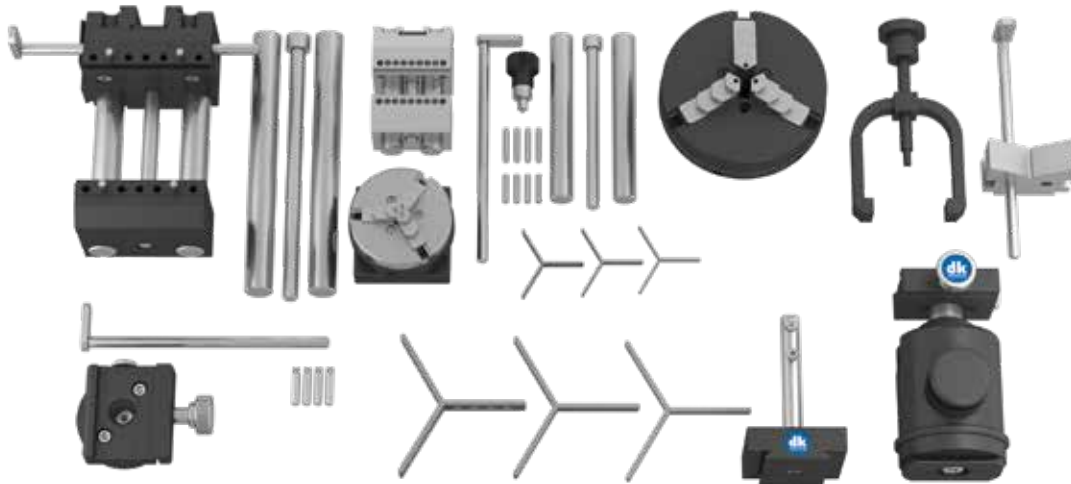
Clamping set "C"

Description

Set "C" with basic, structural and a range of clamping elements in various sizes. The 50 mm precision vice with a range of accessories, 80 mm vice, 65 mm and 100 mm chucks, small-parts clamp and V-block with stop and U-clamp can be mounted directly to the quick-action basic clamp as a kind of zero-point clamping fixture. Alternatively, a 3D adjustment unit can be mounted in between enabling 3D spatial positioning of the clamping element and workpiece. This enables zero-point clamping with variable, spatial alignment for a variety of workpiece geometries and sizes.

Ordering information

When ordering, select the appropriate quick-action clamp or let us know the thread or T-slot size on your measuring equipment.



Set versions

Order No.	Description
340700	Clamping set "C"

Set contents

Order No.	Description	Quantity
282100	50 mm vice with accessories	1
282300	Set of stepped pins for 50 mm vice	1
308300	80 mm vice with connections for SWA 39 on 3 faces	1
307800	Set of stepped pins for 80 mm vice	1
329700	65 mm chuck	1
283250	Seating spacers for 65 mm chuck, 3, 5, and 7 mm high.	1
283220	100 mm chuck	1
283255	Seating spacers for 100 mm chuck, 5, 8, and 12 mm high.	1
272700	120° V-block	1
272920	U-clamp for V-block	1

Order No.	Description	Quantity
275600	Small-parts clamp, smooth	1
270500	Swivel unit with ball joint	1
See below	Quick-action clamps	
Order No.	Fastening	
285206	M 6	
285208	M 8	
285210	M 10	
285212	M 12	
285300	T-slot	

Application examples

