

EASY. SECURED. CLAMPED.

# CLAMPING DEVICES

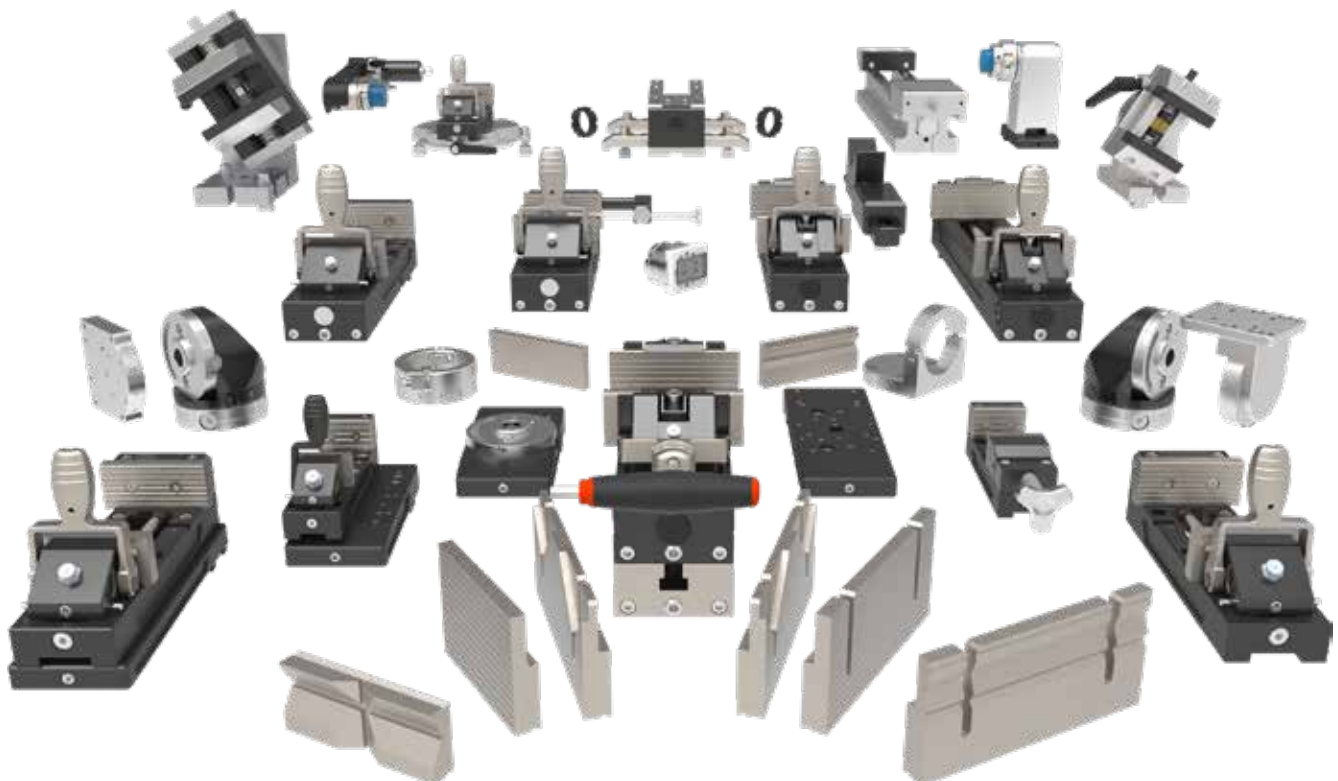
# Fast, Powerful, Flexible

Our innovative clamping devices are used to clamp workpieces securely and precisely to ensure exact cutting and grinding processes. There is a wide range of different clamping devices that have been developed for specific applications and workpiece sizes. This brochure will give you a comprehensive insight into the world of clamping devices and help you find the optimum clamping device for your application.



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# Clamping Device Selection Guide

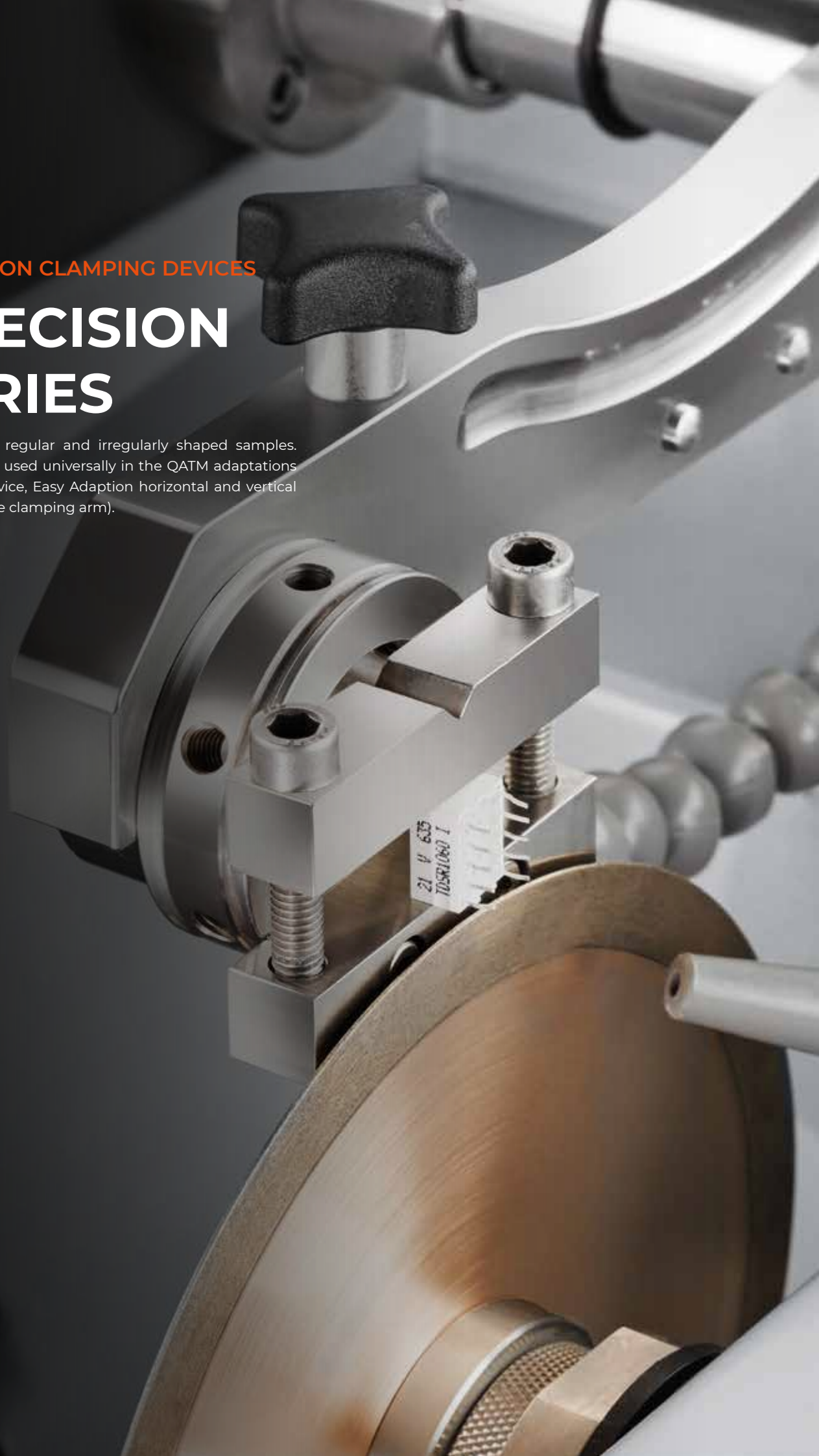
	Regularly shaped workpieces			
	Precision Series	Qtool 40 Series	Qtool 60 Series	Qtool 80 Series
Max. sample size	max. L = 40 mm / Ø 40 mm	max. L = 60 mm / Ø 40 mm	max. L = 100 mm / Ø 60 mm	max. L = 250 mm / Ø 80 mm
Qcut 150 M / Qcut 150 A				
Qcut 200 A				
Brillant 230				
Qcut 250 M / Qcut 250 A				
Qcut 350 A				
Qcut 400 A				
Qcut 500 A				
Qcut 600 A / Qcut 600 BOT				
<b>CLAMPING FORCE</b>				
Clamping Force	variable	ca. 1000 N	ca. 2000 N	ca. 4000 N
<b>ACCESSORIES</b>				
Easy Clamping system	Easy plate S	Easy plate S / M	Easy plate S / M	integrated
Accessories	Easy adaption horizontal / vertical	Selection of clamping jaws	Selection of clamping jaws / workpiece stop	Selection of clamping jaws / Easy multifunctional plate
<b>ACCESSORIES FOR SWIVEL CLAMPING DEVICES (VERTICAL AXIS OF ROTATION)</b>				
	Option: + Easy plate S with rotation function + Easy adaption horizontal	Option 1: + Easy plate S with rotation function + Easy adaption Qtool 40/60 Option 2: + Easy plate M + Multi-Tower turntable + Easy adaption Qtool 40/60	Option: + Swivel unit Qtool 60-80	
<b>ACCESSORIES FOR SWIVEL CLAMPING DEVICES (HORIZONTAL AXIS OF ROTATION)</b>				
	Option: + Easy plate S with rotation function + Easy adaption vertical	Option 1: + Easy plate S with rotation function + Multi-Tower (as often as needed) + Swivel unit Qtool 40-60 Option 2: + Easy plate M + Multi-Tower turntable + Multi-Tower (as often as needed) + Swivel unit Qtool 40-60	Alternative clamping device: - Angle vice 40 - Angle vice 80	

Regularly shaped workpieces		Irregularly shaped workpieces (Clamping on the table)	Rotation devices	
Universal power clamping system LC90	Universal power clamping system 100/540	Universal vice	Qcut 150 A / Type RD1	Qcut 200 A / Type RD2
				
max. L = 217 mm / Ø 100 mm	max. L = 365 mm / Ø 100 mm		Ø 40 mm	Ø 56 mm
<b>CLAMPING FORCE</b>		<b>CLAMPING FORCE</b>		
25 kN	28 kN	Piccolo, Universal, chain vice		
<b>ACCESSORIES</b>		<b>ACCESSORIES</b>		
-	-	-	-	-
Selection of clamping jaws / X-Clamp	Selection of clamping jaws / X-Clamp	Clamping rail, prisms / Height adapter etc.	Clamping vices / precision series / reduction ring / 3 jaw chuck	
-	-	Option: Manual turntable		
-Base 90°	-	-		

## PRECISION CLAMPING DEVICES

# PRECISION SERIES

Suitable for regular and irregularly shaped samples. They can be used universally in the QATM adaptations (rotating device, Easy Adaption horizontal and vertical as well as the clamping arm).



# Precision clamping devices

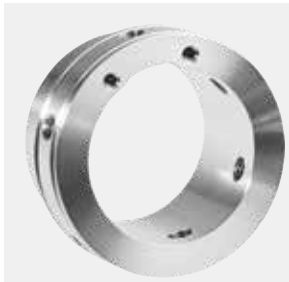
## Can be installed directly on:

- | Easy adaption vertical
- | Easy adaption horizontal
- | Rotation device type RD1 and RD2

## Accessories

- | Easy clamping plate S with rotating device
- | Easy clamping plate S

## SAMPLE HOLDER STANDARD (OPEN)



- | For round or irregular samples
- | 3-point tension
- | Up to 6 fixing screws
- | Open for long, large round samples up to Ø 40 mm
- | Adapter Ø 50 mm

Item No.: Z1870035

## SAMPLE HOLDER STANDARD (CLOSED)



- | For round or irregular samples
- | 3-point tension
- | Up to 6 mounting screws
- | With fixed stop - depth 15 mm
- | For short, large round samples up to Ø 40 mm
- | Adapter Ø 50 mm

Item No.: Z1870037

## SAMPLE HOLDER FLEX



- | For round or irregular samples
- | 3-point tension
- | Up to 6 fixing screws
- | For installation into grinding and polishing machines
- | For specimens up to Ø 40 mm - depth 21 mm
- | Adapter Ø 50 mm

Item No.: Z1870039

## SAMPLE HOLDER PARALLEL CLAMPING VICE (OPEN)



- | Parallel clamping jaws
- | Variable span
- | For flat samples
- | For samples up to Ø 40 mm
- | Adapter Ø 50 mm

Item No.: Z1870043

## SAMPLE HOLDER PARALLEL CLAMPING VICE (CLOSED)



- | Parallel clamping jaws
- | Variable span
- | For flat samples
- | With fixed stop, depth 27 mm
- | For samples up to  $\varnothing$  40 mm
- | Adapter  $\varnothing$  50 mm

Item No.: Z1870041

## DROP SHAPE SAMPLE HOLDER



- | For round or irregular samples ( $\varnothing$  13 -  $\varnothing$  40 mm)
- | 12 mm clamping depth
- | 3-point tension
- | Adapter  $\varnothing$  50 mm

Item No.: Z1870045

## UNIVERSAL CLAMPING VICE



- | For samples of any sample geometry, rings
- | Max. sample cross-section: 40 mm x 40 mm
- | 3-point tension
- | Adapter  $\varnothing$  50 mm

Item No.: Z1870047

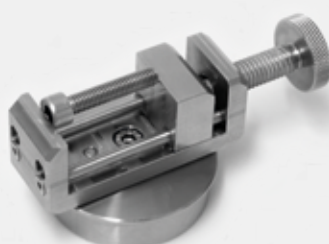
## MATRIX CLAMPING VICE



- | For irregularly shaped samples
- | Max. clamping range: 0 - 40 mm
- | Adapter  $\varnothing$  50 mm

Item No.: Z1870049

## MINI VICE

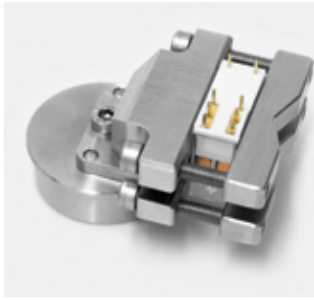


- | Max. clamping range: 0 - 40 mm
- | Clamping range with prism jaw: 0 - 35 mm
- | Incl. prism jaw
- | Adapter  $\varnothing$  50 mm

Item No.: Z1870054



## DOUBLE PARALLEL VICE



- | Parallel clamping jaws
- | Fixing a sample at two clamping points
- | Components remain clamped even after cutting
- | For cutting wheel up to Ø 150 mm
- | Max. clamping range: 0 - 40 mm
- | Adapter Ø 50 mm

Item No.: Z1870056

## ADAPTER WITH BALL JOINT



- | Swivel device for aligning the sample to the cutting wheel
- | Can be combined with all clamping devices
- | Swivel range  $\pm 18^\circ$
- | Adapter Ø 50 mm

Item No.: Z1870058



## VACUUM CLAMPING UNIT



- | For the preparation of plane-parallel sample surfaces
- | Suitable for clamping glass slides 28 mm x 48 mm
- | Stops can be recessed via an integrated handwheel for plan-parallel grinding of the ceramic stone.
- | A vacuum pump is required to generate the vacuum

For use on:

- | Qcut 150 A/M  
(clamping arm L required - Item No.: Z1870031)
- | Qcut 200 A  
(Easy adaption vertical required - Item No.: Z2236033)

Item No.: Z1870028

## REDUCER RING

NEW



- | Reducer ring for direct clamping of mounted samples
- | Outer diameter Ø 50 mm
- | For mounted samples with Ø 25 mm, 30 mm, 40 mm, 1", 1 ¼", 1 ½"
- | Can be used in rotary device and Easy adaption vertically / horizontally

For use on:

- | Qcut 150 A/M  
(clamping arm L required - Item No.: Z1870031)
- | Qcut 200 A  
(Easy adaption vertical required - Item No.: Z2236033)

Item No.: Z1870064 (Reducer ring for Ø 25 mm)

Item No.: Z1870063 (Reducer ring for Ø 30 mm)

Item No.: Z1870071 (Reducer ring for Ø 40 mm)

Item No.: Z1870067 (Reducer ring for Ø 1")

Item No.: Z1870066 (Reducer ring for Ø 1 ¼")

Item No.: Z1870065 (Reducer ring for Ø 1 ½")



## QUICK CLAMPING TOOLS

# QTOOL SERIES

- | Fast, repeat-accurate clamping
- | Regularly shaped workpieces can be clamped very fast with the help of the quick clamping systems

### High quality and robust

- | Specially coated components with extremely high surface hardness and improved corrosion protection
- | Best sliding properties
- | Minimal light reflection when working with the laser
- | Sophisticated concept: Clamping lever can be ergonomically extended
- | Optimum positioning of the component thanks to adjustable back stop

### Comprehensive range of accessories

- | Extremely quick to mount via quick-release fastener on the Easy plates
- | Gas-nitrided clamping jaws for a long service life
- | Can be individually extended with additional jaws (with prisms, bevels, slotted jaws, etc.)



# Qtool 40 Series



**Qtool 40**



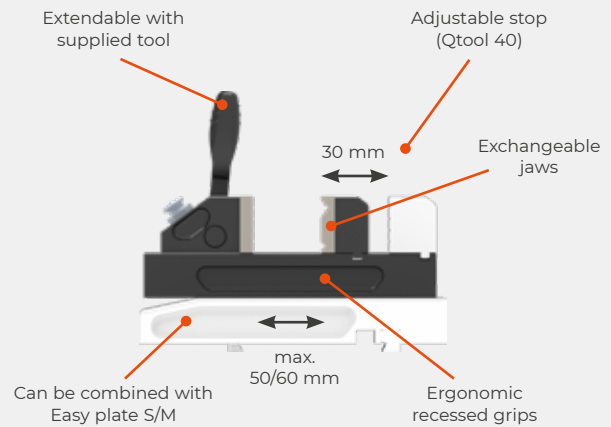
**Qtool 40 S**

	Item No.	Clamping range	Jaw width	Jaw height	Clamping force
<b>Qtool 40</b>	Z2270200	0 - 60 mm	50 mm	25 mm	ca. 1000 N
<b>Qtool 40 S</b>	Z2270201	0 - 50 mm	50 mm	25 mm	variable

For further technical data, see page 53

## Highlights

- For small components: Ø 40 mm | W = 60 mm
- Screw clamp (Qtool 40 S) with star handle to manually dose the clamping force
- Eccentric clamp (Qtool 40) for fast and powerful clamping
- Rear stop adjustable for optimal position during cutting
- Diverse clamping jaw program



## Compatibility Qtool 40 Series



Compatible with cut-off machine	Qcut 200 A	Qcut 250 A	Qcut 250 M	Qcut 350 A	Brillant 230
<b>Direct mounting via T-slot nut / Spacing</b>	✓ 8 mm / 60 mm	-	-	-	-
<b>via Easy plate</b>	✓ S / M	✓ S / M	✓ S / M	✓ S / M	✓ S / M

## Clamping jaws for Qtool 40 Series

With the wide range of clamping jaws, the Qtools can be individually customized to the components to be cut:

### Round components

- Can be clamped precisely and securely using the prismatic jaws or the bevelled jaw
- The geometry of the jaws creates a defined 3-point contact between the workpiece and the clamping device
- This prevents the components from slipping
- Round components can also be clamped vertically using the cross prism and cutted above the clamping device

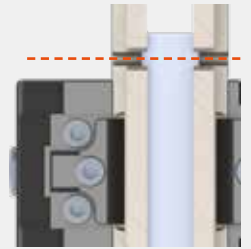


### Large components

- The high jaws offer a larger clamping surface for geometrically large components

### Clamping the cut-off side of the component

- The cut-off side of the component can also be clamped using the slotted jaws
- This greatly reduces burr formation during cutting and avoids subsequent grinding of the burr before embedding in a mounting press



## CLAMPING JAW, STANDARD (WITH QTOOL INCLUDED)



- Standard jaws Qtool 40
- Jaw height: 25 mm
- Jaw width: 40 mm
- Universal jaw
- Scope of delivery: 1 jaw (spare jaw)

Item No.: 02270202

## CLAMPING JAW, BEVELLED



- Jaw height: 25 mm
- Jaw width: 40 mm
- 5° bevelled clamping surface
- Clamping jaw for pressing down round material
- For round components up to Ø 50 mm
- Scope of delivery: 1 jaw (as counter jaw we recommend the clamping jaw standard (included in the scope of delivery Qtool))

Item No.: 02270212

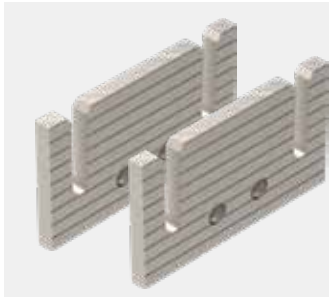
## CLAMPING JAW, HIGH



- Jaw height: 45 mm
- Jaw width: 50 mm
- Universal jaw for large components
- Scope of delivery: 2 jaws

Item No.: Z2270202

## CLAMPING JAW, HIGH SLOTTED



- | Jaw height: 45 mm
- | Jaw width: 80 mm
- | Separated component remains clamped even after cutting
- | Scope of delivery: 2 jaws

Item No.: Z2270203

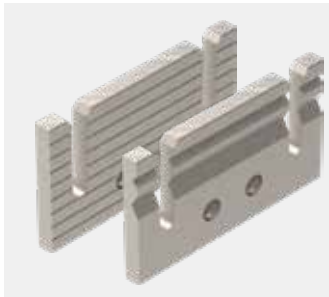
## CLAMPING JAW, CROSS PRISM



- | Jaw height: 25 mm
- | Jaw width: 40 mm
- | Horizontal and vertical prism for clamping round components (3-point support)
- | Horizontal prism max.  $\varnothing$  17 mm
- | Vertical prism max.  $\varnothing$  17 mm
- | Scope of delivery: 1 jaw (as a counter jaw we recommend the clamping jaw standard (included in the scope of delivery Qtool))

Item No.: 02270213

## CLAMPING JAW, HIGH, SLOTTED, WITH PRISM



- | Jaw height: 45 mm
- | Jaw width: 80 mm
- | Horizontal prism max.  $\varnothing$  17 mm - for clamping round components (3 point support)
- | Sample remains clamped even after cutting
- | Scope of delivery: 2 jaws (1 slotted jaw high standard, 1 slotted jaw with prism)

Item No.: Z2270204

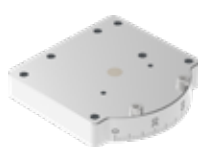
## ACCESSORIES



Easy clamping plate S



Easy clamping plate S with rotation function



Easy adaption Qtool 40-60



Multi-Tower



Swivel unit Qtool 40-60



# Qtool 60 Series



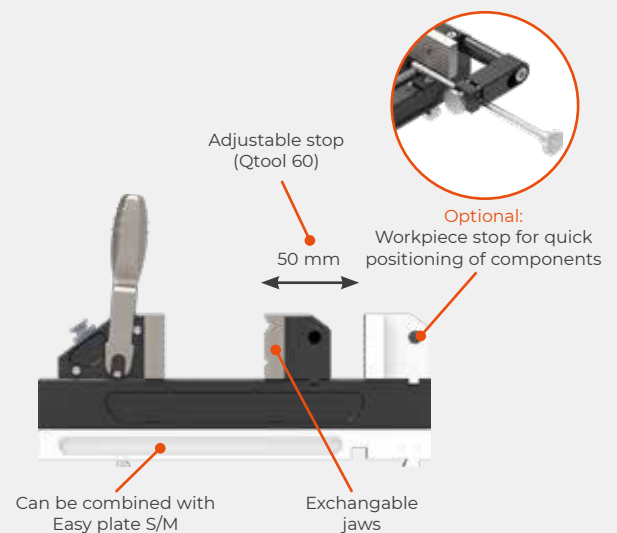
**Qtool 60**

	Item No.	Clamping range	Jaw width	Jaw height	Clamping force
<b>Qtool 60</b>	Z2235200	0 - 100 mm	70 mm	32 mm	ca. 2000 N

For further technical data, see page 53

## Highlights

- I For medium-sized components  $\varnothing$  60 mm | W = 100mm
- I Eccentric clamp for fast and powerful clamping
- I Adjustable rear stop (50mm) for optimal position during cutting
- I Diverse jaw program
- I Optionally expandable with cross stop



## Compatibility Qtool 60 Series



Compatible with cut-off machine	Qcut 200 A	Qcut 250 A	Qcut 250 M	Qcut 350 A	Brillant 230
<b>Direct mounting via T-slot nut / Spacing</b>	✓ 8 mm / 60 mm	✓ 12 mm / 75 mm	–	✓ 12 mm / 75 mm	✓ 12 mm / 75 mm
<b>via Easy plate</b>	✓ S / M	✓ S / M	✓ M	✓ S / M	✓ S / M



# Clamping jaws for Qtool 60 Series

With the wide range of clamping jaws, the Qtools can be individually customized to the components to be cut:

## Round components

- | Can be clamped precisely and securely using the prismatic jaws or the bevelled jaw
- | The geometry of the jaws creates a defined 3-point contact between the workpiece and the clamping device
- | This prevents the components from slipping
- | Round components can also be clamped vertically using the cross prism and cutted above the clamping device

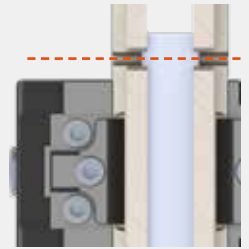


## Large components

- | The high jaws offer a larger clamping surface for geometrically large components

## Clamping the cut-off side of the component

- | The cut-off side of the component can also be clamped using the slotted jaws.
- | This greatly reduces burr formation during cutting and avoids subsequent grinding of the burr before embedding in a mounting press



## CLAMPING JAW, STANDARD (WITH QTOOL INCLUDED)



- | Standard jaws
- | Jaw height: 32 mm
- | Jaw width: 70 mm
- | Scope of delivery: 1 jaw (spare jaw)

Item No.: 02235202

## CLAMPING JAW, BEVELLED



- | Jaw height: 32 mm
- | Jaw width: 70 mm
- | 5° bevelled clamping surface
- | Clamping jaw for pressing down round material
- | For round components up to  $\varnothing$  60 mm
- | Scope of delivery: 1 jaw (as counter jaw we recommend the clamping jaw standard (included in the scope of delivery Qtool))

Item No.: 02235212

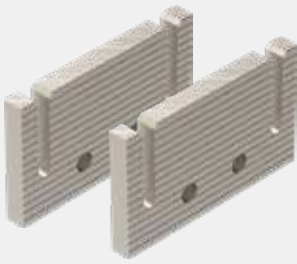
## CLAMPING JAW, HIGH



- | Jaw height: 60 mm
- | Jaw width: 70 mm
- | For large components
- | Scope of delivery: 2 jaws

Item No.: Z2235201

## CLAMPING JAW, HIGH SLOTTED



- | Jaw height: 60 mm
- | Jaw width: 100 mm
- | Sample remains clamped even after cutting
- | Scope of delivery: 2 jaws

Item No.: Z2235202

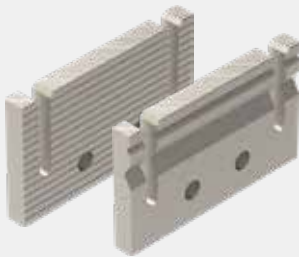
## CLAMPING JAW, CROSS PRISM



- | Jaw height: 32 mm
- | Jaw width: 70 mm
- | Horizontal and vertical prism for clamping round components (3-point support)
- | Horizontal prism max.  $\varnothing$  18 mm
- | Vertical prism max.  $\varnothing$  32 mm
- | Scope of delivery: 1 jaw (as a counter jaw we recommend the clamping jaw standard (included in the scope of delivery Qtool))

Item No.: 02235213

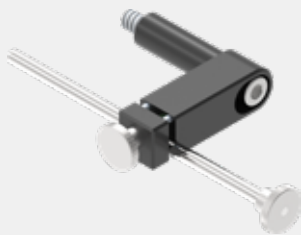
## CLAMPING JAW, HIGH, SLOTTED, WITH PRISM



- | Jaw height: 60 mm
- | Jaw width: 100 mm
- | Horizontal prism max.  $\varnothing$  17 mm - for clamping round components (3 point support)
- | Sample remains clamped even after cutting
- | Scope of delivery: 2 jaws (1 slotted jaw smooth, 1 slotted jaw with prism)

Item No.: Z2235203

## WORKPIECE STOP



For repetitive cuts of components with the same geometry, the component can be reproducibly positioned in the same way using the workpiece stop.

- | Jaw mountable on Qtool 60, 80, 80 VARIO left or right
- | Stop range up to 120 mm

Item No.: Z2231210

## ACCESSORIES



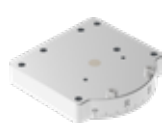
Easy clamping  
plate S



Easy clamping  
plate S with  
rotation function



Easy clamping  
plate M



Easy adaption  
Qtool 40-60



Multi-Tower



Swivel unit  
Qtool 40-60



Swivel unit  
Qtool 60-80

# Qtool 80 / Qtool 80 VARIO Series


**Qtool 80 - 100**
**Qtool 80 - 150**

	Item No.	Clamping area	Jaw width	Jaw height	Clamping force
<b>Qtool 80 - 100</b>	Z2231203	0 - 100 mm	100 mm	40 mm	ca. 4000 N
<b>Qtool 80 - 150</b>	Z2231204	0 - 150 mm	100 mm	40 mm	ca. 4000 N

For further technical data, see page 53


**Qtool 80 VARIO - 100**
**Qtool 80 VARIO - 150**
**Qtool 80 VARIO - 250**

	Item No.	Clamping area	Jaw width	Jaw height	Clamping force
<b>Qtool 80 VARIO - 100</b>	Z2231200	0 - 100 mm	100 mm	40 mm	ca. 4000 N / 2500 N
<b>Qtool 80 VARIO - 150</b>	Z2231201	0 - 150 mm	100 mm	40 mm	ca. 4000 N / 2500 N
<b>Qtool 80 VARIO - 250</b>	Z2231202	0 - 250 mm	100 mm	40 mm	ca. 4000 N / 2500 N

For further technical data, see page 53

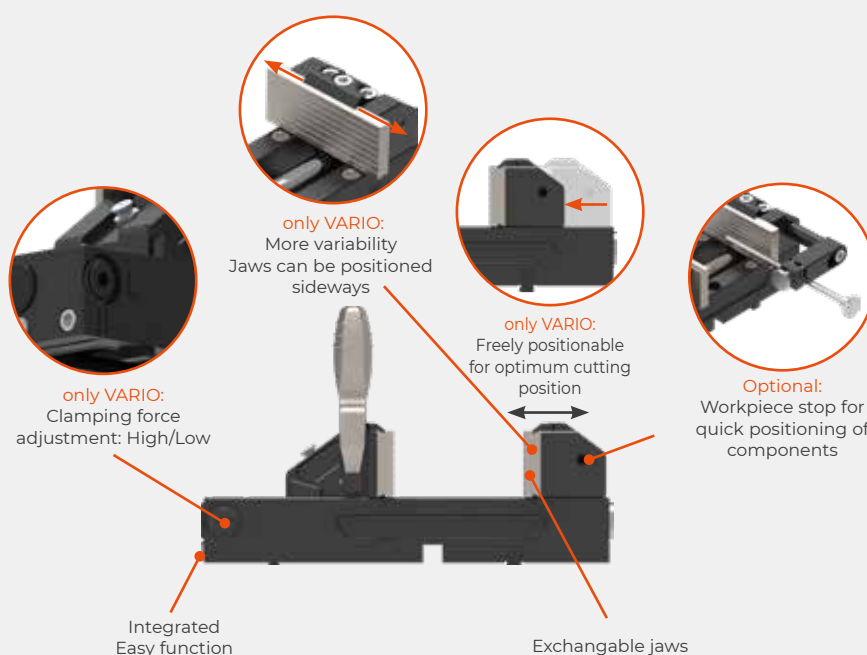
# Qtool 80 / Qtool 80 VARIO Series

## Highlights

- | For large components Ø 80 mm | W=100 mm
- | Eccentric clamp for fast and powerful clamping
- | Integrated easy function for quick attachment to the table (T-slot nuts also possible)
- | Adjustable rear stop (50 / 100 mm for Qtool 80 - 150)
- | Diverse clamping jaw program
- | Optionally expandable with cross stop

### Special Highlights of Qtool 80 VARIO

- | Rear stop can be variably moved freely
- | Jaws can be freely moved laterally
- | Clamping force adjustment High and Low (ca. 4 / 2.5 kN)



## Compatibility Qtool 80 / Qtool 80 VARIO Series



Compatible with cut-off machine	Qcut 250 A	Qcut 250 M	Qcut 350 A	Brillant 230
via Easysystem	✓	✓	✓	✓



Compatible with cut-off machine	Qcut 400 A	Qcut 500 A	Qcut 600 A/BOT	Qcut 800 A
via Easysystem	✓	✓	✓	✓

# Clamping jaws for Qtool 80 / Qtool 80 VARIO Series

With the wide range of clamping jaws, the Qtools can be individually customized to the components to be cut:

## Round components

- | Can be clamped precisely and securely using the prismatic jaws or the bevelled jaw
- | The geometry of the jaws creates a defined 3-point contact between the workpiece and the clamping device
- | This prevents the components from slipping
- | Round components can also be clamped vertically using the cross prism and cut above the clamping device

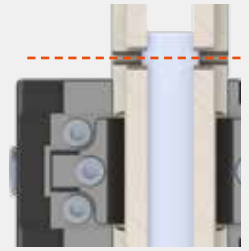


## Large components

- | The high jaws offer a larger clamping surface for geometrically large components

## Clamping the cut-off side of the component

- | The cut-off side of the component can also be clamped using the slotted jaws.
- | This greatly reduces burr formation during cutting and avoids subsequent grinding of the burr before embedding in a mounting press



## Longitudinal sections of cylindrical components

- | The special round bar jaws are designed to cut cylindrical components precisely lengthwise



## CLAMPING JAW, STANDARD (WITH QTOOL INCLUDED)



- | Standard jaws
- | Jaw height: 40 mm
- | Jaw width: 90 mm (Qtool 80) / 100 mm (Qtool 80 VARIO)
- | Universal jaw
- | Scope of delivery: 1 jaw (spare jaw)

Item No.: 02231243 (for Qtool 80)

Item No.: 02231200 (for Qtool 80 VARIO)

## CLAMPING JAW, BEVELLED



- | Jaw height: 40 mm
- | Jaw width: 90 mm (Qtool 80) / 100 mm (Qtool 80 VARIO)
- | 5° bevelled clamping surface
- | Clamping jaw for pressing down round material
- | For round components up to  $\varnothing$  80 mm
- | Scope of delivery: 1 jaw (as counter jaw we recommend the clamping jaw standard (included in the scope of delivery Qtool))

Item No.: 02231245 (for Qtool 80)

Item No.: 02231229 (for Qtool 80 VARIO)

## CLAMPING JAW, HIGH



- | Jaw height: 70 mm
- | Jaw width: 90 mm (Qtool 80) / 100 mm (Qtool 80 VARIO)
- | For large components
- | Scope of delivery: 2 jaws

Item No.: Z2231215 (for Qtool 80)

Item No.: Z2231211 (for Qtool 80 VARIO)

## CLAMPING JAW, HIGH SLOTTED



- | Jaw height: 70 mm
- | Jaw width: 150 mm
- | Separated component remains clamped even after cutting
- | Scope of delivery: 2 jaws

Item No.: Z2231216 (for Qtool 80)

Item No.: Z2231214 (for Qtool 80 VARIO)

## CLAMPING JAW, CROSS PRISM



- | Jaw height: 40 mm
- | Jaw width: 90 mm (Qtool 80) / 100 mm (Qtool 80 VARIO)
- | Horizontal and vertical prism for clamping round components (3-point support)
- | Horizontal prism max.  $\varnothing$  55 mm
- | Vertical prism max.  $\varnothing$  55 mm
- | Scope of delivery: 1 jaw (as a counter jaw we recommend the clamping jaw standard (included in the scope of delivery Qtool))

Item No.: 02231246 (for Qtool 80)

Item No.: 02231230 (for Qtool 80 VARIO)

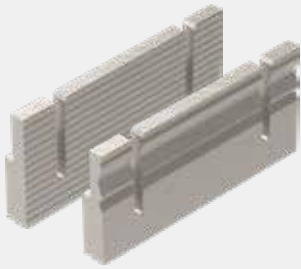
## CLAMPING JAW, PRISM



- | Jaw height: 40 mm
- | Jaw width: 100 mm
- | 2 horizontal prisms for clamping round components (3-point support)
- | Horizontal prisms,  $\varnothing$  5 - 28 mm
- | Scope of delivery: 1 jaw (as a counter jaw we recommend the clamping jaw standard (included in the scope of delivery Qtool))

Item No.: - (for Qtool 80)      Item No.: 02231213 (for Qtool 80 VARIO)

## CLAMPING JAW, HIGH, SLOTTED PRISM



- | Jaw height: 70 mm
- | Jaw width: 150 mm
- | Horizontal prism max.  $\varnothing$  70 mm - for clamping round components (3 point support)
- | Separated component remains clamped even after cutting
- | Scope of delivery: 2 jaws (1 slotted jaw standard high, 1 slotted jaw with prism)

Item No.: Z2231217 (for Qtool 80)      Item No.: Z2231213 (for Qtool 80 VARIO)

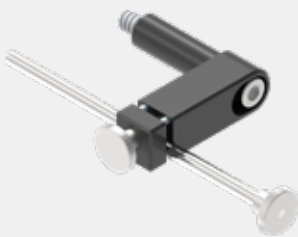
## CLAMPING JAW, SLOTTED FOR ROUND BAR



- | Jaw height: 70 mm
- | Jaw width: 150 mm
- | To separate cylindrical components along the longitudinal axis
- | 2 horizontal prisms for max.  $\varnothing$  70 mm
- | Separated component remains clamped even after cutting
- | Scope of delivery: 2 jaws

Item No.: - (for Qtool 80)      Item No.: Z2231212 (for Qtool 80 VARIO)

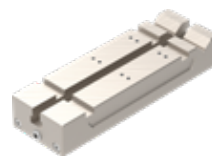
## WORKPIECE STOP



- | mountable on Qtool 60, 80, 80 VARIO left or right
- | Stop range up to 120 mm

Item No.: Z2231210

## ACCESSORIES



Easy multifunctional plate (height mounting)



Swivel unit Qtool 60-80



POWER CLAMPING SYSTEMS FOR LARGE CUTTING MACHINES

# Universal power clamping system 100/540



100/540

	Item No.	Clamping area	Jaw width	Jaw height	Clamping force
<b>Universal power clamping system 100/540</b>	Z2234016	0 - 365 mm	100 mm	30 mm	28 kN

## Highlights

- | Integrated mechanical-hydraulic power transmission
- | Incl. fastening material for T-slots 12 mm
- | Max. clamping force 25 kN
- | W x H x D: 100 x 104 x 625 mm

## Compatibility Universal power clamping system 100/540



Compatible with cut-off machine	Qcut 400 A	Qcut 500 A	Qcut 600 A/BOT	Qcut 800 A
<b>Direct mounting via T-slot nut</b>	✓	✓	✓	✓



## Accessories for clamping system 100/540

With the accessories, the power clamp can be individually modified to suit the components to be cut and the clamping situation.

### PRISM CLAMPING JAW



- | Horizontal prism
- | Can be combined with flat clamping jaw
- | Jaw width: 100 mm
- | Prism for  $\varnothing$  10 - 100 mm

Item No.: Z2234018

### CLAMPING JAW FLAT



- | Jaw height: 80 mm
- | Jaw width: 100 mm
- | Ribbed clamping surface
- | For clamping parallel bodies
- | Can be combined with prism clamping jaw

Item No.: Z2234017

### ANGULAR DRIVE



- | Possibility to clamp the component comfortably from above

Item No.: Z2234019

### Notes

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POWER CLAMPING SYSTEMS FOR LARGE CUTTING MACHINES

# Universal power clamping system LC 90



LC 90

	Item No.	Clamping area	Jaw width	Jaw height	Clamping force
<b>Universal power clamping system LC 90</b>	Z2234001	0 - 217 mm	100 mm	70 mm	25 kN

## Highlights

- I Simple and safe clamping of a wide variety of workpieces
- I A wide variety of easy-to-change clamping jaws
- I Low effort due to mechanical force transmission
- I Clamping force pre-adjustable in 11 steps (up to 28 kN)
- I incl. fastening material for T-slots 12 mm and hand crank

## Compatibility Universal power clamping system LC 90



Compatible with cut-off machine	Qcut 400 A	Qcut 500 A	Qcut 600 A/BOT	Qcut 800 A
<b>Direct mounting via T-slot nut</b>	✓	✓	✓	✓

## Accessories for clamping system LC 90

The LC 90 power clamp builds the basis of the clamping system. Depending on the application, it is supplemented with one of the following modules. It can be used to powerfully and securely clamp a wide range of irregularly shaped components.

### CARRIER JAWS LC 90



- | Carrier module for clamping jaws
- | Base for prism jaw and V-groove jaw 100
- | Made of high-strength aluminium with ceramic coating
- | Jaw width: 100 mm

Item No.: Z2234003

### V-GROOVE JAW 100



- | Jaw height: 70 mm
- | Jaw width: 100 mm
- | 1 pc., can be combined with clamping jaw flat
- | Rotatable jaw made of hardened steel
- | Surface with two horizontal prisms for clamping round material from  $\varnothing$  10 to 100 mm

Item No.: Z2234004

### CLAMPING JAW FLAT



- | Smooth clamping surface
- | For clamping parallel bodies
- | 1 pc., can be combined with V-groove jaw 100

Item No.: Z2234005

### QUICK-CHANGE ADAPTER



- | Fast and secure connection of the individual modules by means of pull-down pins
- | For fastening
  - Step jaw 100
  - Clamping system X-Clamp 100
  - Customer-specific solutions

Item No.: Z2234009

## STEP JAW 100



- | Jaw height: 65 mm
- | Jaw width: 100 mm
- | Clamping of parallel workpiece surfaces
- | Clamping force generation via basic module LC 90
- | Step jaw can be rotated 180°
- | Use only with quick-change adapter

Item No.: Z2234008

## CLAMPING SYSTEM X-CLAMP 100



- | Individual and safe clamping of a wide variety of specimens and free-form parts by means of individually spring-loaded rams made of stainless steel
- | Perfect fit with minimum clamping force
- | Minimal time expenditure
- | Use only with quick-change adapter
- | incl. torque wrench and fastening screws

Item No.: Z2234002



## SOCKET 90°



- | For assembly of the basic module LC 90 in lateral position 90°
- | For T-slots DIN 650 12 mm

Item No.: Z2234006

## SUPPORT ELEMENT



- | Jaw height: 70 mm
- | Jaw width: 100 mm
- | 1 piece for supporting long components
- | Reduction of vibrations
- | Spring-loaded rams attach themselves to the workpiece
- | Additional fixation of the component from above with universal clamp possible
- | Fast and safe connection of the individual modules by means of pull-down pins

Item No.: Z1350023

## SPECIAL CLAMPING JAWS



- | QATM Service: Send us your component drawing as DXF or DWG file or photos of your component. We plan your optimal clamping device



# Easy adaptations, clamping device accessories



**Easy clamping  
plate S**

**Easy clamping  
plate S  
with rotating function**

NEW



**Easy clamping  
plate M**

## Highlights

- | Unique quick-change easy system to quickly change and position QATM clamping systems
- | Time-consuming threading via slot nuts is no longer necessary
- | Easy function is integrated into the clamping device of the Qtool 80 series
- | Other series can be combined with the Easy clamping plates
- | Easy clamping plates allow for numerous combinations of clamping elements

## Compatibility chart



Compatible with cut-off machine	Qcut 200 A	Qcut 250 A	Qcut 250 M	Qcut 350 A	Brillant 230
Easy clamping plate S	✓	✓	–	✓	–
Easy clamping plate S with rotating function	✓	✓	–	✓	–
Easy clamping plate M	✓	✓	✓	✓	✓

# Easy clamping plate S



Easy clamping plate S

	Item No.	Dimensions (W x H x D)
Easy clamping plate S	Z2236030	20 mm x 70 mm x 136 mm

#### MATCHING MODULES

- | Qtool 40, Qtool 40 S
- | Qtool 60
- | Easy Adaption Vertical
- | Easy Adaption Horizontal
- | Easy Adaption Vertical
- | Multi-Tower Turntable
- | QATM Precision Clamping Devices (via Easy Adaptions)

## Compatibility easy clamping plate S



Compatible with cut-off machine	Qcut 200 A	Qcut 250 A	Qcut 250 M	Qcut 350 A	Brillant 230
Easy clamping plate S	✓	✓	–	✓	–

## Compatible accessories



Precision Series



Qtool 40 / 40 S / 60



Easy adaption vertical



Easy adaption horizontal



Easy clamping plate S



## Notizen

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# Easy clamping plate S with rotating function



Easy clamping plate S with rotating function

	Item No.	Dimensions (W x H x D)
Easy clamping plate S with rotating function	Z2236031	20 mm x 70 mm x 136 mm

#### MATCHING MODULES

- | Easy Adaption Vertical
- | Easy Adaption Horizontal
- | Easy Adaption Qtool 40-60
- | Z2236039 Multi-Tower
- | QATM Precision Clamping Devices (via adaption)
- | Z2236040 Swivel unit Qtool 40-60 (via Multi-Tower)
- | Qtool 40 / 60 (via Adaption / Swivel unit)

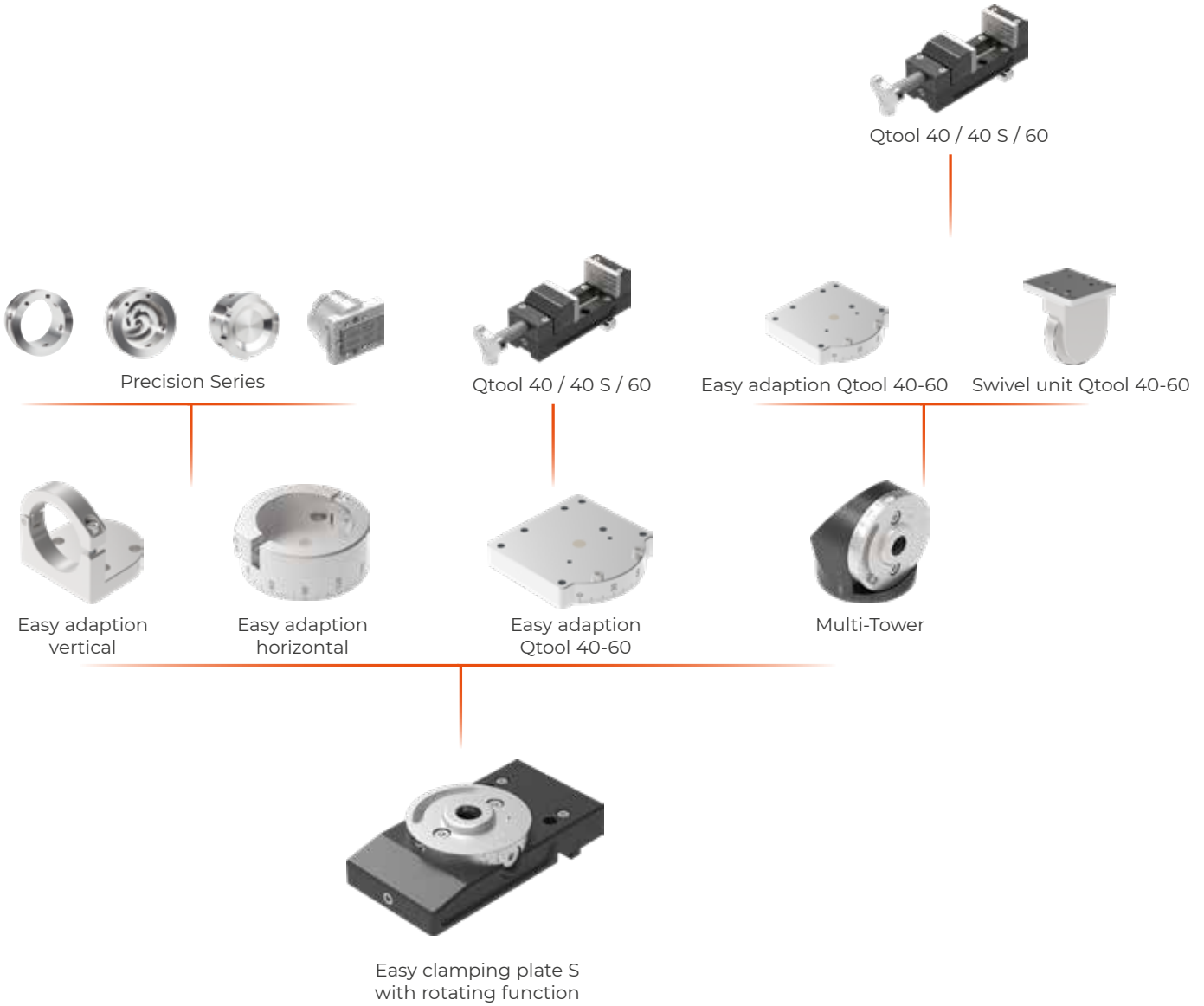
## Compatibility easy clamping plate S



Compatible with cut-off machine	Qcut 200 A	Qcut 250 A	Qcut 250 M	Qcut 350 A	Brillant 230
Easy clamping plate S with rotating function	✓	✓	–	✓	–



# Compatible accessories



## Notes

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# Easy clamping plate M



**Easy clamping plate M**

	Item No.	Dimensions (W x H x D)
<b>Easy clamping plate M</b>	Z2236035	15 mm x 70 mm x 196 mm

**MATCHING MODULES**

- | Qtool 40, Qtool 40 S (e.g. 2 next to each other)
- | Qtool 60
- | Mold clamp X-Clamp 3858
- | Easy Adaption Horizontal
- | Easy Adaption Vertical
- | Multi-Tower Turntable
- | QATM Precision Clamping Devices (via Adaption)
- | Multi-Tower (via Multi-Tower Turntable)
- | Easy Adaption Qtool 40-60 (via Multi-Tower Turntable)
- | Qtool 40 / 60 (via Adaption / Swivel unit)

## Compatibility easy clamping plate M



Compatible with cut-off machine	Qcut 200 A	Qcut 250 A	Qcut 250 M	Qcut 350 A	Brillant 230
<b>Easy clamping plate M</b>	✓	✓	✓	✓	✓

## Compatible accessories



Precision Series

See:  
Easy clamping plate S  
with rotating function



Qtool 40 / 40 S / 60



Easy adaption  
vertical



Easy adaption  
horizontal



Multi-Tower  
turntable



X-clamp  
3858



Easy clamping plate M



## Notizen

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# Accessories for Easy clamping plates

Adaptations for precision clamping devices / for direct clamping of mounted samples

## EASY ADAPTION HORIZONTAL



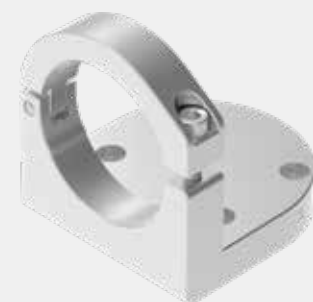
- | Direct clamping of mounted samples (with reduction ring)
- | Holder for precision clamping devices
- | Horizontal mount for quick clamping of various small clamping devices with adapter Ø 50 mm
- | Dimensions: Ø 69 mm x 28 mm (W x H x D)

Item No.: Z2236032

### MATCHING MODULES

- | Easy Clamping Plate S, S with rotating function, Plate M
- | QATM precision clamping devices (e.g. matrix clamps, etc.)
- | Reduction ring

## EASY ADAPTION VERTICAL



- | Direct clamping of mounted samples (with reduction ring)
- | Holder for precision clamping devices
- | Vertical mount for quick clamping of various small clamping devices with adapter Ø 50 mm
- | Dimensions: 74 mm x 69 mm x 74.5 mm (W x H x D)

Item No.: Z2236033

### MATCHING MODULES

- | Easy Clamping Plate S, S with rotating function, Plate M
- | QATM precision clamping devices (e.g. matrix clamps, etc.)
- | Reduction rings

## EASY ADAPTION QTOOL 40-60

NEW



- | Adapter for Qtool 40 and Qtool 60
- | Stops for aligning the Qtool 40
- | Quick clamping holder for quick fastening, e.g. on Easy-Clamping Plate S with rotating unit (Z2236031)
- | Dimensions: Ø 69 mm x 28 mm (W x H x D)

Item No.: Z2236034

### MATCHING MODULES

- | Qtool 40 / S, Qtool 60
- | Easy Clamping Plate S with rotating function

## MULTI-TOWER TURNTABLE

NEW



- | Quick clamping holder for quick change and release of the head joints
- | Angular scale  $\frac{1}{2}^\circ$ ; Angle grid  $15^\circ$
- | Dimensions:  $\varnothing 70$  mm x 17 mm (W x H)

Item No.: Z2236038

### MATCHING MODULES

- | Multi-Tower
- | Easy clamping plate M
- | Qtool 40 / 60 (via Multi-Tower)
- | Swivel unit Qtool 40-60 (via Multi-Tower)

## MULTI-TOWER

NEW



- | Module with 2 axes of rotation (angular scale  $\frac{1}{2}^\circ$ )
- | Possibility of multidimensional alignment of clamping devices
- |  $360^\circ$  rotation range with adjustable stops
- | Dimensions: 70 mm x 90 mm x 70 mm (W x H x D)

Item No.: Z2236039

### MATCHING MODULES

- | Easy clamping plate S with rotating function
- | Multi-tower turntable
- | Multi-tower (several times in a row)
- | Easy adaption Qtool 40-60
- | Easy clamping plate M (via Mutli-Tower Turntable)
- | Qtool 40 / 40 S / 60 (via Adaption)

## SWIVEL UNIT QTOOL 40-60

NEW



- | Possibility to swivel the Qtool 40 / Qtool 60
- | Swivel range  $\pm 90$
- | Dimensions: 70 mm x 90 mm x 70 mm (W x H x D)

Item No.: Z2236040

### MATCHING MODULES

- | Easy clamping plate S with rotating function
- | Multi-Tower
- | Easy plate M (via Multi-Tower)
- | Qtool 40 / 60 (via Adaption)



# Clamping accessories for rotating, swiveling and special applications

## Swivel unit Qtool 60-80

NEW



- | Possibility to swivel the Qtool 60 and 80 for diagonal cuts ( $\pm 90^\circ$ )
- | Resting points in  $15^\circ$  steps
- | Dimensions: 190 mm x 180 mm x 30 mm (W x H x D)

Item No.: Z2236041

### MATCHING MODULES

- | Qtool 80 - 100 / Qtool 80 VARIO - 100
- | Qtool 80 - 150 / Qtool 80 VARIO - 150
- | Qtool 60

## Compatibility swivel unit Qtool 60-80



Compatible with cut-off machine

Qcut 250 A

Qcut 250 M

Qcut 350 A

Brillant 230

Swivel unit Qtool 60-80

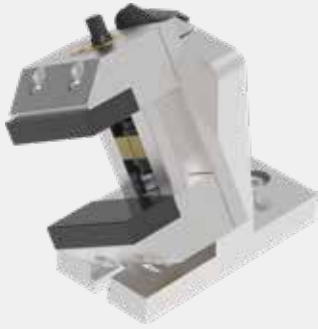
✓

✓

✓

✓

# Angle vice 60



- | Clamping range: 55 mm
- | Specimen diameter Ø 10-60 mm (with prism jaw)
- | Vertically centred, stainless steel (incl. 2x flat clamping jaws)
- | Rotation range: 270° (±135°)
- | Fastening to the table with a groove width of 12 mm
- | Dimensions: ca. 195 mm x 80 mm x 165 mm (W x H x D)

**MATCHING MODULES**

- | Clamping jaws prism

Item No.: Z1304001

## ACCESSORIES: CLAMPING JAW, PRISM



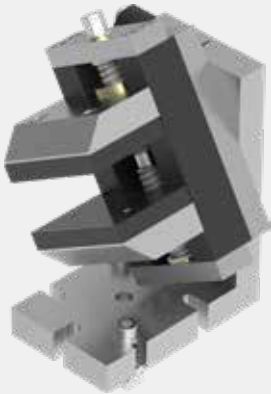
- | Jaw height: 40 mm
- | Jaw width: 80 mm

Item No.: 01304008

## Compatibility angle vice 60

Compatible with cut-off machine	Qcut 250 A	Qcut 250 M	Qcut 350 A	Brillant 230	
<b>Angle vice 60</b>	✓	✓	✓	✓	
Compatible with cut-off machine	Brillant 255	Qcut 400 A	Qcut 500 A	Qcut 600 A/BOT	Qcut 800 A
<b>Angle vice 60</b>	✓	✓	✓	✓	✓

# Angle vice 80



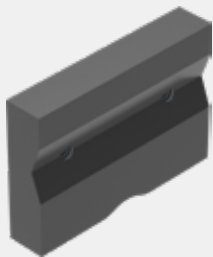
- | Clamping range: 70mm
- | Specimen diameter  $\varnothing$  10-60 mm (with prism jaw)
- | vertically centred, stainless steel (incl. 2x flat clamping jaws)
- | Rotation range: 270° ( $\pm$ 135°)
- | Fastening to the table with a groove width of 12 mm
- | Dimensions: ca. 195 mm x 80 mm x 205 mm (W x H x D)

Item No.: Z1302000

## MATCHING MODULES

- | Clamping jaws prism

## ACCESSORIES: CLAMPING JAW, PRISM



- | Jaw height: 70 mm
- | Jaw width: 100 mm

Item No.: 01302016

## Compatibility angle vice 80



Compatible with cut-off machine	Brillant 255	Qcut 400 A	Qcut 500 A	Qcut 600 A/BOT	Qcut 800 A
Angle vice 80	✓	✓	✓	✓	✓



# Cross clamp



**Cross clamp 50/100**

	Item No.	Max. sample cross-section	Max. sample diameter	Span	Groove width
<b>Cross clamp 50/100</b>	Z1340010	50x50 mm	Ø 60 mm	100 mm	12 mm
<b>Cross clamp 80/100</b>	Z1340000	80x50 mm	Ø 90 mm	100 mm	12 mm
<b>Transverse clamp 80/150</b>	Z1340001	80x50 mm	Ø 90 mm	150 mm	12 mm

## Highlights

- Components with residual stresses tend to contract in the kerf and block the cut-off wheel when they are ripped open.
- For parallel clamping of round and rectangular workpieces, in particular for longitudinal sections in hardened materials
- Fast workpiece change thanks to eccentric clamping elements

## Compatibility cross clamp



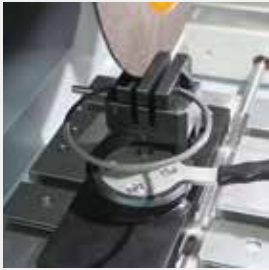
Compatible with cut-off machine	Qcut 250 A	Qcut 250 M	Qcut 350 A	Brillant 230	Brillant 255
<b>Cross clamp 50/100</b>	✓	✓	✓	✓	✓



Compatible with cut-off machine	Qcut 400 A	Qcut 500 A	Qcut 600 A/BOT	Qcut 800 A
<b>Cross clamp 80/100</b>	✓	✓	✓	✓
<b>Transverse clamp 80/150</b>	-	✓	✓	✓



# Vertical clamp



### Vertical clamp

- | For clamping delicate, thin parts (e.g. rings, wires etc.)
- | Clamping system with integrated Easy clamping plate M
- | Incl. adjustable stop
- | Separated segment remains clamped after completion of the cutting process



**Vertical clamp single**

Item No.: Z2236009



**Vertical clamp double**

- | Possibility of making a double cut and thus cutting out a complete segment, e.g. from a ring

Item No.: Z2236010

## Compatibility vertical clamp



Compatible with cut-off machine	Qcut 200 A	Qcut 250 A	Qcut 250 M	Qcut 350 A	Brillant 230
<b>Vertical clamp</b>	✓	✓	✓	✓	✓

# Clamping system X-Clamp 3858



- | Form-fit fixing of the workpiece in seconds
- | Optimal fixing of complex workpieces
- | Perfect fit with minimum clamping force
- | No need for individual forming jaws and special fixtures

Item No.: Z2234010

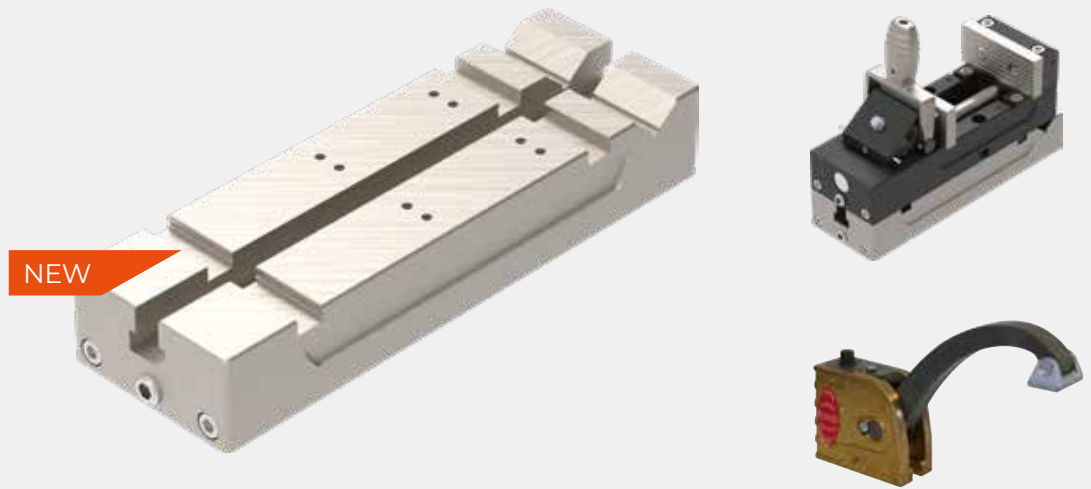


## Compatibility Clamping system X-Clamp 3858



Compatible with cut-off machine	Qcut 200 A	Qcut 250 A	Qcut 250 M	Qcut 350 A	Brillant 230
<b>Clamping system X-Clamp 3858</b>	✓	✓	✓	✓	✓

# Easy multifunctional plate



Easy multifunctional plate

	Item No.	Dimensions (W x H x D)
Easy multifunctional plate	Z2236036	ca. 250 mm x 80 mm x 40 mm

## Highlights

- I Base to vary the height of Qtool 60 and 80
- I Integrated clamping rail with prism for universal clamps
- I Prism for round components (Ø 6 - 37 mm)
- I Built-in easy function
- I Can be set up multiple times
- I Suitable for all universal clamps with slot nuts 12 mm



## Compatibility Easy multifunctional plate

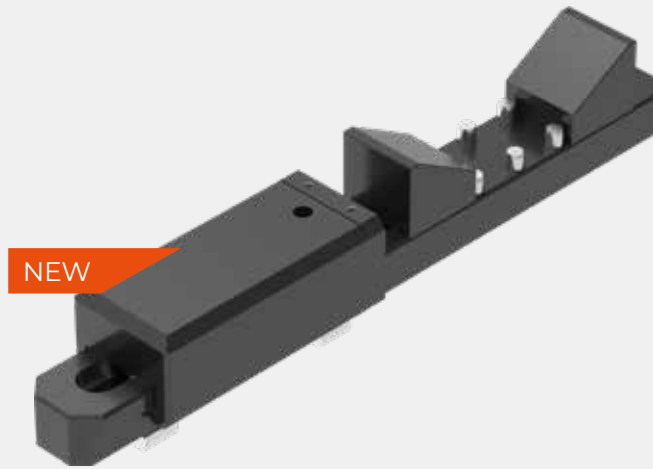


Compatible with cut-off machine	Qcut 200 A	Qcut 250 A	Qcut 250 M	Qcut 350 A	Brillant 230
Easy multifunctional plate	-	✓	-	✓	✓



Compatible with cut-off machine	Brillant 255	Qcut 400 A	Qcut 500 A	Qcut 600 A/BOT	Qcut 800 A
Easy multifunctional plate	✓	✓	✓	✓	✓

# Clamping rail



Clamping rail

	Item No.	Sample diameter	Dimensions (W x H x L)
Clamping rail	Z1350025	Ø 20 - 250 mm	56 mm x 50 mm x 350 mm

## Highlights

- I Basis for the universal tensioners Mono, Duo and chain tensioners
- I For clamping shafts, crankshafts and camshafts
- I Adjustable prism supports
- I 2 inclined supports for component sizes: Ø 20 – 250 mm included in the scope of delivery
- I Universal clamp is mounted on a sliding carriage, so the component can be removed quickly and easily.



## Compatibility clamping rail



Compatible with cut-off machine	Qcut 350 A	Brillant 255	Qcut 400 A	Qcut 500 A	Qcut 600 A/BOT	Qcut 800 A
Clamping rail	✓	–	✓	✓	✓	✓



FOR GREATER PRECISION

# ROTATION DEVICES

- | The use of the adaptive rotation axis results in a more uniform cutting pattern and reduces the risk of the cut-off wheel running. This reduces the effort required for subsequent plane-parallel grinding of the sample.
- | The cutting time is halved for rotationally symmetrical parts.



# Rotation device type RD1



**Rotation device type RD1**

	Item No.	Clamping diameter
<b>Rotation device type RD1</b>	Z1870059	Ø 50 mm

## Highlights

- | For Qcut 150 A (modularly adaptable)
- | Speed range: 5 – 30 rpm
- | Expandable with precision clamping device (holder Ø 50 mm)

## Compatibility of rotation device type RD1



Compatible with cut-off machine	Qcut 150 A
<b>Rotation device type RD1</b>	✓

## Accessories

- | See clamping devices precision series



# Rotation device type RD2



**Rotation device type RD2**

	Item No.	Clamping diameter
<b>Rotation device type RD2</b>	Z1891001	Ø 50 mm

## Highlights

- | For Qcut 200 A (modularly adaptable)
- | Rotation and oscillating oscillation possible
- | Speed range: 3.5 – 22 rpm
- | Expandable with precision clamping device (holder Ø 50 mm)

## Compatibility of rotation device type RD2



Compatible with cut-off machine	Qcut 200 A
<b>Rotation device type RD2</b>	✓

## Accessories

- | See clamping devices precision series

# Universal vices



**Piccolo 54**



**Piccolo 100**



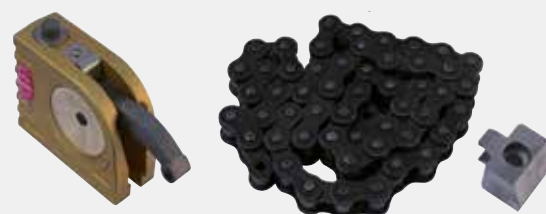
**Mono 61**



**Mono 132**



**Duo vice**



**Chain clamping vice**

	Item No.	Arm unloading	Clamping height	Clamping force	Fastening screw	T-slot brick screw
<b>Piccolo 54</b>	Z1350008	54 mm	15 - 58 mm	6.5 kN	M8 x 25	M8 x 12
<b>Piccolo 100</b>	Z1350012	100 mm	40 - 90 mm	4.2 kN	M8 x 25	M8 x 12
<b>Mono 61</b>	Z1350002	61 mm	8 - 102 mm	12 kN	M10 x 32	M10 x 12
<b>Mono 132</b>	Z1350011	132 mm	43 - 155 mm	8 kN	M10 x 32	M10 x 12
<b>Duo vice</b>	Z1350005*	46-91 mm	4 - 142 mm	11 kN	M10 x 32	M10 x 12
<b>Chain clamping vice</b>	Z1350006**	Chain length: 1 m	-	16 kN	M10 x 32/25	M10 x 12

## Highlights

| Delivery incl. tension wrench

### \*Universal vice duo

- | For clamping and lifting
- | Lifting height: 4 - 142 mm
- | With 2 interchangeable clamping arms

### \*\*Chain clamping vice

- | For clamping large components
- | Incl. 1x universal tensioner duo and hook block for chain

## Accessories for universal vices

Accessories with which the universal clamping devices can be individually adapted to the respective components.

### CASE SET UNIVERSAL CLAMP MONO 61



- | 2x Universal Clamp Mono 61
  - | 2x Height pedestal Mono
  - | 1x Extension Arm
  - | 3x Tension Shoe Standard
  - | 1x clamping shoe transverse bridge, longitudinal bridge, transverse prism, longitudinal prism
  - | 4x T-slot nut stainless M 10 x 12
  - | 4x fastening screws M 10 x 32 | incl. tension wrench
- Item No.: Z1350004

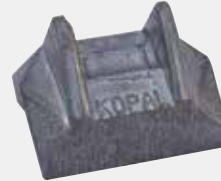
### LONGITUDINAL V-SHOE (PRISM)



- | For all universal clamps
- | For clamping cylindrical components

Item No.: 92005796

### TRAVERSE V-SHOE (PRISM)



- | For all universal clamps
- | For clamping cylindrical components

Item No.: 92005797

### LONGITUDINAL BRIDGE



- | For all universal clamps
- | For clamping larger components

Item No.: 92005799

### TRAVERSE BRIDGE



- | For all universal clamps
- | For clamping larger components

Item No.: 92005800

### STANDARD CLAMPING SHOE



- | For all universal clamps and applications

Item No.: 92005798

## FIXING SCREW



For all universal clamps Piccolo

M6 x 25  
Item No.: Z1304591

For all universal clamps Piccolo

M8 x 25  
Item No.: 95003169

For all universal clamps Piccolo

M10 x 25  
Item No.: 95003170

For Universal Tensioner Mono, Duo, Chain Tensioner

M10 x 32  
Item No.: 95003168

## T-SLOT NUT STAINLESS\*



\*all other sizes of slot nuts on request

M6 x 8  
Item No.: 91001157

M8 x 10  
Item No.: 91001161

M8 x 12  
Item No.: 91001159

M10 x 12  
Item No.: 91001158

## HEIGHT ADAPTER PICCOLO



Height: 60 mm  
Mounting screw: M8 x 25  
T-slot nut (stainless): M8 x 12

Item No.: Z1350007

## HEIGHT ADAPTER MONO



Height: 74 mm  
Mounting screw: M10 x 32  
T-slot nut (stainless): M10 x 12

Item No.: Z1350003

## CLAMPING ARM EXTENSION



For Piccolo 54 and Mono 61  
Mounting screw: M10 x 32  
T-slot nut (stainless): M10 x 12

Item No.: 95003172

## PAIR OF PRISMS

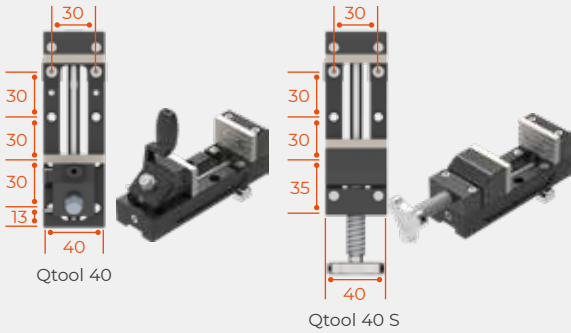


90° prism  
For Ø 5-50 mm components  
Dimensions (WxD): 50 x 150 mm

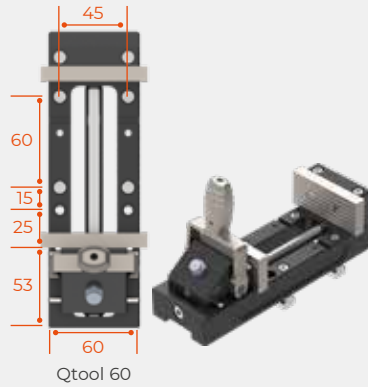
Item No.: 92005805

# Technical Data Qtool Series

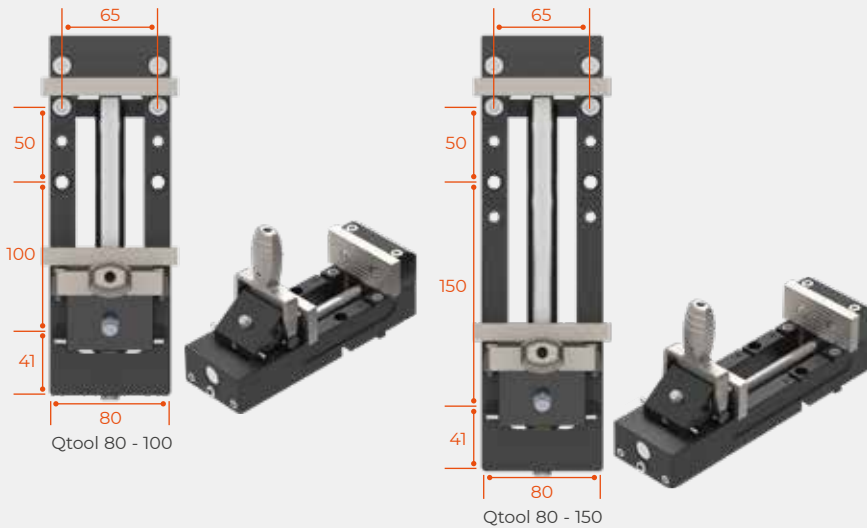
## QTOOL 40 SERIES



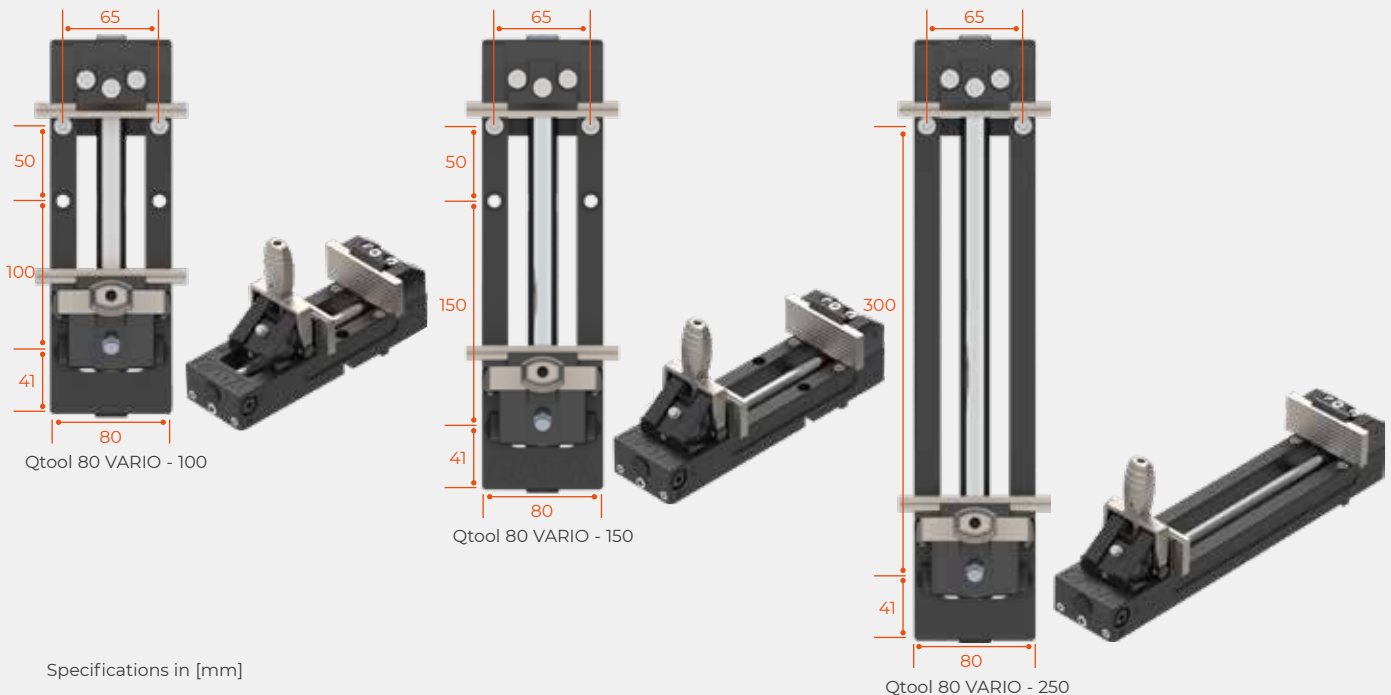
## QTOOL 60 SERIES



## QTOOL 80 SERIES



## QTOOL 80 VARIO SERIES



### T-SLOT NUT

- For Qtool 40 Series  
M5 x 8  
Item No.: 90003324
- For Qtool 60 Series  
M5 x 8  
Item No.: 90003324
- M5 x 12  
Item No.: 95017406
- For Qtool 80 Series  
M8 x 10  
Item No.: 91001161
- M8 x 12  
Item No.: 91001159
- For Qtool 80 VARIO Series  
M8 x 10  
Item No.: 91001161
- M8 x 12  
Item No.: 91001159

Specifications in [mm]





# ENABLING PROGRESS.

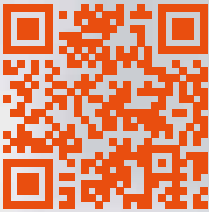
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**MILLING & SIEVING**  
**PARTICLE CHARACTERIZATION**  
**PHARMACEUTICAL TESTING**

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