# norelem

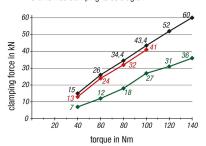
#### Item description/product images







5-axis vice clamping force diagram



- Spindle tractive force
- Normal vice / clamping blanks
- Positive-down effect clamping by 1 mm trave



## **Description**

## **Product description:**

The 5-axis vice features excellent stability and flexibility, and is extremely easy to use. The 5-axis vice can be used as a positive-down force vice or normal vice. When the positive down force function is used, the workpiece can be held with a repeat accuracy of  $\pm 0.01$  mm. A workpiece clamping height of 155/180 mm enables easy access during machining. The clamping width is preset using the crank handle, cutting down on setup times. Additionally, the closed geometries and the resistance to dirt that they provide keep maintenance and repair times to a minimum.

#### Material:

Steel.

#### Version:

Baseplate and workpiece support hardened.

#### Note:

Additional product information can be found in the operating instructions.

## Type of operation:

Quick adjustment using crank handle.

#### **Advantages:**

For use as centric-clamping device with positive down force function or vice. Straightforward, infinite clamping width adjustment using crank handle. Optimum clamping height for 5-axis machining. Flexible options for connection to machine tables.

## On request:

Various spare parts, larger clamping widths.

### Supplied with:

Depending on the baseplate length, see operating instructions.

#### **Accessory:**

Baseplates 41405

Jaw plates with pins 41410

Combination jaw plates, smooth/with pins 41410

Jaw plates, machinable 41320

Seating ledges 41345

Extension shafts 41355

Cylinder clamping set 41350

Stop set 41370

Clamping pin 42208-140250516, 42208-240250516

Clamping claw sets 41375

Slot nuts 03240-1814x20

Fitted bolts 07533-12065

Socket head screws 07160-12X60

Torque wrench 96662-01-01

## **Applications:**

Suitable for T-slot and grid hole tables and zero-point clamping systems. Size 282.84mm for diagonal alignment on zero-point clamping systems with gauge 52/96/200mm.

## **Tolerances:**

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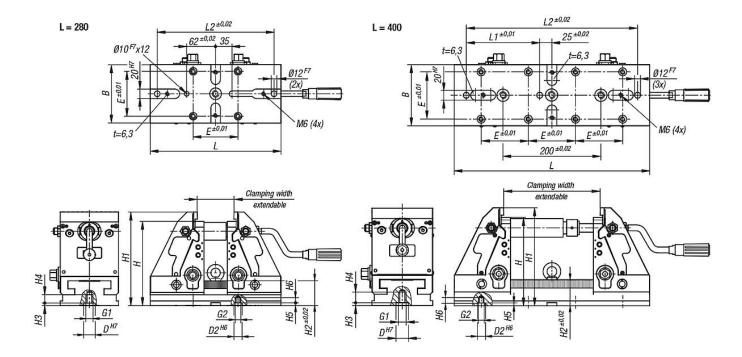


# Item description/product images



With a clamping depth of > 5 mm, the repeat accuracy while the positive down force function is being used is  $\pm 0.01$ .

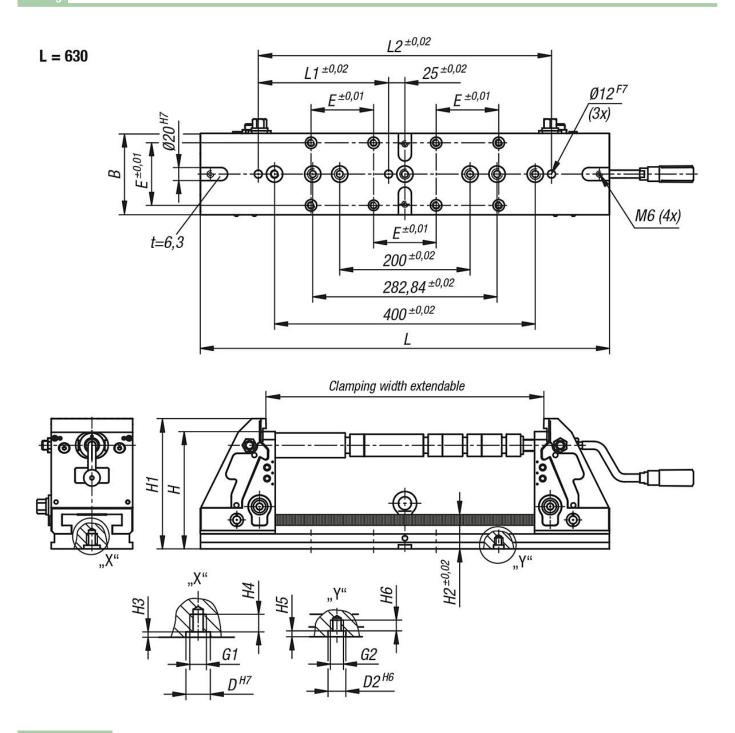
## Drawings



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Drawings



## Overview of items

Order No.	В	L	Н	L1	L2	H1	H2	Н3	H4	H5	H6	D	D2	Е	G1	G2	Clamping width extendable	Tractive force max. kN
41400-122800901550	90	280	155	-	250	175	53	5,5	18	6	11	25H7	12H6	52	M12	M8	28-180	see diagram
41400-124000901550	90	400	155	150	350	175	53	5,5	18	6	11	25H7	12H6	52	M12	M8	28-300	see diagram
41400-122801251800	125	280	180	-	250	200	53	5,5	18	6	11	25H7	16H6	96	M12	M10	28-180	see diagram
41400-124001251800	125	400	180	150	350	200	53	5,5	18	6	11	25H7	16H6	96	M12	M10	28-300	see diagram
41400-126301251800	125	630	180	200	450	200	53	5,5	18	6	11	25H7	16H6	96	M12	M10	28-528	see diagram

# 41400 5-axis vice jaw plates smooth



Overview of items

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