

ALLMATIC HD – EXTREMELY ROBUST AND RELIABLE

For more than 40 years now, ALLMATIC HD has been a watchword for reliability. Its sturdy design effectively makes it a lifetime investment.



ALLMATIC HD – MECHANICAL

Scope of application:

- Suitable for heavy machining work, single pieces and small batches
- Designed particularly for use on conventional milling machines

Product features:

- Clamping force preselection, 2 to 4 increments, allows accurate repetition (type 100 – 2 increments; types 125, 160 – 4 increments)
- Our tried and tested HD vice enables problem-free working with high clamping force and long-term reliability



Hardened, ground and polished guideway

Robust base made of GGG 60

Clamping force presetting

M8 thread for workpiece stop

Precise aligning slots (longitudinal/transverse) in the bottom surface for optimal alignment on the machine table

Fixing bolt for presetting the clamping range

Order no. jaw width 100: 6921011000055
125: 6921021000055
160: 6921031000055

Scope of supply:

- 1 high-pressure vice
- 4 side clamps
- 1 pair of serrated clamping jaws (1501)
- 1 hand crank

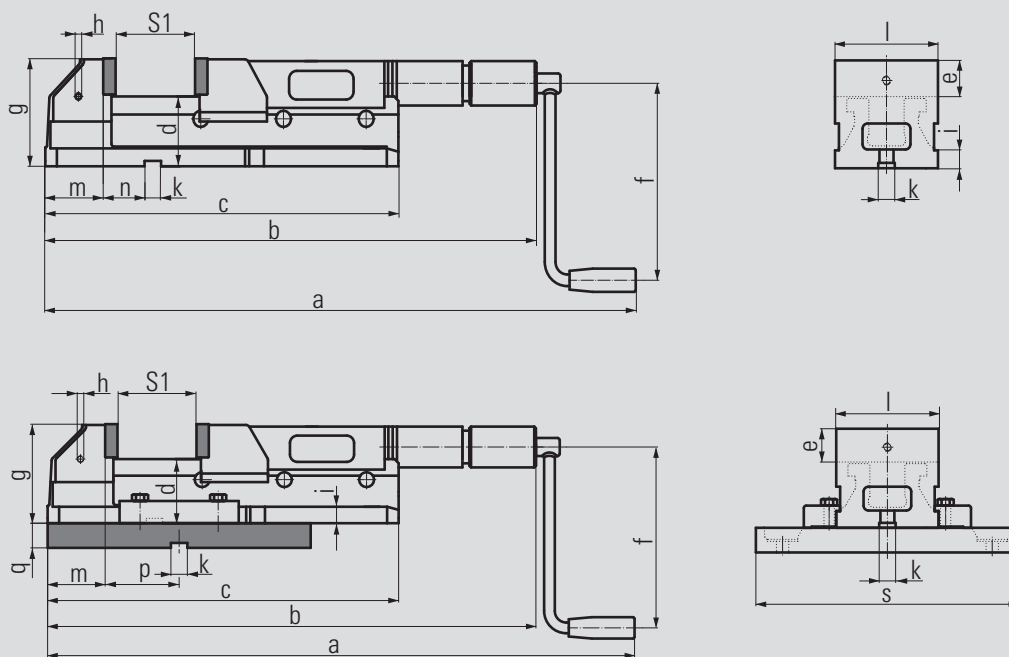
with swivel base: order no. jaw width 100: 6921011000455
125: 6921021000455

Scope of supply:

- 1 high-pressure vice
- 1 pair of serrated clamping jaws
- 1 swivel base
- 1 hand crank

An overview of the clamping jaws and other accessories is given on the following pages.





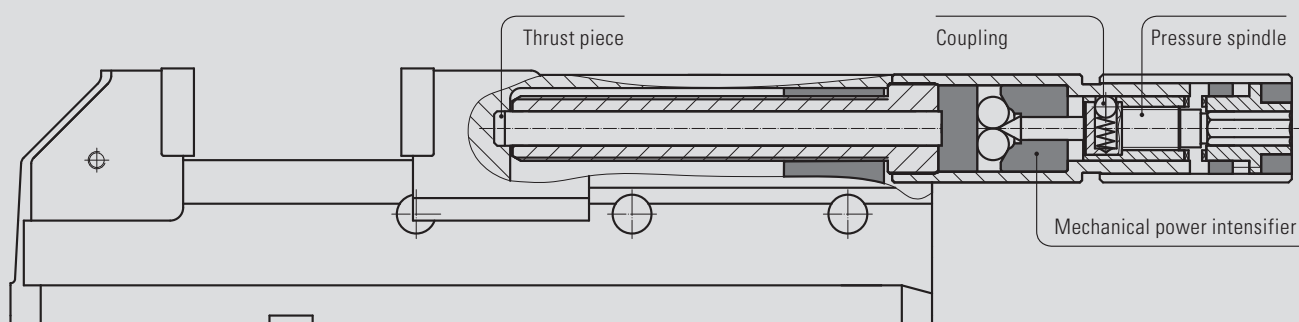
Technical data

Jaw width		100	125	160
Dimensions / tolerances in mm	a min.	520	612	717
	a max.	682	814	1019
	b min.	419	507	613
	b max.	581	709	915
	c	362	427	582
	d	53.5	78	85
	e	32	40	50
	f	147	178	178
	g	87	120	137
	h	M8	M8	M8
	i	15	21	21
	k	20	20	20
	l	100	125	160
	m	52	70	88
	n	47	50	100
p	73	75	—	
q	26	30	—	
s	Ø 260	Ø 320	—	

Jaw width	100	125	160
Clamping range S1 in mm	0 – 82	0 – 102	0 – 152
Clamping range S2 in mm (can be changed by means of fixing bolt)	78 – 162	98 – 202	147 – 302

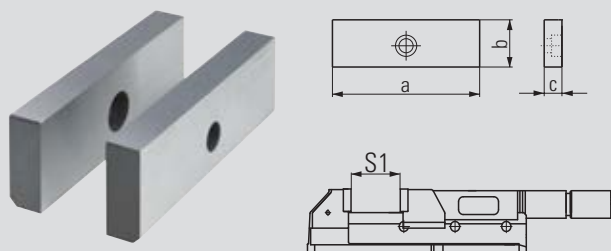
Clamping force increments	2	4	4
Max. clamping force in kN	30	40	60
Weight in kg HD	18	30	60
Weight in kg HD with swivel base	24	42	—

Spindle cross-section



ALLMATIC HD – mechanical (accessories)

Smooth jaws (pair)



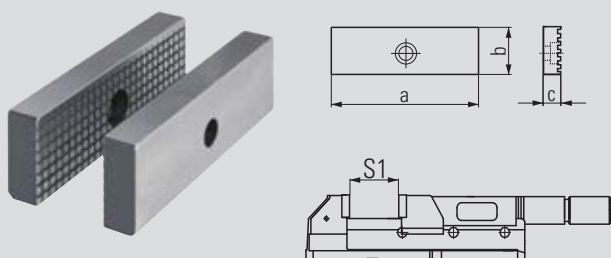
- Material: hardened steel
- For parts with delicate clamping surfaces
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 100: 6921014022031
 125: 6921024022031
 160: 6921034022031

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	12	15	20

Clamping range S1	0 – 82	0 – 102	0 – 152
Can be changed by means of fixing bolt	78 – 162	98 – 202	147 – 302

Serrated jaws (pair)



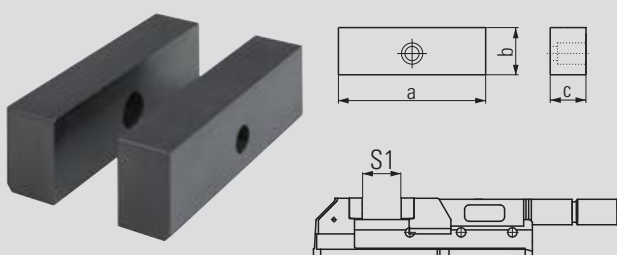
- Material: hardened steel
- Standard jaws with serration
- To increase the specific contact pressure per unit area
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 100: 6921011005031
 125: 6921021005031
 160: 6921031005031

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	12	15	20

Clamping range S1	0 – 82	0 – 102	0 – 152
Can be changed by means of fixing bolt	78 – 162	98 – 202	147 – 302

Soft jaws (pair)



- Material: 21MnCr5G, mat. no.: 1.2162
- Jaws can be case-hardened
- For production of special jaws by the customer
- Please order fastening bolts separately (order no. 6921011023000)

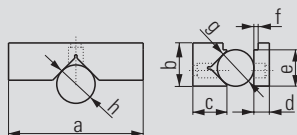
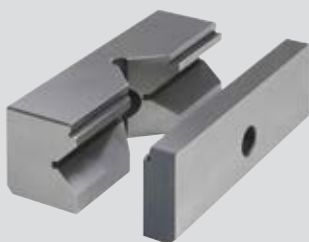
Order no. jaw width 100: 6921014023031
 125: 6921024023031
 160: 6921034023031

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	20	25	30

Clamping range S1	0 – 66	0 – 84	0 – 132
Can be changed by means of fixing bolt	62 – 146	80 – 184	127 – 282

ALLMATIC HD – mechanical (accessories)

Prismatic jaws (set)

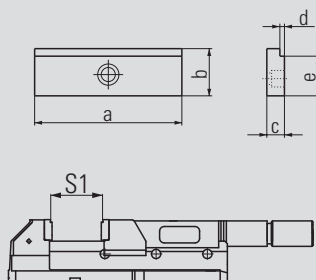


- Material: hardened steel
- For horizontal and vertical clamping of round and flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 100: 6921014024031
 125: 6921024024031
 160: 6921034024031

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	30	35	45
	d	12	15	20
	e	28	35	45
	f	3	3	3
	g	Ø 10 – 25	Ø 12 – 28	Ø 15 – 40
	h	Ø 15 – 45	Ø 18 – 55	Ø 22 – 65

Step jaws (pair)



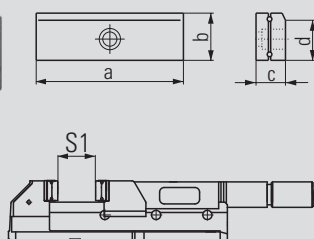
- Material: hardened steel
- For horizontal clamping of flat workpieces
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 100: 6921014025031
 125: 6921024025031
 160: 6921034025031

Jaw width		100	125	160
Dimensions in mm	a	100	125	160
	b	32	40	50
	c	12	15	20
	d	3	3	3
	e	28	35	45

Clamping range S1	7 – 88	7 – 108	7 – 158
Can be changed by means of fixing bolt	84 – 168	104 – 208	153 – 308

Roller pull-down jaws (pair)



- Material: hardened steel
- For parts with delicate clamping surfaces
- Jaw parts in contact with the workpiece press the workpiece onto the support surface
- Please order fastening bolts separately (order no. 6921011023000)

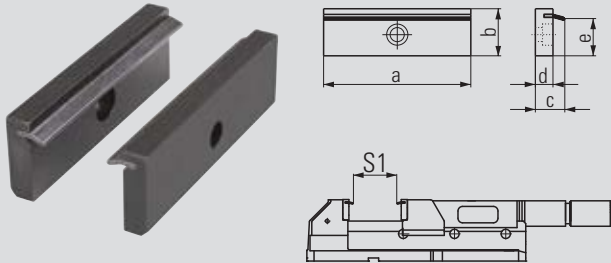
Order no. jaw width 125: 6921024005131
 160: 6921034005131

Jaw width		125	160
Dimensions in mm	a	125	160
	b	40	50
	c	26	35.5
	d	35	45

Clamping range S1	0 – 80	0 – 115
Can be changed by means of fixing bolt	76 – 180	110 – 265

ALLMATIC HD – mechanical (accessories)

Spring leaf pull-down jaws (pair)



- Material: hardened steel
- For parts with unmachined clamping surfaces
- Spring leaves press the workpiece onto the support surface
- Spring leaves are interchangeable, (see below)
- Please order fastening bolts separately (order no. 6921011023000)

Order no. jaw width 100: 6921014001042
 125: 6921024001042
 160: 6921034001042

Jaw width	100	125	160
Dimensions in mm			
a	100	125	160
b	32	40	50
c	20	20	23
d	12	12	15
e	25	33	43

Clamping range S1	0 – 66	0 – 92	0 – 146
Can be changed by means of fixing bolt	62 – 146	88 – 192	141 – 296

Spring leaves (pair)



Order no. jaw width
 100: 6921014002131
 125: 6921024002131
 160: 6921034002131

- Spring leaves (spare)
for the spring leaf pull-down jaws, (see above)

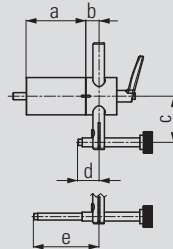
Jaw fixing bolt



Order no. 6921011023000

- Bolt with shoulder – M10 x 23
- Suitable for all jaws, jaw width 090 mm to 160 mm

Workpiece stop



Order no. 6921285650144

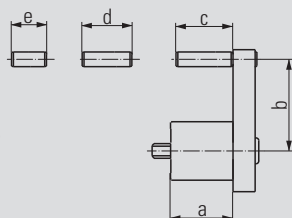
Dimensions in mm	a	b	c	d	e
	67	15	33 – 92	12 – 63.5	53.5 – 113.5

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Position of the third workpiece axis can be preset and clamped
- Workpiece stop can be swivelled away once the workpiece has been clamped
- This allows the stop side of the workpiece to also be machined (repeating accuracy: ± 0.01)



ALLMATIC HD – mechanical (accessories)

Workpiece stop

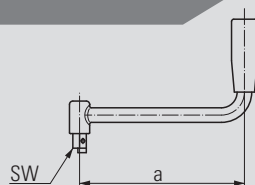


Order no. 6921685670042

Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19

- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Can be pre-mounted with various fixed dimensions
- Position of the third workpiece axis can be preset

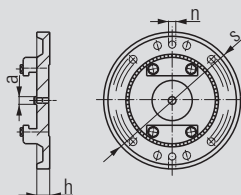
Hand crank



Order no. jaw width 100: 6923015000131
125 & 160: 6923025000131

Jaw width	100	125	160	
Dimensions in mm	a	147	178	178
	SW	12	14	14

Swivel base



Order no. jaw width 100: 6921013000044
125: 6921023000044

Jaw width	100	125	
Dimensions in mm	a	Ø 20	Ø 20
	h	26	30
	n	20	20
	s	Ø 260	Ø 320

- Particularly suitable for single-piece production if you wish to make your vice rotatable
- Can be removed at any time
- Swivel base supporting edge larger than the vice's maximum clamping range

- Swivels 360° without indexing
- Alignment on the machine with T-keys in slots in the swivel base
- Clamping slots arranged in the form of a ring for machines with different slot spacings

Side clamps (pair)



Order no. jaw width
100: 6921015000231
125 & 160: 6921025000031

- For securing the HD high-pressure vice on the machine table

- Supplied as a set of 2

Aligning and fixing set



Order no. – see table

T-slot/thread	Order no.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

- For aligning (positioning) and securing the vice on pallet and machine table
- Size according to T-slot or thread in the machine table