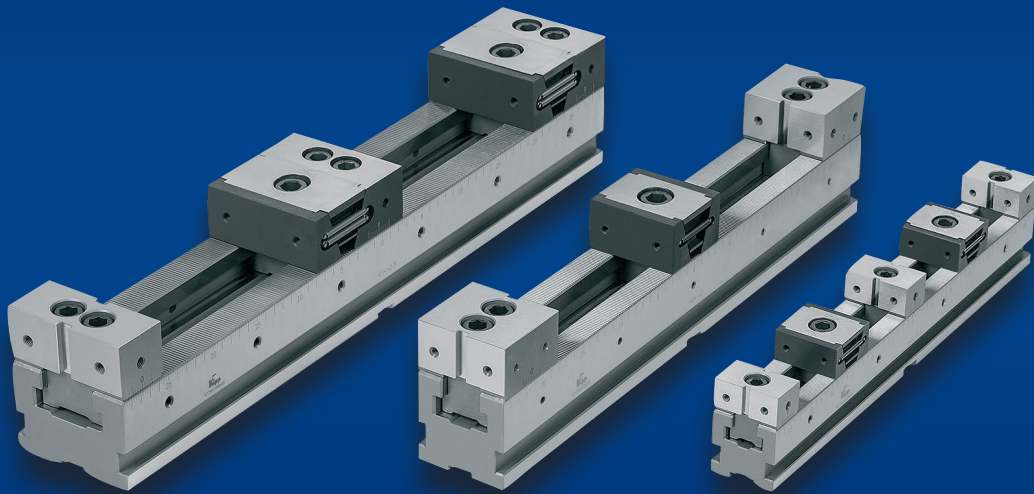




HEINRICH KIPP WERK



# MULTI-CLAMPING SYSTEM

Edition 2024

Clamping Technology

Standard Elements

Operating Parts





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## Multi-clamping system

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Interfaces	5
Applications	6, 11, 15, 19, 39
Products	8 - 38

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Reg. Nr. 002081 QM



## SERVICE HOURS (CET)

MONDAY-THURSDAY	7.00 am - 5.30 pm
FRIDAY	7.00 am - 3.30 pm

# Multi-clamping system



Multi-clamping systems are mainly used for machining large workpiece batches.

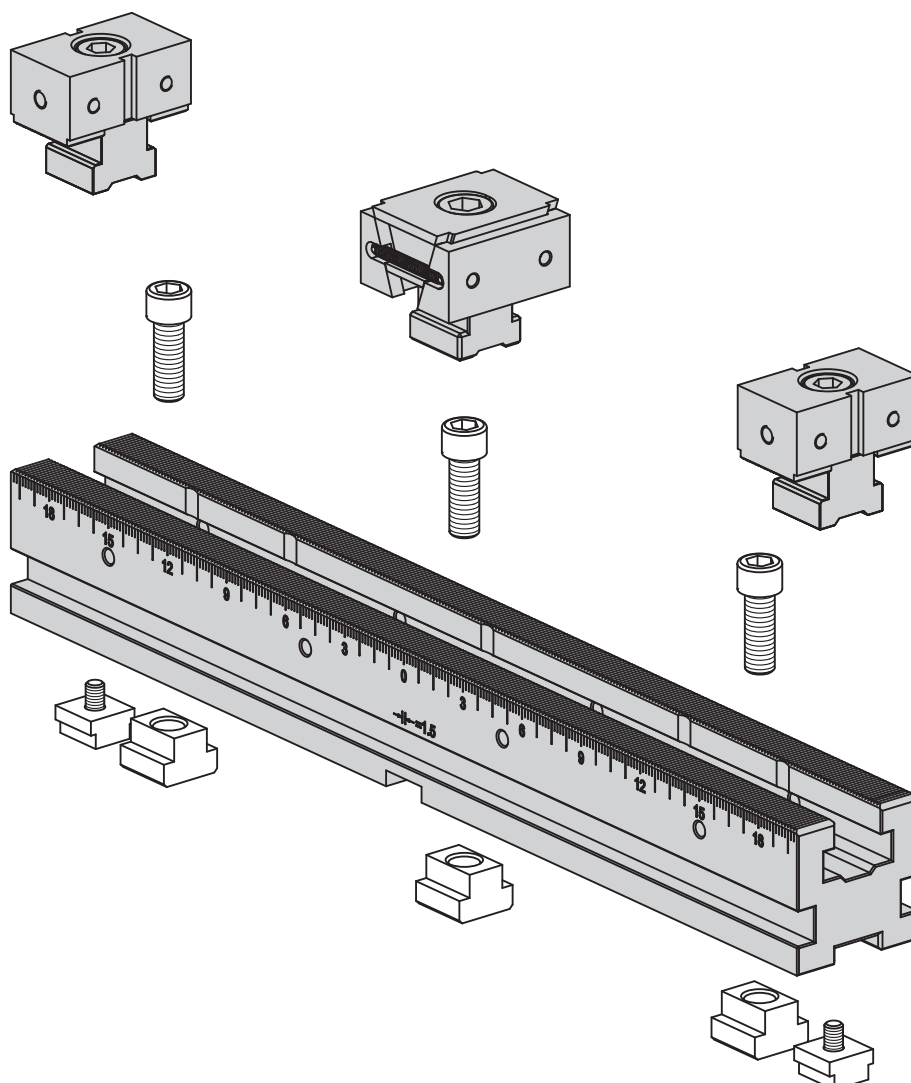
The system can be optionally set up for one or more workpieces.

Depending on the workpiece size and clamping rail length, several workpieces can thus be clamped simultaneously.

Due to the large component selection of the multiple clamping system (clamping rails, fixed jaws, wedge clamps and accessories) workpieces of different quantities and dimensions can be machined without problems and with optimised set-up times.

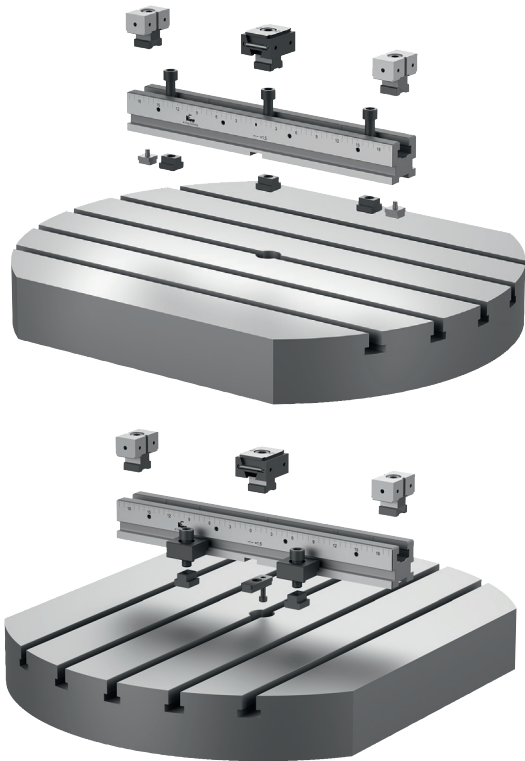
The user can choose between single-sided or double-sided types of wedge clamps.

The teeth on the clamping rails are precision-ground and guarantee secure and precise fastening of the fixed stops. By mounting several clamping rails along and across the table, the working area and the number of workpieces can be effectively optimised.

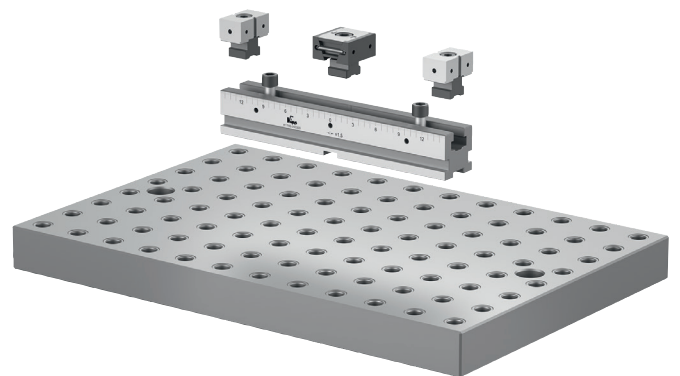




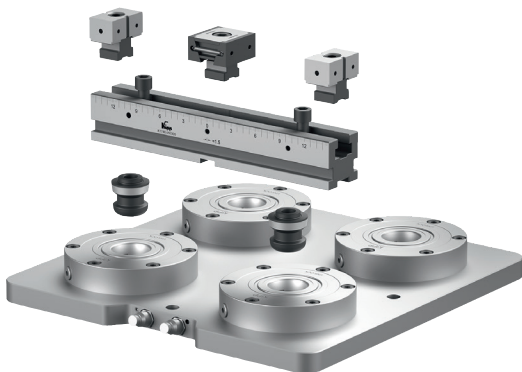
# Interfaces



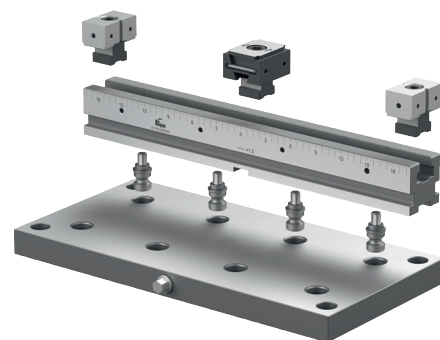
Mounting of the multi-clamping system along and across a T-slot machine table is possible.  
Alignment with slot keys. Secured using screws or clamping claws.



Mounting the multi-clamping system on a grid system.  
Positioned and fastened using shoulder screws.

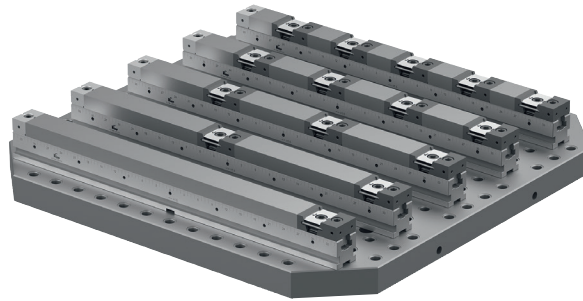


Adaptation of the multi-clamping system to a conventional zero-point clamping system.  
Fits on 200 mm gauge size.  
Ø25H6 locating hole and M12 fastening screw.



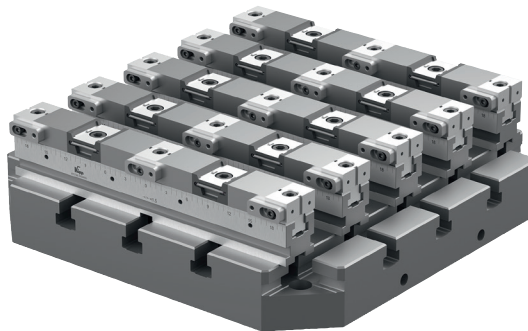
Adaptation of the multi-clamping system to a mechanical zero-point clamping system.  
Fits on 96mm gauge size.  
Ø16H6 locating hole and M10 fastening thread.

# Example of a multi-clamping system



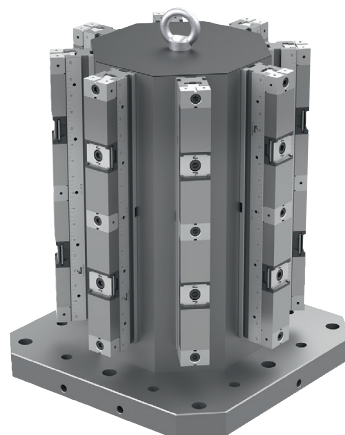
Application of the multi-clamping system with different workpieces.  
Wedge clamps used here have the force coming from one side.  
Depending on the workpiece size, several workpieces can be clamped using identical clamping rails.  
The multi-clamping system can be modified flexibly and quickly.

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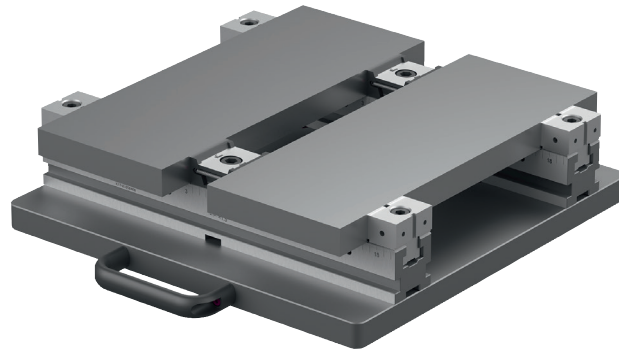
Multi-clamping system aligned and secured on pallet with T-slots.  
Multi-clamping system set up for 20 identical workpieces.  
Space-saving fixed jaws with one mounting screw.  
Wedge clamps constructed as double-sided clamping element.

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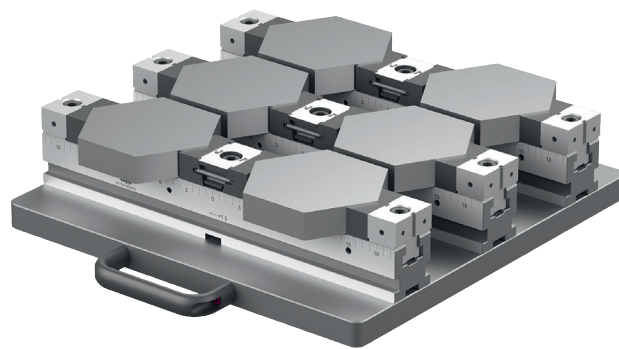


Flexible application of the multi-clamping system on an octagonal workholding tower.  
With this clamping arrangement, many workpieces can be clamped simultaneously to extend the machine running time.

# Example of a multi-clamping system



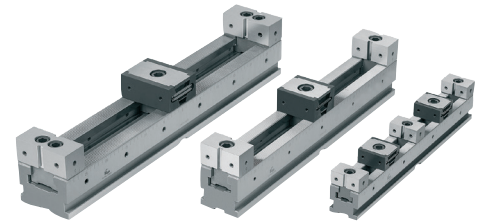
Multi-clamping system mounted on an interchangeable pallet.  
The workpieces can be reloaded externally to the machine to extend the machine running time.  
With the double-sided arrangement of the wedge clamps, both plates can be clamped simultaneously.



Multi-clamping system mounted on an interchangeable pallet.  
Attachment jaws with prisms are screwed onto the fixed jaws of the multi-clamping system.  
Machinable wedge clamps are used on the clamping elements. The workpiece contour is machined into the excess material.

## Multi-clamping system double-sided wedge clamps

fixed jaw ES



**Material:**

Clamping rail and fixed jaw tool steel.  
Wedge clamp mild steel.

**Version:**

Clamping rail and fixed jaw hardened and ground (HRC 55 ± 2).  
Wedge clamp hardened, phosphated.

**Sample order:**

K1828.05040001

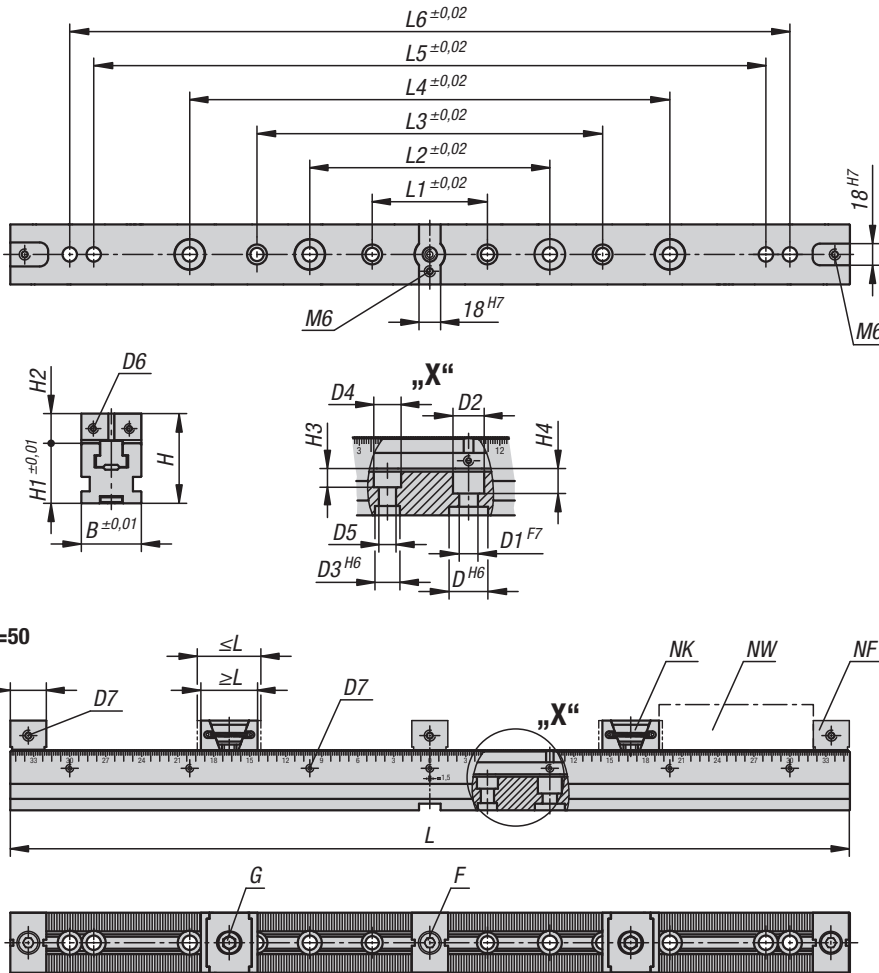
**Note:**

The multi-clamping system can be fastened using various interfaces.

1. Lateral clamping edge for clamping claw set. Claw clamps can be fastened at any position.
2. Holes for DIN cap screws.
3. Ø25 mm locating holes for conventional zero-point clamping systems with 200 mm spacing.
4. Ø16 mm locating holes for zero-point clamping systems with 96 mm spacing.
5. Three 18H7 alignment slots for crosswise and lengthwise alignment on T-slot tables.
6. Ø12F7 and Ø16F7 reamed holes for 40 and 50 mm grid systems.

Three different versions are available:

- Multi-clamping system double-sided wedge clamp with OS fixed jaw / K1828.
- Multi-clamping system double-sided wedge clamp with DS fixed jaw / K1829.
- Multi-clamping system single-sided wedge clamp with OS fixed jaw / K1830.



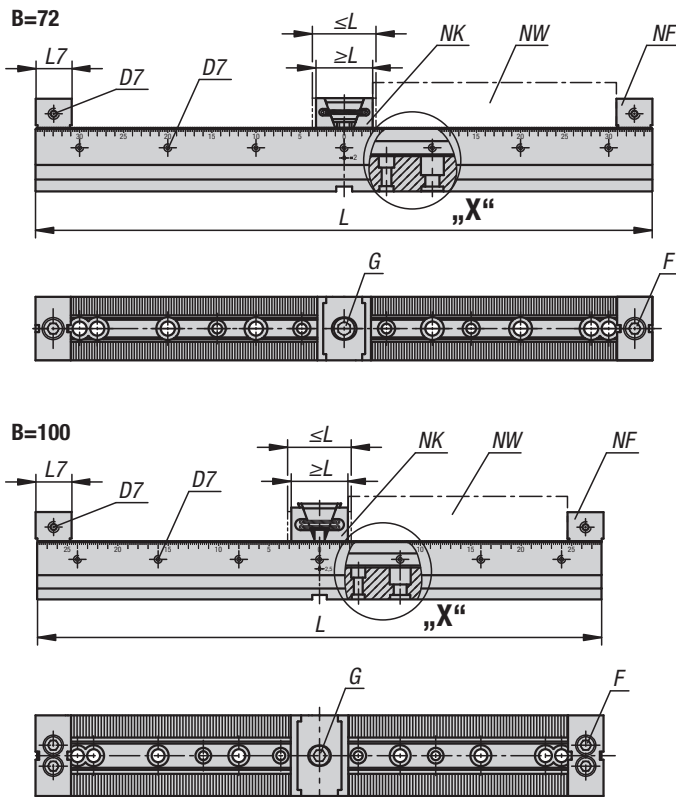
### KIPP Multi-clamping system double-sided wedge clamps, fixed jaw ES

Order No. smooth	Order No. serrated	B	L	H	L min.	L max.	L1	L2	L3	L4	L5	L6	L7	D	D1	D2	D3	Clamping force max. kN	Tightening torque max. Nm
K1828.05030001	K1828.05030002	50	300	75	44,5	50,5	96	200	-	-	-	-	30	25	12	20	16	10	30
K1828.05040001	K1828.05040002	50	400	75	44,5	50,5	96	200	288	300	-	-	30	25	12	20	16	10	30
K1828.05050001	K1828.05050002	50	500	75	44,5	50,5	96	200	288	400	-	-	30	25	12	20	16	10	30
K1828.05060001	K1828.05060002	50	600	75	44,5	50,5	96	200	288	400	500	-	30	25	12	20	16	10	30
K1828.05070001	K1828.05070002	50	700	75	44,5	50,5	96	200	288	400	560	600	30	25	12	20	16	10	30
K1828.07240001	K1828.07240002	72	400	112	61	68	96	200	288	300	-	-	40	25	16	26	16	20	50
K1828.07250001	K1828.07250002	72	500	112	61	68	96	200	288	400	-	-	40	25	16	26	16	20	50
K1828.07260001	K1828.07260002	72	600	112	61	68	96	200	288	400	500	-	40	25	16	26	16	20	50
K1828.07270001	K1828.07270002	72	700	112	61	68	96	200	288	400	560	600	40	25	16	26	16	20	50
K1828.10040001	K1828.10040002	100	400	114,6	71	78	96	200	288	300	-	-	44	25	16	26	16	30	65
K1828.10050001	K1828.10050002	100	500	114,6	71	78	96	200	288	400	-	-	44	25	16	26	16	30	65
K1828.10060001	K1828.10060002	100	600	114,6	71	78	96	200	288	400	500	-	44	25	16	26	16	30	65
K1828.10070001	K1828.10070002	100	700	114,6	71	78	96	200	288	400	560	600	44	25	16	26	16	30	65

## Multi-clamping system double-sided wedge clamps



fixed jaw ES



### Application:

A number of multi-clamping systems with different lengths can be mounted one behind the other or beside each other. The precision toothing enables highly precise positioning of the fixed jaws. Due to the lateral graduations on the clamping rails, each position of the fixed jaws can be documented and reset identically. Stops can be mounted in the tapped holes on the side. Turning the clamping screw moves the clamping segments outwards and press the workpieces against the fixed jaw.

### Advantages:

Universal and flexible.  
For small and large batch sizes.  
Large components can also be clamped next to each other on several multiple clamping systems.

### Supplied with:

1x clamping rail  
The number of wedge clamps and fixed jaws is dependent on the system size (see table).

### Accessories:

- Clamping pin K0967.
- Cap screws K0869.
- Shoulder screws K0815.12045 / K0815.16055.
- Seating ledges K1752.
- Attachment jaws with machining allowance K1753.
- Attachment jaws with prism K1754.
- Workpiece stop K1755.
- Spacer K1756.
- Clamping claw set K1757.
- T-slot nut K1758.
- T-slot key K0954.

### Technical data:

System width 50  
Maximum clamping force: 10 kN  
Maximum tightening torque: 30 Nm

System width 72  
Maximum clamping force: 20 kN  
Maximum tightening torque: 50 Nm

System width 100  
Maximum clamping force: 30 kN  
Maximum tightening torque: 65 Nm

Order No. smooth	Order No. serrated	B	L	D4	D5	D6	D7	H1	H2	H3	H4	F Socket head screw DIN 912	G cap screw DIN 912	NK = Quantity Wedge clamp	NF = Quantity Fixed jaw	NW = Quantity Workpieces
K1828.05030001	K1828.05030002	50	300	17,5	11	M5	M6	50	25	12	16	M10x30	M12x25	2	3	4
K1828.05040001	K1828.05040002	50	400	17,5	11	M5	M6	50	25	12	16	M10x30	M12x25	2	3	4
K1828.05050001	K1828.05050002	50	500	17,5	11	M5	M6	50	25	12	16	M10x30	M12x25	2	3	4
K1828.05060001	K1828.05060002	50	600	17,5	11	M5	M6	50	25	12	16	M10x30	M12x25	2	3	4
K1828.05070001	K1828.05070002	50	700	17,5	11	M5	M6	50	25	12	16	M10x30	M12x25	2	3	4
K1828.07240001	K1828.07240002	72	400	17,5	11	M6	M6	72	40	15	23,5	M14X1,5X50	M16x40	1	2	2
K1828.07250001	K1828.07250002	72	500	17,5	11	M6	M6	72	40	15	23,5	M14X1,5X50	M16x40	1	2	2
K1828.07260001	K1828.07260002	72	600	17,5	11	M6	M6	72	40	15	23,5	M14X1,5X50	M16x40	1	2	2
K1828.07270001	K1828.07270002	72	700	17,5	11	M6	M6	72	40	15	23,5	M14X1,5X50	M16x40	1	2	2
K1828.10040001	K1828.10040002	100	400	17,5	11	M6	M8	72	42,6	15	23,5	M14X1,5X50	M16x40	1	2	2
K1828.10050001	K1828.10050002	100	500	17,5	11	M6	M8	72	42,6	15	23,5	M14X1,5X50	M16x40	1	2	2
K1828.10060001	K1828.10060002	100	600	17,5	11	M6	M8	72	42,6	15	23,5	M14X1,5X50	M16x40	1	2	2
K1828.10070001	K1828.10070002	100	700	17,5	11	M6	M8	72	42,6	15	23,5	M14X1,5X50	M16x40	1	2	2

## Multi-clamping system double-sided wedge clamps

fixed jaw ES



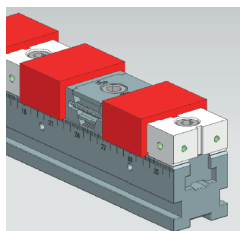
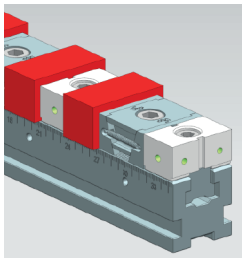
Maximum workpiece size for types double-sided wedge clamps and fixed jaw ES

Clamping rails	1 pcs.			2 pcs.		
	B=50	B=72	B=100	B=50	B=72	B=100
L=300	193	-	-	96	-	-
L=400	292	257	241	146	128	121
L=500	394	357	341	197	178	171
L=600	493	457	441	246	228	221
L=700	592	557	541	296	278	271

Clamping rails	3 pcs.			4 pcs.		
	B=50	B=72	B=100	B=50	B=72	B=100
L=300	39	-	-	29	-	-
L=400	72	51	41	54	38	31
L=500	106	72	74	79	63	56
L=600	139	118	107	104	88	81
L=700	172	151	141	129	113	106

Clamping rails	5 pcs.			6 pcs.		
	B=50	B=72	B=100	B=50	B=72	B=100
L=300	8	-	-	6	-	-
L=400	27	10	-	23	8	-
L=500	48	30	21	40	25	17
L=600	68	50	51	56	42	34
L=700	87	70	61	73	58	51

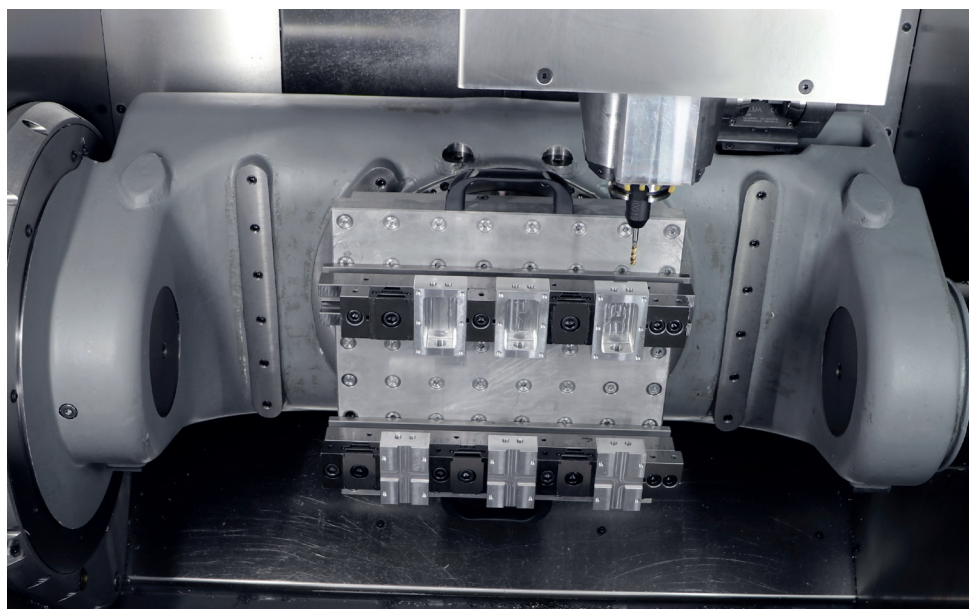
Clamping rails	7 pcs.			8 pcs.		
	B=50	B=72	B=100	B=50	B=72	B=100
L=300	-	-	-	-	-	-
L=400	9	-	-	8	-	-
L=500	23	7	-	20	6	-
L=600	37	21	12	33	18	11
L=700	51	35	51	45	31	23



Combination of clamping rails for multi-clamping system K1746.  
Wedge clamp K1748 and  
Fixed jaw ES for multi-clamping system K1750.



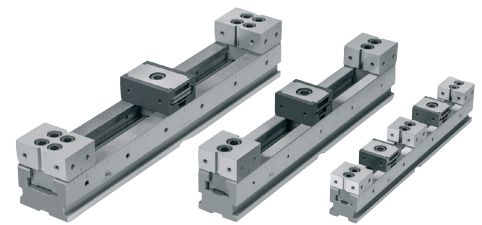
## Example of a multi-clamping system



The multi-clamping system mounted on an interchangeable plate with grid system.

## Multi-clamping system double-sided wedge clamps

fixed jaw DS



**Material:**

Clamping rail and fixed jaw tool steel.  
Wedge clamp mild steel.

**Version:**

Clamping rail and fixed jaw hardened and ground (HRC 55 ± 2).  
Wedge clamp hardened, phosphated.

**Sample order:**

K1829.05040001

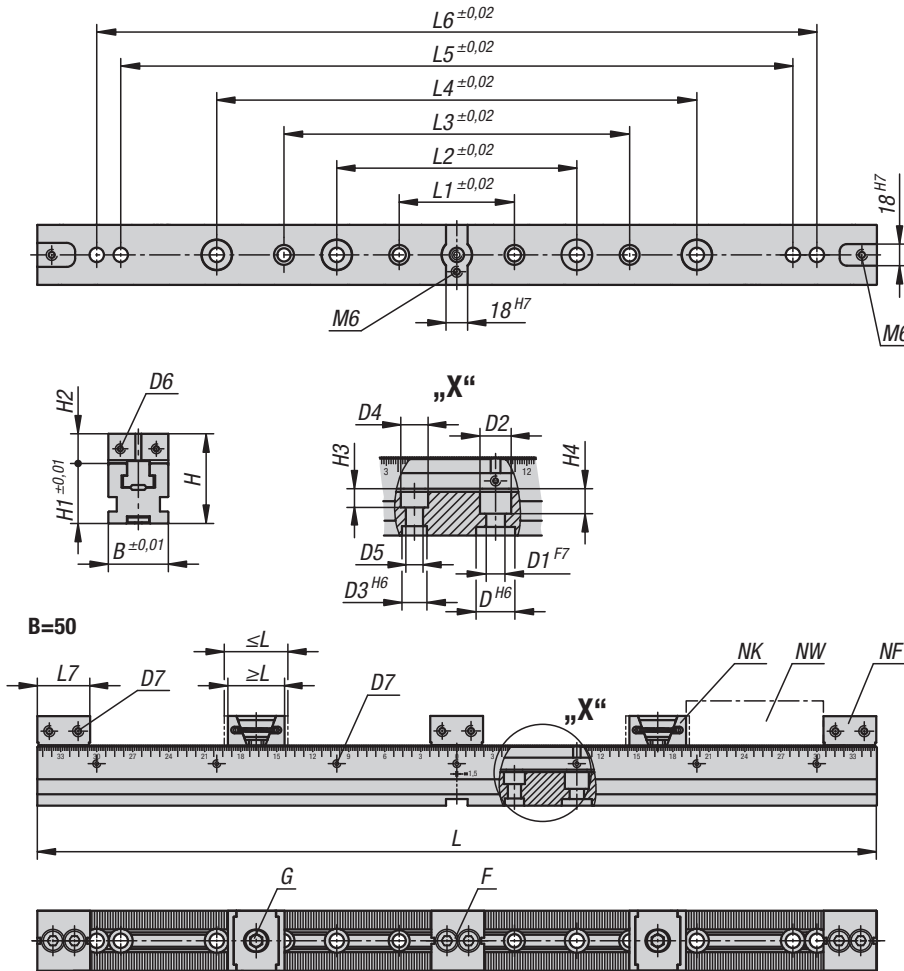
**Note:**

The multi-clamping system can be fastened using various interfaces.

1. Lateral clamping edge for clamping claw set. Claw clamps can be fastened at any position.
2. Holes for DIN cap screws.
3. Ø25 mm locating holes for conventional zero-point clamping systems with 200 mm spacing.
4. Ø16 mm locating holes for zero-point clamping systems with 96 mm spacing.
5. Three 18H7 alignment slots for crosswise and lengthwise alignment on T-slot tables.
6. Ø12F7 and Ø16F7 reamed holes for 40 and 50 mm grid systems.

Three different versions are available:

- Multi-clamping system double-sided wedge clamp with OS fixed jaw / K1828.
- Multi-clamping system double-sided wedge clamp with DS fixed jaw / K1829.
- Multi-clamping system single-sided wedge clamp with OS fixed jaw / K1830.



### KIPP Multi-clamping system double-sided wedge clamps, fixed jaw DS

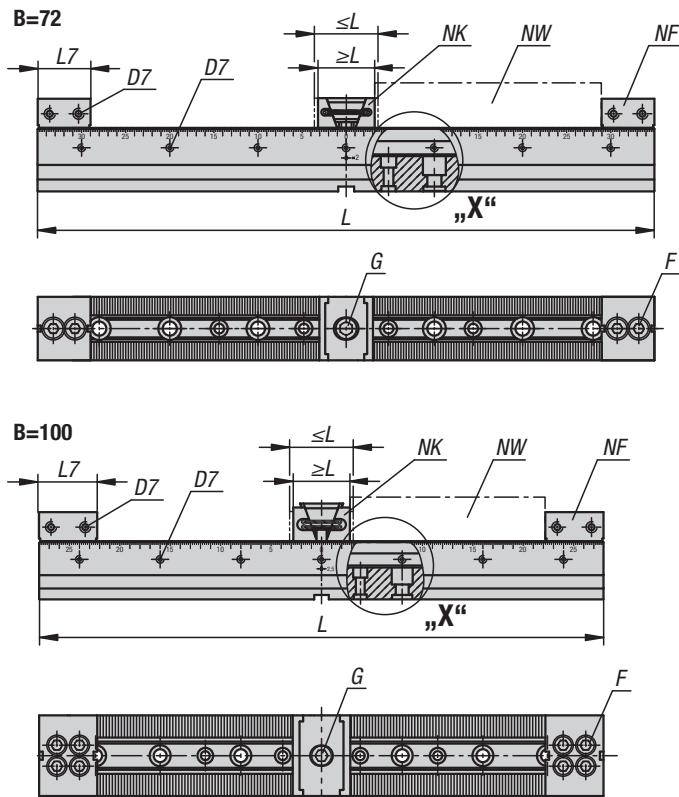
Order No. smooth	Order No. serrated	B	L	H	L min.	L max.	L1	L2	L3	L4	L5	L6	L7	D	D1	D2	D3	Clamping force max. kN	Tightening torque max. Nm
K1829.05030001	K1829.05030002	50	300	75	44,5	50,5	96	200	-	-	-	-	44	25	12	20	16	20	50
K1829.05040001	K1829.05040002	50	400	75	44,5	50,5	96	200	288	300	-	-	44	25	12	20	16	20	50
K1829.05050001	K1829.05050002	50	500	75	44,5	50,5	96	200	288	400	-	-	44	25	12	20	16	20	50
K1829.05060001	K1829.05060002	50	600	75	44,5	50,5	96	200	288	400	500	-	44	25	12	20	16	20	50
K1829.05070001	K1829.05070002	50	700	75	44,5	50,5	96	200	288	400	560	600	44	25	12	20	16	20	50
K1829.07240001	K1829.07240002	72	400	112	61	68	96	200	288	300	-	-	65	25	16	26	16	30	65
K1829.07250001	K1829.07250002	72	500	112	61	68	96	200	288	400	-	-	65	25	16	26	16	30	65
K1829.07260001	K1829.07260002	72	600	112	61	68	96	200	288	400	500	-	65	25	16	26	16	30	65
K1829.07270001	K1829.07270002	72	700	112	61	68	96	200	288	400	560	600	65	25	16	26	16	30	65
K1829.10040001	K1829.10040002	100	400	114,6	71	78	96	200	288	300	-	-	70	25	16	26	16	40	100
K1829.10050001	K1829.10050002	100	500	114,6	71	78	96	200	288	400	-	-	70	25	16	26	16	40	100
K1829.10060001	K1829.10060002	100	600	114,6	71	78	96	200	288	400	500	-	70	25	16	26	16	40	100
K1829.10070001	K1829.10070002	100	700	114,6	71	78	96	200	288	400	560	600	70	25	16	26	16	40	100



## Multi-clamping system double-sided wedge clamps



fixed jaw DS



### Technical data:

System width 50  
 Maximum clamping force: 20 kN  
 Maximum tightening torque: 50 Nm

System width 72  
 Maximum clamping force: 30 kN  
 Maximum tightening torque: 65 Nm

System width 100  
 Maximum clamping force: 40 kN  
 Maximum tightening torque: 100 Nm

### Application:

A number of multi-clamping systems with different lengths can be mounted one behind the other or beside each other. The precision toothing enables highly precise positioning of the fixed jaws. Due to the lateral graduations on the clamping rails, each position of the fixed jaws can be documented and reset identically. Stops can be mounted in the tapped holes on the side. Turning the clamping screw moves the clamping segments outwards and press the workpieces against the fixed jaw.

### Advantages:

Universal and flexible.  
 For small and large batch sizes.  
 Large components can also be clamped next to each other on several multiple clamping systems.

### Supplied with:

1x clamping rail  
 The number of wedge clamps and fixed jaws is dependent on the system size (see table).

### Accessories:

Clamping pin K0967.  
 Cap screws K0869.  
 Shoulder screws K0815.12045 / K0815.16055.  
 Seating ledges K1752.  
 Attachment jaws with machining allowance K1753.  
 Attachment jaws with prism K1754.  
 Workpiece stop K1755.  
 Spacer K1756.  
 Clamping claw set K1757.  
 T-slot nut K1758.  
 T-slot key K0954.

Order No. smooth	Order No. serrated	B	L	D4	D5	D6	D7	H1	H2	H3	H4	F Socket head screw DIN 912	G cap screw DIN 912	NK = Quantity Wedge clamp	NF = Quantity Fixed jaw	NW = Quantity Workpieces
K1829.05030001	K1829.05030002	50	300	17,5	11	M5	M6	50	25	12	16	M10x30	M12x25	2	3	4
K1829.05040001	K1829.05040002	50	400	17,5	11	M5	M6	50	25	12	16	M10x30	M12x25	2	3	4
K1829.05050001	K1829.05050002	50	500	17,5	11	M5	M6	50	25	12	16	M10x30	M12x25	2	3	4
K1829.05060001	K1829.05060002	50	600	17,5	11	M5	M6	50	25	12	16	M10x30	M12x25	2	3	4
K1829.05070001	K1829.05070002	50	700	17,5	11	M5	M6	50	25	12	16	M10x30	M12x25	2	3	4
K1829.07240001	K1829.07240002	72	400	17,5	11	M6	M6	72	40	15	23,5	M14X1,5X50	M16x40	1	2	2
K1829.07250001	K1829.07250002	72	500	17,5	11	M6	M6	72	40	15	23,5	M14X1,5X50	M16x40	1	2	2
K1829.07260001	K1829.07260002	72	600	17,5	11	M6	M6	72	40	15	23,5	M14X1,5X50	M16x40	1	2	2
K1829.07270001	K1829.07270002	72	700	17,5	11	M6	M6	72	40	15	23,5	M14X1,5X50	M16x40	1	2	2
K1829.10040001	K1829.10040002	100	400	17,5	11	M6	M8	72	42,6	15	23,5	M14X1,5X50	M16x40	1	2	2
K1829.10050001	K1829.10050002	100	500	17,5	11	M6	M8	72	42,6	15	23,5	M14X1,5X50	M16x40	1	2	2
K1829.10060001	K1829.10060002	100	600	17,5	11	M6	M8	72	42,6	15	23,5	M14X1,5X50	M16x40	1	2	2
K1829.10070001	K1829.10070002	100	700	17,5	11	M6	M8	72	42,6	15	23,5	M14X1,5X50	M16x40	1	2	2

## Multi-clamping system double-sided wedge clamps

fixed jaw DS



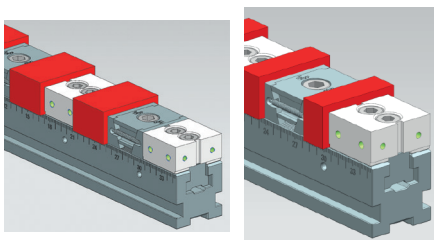
Maximum workpiece sizes for the types double-sided wedge clamp and fixed jaw DS

Clamping rails	1 pcs.			2 pcs.		
	B=50	B=72	B=100	B=50	B=72	B=100
L=300	164	-	-	82	-	-
L=400	263	208	190	131	104	95
L=500	365	308	290	182	154	145
L=600	464	408	390	232	204	195
L=700	563	508	490	281	254	245

Clamping rails	3 pcs.			4 pcs.		
	B=50	B=72	B=100	B=50	B=72	B=100
L=300	24	-	-	18	-	-
L=400	57	26	15	43	20	17
L=500	91	60	48	68	45	36
L=600	124	93	82	93	70	61
L=700	157	126	115	118	95	86

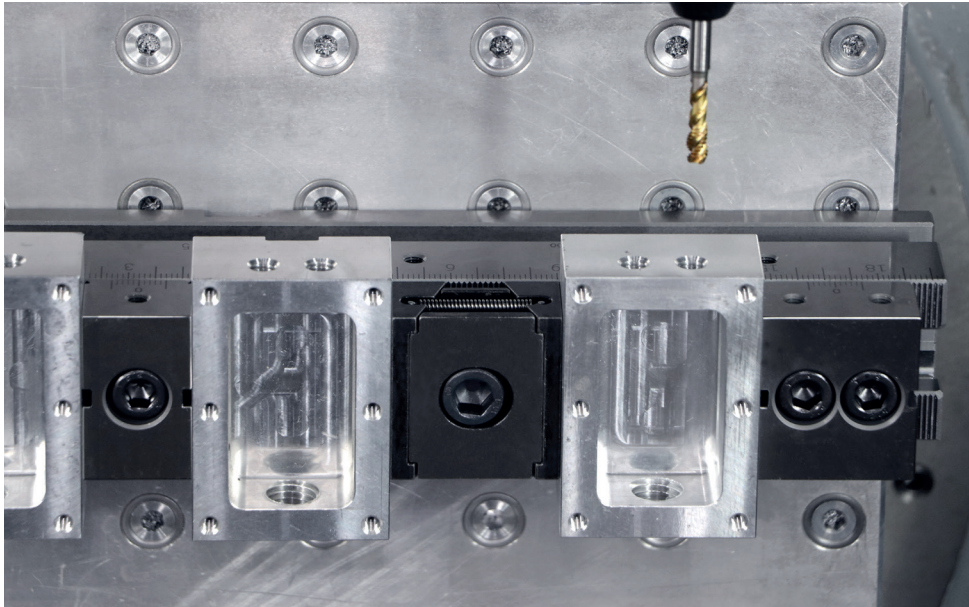
Clamping rails	5 pcs.			6 pcs.		
	B=50	B=72	B=100	B=50	B=72	B=100
L=300	-	-	-	-	-	-
L=400	16	-	-	13	-	-
L=500	36	10	-	30	9	-
L=600	56	30	20	47	25	17
L=700	76	50	40	63	42	33

Clamping rails	7 pcs.			8 pcs.		
	B=50	B=72	B=100	B=50	B=72	B=100
L=300	-	-	-	-	-	-
L=400	-	-	-	-	-	-
L=500	13	-	-	11	-	-
L=600	27	-	-	24	-	-
L=700	41	18	18	36	15	7



Combination of clamping rails for multi-clamping system K1746.  
Wedge clamp K1748 and  
Fixed jaw DS for multi-clamping system K1751.

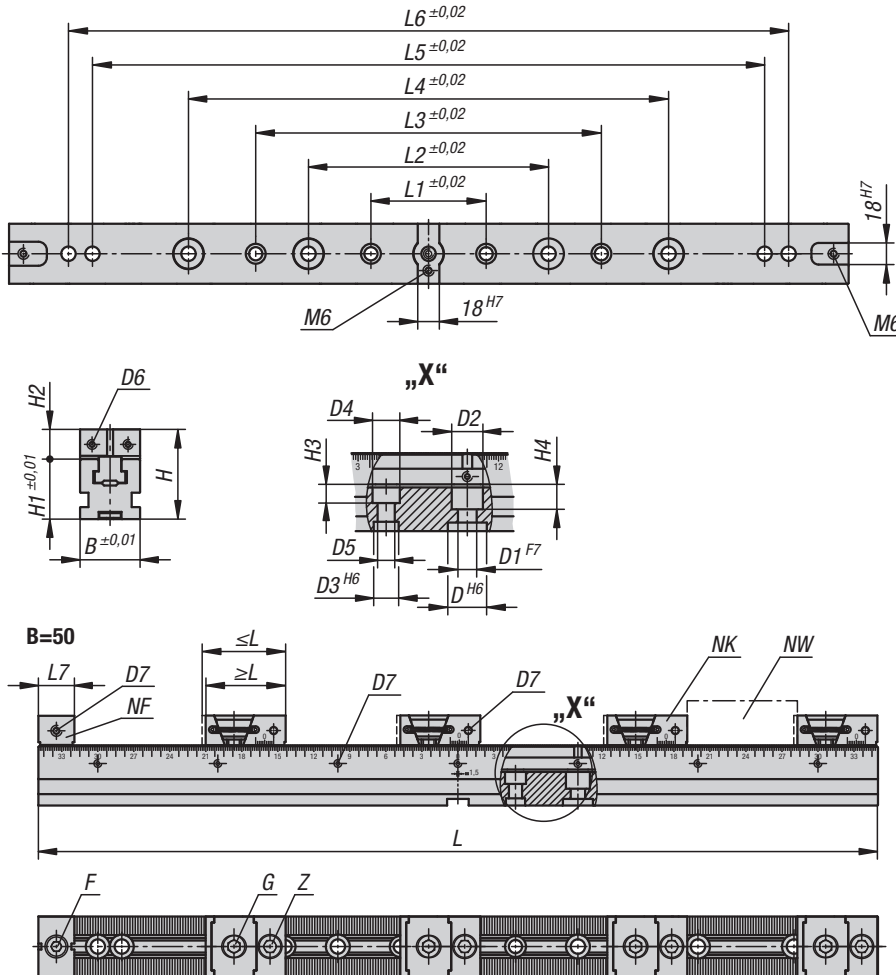
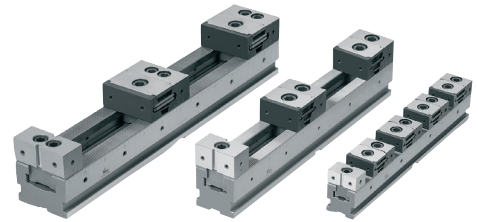
## Example of a multi-clamping system



The multi-clamping system with wedge clamps double-sided and various fixed jaws combined.

## Multi-clamping system single-sided wedge clamps

fixed jaw ES



**Material:**

Clamping rail and fixed jaw tool steel.  
Wedge clamp mild steel.

**Version:**

Clamping rail and fixed jaw hardened and ground (HRC 55 ±2).  
Wedge clamp hardened, phosphated.

**Sample order:**

K1830.05050001

**Note:**

The multi-clamping system can be fastened using various interfaces.

1. Lateral clamping edge for clamping claw set. Claw clamps can be fastened at any position.
2. Holes for DIN cap screws.
3. Ø25 mm locating holes for conventional zero-point clamping systems with 200 mm spacing.
4. Ø16 mm locating holes for zero-point clamping systems with 96 mm spacing.
5. Three 18H7 alignment slots for crosswise and lengthwise alignment on T- slot tables.
6. Ø12F7 and Ø16F7 reamed holes for 40 and 50 mm grid systems.

Three different versions are available:

- Multi-clamping system double-sided wedge clamp with OS fixed jaw / K1828.
- Multi-clamping system double-sided wedge clamp with DS fixed jaw / K1829.
- Multi-clamping system single-sided wedge clamp with OS fixed jaw / K1830.

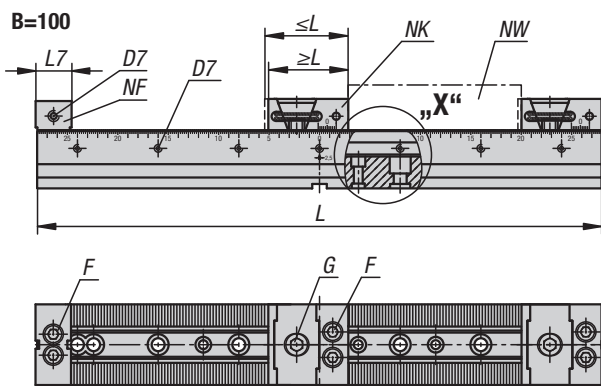
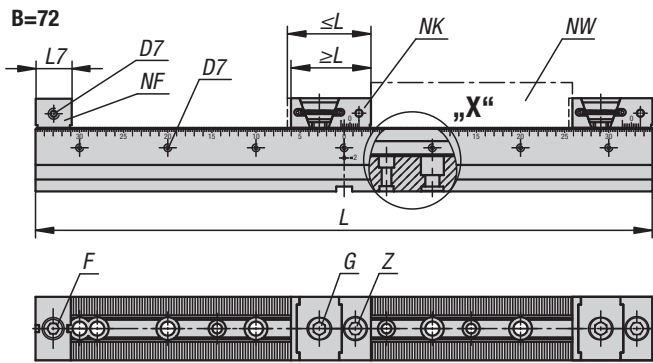
### KIPPA Multi-clamping system single-sided wedge clamps fixed jaw ES

Order No. smooth	Order No. serrated	B	L	H	L min.	L max.	L1	L2	L3	L4	L5	L6	L7	D	D1	D2	D3	D4	D5	D6	D7	Clamping force max. kN	Tightening torque max. Nm
K1830.05040001	K1830.05040002	50	400	75	64	70	96	200	288	300	-	-	30	25	12	20	16	17,5	11	M5	M6	15	55
K1830.05050001	K1830.05050002	50	500	75	64	70	96	200	288	400	-	-	30	25	12	20	16	17,5	11	M5	M6	15	55
K1830.05060001	K1830.05060002	50	600	75	64	70	96	200	288	400	500	-	30	25	12	20	16	17,5	11	M5	M6	15	55
K1830.05070001	K1830.05070002	50	700	75	64	70	96	200	288	400	560	600	30	25	12	20	16	17,5	11	M5	M6	15	55
K1830.07240001	K1830.07240002	72	400	112	86	93	96	200	288	300	-	-	40	25	16	26	16	17,5	11	M6	M6	25	60
K1830.07250001	K1830.07250002	72	500	112	86	93	96	200	288	400	-	-	40	25	16	26	16	17,5	11	M6	M6	25	60
K1830.07260001	K1830.07260002	72	600	112	86	93	96	200	288	400	500	-	40	25	16	26	16	17,5	11	M6	M6	25	60
K1830.07270001	K1830.07270002	72	700	112	86	93	96	200	288	400	560	600	40	25	16	26	16	17,5	11	M6	M6	25	60
K1830.10040001	K1830.10040002	100	400	114,6	101,5	111,5	96	200	288	300	-	-	70	25	16	26	16	17,5	11	M6	M8	35	85
K1830.10050001	K1830.10050002	100	500	114,6	101,5	111,5	96	200	288	400	-	-	70	25	16	26	16	17,5	11	M6	M8	35	85
K1830.10060001	K1830.10060002	100	600	114,6	101,5	111,5	96	200	288	400	500	-	70	25	16	26	16	17,5	11	M6	M8	35	85
K1830.10070001	K1830.10070002	100	700	114,6	101,5	111,5	96	200	288	400	560	600	70	25	16	26	16	17,5	11	M6	M8	35	85

## Multi-clamping system single-sided wedge clamps



fixed jaw ES



### Technical data:

System width 50  
 Maximum clamping force: 15 kN  
 Maximum tightening torque: 55 Nm

System width 72  
 Maximum clamping force: 25 kN  
 Maximum tightening torque: 60 Nm

System width 100  
 Maximum clamping force: 35 kN  
 Maximum tightening torque: 85 Nm

### Application:

A number of multi-clamping systems with different lengths can be mounted one behind the other or beside each other. The precision toothing enables highly precise positioning of the fixed jaws. Due to the lateral graduations on the clamping rails, each position of the fixed jaws can be documented and reset identically. Stops can be mounted in the tapped holes on the side. Turning the clamping screw moves the clamping segments outwards and press the workpieces against the fixed jaw.

### Advantages:

Universal and flexible.  
 For small and large batch sizes.  
 Large components can also be clamped next to each other on several multiple clamping systems.

### Supplied with:

1x clamping rail  
 The number of wedge clamps and fixed jaws is dependent on the system size (see table).

### Accessories:

- Clamping pin K0967.
- Cap screws K0869.
- Shoulder screws K0815.12045 / K0815.16055.
- Seating ledges K1752.
- Attachment jaws with machining allowance K1753.
- Attachment jaws with prism K1754.
- Workpiece stop K1755.
- Spacer K1756.
- Clamping claw set K1757.
- T-slot nut K1758.
- T-slot key K0954.

Order No. smooth	Order No. serrated	B	L	H1	H2	H3	H4	F Socket head screw DIN 912	G cap screw DIN 912	Z cap screw DIN 912	NK = Quantity Wedge clamp	NF = Quantity Fixed jaw	NW = Quantity Workpieces
K1830.05040001	K1830.05040002	50	400	50	25	12	16	M10x30	M12x25	M12x30	4	1	4
K1830.05050001	K1830.05050002	50	500	50	25	12	16	M10x30	M12x25	M12x30	4	1	4
K1830.05060001	K1830.05060002	50	600	50	25	12	16	M10x30	M12x25	M12x30	4	1	4
K1830.05070001	K1830.05070002	50	700	50	25	12	16	M10x30	M12x25	M12x30	4	1	4
K1830.07240001	K1830.07240002	72	400	72	40	15	23,5	M14X1,5X50	M16x40	M16X50	2	1	2
K1830.07250001	K1830.07250002	72	500	72	40	15	23,5	M14X1,5X50	M16x40	M16X50	2	1	2
K1830.07260001	K1830.07260002	72	600	72	40	15	23,5	M14X1,5X50	M16x40	M16X50	2	1	2
K1830.07270001	K1830.07270002	72	700	72	40	15	23,5	M14X1,5X50	M16x40	M16X50	2	1	2
K1830.10040001	K1830.10040002	100	400	72	42,6	15	23,5	M14X1,5X50	M16x40	-	2	1	2
K1830.10050001	K1830.10050002	100	500	72	42,6	15	23,5	M14X1,5X50	M16x40	-	2	1	2
K1830.10060001	K1830.10060002	100	600	72	42,6	15	23,5	M14X1,5X50	M16x40	-	2	1	2
K1830.10070001	K1830.10070002	100	700	72	42,6	15	23,5	M14X1,5X50	M16x40	-	2	1	2

## Multi-clamping system single-sided wedge clamps

fixed jaw ES



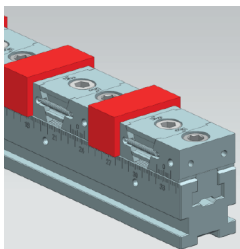
Maximum workpiece sizes for the types wedge clamp with fixed jaw

Clamping rails	1 pcs.			2 pcs.		
	B=50	B=72	B=100	B=50	B=72	B=100
L=300	203	-	-	68	-	-
L=400	302	273	253	118	92	74
L=500	404	373	353	169	142	124
L=600	503	473	453	218	192	174
L=700	602	573	553	268	242	224

Clamping rails	3 pcs.			4 pcs.		
	B=50	B=72	B=100	B=50	B=72	B=100
L=300	23	-	-	-	-	-
L=400	56	32	14	26	-	-
L=500	90	65	48	51	27	9
L=600	123	99	81	76	52	34
L=700	156	132	114	101	77	59

Clamping rails	5 pcs.			6 pcs.		
	B=50	B=72	B=100	B=50	B=72	B=100
L=300	-	-	-	-	-	-
L=400	7	-	-	-	-	-
L=500	27	-	-	12	-	-
L=600	47	24	6	28	5	-
L=700	67	24	26	45	22	-

Clamping rails	7 pcs.			8 pcs.		
	B=50	B=72	B=100	B=50	B=72	B=100
L=300	-	-	-	-	-	-
L=400	-	-	-	-	-	-
L=500	-	-	-	-	-	-
L=600	15	-	-	5	-	-
L=700	29	6	-	17	7	-



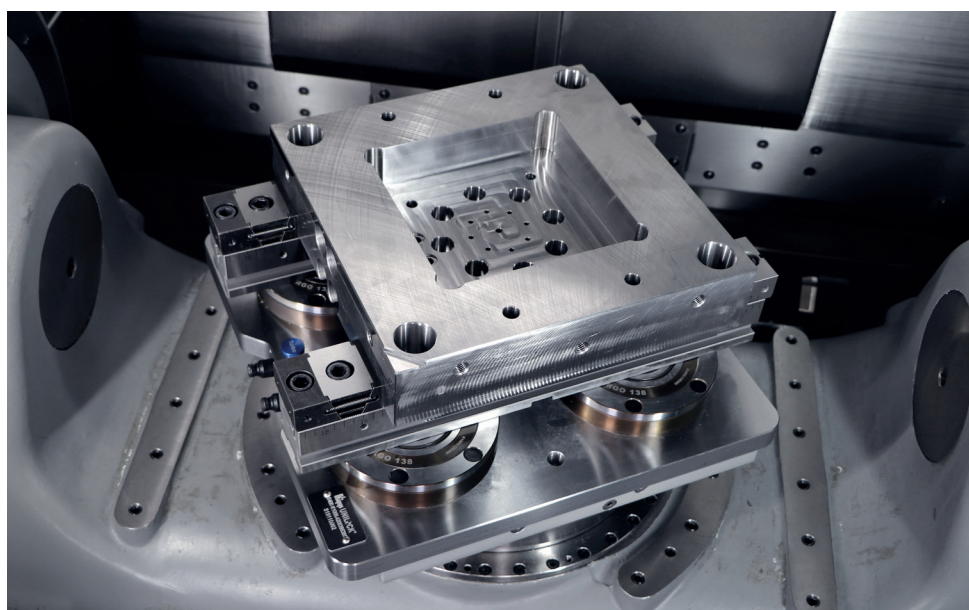
Combination of clamping rails for multi-clamping system K1746.  
 Wedge clamp with fixed jaw for multi-clamping system K1749 and 1x fixed jaw ES for multi-clamping system K1750.



## Example of a multi-clamping system



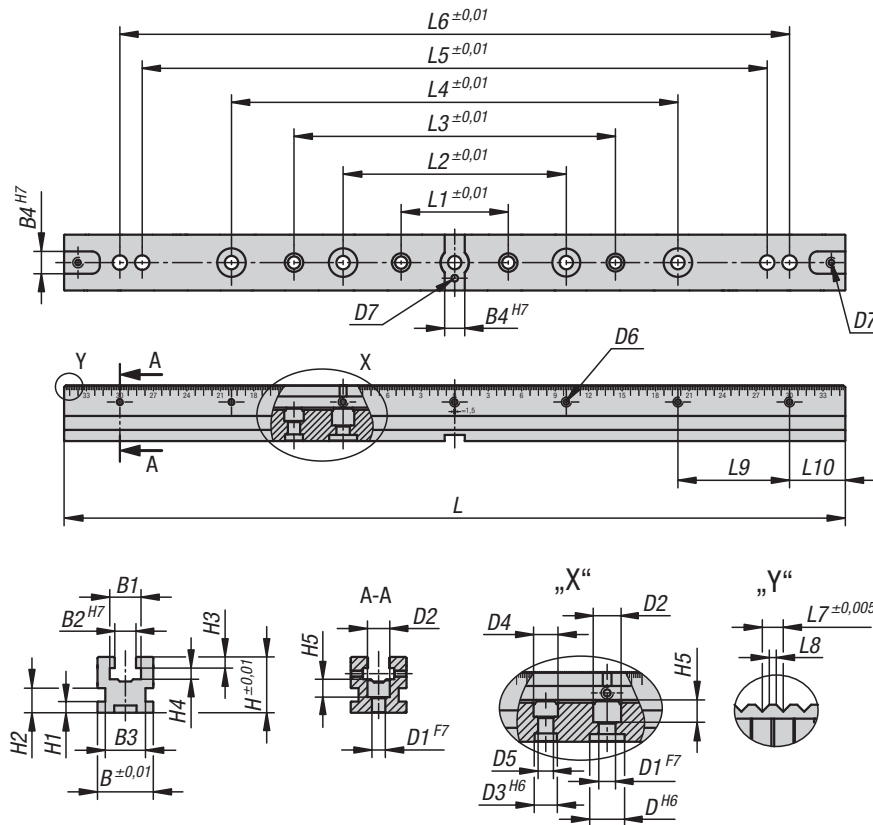
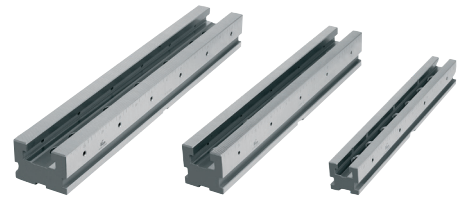
Wedge clamps with fixed jaw of the multi-clamping system System width 50.



Workpiece clamping with fixed jaw (right) and wedge clamps with fixed jaw (left).

## Clamping rails

for multi-clamping system



**Material:**  
Tool steel.

**Version:**  
Hardened and ground (HRC 55 ± 2).

**Sample order:**  
K1746.050300

**Note:**

The clamping rails can be fastened using various methods.

1. Lateral edge for claw clamp set. Claw clamps can be fastened at any desired position.
2. Holes for DIN cap screws.
3.  $\varnothing 25^{H6}$  mm locating holes for conventional zero-point clamping systems with 100 mm system spacing.
4.  $\varnothing 16^{H6}$  mm locating holes for zero-point clamping systems with 96 mm system spacing.
5. Three 18H7 alignment slots for T-slot tables.
6.  $\varnothing 12^{F7}$  and  $\varnothing 16^{F7}$  reamed holes for 40 mm and 50 mm grid systems.

**Application:**

Several clamping rails with different lengths can be mounted one behind the other or next to each other. The precision toothing enables very accurate positioning of the fixed jaws. Due to the scale on the side of the clamping rails, each position of the fixed jaws can be documented and reset identically. Stops can be mounted in the tapped holes on the side.

**Advantages:**

Universal and flexible.

For small and large batch sizes.

Large components can also be clamped beside each other on a number of clamping rails.

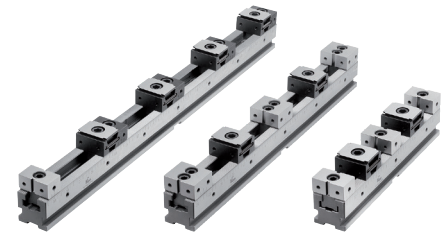
**Technical data:**

The maximum clamping forces and the tightening torques given for the respective system widths for the K1828, K1829 and K1830 product families must be observed.



## Clamping rails

for multi-clamping system



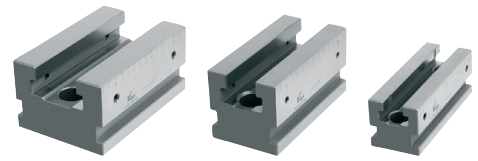
### KIPP Clamping rails for multi-clamping system

Order No.	B	suitable for system width	L	H	L1	L2	L3	L4	L5	L6	L7	L8	L9	L10
K1746.050300	50	50	300	50	96	200	-	-	-	-	1,5	0,5	100	50
K1746.050400	50	50	400	50	96	200	288	300	-	-	1,5	0,5	100	50
K1746.050500	50	50	500	50	96	200	288	400	-	-	1,5	0,5	100	50
K1746.050600	50	50	600	50	96	200	288	400	500	-	1,5	0,5	100	50
K1746.050700	50	50	700	50	96	200	288	400	560	600	1,5	0,5	100	50
K1746.072400	72	72	400	72	96	200	288	300	-	-	2	0,7	100	50
K1746.072500	72	72	500	72	96	200	288	400	-	-	2	0,7	100	50
K1746.072600	72	72	600	72	96	200	288	400	500	-	2	0,7	100	50
K1746.072700	72	72	700	72	96	200	288	400	560	600	2	0,7	100	50
K1746.100400	100	100	400	72	96	200	288	300	-	-	2,5	0,85	100	50
K1746.100500	100	100	500	72	96	200	288	400	-	-	2,5	0,85	100	50
K1746.100600	100	100	600	72	96	200	288	400	500	-	2,5	0,85	100	50
K1746.100700	100	100	700	72	96	200	288	400	560	600	2,5	0,85	100	50

Order No.	B	L	B1	B2	B3	B4	H1	H2	H3	H4	H5	D	D1	D2	D3	D4	D5	D6	D7
K1746.050300	50	300	28	19	36	18	10	22	10	10	16	25	12	20	16	17,5	11	M6	M6
K1746.050400	50	400	28	19	36	18	10	22	10	10	16	25	12	20	16	17,5	11	M6	M6
K1746.050500	50	500	28	19	36	18	10	22	10	10	16	25	12	20	16	17,5	11	M6	M6
K1746.050600	50	600	28	19	36	18	10	22	10	10	16	25	12	20	16	17,5	11	M6	M6
K1746.050700	50	700	28	19	36	18	10	22	10	10	16	25	12	20	16	17,5	11	M6	M6
K1746.072400	72	400	42	30	58	18	14	30	15	15	22	25	16	26	16	17,5	11	M6	M6
K1746.072500	72	500	42	30	58	18	14	30	15	15	22	25	16	26	16	17,5	11	M6	M6
K1746.072600	72	600	42	30	58	18	14	30	15	15	22	25	16	26	16	17,5	11	M6	M6
K1746.072700	72	700	42	30	58	18	14	30	15	15	22	25	16	26	16	17,5	11	M6	M6
K1746.100400	100	400	58	45	86	18	14	30	15	15	22	25	16	26	16	17,5	11	M8	M6
K1746.100500	100	500	58	45	86	18	14	30	15	15	22	25	16	26	16	17,5	11	M8	M6
K1746.100600	100	600	58	45	86	18	14	30	15	15	22	25	16	26	16	17,5	11	M8	M6
K1746.100700	100	700	58	45	86	18	14	30	15	15	22	25	16	26	16	17,5	11	M8	M6

## Clamping rails, short

for multi-clamping system



**Material:**

Tool steel.

**Version:**

Hardened and ground (HRC 55 ±2).

**Sample order:**

K1747.050130

**Note:**

The clamping rails can be fastened using various methods.

1. Lateral edge for claw clamp set. Claw clamps can be fastened at any desired position.
2. Holes for DIN cap screws.
3. One 18H7 alignment slot for T-slot tables.
4. Ø12F7 and Ø16F7 reamed holes for 50 mm grid systems.

**Application:**

With the short clamping rails, clamping tasks can be implemented with low space requirements. The precision toothing enables very accurate positioning of the fixed jaws. Due to the scale on the side of the clamping rails, each position of the fixed jaws can be documented and reset identically. Stops can be mounted in the tapped holes on the side.

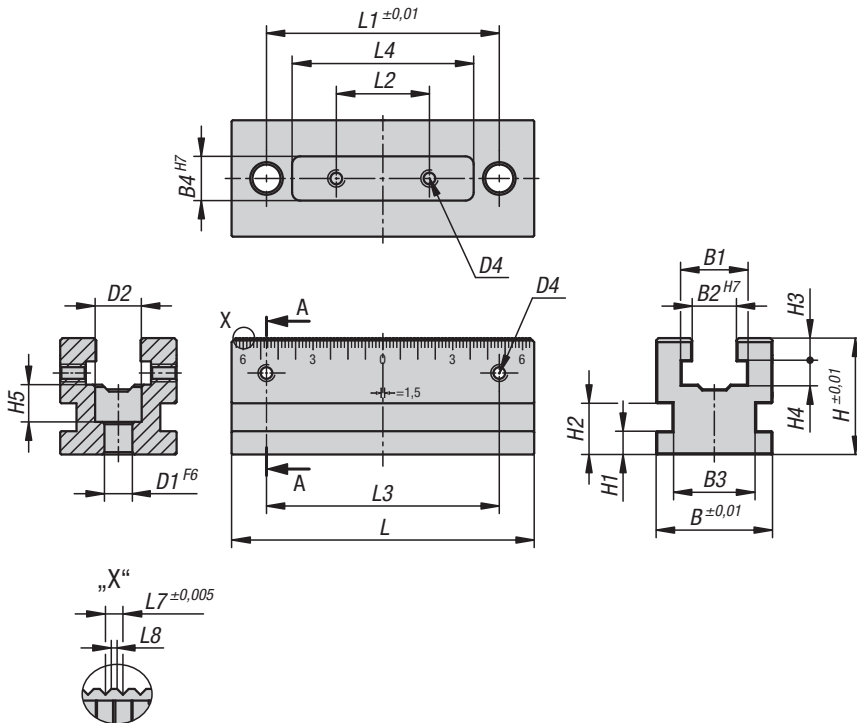
**Advantages:**

Universal and flexible application.

A number of short clamping rails can also be used to adapt flexibly to different clamping situations.

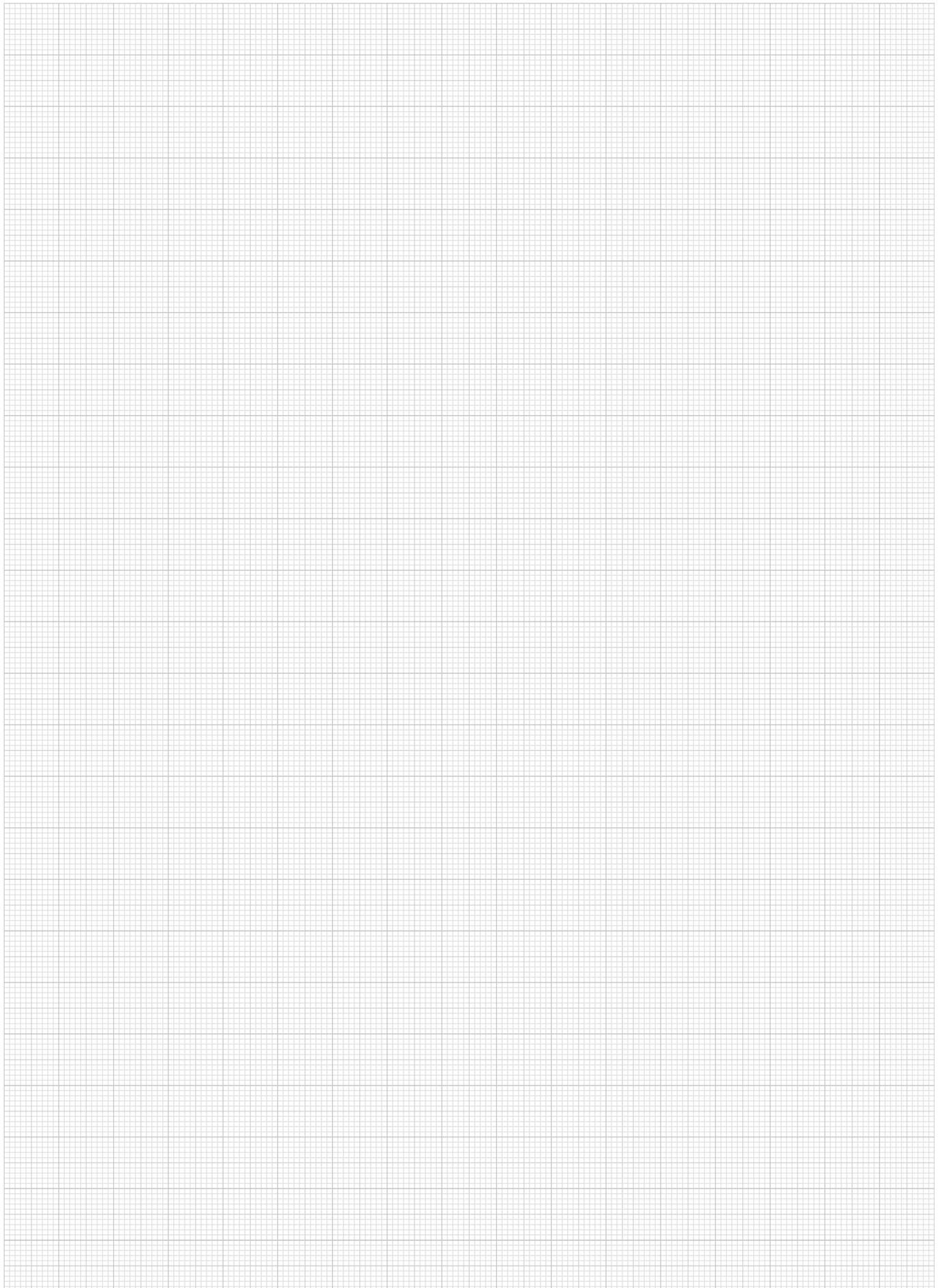
**Technical data:**

The maximum clamping forces and the tightening torques given for the respective system widths for the K1828, K1829 and K1830 product families must be observed.

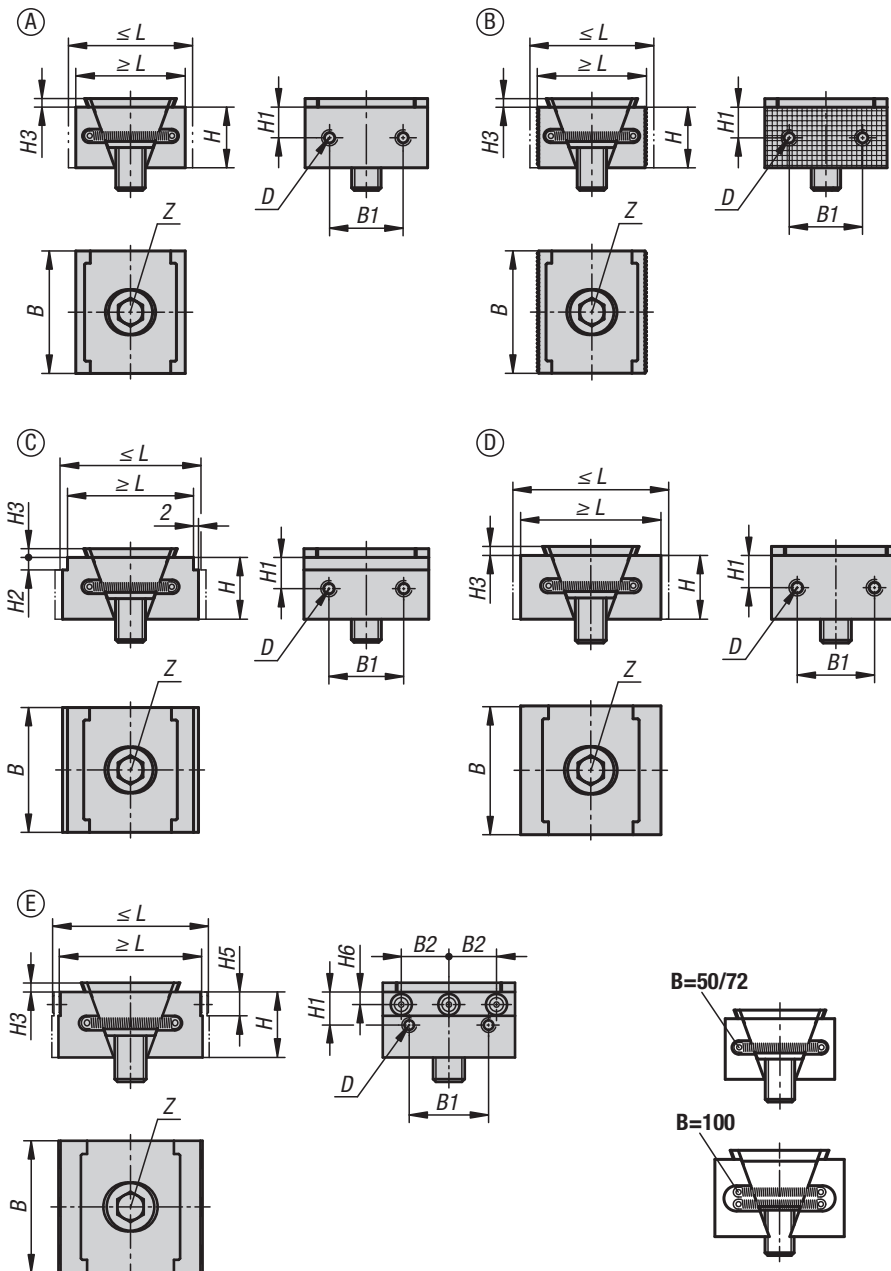


### KIPP Clamping rails, short, for multi-clamping system

Order No.	B	suitable for system width	L	H	L1	L2	L3	L4	L7	L8	B1	B2	B3	B4	H1	H2	H3	H4	H5	D1	D2	D3	D4
K1747.050130	50	50	130	50	100	40	100	77	1,5	0,5	28	19	36	18	10	22	10	10	16	12	20	M6	M6
K1747.072140	72	72	140	72	100	40	100	77	2	0,7	42	30	58	18	14	30	15	15	22	16	26	M6	M6
K1747.100148	100	100	148	72	100	40	100	77	2,5	0,85	58	45	86	18	14	30	15	15	22	16	26	M8	M6



# Wedge clamps



The functioning principle make the wedge clamps ideal for multi-clamping.

The wedge shape creates high clamping forces. The wedge clamps can be used for clamping in conjunction with the clamping rail or mounted in tapped holes or T-slots.

Tightening the clamping screw moves the two clamping segments outwards and press the workpieces against the fixed jaws of the machining fixture.

The double wedge has an elongated hole allowing for movement and to compensate for tolerances. Displacement: M12 =  $\pm 1$  mm, M16 =  $\pm 1.5$  mm.

**Material:**

Double wedge and clamping segments mild steel.

**Version:**

Double wedge and clamping segments hardened, phosphated.

**Sample order:**

K1748.05002

**Note:**

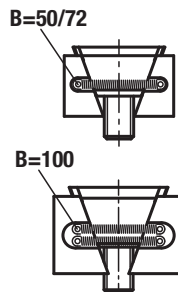
The two screw-on holes in the clamping faces also enable seating ledges to be mounted so as to optimise the clamping depth of the workpieces.

**Supplied with:**

Wedge clamps.  
Fastening screw.

**Drawing reference:**

- Form A: Smooth jaw face
- Form B: Serrated jaw facet
- Form C: With step
- Form D: With machining allowance
- Form E: With jaw pins



## Wedge clamps



## KIPP Wedge clamps

Order No.	Form	L min.	L max.	B	H	B1	B2	H1	H2	H3	H5	H6
K1748.0500112	A	44,5	50,5	50	25	30	-	12,5	-	3,5	-	-
K1748.0720112	A	61	68	72	39,7	44	-	21,3	-	3,5	-	-
K1748.0720116	A	61	68	72	39,7	44	-	21,3	-	3,5	-	-
K1748.1000116	A	71,5	81,5	100	42,6	64	-	21,6	-	5	-	-
K1748.0500212	B	44,5	50,5	50	25	30	-	12,5	-	3,5	-	-
K1748.0720212	B	61	68	72	39,7	44	-	21,3	-	3,5	-	-
K1748.0720216	B	61	68	72	39,7	44	-	21,3	-	3,5	-	-
K1748.1000216	B	71,5	81,5	100	42,6	64	-	21,6	-	5	-	-
K1748.0502312	C	50,5	56,5	50	25	30	-	12,5	2	3,5	-	-
K1748.0505312	C	50,5	56,5	50	25	30	-	12,5	5	3,5	-	-
K1748.0722316	C	67	74	72	39,7	44	-	21,3	2	3,5	-	-
K1748.0725316	C	67	74	72	39,7	44	-	21,3	5	3,5	-	-
K1748.1002316	C	77,5	87,5	100	42,6	64	-	21,6	2	5	-	-
K1748.1005316	C	77,5	87,5	100	42,6	64	-	21,6	5	5	-	-
K1748.0500412	D	54,5	60,5	50	25	30	-	12,5	-	3,5	-	-
K1748.0720412	D	71	78	72	39,7	44	-	21,3	-	3,5	-	-
K1748.0720416	D	71	78	72	39,7	44	-	21,3	-	3,5	-	-
K1748.1000416	D	81,5	91,5	100	42,6	64	-	21,6	-	5	-	-
K1748.0500512	E	54	60	50	25	30	18	12,5	-	3,5	9	4,75
K1748.0720512	E	70,2	77,6	72	39,7	44	27	21,3	-	3,5	9	4,75
K1748.0720516	E	70,2	77,6	72	39,7	44	27	21,3	-	3,5	9	4,75
K1748.1000516	E	80,5	90,5	100	42,6	64	40	21,6	-	5	9	4,75

Order No.	Form	D Internal thread	Z cap screw DIN 912	Clamping force max. kN	Tightening torque max. Nm
K1748.0500112	A	M5	M12x25	30	85
K1748.0720112	A	M6	M12X40	30	85
K1748.0720116	A	M6	M16X40	50	150
K1748.1000116	A	M8	M16X40	50	150
K1748.0500212	B	M5	M12x25	30	85
K1748.0720212	B	M6	M12X40	30	85
K1748.0720216	B	M6	M16X40	50	150
K1748.1000216	B	M8	M16X40	50	150
K1748.0502312	C	M5	M12x25	30	85
K1748.0505312	C	M5	M12x25	30	85
K1748.0722316	C	M6	M16X40	50	150
K1748.0725316	C	M6	M16X40	50	150
K1748.1002316	C	M8	M16X40	50	150
K1748.1005316	C	M8	M16X40	50	150
K1748.0500412	D	M5	M12x25	30	85
K1748.0720412	D	M6	M12X40	30	85
K1748.0720416	D	M6	M16X40	50	150
K1748.1000416	D	M8	M16X40	50	150
K1748.0500512	E	M5	M12x25	30	85
K1748.0720512	E	M6	M12X40	30	85
K1748.0720516	E	M6	M16X40	50	150
K1748.1000516	E	M8	M16X40	50	150

## Wedge clamps with fixed jaw

for multi-clamping system



The functioning principle make the wedge clamps ideal for multi-clamping. The wedge shape creates high clamping forces. Tightening the clamping screw moves the clamping segments outwards and press the workpieces against the fixed jaws.

The wedge has a slightly elongated hole allowing for movement to compensate for tolerances. Displacement: M12 = ±1 mm, M16 = ±1.5 mm.

**Material:**

Double wedge and clamping segments mild steel.

**Version:**

Double wedge and clamping segments hardened, phosphated.

**Sample order:**

K1749.05002

**Note:**

These wedge clamps can only be used in conjunction with the clamping rail K1746 for multiple clamping. The lateral fastening holes are used to fasten workpiece stops.

The two screw-on holes in the clamping faces also enable seating ledges to be mounted so as to optimise the clamping depth of the workpieces.

**Advantages:**

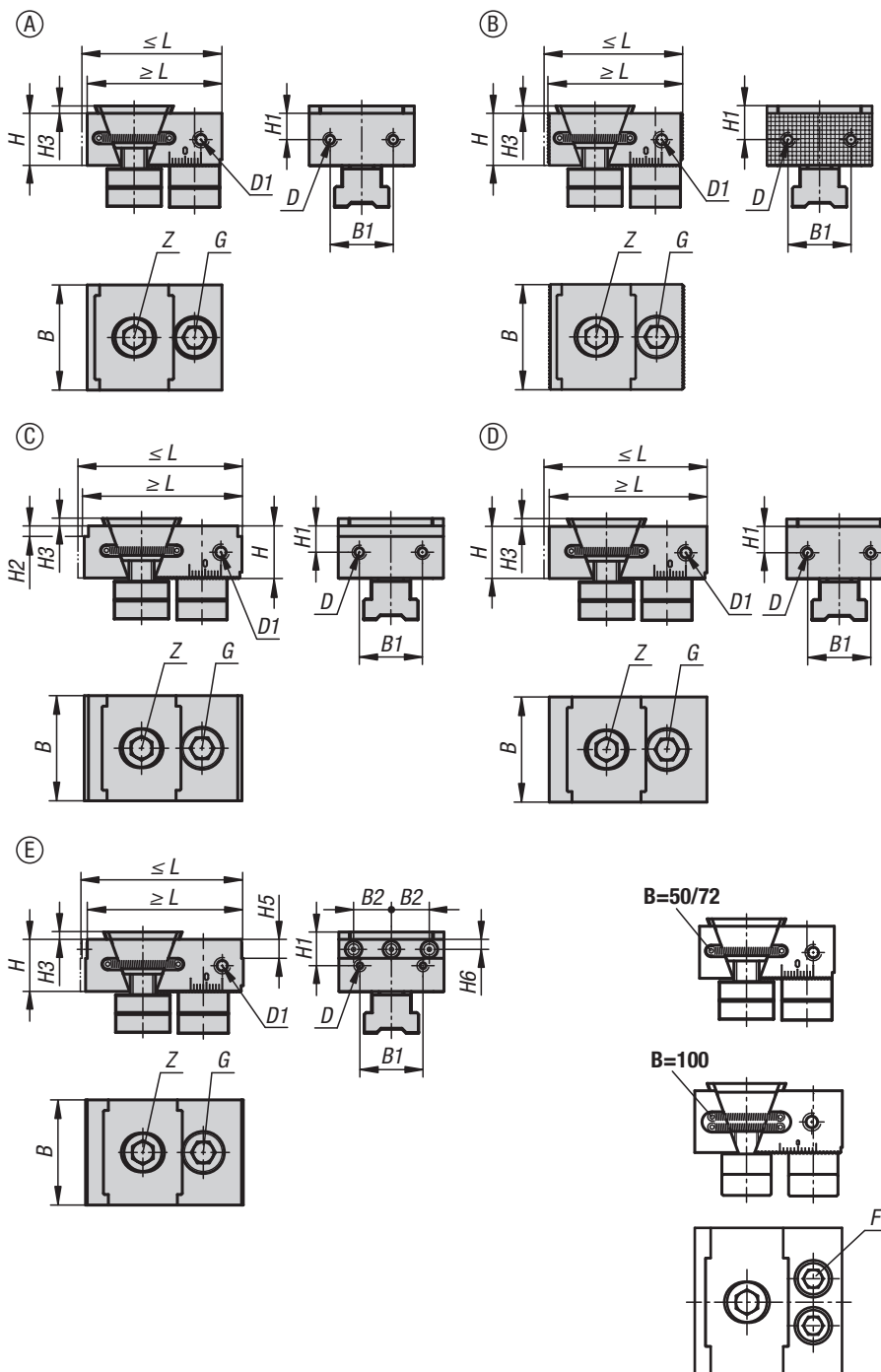
The lateral scale on the clamping rail and the fixed jaw guarantees a very high repeat clamping accuracy.

**Supplied with:**

- Wedge clamps
- Fastening screws.
- Slot keys.

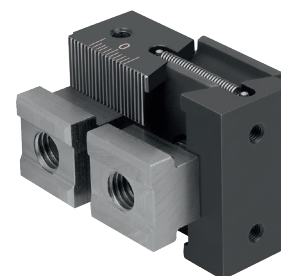
**Drawing reference:**

- Form A: Smooth jaw face
- Form B: Serrated jaw facet
- Form C: With step
- Form D: With machining allowance
- Form E: With jaw pins



## Wedge clamps with fixed jaw

for multi-clamping system



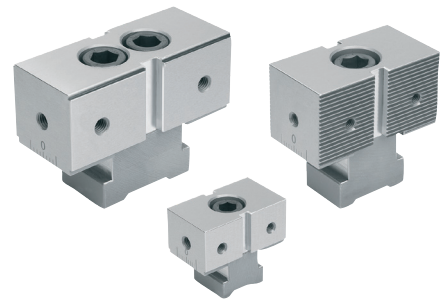
### KIPP Wedge clamps with fixed jaw for multi-clamping system

Order No.	Form	L min.	L max.	B	H	B1	B2	H1	H2	H3	H5	H6
K1749.0500112	A	64	70	50	25	30	-	12,5	-	3,5	-	-
K1749.0720116	A	86	93	72	39,7	44	-	21,3	-	3,5	-	-
K1749.1000116	A	101,5	111,5	100	42,6	64	-	21,6	-	5	-	-
K1749.0500212	B	64	70	50	25	30	-	12,5	-	3,5	-	-
K1749.0720216	B	86	93	72	39,7	44	-	21,3	-	3,5	-	-
K1749.1000216	B	101,5	111,5	100	42,6	64	-	21,6	-	5	-	-
K1749.0502312	C	71	77	50	25	30	-	12,5	2	3,5	-	-
K1749.0505312	C	71	77	50	25	30	-	12,5	5	3,5	-	-
K1749.0722316	C	91,2	98,6	72	39,7	44	-	21,3	2	3,5	-	-
K1749.0725316	C	91,2	98,6	72	39,7	44	-	21,3	5	3,5	-	-
K1749.1002316	C	107,5	117,5	100	42,6	64	-	21,6	2	5	-	-
K1749.1005316	C	107,5	117,5	100	42,6	64	-	21,6	5	5	-	-
K1749.0500412	D	75	81	50	25	30	-	12,5	-	3,5	-	-
K1749.0720416	D	95	103	72	39,7	44	-	21,3	-	3,5	-	-
K1749.1000416	D	111,5	121,5	100	42,6	64	-	21,6	-	5	-	-
K1749.0500512	E	74,5	80,5	50	25	30	18	12,5	-	3,5	9	4,75
K1749.0720516	E	94,6	102	72	39,7	44	27	21,3	-	3,5	9	4,75
K1749.1000516	E	111	121	100	42,6	64	40	21,6	-	5	9	4,75

Order No.	Form	D Internal thread	D1	F Socket head screw DIN 912	G cap screw DIN 912	Z cap screw DIN 912	Clamping force max. kN	Tightening torque max. Nm
K1749.0500112	A	M5	M6	-	M12x30	M12x25	30	85
K1749.0720116	A	M6	M6	-	M16x50	M16X40	50	150
K1749.1000116	A	M8	M8	M14X1,5X50	-	M16X40	50	150
K1749.0500212	B	M5	M6	-	M12x30	M12x25	30	85
K1749.0720216	B	M6	M6	-	M16x50	M16X40	50	150
K1749.1000216	B	M8	M8	M14X1,5X50	-	M16X40	50	150
K1749.0502312	C	M5	M6	-	M12x30	M12x25	30	85
K1749.0505312	C	M5	M6	-	M12x30	M12x25	30	85
K1749.0722316	C	M6	M6	-	M16x50	M16X40	50	150
K1749.0725316	C	M6	M6	-	M16x50	M16X40	50	150
K1749.1002316	C	M8	M8	M14X1,5X50	-	M16X40	50	150
K1749.1005316	C	M8	M8	M14X1,5X50	-	M16X40	50	150
K1749.0500412	D	M5	M6	-	M12x30	M12x25	30	85
K1749.0720416	D	M6	M6	-	M16x50	M16X40	50	150
K1749.1000416	D	M8	M8	M14X1,5X50	-	M16X40	50	150
K1749.0500512	E	M5	M6	-	M12x30	M12x25	30	85
K1749.0720516	E	M6	M6	-	M16x50	M16X40	50	150
K1749.1000516	E	M8	M8	M14X1,5X50	-	M16X40	50	150

## Fixed jaws ES

for multi-clamping system



**Material:**

Tool steel.

**Version:**

Hardened and ground (HRC 55 ±2).

**Sample order:**

K1750.0503001

**Note:**

There are three different fixed jaw versions to choose from:

- Smooth version Form A for pre-machined workpieces.
- Serrated version Form B for raw parts.
- Offset jaws Form C for clamping with a small clamping edge.

The lateral fastening holes are used to fasten workpiece end stops. The two screw-on holes on the clamping surfaces also allow seating ledges to be mounted so as to optimise the clamping depth of the workpieces.

**Application:**

The ES fixed jaws are positioned on the clamping rails according to the clamping situation. When the fastening screw is tightened, the toothing allows a form-fit connection to be created. This allows high retaining forces to be carried through the clamping elements. With its slim design, the ES fixed jaw is especially suitable for clamping processes with smaller workpieces and large batch sizes. This also means that large production batches can be processed economically.

**Advantages:**

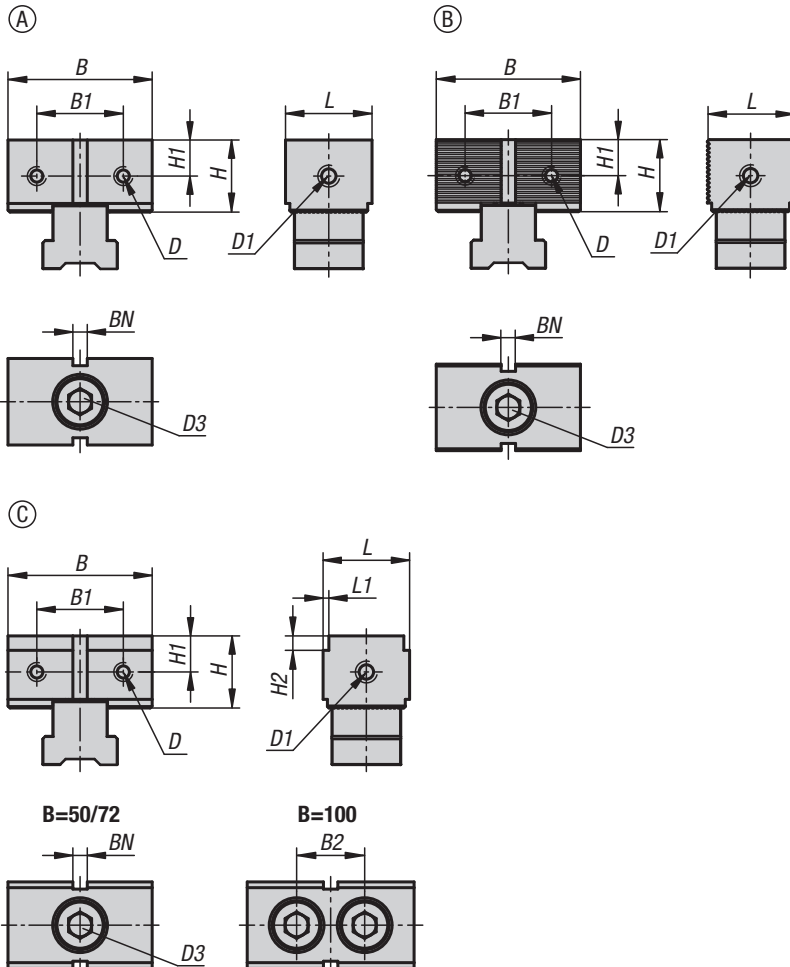
The lateral scale on the clamping rails and the fixed jaws allows precise positioning of the fixed stops.

**Supplied with:**

- ES fixed jaw.
- Fastening screw.
- Slot key.

**Technical data:**

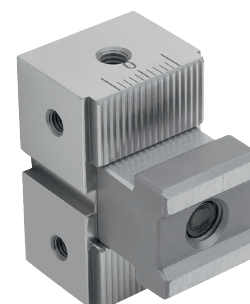
The maximum clamping forces and the tightening torques given for the respective system widths for the K1828, K1829 and K1830 product families must be observed.





## Fixed jaws ES

for multi-clamping system

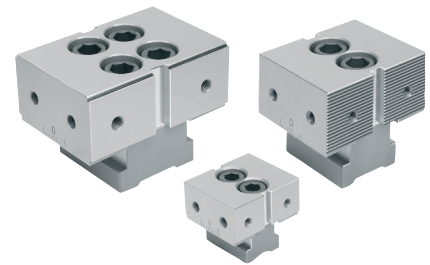


### KIPP Fixed jaws ES for multi-clamping system

Order No.	suitable for system width	Form	Form definition	L	B	H	L1	B1	B2	H1	H2	D Internal thread	D1 internal thread	D3	BN=Slot width
K1750.0503001	50	A	smooth	30	50	25	-	30	-	12,5	-	M5	M6	M10x30	5
K1750.0503002	50	B	serrated	30	50	25	-	30	-	12,5	-	M5	M6	M10x30	5
K1750.0503023	50	C	stepped	30	50	25	2	30	-	12,5	2	M5	M6	M10x30	5
K1750.0503053	50	C	stepped	30	50	25	2	30	-	12,5	5	M5	M6	M10x30	5
K1750.0724001	72	A	smooth	40	72	40	-	44	-	21,5	-	M6	M6	M14x1,5x50	8
K1750.0724002	72	B	serrated	40	72	40	-	44	-	21,5	-	M6	M6	M14x1,5x50	8
K1750.0724023	72	C	stepped	40	72	40	2	44	-	21,5	2	M6	M6	M14x1,5x50	8
K1750.0724053	72	C	stepped	40	72	40	2	44	-	21,5	5	M6	M6	M14x1,5x50	8
K1750.1004401	100	A	smooth	44	100	43	-	64	26	22	-	M8	M8	M14x1,5x50	10
K1750.1004402	100	B	serrated	44	100	43	-	64	26	22	-	M8	M8	M14x1,5x50	10
K1750.1004423	100	C	stepped	44	100	43	2	64	26	22	2	M8	M8	M14x1,5x50	10
K1750.1004453	100	C	stepped	44	100	43	2	64	26	22	5	M8	M8	M14x1,5x50	10

## Fixed jaws DS

for multi-clamping system



**Material:**

Tool steel.

**Version:**

Hardened and ground (HRC 55 ±2).

**Sample order:**

K1751.0504401

**Note:**

- There are three different fixed jaw versions to choose from:
- Smooth version Form A for pre-machined workpieces.
  - Serrated version Form B for raw parts.
  - Offset jaws Form C for clamping with a small clamping edge.

The lateral fastening holes are used to fasten workpiece end stops. The two screw-on holes on the clamping surfaces also allow seating ledges to be mounted so as to optimise the clamping depth of the workpieces.

**Application:**

The DS fixed jaws are positioned on the clamping rails according to the clamping situation. When the fastening screw is tightened, the toothing allows a form-fit connection to be created. Fixed jaws with two fastening screws are to be preferred where higher machining forces are to be applied.

**Advantages:**

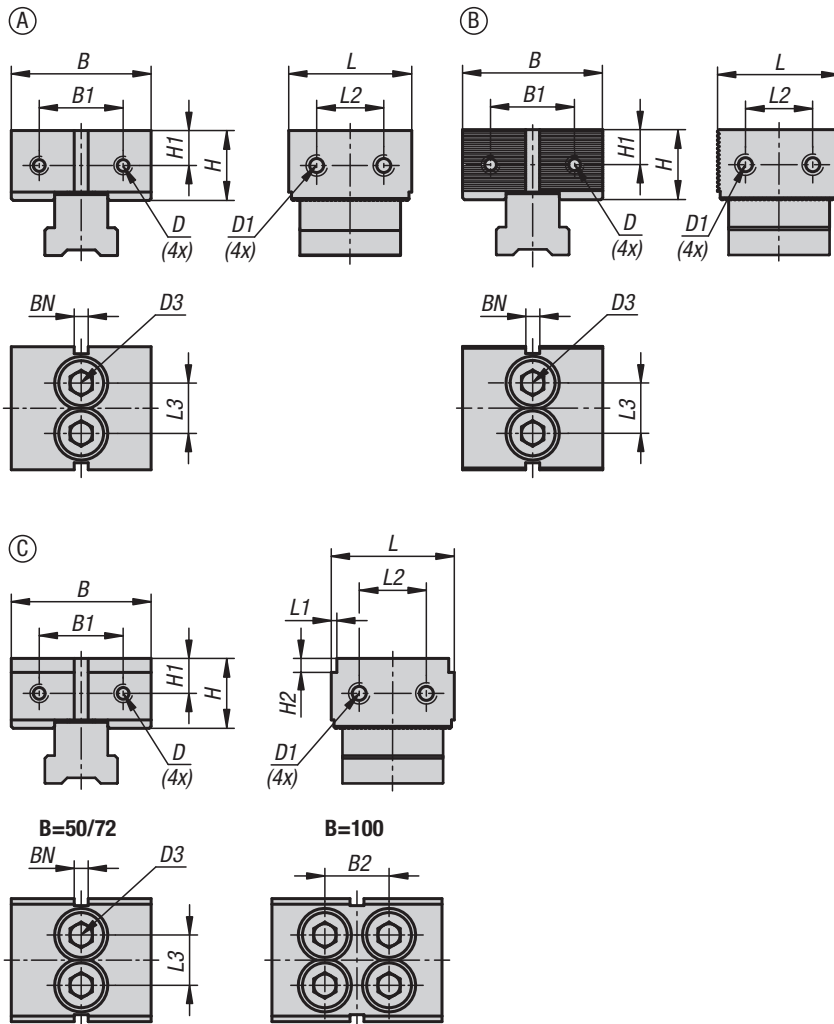
The lateral scale on the clamping rails and the fixed jaws allows precise positioning of the fixed stops.

**Supplied with:**

- DS fixed jaw.
- Fastening screw.
- Slot key.

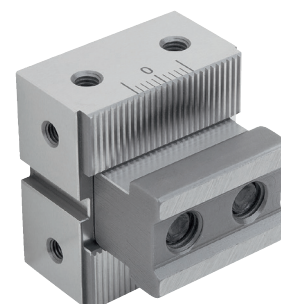
**Technical data:**

The maximum clamping forces and the tightening torques given for the respective system widths for the K1828, K1829 and K1830 product families must be observed.



## Fixed jaws DS

for multi-clamping system

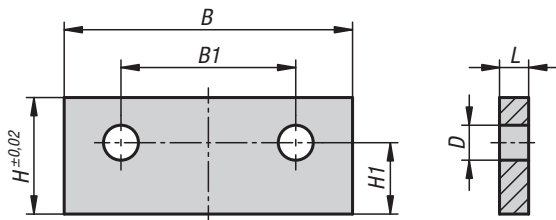


### KIPP Fixed jaws DS for multi-clamping system

Order No.	suitable for system width	Form	Form definition	L	B	H	L1	L2	L3	B1	B2	H1	H2	D Internal thread	D1 internal thread	D3	BN=Slot width
K1751.0504401	50	A	smooth	44	50	25	-	24	18	30	-	12,5	-	M5	M6	M10x30	5
K1751.0504402	50	B	serrated	44	50	25	-	24	18	30	-	12,5	-	M5	M6	M10x30	5
K1751.0504423	50	C	stepped	44	50	25	2	24	18	30	-	12,5	2	M5	M6	M10x30	5
K1751.0504453	50	C	stepped	44	50	25	2	24	18	30	-	12,5	5	M5	M6	M10x30	5
K1751.0726501	72	A	smooth	65	72	40	-	35	25	44	-	21,5	-	M6	M6	M14x1,5x50	8
K1751.0726502	72	B	serrated	65	72	40	-	35	25	44	-	21,5	-	M6	M6	M14x1,5x50	8
K1751.0726523	72	C	stepped	65	72	40	2	35	25	44	-	21,5	2	M6	M6	M14x1,5x50	8
K1751.0726553	72	C	stepped	65	72	40	2	35	25	44	-	21,5	5	M6	M6	M14x1,5x50	8
K1751.1007001	100	A	smooth	70	100	43	-	35	30	64	26	22	-	M8	M8	M14x1,5x50	10
K1751.1007002	100	B	serrated	70	100	43	-	35	30	64	26	22	-	M8	M8	M14x1,5x50	10
K1751.1007023	100	C	stepped	70	100	43	2	35	30	64	26	22	2	M8	M8	M14x1,5x50	10
K1751.1007053	100	C	stepped	70	100	43	2	35	30	64	26	22	5	M8	M8	M14x1,5x50	10

## Screw-on seating ledges

for multi-clamping system



**Material:**

Tool steel.

**Version:**

Hardened and ground (HRC 55 ±2).

**Sample order:**

K1752.050175

**Note:**

The seating ledges allow different workpiece clamping depths to be set.

**Application:**

The seating ledges can be screwed together with the ES and DS fixed jaws and with the wedge clamps.

**Advantages:**

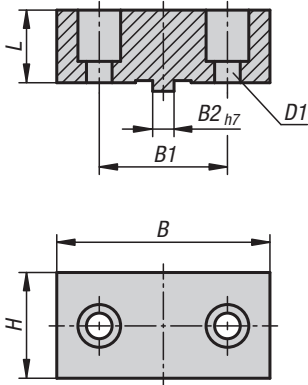
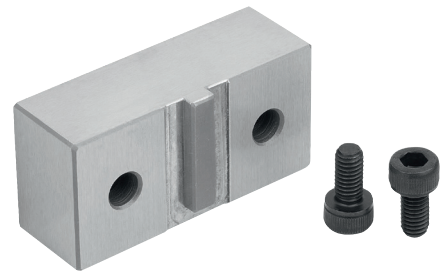
Quick setup of workpieces on the multiple clamping system. Uniform clamping depth of the workpieces with the ground support surface height.

### KIPP Screw-on seating ledges for multi-clamping system

Order No.	suitable for system width	L	B	H	B1	H1	D
K1752.050175	50	5	49,5	17	30	12,3	6
K1752.050205	50	5	49,5	20	30	12,3	6
K1752.050223	50	3	49,5	22	30	12,3	6
K1752.072255	72	5	71,5	25	44	18,4	7
K1752.072305	72	5	71,5	30	44	18,4	7
K1752.072355	72	5	71,5	35	44	18,4	7
K1752.072373	72	3	71,5	37	44	18,4	7
K1752.100298	100	8	99,5	29	64	21	9
K1752.100338	100	8	99,5	33	64	21	9
K1752.100388	100	8	99,5	38	64	21	9
K1752.100405	100	5	99,5	40	64	21	9

## Attachment jaws machinable

for fixed jaws DS and ES



**Material:**

Tool steel.

**Version:**

tempered (HRC32).

**Sample order:**

K1753.05017

**Note:**

Attachment jaws are used to incorporate customer-specific workpiece contours.

**Application:**

The attachment jaws are screwed onto the ES and DS fixed stops.

**Advantages:**

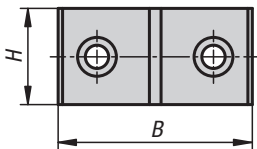
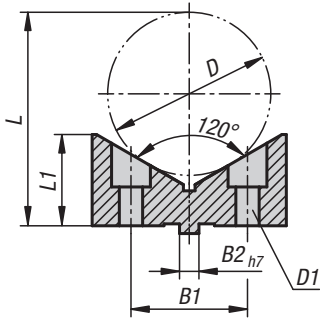
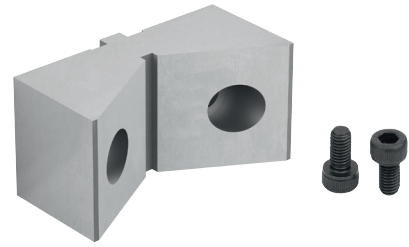
Machined attachment jaws can be re-used for later series productions.

### KIPP Attachment jaws machinable for fixed jaws DS and ES

Order No.	suitable for system width	L	B	H	B1	B2	D1 for screw to DIN 912
K1753.05017	50	17	50	25	30	5	M5
K1753.05027	50	27	80	25	30	5	M5
K1753.07219	72	19	72	40	44	8	M6
K1753.07230	72	30	115	40	44	8	M6
K1753.10025	100	25	100	43	64	10	M8
K1753.10035	100	35	150	43	64	10	M8

## Attachment jaws with prism

for fixed jaws DS and ES



**Material:**

Tool steel.

**Version:**

Hardened and ground (HRC 55).

**Sample order:**

K1754.05070

**Note:**

Attachment jaws with prism are used for clamping round workpieces. With the longitudinal slot on the back, they can be aligned exactly on the ES and DS fixed jaws.

**Application:**

The attachment jaws with prism are screwed onto the ES and DS fixed stops.

**Advantages:**

The attachment jaws with prism ensure repeat accuracy when clamping workpieces.

### KIPP Attachment jaws with prism for fixed jaws DS and ES

Order No.	suitable for system width	L	B	H	L1	B1	B2	D	max. clamping diameter	D1 for screw to DIN 912
K1754.05070	50	54,98	50	25	23,5	30	5	42	70	M5
K1754.072110	72	82,45	72	40	35	44	8	62	110	M6
K1754.100160	100	90,24	100	43	50	64	10	62	160	M8

## Workpiece stops

for multi-clamping system



**Material:**

Carbon steel.

**Version:**

Tempered and flat faces ground (HRC 32).

**Sample order:**

K1755.05045

**Note:**

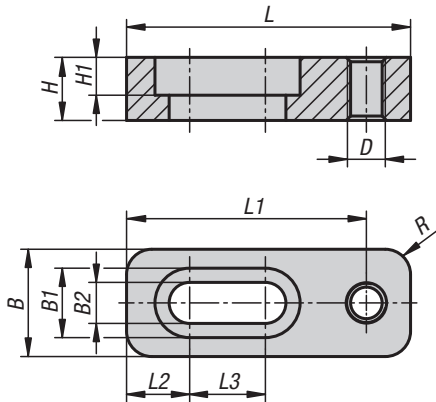
Workpieces can be positioned laterally using the workpiece stops for multi-clamping systems.

**Application:**

The end stop can be mounted laterally on both surfaces of the fixed jaws.

**Advantages:**

Flexible adjustment with the elongated hole.

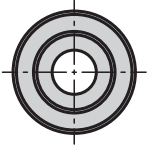
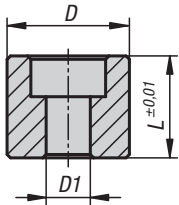


### KIPP Workpiece stops for multi-clamping system

Order No.	suitable for system width	L	B	H	L1	L2	L3	B1	B2	H1	R	D Internal thread
K1755.05045	50	45	17	10	38	10	12	11	6,5	6	4	M6
K1755.07250	72	50	17	10	43	10	12	11	6,5	6	4	M6
K1755.10055	100	55	25	15	45	11,5	16	14	9	8,5	5	M8

## Spacers

for multi-clamping system workpiece stop



**Material:**

Carbon steel.

**Version:**

Tempered and flat faces ground (HRC 32).

**Sample order:**

K1756.05010

**Note:**

The spacer for the workpiece stop is used to extend the lateral stop dimension.

**Application:**

The spacer is screwed onto the side of the fixed jaw together with the workpiece stop.

**Advantages:**

Increases the adjustment range of the lateral end stop.

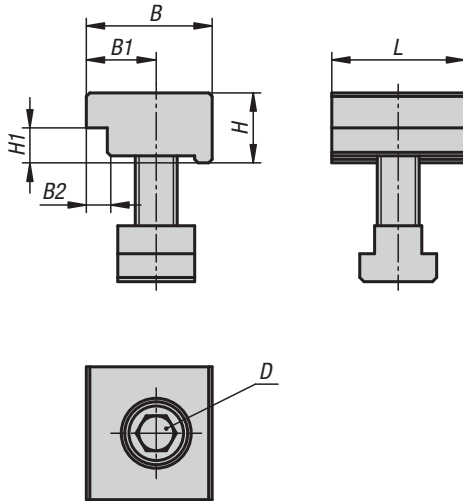
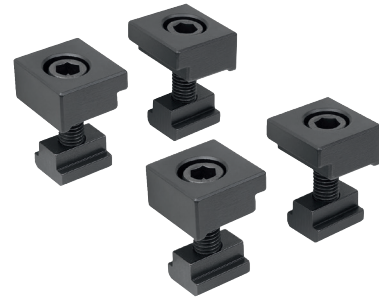
### KIPP Spacers for multi-clamping system workpiece stop

Order No.	suitable for system width	L	D	D1 for screw to DIN 912
K1756.05010	50/72	10	18	M6
K1756.05015	50/72	15	18	M6
K1756.05023	50/72	23	18	M6
K1756.10015	100	15	25	M8
K1756.10020	100	20	25	M8
K1756.10025	100	25	25	M8



## Clamping claw sets

for multi-clamping system



**Material:**

Carbon steel.

**Version:**

Tempered. Support faces ground (HRC 32).

**Sample order:**

K1757.05012

**Note:**

Using these clamping claw sets, the clamping rails can be secured at any position on the machine table.

**Application:**

The clamping claw set is inserted into the T-slot on the machine table and slid along to the desired position on the clamping rail. Tightened using a cap screw.

**Advantages:**

The clamping claw set can also be used for other types of mounting in the multi-clamping system.

**Supplied with:**

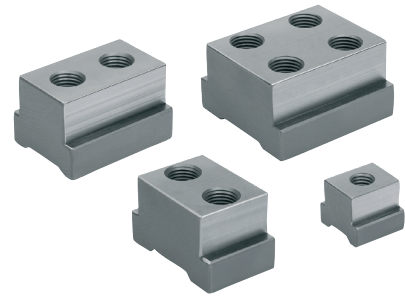
- 4x claw clamps.
- 4x DIN 912 cap screws.
- 4x DIN 508 T-slot nuts.

### KIPP Clamping claw sets for multi-clamping system

Order No.	suitable for system width	L	B	H	B1	B2	H1	D for screw DIN 912	Slot width
K1757.05012	50	38	36	20	20	6	10	M12	14
K1757.07216	72/100	40	50	28	27	8	14	M16	18

## T-slot keys

for wedge clamps



**Material:**  
Carbon steel.

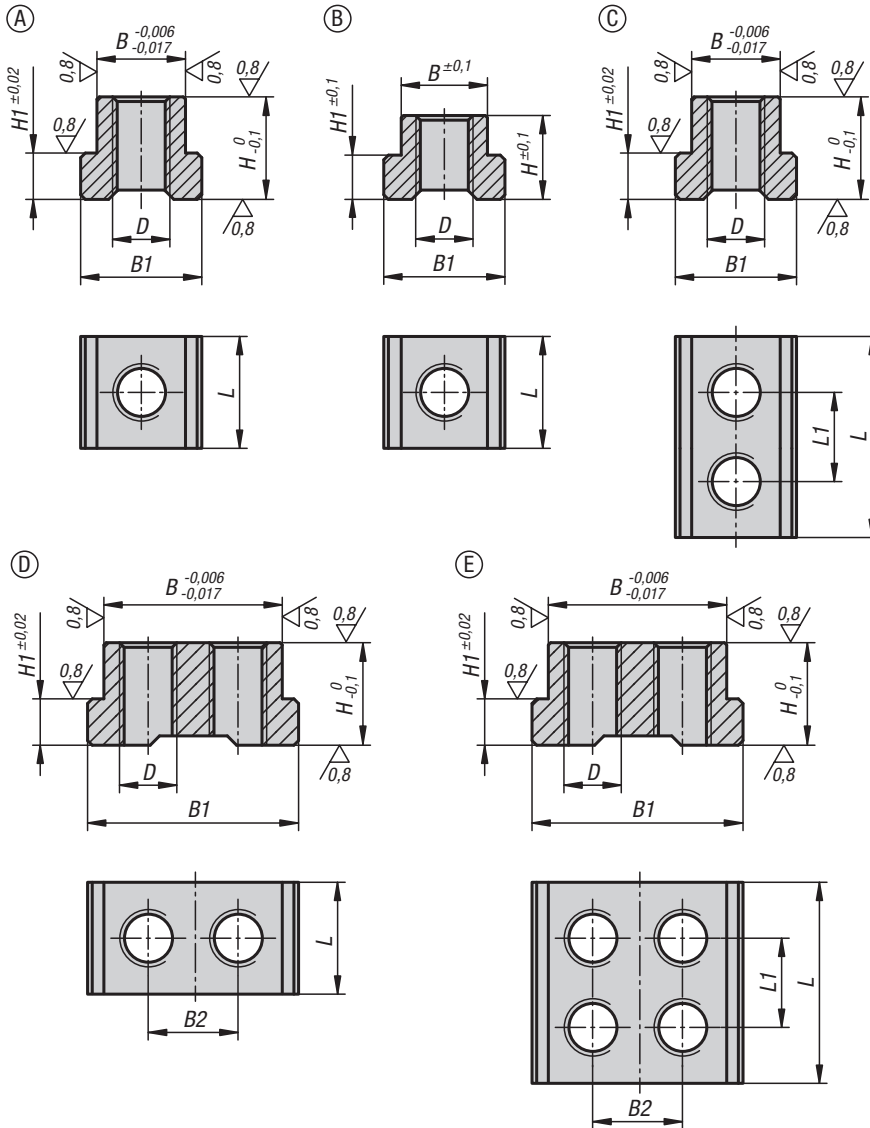
**Version:**  
Tempered. Guide faces ground (HRC 38).

**Sample order:**  
K1758.05010241

**Note:**  
T-slot keys are matched to the multiple clamping system.  
Form A/C are used for fixed stops.  
Form B is for operating the clamping wedge of the clamping wedge segments.

**Application:**  
The T-slot keys are inserted into the clamping rail at the appropriate position. The cap screw is used to screw the T-slot keys to the fixed stops and wedge clamps.

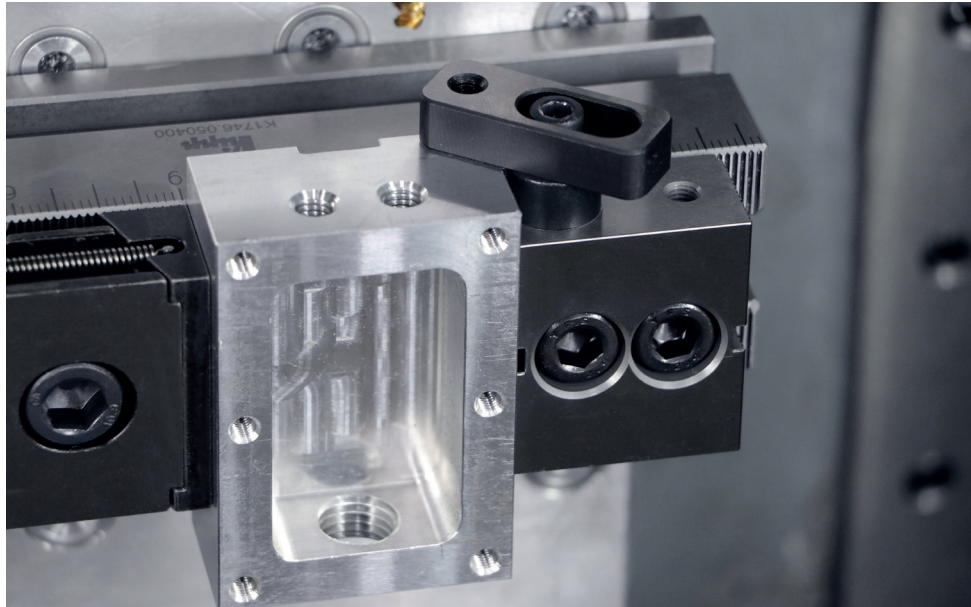
**Advantages:**  
With Form A/C, the T-slot key has very little play in the clamping rail, so the fixed stops can also be inserted from the side.



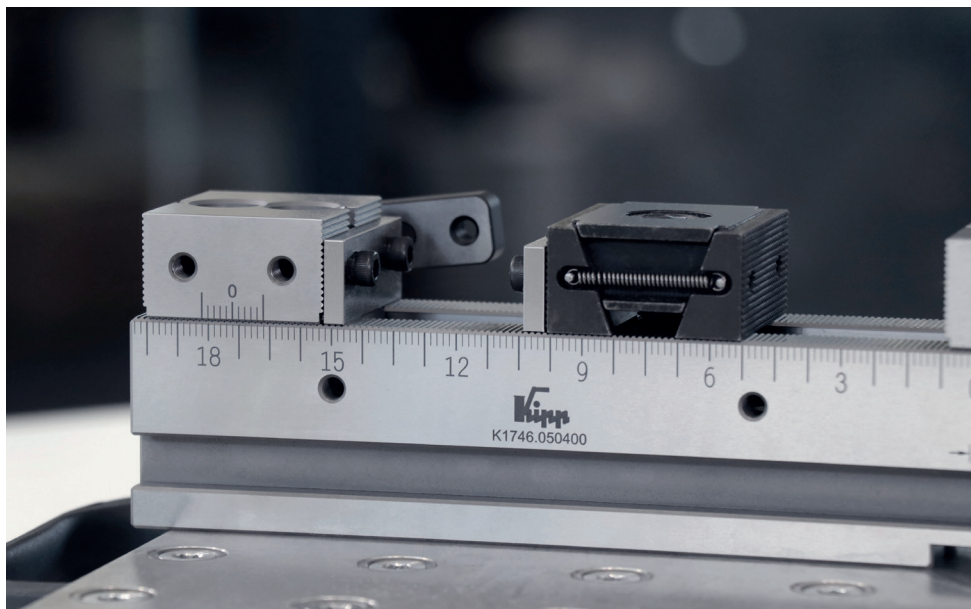
### KIPP T-slot keys for wedge clamps

Order No.	suitable for system width	Form	Suitable for	L	L1	B	H	B1	H1	D
										Internal thread
K1758.05010241	50	A	fixed jaw single-sided	24	-	19	22	26	9,95	M10
K1758.05010361	50	C	fixed jaw double-sided	36	18	19	22	26	9,95	M10
K1758.05012241	50	A	wedge clamp with fixed jaw	24	-	19	22	26	9,95	M12
K1758.05012262	50	B	double-sided wedge clamp	26	-	18,5	18	26	9,5	M12
K1758.07214281	72	A	fixed jaw single-sided	28	-	30	33	40	14,95	M14x1,5
K1758.07214533	72	C	fixed jaw double-sided	53	28	30	33	40	14,95	M14x1,5
K1758.07216281	72	A	wedge clamp with fixed jaw	28	-	30	33	40	14,95	M16
K1758.07216302	72	B	double-sided wedge clamp	30	-	29,5	28,5	39,5	14,5	M16
K1758.10014344	100	D	Fixed jaw one side / Wedge clamp with fixed jaw	34	-	45	33	56	14,95	M14x1,5
K1758.10014595	100	E	fixed jaw double-sided	59	30	45	33	56	14,95	M14x1,5
K1758.10016342	100	A	double-sided wedge clamp	34	-	44,5	28,5	55,5	14,5	M16

## Example of a multi-clamping system



Fixed jaw of the multi-clamping system with workpiece stop.



Multi-clamping system with support bars and lateral workpiece stop for the workpiece.





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