

UNILOCK turn clamping stations

Item description/product images



Description

Material:

Baseplate steel.
Clamping module case-hardening steel.

Version:

Baseplate ground and oxidised both sides.
Clamping module contact faces hardened and ground.

Note:

Pre-assembled turn clamping stations with integrated UNILOCK ESM138-C clamping modules for turning/milling centres. Turning technology and stationary clamping technology can be combined using these clamping stations. The clamping stations are attached to the machine table using centring pins and slot keys. The clamping modules are actuated using a central pneumatic port. The high clamping forces are generated via the integrated spring package (the unit clamps while not under pressure). A visual indicator pin shows that the turbo function is activated. Clamping is released pneumatically.

The following clamping forces are possible with the UNILOCK clamping bolt in conjunction with M10, M12, M16 fastening screws:

- Clamping force (M10) 35,000 N/module
- Clamping force (M12) 50,000 N/module
- Clamping force (M16) 75,000 N/module

Clamping force with DIN EN ISO 4762 -12.9 cap screws

Clamping bolts may only be clamped in conjunction with a mounted interchangeable unit in the clamping module.

Type of operation:

K2351.320045075

Max. speed: 1400 1/min

K2351.520057079

Max. speed: 2000 1/min

Technical data:

- Opening pressure: 6 bar, lubricated air.
- Air port: G1/8.
- Repeat accuracy ≤ 0.005 mm.
- Concentricity < 0.02 mm.

Temperature range:

+5 °C to +60 °C.

On request:

Clamping station in special dimensions.

Supplied with:

- Clamping station.
- Mounting screws.
- Centring pin.
- Alignment pins.

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- Slot keys.
- Ring bolts.
- Operating instructions.

Accessory:

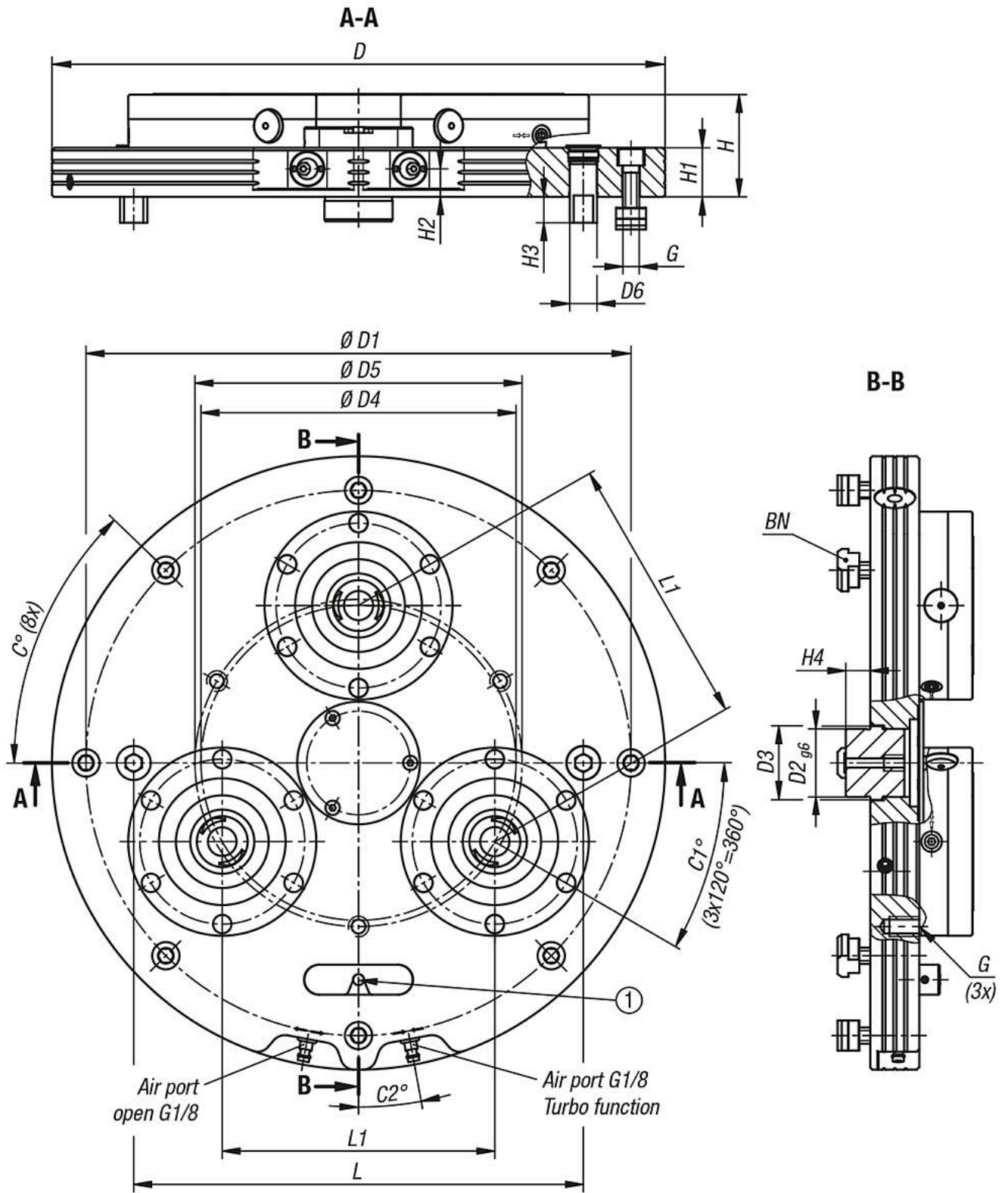
- UNILOCK clamping bolts K0967.
- UNILOCK interchangeable subplates for zero-point clamping system K1218.
- UNILOCK protective bolts for clamping module K1010.
- UNILOCK protective plugs for clamping module K1010.

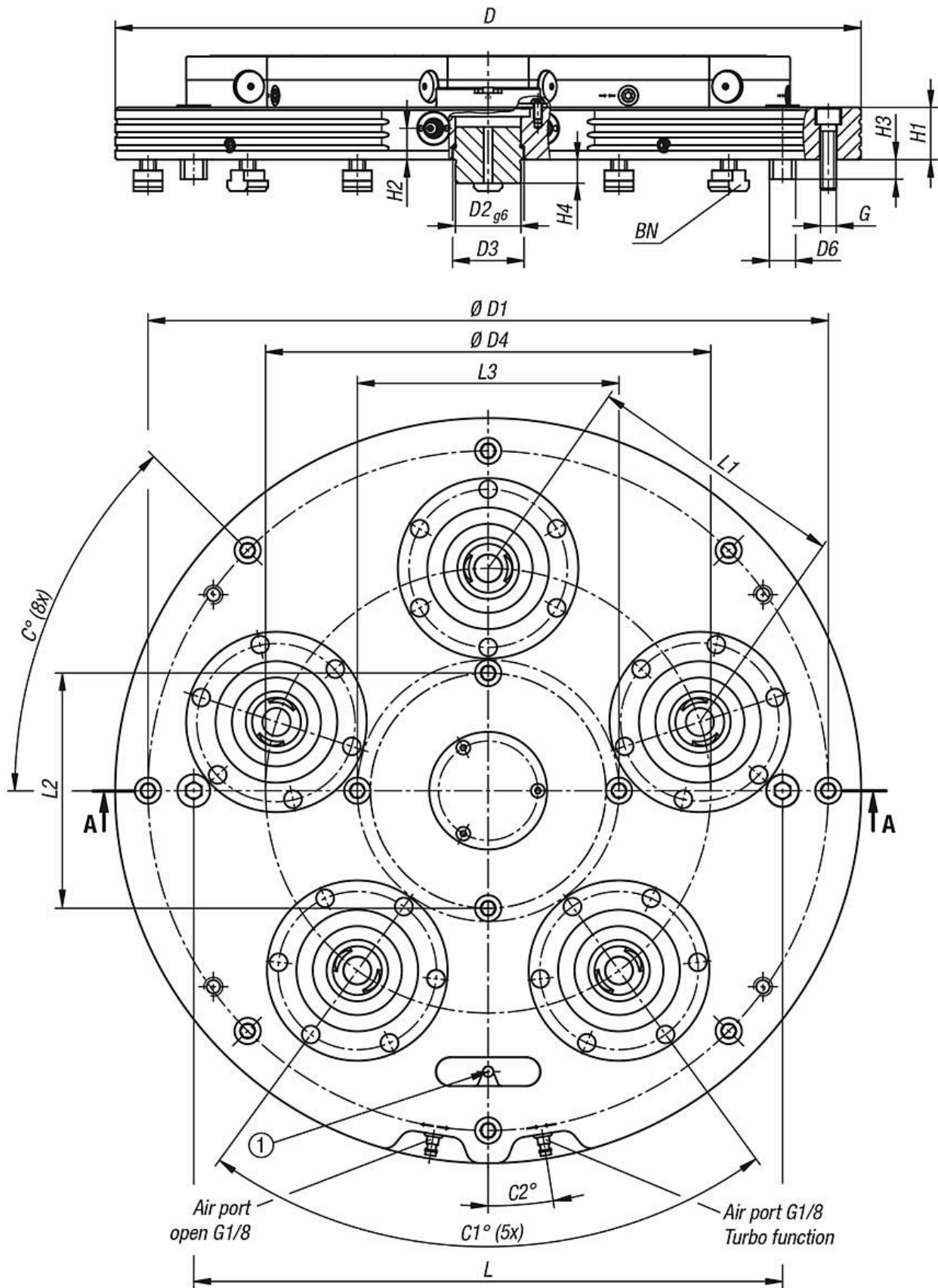
Drawing reference:

- 1) Visual indicator for turbo function

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Drawings





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Overview of items

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Order No.	Version 2	Form definition	D	H	C	C1	C2	D1	D2	D3	D4	D5	D6
K2351.320045075	3x	without rotation lock	450	75	45	30	10,5	400	50	55	230,94	240	20
K2351.520057079	5x	without rotation lock	570	79	45	72	9	520	50	55	340,26	-	20

Order No.	Version 2	G	H1	H2	H3	H4	L	L1	L2	L3	BN=Slot width	Retraction force with turbo kN
K2351.320045075	3x	M12	36	20,5	19	18	330	200	-	-	14	84
K2351.520057079	5x	M12	40	25	15	18	450	200	180	200	14	140