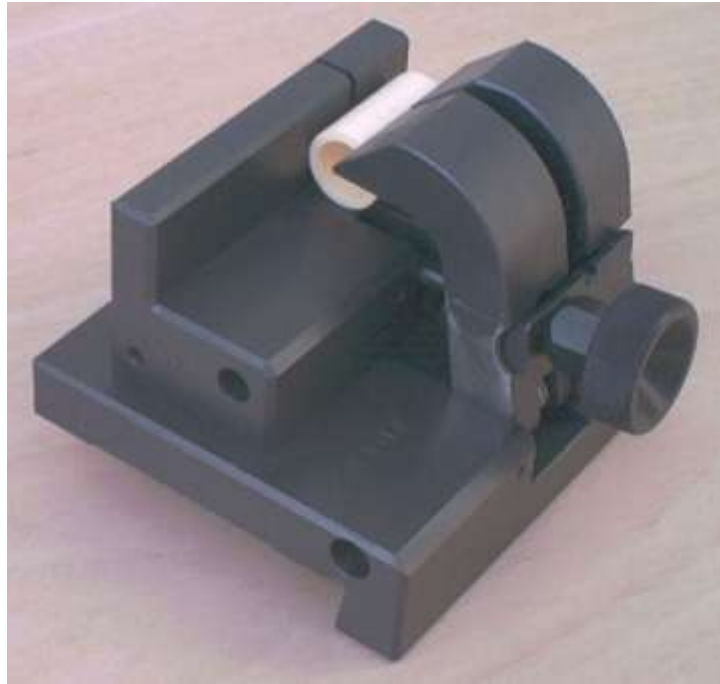


Technical information 370.78.402.10

Thanks to our large selection of clamping systems, the UFT 200/  
UFT 210/UFT 370 immersion cutting machine can be used for very many  
applications.

All available standard clamping systems are shown below.





Three-point double clamping device 370.17.100.00 for cylindrical workpieces from  $\varnothing$  3mm up to  $\varnothing$  5mm



For the safe clamping of mills, hole punches, ejectors, material samples, cylindrical and angular workpieces.



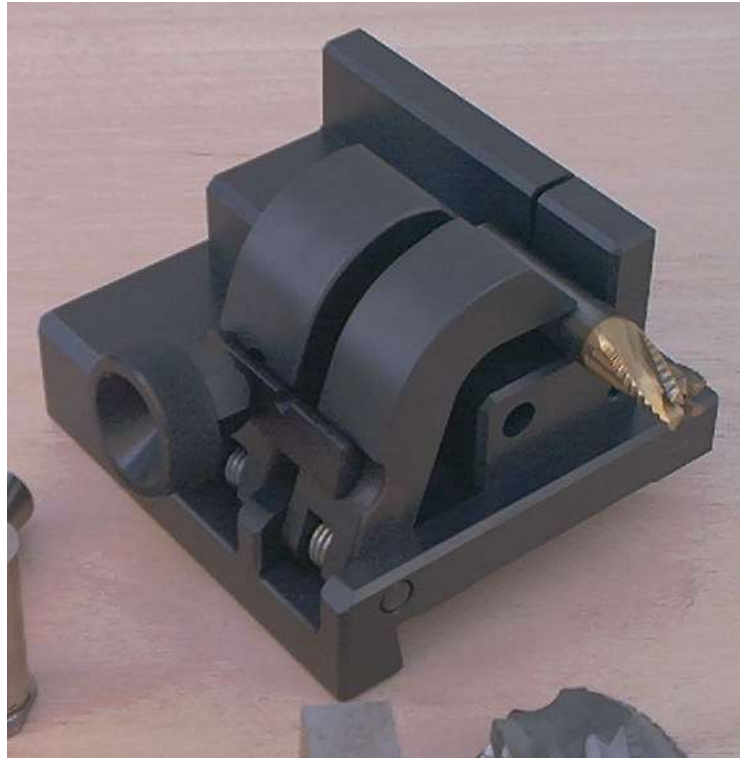
Clamping device 370.17.100.00 with limit stop 370.17.510.00 to cut several workpieces to identical length up to 130mm (fits for UFT 200)



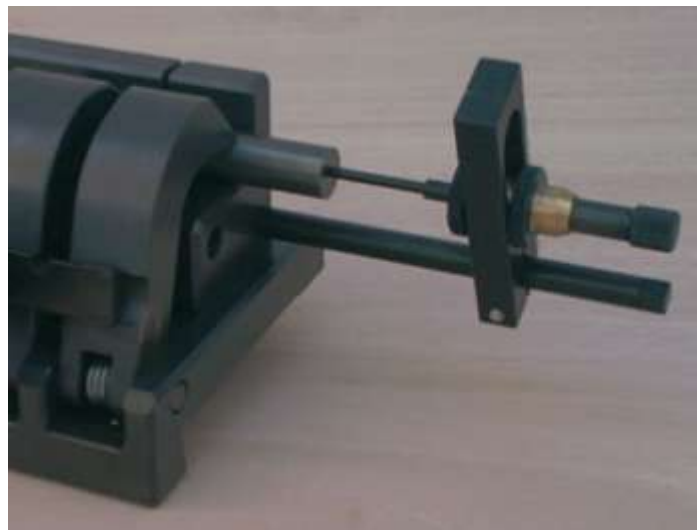
Clamping device 370.17.100.00 with limit stop 370.17.515.00 to cut several workpieces to identical length up to 270mm



Clamping device 370.17.070.00 only in connection with 3 point-clamping device 370.17.100.00 or 370.17.140.00 for a quick clamping of the workpieces



Cutters with a straight shank are clamped as shown above to cut off the front end.



Clamping device 370.17.100.00 with stop 370.17.110.00 for cutting several workpieces to identical length.



370.17.250.00 clamping mandrel for shell end mills; all tool bore diameters on one holder.



The clamping mandrel is clamped in the clamping device 370.17.100.00. Shell end mills up to  $\text{Ø } 125\text{mm}$  can be cut off in several steps by fixing the clamping mandrel by its collar on the clamping device.





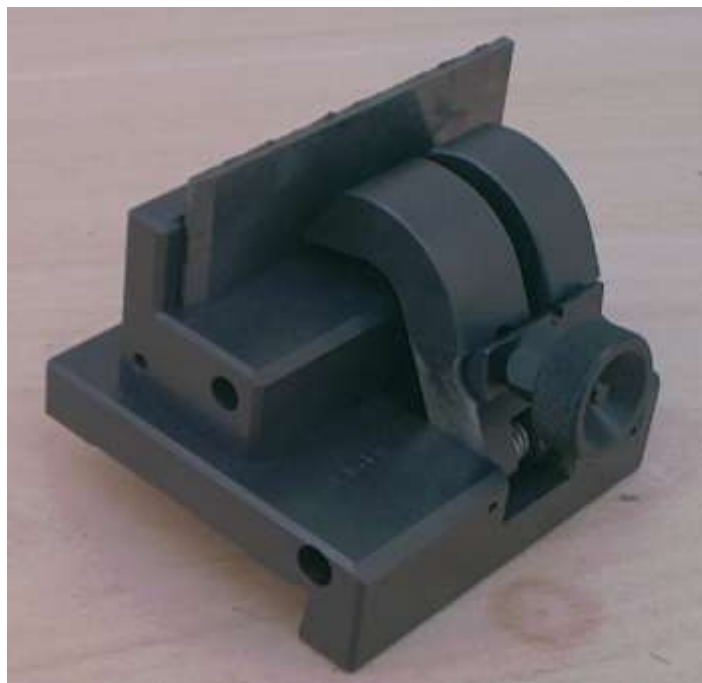
Special clamping sleeves 370.17.210.00 for MT 1, 370.17.220.00 for MT 2 and 370.17.230.00 for MT 3 are available for clamping shaft mills with tapered shank.



Baseplate 370.17.120.00 is available on its own for you to solve your special clamping problems.



Clamping device 370.17.130.00 for 45° bevel cuts at both ends.  
Only for flat material at least 4mm thick.



90° cuts in flat material are also possible with clamping device  
370.17.100.00.





Clamping device 370.17.140.00 for clamping small parts,  $\varnothing$  1 – 30mm. Same as 370.17.100.00 but with a smaller Vee.

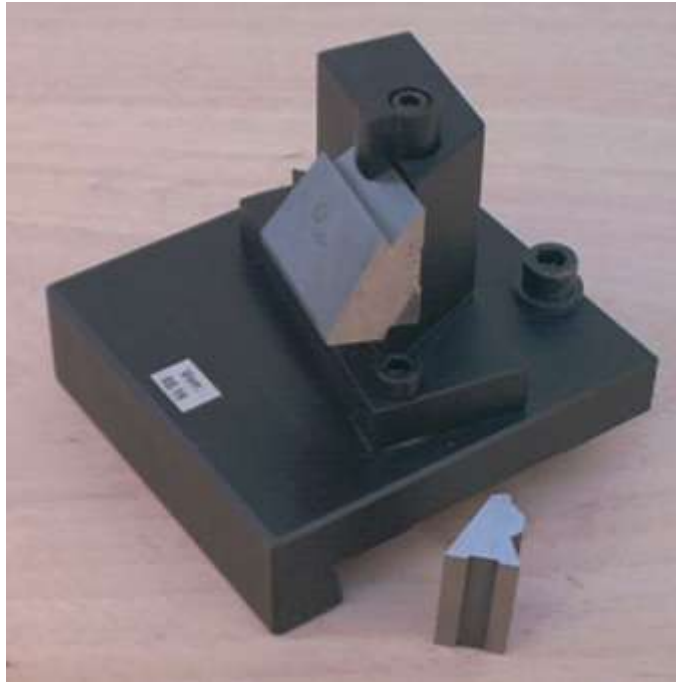


Clamping device 370.17.150.00 for cutting twist drill bits up to  $\varnothing$  25mm. The point angle can be set from 110° to 150°.



Clamping device 370.17.156.00 for cutting twist drill bits up to  $\varnothing$  40mm. The point angle can be set from 110° to 150°.

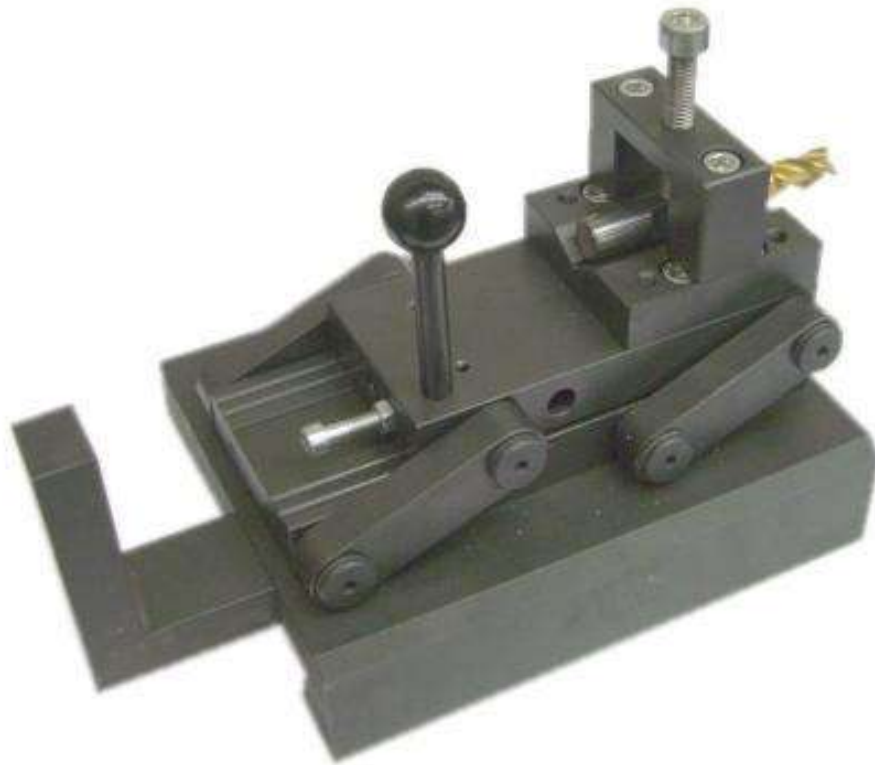




Clamping device 370.17.160.00 for the cutting and surface grinding of tangential lathe tools.



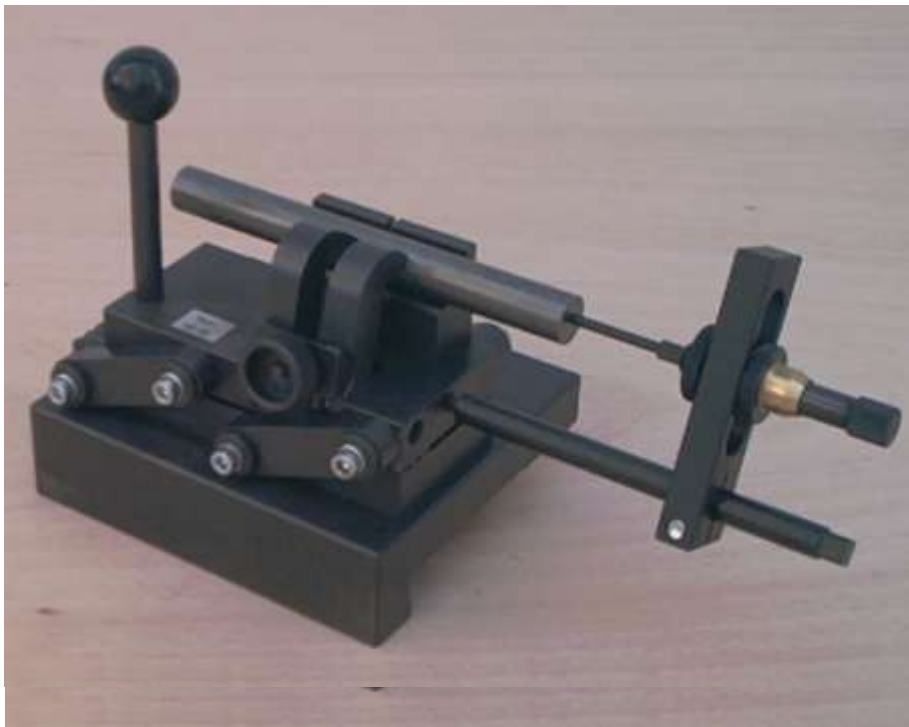
Locating mount for shaft mills with MK shafts and ISO taper shafts:  
370.17.240.00 für MT 4                      370.17.260.00 für ISO 40  
370.17.245.00 für MT 5                      370.17.265.00 für ISO 50



Clamping device 370.17.170.00 for cutting mills with mobile clamping up to  $\varnothing$  25mm at the front end.



This clamping device is special as it can be swung out of the water by means of a parallelogram, without having to drain the water.



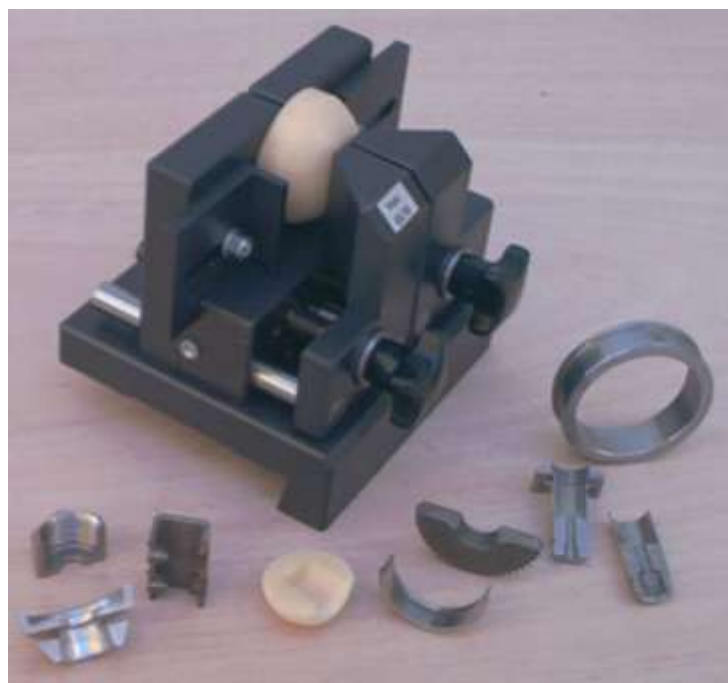
Three-point clamping device 370.17.180.00 for the clamping of cylindrical workpieces of up to  $\varnothing$  25mm (like 370.17.100.00) plus stop 370.17.110.00



This clamping device is special as it can be swung out of the water by means of a parallelogram, without having to drain the water.



Clamping device 370.17.190.00 with two separately adjustable clamping jaws for clamping turned parts in axial direction.



This device can be used to cut workpieces in order to test their metallurgical properties and internal contours.





Clamping device 370.17.195.00 for the cutting of planing knives and back serrated blanks – a stop with scale is available.

To cut long knives it may be necessary to extend the water trough of the UFT 370 on the left side or on both sides.



Revolving clamping device 370.17.200.00 for big workpieces up to max.  $\varnothing$  125mm. Three-point chuck driven by electrical motor and clutch.





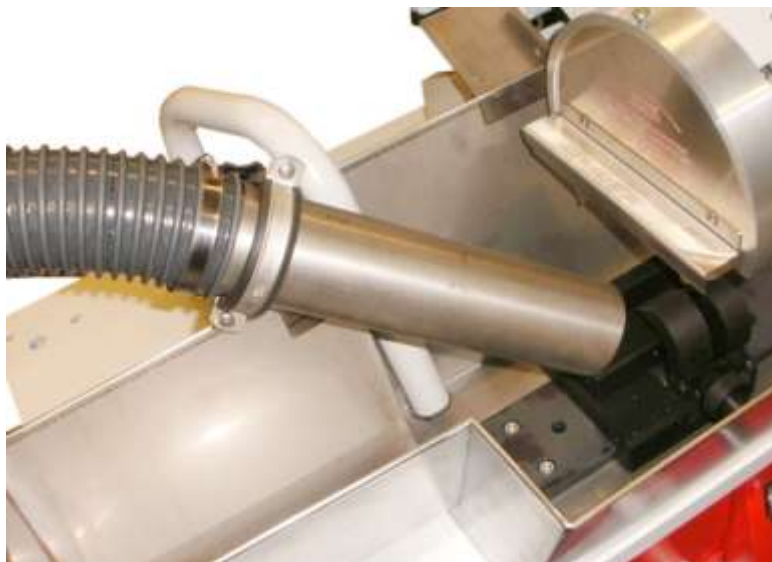
If none of the clamping devices shown above is suitable for clamping your workpiece correctly we will be glad to manufacture a special purpose jig for your needs.

## Accessories – dust collector



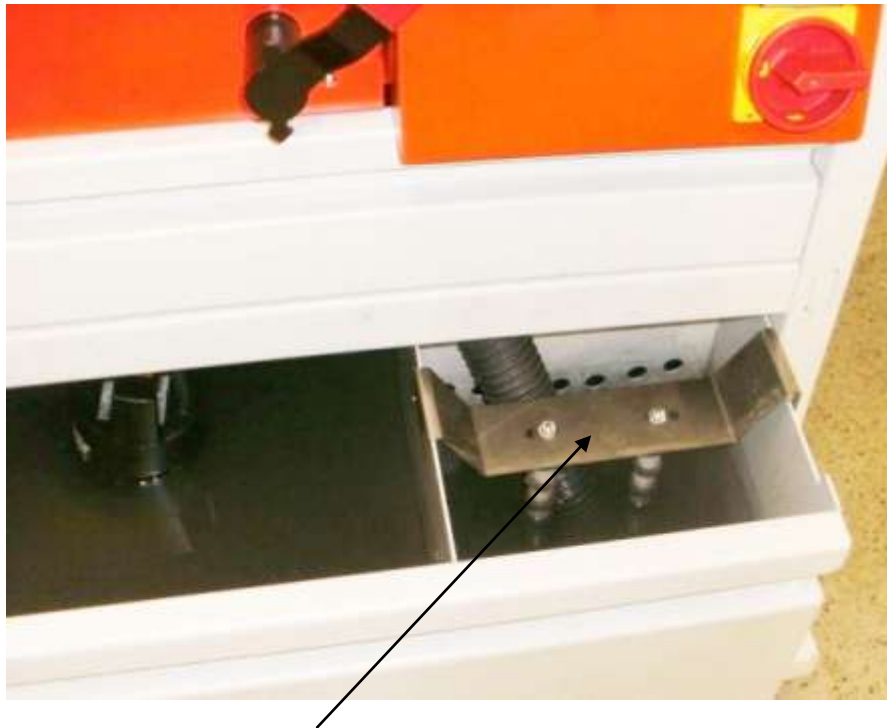
Dust collector 370.16.210.00 to suck out grinding fumes.  
This aspiration is placed at UFT 200 on the side of the coolant tank.

## Accessories – dust collector



Dust collector 370.16.220.00 to suck out grinding fumes.  
This aspiration is placed on the side of the coolant tank of UFT 370.

## Accessories – magnetic candle



Magnetic candle 370.15.140.00 to be put in the right compartment at the front of the decantation chamber at the base of the machine

This magnetic candle will fix magnetic particles which are in the coolant and prevent them going again into the cooling cycle.

Other accessories like coolant tank with special dimensions, pneumatic clamping devices, digital length measurement etc. on request.