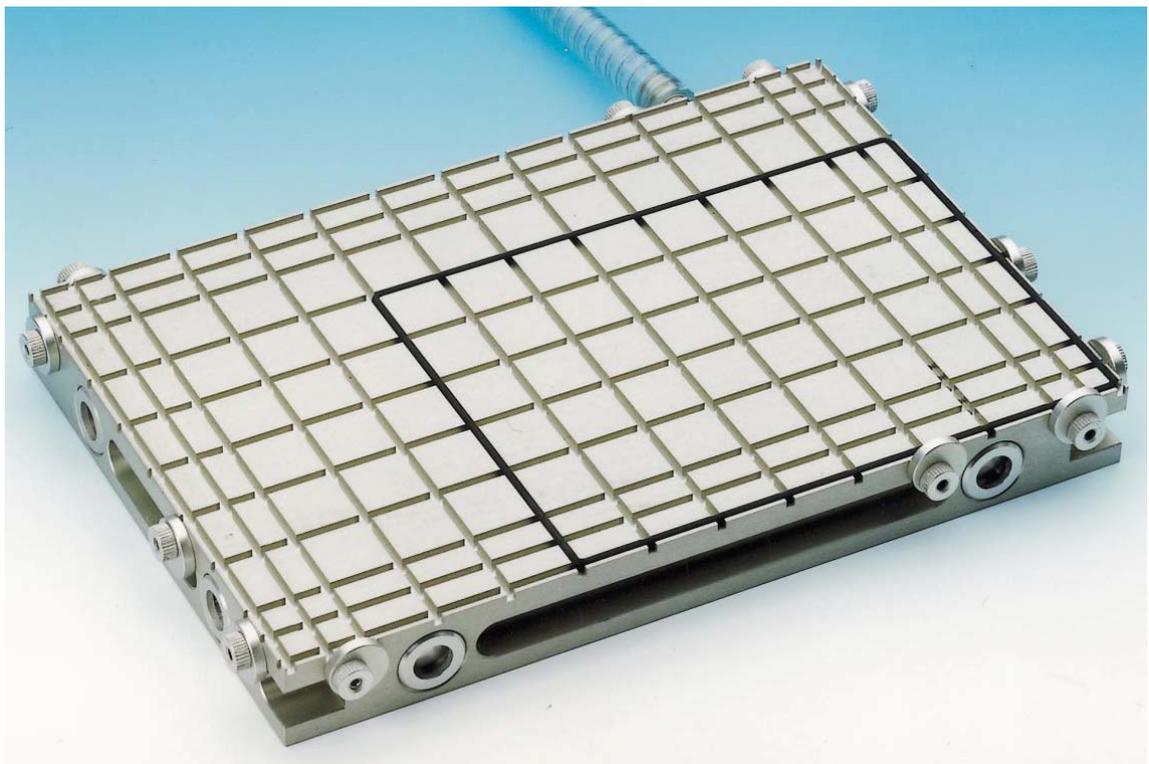


# Operating Instructions

## Vacuum Clamping Chuck Grid type





Doc-ID: Witt-7444

**Before starting all tasks, read the operating instructions!**

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## General

# 1 General

## 1.1 Information to these instructions

These instructions facilitate the safe and efficient handling of the equipment.

The instructions are part of the equipment and must be kept in the direct vicinity of the equipment, accessible for the personnel at all times. Before starting all tasks, personnel must carefully read and understand these instructions. Prerequisite for safe working is the compliance with all specified safety and handling instructions in these instructions.

Furthermore, the local statutory accident prevention and general safety regulations for the operating area of the equipment apply.

Figures in these instructions are for the fundamental understanding and can deviate from the actual construction of the equipment.

## 1.2 Other applicable documents

The clamping chuck must be connected to a vacuum pump.

In addition to these instructions, also refer to the documentation of the vacuum pump used for the clamping chuck.

## 1.3 Symbol explanation

### Safety Instructions

In these instructions, safety instructions are designated by symbols. The safety instructions are initiated by key words that express the extent of the hazard.

To prevent accidents, injury to persons and damage to property, comply implicitly with the safety instructions and be careful.



#### **WARNING!**

... indicates a possible hazardous situation that can lead to death, or to severe injuries, if they are not prevented.



#### **CAUTION!**

... indicates a possible hazardous situation that can lead to lesser or lighter injuries, if they are not prevented.



#### **CAUTION!**

... indicates a possible hazardous situation that can lead to damage of property, if they are not prevented.

### Tips and recommendations



#### **NOTE!**

... accentuates useful tips and recommendations, as well as information for efficient and fault-free operation.



## General

### 1.4 Liability Limitation

All data and notes in these instructions were prepared with consideration to the statutory standards and regulations, the present state of technology, as well as our many years of knowledge and experience.

The manufacturer accepts no liability for damage caused because of:

- Non-compliance with the instructions
- Non-specified use
- Use of untrained personnel
- Arbitrary modification
- Technical changes
- Use of uncertified spare parts

The actual scope of delivery can, by special designs, deviate from the explanations and presentations given here, because of the utilization of additional order options, or because of the most recent technical changes.

The responsibilities agreed in the delivery contract, the General Terms and Conditions as well as the delivery conditions of the manufacturer and the statutory regulations valid at the time of the conclusion of the contract are effective.

We reserve the right to make technical changes in the framework of improvement of the handling features and further development.

### 1.5 Copyright protection

These instructions are copyright protected and are determined exclusively for internal purposes.

Except for internal use, relinquishment of the instructions to a third party, duplication in any type or form – also extracts – as well as exploitation and/or communication of the contents is not permitted without the written authority of the manufacturer.

Contravention commits to compensation. Rights reserved for further demands.

## 1.6 Warranty conditions

### Guarantee

- The company must immediately reprehend all forms of deficiencies and claims. Apparent defects must be notified in writing within a period of two weeks from receipt of the goods. Punctual dispatch suffices to comply with the time limit. The company takes full liability for proof for all claims, especially for the deficiency itself, for the time of identifying the defect and for the punctual notification of the defect. The notice of defect is to be effected by quoting the contract or invoice number. Non-apparent defects must be notified within two weeks of detection, in accordance with the aforementioned explanations.
- If there is a defect, the company WITTE has the right to select the warranty afforded, namely a choice of supplying a spare part or by rectification. The company WITTE is authorized to refuse the remedy requested by the company, if it is only possible with disproportionate costs and the other type of remedy has no remaining substantial disadvantages for the company.
- The warranty demands can no longer be invoked after the expiry of one year after delivery of the goods. Fundamentally, only the product description is decisive and agreed for the quality of the goods. Public announcements, promotions or advertising, in addition to non-contractual statements, do not represent the quality of the goods.
- In the case of a legal deficiency or material defect, after unsuccessful rectification, the company only has the right to withdraw from the contract. In addition, there is no claim for indemnity through the defect.

### Severability clause

Should individual conditions of the contract with the company be, or become, invalid in whole or in part, including these General Terms and Conditions, the effectivity of the remaining conditions is not prejudiced herewith. The whole, or partly invalid settlement, should be replaced by a settlement, whose commercial success is as near as possible to the invalid one. Verbal agreements are not valid, if they are not agreed retrospectively or in writing.



## General

### Liability exclusion

- The company WITTE accepts no liability for facile, negligent breaches of responsibility, provided that it is not concerned with essential contractual obligations (cardinal obligations), independent of whether the company WITTE, or a vicarious agent, perpetrates a breach of obligation. The company WITTE accepts no liability for fundamental culpable blame, as a non-managerial vicarious agent. By moderate negligence of breaches of responsibility, the liability is limited to the typical damage occurring in transactions of the contractual type.
- The aforementioned liability limitations are not applicable to demands of the company regarding product liability. Furthermore, the liability limitations are not valid for bodily and health injuries attributable to us, or by loss of life of the contractor or his vicarious agent.
- Any claim for indemnity by the contractor for a defect becomes invalid after one year from the delivery of the goods. This is not valid if the company WITTE is reproached for malice.

## 1.7 After-sales service

For technical advice, our after-sales service is available. Contact data, refer to Page 2.

Furthermore, our staff are continually interested in new information and experiences that comes from the application and could be useful for improving our products.

## 2 Safety

This section gives an overview of all important safety aspects for optimum protection of the personnel, as well as for the safe and fault-free operation.

The non-compliance of the handling and safety instructions given in these instructions can lead to serious hazards.

### 2.1 Responsibility of the operating company

The equipment is used in the industrial field. Thus, the operating company of the equipment is subject to the statutory obligations for occupational health and safety.

Additional to the occupational health and safety instructions in these operating instructions, the accident prevention and environmental protection regulations for the field of operation must also be adhered to. Thereby, it is especially imperative that:

- The operating company must inform itself about the effective industrial regulations and determine additional hazards in a risk assessment that result through the special working conditions at the place of operation of the equipment. The company must implement these in the form of operating instructions for the operation of the equipment.
- During the total operating time of the equipment, the operating company must check to make sure that the established operating instructions conform to the current status of the rules and standards and, as necessary, adapt them.
- The operating company must make sure that all staff who handle the equipment have read the operating instructions and understood them.  
Furthermore, the personnel must be instructed at regular intervals and informed about the dangers.
- The operating company must provide the required safety equipment for the personnel.

## 2.2 Personnel Requirements

### 2.2.1 Qualifications

**WARNING!****Danger of injury if the skills are insufficient!**

Incorrect handling can lead to substantial injuries to persons and damage to property.

Therefore:

- All tasks must be carried out by personnel qualified for the tasks.

In the operating instructions, the qualification for the different fields of activity are given as follows.

**■ Instructed person**

was instructed by the operating company in a briefing about the tasks assigned to them and instructed about possible hazards because of improper conduct.

**■ Specialists**

because of the technical training, knowledge and experience and also awareness of the relevant regulations, are in the position to carry out the tasks assigned to them and be able to autonomously identify and prevent possible hazards.

Only persons who can be expected to carry out their tasks reliably are authorized. Persons whose responsiveness is affected, e.g. by drugs, alcohol or medicines are not authorized.

- When selecting the operating personnel, make sure to observe all age and occupational regulations applicable at the place of installation.

### 2.2.2 Unauthorized persons

**WARNING!****Danger to unauthorized persons!**

Unauthorized persons are those who do not fulfil the requirements described here, do not know the hazards in the area of operation.

Therefore:

- Keep unauthorized persons clear of the area of operation.
- If in doubt, address the persons and banish them from the area of operation.
- Interrupt the tasks as long as the unauthorized person is in the area of operation.

## 2.3 Personal Protective Equipment

When working, it is necessary to wear personal protective equipment in order to reduce the health dangers.

- When working, the protective equipment required for the respective task must always be worn.
- Obey the instructions attached in the work area for the personal protective equipment.

### Fundamental workwear

For all tasks, fundamentally wear:



#### Protective clothing

is close fitting workwear with a low tear strength, with tight sleeves and no protruding parts. They predominantly serve to protect from catching in moving machine parts.

Do not wear rings, chains or other jewellery.



#### Safety shoes

for the protection against heavy parts falling down and from slipping on slippery surface.



#### Protective gloves

to protect the hands from rubbing, abrasions, cuts or more profound injuries, as well as when touching hot surfaces.



#### Safety glasses

to protect the eyes from flying parts and splashing liquid.



## Safety

### 2.4 Intended use

The chuck is exclusively conceived and designed for the intended use as described here.

The vacuum clamping chuck serves to clamp and fix simple shaped workpieces with a coarse surface so that they can be mechanically machined or measured.



**WARNING!**  
**Danger by inappropriate use!**

Every application in excess of the intended use and/or other use of the chuck, can lead to hazardous situations.

Therefore:

- Only use the chuck for its intended use.
- It is imperative to adhere to all information in these operating instructions.
- No clamping of the workpieces beyond the specification.

Claims in all form are excluded by inappropriate use.

The operating company is liable for all damage caused by inappropriate use.

## 2.5 Special Hazards

In the following section, remaining risks are specified that were determined during a risk evaluation.

- In order to reduce danger to health and prevent hazardous situations, observe the safety instructions given here and the warning notices in the further chapters in these instructions.

### Pneumatics



#### **CAUTION!**

#### **Danger of injury from pneumatic power!**

Pneumatic power can cause injuries.

Therefore:

- Tasks on the pneumatics must only be carried out by trained specialists.
- Before beginning tasks on the pneumatic system, completely discharge the pressure. Thereby, pay attention to the pressure accumulator.
- Never load the vacuum clamping chuck with a workpiece when operating pressure is present (danger of crushing!).

### Sharp edges and corners



#### **CAUTION!**

#### **Danger of injury from the edges and corners!**

Sharp edges and corners can cause abrasions to and cut the skin.

Therefore:

- Be very careful when carrying out tasks near sharp edges and corners.
- If in doubt, wear protective gloves.

## Technical Data

### Contamination and objects laying around



#### CAUTION!

#### Danger of tripping on contamination and over objects laying around!

Contamination and objects laying around generate sources of slipping and tripping and can cause substantial injuries.

Therefore:

- Always keep the work area clean.
- Remove objects no longer required.
- Designate tripping positions with yellow-black marker band.

### Hot surfaces



#### CAUTION!

#### Danger of burning on hot surfaces!

Contact with hot components can cause burns.

Therefore:

- As a matter of principle, for all tasks near hot components, protective clothing and gloves must be worn.
- Before all tasks, make sure that all components have cooled down to the ambient temperature.

## 3 Technical Data

Specification	Value	Unit
Weight	5	kg
Length	300	mm
Width	200	mm
Height	32,5	mm
Diameter of connection adapters	13	mm

## 4 Design and Function

### 4.1 Brief description

The grid chuck consists of an aluminium plate, in which grooves are milled into the surface in a fixed grid. An O-shaped seal, dependent on the geometry of the workpiece to be clamped, is placed in these grooves. Thereby, when mounting the workpiece, an enclosed area is created that can be evacuated. The seal ensures the constant underpressure of the operating vacuum.

The grid chuck is mounted to the machine table using clamps and is connected to a vacuum pump, vacuum generator or to the vacuum system.

The workpiece positioned on the grid chuck is clamped by the operating vacuum evacuating the air between the workpiece bearing surface and the clamping surface.

The workpiece can then be machined on 5 sides.

Multiple grid chucks can be connected to one another, by the vacuum plate adapter, so that workpieces with a larger surface can also be clamped.

### 4.2 Overview

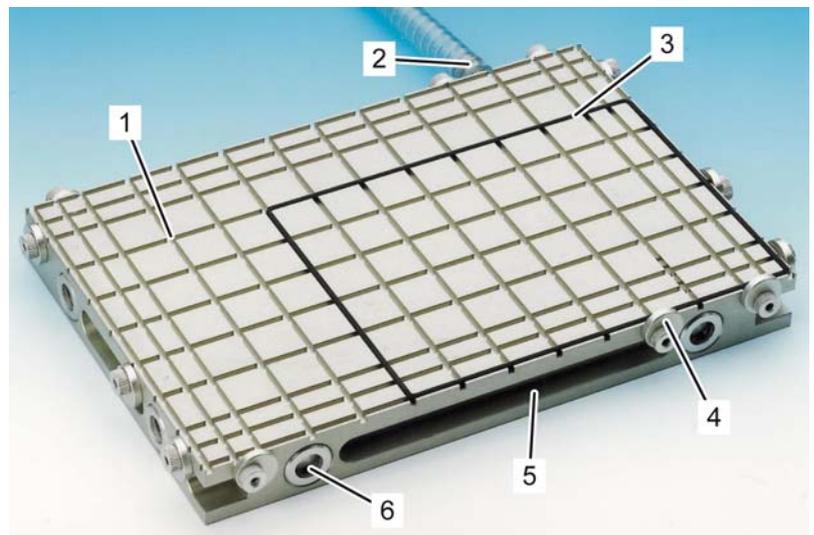


Fig. 1: Overview

- |   |                                |   |   |
|---|--------------------------------|---|---|
| 1 | Grid (clamping surface)        | 5 | Clamping groove for the clamps                                |
| 2 | Vacuum connector               | 6 | Blanking plugs (connection hole for the vacuum plate adapter) |
| 3 | O-shaped seal                  |   |   |
| 4 | Stop washer, height adjustable |   |   |



## Design and Function

### 4.3 Scope of delivery

- 1 x Vacuum clamping chuck
- 1 x Vacuum connector
- 7 x Blanking plugs
- 10 x O-Rings
- 1 x Plug LW 12
- 1 x O-shaped seal ( $\varnothing = 4$  mm, L = 10 m)
- 1 x Vacuum hose with wire spiral 18/12 (L = 1 m)
- 2 x Clamps
- Stop washers (height adjustable, mounted excentrically)

## 5 Transportation, Packaging and Storage

### 5.1 Safety instructions for transportation

#### Improper transportation

**CAUTION!****Damage through improper transportation!**

Damage can occur by improper transportation.

Therefore:

- When unloading the packed chuck on delivery, as well as internal transportation, proceed very carefully and obey the symbols and instructions on the packaging.
- Only remove the packaging immediately prior to installation.

### 5.2 Transportation inspection

Upon receipt of the delivery, immediately check for completeness and for damage during transportation.

In case of obvious external damage through transportation, proceed as follows:

- Do not accept the delivery, or only conditionally.
- Record the scope of the damage on the transport documents of the carrier, or on the delivery note.
- Initiate the reclamation.

**NOTE!**

*Reclaim about each defect immediately it is detected. Claims for damage can only be invoked within the statutory reclamation period.*

### 5.3 Packaging

#### For packaging

The chuck is packed according to the anticipated transportation conditions. Environmentally friendly material is used exclusively for the packaging.

The packaging should protect the chuck and its assemblies from damage during transportation, corrosion and other damage until the installation. Therefore, do not damage the packaging and only remove immediately before installation.

## Transportation, Packaging and Storage

### Handling the packaging material

Dispose of the packaging material in accordance with the respective statutory regulations and local instructions.



#### **CAUTION!**

#### **Environmental damage by incorrect disposal!**

Packaging material is valuable raw material and can be used again in many cases, or expediently reprocessed and recycled.

Therefore:

- Dispose packaging material environmentally friendly.
- Observe the local statutory disposal instructions. As necessary, assign a specialized firm for the disposal.

## 5.4 Storage

### Storing the packaging

Store the clamping chuck under the conditions given as follows:

- Do not keep outside.
- Store in the dry and dust-free.
- Do not expose to any aggressive medium.
- Protect from solar radiation.
- Prevent mechanical vibration.
- Storage temperature: 15 to 35 °C.
- Relative humidity: 60 % max.
- For storage of more than 3 months, check the general condition of all components and the packaging. As necessary, renew or replace the conservation.



#### **NOTE!**

*Possibly, there are instructions on the packaging for storage that exceed the requirements mentioned here. Conform to these respectively.*

## 6 Installation and Commissioning

### 6.1 Safety

#### Improper installation and commissioning

**WARNING!****Danger of injury through improper installation and commissioning!**

Improper installation and commissioning can cause injury to persons or damage to property.

Therefore:

- Before starting the tasks, make sure that there is sufficient space for installation.
- Be very careful with open components with sharp edges.
- Pay attention to order and cleanliness at the installation site! Loose components and tools on top of one another, or laying around, are sources of accidents.
- All installation tasks should be carried out exclusively by specialists.

#### Personal Protective Equipment

The protective equipment given as follows must be worn for all installation and commissioning tasks:

- Protective clothing
- Safety shoes
- Protective gloves
- Safety glasses

## Installation and Commissioning

### 6.2 Installation



Fig. 2: Attaching the clamps

1. Align the vacuum chuck on the machine table.
2. Mount the vacuum chuck with the clamps on the machine table.



Fig. 3: Connect the vacuum hose

3. Connect the vacuum hose with a 3/2-way valve to the connection adapters on the vacuum clamping chuck.
4. Secure the vacuum hose with a hose clamp.
5. Connect the other end of the vacuum hose to a vacuum unit and a vacuum switch with indicator (Order No. 84886).  
→ **Observe the instructions for the vacuum unit.**
6. Arrange the vacuum hose so that no-one can trip over it and, as necessary, designate it with yellow-black marking band.



#### CAUTION!

##### Danger through liquids sucked in!

Liquids (e.g. coolant) sucked in during the machining of the workpiece and that get between the clamping surface and the workpiece bearing area can damage the vacuum pump and reduce the workpiece coefficient of friction.

Therefore:

- When using liquids during machining, always connect a liquid separator between the vacuum clamping chuck and vacuum pump.
- Check the workpiece to make sure that it sits firmly.

### 6.3 Coupling vacuum clamping chucks

A further vacuum chuck can be connected to each side of the vacuum chuck.

It is not necessary for the connected vacuum chuck to have an additional vacuum hose, because the operating vacuum is effective for all vacuum clamping chucks through the chuck connectors.



*Fig. 4: Release the screws*

1. Release the screws on the sides of the vacuum clamping chuck to which further vacuum clamping chucks should be connected.



*Fig. 5: Remove the blanking plugs*

2. Use the assembly tool and remove the blanking plugs.



*Fig. 6: Install the plate adapter*

3. Install the chuck connectors.

## Installation and Commissioning

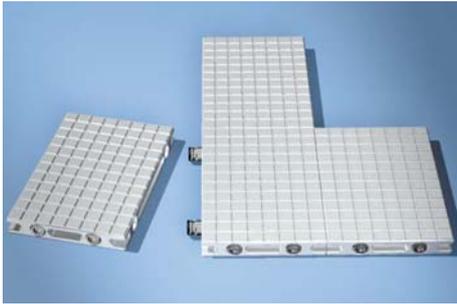


Fig. 7: Connected plates

4. Connect further vacuum clamping chucks.
5. Tighten all screws.

### 6.4 Install the stop washer

With the assistance of the stop washers, the workpieces can be aligned on the bearing surface of the vacuum chuck. Thereby, the excentric stop washers must protrude over the edge of the vacuum clamping chuck.

If the workpieces to be machined are, in contrast, larger than the clamping surface of the vacuum chuck, the stop washers must not protrude over the edge of the vacuum chuck.



Fig. 8: Install the set screw

1. Install the set screw with knurled nut and stop washer into the hole provided.



Fig. 9: Tighten the stop washer

2. Turn the stop washer so that it protrudes over the edge of the vacuum clamping chuck.
3. Tighten the stop washer with the knurled nut.

## 6.5 Clamping the workpiece



**CAUTION!**  
**Insufficient retention force between the workpiece and vacuum clamping chuck!**

Clamped workpieces can loosen themselves from the vacuum clamping chuck and cause injuries and damage to property.

Therefore:

- The operating vacuum must be constant and a minimum of 0.75 bar.
- During the machining of the workpiece, continually check the operating vacuum on a manometer.
- The machining force must always be less than the retaining force.
- In case of heavier chip removal, always use the stops to secure the workpiece.
- If possible, make sure that the machining forces, or feed motion, is always towards the stops.

To prevent loss of the vacuum, a caulking strip must be placed in the grid between the workpiece and vacuum clamping chuck.

(→ **Accessories**).

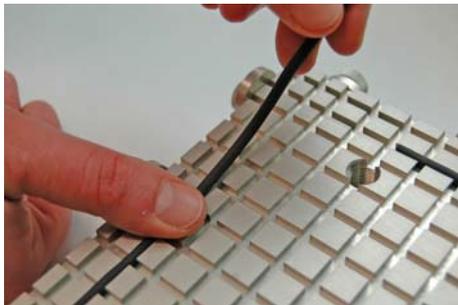


Fig. 10: Place seal

1. Cut the O-shaped seal according to the size of the workpiece.
2. According to the dimensions of the workpiece, place the seal in the recesses of the grid surface. Thereby, make sure that the intended vacuum area is enclosed by the seal.
3. Place the seal so that the end and start are face to face. Thereby, prevent compressing and pulling of the seal.



**NOTE!**

*Moisten hands when placing the seal.*

## Installation and Commissioning



Fig. 11: Seal in position

4. Place the workpiece to be clamped on the seal and, as necessary, align with the stop washers.

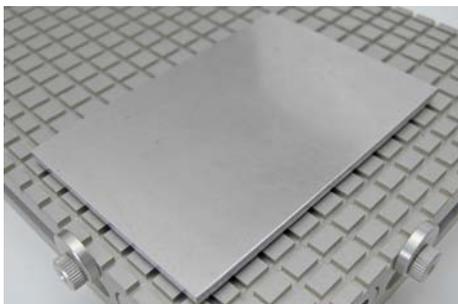


Fig. 12: Clamping the workpiece

5. Switch on the vacuum and clamp the workpiece.  
→ **Observe the instructions for the vacuum unit.**
6. Check the workpiece to make sure that it sits firmly.

## 6.6 Tasks after use

1. After the machining, before removal of the workpiece, the vacuum clamping chuck must be cleaned with an industrial vacuum system and the operating vacuum.
2. After removing all oddments and swarf, switch off the operating vacuum.
3. Remove the workpiece from the vacuum clamping chuck.

## 7 Repair

The possible causes for malfunctions and the tasks for rectification are described in the chapter that follows. For malfunctions that cannot be rectified by the following instructions, contact the manufacturer, refer to the Service Address, Page 2.

### 7.1 Servicing

The vacuum chuck is maintenance-free. The vacuum chuck must be cleaned at regular intervals and freed from swarf, depending on the requirements, application and degree of contamination. Remove contamination with a cloth or compressed air. No corrosive cleaning agent must be used.

### 7.2 Malfunction Table

Malfunction	Possible cause	Fault rectification	Rectified by
Operating vacuum is not attained, or is too low and the vacuum pump operates continuously	Leaking vacuum hoses	Replace vacuum hoses	Specialist
	Contamination between the workpiece and vacuum clamping chuck	Clean the material surface and clamping chuck surface	Manufacturer
	Seal defect, or not correctly installed	Replace seal	Specialist
	Kinked vacuum hoses	Correctly adjust the vacuum hoses	Operator
Clamping surface of the vacuum clamping chuck damaged	Machining of the workpiece is inaccurate	Check the machining program	Specialist
Retaining force is insufficient to machine the workpiece	Clamping area is too small	Increase clamping area	Specialist
		Use additional stops for the workpieces	
	Diameter of the vacuum hoses is too small, or vacuum hoses too long	Increase the diameter of the vacuum hoses, or shorten the vacuum hoses	Specialist
	Insufficient performance of the vacuum pump	Increase the performance of the vacuum pump	Specialist

## Accessories and Spare Parts

### 8 Accessories and Spare Parts



#### WARNING!

**Danger of injuries through incorrect spare parts!**

Incorrect or defective spare parts can cause damage, incorrect functioning or complete failure, as well as affecting the safety.

Therefore:

- Only use original manufacturer spare parts.

The spare parts also not quoted in the following table can be obtained directly from Horst Witte Gerätebau. Address, refer to Page 2.

#### 8.1 O-shaped seal

Figure	Diameter [mm]	Order No.
 <p><b>i</b> <i>NOTE!</i> Minimum order quantity: 50 m per diameter</p>	2,0	00188
	3,0	00069
	3,5	00170
	4,0	00070
	4,5	00157
	5,0	00071
	5,5	00171
	6,0	00072
	6,5	00172
	7,0	00073
	8,0	00251
10,0	00316	

**O-shaped seal tolerances  
(in accordance with DIN ISO3302-1)**

Nominal size range [mm]	Tolerance [mm]
0 to 1.5	± 0,40
1.5 to 2.5	± 0,50
2.5 to 4	± 0,70
4 to 6.3	± 0,80
6.3 to 10	± 1,00
10 to 16	± 1,30
16 to 25	± 1,60
25 to 40	± 2,00
40 to 63	± 2,50
63 to 100	± 3,20

**8.2 Vacu grease**

The vacu grease is for the occasional lubrication of the suction hose and tension release for the sealing of workpieces with coarser and grooved bearing surface.

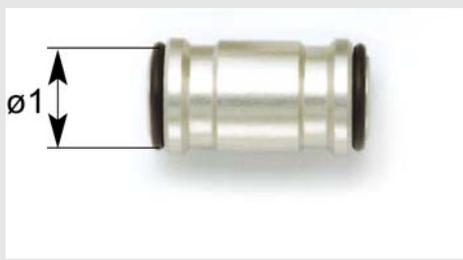
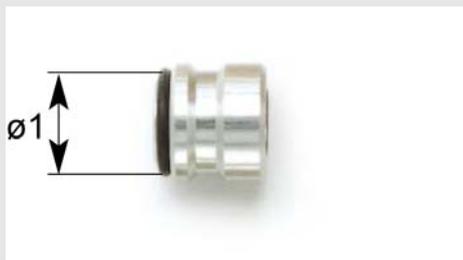

**NOTE!**

*The vacu grease contains silicone.  
Check the workpieces for compatibility with silicone.*

Figure	Content [g]	Weight [g]	Order No.
	250	290	80140

## Accessories and Spare Parts

### 8.3 Other

Figure	Designation	Dimensions [mm]	Order No.
	Vacuum connectors incl. O-ring	$\text{Ø}1 = 23$ $\text{Ø}2 = 14$	81761
	Chuck connectors O-ring	$\text{Ø}1 = 23$	81762
	Blanking plugs incl. O-ring	$\text{Ø}1 = 23$	81774
	O-ring	$\text{Ø}16 \times 2.5$	34798
	Assembly tool	$\text{Ø}16 \times 120$	28331

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