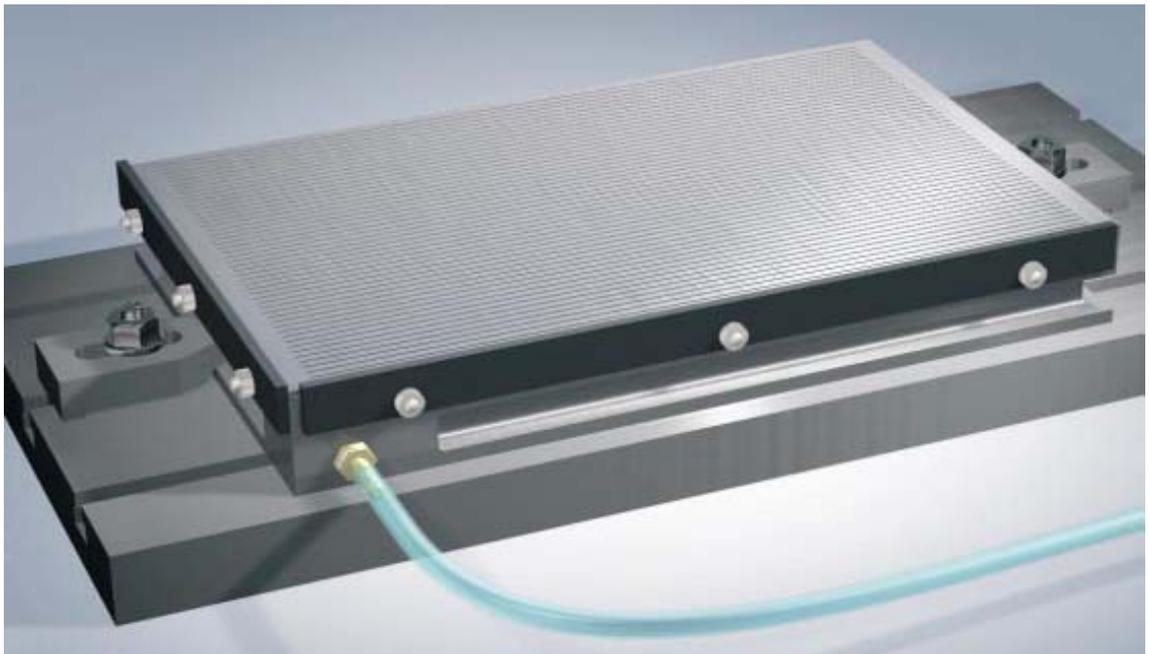


Operating Instructions

Vacuum Clamping Chuck Slot Type





Doc-ID: Witt-7444

Before starting all tasks, read the operating instructions!

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Contents

1	General	6
1.1	Information to these instructions	6
1.2	Other applicable documents	6
1.3	Symbol explanation	7
1.4	Liability Limitation	8
1.5	Copyright protection	8
1.6	Warranty conditions	9
1.7	After-sales service	10
2	Safety	11
2.1	Responsibility of the operating company	11
2.2	Personnel Requirements	12
2.2.1	Qualifications	12
2.2.2	Unauthorized persons	12
2.3	Personal Protective Equipment	13
2.4	Intended use	14
2.5	Special Hazards	15
3	Technical Data	16
4	Design and Function	17
4.1	Brief description	17
4.2	Overview	17
4.3	Scope of delivery	18
5	Transportation, Packaging and Storage	19
5.1	Safety instructions for transportation	19
5.2	Transportation inspection	19
5.3	Packaging	19
5.4	Storage	20
6	Installation and Commissioning	21
6.1	Safety	21
6.2	Installation	22
6.3	Clamping the workpiece	23
6.3.1	Clamping the workpiece with adapter mat ...	23
6.3.2	Clamping the workpiece with detention film	25
6.4	Locking the clamping area	25
6.5	Tasks after use	25



7	Repair	26
7.1	Servicing	26
7.2	Malfunction Table	26
8	Accessories and Spare Parts	27
8.1	Vacu grease.....	27
8.2	Adapter mat, red	28
8.3	Adapter mat, black	29
8.4	Detention film; blue .Fehler! Textmarke nicht definiert.	
9	Index.....	31



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 any 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 workpieces of a complicated shape, 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		kg
Length	340	mm
Width	280	mm
Height	28	mm
Diameter of connection adapters	6	mm

4 Design and Function

4.1 Brief description

The vacuum clamping chuck consists of an aluminium plate, in which narrow longitudinal slots are incorporated in the surface.

The longitudinal slots permit limitation from the operating vacuum, depending on the size of the workpiece.

The vacuum clamping chuck is attached to a machine table and a vacuum pump.

An adapter mat, placed between the longitudinal slots and workpiece, improves the workpiece coefficient of friction and limits the clamping range.

Through perforation of the mat, the clamping range can be clearly defined.

The workpiece, positioned on the adapter mat, is clamped by an operating vacuum so that it can be subsequently machined from 5 sides.

4.2 Overview

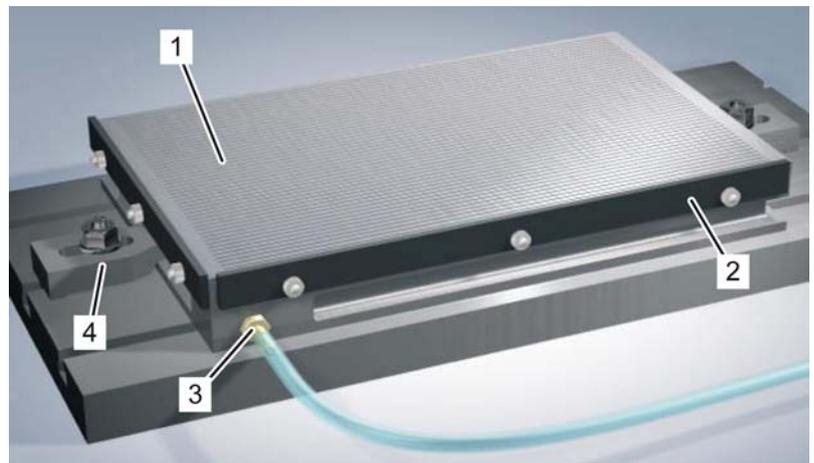


Fig. 1: Overview

- | | | | |
|---|--------------------------------------|---|---------------------|
| 1 | Longitudinal slot (clamping surface) | 3 | Connection adapters |
| 2 | Stop bars | 4 | Clamps |



Design and Function

4.3 Scope of delivery

- 1 x Vacuum clamping chuck
- 1 x Vacuum stopper
- 1 x Rubber adapter mat
- 3 x Stop bars (height adjustable)
- 1 x Vacuum hose with connection for quick release coupling
18/12 (L = 1 m)

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: Machined slot on chuck edge

1. Align the vacuum clamping chuck on the machine table.
2. Use the slots on the chuck edge to mount the vacuum chuck 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. Tighten the locknut.
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 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.

6.3.1 Clamping the workpiece with adapter mat

The adapter mat is placed between the workpiece and clamping surface and serves to improve the coefficient of friction.

Using the adapter mat, geometrically awkward workpieces (e.g. workpieces with recesses) can be clamped.

The slots that are not covered when the workpiece is clamped, must be covered by the adapter mat to prevent vacuum losses.

The adapter mat must be prepared for each different workpiece contour. When using the same workpiece contours, the adapter mat can be used several times.

It can cut into the adapter mat by up to a depth of 1.5 mm, without a vacuum loss occurring. Requirements for the preparation is a level and smooth workpiece surface.

The advantage of the adapter mat is that the coefficient of friction features a good resistance against the feed forces occurring during the machining (→ **accessories**).

Installation and Commissioning

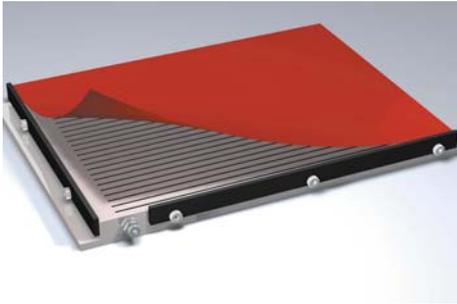


Fig. 4: Place the adapter mat

1. Place the adapter mat on the vacuum chuck.



Fig. 5: Apply the workpiece contours

2. Using the adjustable stop bars, align the workpiece on the adapter mat.
3. Use a pen to trace the workpiece contour on the adapter mat.

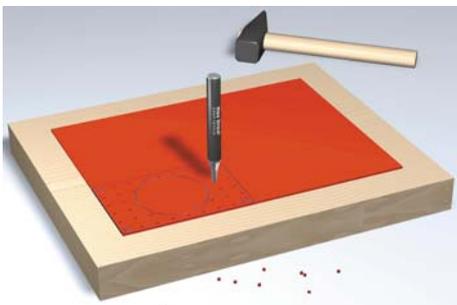


Fig. 6: Pierce the adapter mat

4. Place the adapter mat on a firm base.
5. Use a hole puncher to pierce the adapter mat within the marked workpiece contour. The position of the holes must correspond to the slots in the vacuum plate.



Fig. 7: Clamping the workpiece

6. Replace the workpiece, with the pierced adapter, on the clamping plate.
7. Switch on the vacuum and clamp the workpiece.
→ **Observe the instructions for the vacuum unit.**
8. Check the workpiece to make sure that it sits firmly.

6.3.2 Clamping the workpiece with rubber friction mat

The rubber friction mat (**Order No. 14927**) is thinner than the adapter mat and has a higher coefficient of friction. Thus, the mat features a higher resistance against the feed forces that occur during machining.

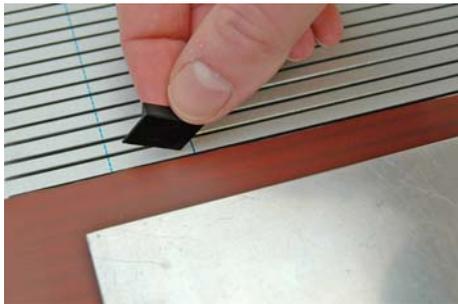
The preparation of the mat is identical to that of the preparation of the adapter mat (→ **Clamping workpiece with adapter mat**).

By always using the same workpiece contours, the mat can be used several times. Requirements for the preparation is a level and smooth workpiece surface.

After use, the mat is removed. The slotted vacuum plate remains free from remaining adhesive (→ **accessories**).

6.4 Limiting the clamping area

If smaller workpieces are to be clamped, or the adapter mat does not fully cover the clamping surface, the clamping area of the clamping surface not utilized can be reduced using the vacuum stopper, to prevent vacuum loss.



1. Place the adapter mat, with workpiece, on the clamping surface of the vacuum clamping chuck.
2. Insert the vacuum stopper in the next available slot adjacent to the adapter mat, inside the two blue lines.

The clamping areas that are behind the vacuum stopper are unaffected from the operating vacuum.

Fig. 8: Limiting the clamping area

6.5 Tasks after use

1. After machining, before removal of the workpiece, the vacuum 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 chuck.

Repair

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 clamping chuck is maintenance-free. The vacuum clamping 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 retainers 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

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 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

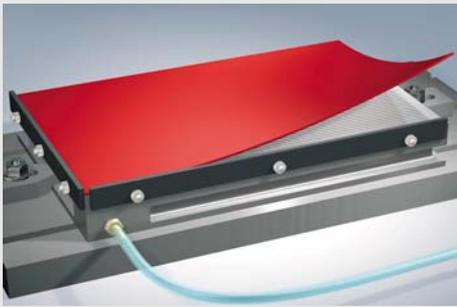
Accessories and Spare Parts

8.2 Adapter mat, red

The red adapter mat is made from polyurethane (PU).

It has a higher coefficient of friction than the black adapter mat; however, like the blue rubber foil, it is too soft for face milling.

Figure



NOTE!

The height tolerance of the adapter mat is in a range of ± 0.3 mm (DIN 7715)

Order No.	Dimensions [mm]
00005	150 x 100 x 3
00006	200 x 100 x 3
00007	250 x 150 x 3
00008	200 x 200 x 3
00609	200 x 500 x 3
00564	200 x 600 x 3
00009	300 x 150 x 3
00010	350 x 150 x 3
00011	400 x 200 x 3
00013	350 x 250 x 3
00014	300 x 300 x 3
00015	400 x 250 x 3
00016	400 x 300 x 3
00017	400 x 400 x 3
00415	500 x 300 x 3
00164	500 x 500 x 3
00418	500 x 1000 x 3
00437	600 x 300 x 3
00414	600 x 400 x 3
00409	1000 x 1000 x 3
00682	1000 x 2000 x 3
00732	1000 x 2000 x 1
00733	1000 x 2000 x 1.5

8.3 Adapter mat, black

The black adapter mat is made from Elastomer.

These adapter mats can be face milled and enable substantially greater plane parallelism.

Figure	Order No.	Dimensions [mm]
 <p data-bbox="260 898 300 969">i</p> <p data-bbox="363 898 611 1066">NOTE! The height tolerance of the adapter mat is in a range of +/- 0.3 mm (DIN 7715)</p>	00845	100 x 150 x 3
	00846	100 x 200 x 3
	00847	150 x 250 x 3
	00848	200 x 200 x 3
	00849	200 x 500 x 3
	00850	200 x 600 x 3
	00851	150 x 300 x 3
	00825	200 x 400 x 3
	00852	250x 350x 3
	00853	300 x 300 x 3
	00796	250 x 400 x 3
	00854	300 x 400 x 3
	00855	400 x 400 x 3
	00856	400 x 500 x 3
	00857	500 x 500 x 3
	00858	300 x 600 x 3
	00791	400 x 600 x 3
	00859	500 x 1000 x 3
	00860	1000 x 1000 x 3
	00861	1000 x 2000 x 3

Accessories and Spare Parts**8.4 Friction mat, blue**

The blue mat has the highest coefficient of friction.
It is available on a roll and must be cut as required.

Figure	Order No.	Dimensions [mm]
	14927	2000 x 400 x 1

9 Index

A		
Accessories	26	
Adapter mat	27	
After-sales service	9	
B		
Brief description	16	
Briefing	11	
C		
Clamping the workpiece	22	
with adapter mat	22	
with detention film	24	
Contact person	9	
Contamination	15	
Copyright protection	7	
D		
Design	16	
Detention film	29	
H		
Hazards	14	
I		
Installation	21	
Intended use	13	
L		
Liability	7	
M		
Malfunction Table	25	
O		
Overview	16	
P		
Packaging	18	
Personnel		
requirements	11	
Pneumatics	14	
Protective equipment	12	
Installation	20	
Protective gloves	12	
Safety glasses	12	
Safety shoes	12	
R		
Repair	25	
S		
Safety		
general	10	
Scope of delivery	17	
Service	9	
Servicing	25	
Spare parts	26	
Specialists	11	
Storage	18, 19	
Surfaces, hot	15	
Symbols		
in the instructions	6	
T		
Technical Data	15	
Transportation	18	
Transportation inspection	18	
V		
Vacu grease	26	
W		
Warranty	8	