

# Spännblock

**Clamping at an angle  
to  $\mu$ -accuracy**

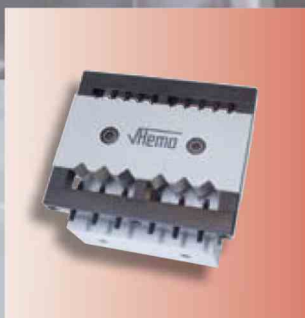
**Produce faster  
by 30%!**



**hemo Clamping Block  
Standard P**



**hemo maxi  
Clamping Square**



**hemo  
Multiple Prism**

**hemo**  
SWISS  
WERKZEUGBAU

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# hemo Standard Clamping Block P

With the hemo Clamping Block, you will manufacture high-precision workpieces to hair's breadth angle accuracy – and this about 30% more quickly, more easily and more accurately.

The hemo Clamping Block P offers maximum repetitive accuracy while the machine has to be set up only once, even when it comes to machining workpieces with the tightest of tolerances on surface grinding machines, jig grinding machines, jig drilling machines, EDM centres, measuring stations.

## Technical data

Angle accuracy <b>Quality grade 1</b>	on entire length × height max. deviation <b>1 μ</b>
Angle accuracy <b>Quality grade 2</b>	on entire length × height max. deviation <b>2 μ</b>
Clamping range	60mm
Dimensions	<b>120×60×134mm</b>
Distance from extendable rotatable cylinders to upper edge	38.5 mm
Net weight	8,7 kg
Gross weight (with wooden box)	10,8 kg



Every hemo Clamping Block P is supplied in a wooden box (picture: equipped with base plate).



Extendable rotatable cylinders

Clamping block

Collet chuck

The block is equipped with extendable rotatable cylinders to support workpieces and spacers. The boreholes have been ground exactly parallel to the base surface. The Clamping Block, which is made of special dimensionally stable steel, fully hardened, approx. 58 HRC, has been carefully aged and microfinished.

No workpiece movement on clamping. The movable jaws also enable non-parallel parts to be clamped.



With the **hemo Base Plate**, the hemo Clamping Block P can be used on any slot table. The plate is microfinished on both sides – so angle accuracy is preserved.

An exchangeable, patented **special jaw** is supplied for the accurate positioning of small parts.



And this is what practice looks like.



1. Parallel grinding of the workpiece on the magnetic clamping plate.



2. Attaching the hemo Clamping Block P to the magnetic plate.

3. Turning out the support cylinders on the hemo Clamping Block P to support the workpieces (clamping height: 38.5mm)

Place low workpieces on support cylinders and parallel parts.

Place tall workpieces on the hemo Clamping Block P without support cylinders.



4. Clamping of workpiece with the hemo collet chuck, and grinding of the first angle.

To clamp long workpieces, the hemo Clamping Block P is turned around 180°.



5. Positioning of ground long workpiece side against stop rail, clamping, and grinding of the second angle.

Produce faster  
by 30%!

Faster and absolutely precise clamping with hemo Clamping Block will save you time and money.



The measurement of workpieces when clamped saves time and provides safety for high-precision cross-cutting.



For the purpose of cross-cutting punches and ejectors, the rear of the hemo Clamping Block P is equipped with prisms for clamping diameters of 2-18mm. Angle accuracy inside the entire height amounts to 0.001mm.



The **hemo Special Prisms** serve to increase the clamping diameter to 50 or 80mm.



With the **hemo Sine Rule**, gauge block settings can be used to set high-precision angles. This is guaranteed by the two jig-ground support cylinders.

The adjustable end-stop allows for precise repetitive accuracy and identical positioning for multiple part machining.



# hemo maxi Clamping Square

The hemo maxi Clamping Square has been designed to hold big workpieces.

The hemo maxi Clamping Square is suitable for rational and precise clamping on surface grinding machines, jig grinding machines, jig drilling machines, EDM centres, measuring stations

## Technical data

Angle accuracy	max. deviation 2 $\mu$ on entire length $\times$ height
Dimensions	<b>250<math>\times</math>160<math>\times</math>295mm</b>
Max. clamping range	<b>135mm</b>
Distance from extendable rotatable cylinders to upper edge	48mm
Net weight	42kg



The counterholder makes it easier to position heavy workpieces.



Heavy and big workpieces can be safely and effortlessly clamped to  $\mu$ -accuracy.



The square is equipped with extendable rotatable cylinders to support workpieces and spacers. The boreholes have been ground exactly parallel to the base surface. The cylinder distance is exactly 100 $\times$ 100 $\times$ 200mm so that any desired angle can be set with the help of gauge blocks (sine function).



The practical suspension device facilitates the transport of the Clamping Block

# hemo Multiple Prism



hemo Multiple Prism with horizontally placed substructure as punch support.  
Clamping range up to a length of 120mm.

The hemo Multiple Prism is suitable for the rational multiple clamping of any standard ejectors, ejector sleeves, as well as round and angled punches.

## Technical data

### Dimensions

#### Multiple Prism

of hardened steel

80/150×25×180mm

#### Weight

4.0kg

#### Substructure

120×60×146mm

#### Weight

4.8kg

#### Spacer

ø60×10mm

#### Weight

0.4kg

#### Clamping range, side A

10-fold: ø 0-8mm; head ø up to 14mm

#### Clamping range, side B

6-fold: ø 3-16mm; head ø up to 22mm

#### or

ø 3-20mm without head



hemo Multiple Prism with vertically placed substructure and workpiece support.  
Clamping range up to a length of 180mm.



hemo Multiple Prism with two vertically placed substructures and workpiece support.  
Clamping range: up to a length of 300mm.



Measurement of a workpiece without dechucking.



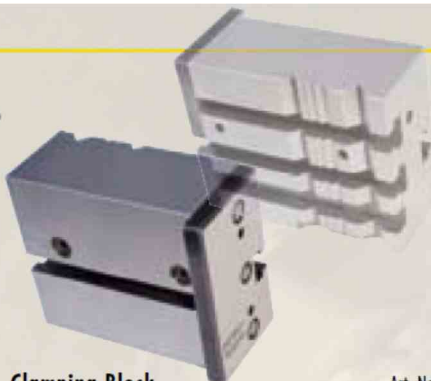
hemo Multiple Prism with horizontally placed substructure (upper part turned).

Needless to say, the hemo Multiple Prism can also be fitted to a hemo Clamping Block P.

## hemo Clamping Block P



**hemo Clamping Block P** Art. No.  
complete with collet chuck, tenon block and  
clamping device for small parts (without base plate) 101412



**Clamping Block** Art.-No.  
101415



**Standard Collet Chuck P** Art.-No.  
101416

**hemo Clamping Block P** Art.-No.  
complete with collet chuck, tenon block and  
clamping device for small parts and base plate 101422

## hemo maxi Clamping Square



**hemo maxi Clamping Square** Art.-No.  
complete with collet chuck and counterholder 101409

### Transport Device



Art.-No.  
101410

### Collet Chuck maxi

Art.-No.  
101411

### Counterholder maxi

Art.-No.  
101423

## Accessories



**Clamping Prism**  
ø max. 50 mm

hemo Prisms are suitable for the  
hemo Clamping Block P and the  
hemo maxi Clamping Square.



Art.-No.  
101418

**Clamping Prism**  
ø max. 80 mm



Art.-No.  
101419

### Sine Rule

suitable for hemo Clamping Block P

Art.-No.  
101417

## hemo Multiple Prism



**hemo Multiple Prism** Art.-No.  
without substructure 101420



**Substructure** Art.-No.  
for Multiple Prism 101421



**Grundplatte zu Spannblock P** Art.-Nr.  
101413



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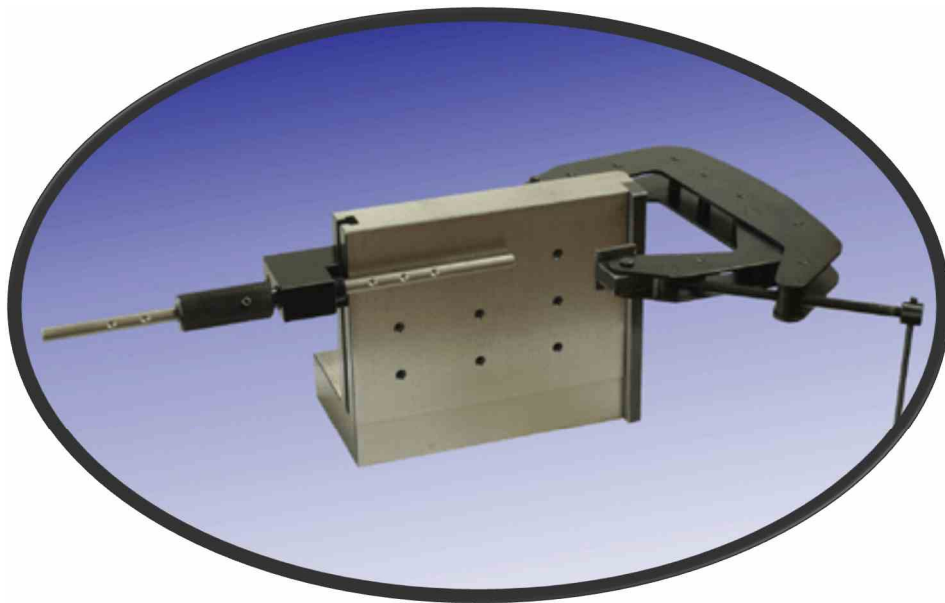


# Anteckningar



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