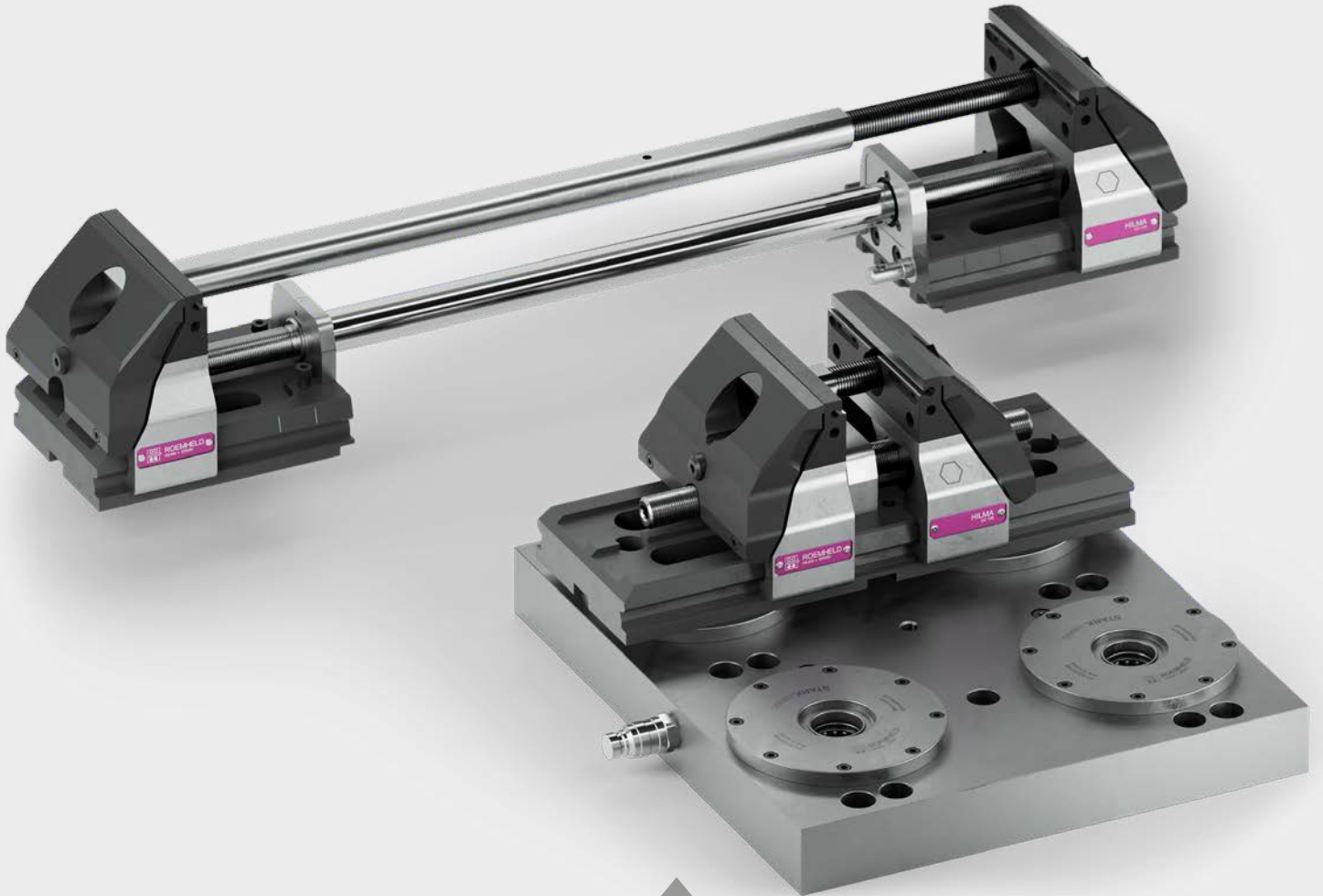




**ROEMHELD**  
HILMA ■ STARK



## HILMA.UC

### 5-axis clamping system

Concentric, modular, precise

Jaw width 125 mm



**ROEMHELD**  
HILMA ■ STARK



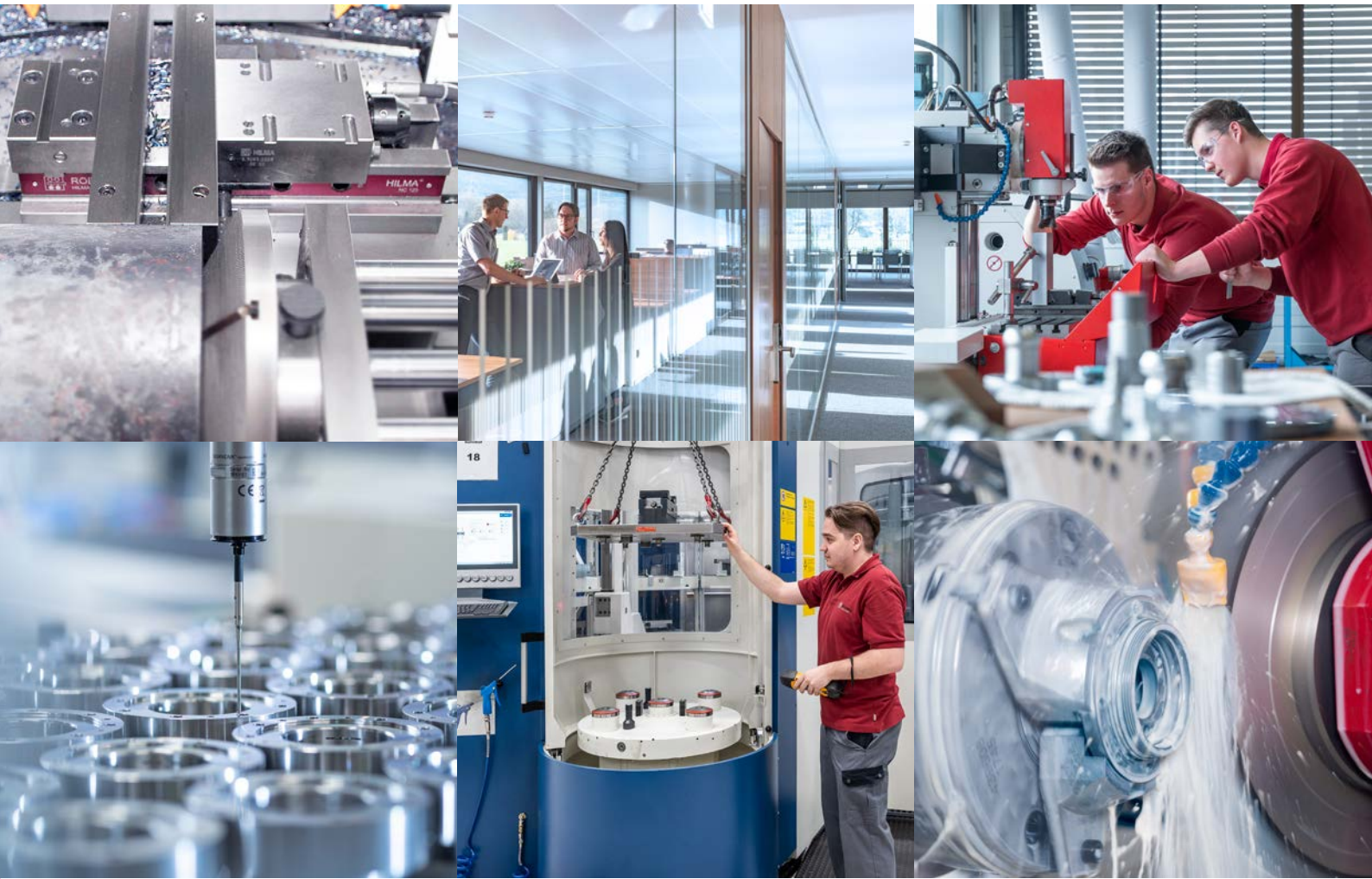
# STARK INNOVATIVE PROFICIENT INDIVIDUAL SAFE

The high-tech company STARK Spannsysteme was established in 1977 in Rankweil, Austria. It manufactures zero point clamping systems and vises of the highest quality and precision for international clients in the automotive, aviation and medical industries, for example.

STARK Spannsysteme products are a byword for minimal set-up times, faster production and high flexibility.

HILMA vises can be complemented and combined perfectly with STARK zero point clamping systems.





AUTOMOTIVE



AVIATION



MACHINE AND TOOL  
CONSTRUCTION



MEDICINE

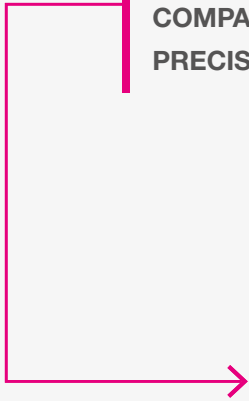
# FOCUS ON INDUSTRIES & MARKETS.

Every customer has specific requirements. Our established and extensive industry expertise allows us to offer you the best solutions, services and products for sustainable and efficient use in your market.

# HILMA.UC 125

**UNIVERSAL**  
**STABLE**  
**COMPACT**  
**PRECISE**

modular system enables versatile clamping options  
no deflection thanks to closed force flow  
reduced design ensures optimum accessibility  
true to position due to pull-down mechanism



HILMA.UC



HILMA.MCP



HILMA.SCS



HILMA.KNC



HILMA.SCT



HILMA.NC



HILMA.TS Vector



HILMA.DS



HILMA.TS TriStar



HILMA.ASE



HILMA.ASH





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# HILMA.UC

## 5-axis clamping system

Pull-down mechanism

The clamping force is applied to the workpiece via the outer edges of the clamping claws above the workpiece stop without touching it directly

Extensive range of clamping jaws for different clamping tasks

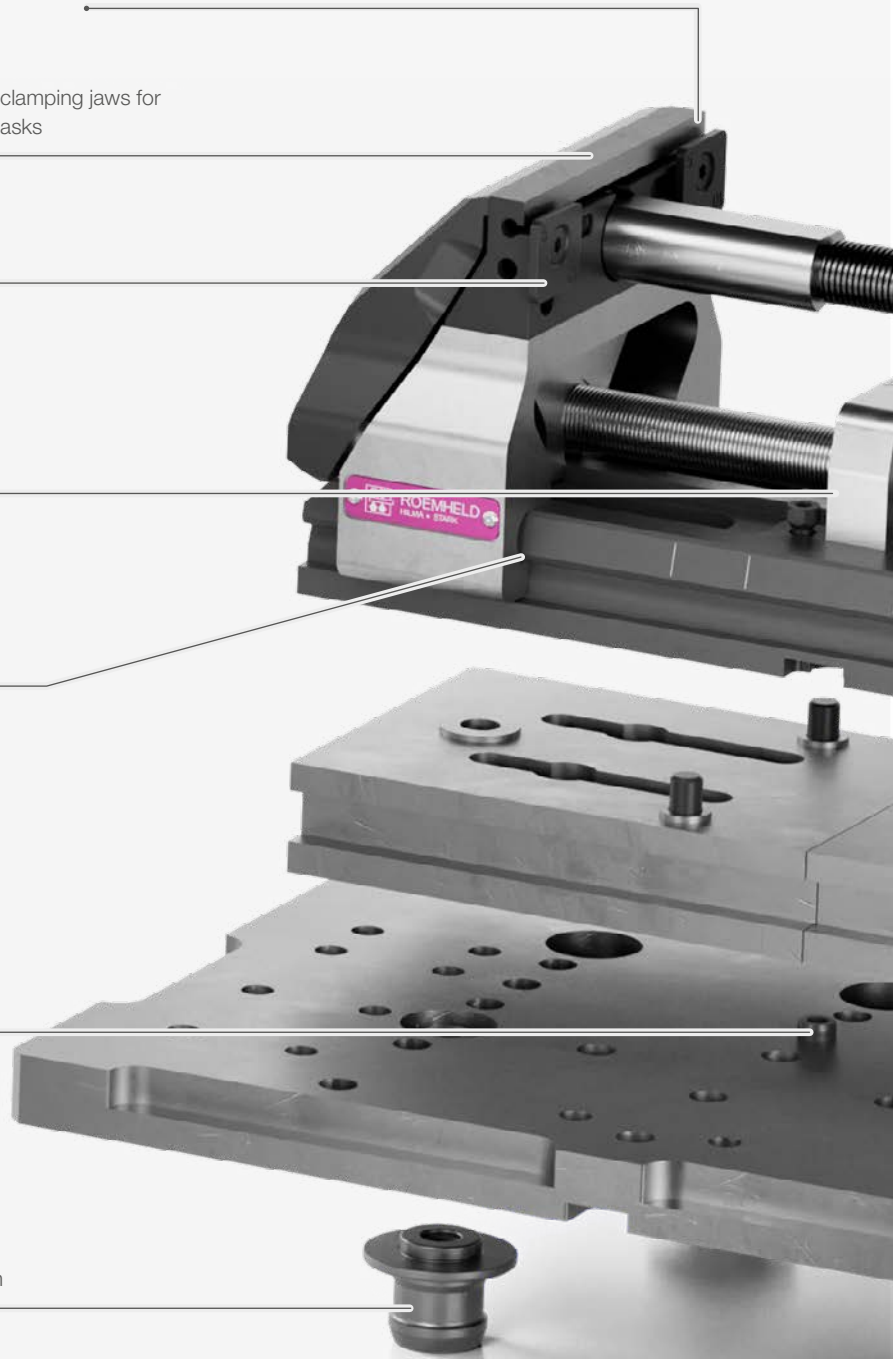
Support bars for different clamping depths

The centre bearing holds the workpiece precisely in the centre with repetitive accuracy

Wide guideways for the clamping elements without air gap and without mechanical load

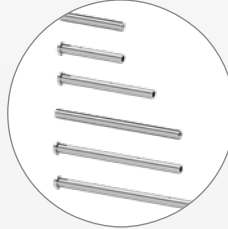
Locating pin for positioning

Retractable nipple for STARK zero point clamping system





Tension spindles and clamping nuts for jaw openings 0-200 mm included in the standard scope of delivery



Accessories for extended jaw openings up to 600 mm

The mechanical actuation takes place via the self-cleaning tension spindle with fine thread

Icon for operating side

The self-cleaning adjustment spindle is not mechanically loaded - it is only used for positioning

Raiser for optimised accessibility

Adapter plates for more flexibility

Zero point clamping system bore holes for retractable nipple as standard version in the base, in raiser and in adapter plates



MAXIMUM FLEXIBILITY

# The HILMA.UC machine vise

The clamping system **HILMA.UC** is suitable for numerous clamping tasks and is used for machining dimensionally stable workpieces in single or multiple clamping systems.

Small workpieces as well as large plates can be clamped and machined without large interference contours. Even when production requirements change, there is no need to invest in new clamping devices.

- For 3-, 4- or 5-axis machining centres
- Milling machines and milling/turning centres

The concentric clamping device **HILMA.UC** can be easily adapted to different

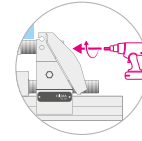
workpiece geometries and is suitable for series production as well as for individual production.

**Mechanical operation**

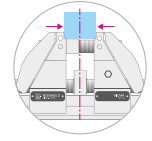
- via spindle
- Spindle applies a pulling force of up to 52 kN (120 Nm)

**Concentric clamping**

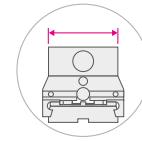
- the centre bearing holds the workpiece precisely in the centre with repetitive accuracy



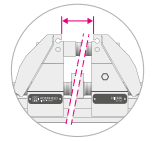
**Operation**  
mechanical



**Clamping principle**  
concentric



**Jaw width**  
125 mm

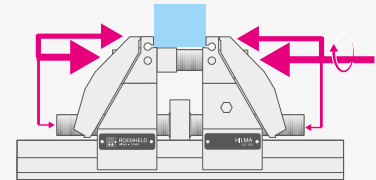


**Jaw opening**  
0 - 600 mm



**High stability**

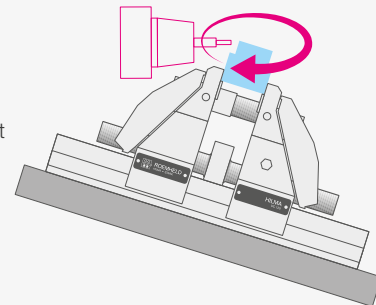
- Closed force flow - no bending force effect in the base
- + No deflection
- Separation of adjusting and tension spindle
- + Optimum force flow
- Pull-down clamping jaws
- + Active workpiece pull-down



**Optimum accessibility**

- Compact design
- + good accessibility - optimum tool length can be used due to smallest interference contour
- Raiser as accessory
- + improved accessibility for special clamping tasks

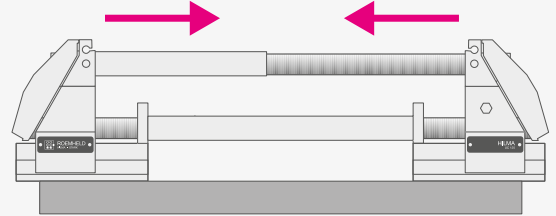
▶ more on page 15





### Concentric clamping system

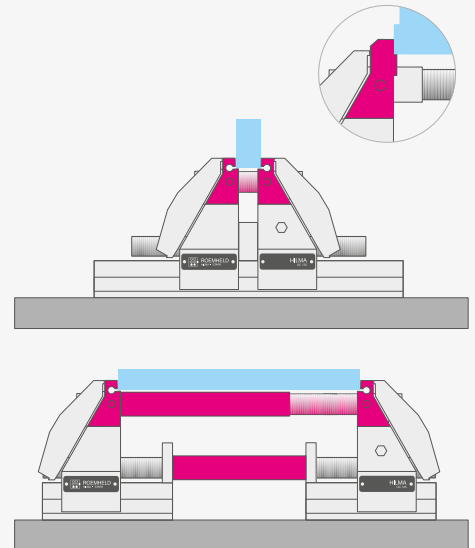
- Centre clamp, optimal for 5-axis applications
- + precise with repetitive accuracy
- + split mounting option



### Flexible jaw opening & range of clamping jaws

- Standard jaw opening from 0 - 200mm, extension sets for extended jaw opening up to 600mm
- Conclusive range of clamping jaws for workpieces in all shapes and surfaces from round to square, small to large and smooth or uneven
- + can be adapted to differently-sized workpiece geometries in just a few steps
- + variable clamping depths
- + optimised accessibility

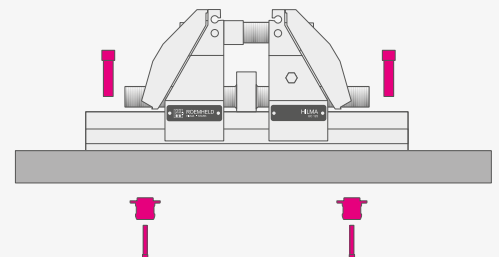
- ▶ more about the extension sets on page 13
- ▶ more about the extension sets on page 14



### Individual fastening

- fastening with sliding block on T-slot table
- fastening via clamping claws
- fastening from above through the base by means of screws
- quick change by means of STARK retractable nipple directly or via adapter plate in the STARK zero point clamping system
- thread adapters for alternative zero point clamping system manufacturers
- standard fast closing plates available

- ▶ more about fastening on page 20

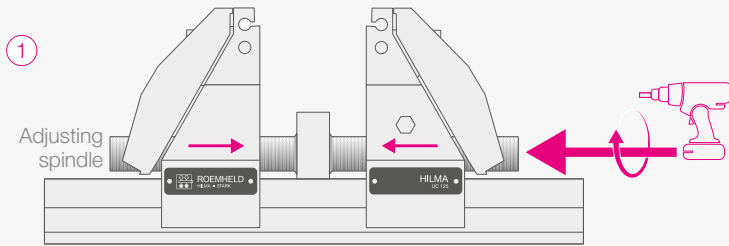


CONCENTRIC CLAMPING DEVICE WITH PULL-DOWN MECHANISM

Operating principle **HILMA.UC**

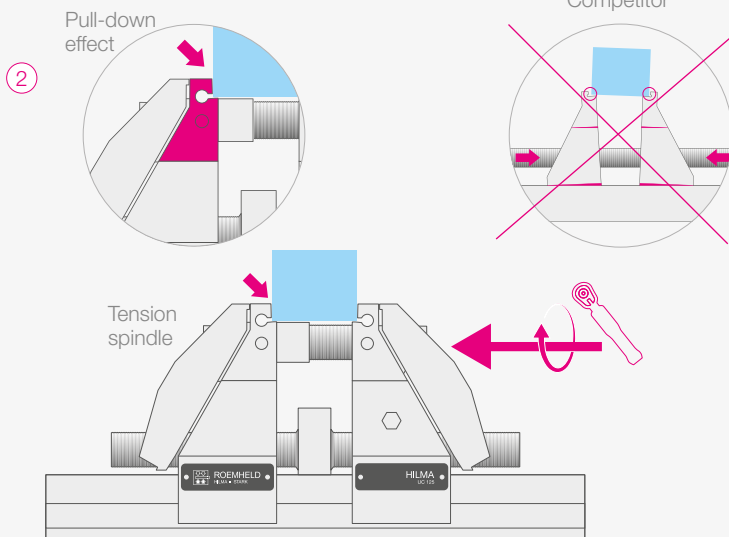
**INFO**

Clamping principle - closed force flow



- ① The clamping range is preset until both clamping jaws are in contact with the workpiece without building up clamping force.

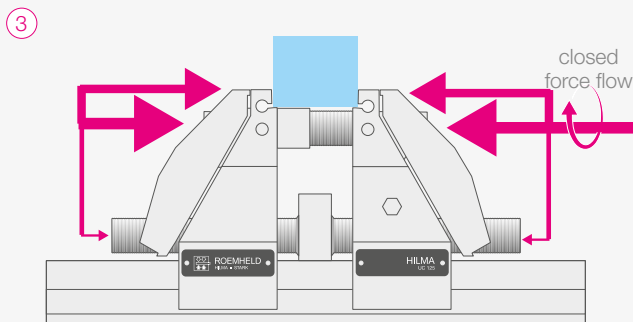
By turning the adjustment spindle clockwise, both adjustment elements move to the centre.



- ② The tension spindle is mounted hand-tight before the clamping force is applied by turning it clockwise using a torque wrench.

The force on the clamping jaws above the workpiece stop is introduced into the workpiece via the outer edges of the clamping claws.

The clamping force develops proportionally to the torque.



- ③ Most of the pulling force is applied directly to the workpiece. The adjustment spindles serve as counter bearings.

In the process, the adjustment elements are clamped to the base plate and the system is completely mechanically locked.

Due to the closed power flow from tension spindle to adjustment spindle, the base remains almost without bending force being applied and tilting of the adjustment elements is avoided.



**HILMA.UC 125**

The **HILMA.UC 125** is a universal 5-axis concentric clamp with mechanical actuation and a jaw width of 125 mm.

The clamping nuts and tension spindles included in the standard scope of delivery allow a maximum clamping range of 200 mm, which can be extended to 600 mm with extension sets. The concentric clamp is supplied with pull-down clamping jaws for clamping pre-machined and smooth surfaces. Retractable nipple bore holes for zero point clamping systems are prepared in the base for fastening.

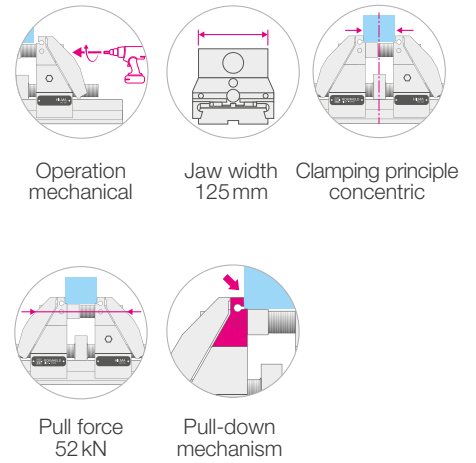
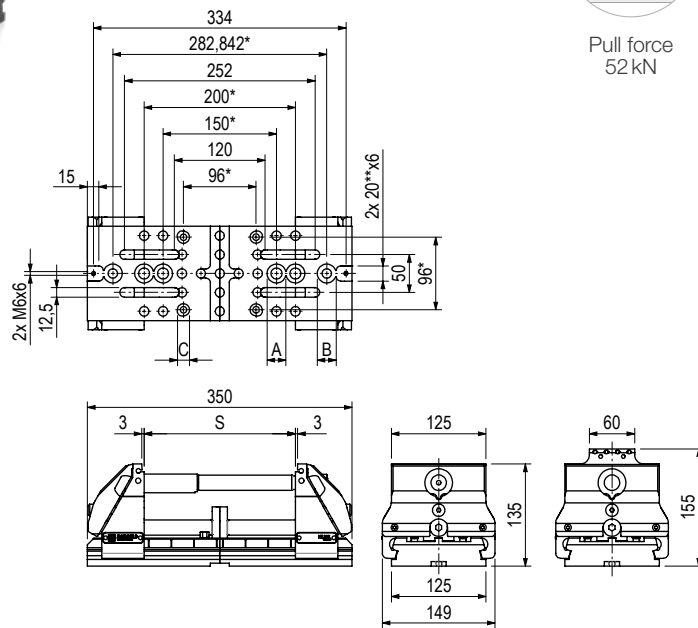


Figure: 970230101  
Standard scope of delivery:  
Machine vise incl. pull-down clamping jaws,  
clamping nut short and long,  
tension spindle short and long



Z\_970230101\_03

\* Tolerance ± 0.02, \*\* tolerance + 0.02  
All dimensions in [mm]

Series		HILMA.UC 125
Operation		mechanical
Base length <sup>1)</sup>	[mm]	350
Pull force	[kN]	52
Clamping principle		concentric
Clamping range S <sup>2)</sup>	[mm]	0 - 200 (max. 600)
Retractable nipple bore hole A	[mm]	4x Ø 25 H7 x 6; 4x M16x1.5 x 18
Retractable nipple bore hole gauge	[mm]	200
Bore hole for fastening from above B	[pc]	2x Ø 25 H7 x 6; 2x flat sink for M12 from above
96 x 96 retractable nipple bore hole gauge C	[mm]	4x Ø 16 ± 0.01 x 6; 4x M10 x 10
Weight with pull-down clamping jaws	[kg]	20
Order no.		970230101

<sup>1)</sup> Base part length without extension with a clamping range of max. 200mm  
<sup>2)</sup> Extension sets for clamping ranges up to 400 mm and up to 600 mm available as accessories ▶ more on page 12 & 13  
Subject to technical changes, all data without guarantee



EXTENSION SETS FOR MAXIMUM JAW OPENINGS

# Flexible clamping widths

The concentric clamping system can be divided in the middle and extended. The clamping range can be extended up to 600 mm by using different tension spindle/clamping nut combinations.

A closed force flow is created between the tension spindle, adjustment element and clamping jaw, thus allowing the modular design. The base plate remains without a bending force being applied.

The extended clamping system can be mounted directly on the machine table, raisers or adapter plates.

## Standard jaw opening 0 - 200mm

Four elements for adjusting the clamping range are included in the standard scope of delivery.

- Tension spindle, short
- Tension spindle, long
- Clamping device, short
- Clamping nut, long



The following clamping ranges can be combined

**0 - 50 mm**

Short tension spindle and short clamping nut



**48 - 104 mm**

Short tension spindle and long clamping nut



**100 - 200 mm**

Long tension spindle and long clamping nut



## Extension set 400 for extended clamping range

The clamping range can be extended to a maximum of 400mm with the extension set 400. The minimum clamping range is increased to min. 196mm by the extension on the adjustment spindle.

The scope of delivery includes two differently-sized clamping nuts and an extension for the adjustment spindle.



Order no.	Extension set 400
	Clamping nut 300
970235002	Clamping nut 400
	Extension for adjustment spindle 200

The following clamping ranges can be realised

### 196-300 mm

Long tension spindle  
(standard scope of delivery)  
Clamping nut 300mm  
Adjustment spindle 200mm



### 296-400 mm

Long tension spindle  
(standard scope of delivery)  
Clamping nut 400mm  
Adjustment spindle 200mm



## Extension set 600 for maximum clamping range

The clamping range can be extended to a maximum of 600mm with the extension set 600. The minimum clamping range is increased to min. 396mm by the extension on the adjustment spindle.

The scope of delivery includes two differently-sized clamping nuts and an extension for the adjustment spindle.



Order no.	Extension set 600
	Clamping nut 500
970235003	Clamping nut 600
	Extension for adjustment spindle 400

The following clamping ranges can be realised

### 396-500 mm

Long tension spindle (standard  
scope of delivery)  
Clamping nut 500mm  
Adjustment spindle 400mm



### 496-600 mm

Long tension spindle (standard  
scope of delivery)  
Clamping nut 600mm  
Adjustment spindle 400mm





THE OPTIMUM JAW FOR EVERY WORKPIECE

# Extensive range of clamping jaws

High clamping quality



High clamping safety

The jaws used have a major influence on the machining result. The range of clamping jaws enables reliable blank and finished part clamping in all shapes from round to square and from small to large.

For smooth clamping jaws and clamping jaws with GripPin, support bars are required as workpiece stops.

▶ more about support bars on page 18



## Finished parts

Clamping jaw 125mm & 60mm, smooth  
Page 16



## Blanks

Clamping jaw with GripPins 125mm & 60mm  
Page 16 & 17



## Three-point clamping

Clamping jaw with round clamping bolts  
Page 19



Finished part, smooth surface

Pull-down clamping jaws, page 16

Figure: 970230101  
HILMA.UC with standard pull-down clamping jaws



Round parts, large

Clamping jaw with round clamping bolts  
Page 19



Cylindrical workpieces

Prism jaw  
Page 17



Blank with special shape

Soft clamping jaw, with specific clamping contour  
Page 19

### Pull-down clamping jaws 125 mm, hardened

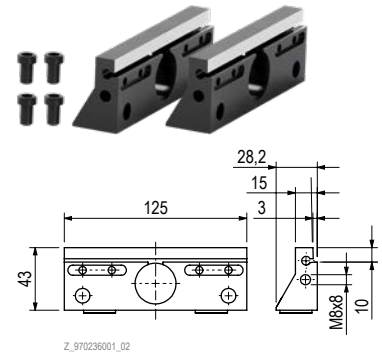
Suitable for clamping pre-machined or smooth surfaces (second side). The bending element of the jaw clamps the workpiece with pull-down and presses it onto the support surface with repetitive accuracy.

Support bars are optional for the clamping jaw. ▶ Page 18

Pull-down clamping jaws are included in the HILMA.UC standard scope of delivery.

Order no.	Clamping range	Supply
970236001	6 - 206 mm*	2 pcs. clamping jaws 4 pcs. fixing screws

\*Standard clamping range without extension set



Z\_970236001\_02

All dimensions in [mm]  
Fastening material included in scope of delivery

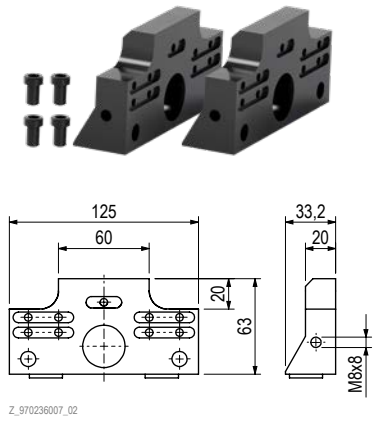
### Clamping jaws 60 mm, smooth, hardened

For clamping pre-machined or smooth surfaces (second side). The narrow version of the clamping jaw has a clamping width of 60 mm and serves to optimise accessibility for narrow workpieces.

The maximum clamping depth is 28 mm. Support bars are required for the clamping jaw. ▶ Page 18

Order no.	Clamping range	Supply
970236007	0 - 190 mm*	2 pcs. clamping jaws 4 pcs. fixing screws

\*Standard clamping range without extension set



Z\_970236007\_02

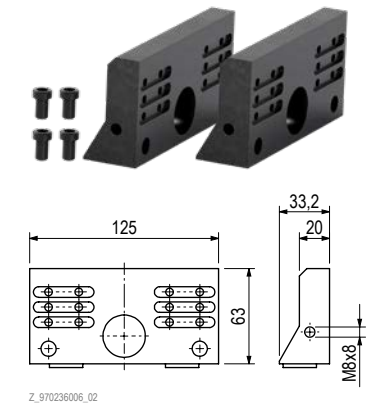
All dimensions in [mm]  
Fastening material included in scope of delivery

### Clamping jaws 125 mm, smooth, hardened

For clamping pre-machined or smooth surfaces (second side). The clamping jaw has a clamping width of 125 mm, the maximum clamping depth is 28 mm. Support bars are required for the clamping jaw. ▶ Page 18

Order no.	Clamping range	Supply
970236006	0 - 190 mm*	2 pcs. clamping jaws 4 pcs. fixing screws

\*Standard clamping range without extension set



Z\_970236006\_02

All dimensions in [mm]  
Fastening material included in scope of delivery

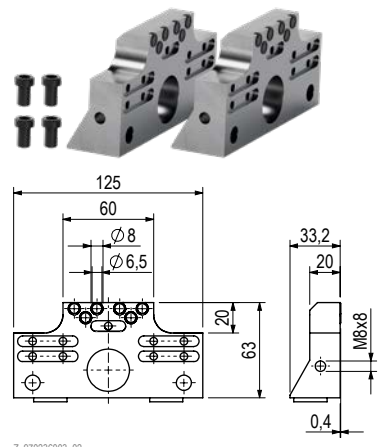
### Clamping jaws with GripPins 60 mm

For secure clamping of uneven surfaces such as saw cuts, blanks and cast parts. The narrow version of the clamping jaw with GripPins has a clamping width of 60 mm and serves to optimise accessibility for narrow workpieces.

Attention: Marks of the pins on the workpiece. The maximum clamping depth is 28 mm. Support bars are required for the clamping jaw. ▶ Page 18

Order no.	Clamping range	Supply
970236003	0 - 190 mm*	2 pcs. clamping jaws incl. 2 x 6 pcs. GripPins 4 pcs. fixing screws

\*Standard clamping range without extension set



Z\_970236003\_02

All dimensions in [mm]  
Fastening material included in scope of delivery



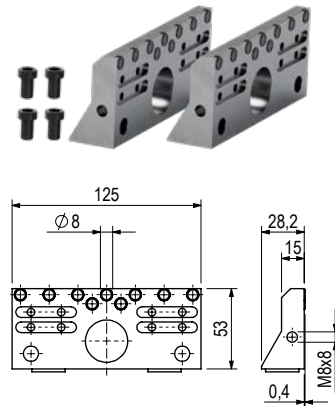
### Clamping jaws with GripPins 125 mm

For secure clamping of uneven surfaces such as saw cuts, blanks and cast parts. The clamping jaw has a clamping width of 125mm, the maximum clamping depth is 28mm. Attention: Marks of the pins on the workpiece.

Support bars are required for the clamping jaw. ▶ Page 18

Order no.	Clamping range	Supply
970236002	0 - 200mm*	2 pcs. clamping jaws incl. 2 x 9 pcs. GripPins 4 pcs. fixing screws

\*Standard clamping range without extension set

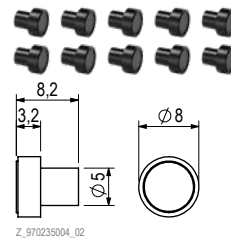


All dimensions in [mm]  
Fastening material included in scope of delivery

### GripPins, hardened

If the pins are worn, they can be replaced in the existing clamping jaw.  
Attention: Marks of the pins on the workpiece.

Order no.	Supply
970235004	10 pcs. spare pins D7



All dimensions in [mm]  
Fastening material included in scope of delivery

#### INFO

#### Change GripPins

With the help of a punch, worn pins can be knocked out of the jaw and new ones inserted.

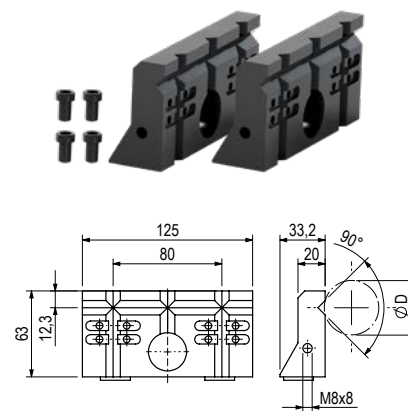


### Prism jaws, hardened

For clamping cylindrical workpieces with a diameter of 8-40mm.  
Workpieces can be clamped horizontally or vertically. With vertical clamping it is possible to place two workpieces in the outer prisms at the same time.  
Support bars are optional for the clamping jaw. ▶ Page 18

Order no.	Clamping range	Supply
970236004	8 - 40mm*	2 pcs. Prism jaws 4 pcs. fixing screws

\*Standard clamping range without extension set

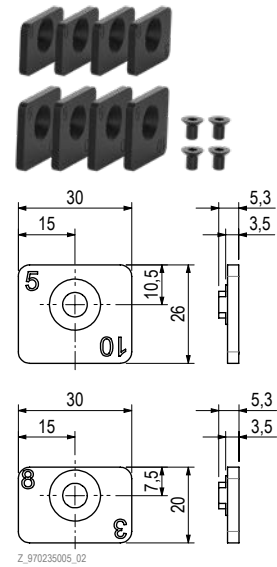


All dimensions in [mm]  
Fastening material included in scope of delivery

### Set of support bars 3.5 mm, hardened

Support bars with 3.5 mm thickness. A support surface for the workpiece is created by attaching the support bars. The clamping depth varies depending on the positioning of the support bar and the selection of the fastening step. The support bars are suitable for all clamping jaws except soft clamping jaw (970236008) and clamping jaw with round clamping bolt (970236005).

Order no.	Clamping range	Supply
970235005	min. 7 mm	4× support bars 3.5 mm for 3 mm/8 mm height of supports 4× support bars 3.5 mm for 5 mm/10 mm height of supports 4 pcs. fixing screws

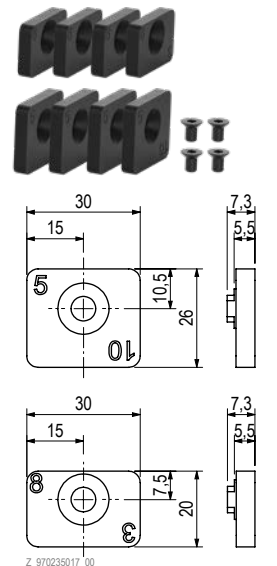


All dimensions in [mm]  
Fastening material included in scope of delivery

### Set of support bars 5.5 mm, hardened

Support bars with 5.5 mm thickness. A support surface for the workpiece is created by attaching the support bars. The clamping depth varies depending on the positioning of the support bar and the selection of the fastening step. The support bars are suitable for all clamping jaws except soft clamping jaw (970236008) and clamping jaw with round clamping bolt (970236005).

Order no.	Clamping range	Supply
970235017	min. 11 mm	4× support bars 5.5 mm for 3 mm/8 mm height of supports 4× support bars 5.5 mm for 5 mm/10 mm height of supports 4 pcs. fixing screws



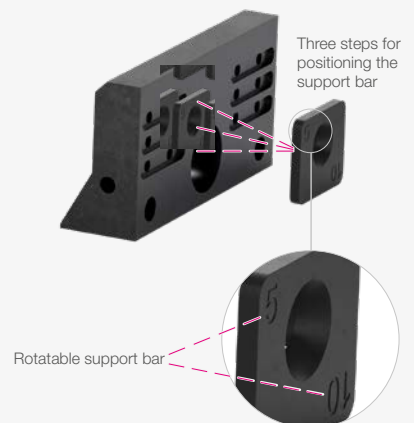
All dimensions in [mm]  
Fastening material included in scope of delivery

#### INFO

#### Support bar application

The support bar creates a workpiece stop and at the same time determines the clamping depth for the workpiece. According to the desired clamping depth, the support bar can be aligned and inserted into the matching slot of the clamping jaw.

Support bar	Clamping depth 1st step	Clamping depth 2nd step	Clamping depth 3rd step
3/8 mm	3 mm	13 mm	23 mm
	8 mm	18 mm	28 mm
5/10 mm	5 mm	15 mm	25 mm
	0 mm	10 mm	20 mm

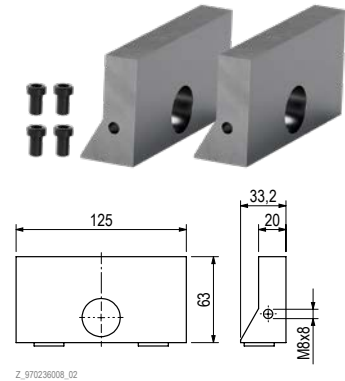


## Soft clamping jaws

Soft jaw for customer insertion of workpiece-specific clamping contours.

Order no.	Clamping range	Supply
970236008	0 - 190mm*	2 pcs. clamping jaws 4 pcs. fixing screws

\*Standard clamping range without extension set



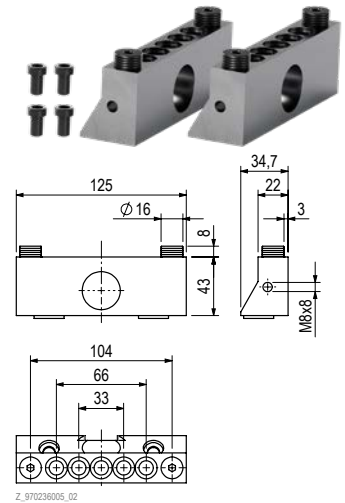
All dimensions in [mm]  
Fastening material included in scope of delivery

## Clamping jaws with round clamping bolts

For vertical clamping of cylindrical workpieces with a diameter of 30 bis 200 mm. The diameter can be flexibly adjusted by repositioning the inserts. Three- and four-point clamping can be realised. Attention: Clamping marks on the workpiece possible.

Order no.	Clamping range	Supply
970236005	30 - 200mm*	2 pcs. clamping jaws incl. 4 pcs. round clamping bolt 4 pcs. fixing screws

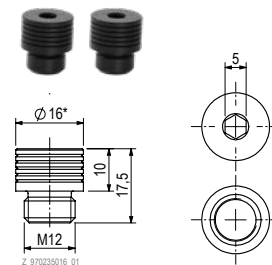
\*Standard clamping range without extension set



## Round clamping bolts

If the round clamping bolts are worn, they can be replaced in the existing clamping jaw. Attention: Marks on the workpiece.

Order no.	Supply
970235016	2 pcs. round clamping bolts

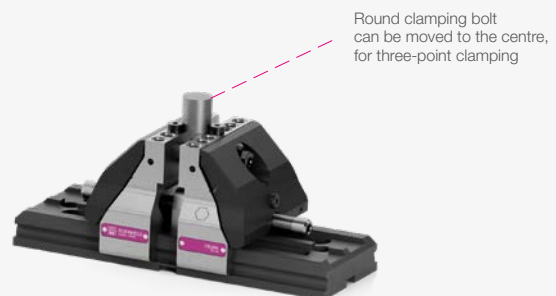


All dimensions in [mm]  
Fastening material included in scope of delivery

### INFO

### Round clamping bolts application

The replaceable round clamping bolts make these clamping jaws universally usable. They can be used for clamping large round plates as well as small cylindrical components.



OPTIONS FOR FASTENING ON THE MACHINE TABLE

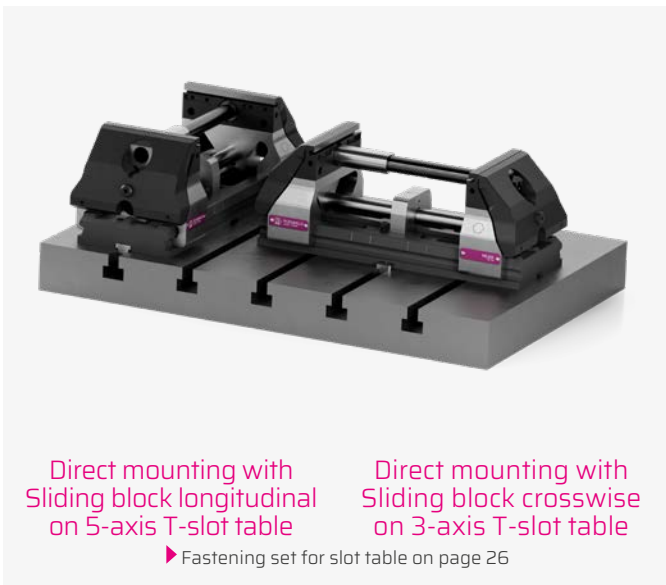
# Fastening options

Stable Fastening on the machine table is of great importance to ensure precise machining. Fastening options can be selected depending on the type of processing and the individual requirements.

Direct mounting  
Adapter plate



Sliding blocks and screws  
Clamping claws  
Zero-point mounting system



Direct mounting with Sliding block longitudinal on 5-axis T-slot table  
▶ Fastening set for slot table on page 26

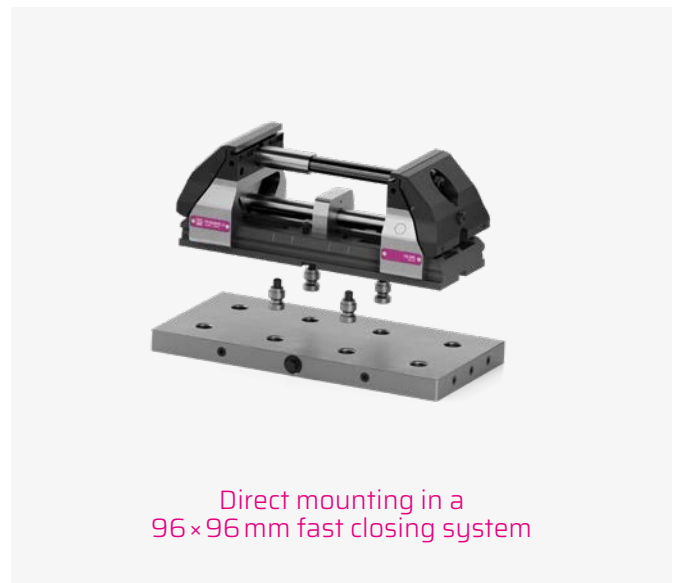
Direct mounting with Sliding block crosswise on 3-axis T-slot table



Direct mounting with retractable nipples in the STARK zero point clamping system  
▶ Fastening set for retractable nipple on page 23  
▶ Quick-action coupling on page 24



Direct mounting with screws from above on hole pattern with raiser on right image  
▶ Raiser on page 25



Direct mounting in a 96×96 mm fast closing system



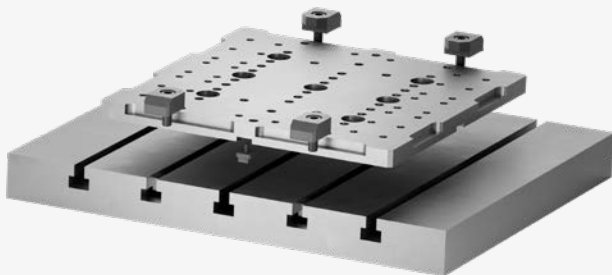
**Fastening on adapter plate**

- ▶ Adapter plates on page 22
- ▶ Fastening set on page 26



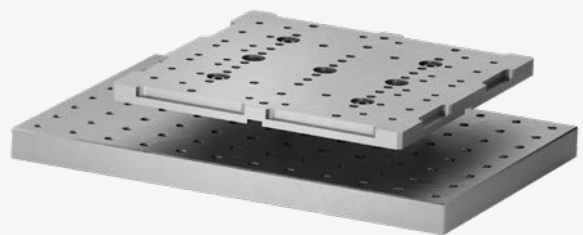
**Fastening via adapter plate in zero point clamping system**

- ▶ Fastening set for retractable nipple on page 23
- ▶ Fast closing plate on page 24



**Fastening via adapter plate with clamping claws**

- ▶ Fastening set for clamping claws on page 26



**Fastening via adapter plate on hole pattern**

- ▶ Fastening set on page 26



## Adapter plates

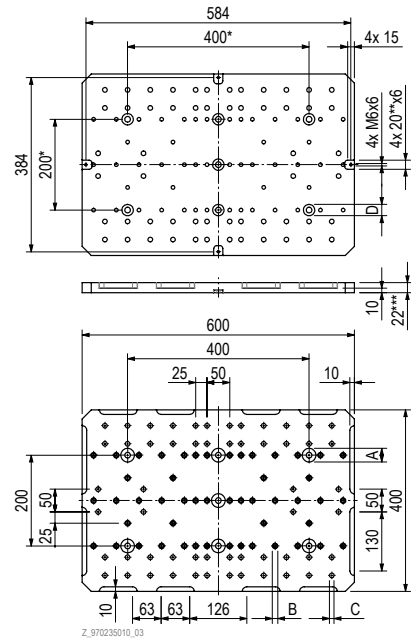
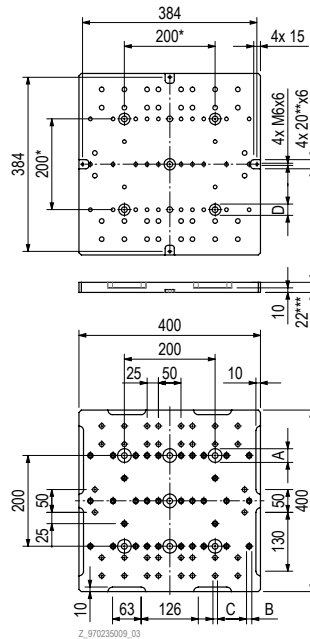
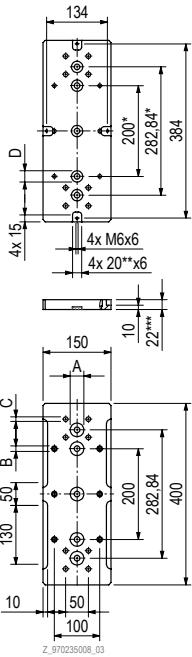
The adapter plates allow the flexibility of the system to be optimally utilised.

- + Simplified assembly
- + Defined interface below
- + Flexible interface above

The locating pins included in the fastening set allow the HILMA.UC to be positioned precisely on the adapter plate, both in the standard version and in the extended version.

Fastening set ▶ Page 23

Order no.	Description	Weight
970235008	1 × adapter plate 150 × 400 mm Bore hole for retractable nipple Bore holes for locating pins and fixing screws	9 kg
970235009	2 × adapter plate 400 × 400 mm Bore hole for retractable nipple Bore holes for locating pins and fixing screws	25 kg
970235010	3 × adapter plate 600 × 400 mm Bore hole for retractable nipple Bore holes for locating pins and fixing screws	37.6 kg



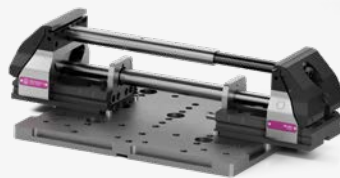
Alle Abmessungen in [mm]  
Befestigungsmaterial in Lieferumfang enthalten

### INFO

#### Fastening examples on adapter plate



**400 × 400 mm**  
Two HILMA.UC placed next to each other on the outside



**400 × 400 mm**  
One HILMA.UC with extension 400 mm placed centrally



**400 × 400 mm**  
Two HILMA.UC with extension 400 mm placed next to each other on the outside

## Retractable nipple for NPS

Thanks to the integrated retractable nipple bore holes in the visebase, HILMA machine vises can be perfectly supplemented and combined with STARK zero-point clamping systems. A zero point clamping system consists of a quick-release fastener into which

retractable nipples are clamped. In order to compensate for manufacturing tolerances and the necessary "mobility for thermal expansion" on a pallet (temperature change), three different types of retractable nipples are combined.

### Retractable nipple set for SVP STARK.classic.2

Set for direct mounting of the HILMA.UC vise.



Order no.	Supply
970235014	Retractable nipple with zero point STARK.classic.2 NP Screws for mounting from below and above Threaded insert M10
	Retractable nipple with compensation STARK.classic.2 AG Screws for mounting from below and above Threaded insert M10

### Retractable nipple set for SVP STARK.basic.M



Order no.	Supply
970235015	Retractable nipple with zero point STARK.basic.M NP Screws for mounting from below and above Threaded insert M10
	Retractable nipple with compensation STARK.basic.M AG Screws for mounting from below and above Threaded insert M10

### Retractable nipple for SVP STARK.classic.2



Individual retractable nipples for individual combination depending on the application. Threaded inserts are required for the retractable nipples. ▶ Page 26

Order no.	Retractable nipple
S804-470	with zero point STARK.classic.2 NP
S804-471	with compensation STARK.classic.2 AG
S804-472	without centring STARK.classic.2 OZ

### Retractable nipple for SVP STARK.basic.M



Individual retractable nipples for individual combination depending on the application. Threaded inserts are required for the retractable nipples. ▶ Page 26

Order no.	Retractable nipple
S8000-300	with zero point STARK.basic.M NP
S8000-301	with compensation STARK.basic.M AG
S8000-302	without centring STARK.basic.M OZ

#### INFO

#### Compensation principle

The combination of retractable nipples depends on the number.

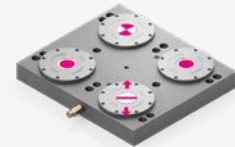
- ⊕ Retractable nipple with zero point (NP)
- ⊖ Retractable nipple with compensation (AG)
- Retractable nipple without centring (OZ)

Assignment example

2x adapter plate on 4x SVP

**NP - OZ**

**OZ - AG**

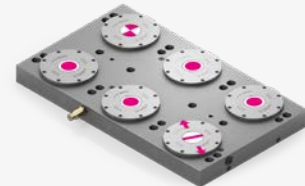


Assignment example

3x adapter plate on 6x SVP

**NP - OZ**

**OZ - OZ - AG**





## Fast closing plates for NPS

STARK standard fast closing plates (SVP) are a cost-effective entry-level solution for high-quality zero point clamping systems (NPS) and provide a secure and versatile connection between the machine vise and machine table.

- SVP made of steel ground on both sides

with mounting holes for different slot spacings

- NPS is clamped mechanically with spring force and released hydraulically/pneumatically

- Application area on 3-, 4- and 5-axis machines for all common machining operations such as milling, grinding, eroding



### Standard fast closing plate STARK.classic

- Hydraulic releasing system
- up to 120kN active retractable force

Order no.	Quick-locking plate	Size	Gauge for bore holes
S804-726	SVP with 4 STARK.classic.2 (S804-452)	4x 396x346x46 mm	200x200 mm
S804-727	SVP with 6 STARK.classic.2 (S804-452)	6x 596x346x46 mm	200x200 mm

### Standard fast closing plate STARK.basic

- Pneumatic releasing system
- up to 54 kN retention force

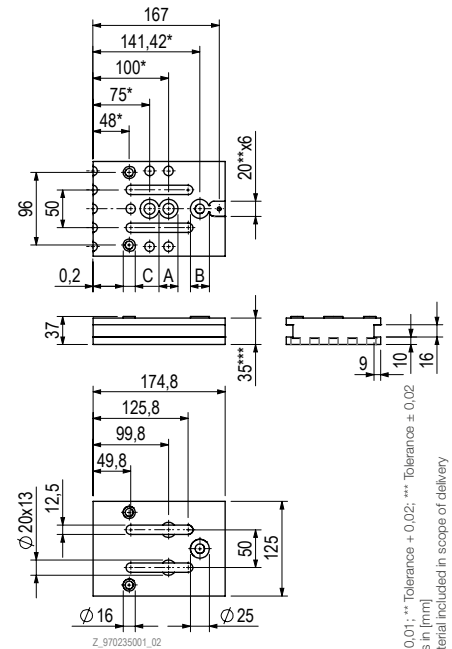


Order no.	Quick-locking plate	Size	Gauge for bore holes
S805-307	SVP with 4 STARK.basic.M (S805-202)	4x 396x346x46 mm	200x200 mm
S805-308	SVP with 6 STARK.basic.M (S805-202)	6x 596x346x46 mm	200x200 mm

## Raiser

Raiser for optimised accessibility.

- + Increased degree of freedom / improved accessibility for special clamping tasks



Order no.	Scope of delivery
970235001	2 pcs. raisers 4 pcs. fixing screws M10 × 45 mm fixing screws M12 × 75 mm

\* Tolerance ± 0.01; \*\* Tolerance + 0.02; \*\*\* Tolerance = 0.02  
All dimensions in [mm]  
Fastening material included in scope of delivery

### INFO

#### Example Fastening with raiser

The raiser is placed between the vise and the adapter plate.



## Fastening accessories

### Fastening set for slot table

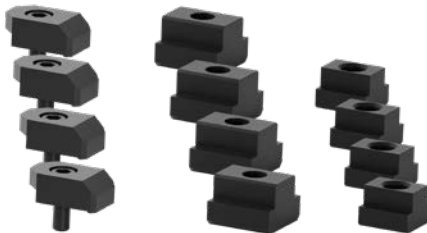
For positioning and mounting the clamping system on a T-slot table, hole pattern table or adapter plate.



Order no.	Scope of delivery
970235007	2 pcs. fitting sliding block 14/18 2 pcs. M6 × 16  4 pcs. T-nut 18 mm 4 pcs. T-nut 14 mm 4 × M12 × 40 mm incl. washers  4 × locating pins 12 × 20

### Clamping claw set

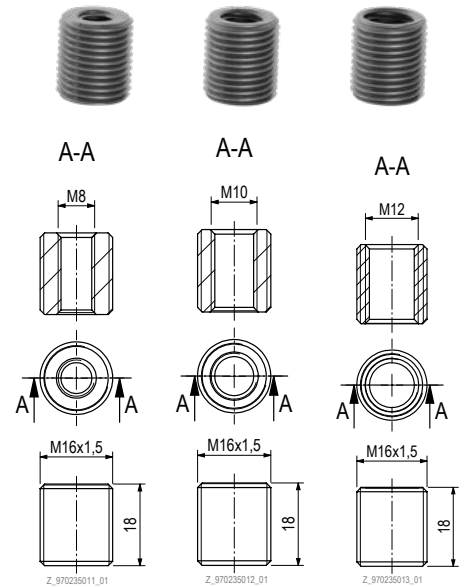
For mounting adapter plates or clamping systems.



Order no.	Scope of delivery
970235006	4 pcs. clamping claws 4 pcs. M12 × 30 mm  4 pcs. T-nut 18 mm 4 pcs. T-nut 14 mm

### Inserts for thread

For fastening with STARK retractable nipples, the standard M16 tapped holes can be reduced to M8/M10/M12 by means of threaded inserts.



Order no.	Scope of delivery
970235011	2x Inserts for M8 thread
970235012	2x Inserts for M10 thread
970235013	2x Inserts for M12 thread

- Further accessories such as Allen key, torque wrench and battery attachment on request.



## Order number directory

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A COMPANY OF THE  
ROEMHELD GROUP

# STARK

## Spannsysteme

The ROEMHELD Group is represented in Germany and Austria with different products and orientations. With numerous subsidiaries, sales partners and service companies on all continents and in more than 50 countries, rapid and intensive customer support is provided in the mechanical engineering, medical technology, automotive, aviation and agricultural industries.

As part of the ROEMHELD Group, STARK benefits from the security and experience of a family-run traditional company as well as from the worldwide sales and service network. At the same time, this background provides the independence to pursue dynamic and innovative goals for new market-driven developments and customer-specific solutions with which STARK maintains its leading technological position.



**ROEMHELD**  
HILMA ■ STARK

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