

ALUFIX Classic

Keyless chucks and Vises



Accurate part positioning for measuring technology

ALUFIX Classic

Keyless chucks and Vises

Secure workpiece clamping and accurate contact to support and contact surfaces



3 Jaw keyless chuck new version with offset pins



Application example for Universal Vise shown on page 11



Vise with offset pins

Features and Benefits

- The keyless chucks and vises are operated by hand, no additional tools are required
- Highest accuracy through precision machining of components on all sides, made of high-strength or medium-strength aluminum
- Extremely light and highly resilient
- High stability with extremely light weight
- Corrosion-resistant and maintenance-free
- Wear-resistant thanks to all-round anodizing
- Various mounting holes on the base allow the use of screw or quick connectors for assembly
- The top jaws on keyless chucks and the forming jaws on vises, enable making of individual workpiece-specific supports

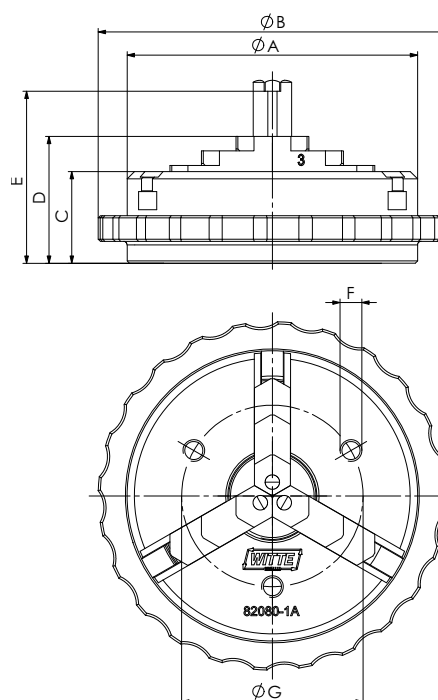


For more flexibility and a larger clamping range, the reversible jaws on all Witte manual chucks can also be rotated.

3 Jaw Keyless Chuck for measuring applications

Nr.	A	B	C	D	E	F	G	Ø
C 82220-1A	50	60	17,3	23,4	28,2	M4	30	-
C 82080-1A	80	96	25,3	35	47,4	M6	50	-
C 82125-1A	125	146	38,4	53,1	68,5	M8	80	-
82200-1A	200	236	55,3	79,1	104,1	M10	120	-

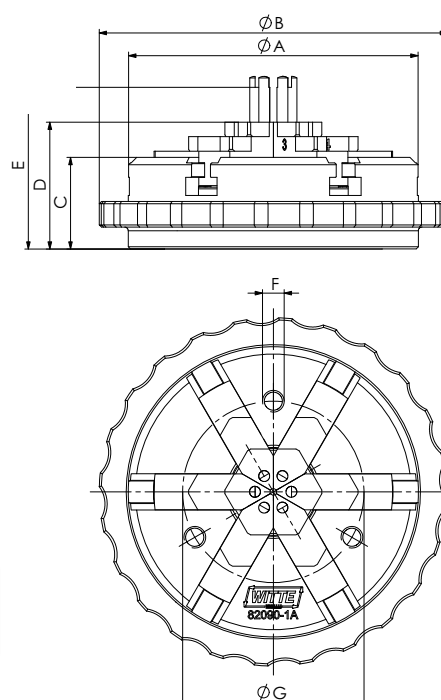
Concentricity base to part:
Repeatable accuracy max. 0,1mm, absolute accuracy 0,3mm



6 Jaw Keyless Chuck for measuring applications

Nr.	A	B	C	D	E	F	G	Ø
82340-1A	50	60	17,3	23,4	28,2	M4	30	-
82090-1A	80	96	25,3	35	44,6	M6	50	-
82135-1A	125	146	38,4	53,1	68,5	M8	80	-
82210-1A	200	236	55,3	79,1	104,1	M10	140	-

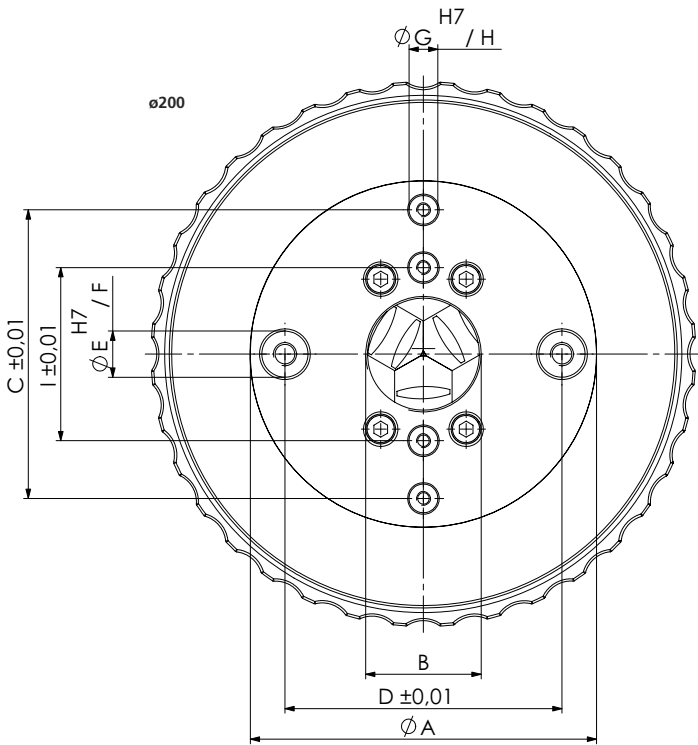
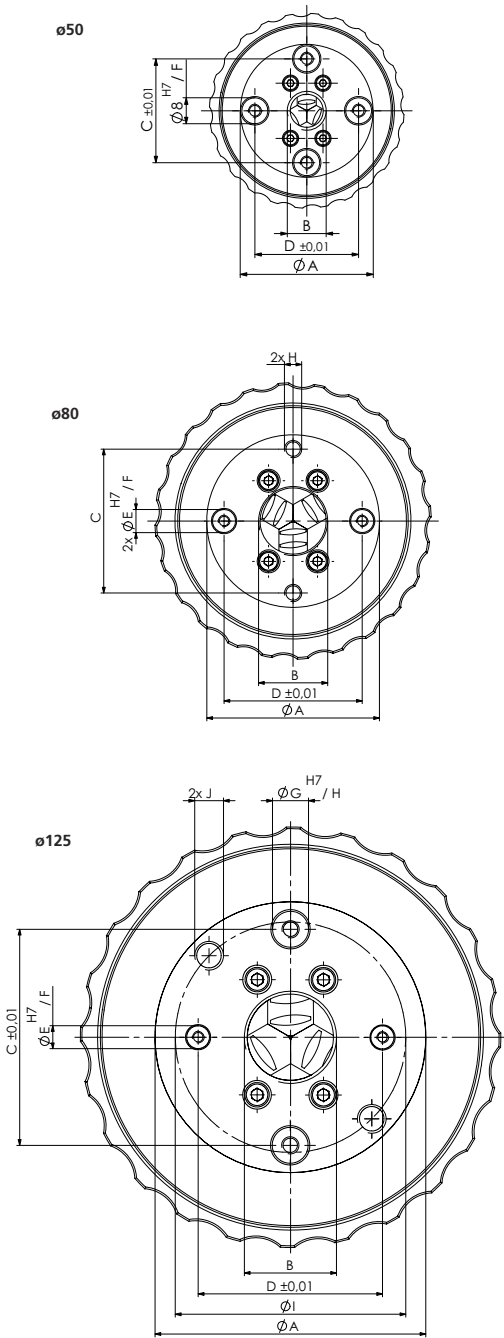
Concentricity base to part:
Repeatable accuracy max. 0,1mm, absolute accuracy 0,3mm



C·E ALUFIX preferred range
Green: Item is available immediately.
C: Classic version, E: Eco version, CE: Classic or Eco
■: color "black"

Further Dimensions
3 and 6 jaw keyless chucks, view from underneath

ø	A	B	C	D	E	F	G	H	I	J	AF
50	41	M12x0,5	32	32	8	M4	-	-	-	-	16
80	60	M 24x1	50	48	8	M4	-	M6	-	-	16/25
125	94	M32x1	75	64	8	M4	12,5	M6	80	M10	16/25/40
200	150	M50x1,5	125	120	20	M10	12,5	M6	75	-	25/40

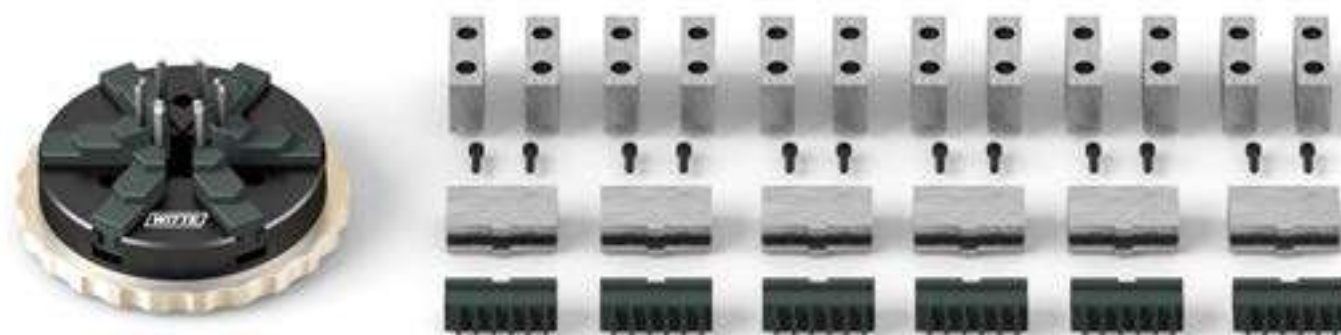




Basic Set 3 jaw Keyless chuck

19-pcs., 1 x chuck with reversible jaws,
1 x Base jaw set, 9 x Top jaws, 6 x Screws

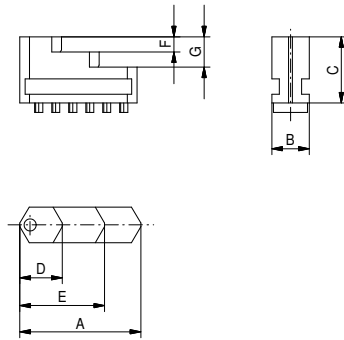
Nr.	ø	comprising of:	g
82373-1A	50	1x82220-1A, 1x82351, 9x26288, 6x11434-S1	138
82376-1A	80	1x82080-1A, 1x82356, 9x26289, 6x11435-S1	523
82378-1A	125	1x82125-1A, 1x82360, 9x26290, 6x10437	1.946
82380-1A	200	1x82200-1A, 1x82364, 9x26291, 6x10631	7.300



Basic Set 6 jaw Keyless chuck

37-pcs., 1 x chuck with reversible jaws,
1 x Base jaw set, 18 x Top jaws, 12 x Screws

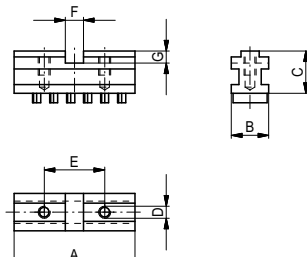
Nr.	ø	comprising of:	g
82374-1A	50	1x82340-1A, 1x82354, 18x26288, 12x11434-S1	173
82377-1A	80	1x82090-1A, 1x82358, 18x26289, 12x11435-S1	690
82379-1A	125	1x82135-1A, 1x82362, 18x26290, 12x10437-S1	2.595
82381-1A	200	1x82210-1A, 1x82366, 18x26291, 12x10631-S1	9.830



Reversible jaws set for 3 jaw chuck

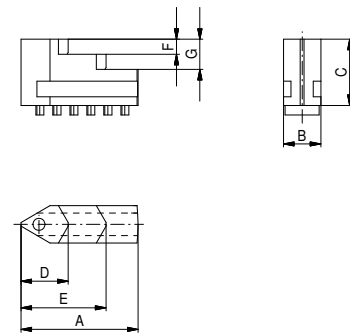
Nr.	for $\varnothing$	A	B	C	D	E	F	G	
82350	50	20	5,9	10,7	7	14	2,5	5	10
82355	80	32	9,9	17,5	11	22	4,0	8	30
82359	125	52	15,9	27,1	17	34	6,0	12	20
82363	200	82	24,9	44,1	27	54	8,0	16	370

Also fit in 6 jaw chucks.



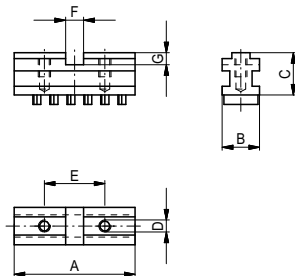
Base jaws set for 3 jaw chuck

Nr.	for $\varnothing$	A	B	C	D	E	F	G	
82351	50	20	5,9	6,6	M2	10	3	2	10
82356	80	32	9,9	10,9	M3	16	5	3	20
82360	125	52	15,9	17,5	M5	24	8	5	160
82364	200	82	24,9	28,5	M8	40	12	8	380



Reversible jaws set for 6 jaw chuck

Nr.	for $\varnothing$	A	B	C	D	E	F	G	
82353	50	20	5,9	10,7	8	14	2,5	5	20
82357	80	32	9,9	17,5	12,5	22,5	4	8	60
82361	125	52	15,9	27,1	20	36	6	12	240
82365	200	82	24,9	44	27	54	8	16	1.000



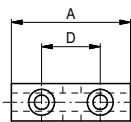
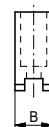
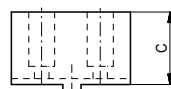
Base jaws set for 6 jaw chuck

Nr.	for $\varnothing$	A	B	C	D	E	F	G	
82354	50	20	5,9	6,6	M2	10	3	2	18
82358	80	32	9,9	10,9	M3	16	5	3	50
82362	125	52	15,9	17,5	M5	24	8	5	190
82366	200	82	24,9	27,5	M8	40	12	8	750

Top jaws single

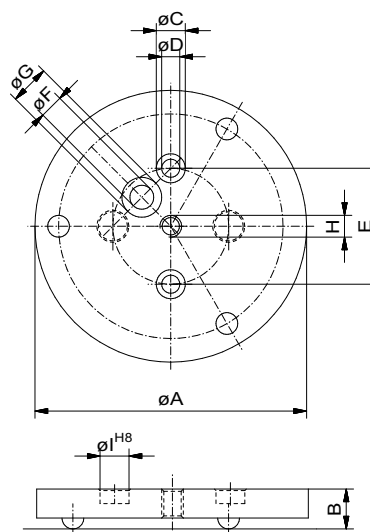
to use on base jaws, for 3 and 6 jaw keyless chucks

Nr.	for ϕ	A	B	C	D	Material	
26288	50	20	5,9	12	10	EN AW-7075	3
26288-10	50	20	5,9	12	10	POM	2
26289	80	32	9,9	18	16	EN AW-7075	13
26289-10	80	32	9,9	18	16	POM	10
26290	125	52	15,9	28	24	EN AW-7075	50
26290-10	125	52	15,9	28	24	POM	43
26291	200	82	24,9	44	40	EN AW-7075	150
26291-10	200	82	24,9	44	40	POM	139

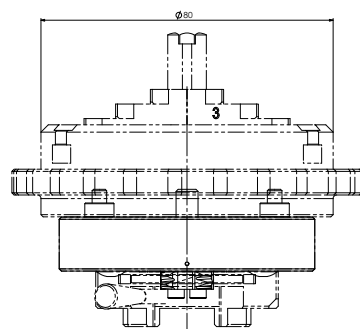
**Center plate**

for 3 and 6 jaw keyless chucks

Nr.	for ϕ	A	B	C	D	E	F	G	H	I	
82371-1	50	75	11	8	5	32	6,6	11	M6	8	100
82159-1	80	120	13	11	6,6	50	-	-	-	8	317
82344-1	125	187	18	11	6,6	75	-	-	-	8	493
82345-1	200	300	28	18	11	120	-	-	-	12,5	528

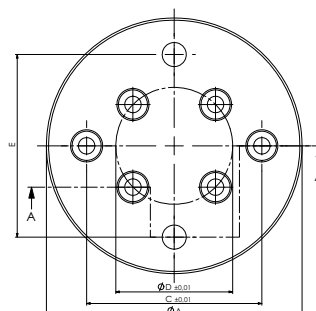
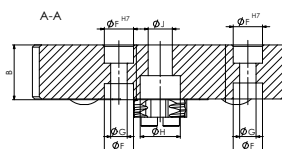
**Quick change coupling**for keyless chucks $\phi 50$ mm and $\phi 80$ mm

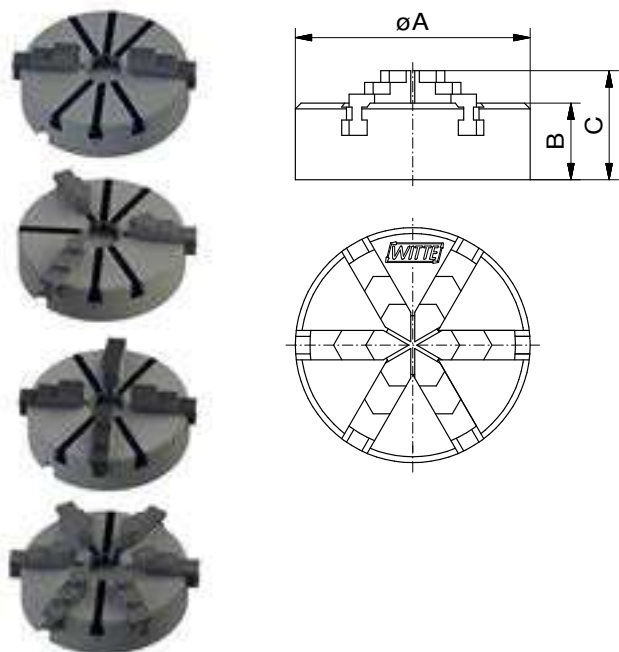
Nr.	ϕA	B	C	ϕD	E	ϕF	ϕG	ϕH	ϕJ	
291548-1	70	15	48	32	50	8	4,5	11	6,6	168



The required connection elements are included in supply.

Picture shows coupling with connection elements, plus quick change coupling bottom section (No. 282474-1) and keyless chuck Dia 80 (No. 82080-1A) not included in supply.





Keyless chuck
for 2,3,4,6 jaws, $\varnothing 125$, anodized natural

Nr.	A	B	C	
285291-1	125	33	50	1300



6 stepped standard jaws are included in supply.
Base and special jaws are available on request.
Base same as chuck $\varnothing 125$: 82125, 82135.
Suitable Center plate: No. 287192-1.



Vise set
10-pcs., comprising of:

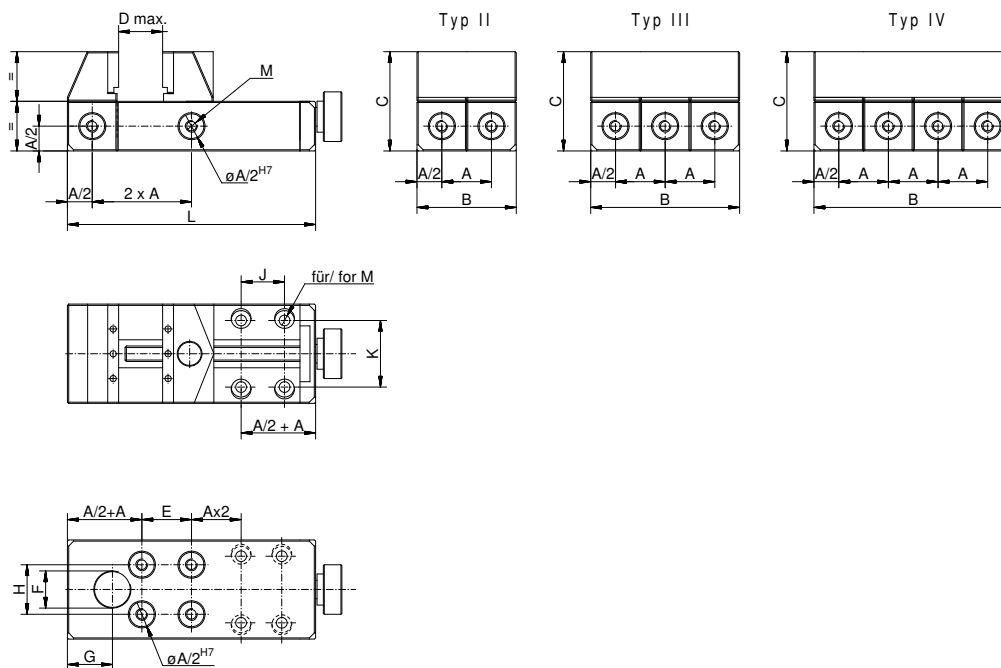
Nr.	System	Vise	Flat jaw	Pins	V-jaw	V-jaw
		1x	Alu 2x	3x	small 2x	big 2x
81790-1	16	81784-1	24580-1	24604	24586-1	24598-1
81791-1	25	81785-1	24581-1	24605	24587-1	24599-1
81792-1	25	81786-1	24582-1	24605	24588-1	24600-1
81793-1	25	81787-1	24583-1	24605	24589-1	24601-1
81794-1	40	81788-1	24584-1	24606	24590-1	24602-1
81795-1	40	81789-1	24585-1	24606	24591-1	24603-1

Jaws also available as single elements
Flat and V jaws are also available in polymer
(POM black).



Parallel-vise without pins

Nr.	AF	Typ	L	B	C	D	E	F	G	H	J	K	M	$\bar{g}$
81784-1	16	II	80	32	32	40	-	M12x0,5	14,5	16	-	16	M4	135
 81785-1	25	II	125	50	50	65	-	M24x1	23	25	-	25	M6	750
81786-1	25	III	150	75	50	90	25	M24x1	37,5	50	-	50	M6	905
81787-1	25	IV	175	100	50	115	25	M24x1	62,5	50	-	50	M6	1.410
81788-1	40	III	320	120	80	225	40	M32x1	100	80	-	80	M10	4.620
81789-1	40	IV	360	160	80	265	40	M32x1	100	80	80	80	M10	6.150

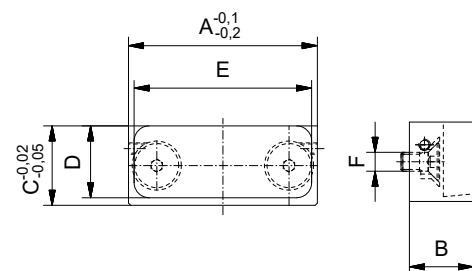


Forming jaw with bushes, for compound resin (page 10)

Nr.	System	A	B	C	D	E	F	$\bar{g}$
81831-1	AF 16	32	10	13,5	12	29	M3	10
81832-1	AF 25	50	17	21	19	47	M5	30
81833-1	AF 25	75	17	21	18,5	71	M5	40
81834-1	AF 25	100	17	21	18,5	96	M5	60
81835-1	AF 40	120	34	33,5	30	112	M8	170
81836-1	AF 40	160	34	33,5	30	152	M8	226



Supply includes:
1 forming jaw,
2 bushes,
2 Threaded pins,
2 countersunk screws.



ALUFIX preferred range

Green: Item is available immediately.

C: Classic version, E: Eco version, CE: Classic or Eco

■: color "black"



Plasticine compound resin
Knead blue and yellow components in ratio 1:1, blend well until colour through out is green.

Apply within 15 minutes. The resin hardens to full strength within 3 hours.

Technical details:
Tensile strength 300 kg/cm²
Compression strength: 800 kg/cm²
Heat resistance upto +200°C



Application example for compound resin in standard moulding cap.

Compound resin
for moulding workpieces

Nr.	Contents g	g
80692	100	120
80685	400	460



Preparing forming jaws with plasticine compound



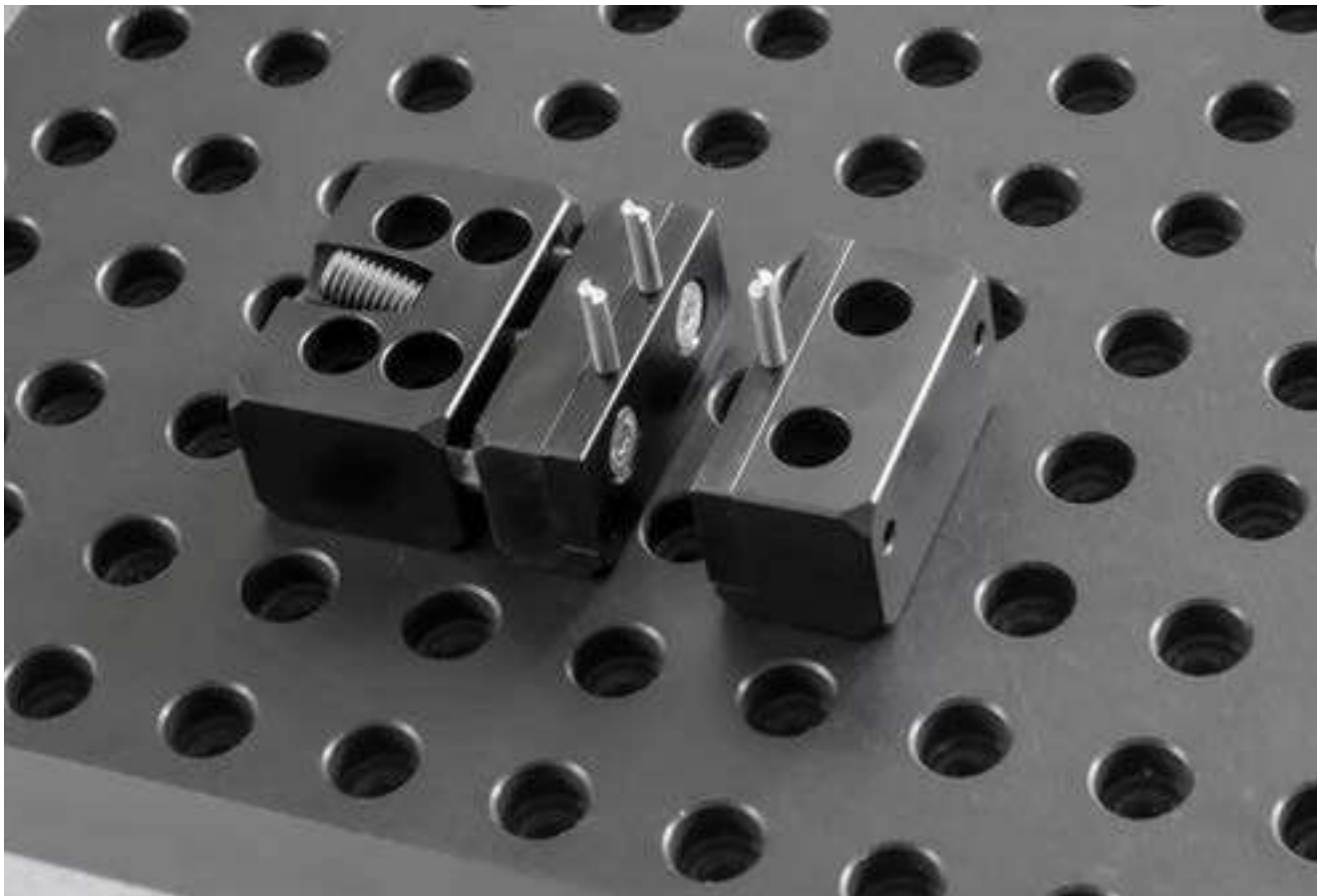
Positioning of workpiece



The forming jaws with the compound resin are pressed together.

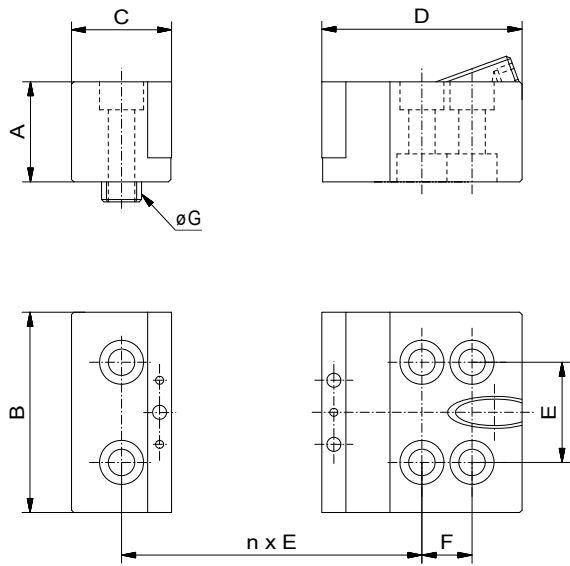


The compound resin adapts to the contours of the workpiece



Universal Vise
2 pcs., for mounting on base plates
or grid base plates, Shift $\pm 12,5$ mm

Nr.	System	A	B	C	D	E	F	G	
93498-1	AF25	25	50	25	40	25	12,5	12,5	296
289488-1	AF40	40	80	40	64	40	20	20	878





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