

28003

Permanent magnet chucks

Type

- **Powerful magnet system**
- Switching on/off with hand lever
- Equipped with longitudinal and transverse limit stops
- Formation of **magnetic field without scatter**, preventing **magnetisation** of the **work piece**
- Magnetic force: max. 80 - 100 N/cm²

28003 102-103

Use

Especially for machining workpieces with a thickness of less than 5 mm and 15 mm Ø or diameter.

28003 106-116

Use

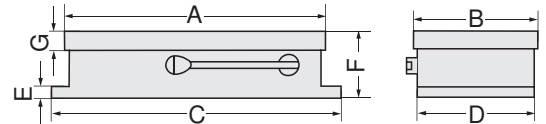
For grinding projects.

Note:

Machining of the top plate without negatively influencing the holding power is possible up to a depth (in steel) of 15 mm (non-ferrous metals up to a depth of 6 mm). Securing of chucks on machining table via clamping brackets.



28003



A mm	B mm	C mm	D mm	E mm	F mm	G mm	Pole spacing steel / non-ferrous metals mm	Weight kg	28003	...
150	100	165	97	15	65	24	6 / 1,5 + 2 / 1,5	7		102
200	100	213	97	15	65	24	6 / 1,5 + 2 / 1,5	9		103
255	130	265	127	15	65	24	6 / 5	13		106
250	150	258	147	15	65	24	6 / 5	15		110
300	150	308	147	15	65	24	6 / 5	18		111
400	150	410	147	15	65	24	6 / 5	23		113
400	200	413	197	15	72	24	6 / 5	32		116

28006

Permanent magnet chucks

Type

- **Powerful magnet system**
- Switching on/off with hand lever
- Equipped with longitudinal and transverse limit stops
- Formation of **magnetic field without scatter**, preventing **magnetisation** of the **work piece**
- Magnetic force: max. 120 N/cm²

Use

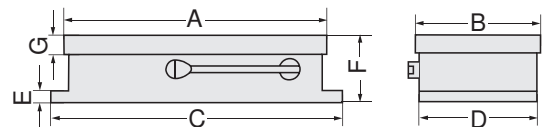
For heavy-duty machining such as milling as part of roughing.

Note:

Machining of the top plate without negatively influencing the holding power is possible up to a depth (in steel) of 15 mm (non-ferrous metals up to a depth of 6 mm). Securing of chucks on machining table via clamping brackets.



28006



A mm	B mm	C mm	D mm	E mm	F mm	G mm	Pole spacing steel / non-ferrous metals mm	Weight kg	28006	...
250	150	260	145	20	93	34	8 / 5	20		201
300	150	310	145	20	93	34	8 / 5	24		202
300	200	295	195	20	93	34	8 / 5	29		207
400	200	395	195	20	93	34	8 / 5	39		208
450	250	445	245	20	93	34	8 / 5	57		214

28007

Permanent magnet chucks

ATORN®

Type

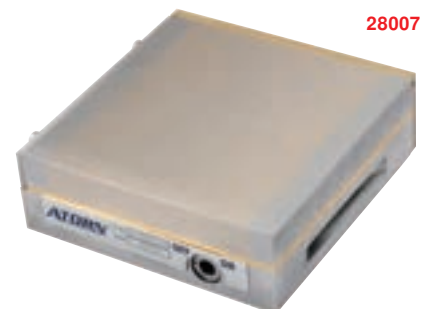
- Double neodyme magnet system for particularly high magnetic forces (up to 120 cm²)
- Very robust structure with rugged base body and solid terminal plate
- Sealed against the ingress of dirt and coolant
- Particularly close pole spacing (ST 1.4 / NF 0.5).

Scope of supply:

With 2 stop strips,
2 clamping brackets,
indexing wrench,
operating manual.

Use

For precise grinding and erosion work. Universal magnet for small, thin and large workpieces.



28007

Length mm	Width mm	Height mm	Weight kg	Strength of terminal plate mm	of which usable mm	Pole spacing steel / non-ferrous metals mm	28007	...
150	150	51	9	20	5	1,4 / 0,5		201
175	100	49	7	20	5	1,4 / 0,5		202
200	100	49	8	20	5	1,4 / 0,5		203
250	150	51	15	20	5	1,4 / 0,5		204
350	150	51	22	20	5	1,4 / 0,5		205
400	200	51	35	20	5	1,4 / 0,5		206



Type

- Angle setting using end blocks
- Base plate hardened and precision-ground
- Flat parallelism 0.01/100 mm
- Pivotal around longitudinal axis through 0-45°
- Sealed against the ingress of dirt and coolant
- Repeatability precision 10 sec.

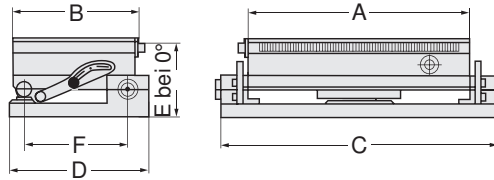
Scope of supply:

With 2 stop strips, clamping wrench, operating manual.

Use

For precise grinding and erosion work. For small and large workpieces.

28009



Clamping surface A mm	Clamping surface B mm	Basic surface C mm	Basic surface D mm	Height E mm	Roller distance F mm	Weight kg	28009	...
140	70	170	100	67	55	5,5		101
175	100	215	115	76	85	10,0		102
250	150	290	165	79	135	21,5		103
350	150	390	165	87	135	34,5		104
450	150	490	165	87	135	44,0		105

28010

Round permanent-magnetic chuck

Type

- Particularly powerful magnet system with fine parallel pole spacing
- Switching on/off with hand lever
- Machined centring grooves make alignment easier
- Infinitely variable controllable magnetic force
- Magnetic force: max. 80 N/cm²

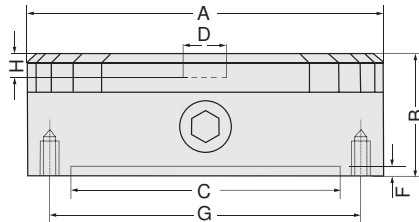
Use

For grinding and eroding even of small workpieces.

Note:

Centring bores possible if needed. Furthermore, boreholes can be drilled into the top plate without negative influence on the holding power (steel 15 mm/non-ferrous metals 6 mm).

28010



A mm	B mm	C mm	D mm	F mm	G mm	H mm	threaded hole	Pole spacing steel/non-ferrous metals mm	Weight kg	28010	...
130	62	90	15	2,5	120	7	4 x M 6	4 / 1.5 + 2 / 1.5	5		102
160	75	125	20	3,0	142	6	4 x M 8	6 / 1.5 + 2 / 1.5	8		103
200	80	150	20	4,5	182	6	4 x M 8	6 / 1.5 + 2 / 1.5	13		104
250	80	200	20	4,5	232	6	4 x M 8	6 / 1.5 + 2 / 1.5	20		105

28012

Round permanent-magnetic chuck

Type

- Powerful neodyme magnet system with radial parallel pole spacing
- Switching on/off with hand lever
- Machined centring grooves make it easier to align workpieces
- Magnetic force: max. 100 N/cm²

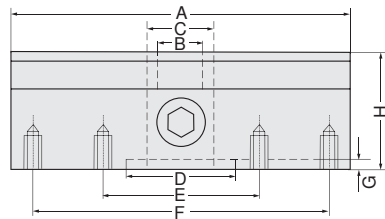
Use

For grinding and turning.

Note:

The chucks can be equipped with a through-bore on request.

28012



A mm	H mm	B mm	C (max.) mm	D mm	G mm	F mm	threaded bores	number of terminals	weight kg	indexing points	28012	...
150	60	15	20	90	4	115	M 8 x 15 (4)	10	8	1		101
200	60	20	25	160	4	180	M 8 x 15 (4)	12	14	1		102
250	60	20	25	200	4	235	M 10 x 15 (4)	12	23	1		103
300	80	35	40	250	4	270	M 12 x 20 (7)	14	43	1		104

28042

Laminated Chuck Blocks and Plates

Type

- Silver hard-soldered steel-brass connection
- Flat or with prism
- Discs made of 3 mm steel / 1 mm brass
- Disc blocks are not magnetic but are superb conductors

Use

Only used in conjunction with magnetic chucks.

Note:

The chucks can be machined on all sides in order to customise them to the workpiece.

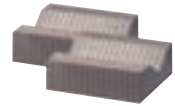
28042 201

Laminated Chuck Blocks
With prism (90°) (pair).

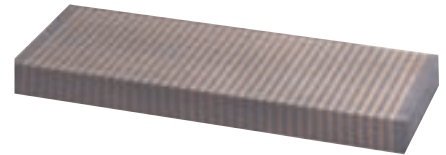
28042 202-203

Laminated Chuck Plates
With pole spacing (piece).

28042 201



28042 202-203



Length x Width x Height mm	28042	...
100 x 80 x 40		201
150 x 75 x 25		202
250 x 75 x 25		203

28048

Plate demagnetisation units

Type

- With signal lamp
- On/off switch and connection cable with plug
- Voltage: AC 230 Volt, 50 Hz

Use

Problem-free demagnetisation of workpieces with residual magnetism.

Note:

Cat. No. 28048 101+102
max. engagement time 10 mins.
Cat.-no. 28048 103 can be used without interruption
(100 % ED).

28048



Length x Width x Height mm	Power VA	28048	...
165 x 120 x 115	286		101
175 x 220 x 120	660		102
210 x 155 x 110	45		103

28050

Hand demagnetisation device

Type

- With signal lamp
- On/off switch and connection cable with plug
- Voltage: AC 230 Volt, 50 Hz

Use

Problem-free demagnetisation of workpieces with residual magnetism.

Note:

Max. engagement time 10 mins.

28050



Length x Width x Height mm	Power VA	28050	...
120 x 105 x 180	1330		101

28052

Tunnel demagnetisation units

Type

- With signal lamp
- On/off switch and connection cable with plug
- Voltage: AC 230/400 Volt, 50 Hz

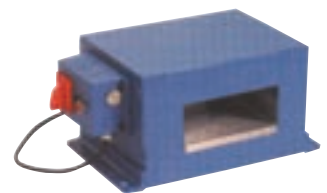
Use

Suitable for runs of workpieces with remaining magnetism.

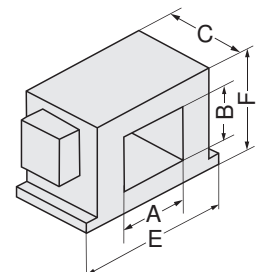
Note:

Can be used without interruption
(100 % ED).

28052



A mm	B mm	C mm	E mm	F mm	Power VA	28052	...
150	60	200	323	166	794		101
200	100	200	415	240	2066		102



Info

Permanent electro-magnetic chucks

wagner
magnete

A new generation of chucks, which has remarkable advantages when compared to standard electric or permanent-magnetic chucks:

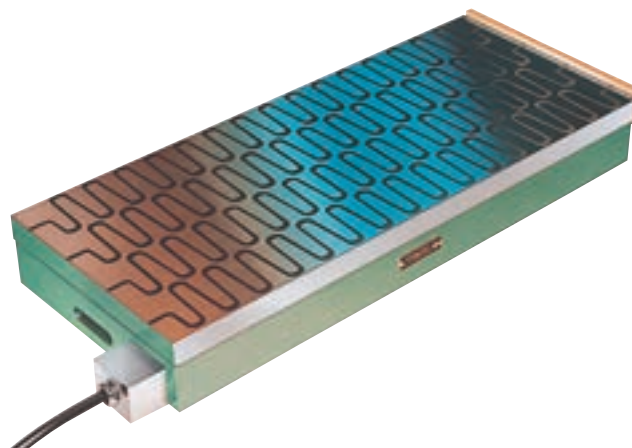
- | | |
|-------------------------------|---|
| higher accuracy | • no generation of heat |
| perfect safety | • thanks to remote control of the magnet |
| great profitability | • a short impulse generates the clamping process, which will last until power is switched off |
| Direct connection to machines | • thanks to pulse contact control with NC control |
| high operating safety | • in case of a power outage, the chuck will retain full magnetic force |

The adhesive force is dependent on the type of pole spacing and the percentage occupation of the plate, as well as on the contact surface, thickness, surface characteristics and quality of the material of the workpiece.

The set consists of:

- electric permanent-magnetic chuck
- pulse contact control
- control unit

Please send us your enquiry!



Performance requires quality.

For example, with the 4-10 Power and 4-15 Power angular milling cutter from ATORN.

- Multi-function milling tool system
- 4 cutting edges on a double-sided indexable insert
- Nickel-plated
- Inner coolant feed

ATORN®
Performance requires quality.

www.atorn.de

Clamping Technology