



THE welding table



SMART
SYSTEMS.
FOR EFFICIENT
WORKING.

MODULAR CLAMPING SYSTEM

Original 3D worktable systems D28 | D22 | D16

www.demmeler.com

Table of contents

D28

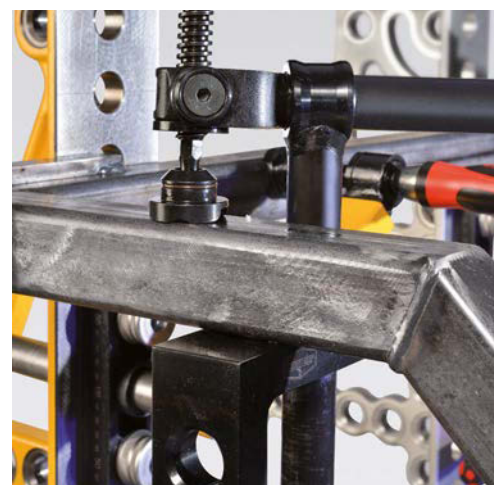
Practical applications	21
3D clamping systems D28	71
Table versions	
Table leg versions	
Sets	
Clamping plates	
Track system	133
Floor plates	
Bolts	169
Spacer block	191
Angles / stops	211
Supports	259
Clamps	273
Quick release skewer	
Pneumatic toggle clamp	
Magnetic clamp	
Accessories	327

D22

3D clamping systems D22	347
Table versions	
Table leg versions	
Sets	
Clamping plates	
Bolts	383
Spacer block	399
Angles / stops	405
Supports	427
Clamps	431
Quick release skewer	
Accessories	451

D16

3D clamping systems D16	465
Table versions	
Table leg versions	
Sets	
Clamping plates	
Bolts	507
Spacer block	521
Angles / stops	533
Supports	559
Clamps	567
Quick release skewer	
Accessories	597



INNOVATION + PERFORMANCE

TECHNOLOGY FROM THE MARKET LEADER



3D CLAMPING SYSTEM

The modular system can no longer be replaced where processing, welding, assembly and measurement occurs. This fitting system is now an international industrial standard due to the tremendous application and combination possibilities.

MANIPULATORS

Welding and assembly in an optimal position. A good ergonomic workplace design allows more efficient and error-free workmanship, protecting staff against health hazards even during laborious tasks. The manipulators from DEMMELER offer preventive occupational safety and ensure a more efficient and safer working environment which, as a result, leads to improved quality in production. Whichever way you look at it, Demmeler manipulators are indispensable.

CNC CLAMPING SYSTEM

As the inventor of the 3D clamping system, we have revolutionised fixture construction in the areas of welding, assembly and straightening. We have received multiple awards as an innovation leader. With our global innovation "CNC - Clamping System", the DEMMELER clamping system for milling and turning centres, we now also support industrial machine manufacture. We place the utmost value on stiffness, damping properties as well as reproducibility and accuracy when developing and producing this system. The modularity allows you to clamp your work pieces (from lightweight to very heavy) very precisely and quickly. By paying particular attention to stiffness and damping properties, you also increase the quality of your work piece to be machined, thus protecting your machine technology and your tools.

ROTARY TABLES / TOOL ARENAS / AUTOMATION

DEMMELE's automation systems are used wherever extremely efficient and high quality products are manufactured. As a quality leader, we deliver our robot-based tool changing systems as well as our carousel, rotary and rotary shifting tables worldwide. We place great importance on individual support and comprehensive service. We guarantee top quality and extreme precision. All areas are oriented to and contribute to this purpose.

CONTRACT MANUFACTURING

Dimensions up to 20 m in length, piece weight up to 100 tonnes and tolerances in the micrometre range – all of these are parameters that have accompanied us for years and characterise us as a supplier of well-known machine tool manufacturers. The main focus of work here is on the production of basic components, such as X, Y and Z axes, machine beds, machine frames, portals and clamping floor plates, which are used in our customers' ultra-modern CNC machines.



MANIPULATORS



CNC CLAMPING SYSTEM



TURNING AND
ROTARY TABLES



TOOL ARENAS



CONTRACT MANUFACTURING



Optimise your production processes with us as an innovation leader, inventor and manufacturer.

A smooth and efficient production process is crucial to your company's success. The topics of "lowering production costs", "increasing quality" and "continuing to develop ergonomics" are and will always be important in remaining competitive. We see ourselves as a reliable and competent partner of our customers in the process. This drives us to continuously develop our products further and to advance new developments.

With us you will find the broadest product portfolio in the area of 3D clamping systems - perfectly tailored to your requirements. You therefore have the right solution for every one of your challenges!

YOUR BENEFITS IN FOCUS

- Premium quality at the best price-performance ratio
- The largest product portfolio in the 3D clamping systems area
- Award-winning in the areas of innovation and ergonomics



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Local District Court of Memmingen / HRA 11517
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Dear business partners,
Dear Ladies and Gentlemen,

In the company's over 55-year success story, we have always placed our product benefits for our customers at the focus of our activities. The philosophy in developing our innovations is always to make your work easier. So we are very proud of having created a standard for the industry with the invention of the 3D clamping system. Our products and our company have already received numerous awards, such as the TOP100 Award. However, it is important that you award us with your loyalty. It is our firm conviction: We are successful when you are successful!

The technology from DEMMELER is the basis for your success. Our drive is to support you in increasing the economic efficiency of your company. Our products help you to accelerate work flows, to produce in a consistently high quality and to ensure a high availability of your employees through the best work ergonomics. We ensure this with the highest quality, power of innovation and individuality. Already during the investment planning stage, we help you to find the best economic and technical solution. We ensure that you are successful across the entire service life with the robust "Made in Germany" products,

which can still be developed further. With our experts on site, the competent sales and development team in the plant and the experienced application consultants, we ensure your success with very high quality and safety standards. Even after installing our products in your value added chain, we are still there for you. You can always meet your changing requirements with modular systems.

We are happy to help you with any new questions and also benefit from your knowledge in the process. You're not just our customer. You are our partner. Our daily actions are aimed at making and developing successful long-term partnerships. We are there for you - with advice and action!



Sincerely,
Johannes Demmeler
Executive Partner



Company

Foreword, Johannes Demmeler	1
Tradition and Innovation	2
Precisely more work pieces up to 500 tonnes	4
Welding and assembly in an optimal position	6
CNC Clamping System	8
The highest "made in Germany" quality	10
Precision redefined	11
Our innovations set new standards	12
Market leadership with strategy and goals	13
Sustainability and future viability	14
Our philosophy	15
Long service life, quick amortisation	16
Globally networked	18
Our service: fast, competent, reliable	20



1961
Founded by Ludwig Demmeler with a focus on welding, turning and milling

1966
Construction of an industrial hall with 600 m² for the realization of turning and boring work

1975
Extension of the business area to include the production of rotary tilting tables

1989
Relocation of the site to Heimertingen and new construction of an industrial hall with 2,500 m²

1990
Development of a new product – The world's first: 3D worktable – clamping systems

1998
Development and patent application of robot-based tool arena





Tradition and Innovation

The success story of our internationally successful family-owned company began when the 19-year old Ludwig Demmeler laid the foundation in 1961: In his small workshop, he worked as a subcontractor for nearby industrial businesses.

Already by 1990, DEMMELER set the standards on the market as the inventor of the 3D clamping system: Originally intended for the company's own production, the device system proved to be a quantum leap in metal processing and today is an international industrial standard due to the many possible applications and combinations.

DEMMELER, managed in the second generation by Johannes Demmeler as the managing director since 2001, operates on more than 40,000 m² of floor space. At the same time, we remain true to our roots in Allgäu. After the relocation in 1989, we have been producing our products exclusively in Heimertingen. This commitment was also recognised by the Bavarian Ministry of Economic Affairs, which honoured Ludwig Demmeler for his entrepreneurial achievements by awarding him the Federal Cross of Merit.

The company's growth was accompanied by several product developments, which were first produced only for their own production facilities. Put through their paces, we now deliver these products to customers worldwide. In addition to the 3D clamping system, these also include the turning, tilting and carousel rotary tables, as well as 3-axis manipulators, tool arenas and tool machine components.

We place great emphasis on the highest quality at a fair market price in the production of products. Extensive vertical integration combined with the most modern machines and highly automated processes allow us to live up to this claim. Our customers' success is the focus: A significant increase in productivity, improved quality in production, ergonomic working, even in difficult handling tasks, and enhanced safety in the workplace. These are the four principles under which we have always been working on new innovations. We were awarded with the TOP100 seal for this.

Innovative and quality leadership are at the centre of our brand image. It is our daily ambition to not only meet our customers' high requirements, but also to exceed them.

2001
Additional business branch with the production of basic components for machine tools

2004
Expansion of the production area to 6,800 m² for steel construction and painting

2005
Development of a new product: NC rotary shifting table

2007
Expansion of the production area to 10,000 m² for production and assembly

2009
Development of a new product: manipulators

2017
Hall expansion with an additional 6,500 m² hall floor space for assembly, logistics and the painting area





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Precisely more work pieces up to 500 tonnes

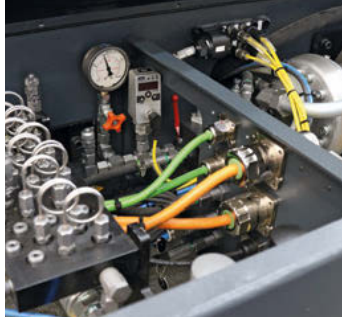
Our rotary, tilt and carousel rotary tables set a clear mark due to the extremely robust design as well as a high level of precision in the micrometre range, speed and repeatability.

A suitable solution can be designed for every application case. We speak with our customers about requirements and work pieces, which are to be processed on the rotary tables. We create the right solution based on our experience from more than 600 projects. Our high-precision rotary tables can withstand a bearing load of up to 500 tonnes. If such masses are being moved, this requires high torques. If these masses need to be accelerated quickly, then they need to be braked quickly, and they need to be precisely positioned with accurate repeatability.

Whether a hydrostatic linear or rotary axis, roller bearing axles or also a combination with both, we have all the solutions in our portfolio. Hydrostatic guides help to avoid wear surfaces, for example at very high loads, and the tables are thus suitable for processing with the highest requirements and the highest accuracy. The best damping properties allow for longer tool lives and high-precision work piece processing. The decisive factor for the

durability and precision of the rotary tables is not only the possible loading, but the largest possible bearing diameter in relation to the worktop size. The machine bed itself is very compact and space-saving. It is well-protected under the steel cover. All the necessary regulation and control elements are easily accessible in a power box located in the rotary table. Thanks to the standardised, plug-in-ready interface, the rotary table can easily be connected to all machine tools.

In addition to rotary tables for positioning work pieces for milling work (also in interpolation operation), patented tilting tables with additional axes, for example, are among the repertoire. Due to the standard angular adjustment of up to 10°, these are suitable for milling large and heavy components and, for example, are used in wind energy technology. Pallet changing systems are used to automate machining centres due to the multiple pallets and the ability to set up during main working hours. Thanks to a powerful drive train design, our carousel rotary table achieves very high machining torques, which makes a very good machining performance possible. In addition to the milling, it is also possible to turn and grind work pieces.



The right solution for every application

- The best technical values in terms of stability and accuracy with an excellent price-performance ratio
- We achieve this with our knowledge and our user experience with a high vertical integration
- The modular design makes it possible to realize different configurations depending on the customer requirements
- Possible tables loads up to 500 tonnes
- Working in the micrometre range, unmatched in the run-out, true running and repeatability
- Our NC rotary tables are available without a shifting axis as well as with a W-axis/V-axis.
- A central and easily accessible, integrated power box contains all the necessary regulation and control elements. The standardised interface allows for an easy connection and integration to the respective machine tool
- Integrated measuring systems in the highest precision, well-protected from additional covers and sealing air, ensure precise positioning

Welding and assembly in an optimal position

The size and bulkiness of work pieces often create difficulties during welding, because not all points can be seen well. However, an optimal overview is a prerequisite for clean and error-free work. Due to their dimensions, work pieces must be moved several times during the work process with a heavy device, usually with a crane. Reduce this safety risk with the manipulator from DEMMELER. The manipulator is a kind of lifting platform on which work pieces can be machined directly. You can add the DEMMELER 3D 'Okto table' to the manipulator for particularly large and bulky parts. This gives you a working surface that is precisely adapted to your work pieces. All locations are easily accessible and simplify welding, milling, measuring and assembling.

Since the tiltable manipulator can be adjusted in height and angle, you create an ergonomic working environment and avoid health problems for your employees with this handling device. The profitability and quality of your products also increase by using the manipulator. The manipulator allows for very precise work with an optimised welding sequence, which significantly reduces the welding distortion rate. In addition, simple and fast assembly is optimally possible with standard processes.



Unique
swivel range
up to
180 degrees.



Excellent posture and maximum productivity

Increase the quality level

- Working in the ideal position and at the ideal height
- Less welding distortion through optimised welding sequences
- Consistent quality with optional teaching function to save reproducible sequences
- Exact mounting in an ideal position

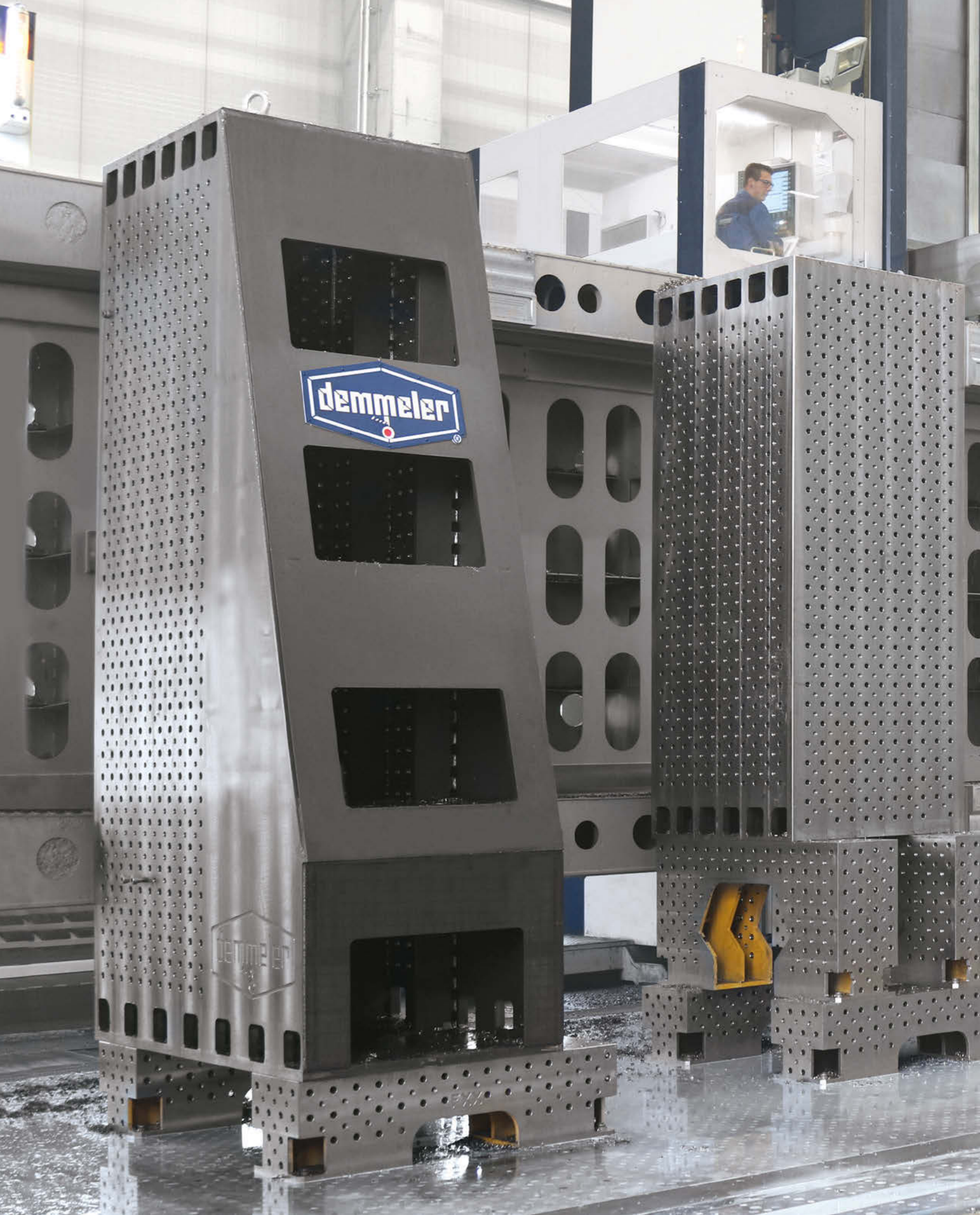
Protection of health and safety

- Avoidance of overloading and poor posture, which means less staff absenteeism
- Ergonomically-optimised work environment
- Employees with physical constraints can perform tasks that you could not perform without the manipulator (possibly investment aid possible by means of funding)
- Dangerous handling of work pieces with a crane is significantly reduced

Increased productivity

- Multiple, time-consuming rotating and turning of the work pieces, for example with a crane, is eliminated for a major reduction in non-productive time and a significant increase in productivity.
- Higher melting deposition efficiency when welding as most seams can be performed in the optimal position (flat position)
- Higher work performance due to optimal working position
- Fast and error-free assembly due to standard procedures





CNC Clamping System

With our world's first, the new CNC Clamping System, we have transferred our experience as a leader in innovation, quality and the market in the area of the 3D Clamping System to the machining area. In the development and manufacture of this system, which is used in the field of milling and turning centres, we attach great importance to high stiffness, the best damping properties as well as reproducibility and accuracy. The modularity allows you to clamp your work pieces very precisely and quickly. In addition, you increase the quality of your work piece to be machined, while protecting your machine technology and your tools. This saves money. The technology from DEMMELER is thus the basis for your success. Our drive is to support you in increasing the economic efficiency of your company. Our products help you to speed up work processes, to produce consistently high quality, to protect your machine technology and to reduce tooling costs. We ensure this with the our power of innovation and individuality. Already during the investment planning stage, we help you to find the best economic and technical solution.

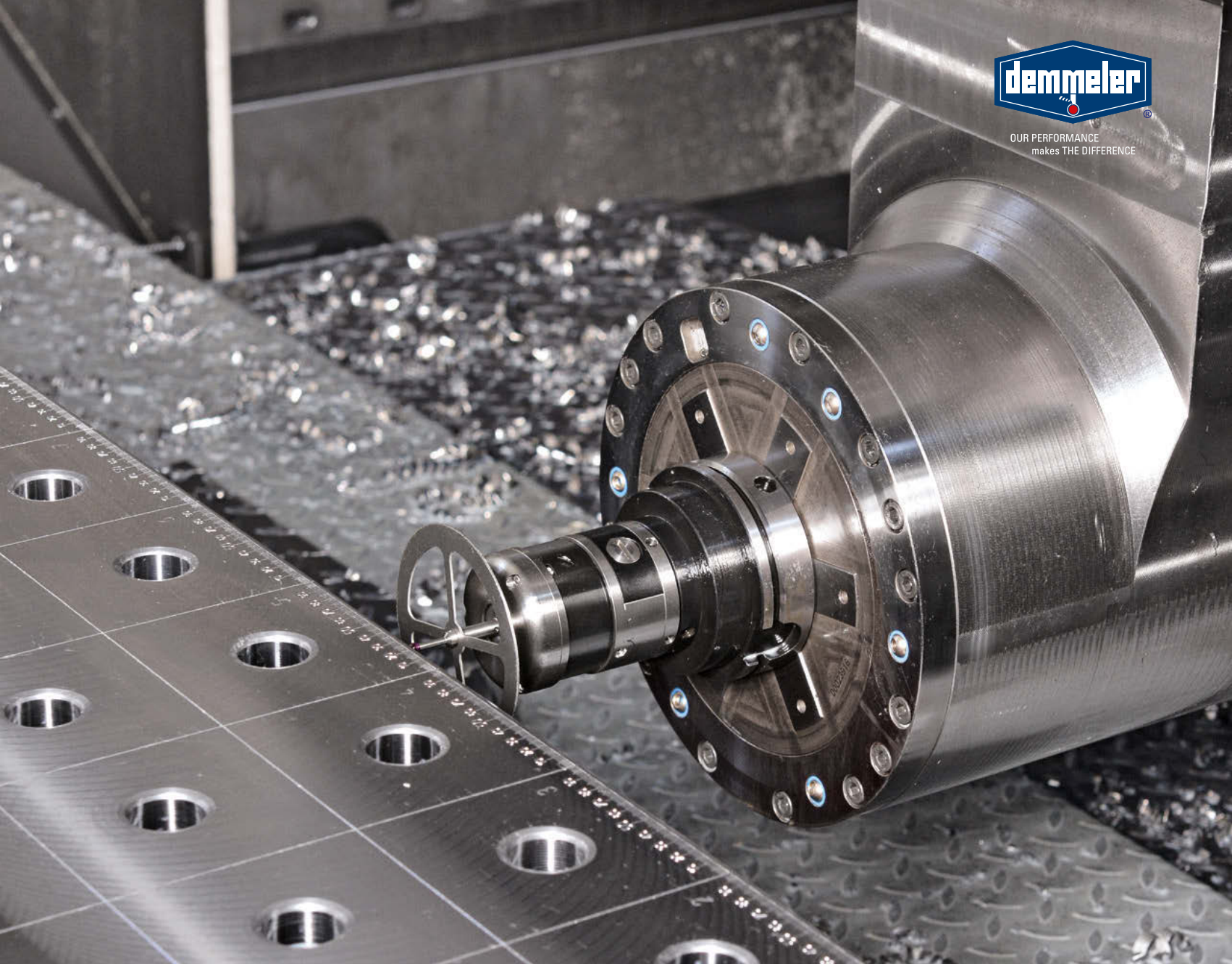
The highest "made in Germany" quality



"Made in Germany" is now regarded as a seal of quality and a sign of quality. We develop and produce exclusively in Germany in order to continuously check and optimise our production processes, i.e. in order to ensure the high quality of our products.

Thanks to our steadily growing and highly specialised team, we ensure that our products will continue to meet the needs of our customers all over the world. The commitment of our employees has already resulted in a number of ground-breaking industry innovations.

The personal and professional development of our employees as well as the advancement of the next generation of young talent is crucial for us. We offer interested and committed graduates an attractive career entry with training with excellent prospects for the future. Trainees are involved in project work from the outset, obtaining an integrated overview from planning to development to production and assembly.



Precision redefined

We set high standards for our production, since it forms the basis for our excellent quality products. Only the best is good enough. We only use materials from certified suppliers, which is a crucial requirement to consistently guarantee a consistently high production quality.

Ultimate precision is a key quality characteristic of our products. That is why we place the utmost value on the dimensional accuracy of all parts that leave our plant. We rely on the latest generation of measuring tools and test systems: 3D coordinate measuring machines, laser measuring systems and optical test equipment.

In addition, DEMMELER complies with the ISO certification DIN EN ISO 3834-2: 2006, comprehensive welding quality requirements in both serial and individual production. Using robotic systems makes it possible to produce large series components up to 26 m in length extremely efficiently and with great precision.

This all forms the framework for excellent services. Ultimately, however, each individual employee decides whether to use them or not based on economically decisive factors such as quality and reliability. We also owe our high standard to the experience and day-to-day commitment of our competent employees in all production departments.

Our innovations set new standards

Many companies launch innovations on the market. However, only a very few companies are successful at launching an innovation that has become a standard for the industry. And that's exactly what we did: DEMMELER 3D worktables and clamping systems have become state of the art. Thanks to the modular design with a perforated grid, our worktables can be used absolutely flexibly in specialised small businesses up to well-known large corporations.

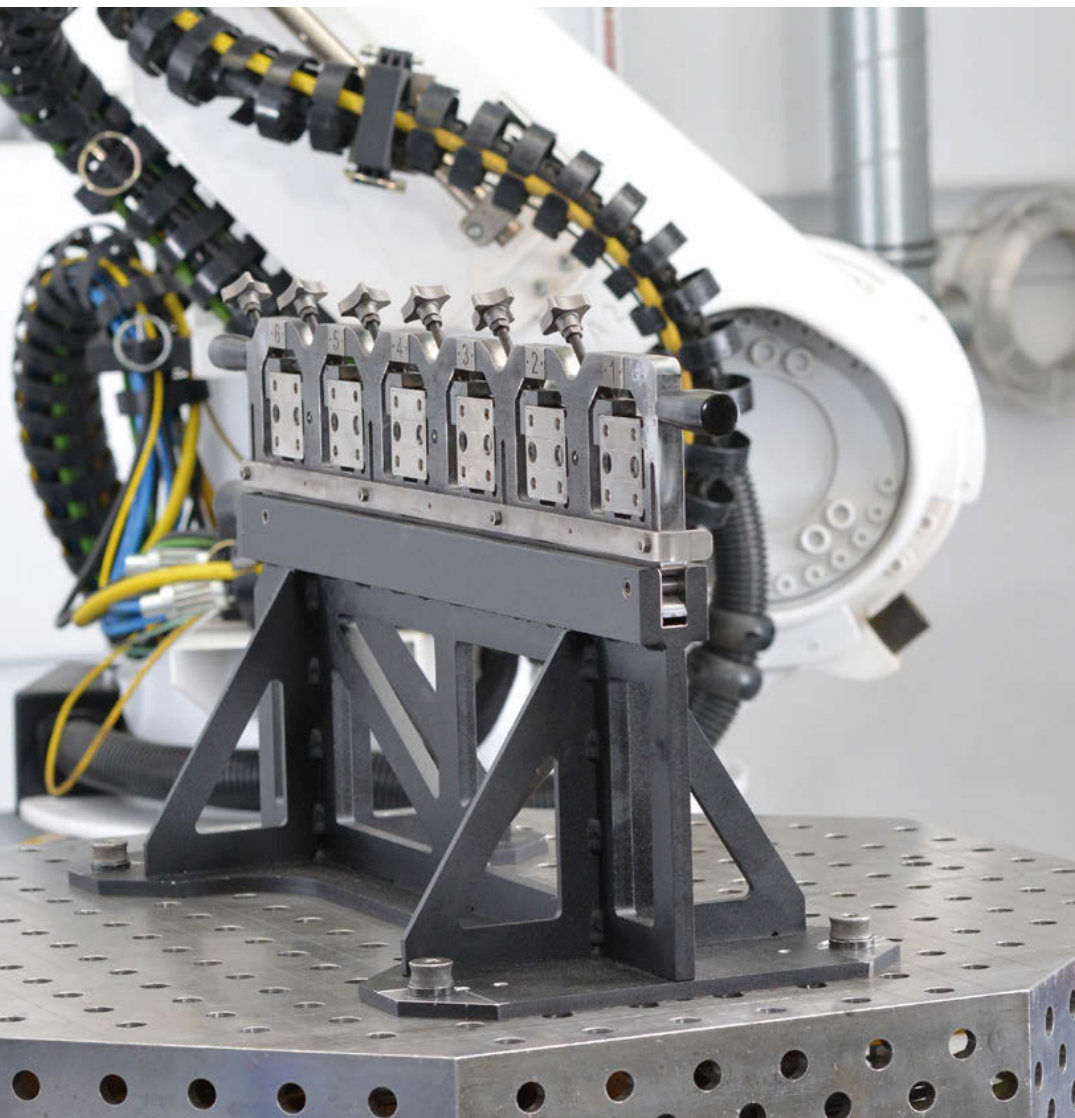
For us, success was never a reason to rest on our laurels, but a motivation to realise new ideas

nobody at first believed in. In the process, we always rely on our knowledge and our experience. We set the standard for the industry with smart products, which significantly increase efficiency and enhance work safety.

Our development engineers consider themselves pacesetters. They do not wait for new requirements of our customers. They observe the market, familiarising themselves with new technologies and methods. How can new process technologies from other sectors be used? Are there new or alternative materials that can

increase durability or reduce production times? What new insights have been gained regarding the ergonomic design of workstations? How can safety continue to be improved?

Our company history has always been characterised by innovations. We significantly increase efficiency and enhance work safety with smart products.



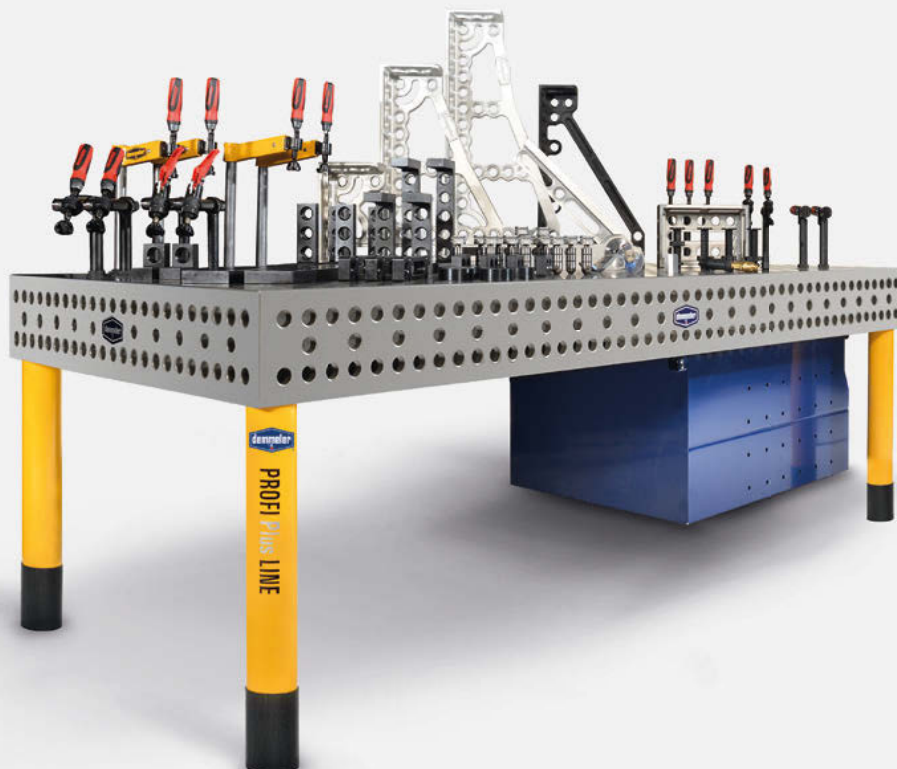
Awarded with the TOP100 seal in 2017, we are one of the most successful innovators in Germany.

Market leadership with strategy and goals

We place great emphasis on the highest quality at a fair market price in the production of our products. We are firmly convinced that investing in a durable, competitive DEMMELER product is far more profitable than the initial savings when buying a cheap imitation.

Our strategy is confirmed by the fact that as a strong partner we are able to count many small and medium-sized trades companies as well as renowned international groups among our customer base.

The outstanding worldwide acceptance of our products and services confirms our commitment to the continued expansion of our unique market share in the worktable systems segment through tireless innovativeness for the benefit of our customers. We are proud to be often copied but never equalled!



We have received numerous awards for our 3D clamping systems and worktables. The system sizes D28, D22 and D16 can be connected to each other. This creates countless areas of application. Thanks to the modular concept, you can set up very complex and accurate fixtures quickly. You can achieve high economic efficiency with all systems for one-off components or series production parts.

Awards: Bavarian State Prize and German Federal Prize.



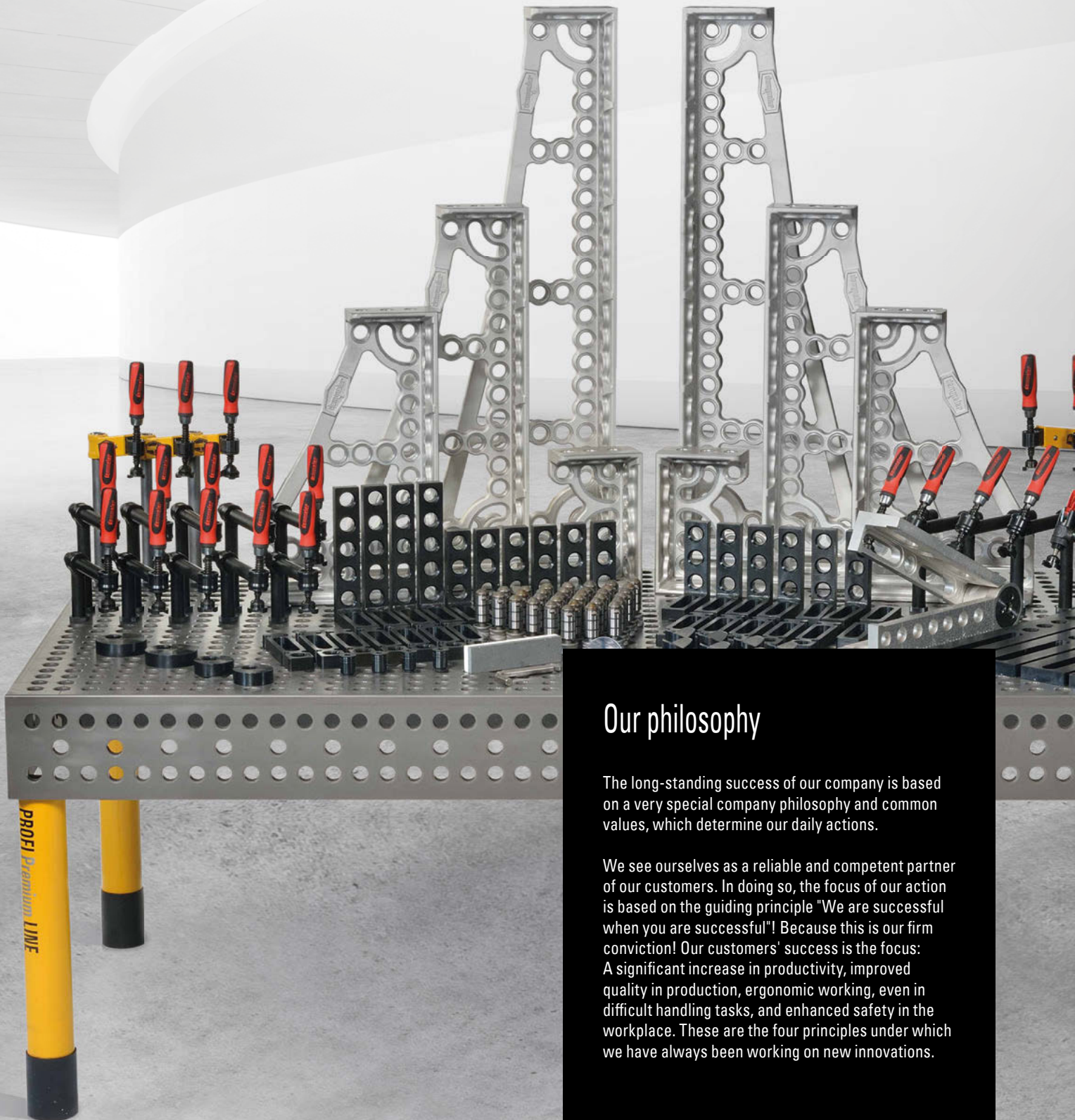
Sustainability and future viability



We are aware of the special responsibility for future generations, especially as a family-owned and operated business. Social and environmental sustainability are more important to us than short-term profit.

We support our employees so that they can take advantage of their opportunities for personal and professional development. In the process, DEMMELER creates room for development opportunities, self-initiative and offers stability: From the promotion of young talent for our trainees to an exciting work environment to a high level of employment security.

We protect our ecological environment by deliberately making our production processes as sustainable as possible. People are increasingly living off of fewer resources. DEMMELER relies on careful raw material selection as well as technical innovations. For example, the company is supplied with its own solar power thanks to its sophisticated energy supply.

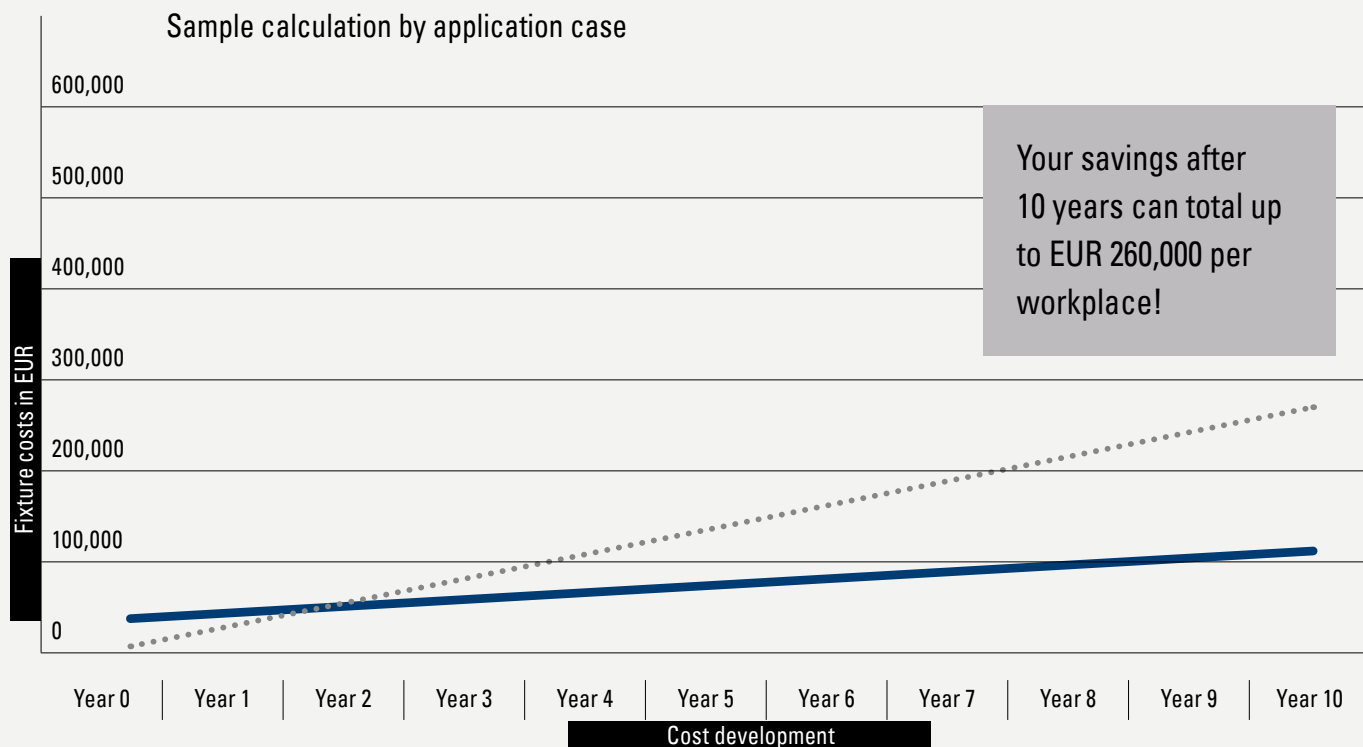


Our philosophy

The long-standing success of our company is based on a very special company philosophy and common values, which determine our daily actions.

We see ourselves as a reliable and competent partner of our customers. In doing so, the focus of our action is based on the guiding principle "We are successful when you are successful"! Because this is our firm conviction! Our customers' success is the focus: A significant increase in productivity, improved quality in production, ergonomic working, even in difficult handling tasks, and enhanced safety in the workplace. These are the four principles under which we have always been working on new innovations.

Long life, fast amortisation – that is our understanding of economic efficiency



LOWER PRODUCTION COSTS

With the acquisition of a clamping system from DEMMELER, you not only receive solid production equipment but also a reliable calculation base. Using your clamping system quickly pays off. And thanks to the long service life and guaranteed compatibility of the tools with each other, you enjoy reassuring planning reliability. The elaborate and costly storage of conventional fixtures is a thing of the past.

INCREASE QUALITY

With our modular system, you can set up your fittings exactly and quickly in a snap: Machine housings, racks, frames, cross members, mounting brackets, railings, stairs, gates, control cabinets, sheet metal coverings and much more can be quickly and conveniently clamped. With this system, you can set and fix the specified sizes for any work piece quickly and precisely. Your individual welded components are clamped at the corresponding faces or points during the tacking and welding process for optimum positioning.



HEALTH
AND
SAFETY

WORKING COMFORTABLY

Ergonomics is an important topic to improve productivity and quality going forward, to prevent expensive downtime and to make production workstations attractive.

A good ergonomic workplace design allows more efficient and error-free workmanship, protecting your staff from health hazards even during laborious tasks. Welding / assembly processes can be carried out with less fatigue and with consistently high precision. Staff shortages caused by overloading and illnesses are also prevented.

WORKPLACE SAFETY

The size and bulkiness of work pieces often create difficulties during welding, because not all points can be seen well. However, an optimal overview is a prerequisite for clean and error-free work. Often, work pieces have to be moved several times during the work process. Because of the dimensions and weights with heavy equipment, this is usually done with a crane.

This safety risk is minimised thanks to our manipulators, a kind of lifting platform on which the work pieces can be machined directly. You can add the DEMMELER 3D 'Okto table' to our manipulators for particularly large and bulky parts. This gives you a working surface that is precisely adapted to your work pieces.



Globally networked

With our worldwide distribution network, we are everywhere our solutions can contribute to more efficient production.

We use on-site consulting to develop tailor-made solutions in partnership with our customers. Always according to the maxim: You have a need, we have the solution!

Our customers around the world benefit from our immense store of knowledge accumulated in numerous successful projects.



A RELIABLE PARTNER ON YOUR SIDE

Our worldwide sales and service representatives are always there for you.
To contact one of our sales partners directly, visit our website at
www.demmeler.com/distribution-partners.



Our service: fast, competent and reliable

Already during the investment planning stage, we help you to find the best economic and technical solution. Our expert consultants on site, the competent sales and development team at the plant and our experienced application consultants are happy to support you. Even after installing our products in your value added chain, we are still there for you. Our modular systems can be adapted to your changing requirements at any time. We are happy to help you with any new questions and

also benefit from your knowledge in the process. We are there for you – with advice and action!

We offer a wide range of support services in addition to our technical and innovative solutions. Take advantage of our comprehensive services, from the service hotline to spare parts deliveries to direct on-site assembly. Short response times are a matter of course.

Practical applications

Best inn Metalltechnik GmbH & Co. KG	22
DB Fahrzeuginstandhaltung GmbH.....	24
EDAG GmbH & Co. KG	26
Edelstahl-Mechanik GmbH.....	28
Stahlbau Füß	30
Goldhofer.....	32
Maschinenfabrik Berthold Hermle AG	36
Formula Student Team Weingarten	38
Intratec Schmock GmbH.....	40
Kaufmann GmbH & Co. KG.....	42
KNOLL Maschinenbau GmbH.....	44
KWM Weisshaar GmbH & Co. KG	46
Liebherr	48
Mauser + Co. GmbH.....	54
Messina Metall Design	56
Metallbau Wolf.....	58
SAMAG Saalfelder Werkzeugmaschinen GmbH...	60
Pascal Selg.....	62
TRUMPF GmbH & Co. KG	64
Zucker Edelstahlschmiede	66
Aircraft industry / fixture construction	70





BEST inn is everything that a successful start-up company in the aluminium welding field should be

The managing directors Mr Eckl and Mr Breu can claim to have revolutionised prototype construction in the field of structures for electric vehicles. While in the past it was necessary to manufacture expensive moulds for one-off or small series and incur very high overhead costs, BEST inn employs welding technology to offer a highly economical solution. However, this demands considerable expertise. This is because the structures of electric vehicles have to be extremely precise and are subject to stringent quality requirements. Alongside the expert knowledge of the founders and their employees, top-quality operating equipment is also essential. DEMMELER's worktable systems and tooling help the company meet the most exacting quality standards. The modular clamping system greatly reduces equipment costs and its high precision ensures uniform high quality and minimum tolerances at all times. BEST inn has acquired an outstanding reputation among the leading automotive manufacturers. This is why Eckl and Breu's concept workshops attract not only leading developers from the automotive industry but also board members from the best-known vehicle manufacturers. A partnership that we can be proud of!



DB Fahrzeuginstandhaltung GmbH
Weilburger Str. 22
60326 Frankfurt/Germany

Clearing the way for greater flexibility and preventive occupational safety



© Deutsche Bahn AG / Kai Michael Neuhold

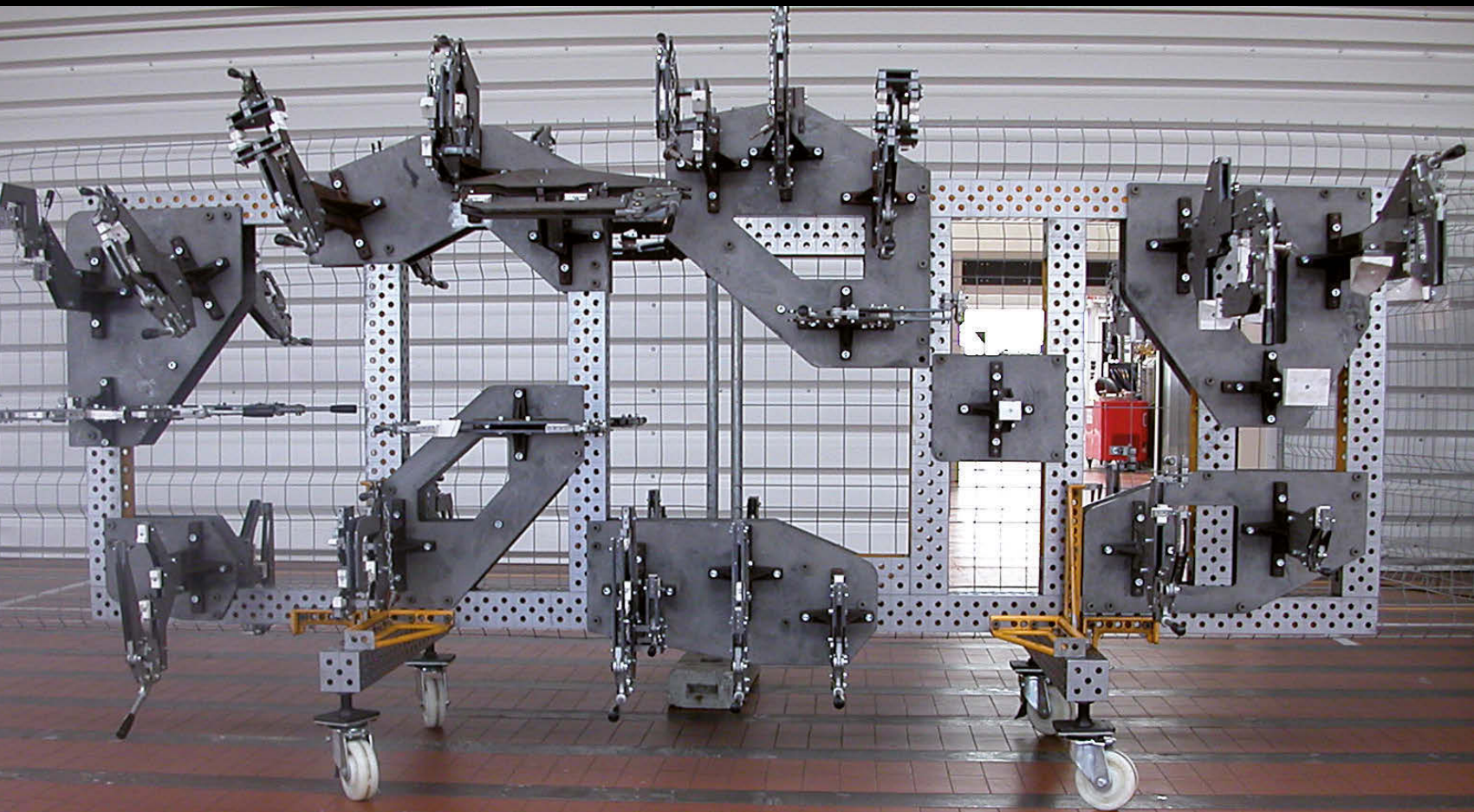
DB Fahrzeuginstandhaltung GmbH offers optimised solutions for the repair and maintenance of rail vehicle fleets. Alongside the modern technology infrastructure in its network of plants and its highly-qualified workforce, the company possesses many decades of know-how that make its range of products and services unique in Europe. Whether technical inspections, modernisation, component preparation or post-accident repairs: The company's expertise covers all maintenance and repair work at rail vehicles and components – from high-speed trains to light rail systems.

Assembling gear sets for urban trains demands flexibility. To ensure quick changeovers of equipment, heavy wheelsets and gearing weighing up to two tonnes must be positioned precisely and securely. Thanks to the large working space coupled with a small footprint, the DEMMELER Ergonomix® M manipulator is the ideal extension to the state-of-the-art production shops. The manipulator, which boasts both angular and height adjustment capabilities, consistently moves even the highest payloads into the ideal position, thus permitting an ergonomic working posture even during heavy handling operations. The assembly operations can be carried out without fatigue and with consistently high precision. Thanks to the patented swivel range of up to 180°, the work pieces can be fully assembled in one clamping cycle without additionally having to be turned over.

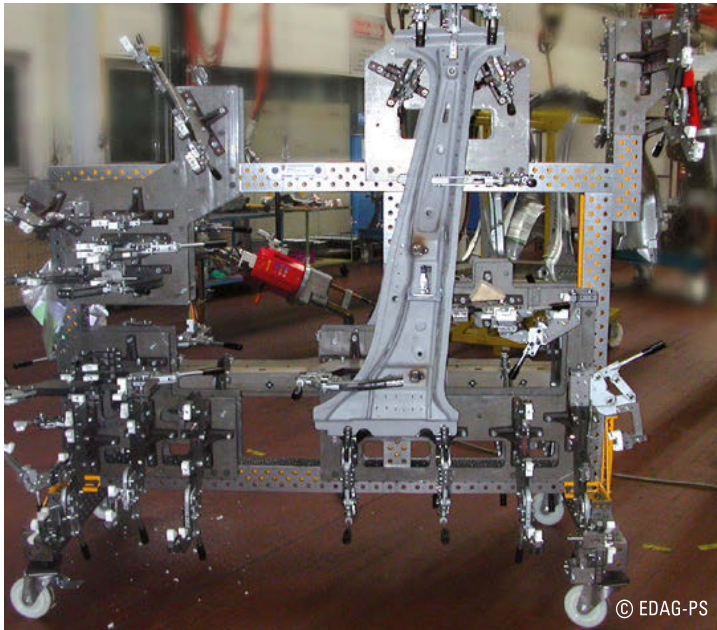




Innovative tools for innovative solutions



© EDAG-PS



© EDAG-PS



© EDAG-PS

EDAG ENGINEERING AG is a globally active development partner for automobile and rail vehicle manufacturers. The experts at EDAG pursue an integrated approach and, beyond conceiving vehicle prototypes, design the corresponding production facilities with the objective of providing effective solutions that optimise value creation.

Developing ideas that overcome existing paradigms, the way EDAG does, requires equipment that can follow these ideas for implementation. In other words: Flexible tradespeople need flexible tools.

With the clamping and worktable solutions from DEMMELER, those in charge at EDAG have found the right workshop equipment for prototype building and plant construction. Especially since the DEMMELER development engineers are willing to explore new ideas and support customers along the way.





Edelstahl-Mechanik GmbH
Gewerbepark Voralb
Bannholzstr. 6
73037 Göppingen/Germany



Everything from a single source



Equipped with state-of-the-art machinery, Edelstahl-Mechanik GmbH is able to cover the entire range of sheet metalworking operations. The Göppingen-based company supplies a wide range of different industries and sectors. Alongside a variety of stainless steels, the company also undertakes the cutting, forming and conventional machining of steel, aluminium and other materials. Its aim is to offer a broad portfolio with a high level of vertical integration. From simple cuts to length through to complex assemblies including engineering services – all from a single source. In addition to all this, Edelstahl-Mechanik has also developed its own products. The company is considered to be one of the outstanding innovators in the field of smoking ovens. As a result, its products are found in mass-catering kitchens and Michelin-starred restaurants worldwide.

To perform its precision-welding operations, the company uses the modular 3D worktable and clamping system from DEMMELER. Oversize welded parts, for example for façade construction, are manufactured at large-scale welding stations. Using the DEMMELER track system, multiple 3D worktables are linked together to form a large working area of up to 24 x 4 m. The high-precision grid system, which is recessed into the floor, permits the exact arrangement of the worktables. In this way, Edelstahl-Mechanik GmbH achieves outstanding precision and reproducibility and is one of the market leaders in its sector.





Flexible solutions for flexible steel construction

Stahlbau Füß produces steel structures of all kinds on over 500 m² of space. Hall construction for renowned industrial customers in the region is a focal point. Stairs, balconies and sophisticated custom structures are also produced for private applications. For municipal clients, Füß realises bicycle and pedestrian bridges among other things.

This broad service portfolio not only requires experienced planners and technicians but also machinery and equipment that is flexible enough so that railings can be produced one day, followed by supporting structures for halls the next.

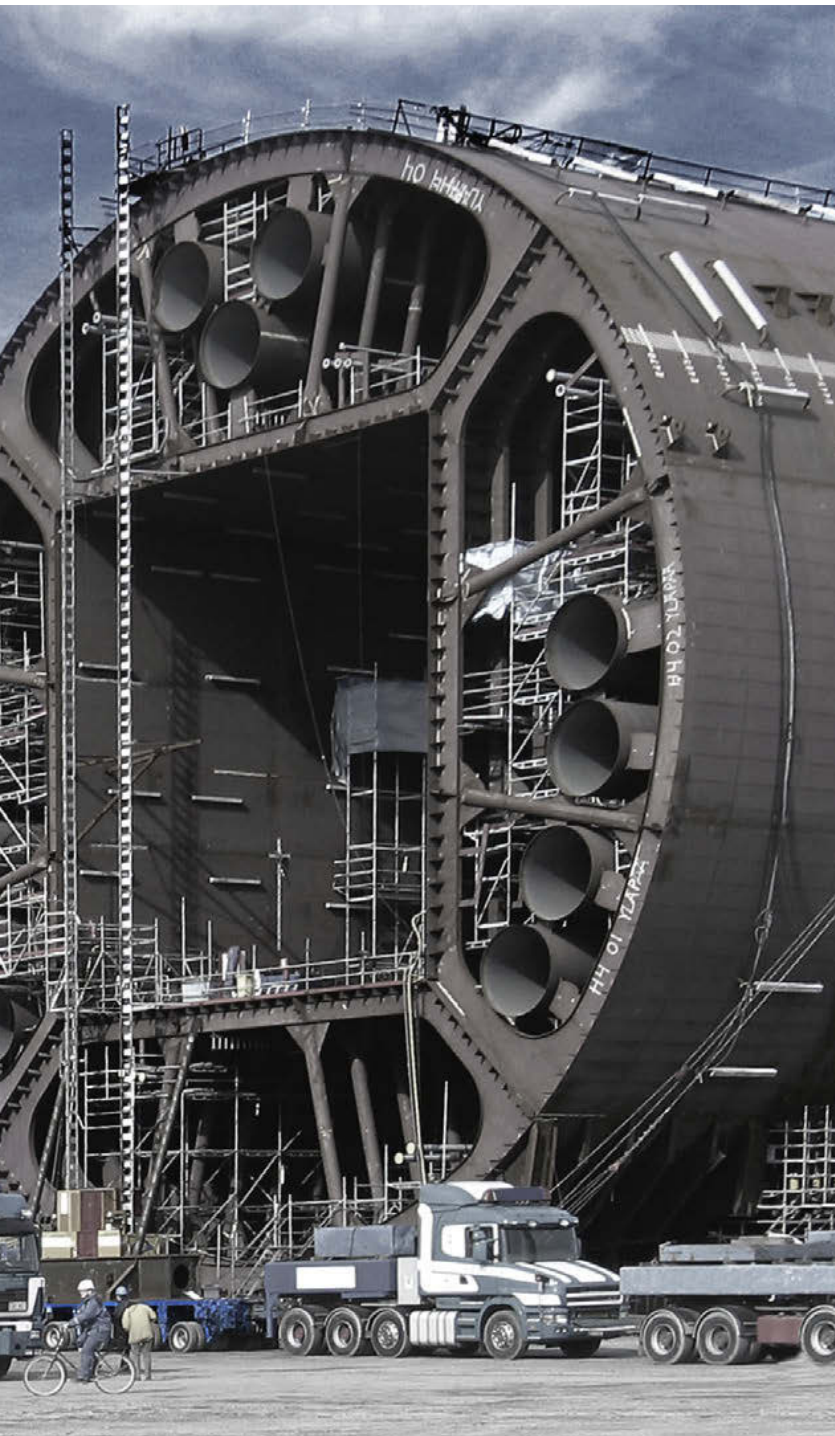
Stahlbau Füß has been building on and with system tables and components from DEMMELER for many years. The sophisticated and flexible system of tables and accessories has proven itself many times over. Should the limits of feasibility nevertheless be encountered at times, the developers and consultants at DEMMELER are ready to contribute their technical expertise and experience, identifying possible solutions.

For sophisticated steel construction and the implementation of unusual ideas at marketable conditions, owner Peter Sikora at Stahlbau Füß counts on machinery and equipment from DEMMELER.



Goldhofer – an eventful history





The global player from the Allgäu looks back on a long company history defined by passion, experience and innovativeness in the field of road haulage, heavy-duty and special transport solutions. Goldhofer enjoys world renown thanks to the perfect integration of road, rail, marine and air transport. Efficiently and reliably mastering extreme challenges defines the company's day-to-day business.

BIG, BIGGER, GOLDHOFER – the Swabian company continuously pushes the limits of feasibility according to this motto. With modern design and production technologies, Goldhofer realises trendsetting and economical transport solutions ranging from trailers to semi-trailers, from aircraft tugs to modular heavy lorries.

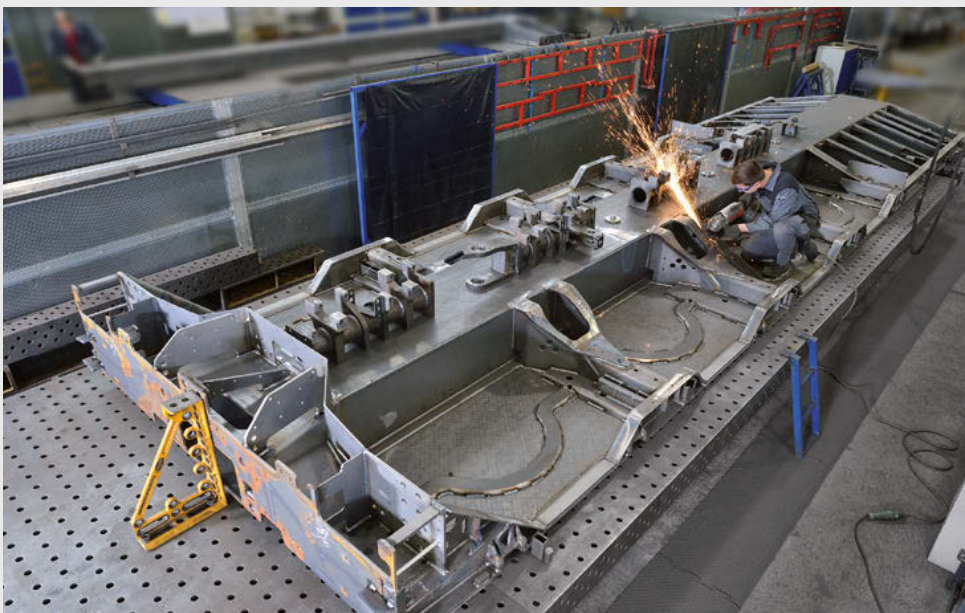
“Heavyweights” for heavy-duty applications



© Goldhofer

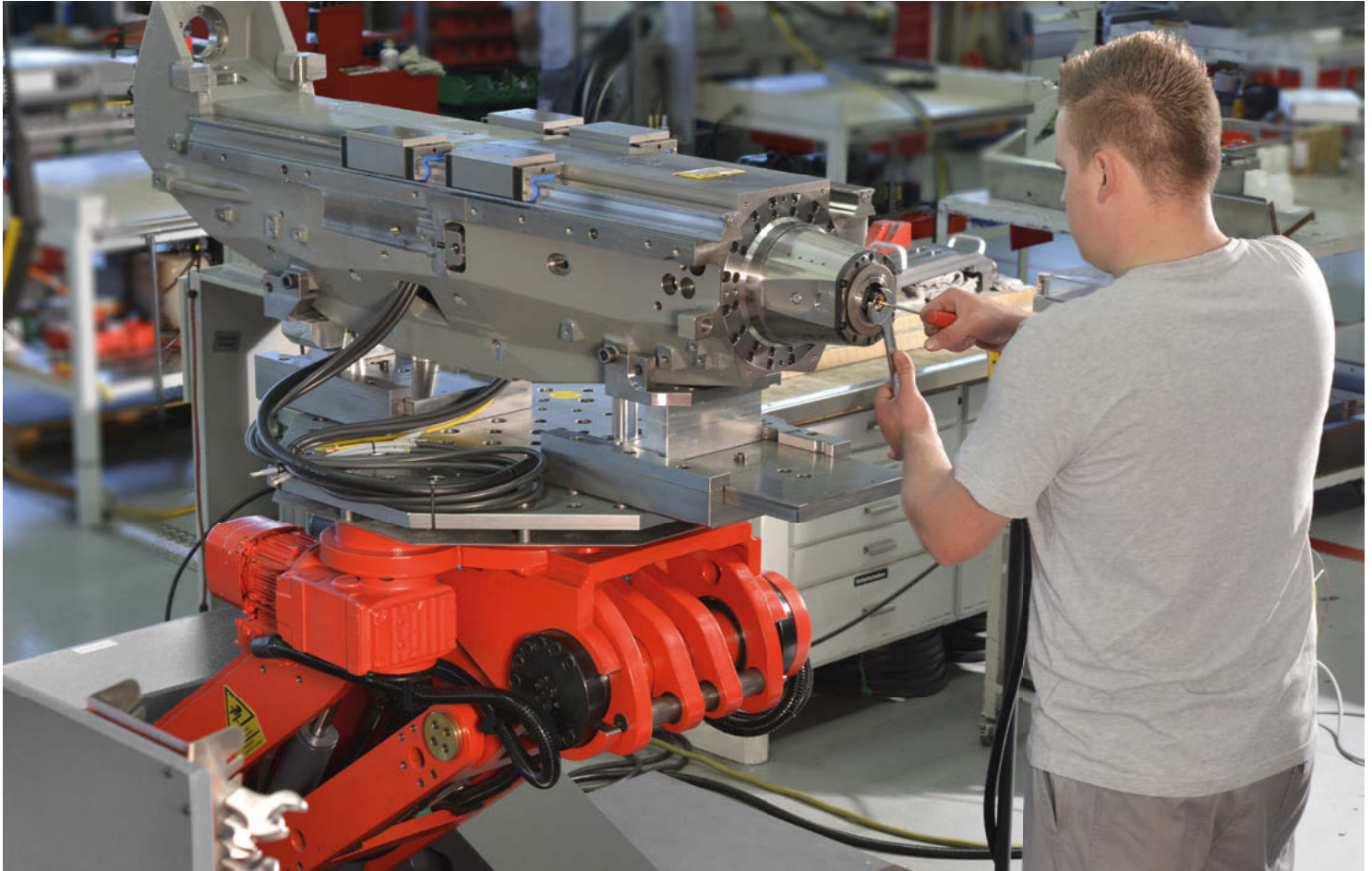


© Goldhofer



The vehicle components in Goldhofer products are true heavyweights. Manufacturing them requires clamping systems with extreme load capacities that are flexible in combination, mobile and can be positioned automatically. A task that literally cannot be taken lightly. Truly a challenge – even for us at DEMMELER as a manufacturing equipment supplier.

Goldhofer is one of the DEMMELER customers using the entire product range from simple worktables to shifting feet and rail systems to manipulators – respectively also in custom versions. Production at Goldhofer provides a quasi overview of the numerous possible applications for the DEMMELER solutions.



Hermle – a name that stands for high-precision processing centres around the world!

With around 1000 highly motivated employees, Hermle is among the leading manufacturers of high-precision processing centres and automation solutions, assuming a leading national and international position.

Better machining is the Hermle slogan for optimised results. This is because the proverbial Hermle precision has made the company an important machine manufacturer in many industries. From large, complex components to miniature high-tech elements. From medical technology to the sport of racing, the Swabian manufacturer proves its know-how day after day.

Based on customer requirements and the concrete components being produced, Hermle also develops comprehensive solutions with perfectly harmonised tools, controllers and automation technologies.

DEMMELEER Ergonomix® M makes work easier! Productivity, precision and innovation are key characteristics of all Hermle products. Naturally this also applies to in-house production. The patented Ergonomix® M manipulator with a swivel range of 180° is capable of the reproducible positioning of components weighing up to 1.5 tons in assembly. Multiple, time-consuming rotating

and turning of the work pieces, for example with a crane, is eliminated for a major reduction in non-productive time. The proven DEMMELEER worktable systems with ergonomic scissor lift are used in welding as well.

Mr. Hipp (Head of Marketing at Hermle) also emphasises that the manipulators relieve the workers of heavy handling tasks and enable working with an ergonomic posture. Assembly work can be carried out with less fatigue and consistently high precision. Excessive strain and missed time due to illness are prevented as well. Many good reasons that speak in favour of the DEMMELEER manipulators.



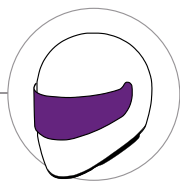
C60 U



© Hermle



© Hermle





Facing the new race season with "Stinger17"

Over a period of many months, the students in the Formula Student Team Weingarten designed, engineered and built their new racing car, the "Stinger17". Now the vehicle has been officially presented for the 2017 season. The forthcoming competitions will show whether it can prove its worth against international competitors and, if possible, thoroughly outclass last year's model, the "Stinger 16", which has been the Formula Student Team Weingarten's most successful racing car to date.

Since 2008, this student project has combined theory and practice by getting the students to go beyond their learned knowledge and gather practical experience. Over the course of a year, they design and build their own racing car in accordance with precise rules. Experts from the world of motor sport as well as from the automotive and supply industries assess the overall package, consisting of engineering, costing, business plan and teamwork.

Since 2015, DEMMELER has been supporting this team, which consists of almost 70 students representing a huge variety of different disciplines. Using the modular 3D worktable and clamping system, the team manufactures the steel tubular grid structures for its racing cars precisely and efficiently. With the D16 system for light to medium applications, the flexible adaptation of the vehicle structure, which is further developed from season to season, poses no problem.



Precision and efficiency in make-to-order and series production

Intratec Schmock GmbH from Weingarten in Upper Swabia focuses on the production of high-quality components for machine building and plant construction. The customers of the midsize enterprise come from a wide variety of industries. Solutions for the pharmaceuticals industry are on the agenda along with make-to-order production for generating plant construction or the series production of customer information terminals, for example for railway operating companies, or components for snow-making equipment in ski regions. The adaptability and scalability of the clamping system is crucial for make-to-order



production. New, individual set-ups have to be realisable quickly and with the required precision. Efficiency along with the highest quality standards is also essential for series production. Here the use of DEMMELER 3D worktables is of crucial importance. The highest dimensional accuracy, including for repetitive process steps, and fast fitting of the work pieces form the basis of high-quality and economical production.

All technology aside, people also need to be considered. Occupational safety along with an ergonomic posture and workstations are key considerations here. DEMMELER clamping systems make a contribution here as well.



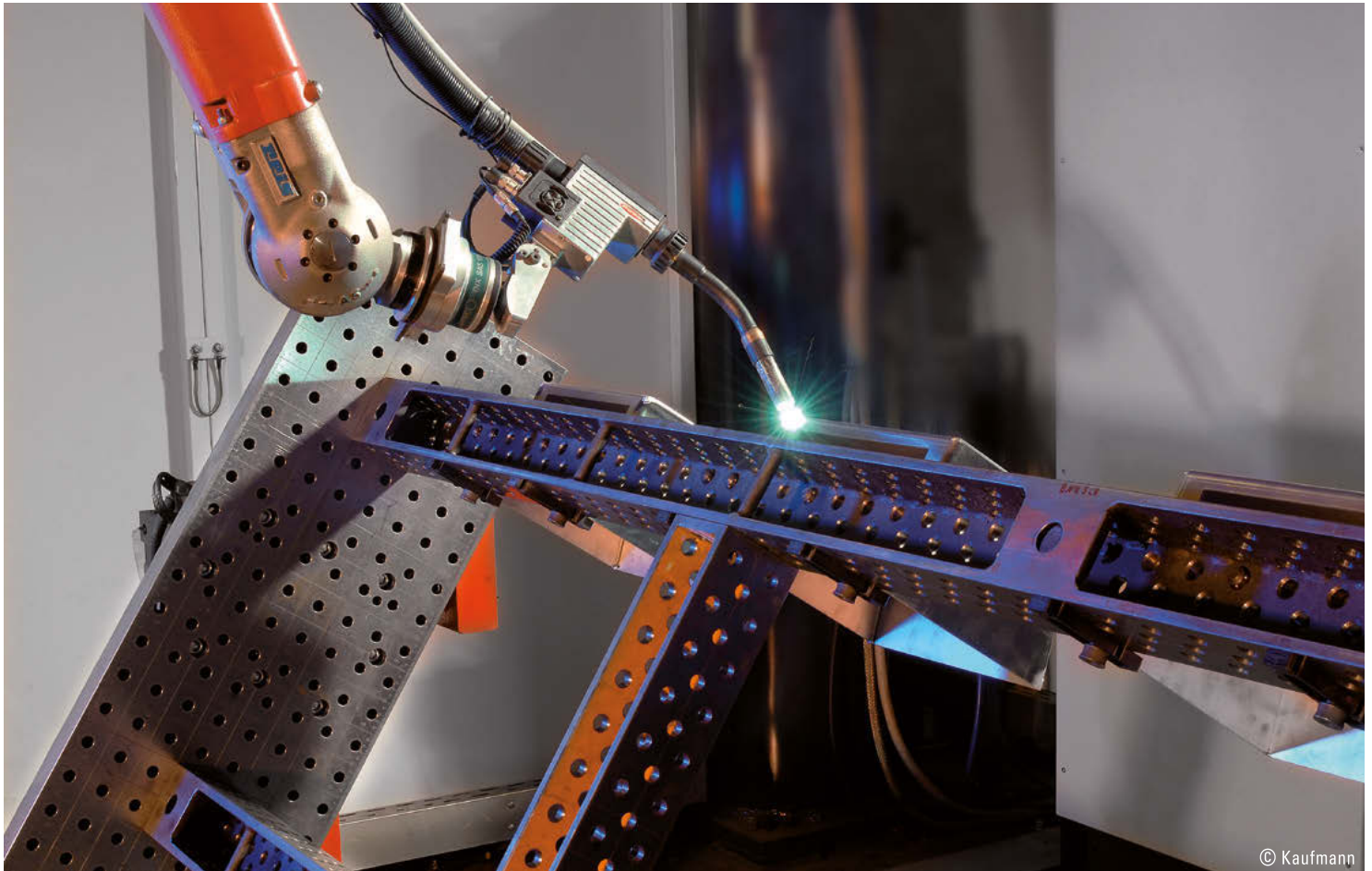
Quality and speed are Kaufmann's special talents

Kaufmann GmbH & Co. KG in Schwegenheim/Germany is active in two business areas: Electrical engineering and metals technology. More than 150 highly qualified employees make products for the rail industry, capital goods industry and the energy sector. Welding various materials such as steel, stainless steel and aluminium assumes an important role in the metalworking process chain. Over 40 tested and certified welding experts fabricate housings, air conditioning systems and driver's cabs for rail vehicles.

For automatic and manual welding, the clamping systems and fixtures from DEMMELER are indispensable for production according to company management. For one thing, the wealth of DEMMELER accessories makes it possible to meet all customer requirements. For another, efficient production at marketable prices can only be realised thanks to the high-precision clamping system.

"Our customers expect all work to be completed on time, from prototype and sample construction to series production. The short setup and changeover times of our clamping tables give us a valuable competitive advantage here."

(Uwe Distler, Head of Metals Technology)



Complex solutions require complex tools

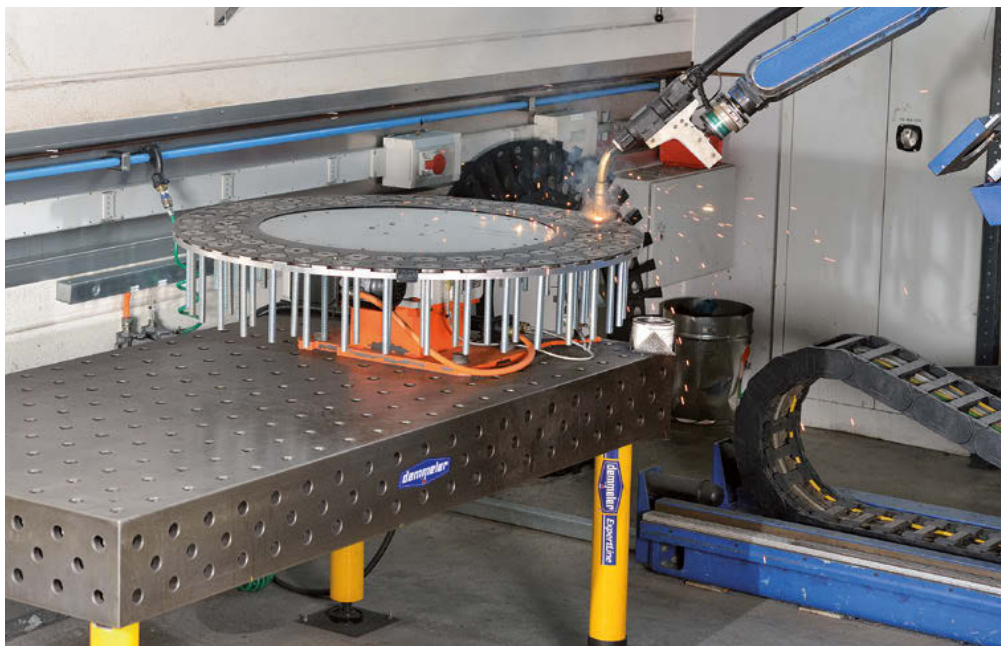
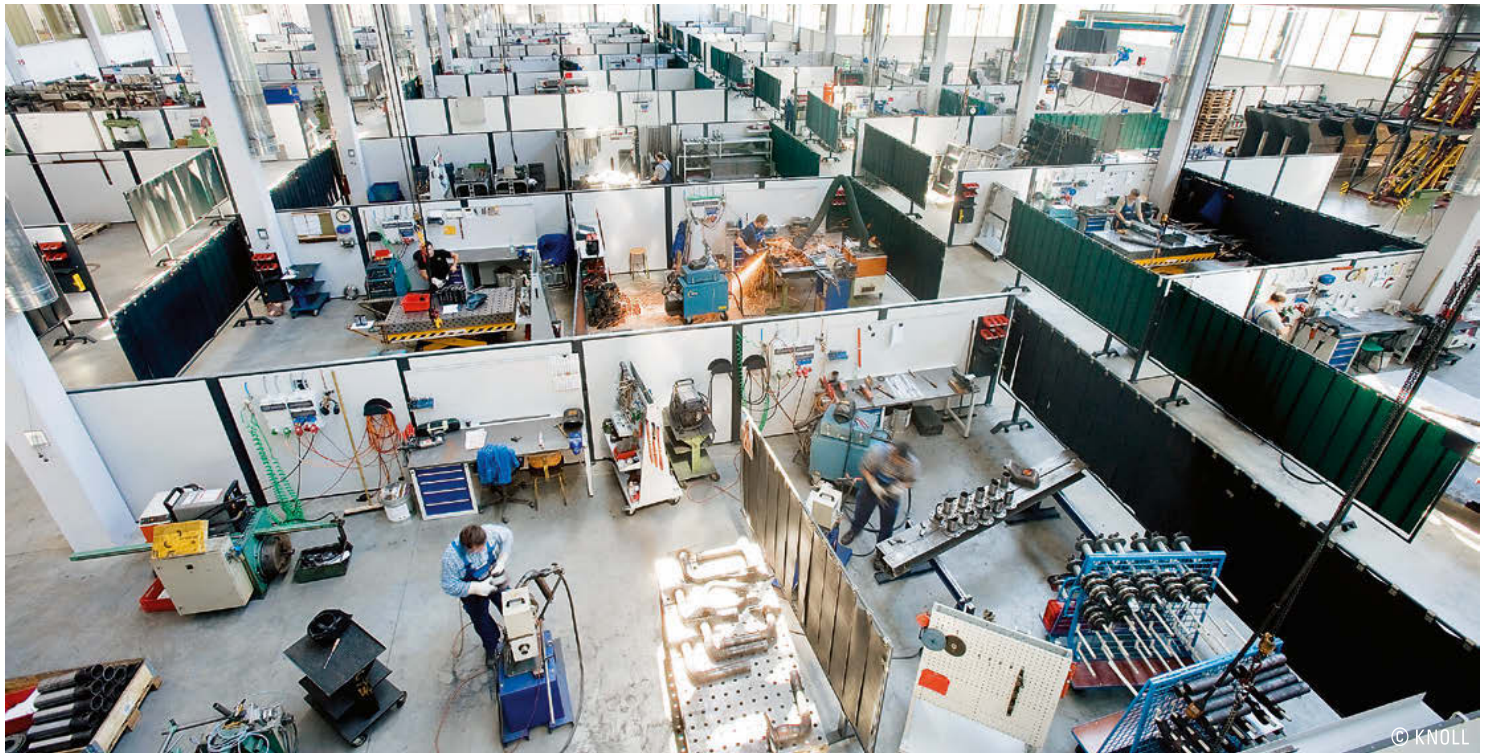


© KNOLL

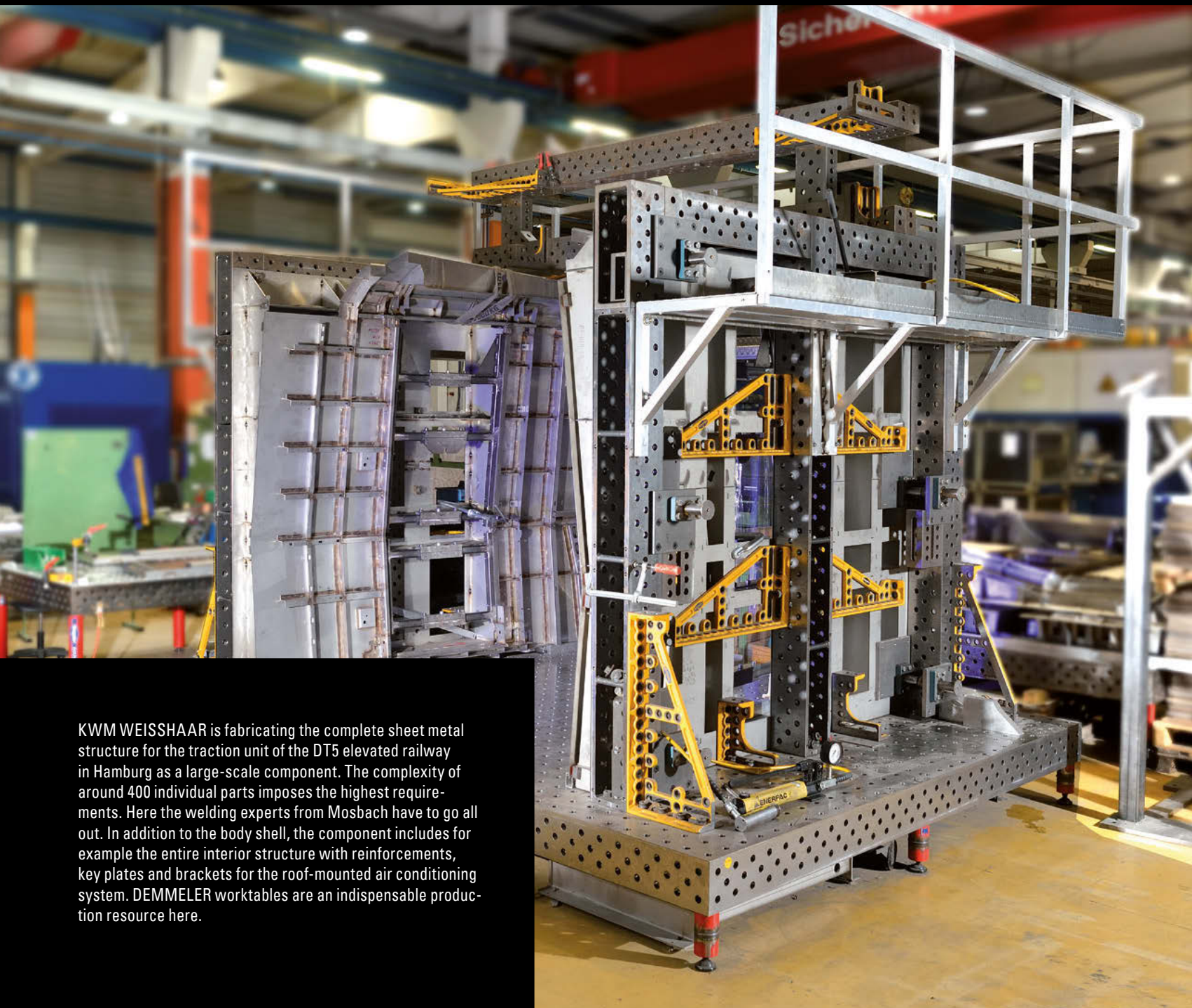
Innovative solutions and quality ensure the success of the company, thereby providing secure jobs for the 1,000 dedicated employees of KNOLL Maschinenbau GmbH in Bad Saulgau, Upper Swabia. From here the KNOLL products have been conquering the global markets in the mechanical engineering, automotive, chemicals, pharmaceuticals and food sectors for almost 50 years.

Knoll Maschinenbau is among the leading suppliers of conveying and filtering systems for chips and cooling lubricants in the field of metal processing. Displacement pumps are also used in the chemical and food industries, for example. Highly flexible assembly and transport systems complement the Knoll product portfolio. Complete plants and system solutions with central and decentral-

ised functions are realised with a comprehensive product range. Complex solutions require complex tools. Meeting individual customer requirements demands machinery and equipment that can be quickly adapted in terms of function and size. This is where the Demmeler clamping systems are of crucial importance. Since the various table types can be combined with each other and expanded as desired with numerous components, KNOLL is very flexible when it comes to the dimensions of individual components. Optimum positioning of the work piece not only makes work more accurate but also more effective. How important an ergonomic posture at work is for the employer and the operation does not even have to be mentioned. Demmeler solutions make a contribution to greater economic efficiency and better health as well.



We shape everything made of sheet metal.



KWM WEISSHAAR is fabricating the complete sheet metal structure for the traction unit of the DT5 elevated railway in Hamburg as a large-scale component. The complexity of around 400 individual parts imposes the highest requirements. Here the welding experts from Mosbach have to go all out. In addition to the body shell, the component includes for example the entire interior structure with reinforcements, key plates and brackets for the roof-mounted air conditioning system. DEMMELER worktables are an indispensable production resource here.

KWM WEISSHAAR offers the entire process chain for sheet metal processing to its customers: Engineering, sheet metal processing, joining & welding, assembly and logistics. With more than 500 employees, the operation in Mosbach, Baden-Württemberg fabricates orders for the automotive industry, mechanical engineering, medical technology, electronics and environmental technology.

The construction of chassis elements for rail vehicles is a focal point of production. Here delicate side wall modules using rib-sheet construction are increasingly replacing the massive pillar-support structures of the old designs. This is due among other things to higher customer expectations for reduced energy consumption, similar to the automotive industry. (Quote: Andreas Bödi; Master Metalworker aluminium / steel / stainless steel).

In order to weld these complex assemblies to the exterior wall of the rail cars, they are fabricated and assembled on DEMMELER worktables. Minimal dimensional tolerances and the highest repeat accuracy are absolutely essential here. Since up to 50 variable design details have to be implemented for the various rail car components, the clamping system requires extremely versatile accessories that are flexible in application.


"The developers and consultants at DEMMELER are by our side with all their experience when we need them. Since all fixtures are in continuous use, the high wear resistance of all system components is an important quality factor for us." (Quote: Karl Weisshaar).

With more than 100 different worktables in total, DEMMELER practically forms the backbone of production at Weisshaar. Since the systems of different generations are compatible and can be combined with each other, the decision in favour of DEMMELER established the direction for the future and was meaningful not only from a technical but also from a business management perspective.



LIEBHERR

Liebherr Werk Nenzing GmbH
Dr. Hans Liebherr Str.
6710 Nenzing /Austria



Sometimes a good idea is all you need
to get things moving.

Liebherr AG is a world leader for perfect solutions to precisely lift heavy loads. The yellow cranes in many different versions are used on construction sites, in factories, container terminals and offshore applications. From tower cranes for high-rise building construction to tracked cranes for wind turbine installation, all models have one thing in common: They safely lift heavy loads up to 2000 tons with precision.

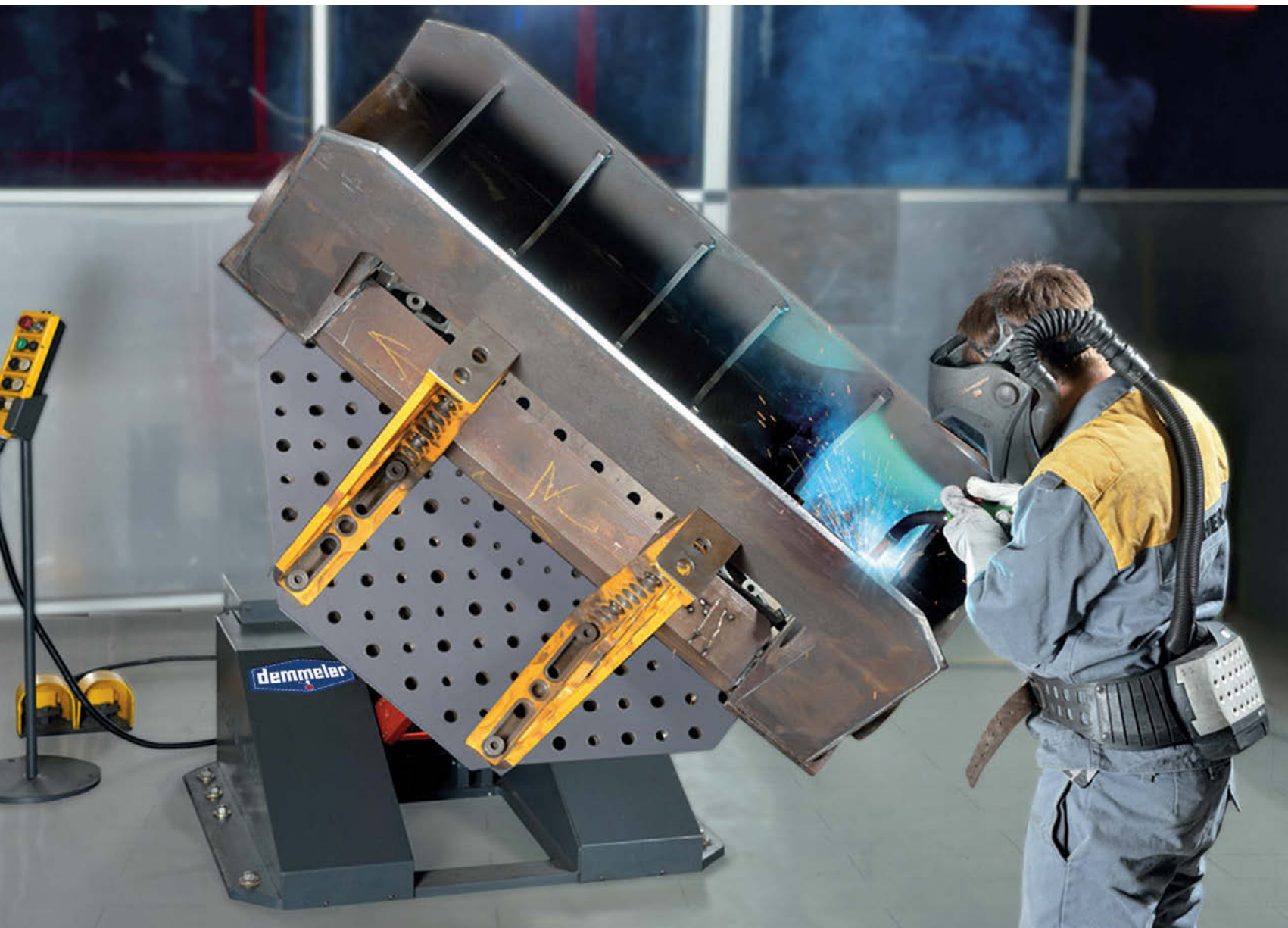


Precisely moving heavy loads – a Liebherr and Demmeler speciality



When tons of weight hang on a hook, massively constructed crane components are essential. This is a tremendous challenge for the production of Liebherr cranes. Heavy work pieces must be moved effectively, safely and exactly. This is precisely what the Demmeler manipulators were designed to do. Not only do they enable an

effective manufacturing process, they also create an ergonomic workplace. An optimum working position prevents fatigue and thereby ensures quality – preventive occupational safety that pays off.



Modular and shifting clamping fixtures

Economical lattice mast production can be realised with the DEMMELER 3D clamping system.



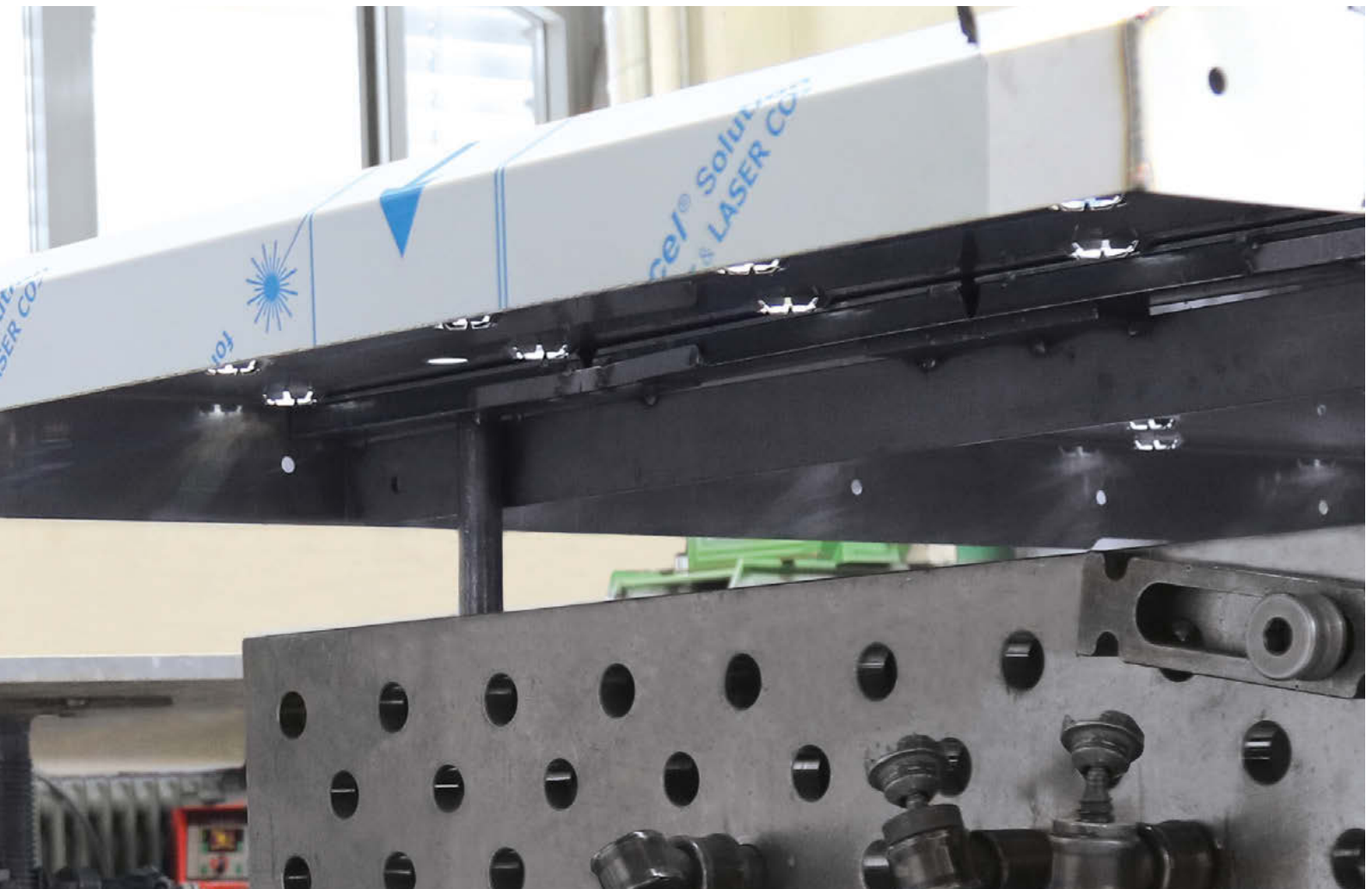


We are passionate about sheet metal

For four generations, Mauser + Co. GmbH has been all about sheet metal. Whether stainless steel, aluminium, cast aluminium or titanium – thanks to state-of-the-art welding technology, the DEMMELER 3D clamping system and experienced employees, this specialist for modern sheet metalworking is able to join together practically any material. The top priorities of the Ditzingen-based company are quality and reproducible precision. The challenge is to deliver ever better, reproducible welding results while simultaneously minimising production costs.

Traditionally, the company has always adopted new technologies at a very early stage. And this willingness to innovate has proved its worth. Thanks to the DEMMELER 3D clamping system, Mauser can respond flexibly to its customers' requests. Mauser is a much sought-after partner both for series contracts and for the manufacture of one-off parts. With DEMMELER's modular clamping system, the company is able to complete every manufacturing job – whether it involves welding, assembly or adjustment – efficiently and at top quality, even when highly complex parts are required. It is therefore ideally positioned to meet the demands of today and the needs of tomorrow. For Mauser, quality has always been and will continue to be the topmost priority.

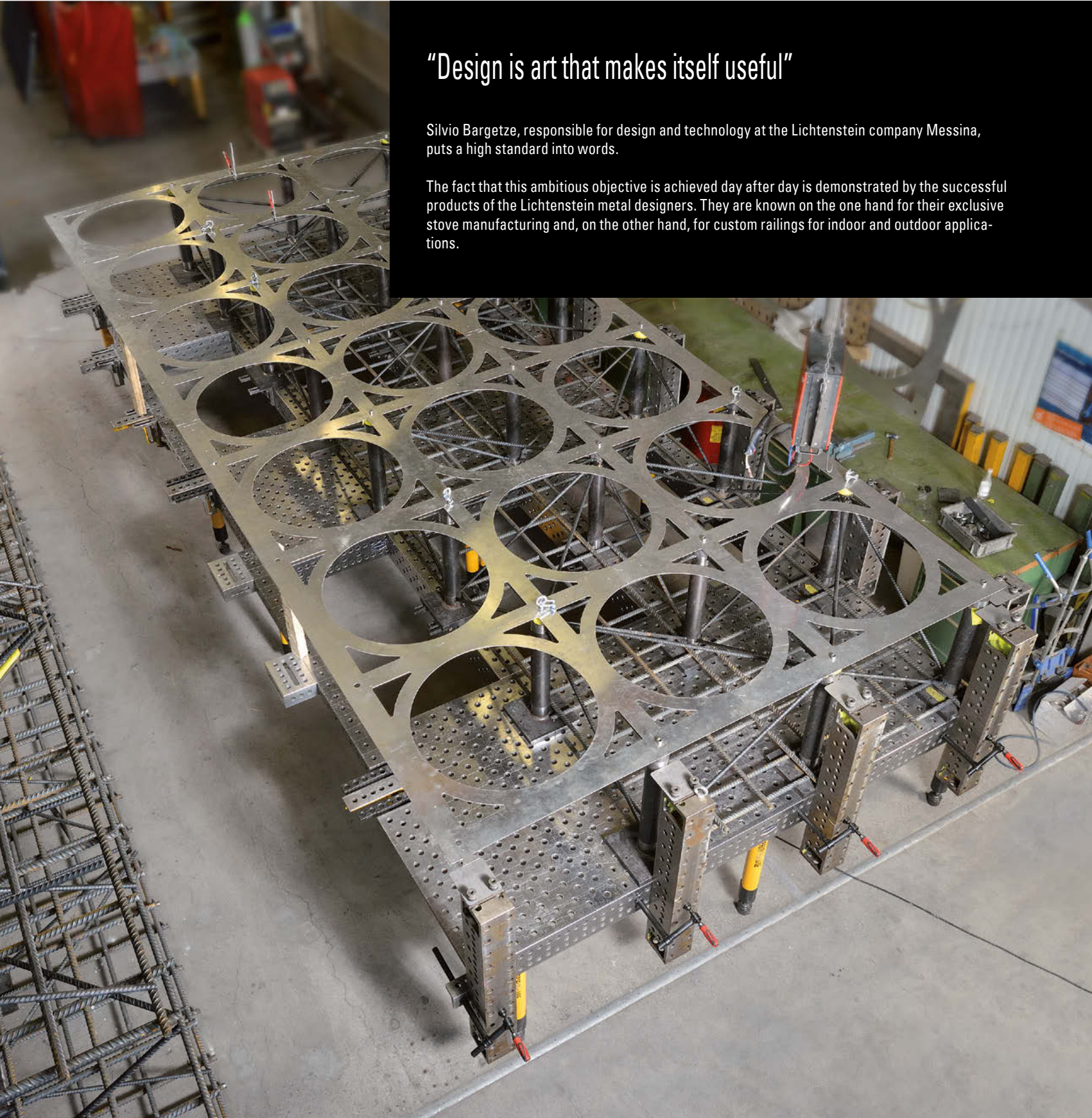




"Design is art that makes itself useful"

Silvio Bargetze, responsible for design and technology at the Lichtenstein company Messina, puts a high standard into words.

The fact that this ambitious objective is achieved day after day is demonstrated by the successful products of the Lichtenstein metal designers. They are known on the one hand for their exclusive stove manufacturing and, on the other hand, for custom railings for indoor and outdoor applications.





Realising unusual projects not only requires ideas but also equipment that makes their exact implementation possible. "Design limits and DIN standards place enough restrictions on our creativity already. We have to make sure that we are able to realise our full potential in production," Bargetze explains. That is why Messina counts on clamping systems from DEMMELER. They support any railing design, no matter how convoluted, and guarantee that the tightest tolerances are met thanks to their extreme dimensional accuracy.

Efficient production is also important in the high-priced segment of exclusive stoves in order to be competitive.

THE BEGINNING: Good training and a table from DEMMELER!



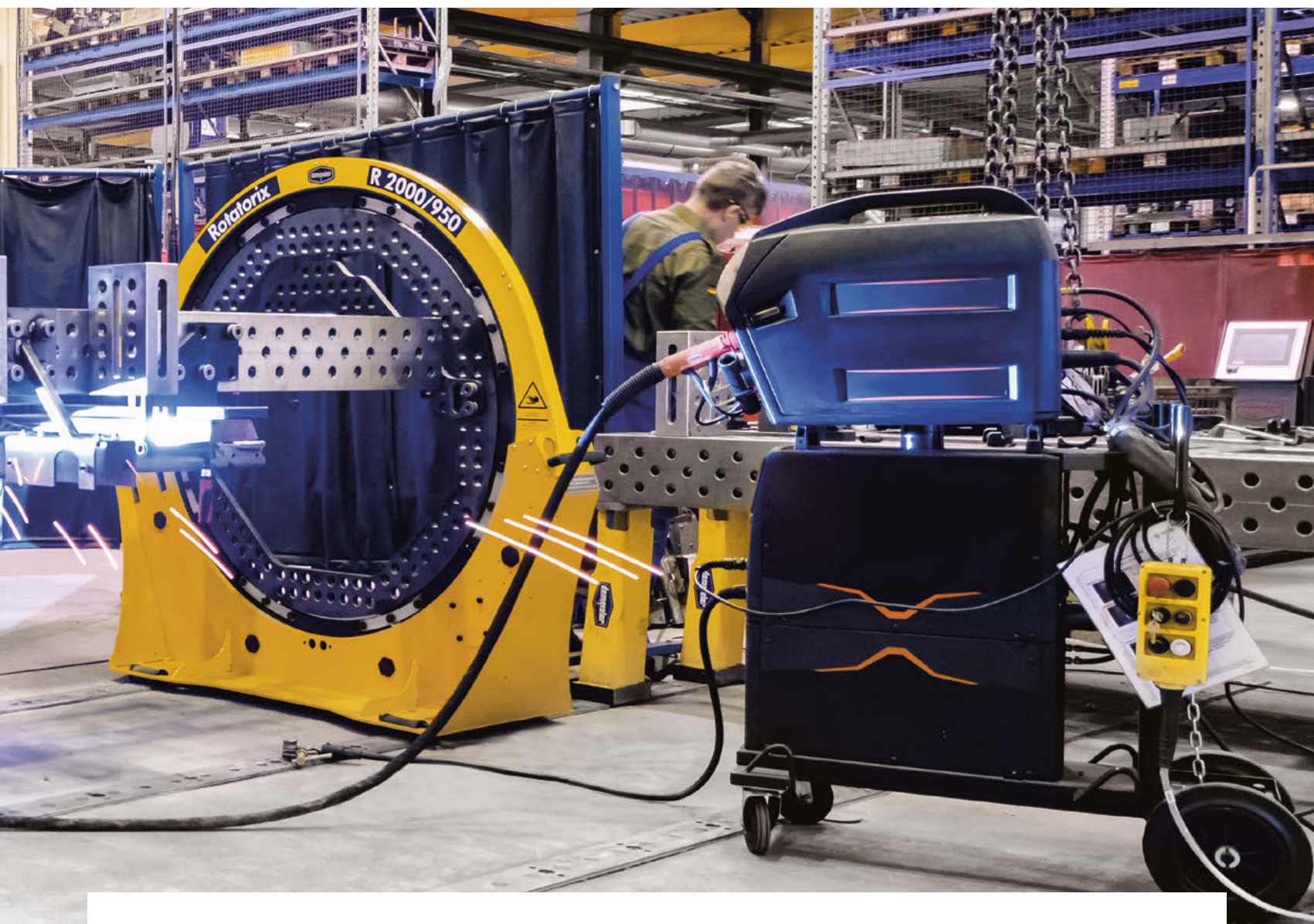
"DEMMELE FROM THE OUTSET – FOR ME, THERE IS NOTHING ELSE!"
(Andreas Wolf, Master Metalworker)

In addition to stair railings, balconies and gates, Master Metalworker Andreas Wolf produces custom pieces for many different applications in his workshop. The variety of tasks is the best way to avoid a monotonous routine on the one hand. On the other hand, it puts the highest demands on the flexibility of people and production facilities. One grows with the task – which not only applies to people but also the workshop equipment. So it

really pays off to have an outfitter from day one who offers several system series, all of which are compatible with each other. The DEMMELE system grows with your company. A seemingly endless selection of accessories is just as important. It may even seem as though the tool developers at DEMMELE were able to foresee the ideas of planners and design engineers, since a tool already exists for any conceivable task.







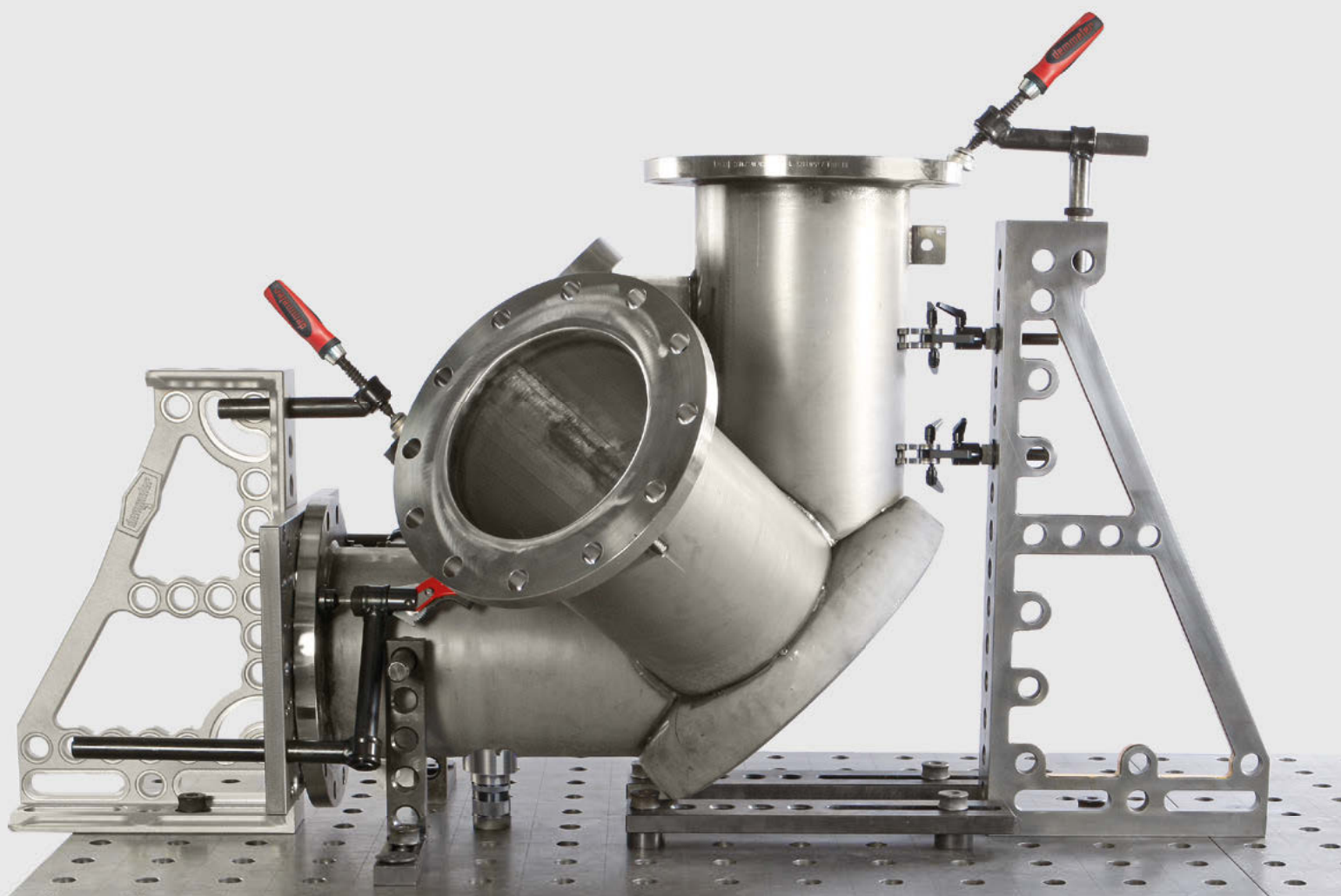
Strong down to the last detail

More than 700 employees, 3 production sites in Germany, many years of experience and great innovative strengths: The SAMAG Group is strong right down to the last detail. Well-designed, durable machines, innovative procedures and detailed solutions based on wide-ranging engineering skills make the company a long-standing partner to the leading automotive manufacturers. Whether complex assemblies such as HGV chassis, bus rear-axle mounts or demanding cast and forged parts for engines and gears. All this is based on more than 140 years of experience coupled with state-of-the-art technologies.

At its site in Rottenbach, SAMAG Truck Components GmbH manufactures parts and components for trucks and special vehicles from practically all the best-known German manufacturers. When assembling systems such as load-bearing structures for swap body containers, the company relies on DEMMELER: Thank to the use of the Rotatorix® R 2000 / 950 manipulator, the structures can be continuously rotated about their own axis in just a single clamping cycle. This is the perfect way to achieve optimised work piece access, shorter clamping times, enhanced workplace safety and consistently high quality.

Everything under control

Metallverarbeitung Pascal Selg with its central position in Baienfurt near Ravensburg is a certified welding company as set out in EN 1090-2. In a separate area, the company machines all commonly used materials, from stainless steels or aluminium alloys and on to steel, in all types of products. It focuses on the high-quality machining and welding of components for customers from the plant construction, pharmaceuticals, foodstuffs and loose parts industries as well as on prototype construction, series manufacture and special parts production.





At the same time, the company also designs and manufactures every aspect of lightweight steel constructions and railings for balconies and stairways. Selg places great emphasis on a high level of flexibility and customer proximity. This can be seen in the implementation of planning performed using modern CAD tools as well as in manufacturing operations that live up to its own expectations and are conducted in close cooperation with the customer.

In manufacturing its welded constructions, Selg prizes DEMMELER's wide-ranging portfolio of accessories such as the clamping and locating angles, corner modules, segmented grid plates, clamping equipment, supports and much more besides. These increase precision at the worktable and optimise the quality of the weld seams.

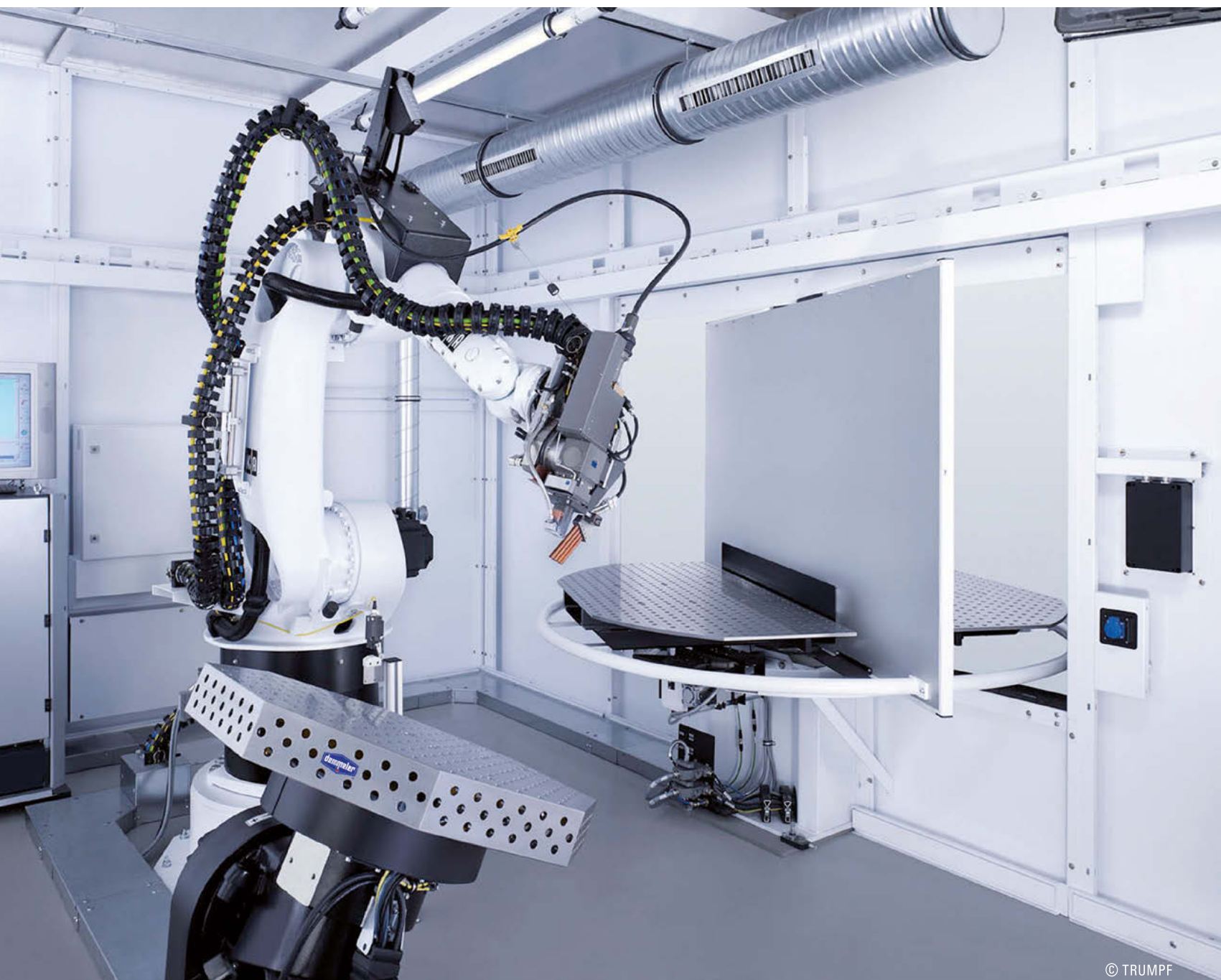




TRUMPF GmbH + Co. KG (Holding)
71252 Ditzingen/Germany
Johann-Maus-Straße 2
71254 Ditzingen/Germany

A good idea demands the right tools

A PRODUCT CAN ONLY WORK WITH THE PRECISION OF THE TOOL USED TO PRODUCE IT.



© TRUMPF

TRUMPF IS THE LEADING HIGH-TECH ENTERPRISE TO FOCUS ON LASER TECHNOLOGY.

Quality products that enjoy an excellent reputation around the world are manufactured in Ditzingen, Swabia. Applications for TRUMPF machine tools and lasers are used in a wide variety of industries, from the automobile industry to steel and sheet metal processing, aviation and aerospace to orthopaedics and medical technology.

TRUMPF places the emphasis on innovation and quality. This requires tools that are flexible in application with short changeover times.

With sophisticated technology and the comprehensive selection of accessories, which is compatible with existing equipment and always being expanded, manufacturing at TRUMPF would be unthinkable without Demmeler worktables.

The readiness of the Heimerting technicians to contribute their know-how, experience and ideas starting with the planning and design process is an invaluable competitive advantage.

MINIMAL DIMENSIONAL TOLERANCES FOR HIGH-TECH PRODUCTS

Precision is an essential characteristic of all TRUMPF products. Which is why TRUMPF counts on Demmeler products in its manufacturing operations. Minimal dimensional tolerances of the Demmeler worktables throughout their service life and the efficient manufacturing possibilities of the versatile systems are fundamental requirements for high-quality production at competitive global market conditions.



© TRUMPF



Zucker
Edelstahlschmiede GmbH
Süßwiesenstraße 4
74549 Wolpertshausen/Germany



Motivated, flexible, close to the customer

The experts at Zucker process all common materials such as steel, stainless steel, aluminium and non-ferrous metals. The product portfolio includes high-quality industrial housings, complex structural components and elaborate sorting systems with the strictest hygiene technology requirements profile for the pharmaceuticals and food industries.



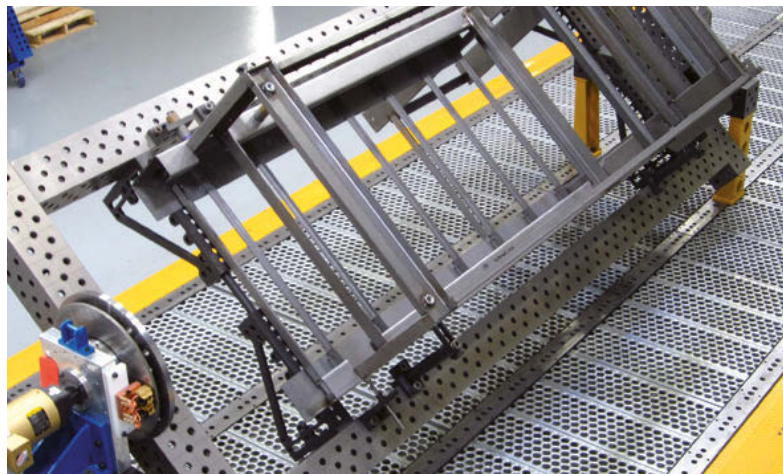
Premium tools for premium steel

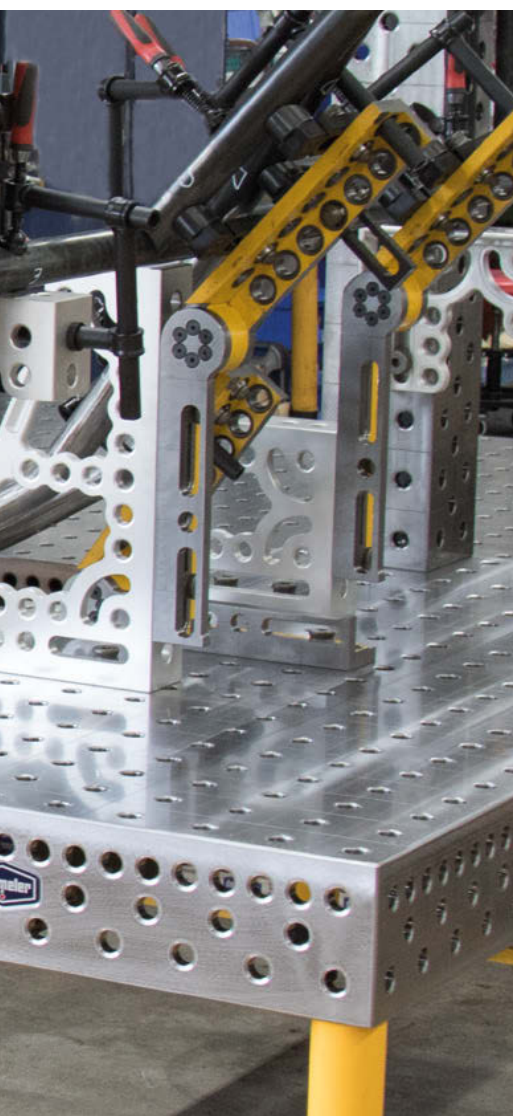


Key success factors for Zucker are flexibility and proximity to the customer. This is achieved on the one hand through motivated, committed employees who proactively contribute their thoughts and experience in every production phase during the entire workflow – from the idea to the CAD implementation to manufacturing. On the other hand, flexibility is ensured by workshop equipment that can respond to individual customer requirements. Here the DEMMELER clamping systems make an important contribution.



Thanks to the varied and sophisticated selection of accessories, even unusual designs can be realised quickly and with minimum dimensional tolerances. DEMMELER worktables have proved themselves ideal for processing soft materials susceptible to scratching. Since weld spatter does not adhere to the premium surface and dirt is extremely easy to remove, flawless processing is readily possible. Thanks to the precise and straightforward handling of the tools, working quickly requires no wizardry. This allows Zucker to act on its maxim: fast, close to the customer, flexible and first-class.







The modular and precise DEMMELE 3D clamping system is ideal for aircraft construction applications. Ours is the most commonly used clamping system in the area of measuring and assembly fixtures.

The highest precision can be achieved easily and cost-effectively with even the largest dimensions.

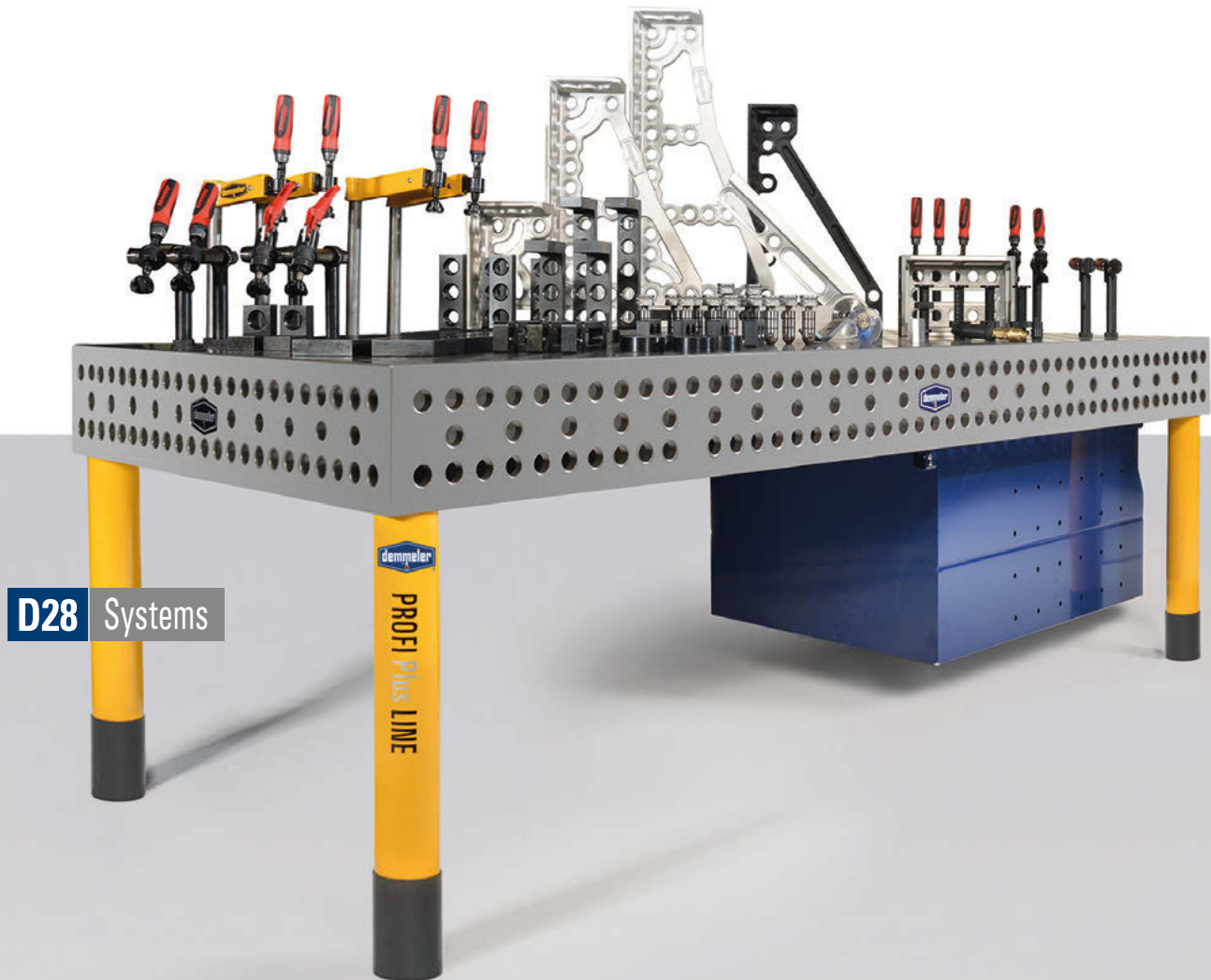




3D clamping system

3D clamping system overview	72
D28 3D clamping system overview.....	74
Benefits of the Demmeler system tables	76
DEMONT 860 M / 760 M.....	78
Leg type variant overview.....	82
D28 table sizes	84
Overview of D28 system table line	86
PROFIPremiumLINE 28 (PP) 3D table.....	90
PROFIPlusLINE 28 (PL) 3D table.....	92
PROFIEcoLINE 28 (PE) 3D table.....	94
HobbyLINE 28 (H) worktop	96
3D measuring, assembly and adjustment table	98
Ordering summary for D28 table legs	100
Scissor lift.....	102
Holding frame.....	104
Pivoting foot M 27	105

The optimum 3D worktable for every application – the intelligent system grids boost productivity



D28 Systems

D28 / For everyday, large welded constructions



D28 PROFIPremiumLINE (PP)

- Grid 50 x 50 mm
- 3-hole drilling pattern in the table side plates, 50 mm grid in the top and bottom rows with additional 100 mm grid in the middle



D28 PROFIPlusLINE (PL)

- Diagonal grid 100 x 100 mm
- 3-hole drilling pattern in the table side plates, 50 mm grid in the top and bottom rows with additional 100 mm grid in the middle



D28 ProfiEco Line (PE)

- Grid 100 x 100 mm
- 3-hole drilling pattern in the table side plates, 50 mm grid in the top row with additional 100 mm grid in the middle and bottom rows



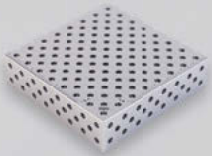
D28 HobbyLINE (H)

- Grid 100 x 100 mm
- Worktop approx. 25 mm high with system bores in a 100 mm x 100 mm grid



D16 Systems

D16 / For delicate applications



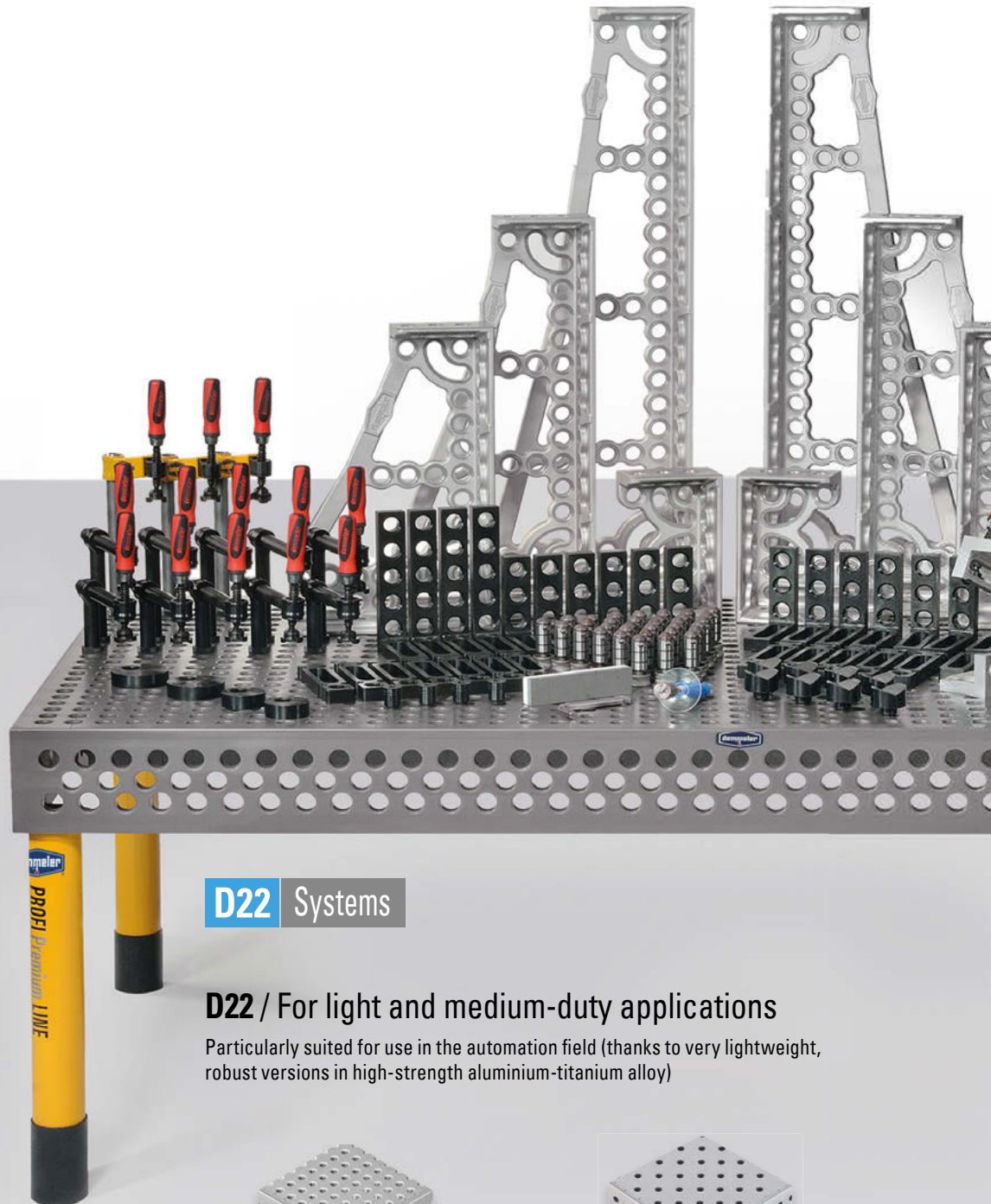
D16 PROFiPlusLINE (PL)

- Diagonal grid 50 x 50 mm
- 3-row bore pattern on the table side plates, 50 mm grid in the top, middle and bottom row



D16 ProfiEco Line (PE)

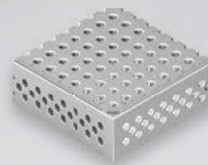
- Grid 50 x 50 mm
- 3-row bore pattern on the table side plates, 50 mm grid in the top, middle and bottom row



D22 Systems

D22 / For light and medium-duty applications

Particularly suited for use in the automation field (thanks to very lightweight, robust versions in high-strength aluminium-titanium alloy)



D22 PROFiPremiumLINE (PP)

- Grid 50 x 50 mm
- 3-row bore pattern on the table side plates, 50 x 50 mm diagonal grid



D22 PROFiPlusLINE (PL)

- Diagonal grid 100 x 100 mm
- 2-row bore pattern on the table side plates, 50 mm grid

D28 3D clamping system overview

28 PROFIPremiumLINE (PP) 3D table

PAGE 90



28 PROFIPlusLINE (PL) 3D table

PAGE 92



28 PROFIEcoLINE (PE) 3D table

PAGE 94



28 HobbyLINE (H) worktop

PAGE 96



28 3D measuring, assembly and adjustment table

PAGE 98



28 Standard leg / telescoping leg / heavy-duty wheel / anchoring leg

PAGE 100



28 Scissor lift

PAGE 102



28 Holding frame / pivoting foot M 27

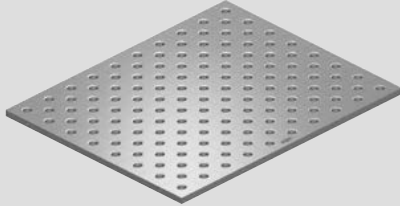
PAGE 104 / PAGE 105





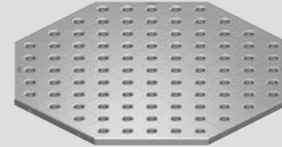
28 Clamping and adapter plate

PAGE 108



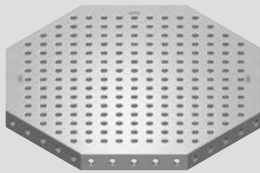
28 Clamping and adapter plate Okto AF

PAGE 109



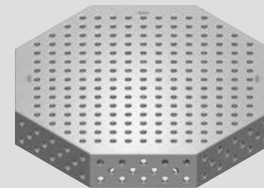
28 3D worktable Okto 100

PAGE 110



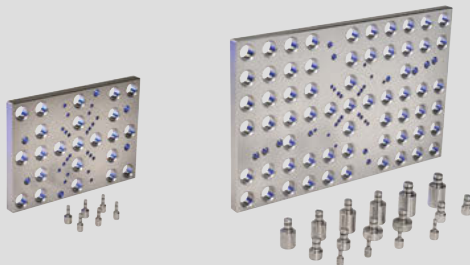
28 3D worktable Okto 200

PAGE 111



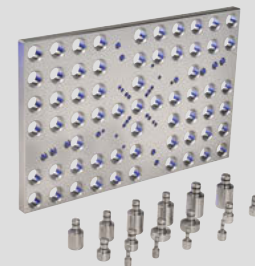
28 Adapter plate for flanges DIN 2632 / 2633 / 2634 / 2635

PAGE 112



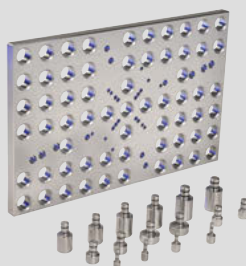
28 Clamping plates for ANSI flanges (ANSI standard B 16.5)

PAGE 113



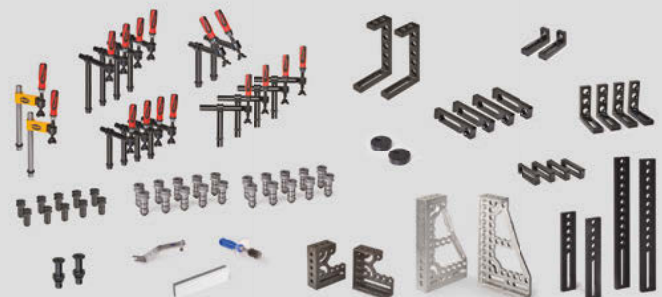
28 Flange plates in accordance with the JIS standard

PAGE 114



28 D28 sets

PAGE 116



3D clamping system

Benefits of the D28 3D system tables

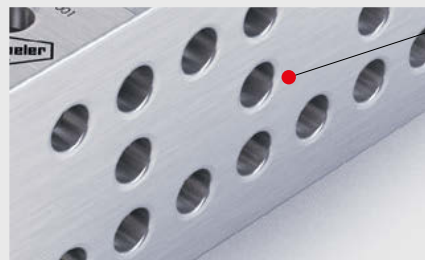


The benefits of a 3D clamping system from DEMMELER!

With our 3D clamping system, you have the right solution for clamping and positioning work pieces near at hand. Optimum positioning of the work piece not only makes work more accurate but also much more effective. In particular, the intelligent system grids give you unlimited clamping capabilities.



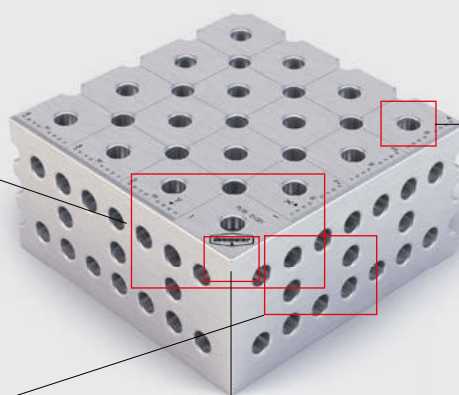
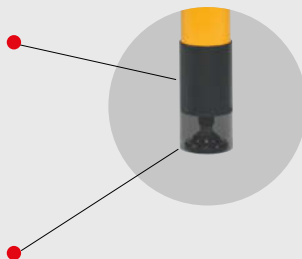
Axis designation in X and Y-direction.
Standard version includes precision scaling.



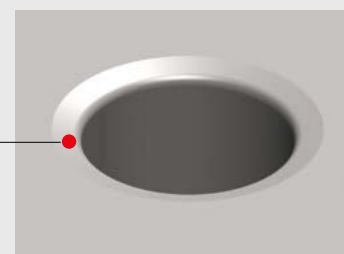
Additional bores in the side stanchion for even more clamping options.

Foot sleeve prevents pinching the welding hose and protects the threaded spindle against dirt.

Pivoting foot with stable M30x2 threaded spindle, finely adjustable 30 mm travel path.



Radius for improved ergonomics and better design



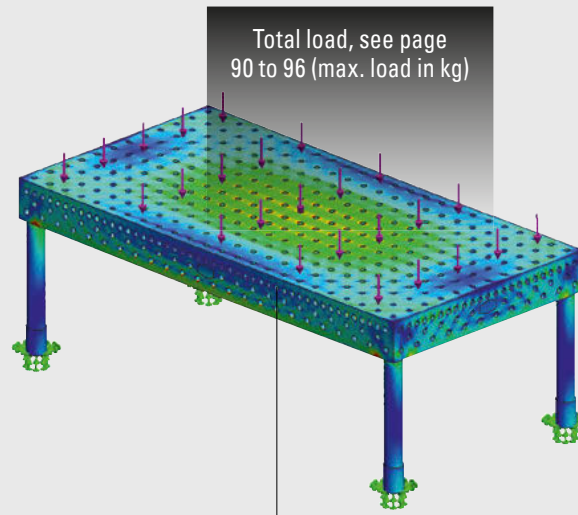
Protective countersink: Optimum bolt and clamp insertion with simultaneous protection of the tabletop against damage from materials, even in case of extreme strain on the system bore or when used with aluminium.



DEMMELEER trademark



OUR PERFORMANCE
makes THE DIFFERENCE



All our tables are generously sized, super sturdy and optimised with FEM calculations on principle.

3D clamping system

The hardness of DEMMELER

Hardness comparison



SOLID

High-strength base material

DEMONT 760 M

Hardened high-strength tool steel up to 760 Vickers

DEMONT 860 M

Hardened high-alloy tool steel up to 860 Vickers



THE hardness of DEMMELER – for the toughest requirements

- + Less wear
- + Protection against adherence of weld spatter
- + Extremely tough and durable
- + Optimum surface qualities

THE HARDNESS



DEMONT 860 M

DEMONT 760 M

DEMONT 860 M

Using a high-alloy base material for the worktop in combination with the special, optimised DEMMELERhardening process results in the best possible material characteristics. A hardness of up to 860 Vickers can be achieved. The combination of a high-alloy base material and special hardening process makes it possible to achieve the best possible worktable properties for extreme demands.

DEMONT 760 M

Stands for the combination of the specified base material and the new DEMMELER hardening process optimised especially for worktables. This results in outstanding material characteristics. A hardness of up to 760 Vickers can be achieved, reducing wear for an even longer service life of your worktable.

		DEMONT 860 M	DEMONT 760 M	SOLID
Load	high bearing loads	◊ ◊ ◊ ◊ ◊ ◊ ◊	◊ ◊ ◊ ◊ ◊ ◊ ◊	◊ ◊ ◊ ◊ ◊ ◊ ◊
Evenness	for outstanding tool quality	◊ ◊ ◊ ◊ ◊ ◊ ◊	◊ ◊ ◊ ◊ ◊ ◊ ◊	◊ ◊ ◊ ◊ ◊ ◊ ◊
Conductivity	for excellent welding results when using the ground connector	◊ ◊ ◊ ◊ ◊	◊ ◊ ◊ ◊ ◊	◊ ◊ ◊ ◊ ◊ ◊ ◊
Base hardness	for high impact resistance	◊ ◊ ◊ ◊ ◊ ◊ ◊	◊ ◊ ◊ ◊ ◊ ◊ ◊	◊ ◊ ◊ ◊ ◊
Surface hardness	resistant to weld spatter	◊ ◊ ◊ ◊ ◊ ◊ ◊	◊ ◊ ◊ ◊ ◊ ◊ ◊	◊ ◊ ◊ ◊ ◊

◊ ◊ ◊ ◊ ◊ ◊ ◊ = outstanding
◊ = adequate

3D clamping system

Planned down to the tiniest details – The 3D clamping system from DEMMELER

Welding results

When using the 3D clamping system, the optimum flow of electricity between the electrode / filler wire and ground connector is vitally important. That is why DEMMELER optimises the material properties of its worktables and accessories and guarantees outstanding precision for optimum form fits. Although hardened worktables are even more robust and better protected against weld spatter, the conductivity also falls slightly. Here again, DEMMELER has developed an optimum solution in the form of the DEMONT 760 M and DEMONT 860 M variants. In this way, DEMMELER provides optimum conditions for ideal welding results!

- **DEMONT 760 M and DEMONT 860 M ①**

Very good conductivity for optimum welding results, extremely tough design and outstanding protection against weld spatter

- **SOLID standard hardness ②**

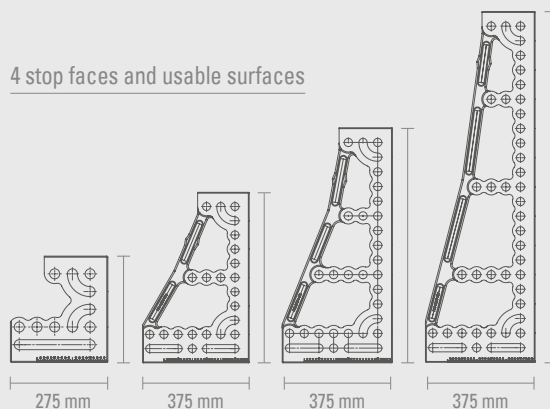
Excellent conductivity for optimum welding results, extremely tough design and high protection against weld spatter

PROFIPremiumLINE clamping and locating angle

The aluminium-titanium design is lightweight enough to permit optimised, extremely simple handling. Only by using the patented PPC clamping pin is it possible to clamp the angles without causing wear. This permits an unlimited service life.

The kidney-shaped 90° system groove makes continuous angle adjustment possible. The extended face plate and increased number of cross braces provide additional bores for clamping. The precision scaling makes adjustment much easier.

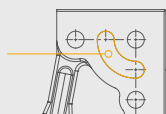
4 stop faces and usable surfaces

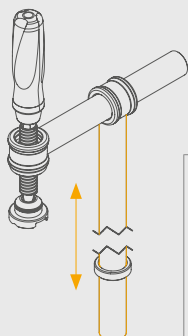


Corner heights,
aluminium-
titanium
300, 600, 800
and 1200 mm

Corner heights,
cast iron,
hardened
300, 600
and 800 mm

Reinforcement in the corners with 90° system
groove in kidney shape supports continuously
variable use, also with angular adjustment



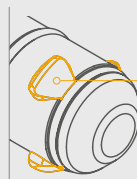


Screw clamp

The DEMMELER screw clamps are constructed using round tubes. This makes them extremely tough and the greatest possible clamping forces are achieved. DEMMELER screw clamps can be extended on a modular basis – for example, use as a 270° screw clamp is possible. Using the performance screw clamp, it is also possible to clamp very high components with the same precision.

PPC bolts – The perfect connection

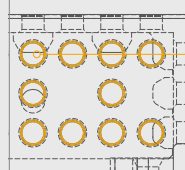
- Self-centring, force-locked and low-wear clamping
- Very quick to clamp and unclamp
- Force-locking through full-area contact
- Easy on materials
- Low susceptibility to dirt
- Extremely tough – long service life guaranteed



Even force distribution across the polygon bolts also reduces bore hole wear compared to conventional bolts. The cone clamping system permits a bearing surface that is 100 times larger.

Intelligent system grid

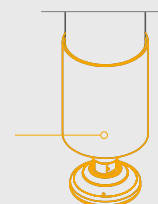
Thanks to the three-row hole pattern on the side stanchions, DEMMELER worktables can be extended on a modular basis – and offer outstanding stability, toughness and very high bearing capacity.



Additional bores in the side stanchion for even more clamping options

Pivoting leg

The extremely solid design ensures very high load-bearing capacity – 3,000 kg per leg. The foot sleeve prevents pinching and reduces wear at the cable-hose assembly. This also provides a convenient way of using the ground connector. It also protects the threaded spindle against dirt and wear. Fine adjustments are possible and fixing is stable and simple.



Foot sleeves prevent pinching the welding hose and protect the threaded spindle against dirt.



3D clamping system

Leg type variant overview



Standard leg

- Pivoting feet, ± 30 mm fine adjustable
- Sturdy M30 threaded spindle
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly
- Also suitable as supporting leg in combination with overhung spacer block U-form, length 1 m and up
- Including countersunk M24 x 60 mounting screw
- Leg tube powder coated
- To order standard legs, see page 100



Telescoping leg

- Pivoting feet, ± 30 mm fine adjustable
- Sturdy M30 threaded spindle
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly
- Telescope adjustment range 350 mm in 50-mm increments
- For flexible height adjustment of the worktable
- Including countersunk M24 x 60 mounting screw
- Leg tube powder coated
- To order telescoping legs, see page 100



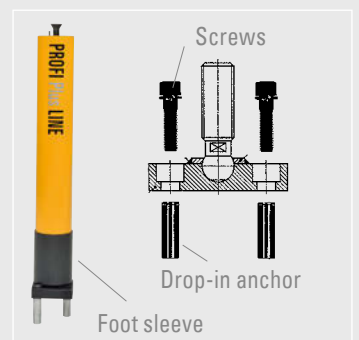
Heavy-duty wheel

- Fine adjustable ± 30 mm
- Sturdy M30 threaded spindle
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly
- Robust version
- With 360° caster
- Max. load capacity 600 kg
- Including countersunk M24 x 60 mounting screw
- Leg tube powder coated
- To order heavy duty wheels, see page 100



Anchoring leg

- Fine adjustable ± 30 mm
- Sturdy M30 threaded spindle
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly
- For firm attachment to the hall floor against tension, pressure and shifting (e.g. robot use)
- Includes M24 x 60 countersunk mounting screw and, for firm anchoring to the floor, 2 x drop-in anchor, 2 x cap screw M16 x 40
- Leg tube powder coated
- To order anchoring legs, see page 100



The right leg for any application



Scissor lift

- Continuously variable height adjustment
- With safety shutdown board
- Fully adapted to 3D worktable D28
- Including hand control
- Power unit internal / external (depending on size)
- Available for D28
- To order scissor lift, see page 102

Holding frame

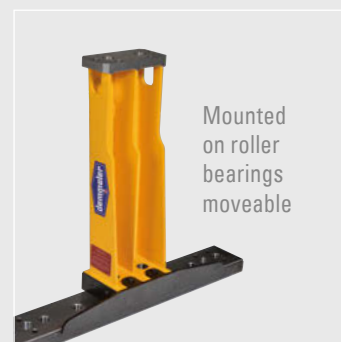
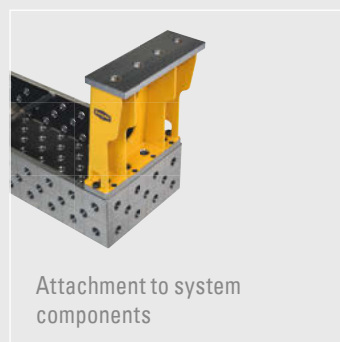
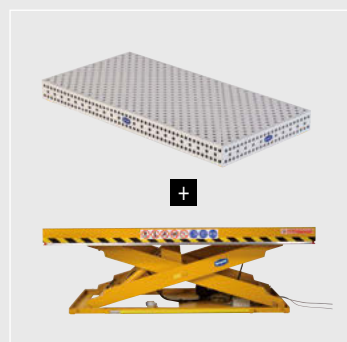
- Exact positioning of 3D worktables is possible using pivoting leg or in lengthwise and crosswise direction on the support and foundation track
- You will find further information on the product in the section on the track system, page 158
- Available for D28
- To order holding frames, see page 104

Table leg for spacer block

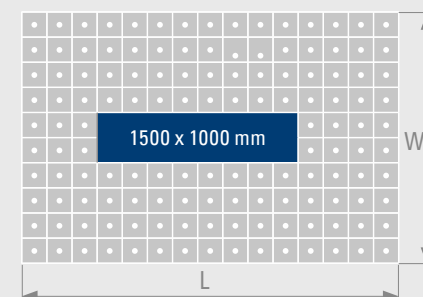
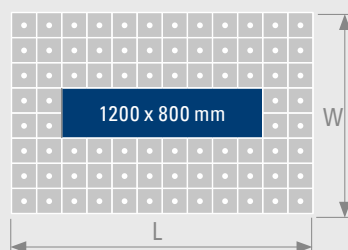
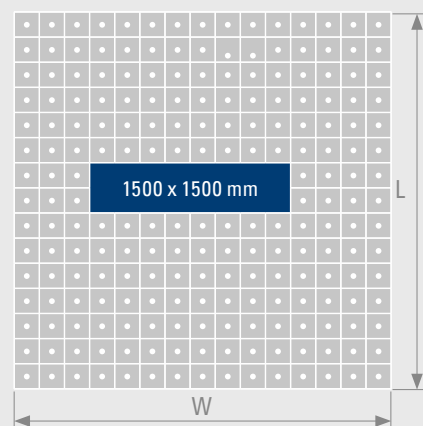
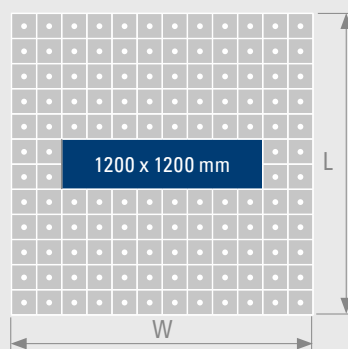
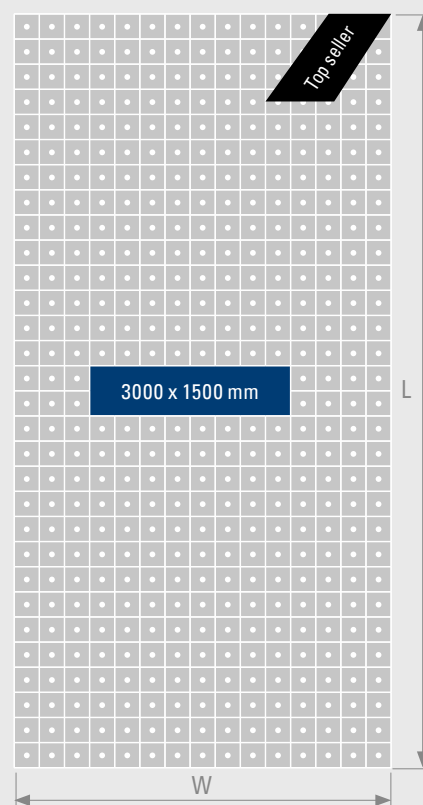
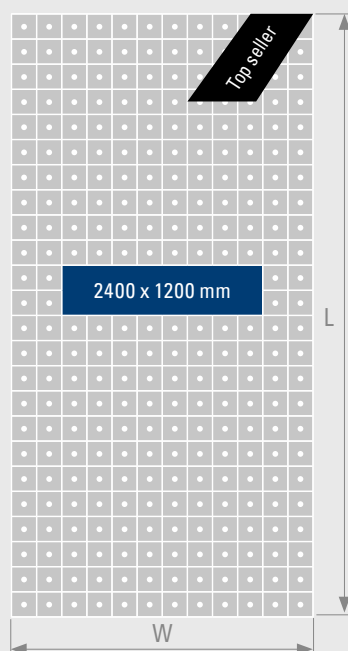
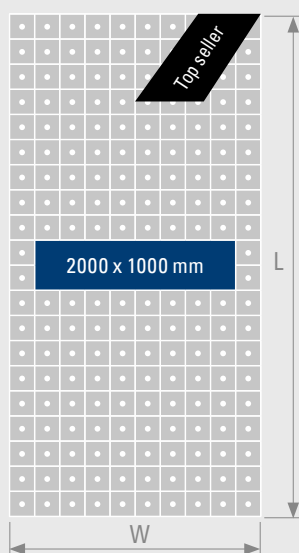
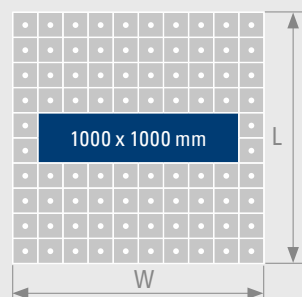
- Connecting elements between spacer block U-form or 3D worktable and support and base rail
- Different setup heights can be adapted to the work piece by simply exchanging the table legs
- You will find detailed information on the product in the section on the track system, page 156
- Available for D28

Shifting foot with casters

- Moving installed system components is possible without using hoisting equipment or a crane
- Different setup heights can be adapted to the work piece by simply exchanging the table legs
- Highest load capacity in the working position thanks to full surface support of the foot on the rail
- You will find detailed information on the product in the section on the track system, page 157
- Available for D28

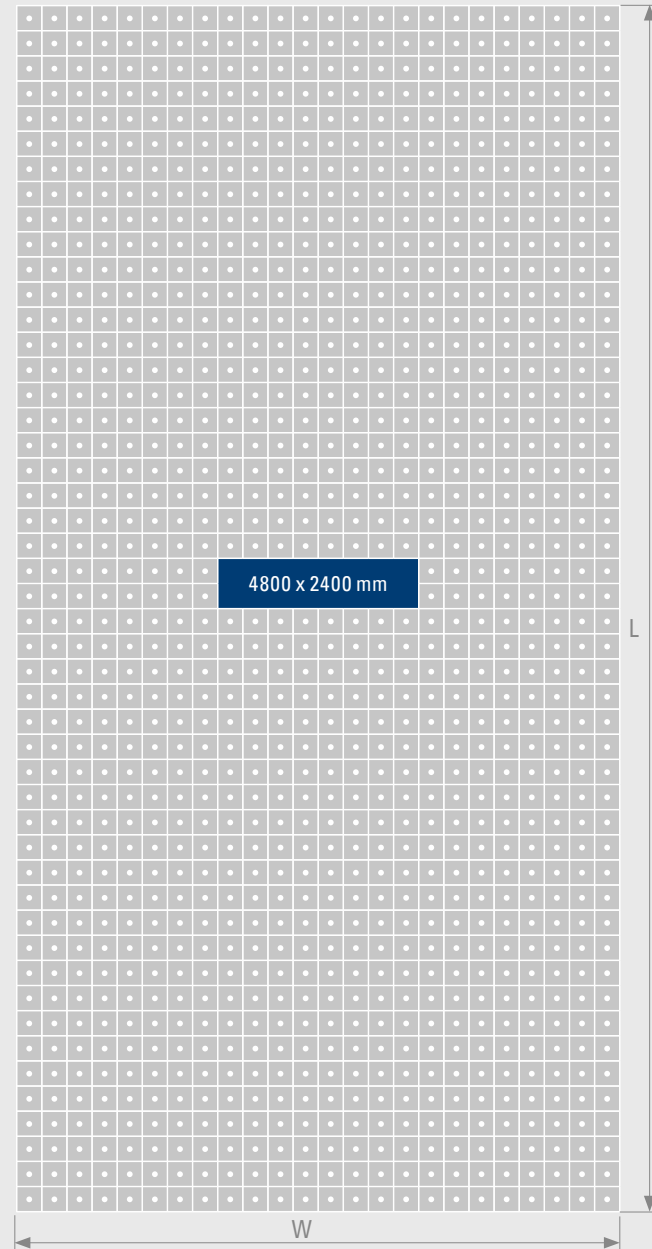
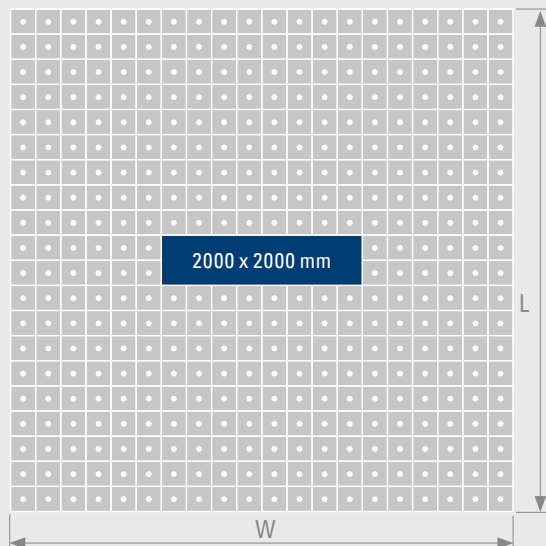
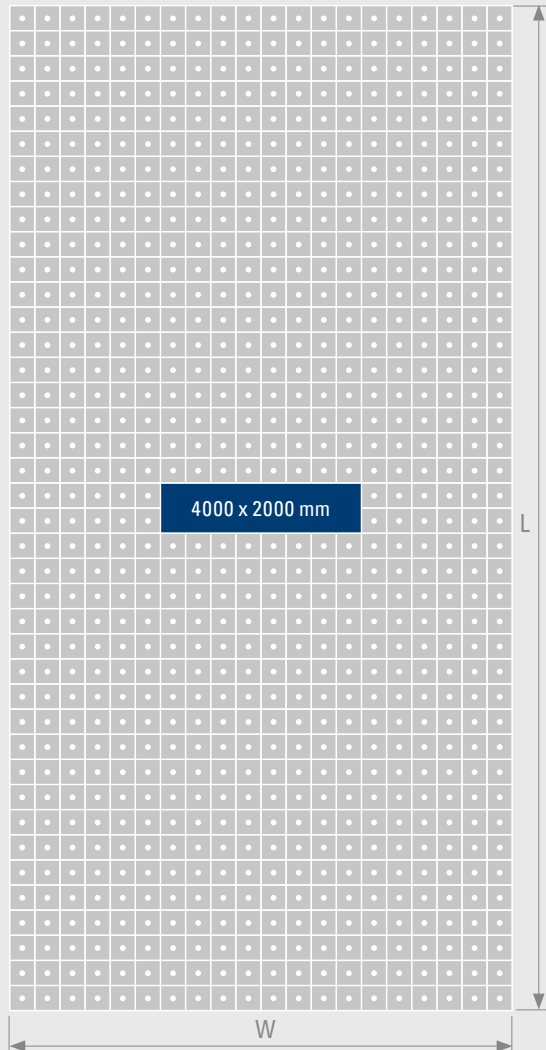


D28 system table sizes



28	L in mm	W in mm	H in mm
	1000	1000	200
	1200	800	200
	1200	1200	200
	1500	1000	200
	1500	1500	200
	2000	1000	200
	2000	2000	200
	2400	1200	200
	3000	1500	200
	4000	2000	200
	4800	2400	200
	Customer dimension*	Customer dimension	Customer dimension

*Custom dimensions and material (e. g. stainless steel) available on request!



For everyday, large welded constructions

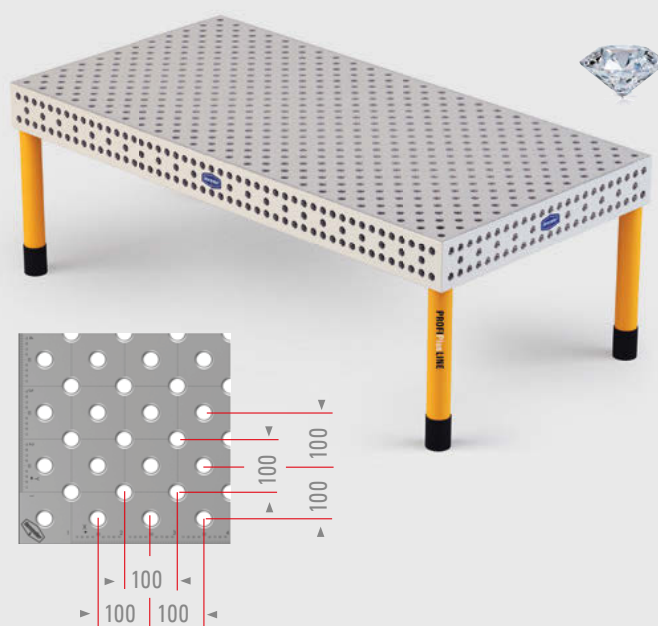
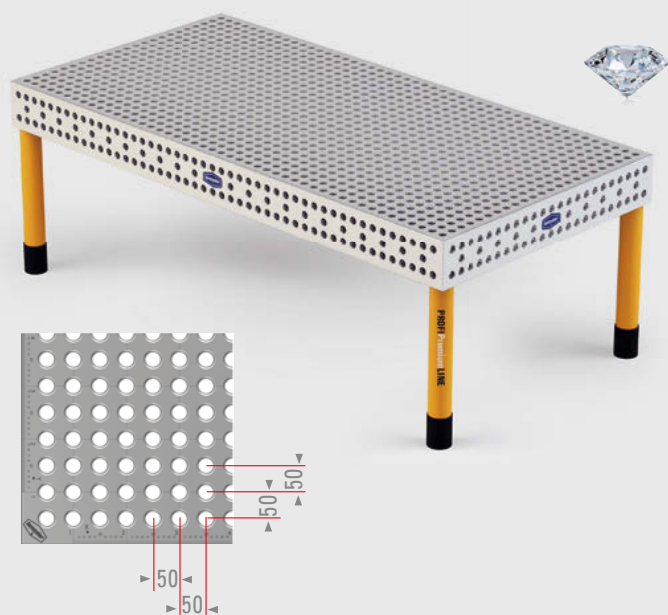


PROFIPremiumLINE (PP) 3D table

PROFIPlusLINE (PL) 3D table

Worktop with D28 system bores
in a 50 mm x 50 mm grid

Worktop with D28 system bores
in diagonal 100 mm x 100 mm grid



Description: PROFIPremiumLINE ▼

- Worktop with D28 system bores in a 50 mm x 50 mm grid. This results in approx. 400 % more clamping options than PROFIEcoLINE and conventional worktables, and approx. 100 % more clamping options than PROFIPlusLINE
- 3-hole drilling pattern in the table side plates with D28 system bores, 50 mm grid in the top and bottom rows with additional 100 mm grid in the middle, which nearly doubles the expansion and clamping options
- All table sizes optionally available in hardened version, DEMONT 760 M and DEMONT 860 M, in up to 860 Vickers
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous gridlines in X and Y-direction, 100 mm spacing
- Precision scaling with millimetre graduation, also available with the DEMONT 760 M and DEMONT 860 M options
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo recessed in all 4 side plates
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

Description: PROFIPlusLINE ▼

- Worktop with D28 system bores in a double 100 mm x 100 mm grid, resulting in approx. 80 % more clamping options than PROFIEcoLINE and conventional worktables
- 3-hole drilling pattern in the table side plates with D28 system bores, 50 mm grid in the top and bottom rows with additional 100 mm grid in the middle, which nearly doubles the expansion and clamping options
- All table sizes optionally available in hardened version, DEMONT 760 M and DEMONT 860 M, in up to 860 Vickers
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous gridlines in X and Y-direction, 100 mm spacing
- Precision scaling with millimetre graduation, also available with the DEMONT 760 M and DEMONT 860 M options
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo recessed in all 4 side plates
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

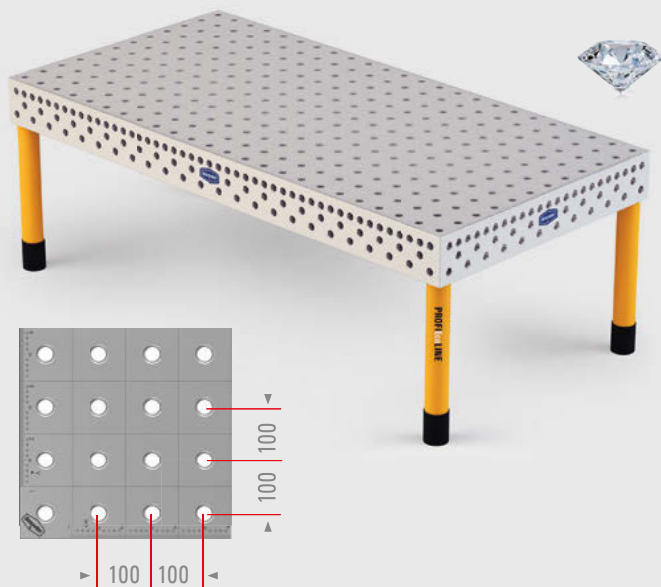
PROFI^{Eco}LINE (PE) 3D table

HobbyLINE (H) worktop

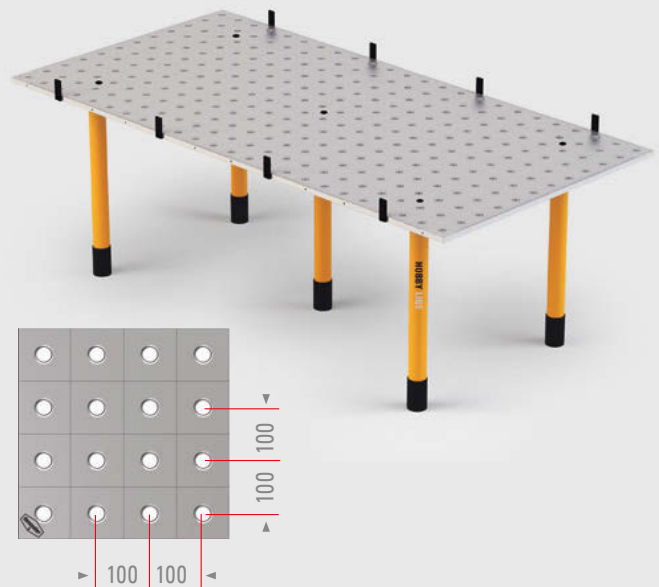


Top seller

Worktop with D28 system bores
in a 100 mm x 100 mm grid



Worktop with D28 system bores
in a 100 mm x 100 mm grid



Description: PROFIEcoLINE ▼

- Worktop with D28 system bores in a 100 mm x 100 mm grid
- 3-hole drilling pattern in the table side plates with D28 system bores, 50 mm grid in the top row with additional 100 mm grid in the middle and in the bottom row, which greatly increases the expansion and clamping options
- All table sizes optionally available in hardened version, DEMONT 760 M and DEMONT 860 M, in up to 860 Vickers
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous gridlines in X and Y-direction, 100 mm spacing
- Precision scaling with millimetre graduation, also available with the DEMONT 760 M and DEMONT 860 M options
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo recessed in all 4 side plates
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

Description: HobbyLINE ▼

- Cost-effective alternative for low loads
- Worktop approx. 25 mm high with D28 system bores in a 100 mm x 100 mm grid
- Accessories for E (EcoLINE), D (PlusLINE) and P (PremiumLINE) can be used on the worktop
- M8 threaded bores on all four sides of the worktop including 8 outer stops with screw
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Continuous gridlines in X and Y-direction, 100 mm spacing
- Coordinate marking of the bores in the X and Y-direction
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly



3D measuring, assembly and adjustment table

Description of the table line 28

Worktop with precision scaling

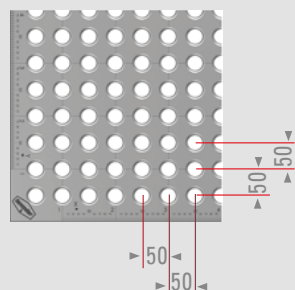


Description: 3D measuring, assembly and adjustment table ▼

- Evenness 0.15 mm/m
- Outstanding precision for adjusting, measuring and assembling components
- Optimised outside table edges
- Incl. precision scaling / gridlines
- Hardened version DEMONT 860 M, up to 860 Vickers
- Improved table reinforcement through additional cross-ribs
- DEMMELER logo recessed in all 4 side plates

PROFI PremiumLINE (PP) 3D table

Up to 400% more clamping options



On request the table is also available in a cast or stainless steel version!

Table without leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	1000	200	290		
	1200	800	200	280		
	1200	1200	200	380		
	1500	1000	200	390		
	1500	1500	200	530		
	2000	1000	200	500		
	2000	2000	200	1000		
	2400	1200	200	710		
	3000	1500	200	1010		
	4000	2000	200	1780		
	4800	2400	200	2550		

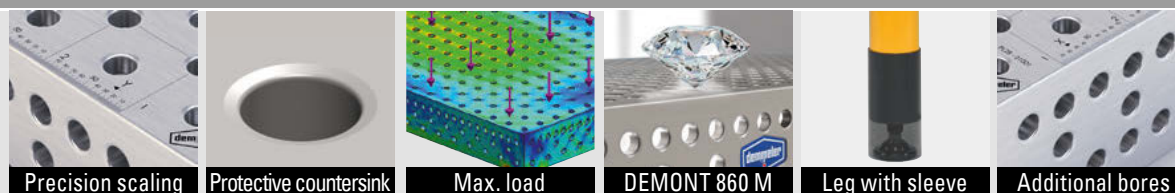


Custom dimensions and material (e. g. stainless steel) available on request

Table with standard leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	1000	850 ±30	324	12000	
	1200	800	850 ±30	314	12000	
	1200	1200	850 ±30	414	12000	
	1500	1000	850 ±30	424	12000	
	1500	1500	850 ±30	564	12000	
	2000	1000	850 ±30	534	12000	
	2000	2000	850 ±30	1034	12000	
	2400	1200	850 ±30	744	12000	
	3000	1500	850 ±30	1061	18000	
	4000	2000	850 ±30	1831	18000	
	4800	2400	850 ±30	2644	33000	



PROFIPremiumLINE (PP) 3D table



DESCRIPTION

- Worktop with D28 system bores in a **50 mm x 50 mm grid**. This results in approx. 400 % more clamping options than PROFIEcoLINE and conventional worktables, and approx. 100% more clamping options than PROFIPlusLINE
- 3-hole drilling pattern in the table side plates with D28 system bores, 50 mm grid in the top and bottom rows with additional 100 mm grid in the middle, which nearly doubles the expansion and clamping options
- All table sizes optionally available in new hardness, DEMONT 760 M and DEMONT 860 M, in up to 860 Vickers
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous gridlines in X and Y-direction, 100 mm spacing
- Precision scaling with millimetre graduation, also available with the DEMONT 760 M and DEMONT 860 M options
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo recessed in all 4 side plates
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

THE HARDNESS



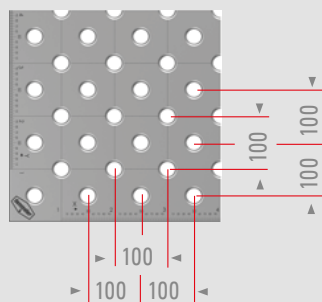
DEMONT 860 M

DEMONT 760 M

	Number of legs	SOLID	DEMONT 760 M hardened	DEMONT 860 M hardened
	without legs	PP28-01001-000	PP28-01001-500	PP28-01001-700
	without legs	PP28-11019-000	PP28-11019-500	PP28-11019-700
	without legs	PP28-01056-000	PP28-01056-500	PP28-01056-700
	without legs	PP28-01011-000	PP28-01011-500	PP28-01011-700
	without legs	PP28-01031-000	PP28-01031-500	PP28-01031-700
	without legs	PP28-01002-000	PP28-01002-500	PP28-01002-700
	without legs	PP28-01006-000	PP28-01006-500	PP28-01006-700
	without legs	PP28-01003-000	PP28-01003-500	PP28-01003-700
	without legs	PP28-01004-000	PP28-01004-500	PP28-01004-700
	without legs	PP28-01005-000	PP28-01005-500	PP28-01005-700
	without legs	PP28-11085-000	PP28-11085-500	PP28-11085-700

	Number of legs	SOLID	DEMONT 760 M hardened	DEMONT 860 M hardened	Selection list for other leg variants as of page 100.
	4	PP28-01001-001	PP28-01001-011	PP28-01001-021	
	4	PP28-11019-001	PP28-11019-011	PP28-11019-021	
	4	PP28-01056-001	PP28-01056-011	PP28-01056-021	
	4	PP28-01011-001	PP28-01011-011	PP28-01011-021	
	4	PP28-01031-001	PP28-01031-011	PP28-01031-021	
	4	PP28-01002-001	PP28-01002-011	PP28-01002-021	
	4	PP28-01006-001	PP28-01006-011	PP28-01006-021	
	4	PP28-01003-001	PP28-01003-011	PP28-01003-021	
	6	PP28-01004-001	PP28-01004-011	PP28-01004-021	
	6	PP28-01005-001	PP28-01005-011	PP28-01005-021	
	11	PP28-11085-001	PP28-11085-011	PP28-11085-021	

PROFIPlusLINE (PL) 3D table

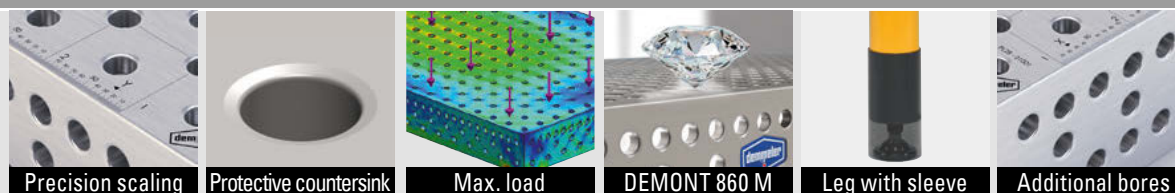


On request the table is also available in a cast or stainless steel version!

Table without leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	1000	200	310		
	1200	800	200	300		
	1200	1200	200	410		
	1500	1000	200	430		
	1500	1500	200	590		
	2000	1000	200	550		
	2000	2000	200	1050		
	2400	1200	200	790		
	3000	1500	200	1150		
	4000	2000	200	1980		
	4800	2400	200	2830		

Custom dimensions and material (e. g. stainless steel) available on request

Table with standard leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	1000	850 ±30	344	12000	
	1200	800	850 ±30	334	12000	
	1200	1200	850 ±30	444	12000	
	1500	1000	850 ±30	464	12000	
	1500	1500	850 ±30	624	12000	
	2000	1000	850 ±30	584	12000	
	2000	2000	850 ±30	1084	12000	
	2400	1200	850 ±30	824	12000	
	3000	1500	850 ±30	1201	18000	
	4000	2000	850 ±30	2031	18000	
	4800	2400	850 ±30	2925	33000	



DESCRIPTION

- Worktop with D28 system bores in a double 100 mm x 100 mm grid, resulting in approx. 80 % more clamping options than PROFIEcoLINE and conventional worktables
- 3-hole drilling pattern in the table side plates with D28 system bores, 50 mm grid in the top and bottom rows with additional 100 mm grid in the middle, which nearly doubles the expansion and clamping options
- All table sizes optionally available in new hardness, DEMONT 760 M and DEMONT 860 M, in up to 860 Vickers
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous gridlines in X and Y-direction, 100 mm spacing
- Precision scaling with millimetre graduation, also available with the DEMONT 760 M and DEMONT 860 M options
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo recessed in all 4 side plates
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

THE HARDNESS



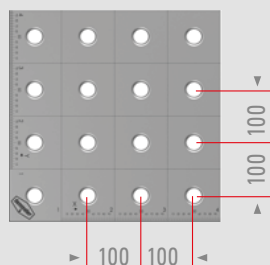
DEMONT 860 M

DEMONT 760 M

	Number of legs	SOLID	DEMONT 760 M hardened	DEMONT 860 M hardened
	without legs	PL28-01001-000	PL28-01001-500	PL28-01001-700
	without legs	PL28-11019-000	PL28-11019-500	PL28-11019-700
	without legs	PL28-01056-000	PL28-01056-500	PL28-01056-700
	without legs	PL28-01011-000	PL28-01011-500	PL28-01011-700
	without legs	PL28-01031-000	PL28-01031-500	PL28-01031-700
	without legs	PL28-01002-000	PL28-01002-500	PL28-01002-700
	without legs	PL28-01006-000	PL28-01006-500	PL28-01006-700
	without legs	PL28-01003-000	PL28-01003-500	PL28-01003-700
	without legs	PL28-01004-000	PL28-01004-500	PL28-01004-700
	without legs	PL28-01005-000	PL28-01005-500	PL28-01005-700
	without legs	PL28-11085-000	PL28-11085-500	PL28-11085-700

	Number of legs	SOLID	DEMONT 760 M hardened	DEMONT 860 M hardened	Selection list for other leg variants as of page 100.
	4	PL28-01001-001	PL28-01001-011	PL28-01001-021	
	4	PL28-11019-001	PL28-11019-011	PL28-11019-021	
	4	PL28-01056-001	PL28-01056-011	PL28-01056-021	
	4	PL28-01011-001	PL28-01011-011	PL28-01011-021	
	4	PL28-01031-001	PL28-01031-011	PL28-01031-021	
	4	PL28-01002-001	PL28-01002-011	PL28-01002-021	
	4	PL28-01006-001	PL28-01006-011	PL28-01006-021	
	4	PL28-01003-001	PL28-01003-011	PL28-01003-021	
	6	PL28-01004-001	PL28-01004-011	PL28-01004-021	
	6	PL28-01005-001	PL28-01005-011	PL28-01005-021	
	11	PL28-11085-001	PL28-11085-011	PL28-11085-021	

PROFI^{Eco}LINE (PE) 3D table



On request the table is also available in a cast or stainless steel version!

Table without leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	1000	200	330		
	1200	800	200	310		
	1200	1200	200	430		
	1500	1000	200	450		
	1500	1500	200	610		
	2000	1000	200	570		
	2000	2000	200	1100		
	2400	1200	200	820		
	3000	1500	200	1180		
	4000	2000	200	2090		
	4800	2400	200	2980		



Custom dimensions and material (e. g. stainless steel) available on request

Table with standard leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	1000	850 ±30	364	12000	
	1200	800	850 ±30	344	12000	
	1200	1200	850 ±30	464	12000	
	1500	1000	850 ±30	484	12000	
	1500	1500	850 ±30	644	12000	
	2000	1000	850 ±30	604	12000	
	2000	2000	850 ±30	1134	12000	
	2400	1200	850 ±30	854	12000	
	3000	1500	850 ±30	1231	18000	
	4000	2000	850 ±30	2141	18000	
	4800	2400	850 ±30	3074	33000	

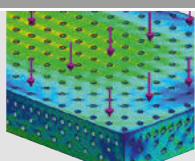




Precision scaling



Protective countersink



Max. load



DEMONT 860 M



Leg with sleeve



Additional bores

DESCRIPTION

- Worktop with D28 system bores in a 100 mm x 100 mm grid
- 3-hole drilling pattern in the table side plates with D28 system bores, 50 mm grid in the top row with additional 100 mm grid in the middle and in the bottom row, which nearly doubles the expansion and clamping options
- All table sizes optionally available in new hardness, DEMONT 760 M and DEMONT 860 M, in up to 860 Vickers
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous gridlines in X and Y-direction, 100 mm spacing
- Precision scaling with millimetre graduation, also available with the DEMONT 760 M and DEMONT 860 M options
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo recessed in all 4 side plates
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

THE HARDNESS



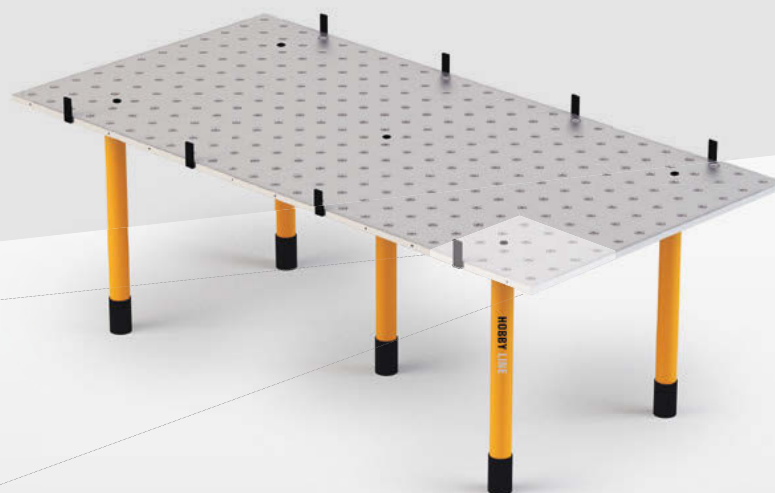
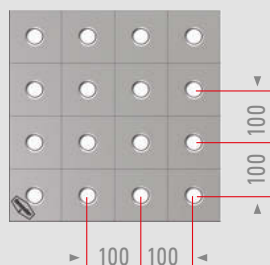
DEMONT 860 M

DEMONT 760 M

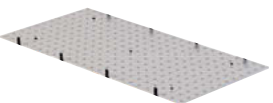
	Number of legs	SOLID	DEMONT 760 M hardened	DEMONT 860 M hardened
	without legs	PE28-01001-000	PE28-01001-500	PE28-01001-700
	without legs	PE28-11019-000	PE28-11019-500	PE28-11019-700
	without legs	PE28-01056-000	PE28-01056-500	PE28-01056-700
	without legs	PE28-01011-000	PE28-01011-500	PE28-01011-700
	without legs	PE28-01031-000	PE28-01031-500	PE28-01031-700
	without legs	PE28-01002-000	PE28-01002-500	PE28-01002-700
	without legs	PE28-01006-000	PE28-01006-500	PE28-01006-700
	without legs	PE28-01003-000	PE28-01003-500	PE28-01003-700
	without legs	PE28-01004-000	PE28-01004-500	PE28-01004-700
	without legs	PE28-01005-000	PE28-01005-500	PE28-01005-700
	without legs	PE28-11085-000	PE28-11085-500	PE28-11085-700

	Number of legs	SOLID	DEMONT 760 M hardened	DEMONT 860 M hardened	Selection list for other leg variants as of page 100.
	4	PE28-01001-001	PE28-01001-011	PE28-01001-021	
	4	PE28-11019-001	PE28-11019-011	PE28-11019-021	
	4	PE28-01056-001	PE28-01056-011	PE28-01056-021	
	4	PE28-01011-001	PE28-01011-011	PE28-01011-021	
	4	PE28-01031-001	PE28-01031-011	PE28-01031-021	
	4	PE28-01002-001	PE28-01002-011	PE28-01002-021	
	4	PE28-01006-001	PE28-01006-011	PE28-01006-021	
	4	PE28-01003-001	PE28-01003-011	PE28-01003-021	
	6	PE28-01004-001	PE28-01004-011	PE28-01004-021	
	6	PE28-01005-001	PE28-01005-011	PE28-01005-021	
	11	PE28-11085-001	PE28-11085-011	PE28-11085-021	


HobbyLINE (H) worktable




On request the table is also available in a stainless steel version!

Table without leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	1000	25	180		
	1200	800	25	180		
	1200	1200	25	260		
	1500	1000	25	270		
	2000	1000	25	360		
	2400	1200	25	510		

Custom dimensions and material (e. g. stainless steel) available on request

Table with standard leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	1000	850 ±30	204	600	
	1200	800	850 ±30	204	600	
	1200	1200	850 ±30	284	600	
	1500	1000	850 ±30	300	600	
	2000	1000	850 ±30	390	600	
	2400	1200	850 ±30	540	600	

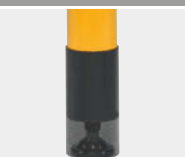
Standard leg single	H in mm	Weight of table leg in kg	Item no.
	826 ±30 fine	6	PL16-10010-005



Precision scaling



Protective countersink



Leg with sleeve

DESCRIPTION

- Cost-effective alternative for low loads
- Worktop approx. 25 mm high with D28 system bores in a 100 mm x 100 mm grid
- Accessories for E (EcoLINE), D (PlusLINE) and P (PremiumLINE) can be used on the worktop
- M8 threaded bores on all four sides of the worktop including 8 outer stops with screw
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Continuous gridlines in X and Y-direction, 100 mm spacing
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

Number of legs	SOLID
without legs	H28-01001-000
without legs	H28-11019-000
without legs	H28-01056-000
without legs	H28-01011-000
without legs	H28-01002-000
without legs	H28-01003-000

Number of legs	SOLID	Selection list for other leg variants as of page 100.
4	H28-01001-001	
4	H28-11019-001	
4	H28-01056-001	
5	H28-01011-001	
5	H28-01002-001	
5	H28-01003-001	

3D measuring, assembly and adjustment table



Table without leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	2000	1000	200	610		
	2400	1200	200	890		
	3000	1500	200	1300		
Table with standard leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	2000	1000	850 ±30	644	12000	
	2400	1200	850 ±30	924	12000	
	3000	1500	850 ±30	1351	18000	



3D measuring, assembly and adjustment table



Precision scaling



Evenness 0.15 mm/m



Leg with sleeve

DESCRIPTION

- Evenness 0.15 mm/m
- Outstanding precision for adjusting, measuring and assembling components
- Optimised outside table edges
- Incl. precision scaling / gridlines
- Hardened version DEMONT 860 M, up to 860 Vickers
- Improved table reinforcement through additional cross-ribs
- DEMMELER logo recessed in all 4 side plates

THE HARDNESS



DEMONT 860 M

	Number of legs	SOLID	DEMONT 860 M hardened
	without legs	M28-01002-000	M28-01002-700
	without legs	M28-01003-000	M28-01003-700
	without legs	M28-01004-000	M28-01004-700
	Number of legs	SOLID	DEMONT 860 M hardened
	4	M28-01002-001	M28-01002-021
	4	M28-01003-001	M28-01003-021
	6	M28-01004-001	M28-01004-021

Selection list for
other leg variants
as of page 100.

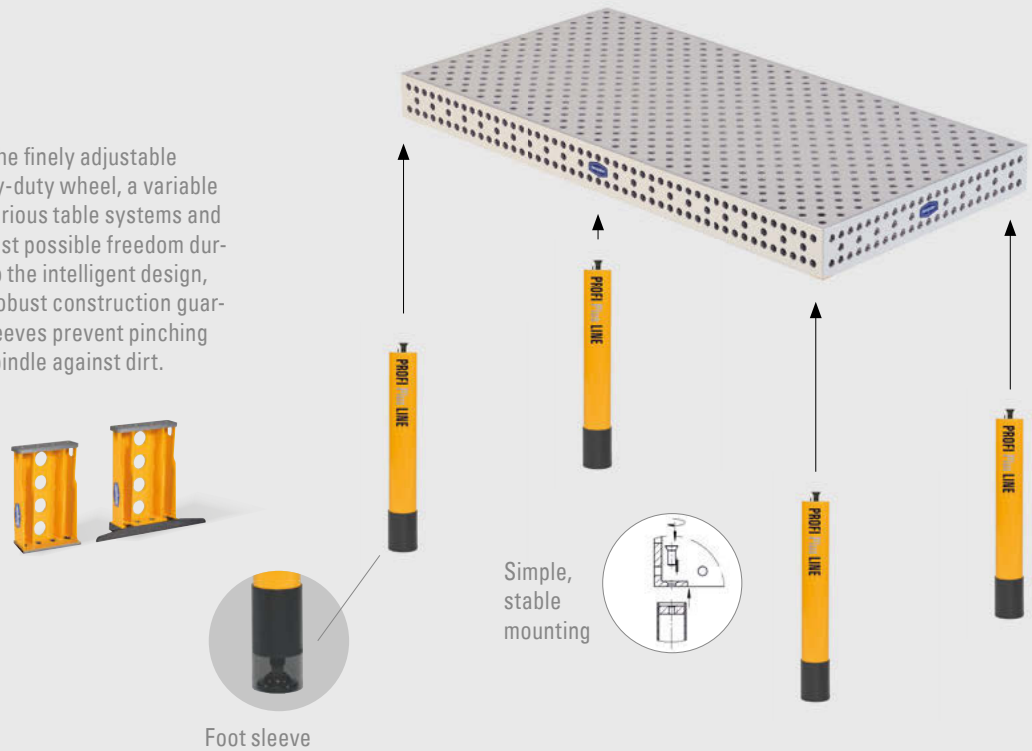
Ordering summary for table legs

D28 system 3D welding tables with suitable standard legs

Legs you can rely on.

Efficient working guaranteed! Starting with the finely adjustable standard leg and on through the mobile heavy-duty wheel, a variable selection of table legs are available for the various table systems and permit any application. This offers you greatest possible freedom during your manufacturing operations. Thanks to the intelligent design, the legs can be fixed simply and stably. The robust construction guarantees a long service life. To this end, foot sleeves prevent pinching the welding hose and protect the threaded spindle against dirt.

As of page 156, you will find the right legs for mounting your system on the DEMMELER track system.



Ordering example:

1. On page 90 - 98, select the desired worktop, resulting in order item no. 1:
e.g. 1x PL28-01031-000



+

2. From the current page, select the leg you want in the corresponding quantity, which results in order item no. 2:
e.g. 4x PL28-10010-001



=

3. The two order item numbers make up your order to DEMMELER.
e.g. 1x PL28-01031-000
+ e.g. 4x PL28-10010-001



The right table legs for any application

System	Standard leg	Telescoping leg	Heavy-duty wheel	Anchoring leg	Scissor lift*
	28	28	28	28	28
PROFIPremiumLINE	●	●	●	●	●
PROFIPlusLINE	●	●	●	●	●
PROFIEcoLINE	●	●	●	●	●
HobbyLINE	●	●	●	●	●


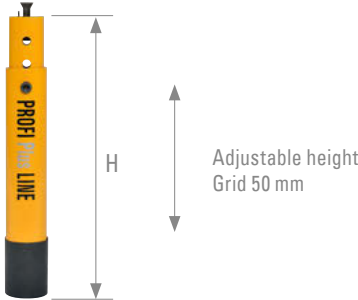

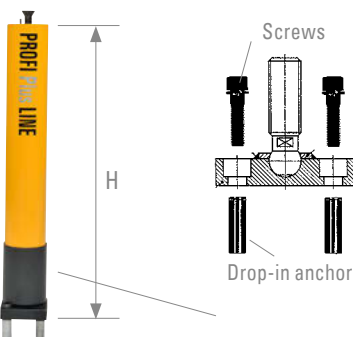
*You will find more detailed information on the scissor lift and order options on page 102.

● available

● by request



Standard leg / telescoping leg / heavy-duty wheel / anchoring leg

Standard leg		Top seller	28				
	For table size		Quantity Legs	Item number	H in mm	Weight in kg	Max. load in kg
	1000x1000		4	PL28-10010-000	650 ^{*1} ± 30	8.5	3000
	1200x800						
	1200x1200						
	1500x1000						
	1500x1500						
	2000x1000						
	2000x2000		6				
	2400x1200						
	3000x1500		11				
	4000x2000						
4800x2400							
Telescoping leg			Quantity Legs	28			
	For table size		Item number	H in mm	Weight in kg	Max. load in kg	
	1000x1000		4	PL28-10010-001	550 to 900 ± 30	12	3000
	1200x800						
	1200x1200						
	1500x1000						
	1500x1500						
	2000x1000						
	2000x2000		6				
	2400x1200						
	3000x1500		11				
	4000x2000						
4800x2400							
Heavy-duty wheel			Quantity Legs	28			
	For table size		Item number	H in mm	Weight in kg	Max. load in kg	
	1000x1000		4	(2x) PL28-10010-002 ^{*2} + (2x) PL28-10010-003 ^{*3}	650 ^{*1} ± 30	12	600
	1200x800					11	
	1200x1200						
	1500x1000						
	1500x1500						
	2000x1000						
	2000x2000		6			12	
	2400x1200					11	
	3000x1500		11			12	
	4000x2000	11					
4800x2400	11						
Anchoring leg			Quantity Legs	28			
	For table size		Item number	H in mm	Weight in kg	Max. load in kg	
	1000x1000		4	PL28-10010-004	650 ^{*1} ± 30	11	3000
	1200x800						
	1200x1200						
	1500x1000						
	1500x1500						
	2000x1000						
	2000x2000		6				
	2400x1200						
	3000x1500		11				
	4000x2000						
4800x2400							

*1 Other leg heights possible on request *2 Wheel with brake *3 Wheel without brake

Scissor lift

- Continuously variable height adjustment
- With safety shutdown board
- Fully adapted to 3D worktable
- Including hand control
- Power unit internal / external (depending on size)



Description ▲

ORDERING EXAMPLE:

(1) On page 90 - 98, select the desired worktop, which results in order item no. 1:



e.g. 1 x PL28-01003-700

+



e.g. 1 x 00000629

=



e.g. 1 x PL28-01003-700
e.g. 1 x 00000629

The two order item numbers make up your order to DEMMELER.

Scissor lift			28	
For table size	Load capacity	H in mm	Item number	Weight in kg
1000x1000	1 to - table weight	385-1310	00016008	155
1200x800	1 to - table weight	200-900	00090594	300
1200x1200	2 to - table weight	200-900	00041421	530
1500x1000	2 to - table weight	200-1000	00040820	500
1500x1500	2 to - table weight	280-1080	00002460	620
2000x1000	2 to - table weight	230-1230	00000628	650
2000x2000	2 to - table weight	280-1280	00090591	950
2400x1200	2 to - table weight	260-1560	00000629	810
3000x1500	3 to - table weight	350-1950	00000627	1000
4000x2000	5 to - table weight	460-2060	00019552	2100
4800x2400	6 to - table weight	460-2060	00090601	2100



Application ▲▼



The scissor lift lift is also available in other dimensions or with a different payload on request.

Holding frame

- Exact positioning of 3D worktables in lengthwise and crosswise direction on the support and base rail is possible
- Very stable version for extremely high loads
- You will find suitable worktops on page 154



Also compatible with:



Description ▲ Application ▼

Application ▼



Setup in lengthwise / crosswise direction

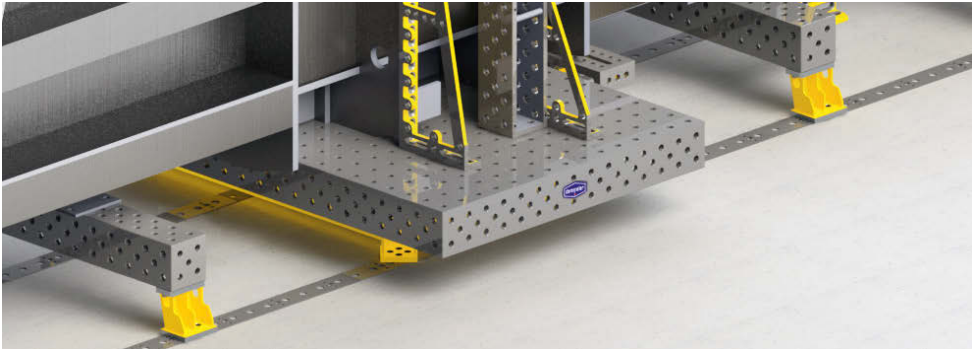


Table size	Track width	H	Weight in kg	Max. load in kg	Item no.
1000 / 1000	1000/1000	600	158	15000	PL00-02004-000
1200 / 1200					
1500 / 1000					
1500 / 1500					
2000 / 1000	2000/1000	600	229	15000	PL00-02004-001
2000 / 2000					
2400 / 1200					
3000 / 1500					
4000 / 2000	4000/2000	600	516	20000	PL00-02004-002
4000 / 2000					
4800 / 2400					

Other sizes by request!



Pivoting foot M 27

For D28 system bores (not for table leg corners)

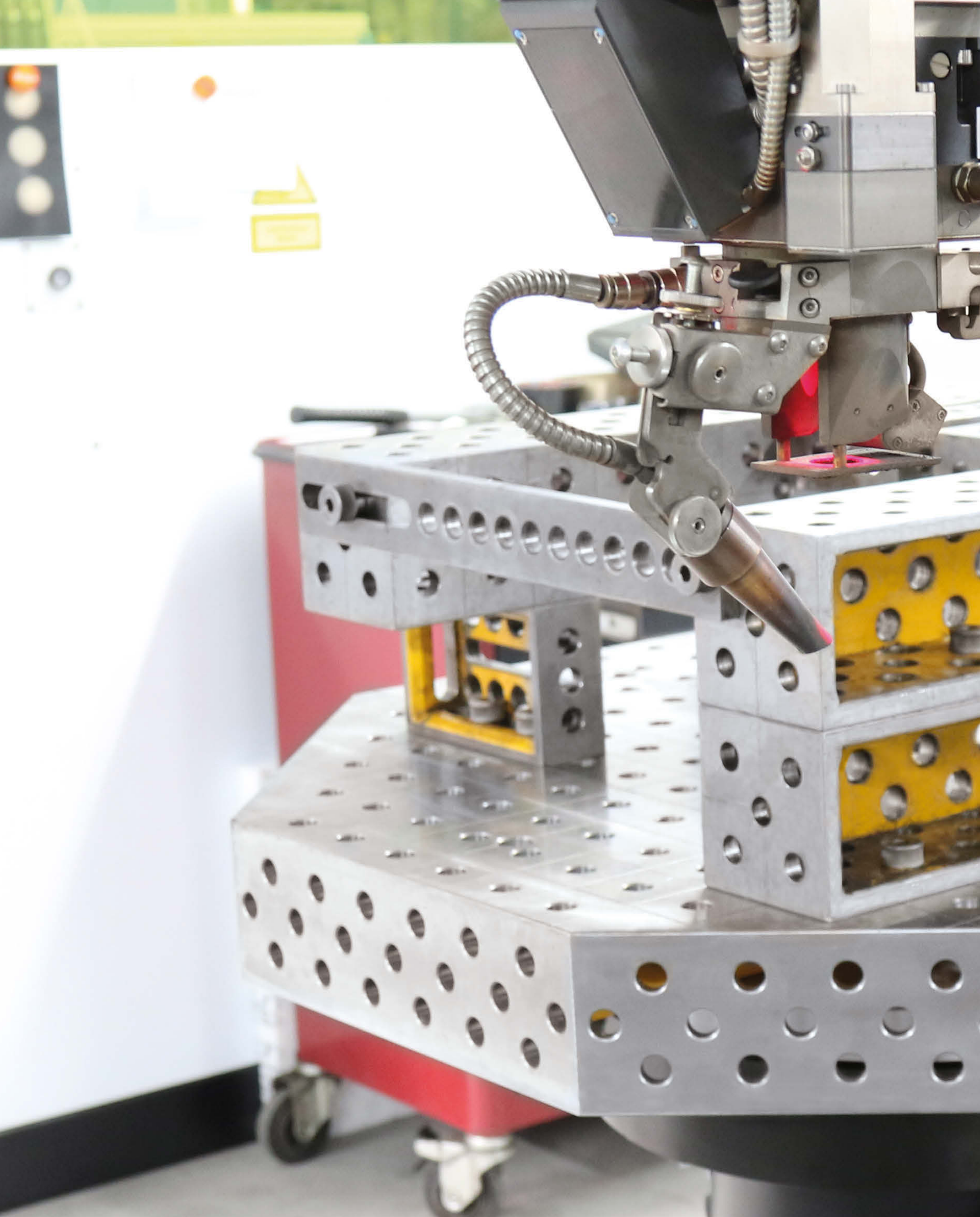
- This leg spindle can be used in any system 28 system bore. For example, to set the holding frame or other system elements onto pivoting feet.
- Scope of delivery: Sturdy M27 threaded spindle with ball head, pivoting foot disc and 2 x M27 nuts



Description ▲ Application



28	A in mm	B Ø in mm	C Ø in mm	Item no.
	140	M27	78	D28-10010-000





OUR PERFORMANCE
makes THE DIFFERENCE

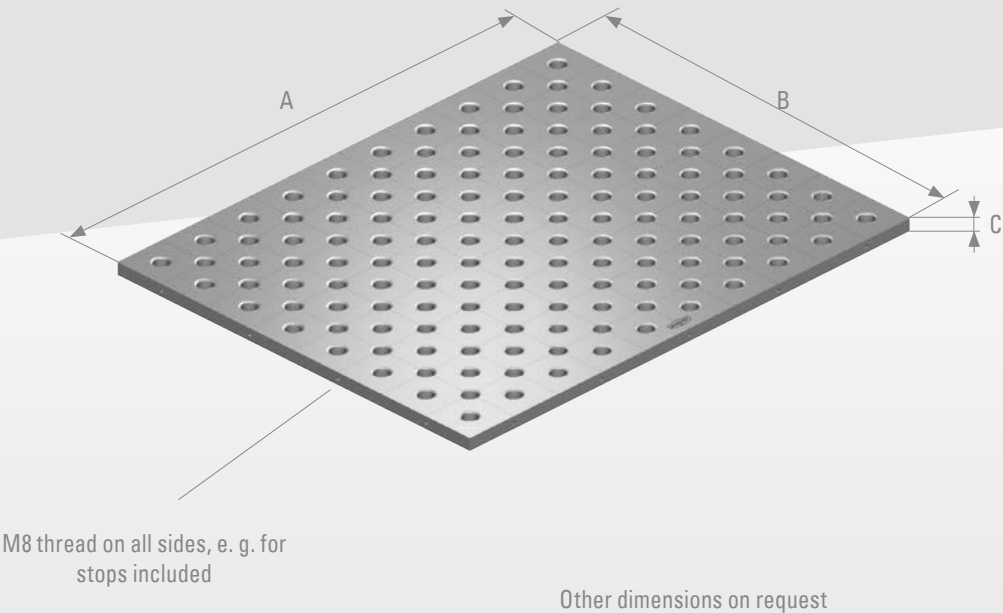
Clamping and adapter plates

Clamping and adapter plate D28	108
D28 clamping and adapter plate Okto AF	109
D28 3D worktable Okto 100	110
D28 3D worktable Okto 200	111
Adapter plate for flanges DIN 2633 / 2632	112
Adapter plate for flanges DIN 2632 / 2633 / 2634 / 2635	112
Clamping plates for ANSI flanges (ANSI standard B 16.5)	113
Flange plates in accordance with the JIS standard	114

Clamping and adapter plate

The miniature worktable with grid lines

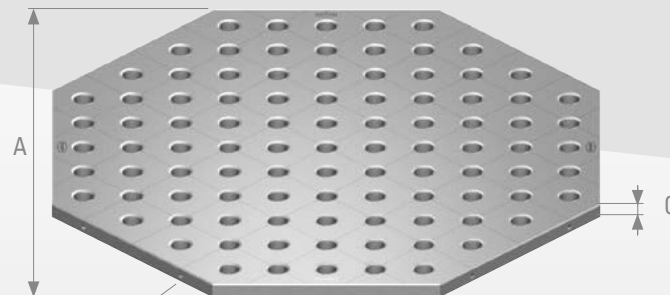
- Used in combination with 3D worktables and welding positioners



Description ▲

28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	1000	800	25	140	Diagonal grid 100 x 100	D28-02001-000

- Used in combination with 3D worktables and welding positioners



M8 thread on all sides, e. g. for stops included

Other dimensions on request

Description ▲

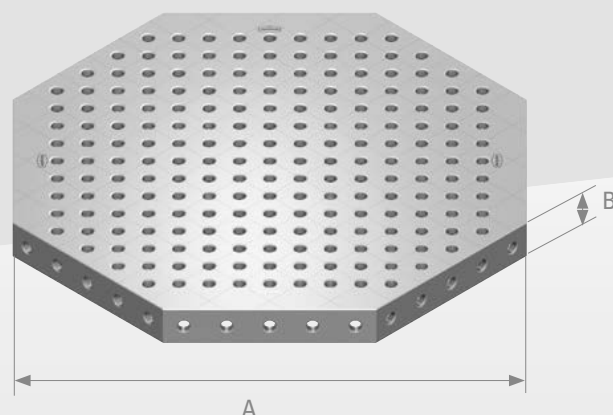
28	A in mm	C in mm	~ Weight in kg	Description	Item no.
	AF 600	25	55	Diagonal grid 100 x 100	D28-02001-201
	AF 800	25	95	Diagonal grid 100 x 100	D28-02001-202
	AF 1000	25	145	Diagonal grid 100 x 100	D28-02001-203

Okto 100 3D worktable

- Preferred use with manipulators in robot cells
- Numerous clamping possibilities on all nine clamping surfaces
- With diagonal grid 100x100

THE FOLLOWING ADDITIONAL OPTIONS ARE POSSIBLE ON REQUEST:

- High-strength aluminium-titanium alloy for ~ 60 % weight reduction and ~ 10 % higher bending strength
- With special connection drilling pattern, adapted to the face plate of your manipulator (please include manipulator type and drawing of the face plate with enquiry - can be offered for a surcharge!)
- Prepared for table legs

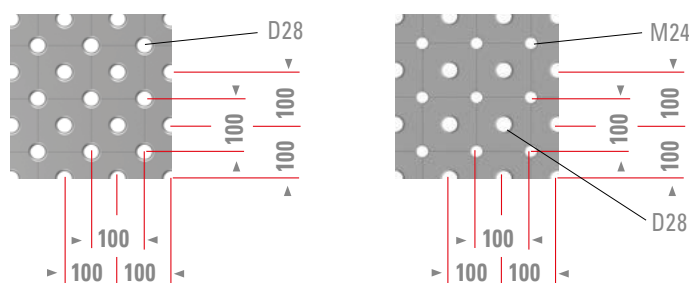


Description ▲ Application ▼

Diagonal grid 100x100 ▼



We can also supply the worktable with 100x100 diagonal grid with M24 thread

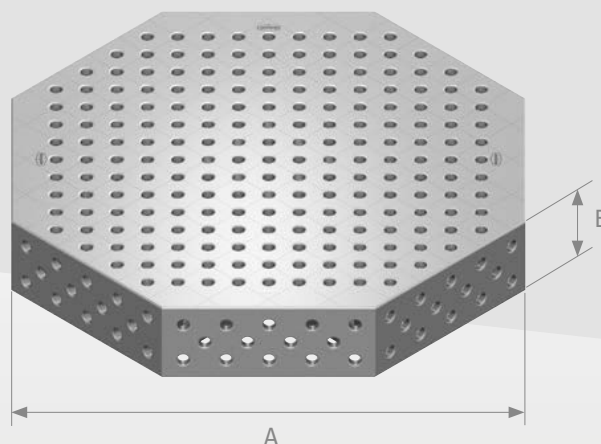


28	A in mm	B in mm	Description	Item no.
	AF 600	100	Diagonal grid 100 x 100	PL28-11008-001
	AF 800	100	Diagonal grid 100 x 100	PL28-01013-001
	AF 1000	100	Diagonal grid 100 x 100	PL28-01038-001
	AF 1200	100	Diagonal grid 100 x 100	PL28-01020-001
	AF 1400	100	Diagonal grid 100 x 100	PL28-01087-001
	AF 1500	100	Diagonal grid 100 x 100	PL28-01059-001
	AF 1600	100	Diagonal grid 100 x 100	PL28-11036-001
	AF 1800	100	Diagonal grid 100 x 100	PL28-01049-001
	AF 2000	100	Diagonal grid 100 x 100	PL28-01058-001
	AF 3000	100	Diagonal grid 100 x 100	PL28-12010-001

- Preferred use with manipulators in robot cells
- Numerous clamping possibilities on all nine clamping surfaces
- With diagonal grid 100x100

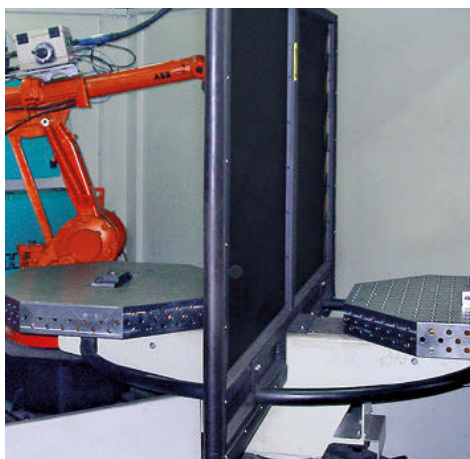
THE FOLLOWING ADDITIONAL OPTIONS ARE POSSIBLE ON REQUEST:

- High-strength aluminium-titanium alloy for ~ 60 % weight reduction and ~ 10 % higher bending strength
- With special connection drilling pattern, adapted to the face plate of your manipulator (please include manipulator type and drawing of the face plate with enquiry - can be offered for a surcharge!)
- Prepared for table legs

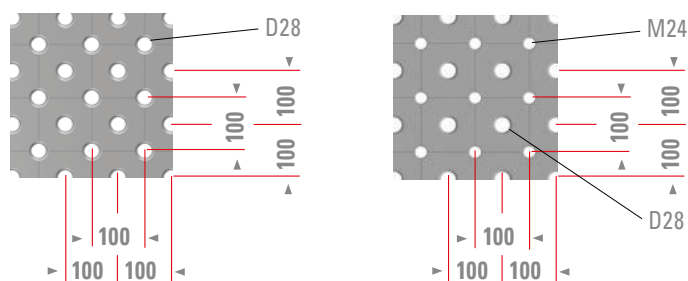


Description ▲ Application ▼

Diagonal grid 100 x 100 ▼



We can also supply the worktable with 100x100 diagonal grid with M24 thread

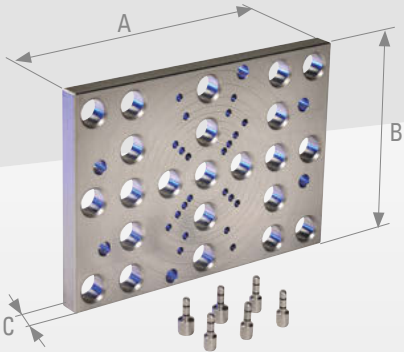


28	A in mm	B in mm	Description	Item no.
	AF 600	200	Diagonal grid 100 x 100	PL28-11008-000
	AF 800	200	Diagonal grid 100 x 100	PL28-01013-000
	AF 1000	200	Diagonal grid 100 x 100	PL28-01038-000
	AF 1200	200	Diagonal grid 100 x 100	PL28-01020-000
	AF 1400	200	Diagonal grid 100 x 100	PL28-01087-000
	AF 1500	200	Diagonal grid 100 x 100	PL28-01059-000
	AF 1600	200	Diagonal grid 100 x 100	PL28-11036-000
	AF 1800	200	Diagonal grid 100 x 100	PL28-01049-000
	AF 2000	200	Diagonal grid 100 x 100	PL28-01058-000
	AF 3000	200	Diagonal grid 100 x 100	PL28-12010-000

Other dimensions on request

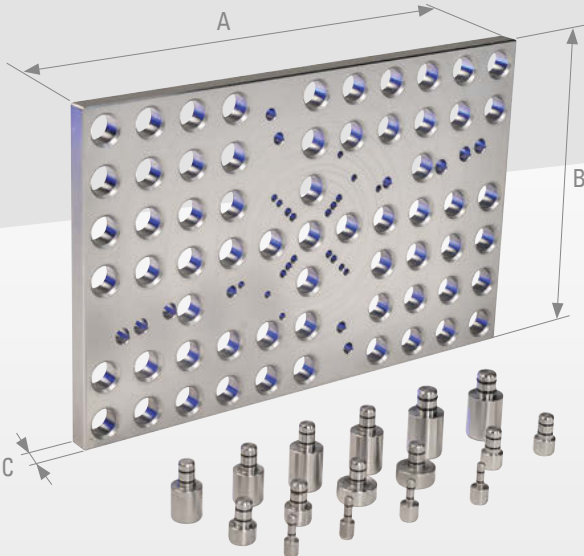
Adapter plate for flanges

Adapter plate for flanges DIN 2632 / 2633 / 2634 / 2635



Marking of the hole circles

D28-02005-000



Marking of the hole circles

D28-02006-000

Description ▼	Description ▼								
<ul style="list-style-type: none">DIN 2633 nominal diameters DN 15 - DN 200DIN 2632 nominal diameters DN 200Incl. attachment bolts:<ul style="list-style-type: none">2 x Ø 13.8 mm2 x Ø 17.8 mm2 x Ø 21.8 mm	<ul style="list-style-type: none">DIN 2632 nominal diameters DN 200 - DN 400DIN 2633 nominal diameters DN 15 - DN 400DIN 2634 nominal diameters DN 200 - DN 400DIN 2635 nominal diameters DN 50 - DN 400Incl. attachment bolts:<table><tr><td>2 x Ø 13.8 mm</td><td>2 x Ø 17.8 mm</td></tr><tr><td>2 x Ø 21.8 mm</td><td>2 x Ø 25.8 mm</td></tr><tr><td>2 x Ø 29.8 mm</td><td>2 x Ø 32.8 mm</td></tr><tr><td>2 x Ø 35.8 mm</td><td>2 x Ø 38.8 mm</td></tr></table>	2 x Ø 13.8 mm	2 x Ø 17.8 mm	2 x Ø 21.8 mm	2 x Ø 25.8 mm	2 x Ø 29.8 mm	2 x Ø 32.8 mm	2 x Ø 35.8 mm	2 x Ø 38.8 mm
2 x Ø 13.8 mm	2 x Ø 17.8 mm								
2 x Ø 21.8 mm	2 x Ø 25.8 mm								
2 x Ø 29.8 mm	2 x Ø 32.8 mm								
2 x Ø 35.8 mm	2 x Ø 38.8 mm								

DIN 2633 / 2632

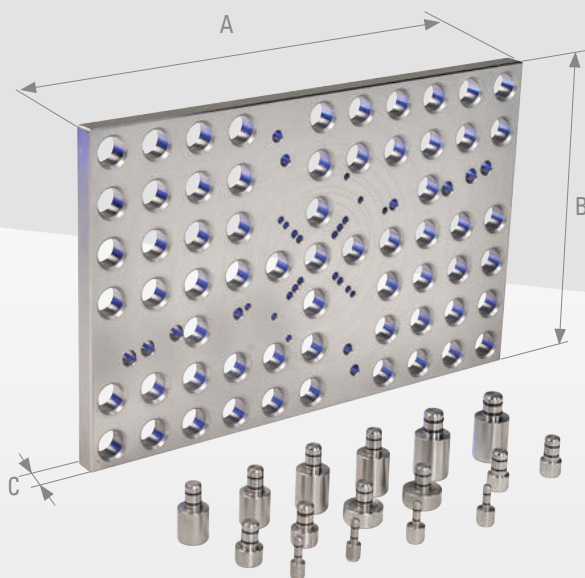
28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	350	250	25	12	Incl. attachment bolts	D28-02005-000

DIN 2632 / 2633 / 2634 / 2635

28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	550	350	25	30	Incl. attachment bolts	D28-02006-000

Clamping plates for ANSI flanges (ANSI standard B 16.5)

Ingenious - the right plate for your flange



Marking of the hole circles

Description ▼

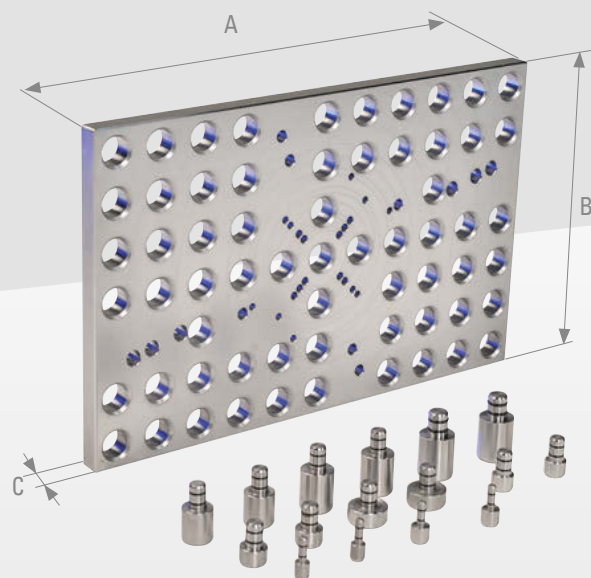
- All clamping plates including attachment bolts
- For pipe flanges can be quickly and precisely set out on the hole circle and attached with the D28-08001-000 quick release skewer. In addition, D28 system bores serve to hold the clamping elements of the system
- Attachment bolts are included in the scope of delivery
- Clamping plate for other flanges on request

Application ▼



28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	350	250	25	12	150 lbs - 1/2" - 08"	D28-02005-011
	350	250	25	12	300 lbs - 1/2" - 08"	D28-02005-012
	350	250	25	12	600 lbs - 1/2" - 06"	D28-02005-013
	550	350	25	30	150 lbs - 1/2" - 14"	D28-02006-026
	550	350	25	30	300 lbs - 1/2" - 14"	D28-02006-024
	550	350	25	30	600 lbs - 1/2" - 14"	D28-02006-025

Clamping plates for flanges as per JIS standard



Marking of the hole circles

Application ▼



28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	350	250	25	12	JIS 5K – DN 10 – DN 225	D28-02005-018
	550	350	25	30	JIS 5K – DN 10 – DN 450	D28-02006-034
	350	250	25	12	JIS 10K – DN 10 – DN 225	D28-02005-019
	550	350	25	30	JIS 10K – DN 10 – DN 450	D28-02006-005
	350	250	25	12	JIS 16K/20K – DN 10 – DN 200	D28-02005-020
	550	350	25	30	JIS 16K/20K – DN 10 – DN 400	D28-02006-035
	350	250	25	12	JIS 30K – DN 10 – DN 200	D28-02005-021
	550	350	25	30	JIS 30K – DN 10 – DN 350	D28-02006-036
	350	250	25	12	JIS 40K – DN 10 – DN 150	D28-02005-022
	550	350	25	30	JIS 40K – DN 10 – DN 350	D28-02006-037
	350	250	25	12	JIS 63K – DN 10 – DN 150	D28-02005-023
	550	350	25	30	JIS 63K – DN 10 – DN 350	D28-02006-038



**PP ⇄ PL ⇄ PE
= 100% compatible**

Thus, for example, accessories from the PROFIPremium set can be used on a PROFIPlusLINE table.

Sets

PROFIPremiumLINE set 710 D28	116
PROFIPremiumLINE set 720 D28	117
PROFIPremiumLINE set 730 D28	118
PROFIPremiumLINE set 740 D28	120
PROFIPlusLINE set 710 D28	122
PROFIPlusLINE set 720 D28	123
PROFIPlusLINE set 730 D28	124
PROFIPlusLINE set 740 D28	126
PROFIEcoLINE set 710 D28	128
PROFIEcoLINE set 720 D28	129
PROFIEcoLINE set 730 D28	130
PROFIEcoLINE set 740 D28	131

PROFIPremiumLINE set 710 (System 28)

Item number: P28-52000-710 (46-piece)

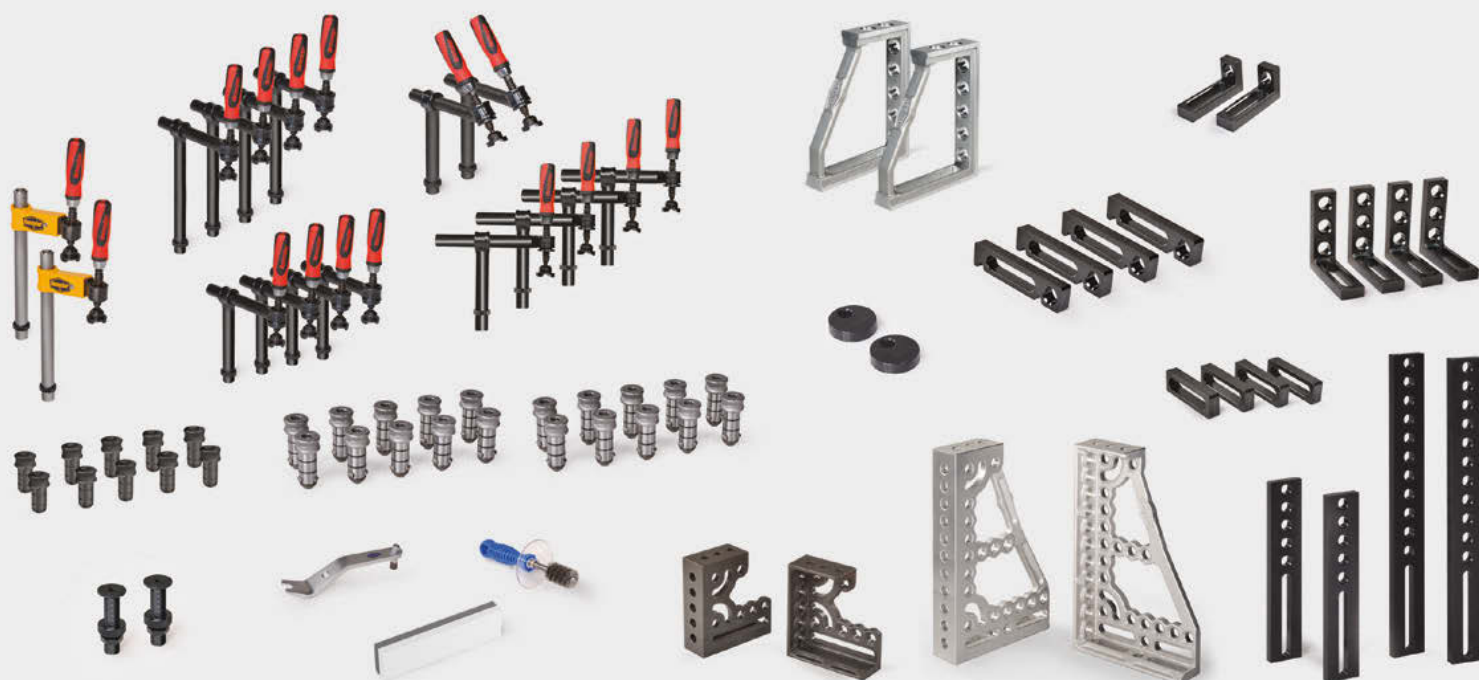


Quantity ▼	Item no. ▼	Item description ▼
1	P28-03002-000	PP clamping and locating angle, right 300x275 mm, hardened
1	P28-03002-001	PP clamping and locating angle, left 300x275 mm, hardened
4	PE28-03001-000	Clamping and locating angle 175x175x50 mm (bore / oblong hole)
4	D28-05001-010	Universal stop with scale 225x50x25 mm
2	D28-05003-000	Stop-strip L 500 - 500x100x25 mm
4	D28-05015-000	Displacement stop - 150x50x25 mm, scale on both sides
12	D28-06025-000	PPC bolt / short - Ø 28-0.02, AF 14, full surface support for optimum force transmission
6	D28-06009-000	Stop and positioning bolt Ø 28 / 40x74 mm
2	D28-07002-000	Compensating swing clamp 200 mm with spindle
4	D28-07005-000	Screw clamp 180° with spindle - vertical tube 220 mm
4	D28-07009-033	Performance-clamp incl. spindle - vertical tube 250 mm, angle-adjustable +-50°
1	D28-10002-000	Round brush Ø 28x260 mm, with protective cap
1	D00-10016-001	Extraction tool - 250x40 mm, AF 14

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIPremium set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFIPremiumLINE set 720 (System 28)

Item number: P28-52000-720 (77-piece)



Quantity ▼	Item no. ▼	Item description ▼
1	P28-03002-000	PP clamping and locating angle, right 300x275 mm, hardened
1	P28-03002-001	PP clamping and locating angle, left 300x275 mm, hardened
1	P28-03003-002	PP clamping and locating angle, aluminium-titanium, right 600x375 mm
1	P28-03003-003	PP clamping and locating angle, aluminium-titanium, left 600x375 mm
4	PE28-03001-000	Clamping and locating angle 175x175x50 mm (bore / oblong hole)
2	D28-03001-005	Clamping and locating angle / small 175x75x50 mm, scale on both sides
2	PP28-03001-017	Clamping and locating angle 250x300x50x150 mm, aluminium-titanium (bore / bore / oblong hole)
4	D28-05001-010	Universal stop with scale 225x50x25 mm
2	D28-05003-000	Stop-strip L 500 - 500x100x25 mm
2	D28-05003-001	Stop-strip L 800 - 800x100x25 mm
2	D28-05013-001	Locating disk Ø 100 - stop dimension 25-75 mm, continuous
4	D28-05015-000	Displacement stop - 150x50x25 mm, scale on both sides
20	D28-06025-000	PPC bolt / short - Ø 28-0.02, AF 14, full surface support for optimum force transmission
10	D28-06009-000	Stop and positioning bolt Ø 28 / 40x74 mm
2	D28-07002-000	Compensating swing clamp 200 mm with spindle
4	D28-07005-014	Screw clamp 180° with spindle - vertical tube 350 mm
4	D28-07005-033	Screw clamp 180° with spindle - vertical tube 500 mm
2	D28-07009-011	Variable screw clamp 45° with adjusting screw - vertical tube 350 mm
4	D28-07009-033	Performance-clamp incl. spindle - vertical tube 250 mm, angle-adjustable + -50°
2	D28-09001-005	Spacer set with thread - Ø 50x125 mm, height compensation 22-105 mm, continuous
1	D28-10002-000	Round brush Ø 28x260 mm, with protective cap
1	D00-10007-000	Bench stone 200x50x25 mm, 2-sided
1	D00-10016-001	Extraction tool - 250x40 mm, AF 14

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIPremium set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFI PremiumLINE set 730 (System 28)

Item number: P28-52000-730 (122-piece)





PROFI PremiumLINE set 730 (System 28)

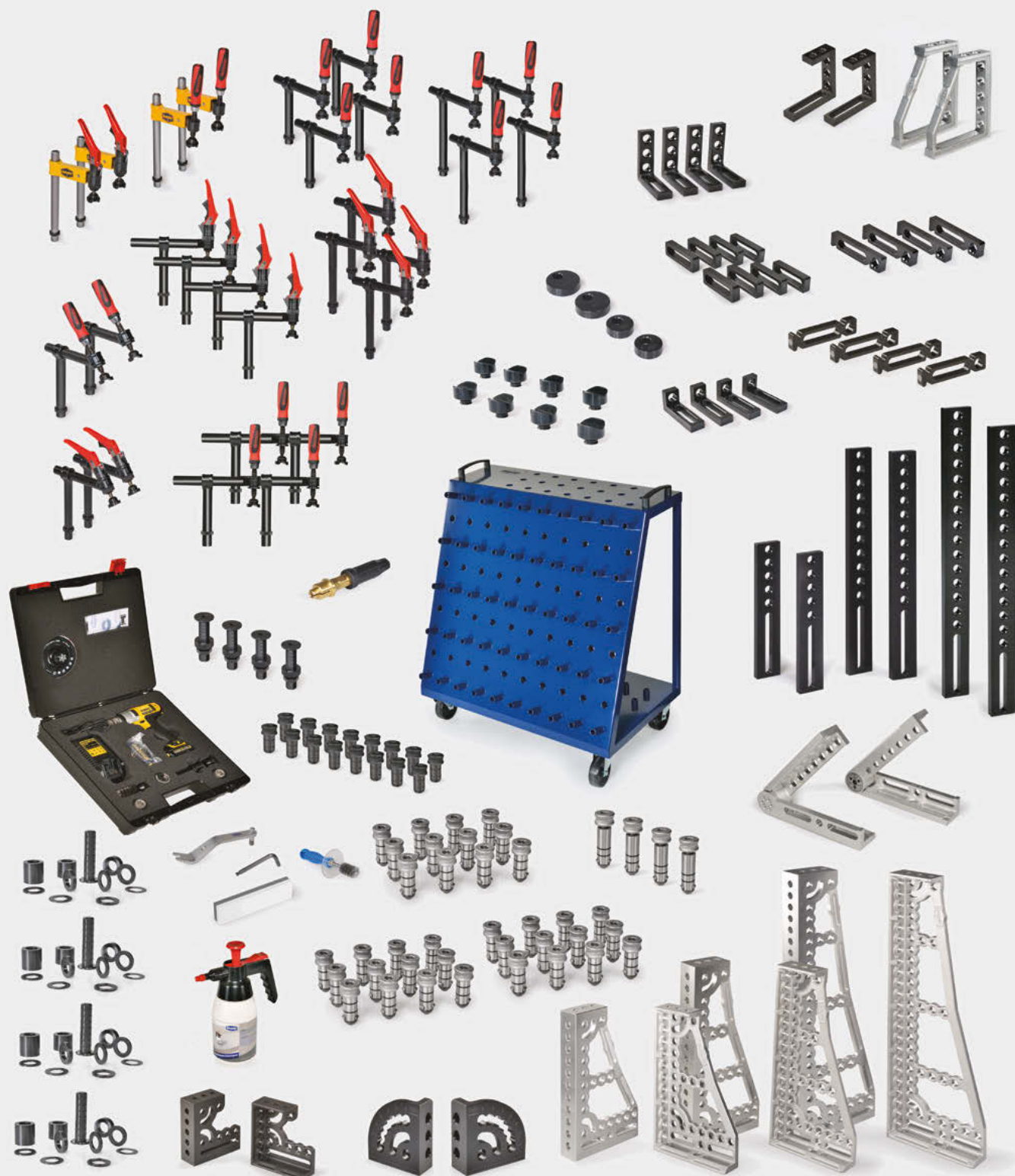
Item number: P28-52000-730 (122-piece)

Quantity ▼	Item no. ▼	Item description ▼
1	P28-03002-000	PP clamping and locating angle, right 300x275 mm, hardened
1	P28-03002-001	PP clamping and locating angle, left 300x275 mm, hardened
1	P28-03003-002	PP clamping and locating angle, aluminium-titanium, right 600x375 mm
1	P28-03003-003	PP clamping and locating angle, aluminium-titanium, left 600x375 mm
4	PE28-03001-000	Clamping and locating angle 175x175x50 mm (bore / oblong hole)
1	P28-03004-000	PP clamping and locating angle, aluminium-titanium, right 800x375 mm
1	P28-03004-001	PP clamping and locating angle, aluminium-titanium, left 800x375 mm
4	D28-03001-005	Clamping and locating angle / small 175x75x50 mm, scale on both sides
2	PP28-03001-017	Clamping and locating angle 250x300x50x150 mm, aluminium-titanium (bore / bore / oblong hole)
2	PL28-03001-015	Clamping and locating angle 225x200x50x125 mm, hardened (bore / bore / oblong hole)
1	D28-05013-011	PP angle bracket, right 200x200x75 mm, hardened
1	D28-05013-012	PP angle bracket, left 200x200x75 mm, hardened
4	D28-05001-001	Universal stop / large with plunger 225x50x25 mm
4	D28-05001-010	Universal stop with scale 225x50x25 mm
2	D28-05003-000	Stop-strip L 500 - 500x100x25 mm
2	D28-05003-001	Stop-strip L 800 - 800x100x25 mm
2	D28-05003-008	Stop-strip L 1000 - 1000x100x25 mm
2	D28-05013-000	Locating disk Ø 75 - stop dimension 25-50 mm, continuous
2	D28-05013-001	Locating disk Ø 100 - stop dimension 25-75 mm, continuous
8	D28-05015-000	Displacement stop - 150x50x25 mm, scale on both sides
24	D28-06025-000	PPC bolt / short - Ø 28-0.02, AF 14, full surface support for optimum force transmission
12	D28-06009-000	Stop and positioning bolt Ø 28 / 40x74 mm
2	D28-07001-001	Compensating swing clamp 150 mm with quick-action clamping cylinder
2	D28-07002-000	Compensating swing clamp 200 mm with spindle
4	D28-07005-014	Screw clamp 180° with spindle - vertical tube 350 mm
4	D28-07005-015	Screw clamp 180° with quick-action clamping cylinder - vertical tube 350 mm
4	D28-07005-033	Screw clamp 180° with spindle - vertical tube 500 mm
2	D28-07009-011	Variable screw clamp 45° with adjusting screw - vertical tube 350 mm
2	D28-07009-012	Variable screw clamp 45° with quick-action clamping cylinder - vertical tube 350 mm
4	D28-07009-033	Performance-clamp incl. spindle - vertical tube 250 mm, angle-adjustable +-50°
4	D28-09001-005	Spacer set with thread - Ø 50x125 mm, height compensation 22-105 mm, continuous
8	D28-09003-000	V-block locations blackened steel, Ø 58 mm - 130° - for tubes up to Ø 70 mm
1	D28-10002-000	Round brush Ø 28x260 mm, with protective cap
1	D00-10007-000	Bench stone 200x50x25 mm, 2-sided
1	D00-10009-000	Ground connector D16/D28 - for cable 50-70 mm², load up to 500 A
1	D00-10016-001	Extraction tool - 250x40 mm, AF 14

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIPremium set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFI PremiumLINE set 740 (System 28)

Item number: P28-52000-740 (158-piece)





PROFIPremiumLINE set 740 (System 28)

Item number: P28-52000-740 (158-piece)

Quantity ▼	Item no. ▼	Item description ▼
1	P28-03002-000	PP clamping and locating angle, right 300x275 mm, hardened
1	P28-03002-001	PP clamping and locating angle, left 300x275 mm, hardened
1	P28-03003-002	PP clamping and locating angle, aluminium-titanium, right 600x375 mm
1	P28-03003-003	PP clamping and locating angle, aluminium-titanium, left 600x375 mm
4	PE28-03001-000	Clamping and locating angle 175x175x50 mm (bore / oblong hole)
1	P28-03004-000	PP clamping and locating angle, aluminium-titanium, right 800x375 mm
1	P28-03004-001	PP clamping and locating angle, aluminium-titanium, left 800x375 mm
1	P28-03009-000	PP clamping and locating angle, aluminium-titanium, right 1200x375 mm
1	PL28-03009-001	PP clamping and locating angle, aluminium-titanium, left 1200x375 mm
4	D28-03001-005	Clamping and locating angle / small 175x75x50 mm, scale on both sides
2	PL28-03001-015	Clamping and locating angle 200x225 mm, hardened (bore / bore / oblong hole)
2	PP28-03001-017	Clamping and locating angle 250x300x50x150 mm, aluminium-titanium (bore / bore / oblong hole)
1	P28-05013-011	PP angle bracket, right 200x200x75 mm, hardened
1	P28-05013-012	PP angle bracket, left 200x200x75 mm, hardened
1	D28-03007-004	Universal pivot and tilt angle aluminium-titanium, right (0-225°)
1	D28-03007-005	Universal pivot and tilt angle aluminium-titanium, left (0-225°)
4	D28-05001-001	Universal stop / large with plunger 225x50x25 mm
4	D28-05001-010	Universal stop with scale 225x50x25 mm
2	D28-05003-000	Stop-strip L 500 - 500x100x25 mm
2	D28-05003-001	Stop-strip L 800 - 800x100x25 mm
2	D28-05003-008	Stop-strip L 1000 - 1000x100x25 mm
2	D28-05013-000	Locating disk Ø 75 - stop dimension 25-50 mm, continuous
2	D28-05013-001	Locating disk Ø 100 - stop dimension 25-75 mm, continuous
8	D28-05015-000	Displacement stop - 150x50x25 mm, scale on both sides
36	D28-06025-000	PPC bolt / short - Ø 28-0.02, AF 14, full surface support for optimum force transmission
4	D28-06026-000	PPC bolt / long - Ø 28-0.02, AF 14, full surface support for optimum force transmission
16	D28-06009-000	Stop and positioning bolt Ø 28 / 40x74 mm
2	D28-07001-001	Compensating swing clamp 150 mm with quick-action clamping cylinder
2	D28-07002-000	Compensating swing clamp 200 mm with spindle
4	D28-07005-014	Screw clamp 180° with spindle - vertical tube 350 mm
4	D28-07005-015	Screw clamp 180° with quick-action clamping cylinder - vertical tube 350 mm
4	D28-07005-033	Screw clamp 180° with spindle - vertical tube 500 mm
2	D28-07009-011	Variable screw clamp 45° with adjusting screw - vertical tube 350 mm
2	D28-07009-012	Variable screw clamp 45° with quick-action clamping cylinder - vertical tube 350 mm
4	D28-07009-033	Performance-clamp incl. spindle - vertical tube 250 mm, angle-adjustable +-50°
4	D28-07009-035	Performance clamp with quick-action clamping cylinder - vertical tube 250 mm, angle-adjustable +-50°
4	D28-09001-000	Spacer set 11 pieces - Ø 50x125 mm, height compensation 5-100 mm increment 1 mm
4	D28-09001-005	Spacer set with thread - Ø 50x125 mm, height compensation 22-105 mm, continuous
8	D28-09003-000	V-block locations blackened steel, Ø 58 mm - 130° - for tubes up to Ø 70 mm
1	D28-10002-000	Round brush Ø 28x260 mm, with protective cap
1	D00-10005-000	Pump bottle with 1 litre Öko anti-spatter spray
1	D00-10007-000	Bench stone 200x50x25 mm, 2-sided
1	D28-10008-000	Ball end hex wrench AF 14x150 mm
1	D00-10009-000	Ground connector D16/D28 - for cable 50-70 mm², load up to 500 A
1	D00-10016-001	Extraction tool - 250x40 mm, AF 14
1	D28-11001-000	Accessory cart - WxDxH = 1000x650x1010 mm, 4 casters
1	D28-13050-000	Power screwdriver set in carrying case

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIPremium set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFIPlusLINE set 710 (System 28)

Item number: D28-52000-710 (44-piece)



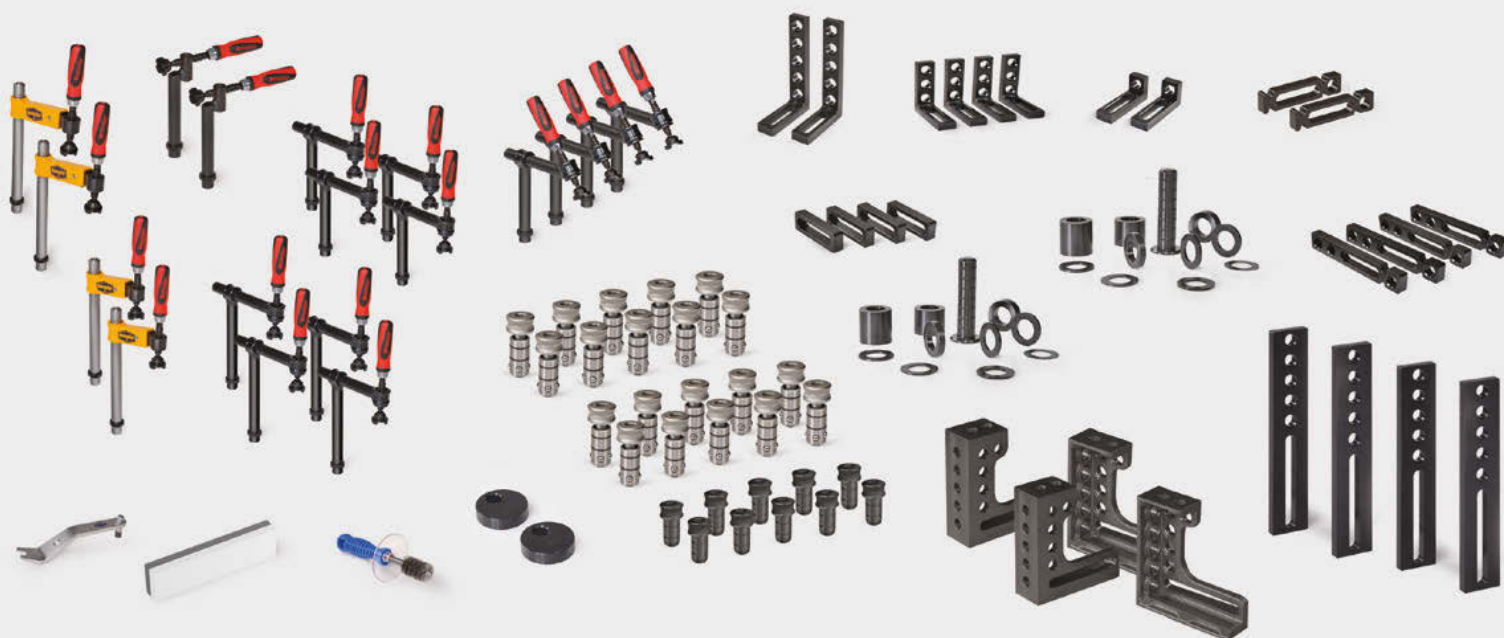
Depicted set also available with PPC bolts instead of PC bolts:
Item no. D28-52000-711


Quantity ▼	Item no. ▼	Item description ▼
4	PE28-03001-000	Clamping and locating angle 175x175x50 mm (bore / oblong hole)
2	PE28-03008-000	Clamping and locating angle 275x175x50 mm
4	D28-05001-000	Universal stop / large 225x50x25 mm
2	D28-05009-000	Universal stop L 300 - 300x50x25 mm
4	D28-05015-000	Displacement stop - 150x50x25 mm, scale on both sides
12	D28-06001-000	PC-bolt / short - Ø 28-0.02, AF 14, clamping range 41-47 mm, 25/200 kN
6	D28-06009-000	Stop and positioning bolt Ø 28 / 40x74 mm
4	D28-07002-000	Compensating swing clamp 200 mm with spindle
4	D28-07009-000	Variable screw clamp 45° with adjusting screw - vertical tube 220 mm
1	D28-10002-000	Round brush Ø 28x260 mm, with protective cap
1	D00-10016-001	Extraction tool - 250x40 mm, AF 14

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFILPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFIPlusLINE set 720 (System 28)

Item number: D28-52000-720 (81-piece)



 Depicted set also available with PPC bolts instead of PC bolts:
Item no. D28-52000-721

Quantity ▼	Item no. ▼	Item description ▼
4	PE28-03001-000	Clamping and locating angle 175x175x50 mm (bore / oblong hole)
2	D28-03001-005	Clamping and locating angle / small 175x75x50 mm, scale on both sides
2	PL28-03002-000	Clamping and locating angle, right 300x275 mm
2	PL28-03002-001	Clamping and locating angle, left 300x275 mm
2	PE28-03008-000	Clamping and locating angle 275x175x50 mm
2	D28-05001-000	Universal stop / large 225x50x25 mm
4	D28-05003-000	Stop-strip L 500 - 500x100x25 mm
4	D28-05009-000	Universal stop L 300 - 300x50x25 mm
2	D28-05013-001	Locating disk Ø 100 - stop dimension 25-75 mm, continuous
4	D28-05015-000	Displacement stop - 150x50x25 mm, scale on both sides
20	D28-06001-000	PC-bolt / short - Ø 28-0.02, AF 14, clamping range 41-47 mm, 25/200 kN
10	D28-06009-000	Stop and positioning bolt Ø 28 / 40x74 mm
2	D28-07001-000	Compensating swing clamp 150 mm with spindle
2	D28-07002-000	Compensating swing clamp 200 mm with spindle
4	D28-07005-000	Screw clamp 180° with spindle - vertical tube 220 mm
4	D28-07005-014	Screw clamp 180° with spindle - vertical tube 350 mm
2	D28-07008-000	Variable screw clamp 90° - vertical tube 260 mm
4	D28-07009-000	Variable screw clamp 45° with adjusting screw - vertical tube 220 mm
2	D28-09001-000	Spacer set 11 pieces - Ø 50x125 mm
1	D28-10002-000	Round brush Ø 28x260 mm, with protective cap
1	D00-10007-000	Bench stone 200x50x25 mm, 2-sided
1	D00-10016-001	Extraction tool - 250x40 mm, AF 14

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFIPlusLINE set 730 (System 28)

Item number: D28-52000-730 (120-piece)



Depicted set also available with PPC bolts instead of PC bolts:
Item no. D28-52000-731



PROFIPlusLINE set 730 (System 28)

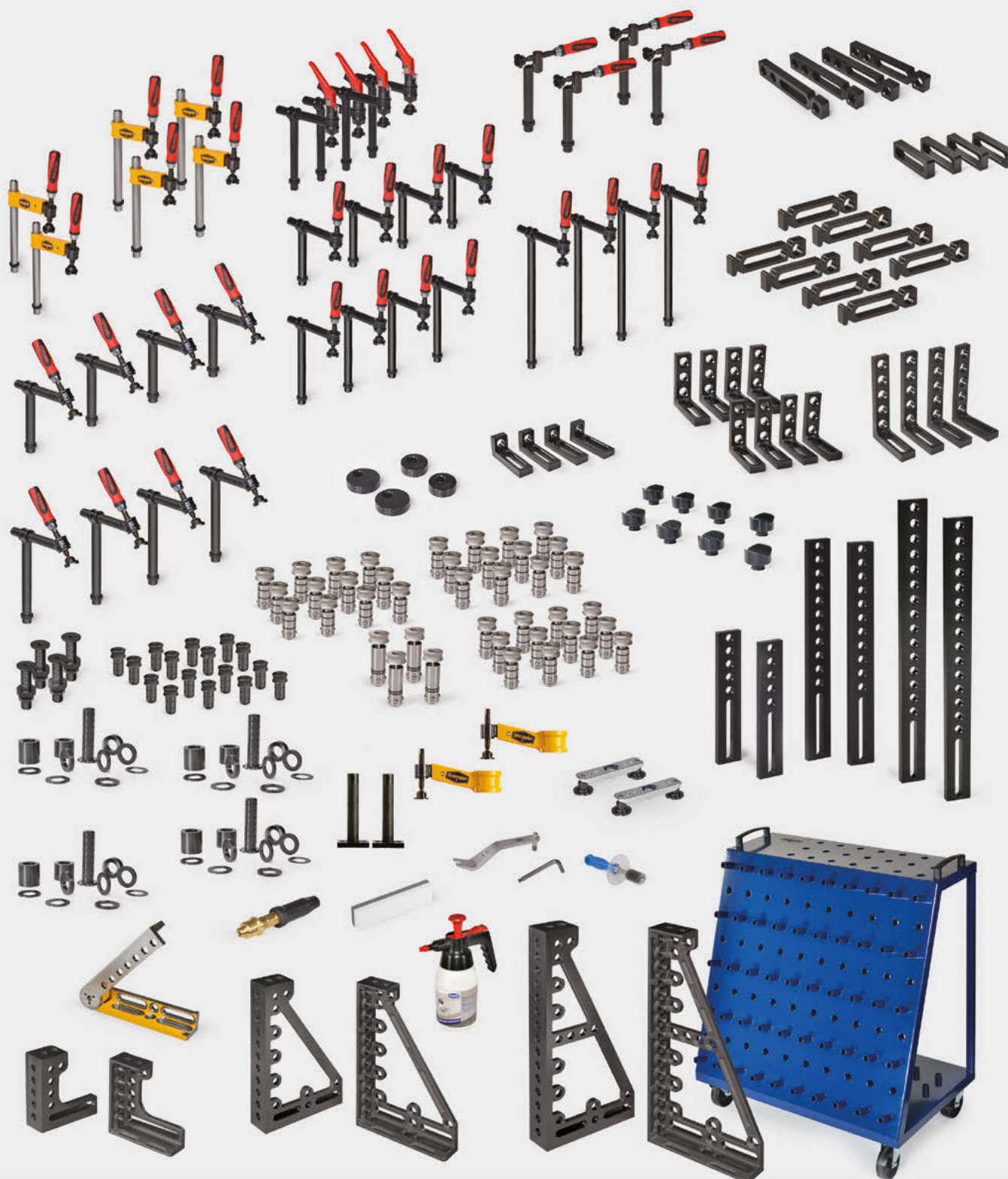
Item number: D28-52000-730 (120-piece)

Quantity ▼	Item no. ▼	Item description ▼
4	PE28-03001-000	Clamping and locating angle 175x175x50 mm
4	D28-03001-005	Clamping and locating angle / small 175x75x50 mm, scale on both sides
1	PL28-03002-000	Clamping and locating angle, right 300x275 mm
1	PL28-03002-001	Clamping and locating angle, left 300x275 mm
1	PL28-03003-000	Clamping and locating angle, right 600x375 mm
1	PL28-03003-001	Clamping and locating angle, left 600x375 mm
4	PE28-03008-000	Clamping and locating angle 275x175x50 mm
4	D28-05001-000	Universal stop / large 225x50x25 mm
2	D28-05003-000	Stop-strip L 500 - 500x100x25 mm
2	D28-05003-001	Stop-strip L 800 - 800x100x25 mm
4	D28-05009-000	Universal stop L 300 - 300x50x25 mm
2	D28-05013-000	Locating disk Ø 75 - stop dimension 25-50 mm, continuous
2	D28-05013-001	Locating disk Ø 100 - stop dimension 25-75 mm, continuous
2	D28-05013-010	Angle-setting template, scale on both sides, 0 - 90°, 15°, 30°, 45°, 60°
4	D28-05015-000	Displacement stop - 150x50x25 mm, scale on both sides
24	D28-06001-000	PC-bolt / short - Ø 28-0.02, AF 14, clamping range 41-47 mm, 25/200 kN
2	D28-06002-000	PC-bolts / long - Ø 28-0.02, AF 14, clamping range 66-72 mm, 25/200 kN
12	D28-06009-000	Stop and positioning bolt Ø 28 / 40x74 mm
2	D28-07001-000	Compensating swing clamp 150 mm with spindle
2	D28-07002-000	Compensating swing clamp 200 mm with spindle
4	D28-07005-000	Screw clamp 180° with spindle - vertical tube 220 mm
4	D28-07005-014	Screw clamp 180° with spindle - vertical tube 350 mm
4	D28-07005-015	Screw clamp 180° with quick-action clamping cylinder - vertical tube 350 mm
4	D28-07008-000	Variable screw clamp 90° - vertical tube 260 mm
4	D28-07009-000	Variable screw clamp 45° with adjusting screw - vertical tube 220 mm
4	D28-07009-011	Variable screw clamp 45° with adjusting screw - vertical tube 350 mm
2	D28-09001-000	Spacer set 11 pieces - Ø 50x125 mm
2	D28-09001-005	Spacer set with thread - Ø 50x125 mm
8	D28-09003-000	V-block locations blackened steel, Ø 58 mm - 130° - for tubes up to Ø 70 mm
1	D28-10002-000	Round brush Ø 28x260 mm
1	D00-10007-000	Bench stone 200x50x25 mm
1	D00-10009-000	Ground connector D16/D28 - for cable 50-70 mm², load up to 500 A
1	D00-10016-001	Extraction tool - 250x40 mm, AF 14

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFIPlusLINE set 740 (System 28)

Item number: D28-52000-740 (168-piece)



Depicted set also available with PPC bolts instead of PC bolts:
Item no. D28-52000-741



PROFIPlusLINE set 740 (System 28)

Item number: D28-52000-740 (168-piece)

Quantity ▼	Item no. ▼	Item description ▼
8	PE28-03001-000	Clamping and locating angle 175x175x50 mm (bore / oblong hole)
4	D28-03001-005	Clamping and locating angle / small 175x75x50 mm, scale on both sides
1	PL28-03002-000	Clamping and locating angle, right 300x275 mm
1	PL28-03002-001	Clamping and locating angle, left 300x275 mm
1	PL28-03003-000	Clamping and locating angle, right 600x375 mm
1	PL28-03003-001	Clamping and locating angle, left 600x375 mm
1	PL28-03004-000	Clamping and locating angle, right 800x375 mm
1	PL28-03004-001	Clamping and locating angle, left 800x375 mm
1	D28-03007-000	Universal pivot and tilt angle, right (0-225°), 475x100x100 mm
4	PE28-03008-000	Clamping and locating angle 275x175x50 mm
8	D28-05001-000	Universal stop / large 225x50x25 mm
2	D28-05003-000	Stop-strip L 500 - 500x100x25 mm
2	D28-05003-001	Stop-strip L 800 - 800x100x25 mm
2	D28-05003-008	Stop-strip L 1000 - 1000x100x25 mm
2	D28-05006-000	Multi-clamping and support tower Ø 55 mm - height 1000 mm
2	D28-05007-000	Compensating clamping arm with short boring spindle - location Ø 55 mm, 20 kN clamping force, AF14
4	D28-05009-000	Universal stop L 300 - 300x50x25 mm
2	D28-05013-000	Locating disk Ø 75 - stop dimension 25-50 mm, continuous
2	D28-05013-001	Locating disk Ø 100 - stop dimension 25-75 mm, continuous
4	D28-05015-000	Displacement stop - 150x50x25 mm, scale on both sides
36	D28-06001-000	PC-bolt / short - Ø 28-0.02, AF 14, clamping range 41-47 mm, 25/200 kN
4	D28-06002-000	PC-bolts / long - Ø 28-0.02, AF 14, clamping range 66-72 mm, 25/200 kN
16	D28-06009-000	Stop and positioning bolt Ø 28 / 40x74 mm
2	D28-07001-000	Compensating swing clamp 150 mm with spindle
4	D28-07002-000	Compensating swing clamp 200 mm with spindle
4	D28-07005-000	Screw clamp 180° with spindle - vertical tube 220 mm
4	D28-07005-014	Screw clamp 180° with spindle - vertical tube 350 mm
4	D28-07005-015	Screw clamp 180° with quick-action clamping cylinder - vertical tube 350 mm
4	D28-07005-033	Screw clamp 180° with spindle - vertical tube 500 mm
4	D28-07008-000	Variable screw clamp 90° - vertical tube 260 mm
4	D28-07009-000	Variable screw clamp 45° with adjusting screw - vertical tube 220 mm
4	D28-07009-011	Variable screw clamp 45° with adjusting screw - vertical tube 350 mm
2	D28-07018-000	2P. clamping bridge with 2 ball pins and 2 steel clamping pads - Ø 170x35x35 mm
4	D28-09001-000	Spacer set 11 pieces - Ø 50x125 mm, height compensation 5-100 mm increment 1 mm
4	D28-09001-005	Spacer set with thread - Ø 50x125 mm, height compensation 22-105 mm, continuous
8	D28-09003-000	V-block locations blackened steel, Ø 58 mm - 130° - for tubes up to Ø 70 mm
1	D28-10002-000	Round brush Ø 28x260 mm, with protective cap, for cleaning the system bore
1	D00-10005-000	Pump bottle with 1 litre Öko anti-spatter spray
1	D00-10007-000	Bench stone 200x50x25 mm, 2-sided, for maintaining the system surfaces
1	D28-10008-000	Ball end hex wrench AF 14x150 mm
1	D00-10009-000	Ground connector D16/D28 - for cable 50-70 mm², load up to 500 A
1	D00-10016-001	Extraction tool - 250x40 mm, AF 14
1	D28-11001-000	Accessory cart - WxDxH = 1000x650x1010 mm, 4 casters

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFI^{Eco}LINE set 710 (System 28)

Item number: E28-52000-710 (32-piece)



Depicted set also available with PC or PPC bolts instead of ECOline bolts:
Set with PC bolts: Item no. E28-52000-711 or set with PPC bolts: Item no. E28-52000-712

Quantity ▼	Item no. ▼	Item description ▼
4	PE28-03001-000	ECO clamping and locating angle 175x175x50 mm
4	E28-05001-000	ECO universal stop / large 225x50x25 mm
2	E28-05002-000	ECO universal stop / small 100x50x25 mm
2	E28-05013-001	ECO locating disk 25-75 mm
12	E28-06001-000	ECOline bolts / short - Ø 28x95 mm
6	E28-07005-000	ECO screw clamp 180° with spindle
1	E28-10002-000	ECO round brush Ø 30 mm
1	E28-10008-000	ECO ball-head Allen key AF 8

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFI^{Eco}LINE set 720 (System 28)

Item number: E28-52000-720 (52-piece)



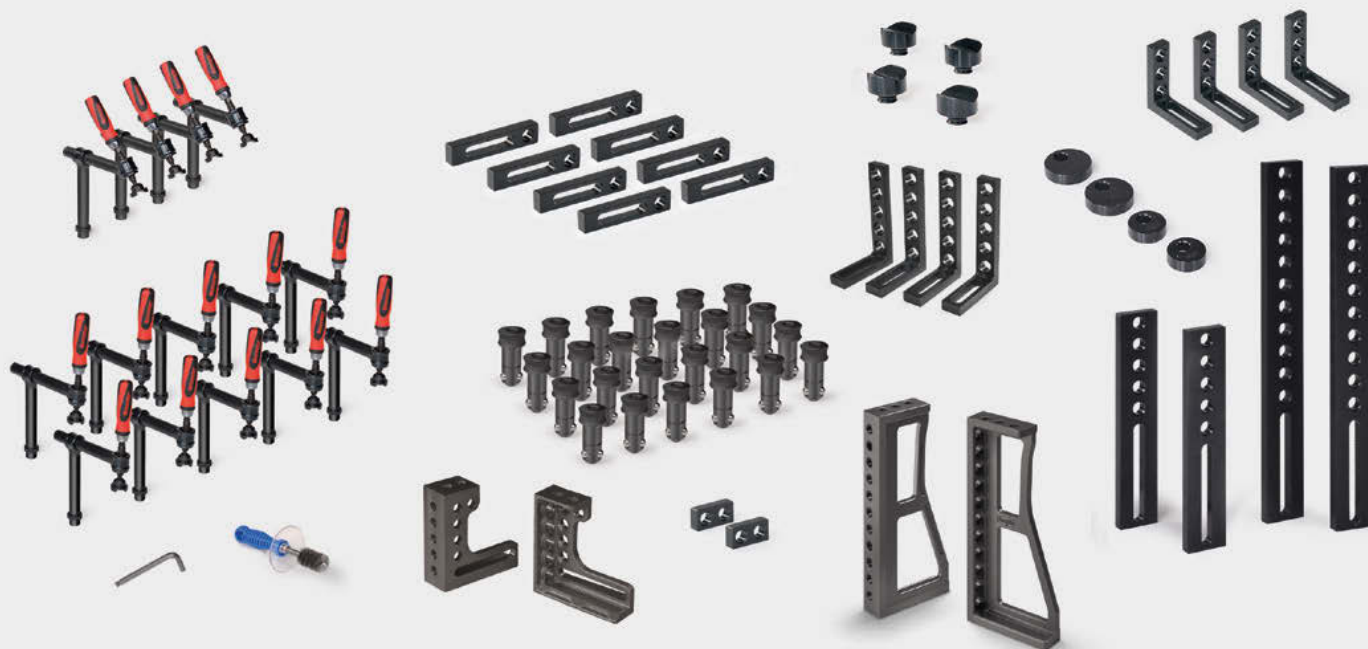
Depicted set also available with PC or PPC bolts instead of ECOline bolts:
Set with PC bolts: Item no. E28-52000-721 or set with PPC bolts: Item no. E28-52000-722

Quantity ▼	Item no. ▼	Item description ▼
4	PE28-03001-000	ECO clamping and locating angle 175x175x50 mm
1	PL28-03002-000	Clamping and locating angle, right 300x275 mm
1	PL28-03002-001	Clamping and locating angle, left 300x275 mm
2	PE28-03008-000	ECO clamping and locating angle 275x175x50 mm
4	E28-05001-000	ECO universal stop / large 225x50x25 mm
2	E28-05002-000	ECO universal stop / small 100x50x25 mm
2	E28-05003-000	ECO stop-strip L 500 - 500x100x25 mm
2	E28-05013-000	ECO locating disk 25-50 mm
2	E28-05013-001	ECO locating disk 25-75 mm
18	E28-06001-000	ECOline bolts / short - Ø 28x95 mm
8	E28-07005-000	ECO screw clamp 180° with spindle
4	E28-07009-000	ECO variable screw clamp 45° with spindle
1	E28-10002-000	ECO round brush Ø 28 mm
1	E28-10008-000	ECO ball-head Allen key AF 8

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFI^{Eco}LINE set 730 (System 28)

Item number: E28-52000-730 (74-piece)



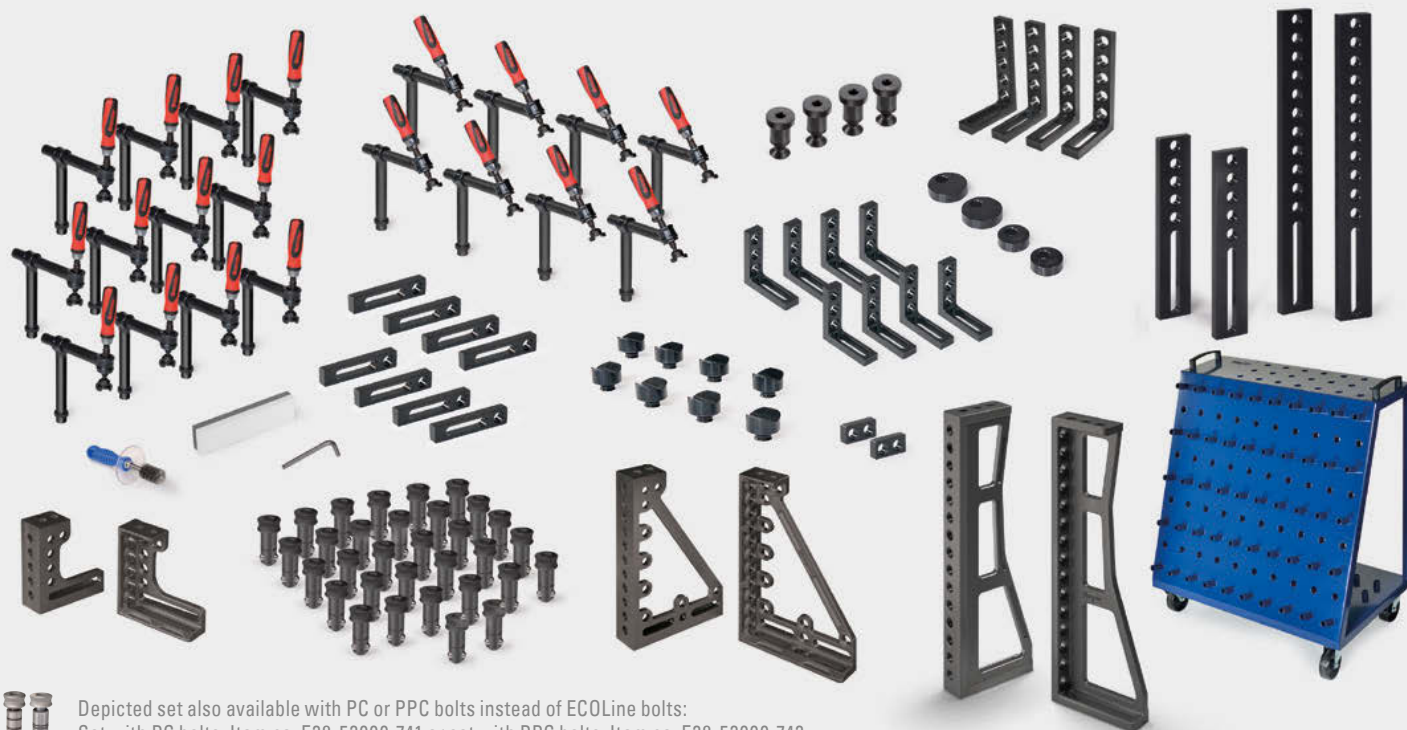
Depicted set also available with PC or PPC bolts instead of ECOLine bolts:
Set with PC bolts: Item no. E28-52000-731 or set with PPC bolts: Item no. E28-52000-732


Quantity ▼	Item no. ▼	Item description ▼
4	PE28-03001-000	ECO clamping and locating angle 175x175x50 mm
1	PL28-03002-000	Clamping and locating angle, right 300x275 mm
1	PL28-03002-001	Clamping and locating angle, left 300x275 mm
1	PE28-03003-000	PE clamping and locating angle, right 600x275x80 mm
1	PE28-03003-001	PE clamping and locating angle, left 600x275x80 mm
4	PE28-03008-000	ECO clamping and locating angle 275x175x50 mm
8	E28-05001-000	ECO universal stop / large 225x50x25 mm
2	E28-05002-000	ECO universal stop / small 100x50x25 mm
2	E28-05003-000	ECO stop-strip L 500 - 500x100x25 mm
2	E28-05003-001	ECO stop-strip L 800 - 800x100x25 mm
2	E28-05013-000	ECO locating disk 25-50 mm
2	E28-05013-001	ECO locating disk 25-75 mm
24	E28-06001-000	ECOLine bolts / short - Ø 28x95 mm
10	E28-07005-000	ECO screw clamp 180° with spindle
4	E28-07009-000	ECO variable screw clamp 45° with spindle
4	E28-09003-000	ECO V-block locations Ø 58 mm - 130° - for tubes up to Ø 70 mm
1	E28-10002-000	ECO round brush Ø 28 mm
1	E28-10008-000	ECO ball-head Allen key AF 8

DEMMELEER welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFI^{Eco}LINE set 740 (System 28)

Item number: E28-52000-740 (104-piece)



 Depicted set also available with PC or PPC bolts instead of ECOline bolts:
Set with PC bolts: Item no. E28-52000-741 or set with PPC bolts: Item no. E28-52000-742

Quantity ▼	Item no. ▼	Item description ▼
8	PE28-03001-000	Clamping and locating angle 175x175x50 mm
1	PL28-03002-000	Clamping and locating angle, right 300x275 mm
1	PL28-03002-001	Clamping and locating angle, left 300x275 mm
1	PL28-03003-000	Clamping and locating angle, right 600x375 mm
1	PL28-03003-001	Clamping and locating angle, left 600x375 mm
1	PE28-03004-000	PE clamping and locating angle, right 800x275x80 mm
1	PE28-03004-001	PE clamping and locating angle, left 800x275x80 mm
4	PE28-03008-000	Clamping and locating angle 275x175x50 mm
8	E28-05001-000	ECO universal stop / large 225x50x25 mm
2	E28-05002-000	ECO universal stop / small 100x50x25 mm
2	E28-05003-000	ECO stop-strip L 500 - 500x100x25 mm
2	E28-05003-001	ECO stop-strip L 800 - 800x100x25 mm
2	E28-05013-000	ECO locating disk 25-50 mm
2	E28-05013-001	ECO locating disk 25-75 mm
32	E28-06001-000	ECOline bolts / short - Ø 28x95 mm
4	E28-06003-000	ECO connecting bolt with screw and washer - Ø 28x45 mm
12	E28-07005-000	ECO screw clamp 180° with spindle
8	E28-07009-000	ECO variable screw clamp 45° with spindle
8	E28-09003-000	ECO V-block locations Ø 58 mm - 130° - for tubes up to Ø 70 mm
1	E28-10002-000	ECO round brush Ø 28 mm
1	E28-10008-000	ECO ball-head Allen key AF 8
1	E28-10007-000	ECO bench stone
1	E28-11001-000	ECO accessory cart

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!





Track system Floor plates

Rail system application.....	134
From planning to final acceptance.....	136
Project implementation	138
Rail system - overview.....	142
Rail system - installation versions.....	144
Rail system - application	146
Support and base rail	148
Support and base rail XL.....	149
Support and base rail, linear.....	150
Base rail, ROUND	151
Support and base rail, DUO	152
Track system - accessories	153
Order overview of table feet for track system.....	154
Table leg for spacer block	156
Shifting foot with casters.....	157
Holding frame	158
Guiding carriage.....	159
Guiding wagons.....	160
Floor plates	162
Clamping floor plate.....	164
Clamping floor plate XL.....	165
Clamping floor plate ProfilINE	166

DEMMELE base rails – for big projects!

Our flexible clamping system grows with your tasks. The modular structure of the base rail system offers you the greatest possible freedom for the production of bigger than normal components.

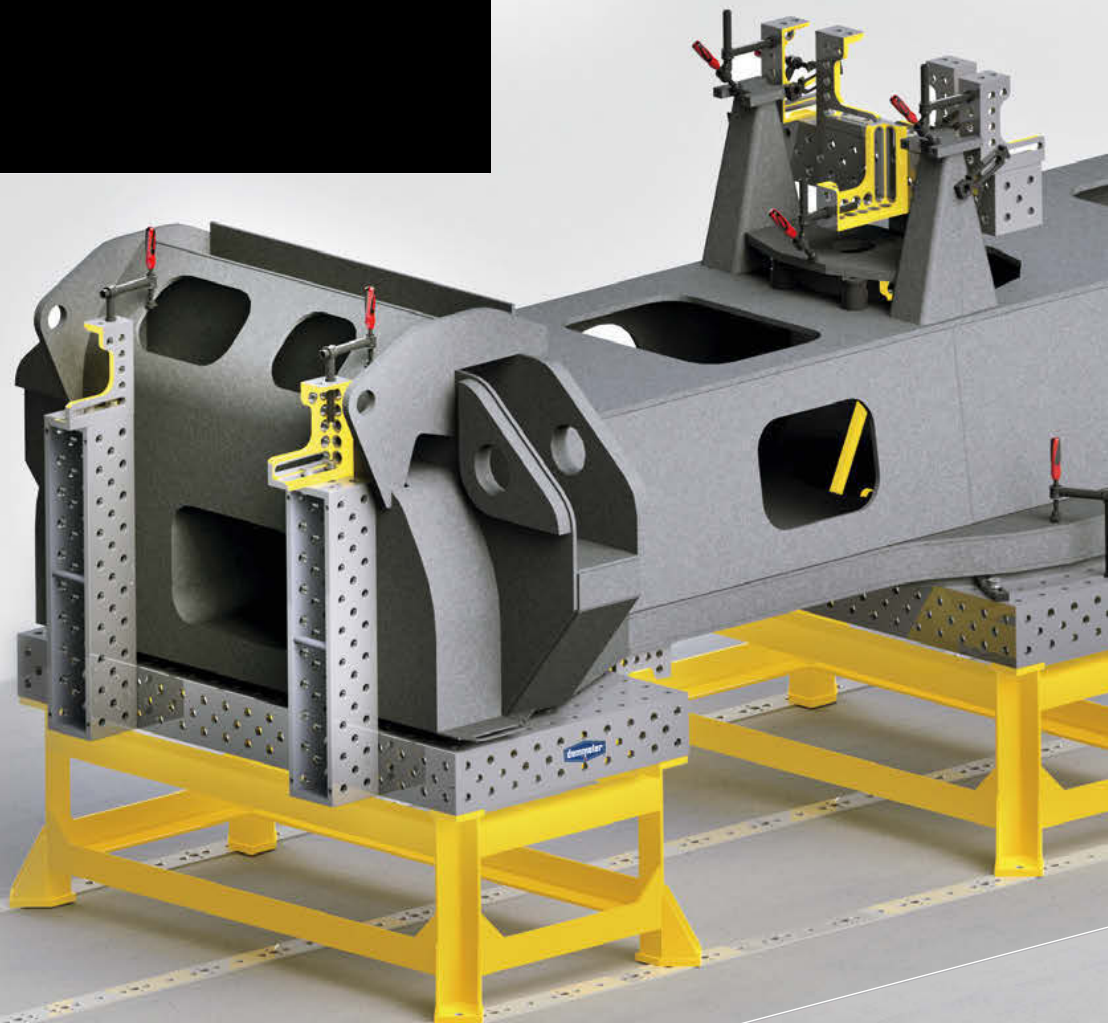
A grid system of any size adapted to your product portfolio can be installed in your production hall. This provides you with a level installation surface over the entire area, including grid bores.

The rail system is installed according to your requirements. Several versions are available to you, for example overfloor or underfloor installation. The advantage of underfloor installation is that the entire work area around the rail system is accessible for persons and vehicles. This accessibility makes work easier, reduces the risk of accidents and thereby boosts safety and increases efficiency in manufacturing.

You have access to the comprehensive selection of DEMMELE accessories to set up your clamping fixtures on the rail system.

Quality

The highest quality with optional laser measuring of your rail system.



A

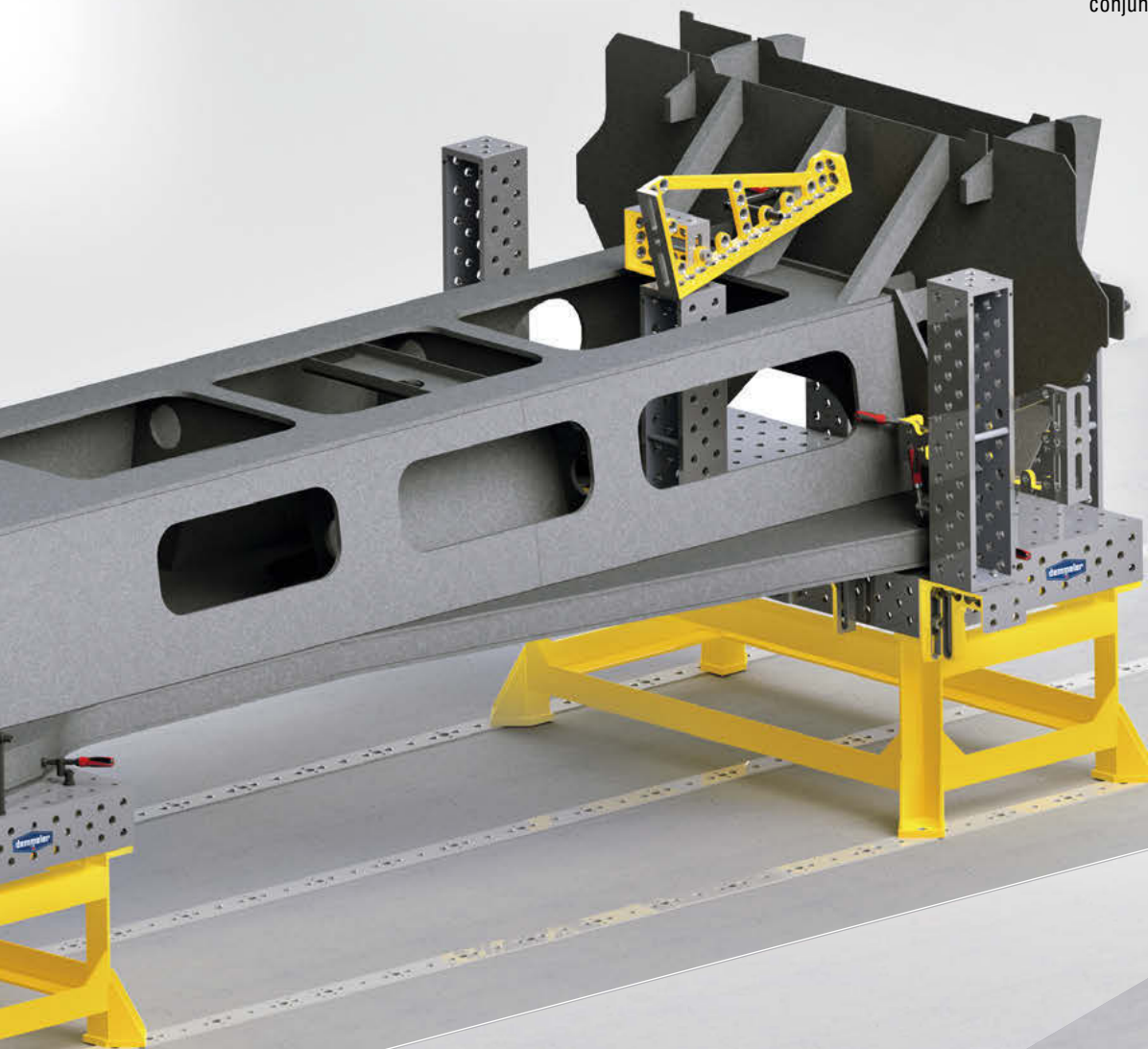


Accuracy

The best accuracy for your large-scale components thanks to an even clamping surface across the entire work area.

Flexible

Combine all system components in conjunction with your rail system.



Modular

An exact bore grid over long distances from A to Z. Reproduce the system accuracy with your work pieces.

From planning to final acceptance!

The DEMMELER experts support you from planning your production facilities to manufacturing.

We contribute our know-how from numerous successful projects. You receive the support of our competent team, helping you make the right decisions starting in the planning phase.

Experienced fitters and technicians will examine the floor characteristics and evenness by request, and offer tips on preparatory measures.

Our assembly teams look after professional installation and the alignment of the base rail system.

Training for your production team guarantees proper use of the equipment.





Project implementation in detail

You can count on our experience with countless projects

Planning, installation and acceptance - everything from one source!

Requirements are coordinated with the customer in close cooperation with our technicians and distribution partners.

By request we manage the entire project for a turnkey solution.

Alternatively you can also implement specific assembly sections yourself.

Give us the task, we develop the right solution for you!

1.

INVENTORY

- Inventory of the floor characteristics
- Determination of local conditions (accessibility, transport etc.) using a checklist
- Establishing the configuration and implementation of the rail system



With implementation by DEMMELER

Costs by request.

2.

PREPARATION

- For example, floor preparation for underfloor installation
- Milling grooves according to the installation situation



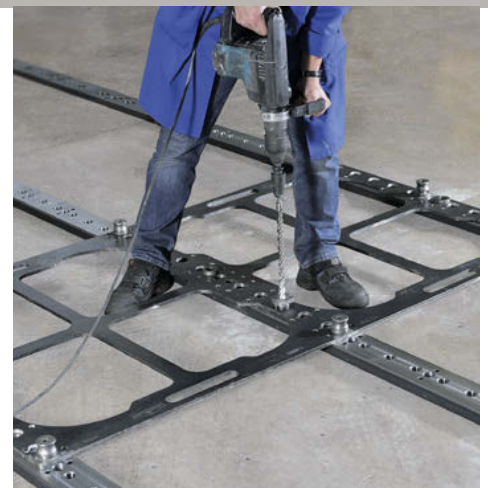
With implementation by DEMMELER

Costs by request.

3.

ASSEMBLY

- Highly accurate templates are used for an exact installation.
- **We loan you an assembly set with templates free of charge if you want to install the system yourself.**
- Mounting materials (set of screws, dowels and shims) are included in the scope of delivery for the base rail.
- As a rule of thumb, the installation time is about one hour per running metre.



With implementation by DEMMELER

Costs by request.



You decide who does what!



CUSTOMER



DEMMELE

4.

MEASURING

- The required accuracy is ensured during installation with laser measuring tools.



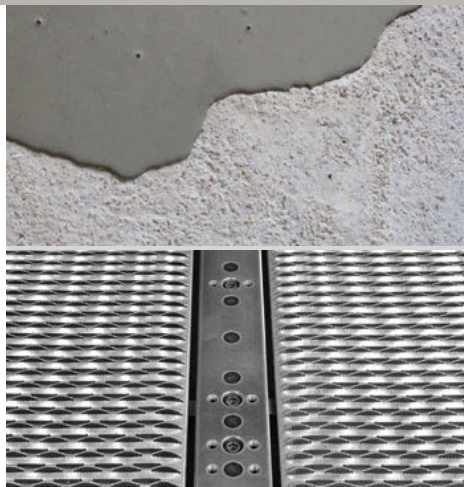
With implementation by DEMMELE

Costs by request.

5.

OPTIONS

- Grouting shafts and grooves after measuring
- Installation of gratings and ramps
- Installation of plugs



With implementation by DEMMELE

Costs by request.

6.

ACCEPTANCE

- Preparation of an acceptance record
- Handover to production
- Annual maintenance and an inspection can be offered by request.



Acceptance record

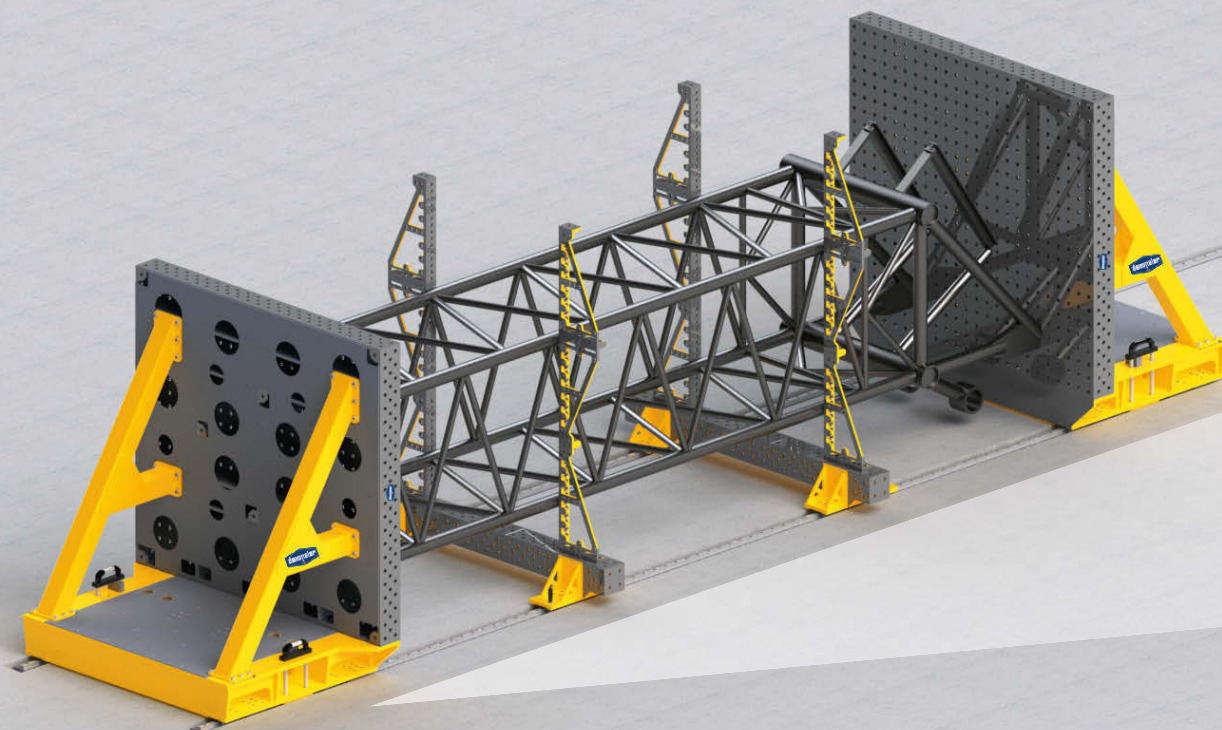
An acceptance record is included in the scope of services with installation by DEMMELE.

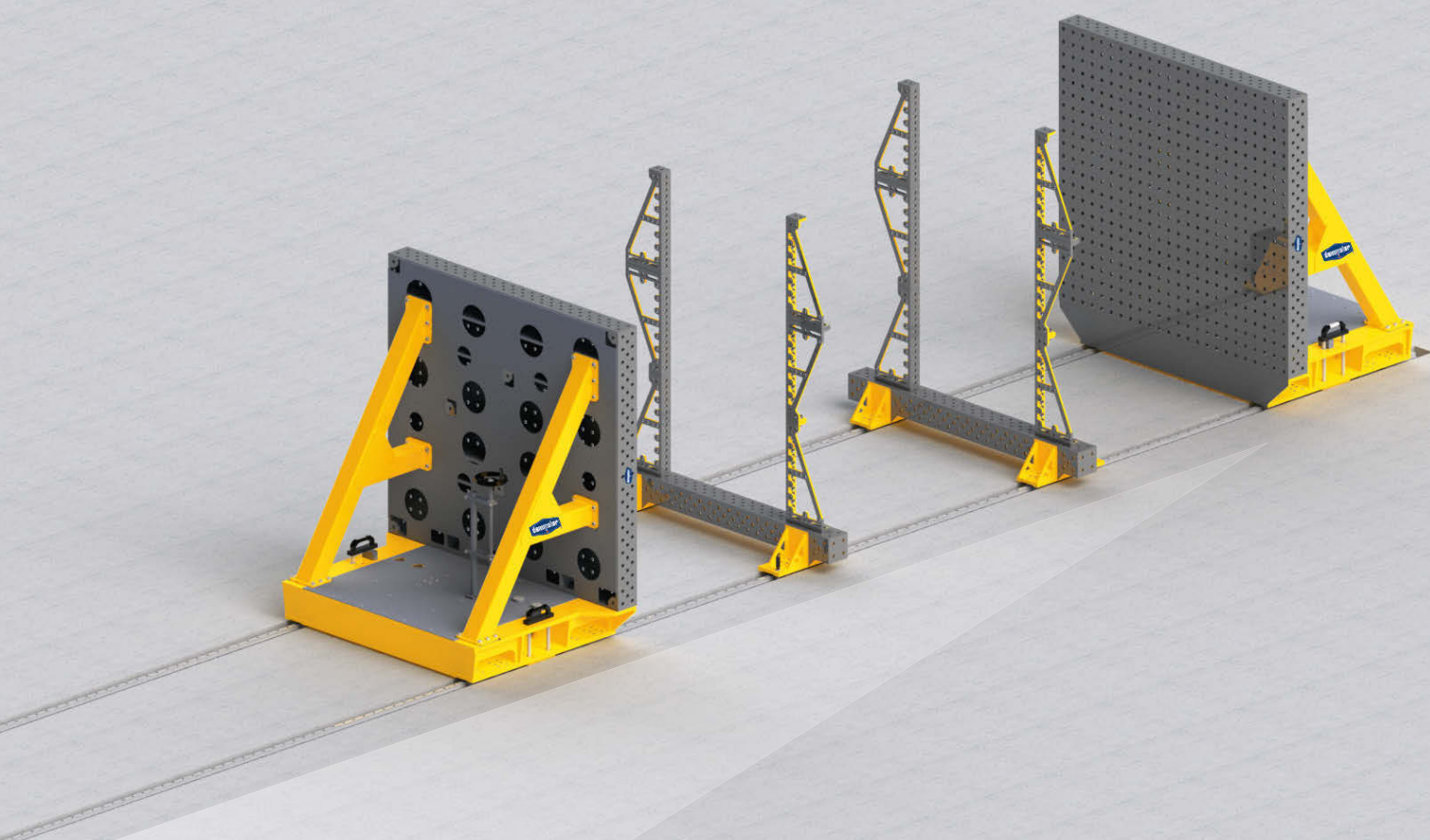
For projects beyond the edge of the table

Those who think in big dimensions like the company Liebherr need equipment that offers numerous possibilities.

With the flexible base rail system, DEMMELER is the ideal partner for the crane manufacturer of world renown. Thanks to modular expandability, the base rail system is suitable for the production of components with a length of 80 metres and more. The highest accuracy of fit is guaranteed thanks to minimal tolerances. This not only makes the trouble-free final assembly of the individual elements on the construction site easier, it also guarantees safe and smooth operation of the cranes.

Thanks to the sophisticated displacement system, the setup times for different types of components are reduced. With the comprehensive selection of accessories, an endless number of fixtures can be realised quickly and safely.

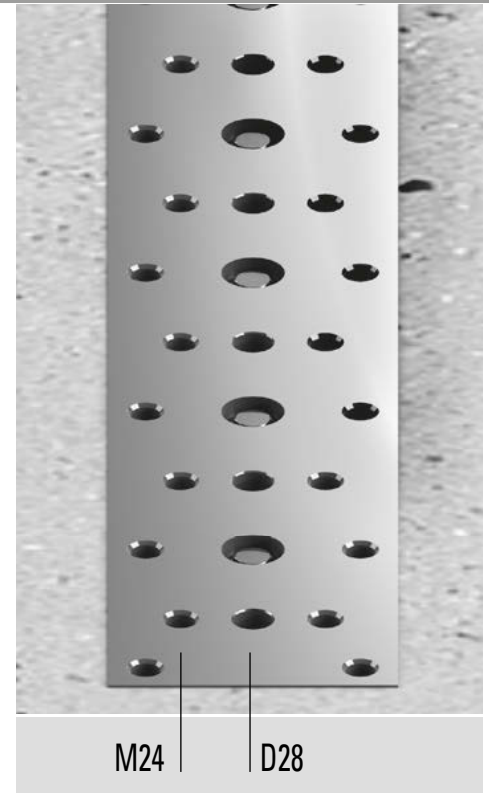
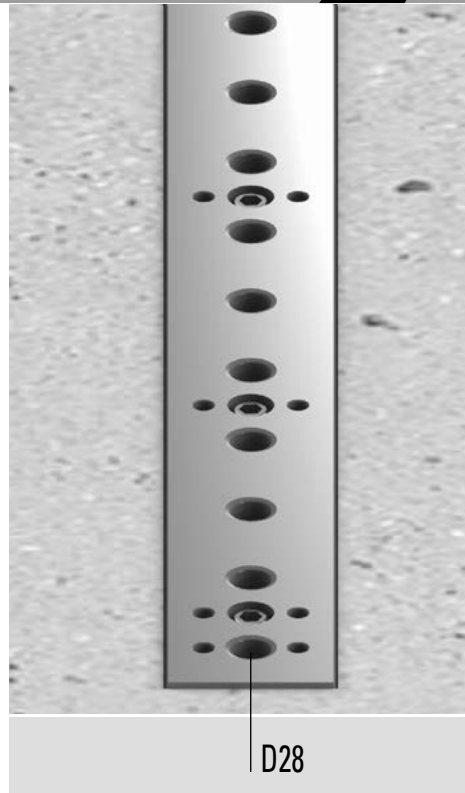
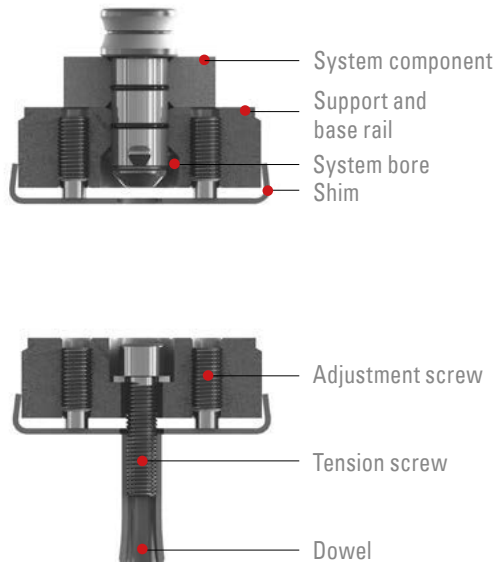




Support and base rail

Support and base rail XL

Top seller



Area of application	Overfloor / underfloor	Overfloor / underfloor
Description	<ul style="list-style-type: none"> • Setup of a modular system grid over large distances is possible • Exact reference level over the entire work area • Precise positioning with D28 bores in a 100 mm grid • Suitable for all standard applications 	<ul style="list-style-type: none"> • Setup of a modular system grid over very large distances is possible • Exact reference level over the entire work area • Precise positioning with D28 bores and M24 threads in a 200 mm grid • Suitable for very heavy-duty and all standard applications • Approx. 80% higher bearing load than the standard support and base rail
Combination	<ul style="list-style-type: none"> • All system components can be used with the bore hole grid 	<ul style="list-style-type: none"> • All system components can be used with the bore hole grid
Grid	<ul style="list-style-type: none"> • D28 system bores every 100 mm 	<ul style="list-style-type: none"> • D28 system bores every 200 mm • M24 threaded bores every 200 mm
Dimensions	<ul style="list-style-type: none"> • Cross-section approx. 120 x 40 mm For details, see page 148 	<ul style="list-style-type: none"> • Cross-section approx. 200 x 50 mm For details, see page 149
Special features	<ul style="list-style-type: none"> • Use of shifting feet and holding frames is possible • System components and 3D worktables can also be set up directly on the rail • Easy shifting of the system components without using a crane thanks to shifting feet • Anchoring to the floor with dowel system • Incl. screw set, dowels and shims 	<ul style="list-style-type: none"> • Use of table leg for spacer block and holding frames is possible • System components and 3D worktables can also be set up directly on the rail • Anchoring to the floor with dowel system • Incl. screw set, dowels and shims

Support and base rail, LINEAR

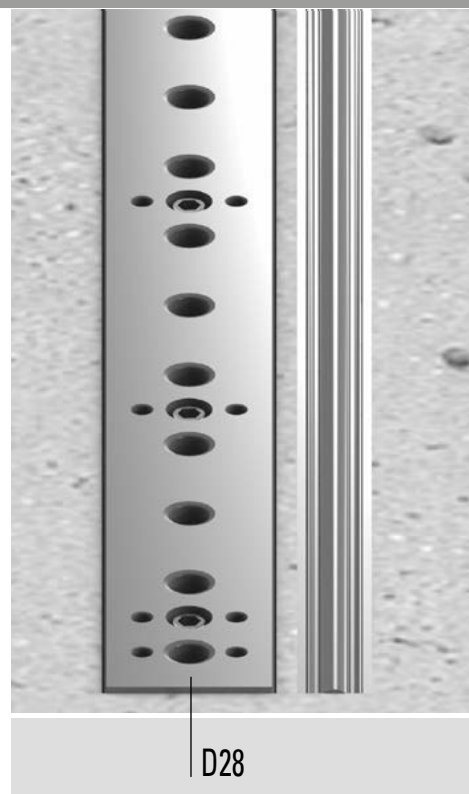
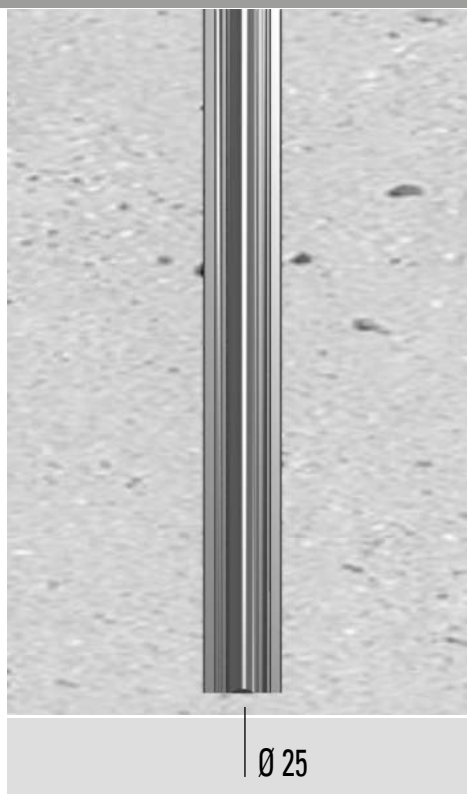
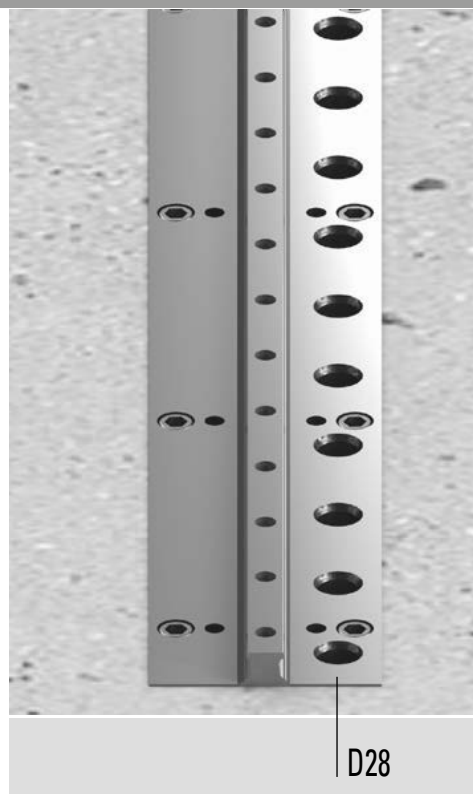
Base rail, ROUND

Support and base rail, DUO

Shifting possible under load! ▼

Shifting possible under load! ▼

Shifting possible under load! ▼

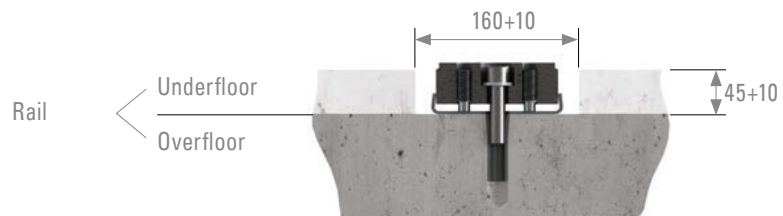


Overfloor / underfloor	Underfloor	Underfloor
<ul style="list-style-type: none"> • Setup of a modular system grid over large distances is possible • Exact reference level over the entire work area • Shifting the system components after setup is possible even under load • Setting out superstructures in the system grid is supported for exact positioning 	<ul style="list-style-type: none"> • Setup of a traversing range over very long distances is possible • Exact reference level over the entire work area • Shifting the system components after setup is possible even under load • Continuously variable positioning of superstructures • Pinning bores for positioning in end positions / work areas possible 	<ul style="list-style-type: none"> • Setup of a traversing range over long distances is possible • Exact reference level over the entire work area • Shifting the system components after setup is possible even under load • Precise positioning with D28 bores in a 100 mm grid • Continuously variable positioning of superstructures
<ul style="list-style-type: none"> • Setup of system components possible indirectly using legs or frames 	<ul style="list-style-type: none"> • Setup of system components possible indirectly using legs or frames 	<ul style="list-style-type: none"> • All system components can be used with the bore hole grid
<ul style="list-style-type: none"> • D28 system bores every 100 mm 	<ul style="list-style-type: none"> • Continuous without bore hole grid 	<ul style="list-style-type: none"> • D28 system bores every 100 mm • In addition, continuous without bore hole grid
<ul style="list-style-type: none"> • Cross-section approx. 160 x 40 mm For details, see page 150 	<ul style="list-style-type: none"> • Cross-section approx. 50 x 50 mm For details, see page 151 	<ul style="list-style-type: none"> • Cross-section approx. 120 x 40 mm Base rail • Cross-section approx. 50 x 50 mm, round rail, see page 152
<ul style="list-style-type: none"> • Suitable for example for pallet changeover systems on robot cells • Hardened and ground version of the profile guide • Tip-resistance thanks to wrap-around guide • Easy shifting of the system components including work piece without a crane • Anchoring to the floor with dowel system • Incl. screw set, dowels and shims • Shifting possible under load! 	<ul style="list-style-type: none"> • Suitable for example for pallet changeover systems on robot cells • Hardened and ground version of the guide shaft • Easy shifting of the system components including work piece without a crane • Anchoring by means of casting in the floor • Installation flush with the floor, no tripping hazards • Scope of delivery includes installation templates • Shifting possible under load! 	<ul style="list-style-type: none"> • Suitable for example for pallet changeover systems on robot cells • Hardened and ground version of the guide shaft • Easy shifting of the system components including work piece without a crane • Anchoring using dowel system and casting in the floor • Includes screw set, dowels and shims • Shifting possible under load!

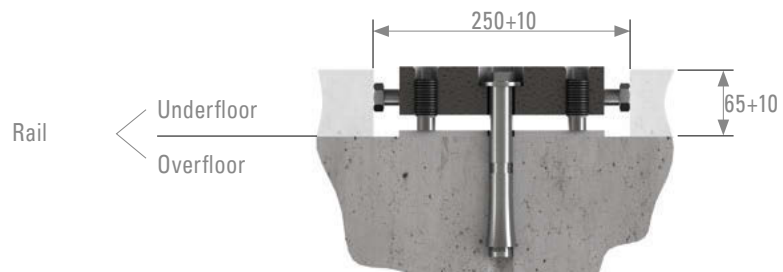
Rail type

Installation type

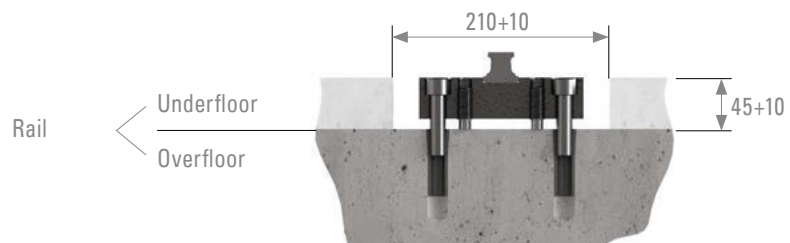
Support and base rail



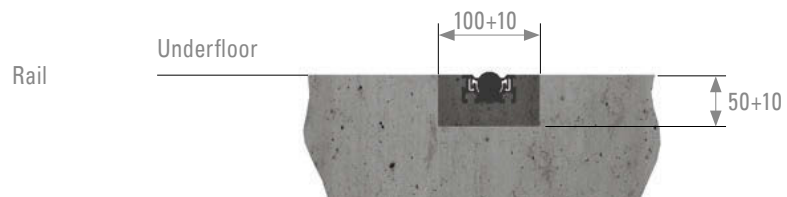
Support and base rail XL



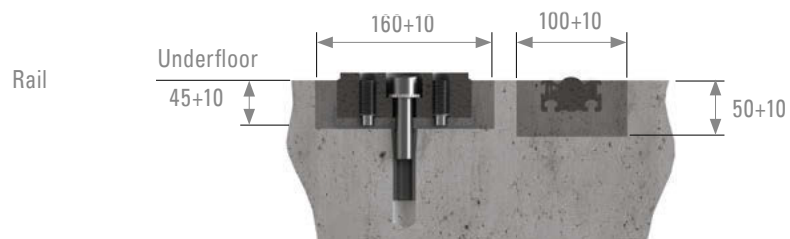
Support and base rail, LINEAR



Base rail, ROUND



Support and base rail, DUO

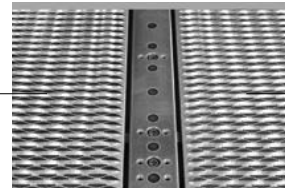
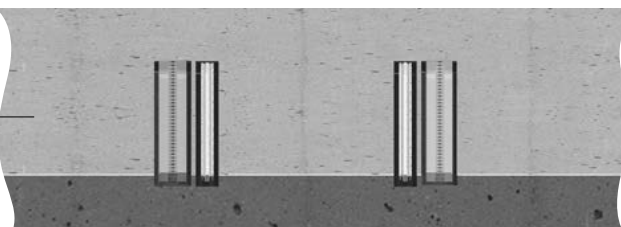
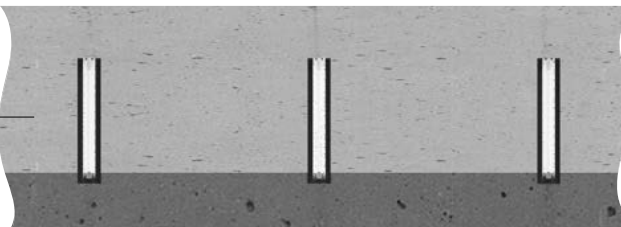
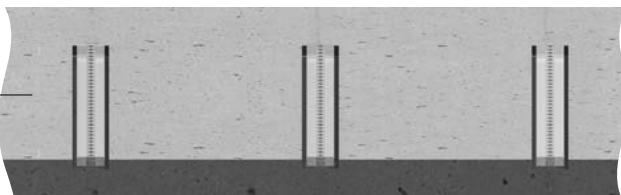
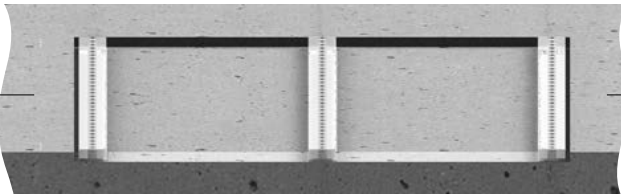
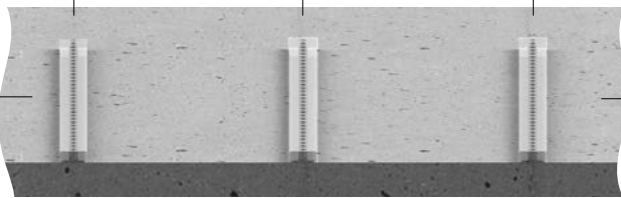


Hall floor versions

Equipment options *

Standard track gauge

1000 1000



Grate



Ramp



Casting

GENERAL INFORMATION:

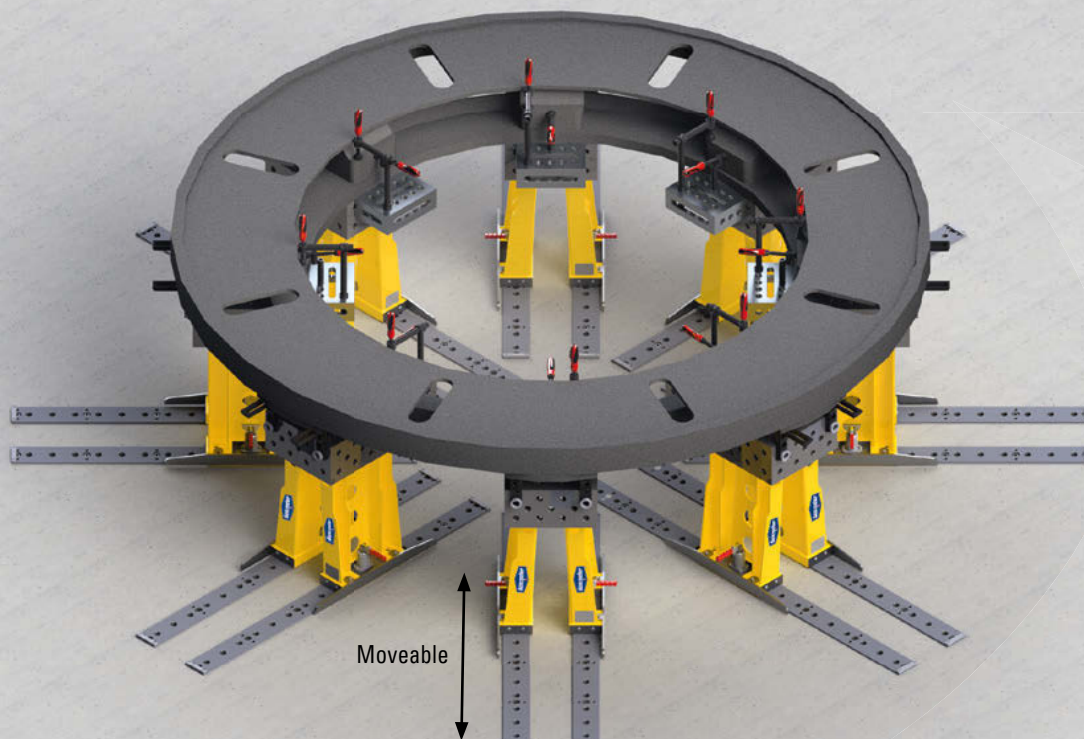
- Standard track gauge preferably 1000 mm. Customer-specific dimensions possible with consultation.
- The number of tracks can be tailored to your requirements.
- Preferred lengths 3000 mm / 6000 mm. Other lengths for the support and base rail are also available on request.
- Base rails have to be closed with adhesive tape or cover caps on the underside before casting to prevent the casting material from rising up into the system bores.
- Mounting materials such as the set of screws, dowels and shims are included in the scope of delivery.
- Please observe internal safety directives for handling
- Always secure the components to prevent tipping
- Persons are never permitted underneath suspended loads

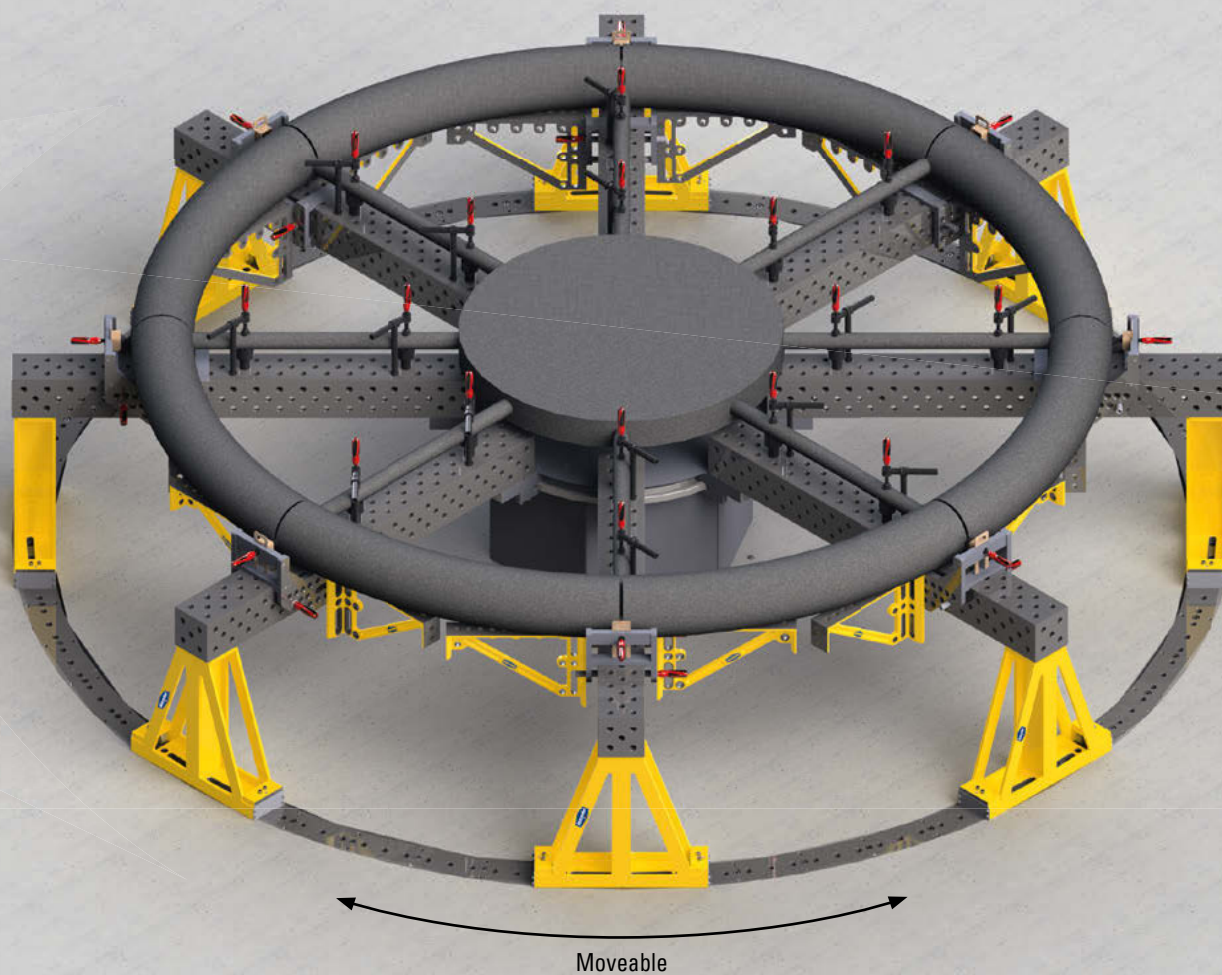
* Equipment options on request!

To make things run smoothly!

If your work pieces are round or circular, we have the right solution for you with the star-shaped arrangement of our modular rail system.

The diameter of the clamping devices is flexible and adaptable within the grid system.





Example representation of special
design, item no. A28-50209-002

Support and base rail

Top seller

- Setup of a modular system grid over large distances is possible
- Exact reference level over the entire work area
- Precise positioning with D28 bores in a 100 mm grid
- Suitable for all standard applications
- **Screw set, dowels and shims included in the scope of delivery**
- Bearing load per metre up to 16 tons
- Allowable tensile load in crack-free concrete 1.0 ton per dowel



Also compatible with:

Table leg for spacer block	Shifting foot	Holding frame	3D table / system components
			

Description ▲ Application ▼	Application ▼
-----------------------------	---------------



L in mm	B in mm	H in mm approx.	Approx. weight in kg	Item no.
1000	120	40	35	D28-02003-067
2000	120	40	70	D28-02003-068
3000*	120	40	105	D28-02003-069
4000	120	40	140	D28-02003-070
5000	120	40	175	D28-02003-071
6000*	120	40	210	D28-02003-072

*Preferred lengths / Other lengths available by request!

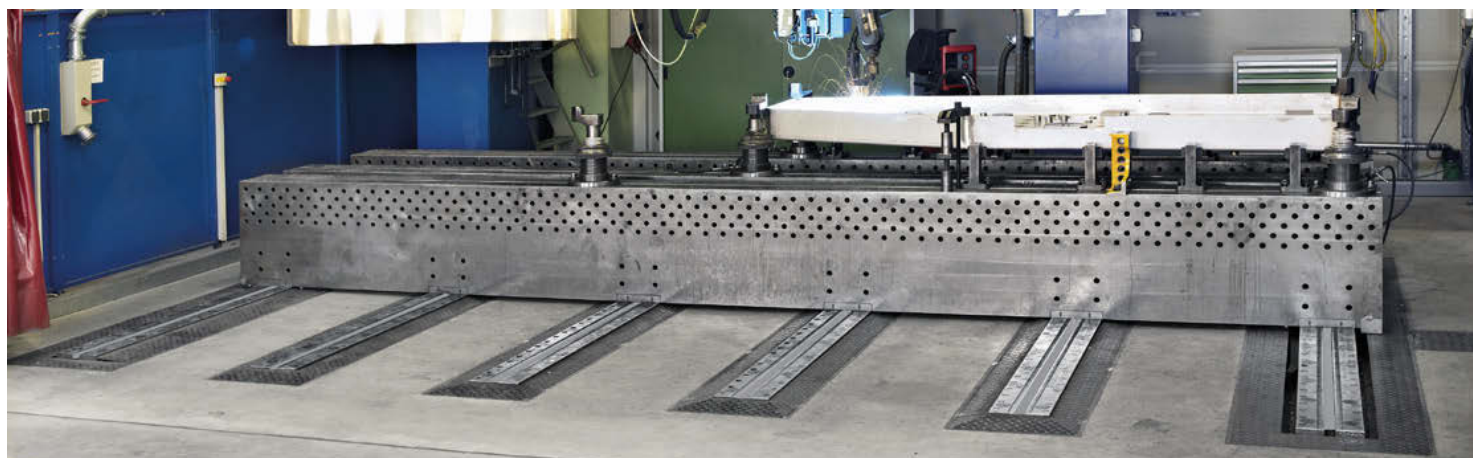
- Setup of a modular system grid over very large distances is possible
- Exact reference level over the entire work area
- Precise positioning with D28 bores in a 200 mm grid
- Suitable for very heavy-duty and all standard applications
- **Screw set, dowels and shims included in the scope of delivery**
- Bearing load per metre up to 30 tons
- Approx. 80% higher bearing load than the standard support and base rail
- Allowable tensile load in crack-free concrete 1.8 tons per dowel



Also compatible with:

Table leg for spacer block	Shifting foot	Holding frame	3D table / system components
			

Description ▲ Application ▼



L in mm	B in mm	H in mm approx.	Approx. weight in kg	Item no.
3000	200	50	230	P28-02003-000
6000	200	50	460	P28-02003-001

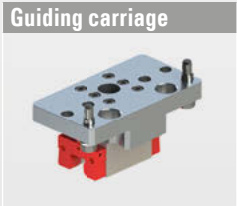
Other lengths available by request!

Support and base rail, LINEAR

- Setup of a modular system grid over large distances is possible
- Exact reference level over the entire work area
- Shifting the system components after setup is possible even under load
- Tip-resistance thanks to wrap-around guide
- Hardened and ground version of the profile guide
- Setting out superstructures in the system grid is supported for exact positioning
- **Screw set, dowels and shims included in the scope of delivery**
- Bearing load per metre up to 16 tons
- Allowable tensile load in crack-free concrete 1.0 ton per dowel



Also compatible with:



Description ▲ Application ▼

Application ▼

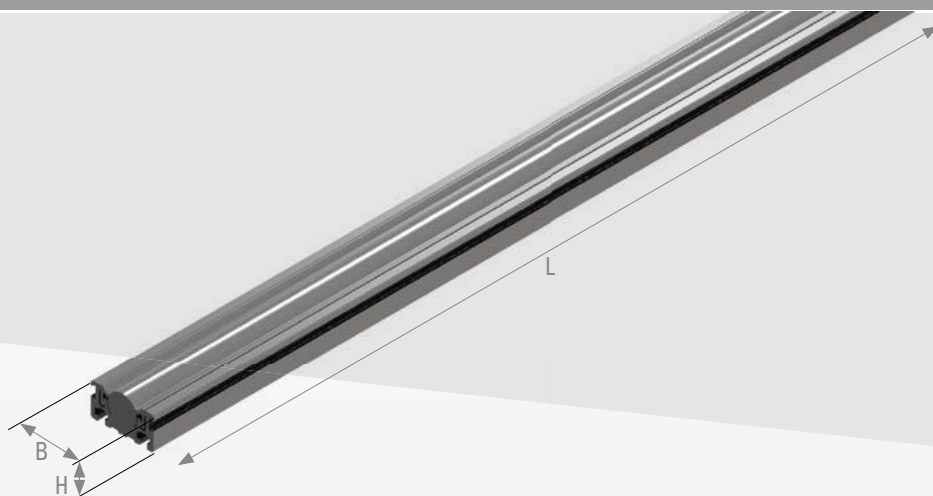


L in mm	B in mm	H in mm	Approx. weight in kg	Item no.
3000	160	40	135	D28-02007-000
6000	160	40	270	D28-02007-001

Other lengths available by request!



- Setup of a traversing range over long distances is possible
- Exact reference level over the entire work area
- Shifting the system components after setup is possible even under load
- Continuously variable positioning of superstructures
- Ideal for pallet changeover systems
- Pinning bores for positioning in end positions / work areas, can be integrated in the floor
- Bearing load per metre up to 10 tons



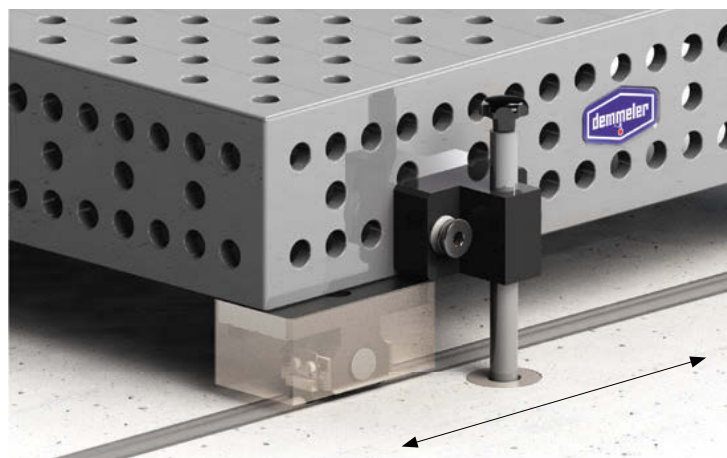
Also compatible with:

Guiding wagon



Description ▲ Application ▼

Application ▼

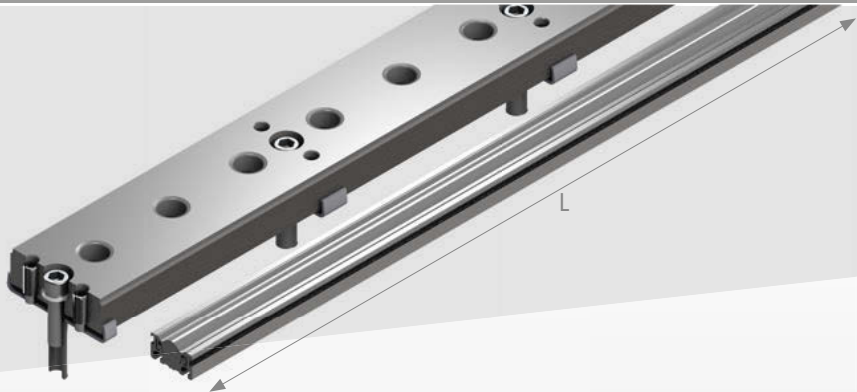


L in mm	B in mm	H in mm	Approx. weight in kg	Item no.
1000	54	48	8	D28-02008-000
2000	54	48	16	D28-02008-001
3000	54	48	24	D28-02008-002

Other lengths available by request!

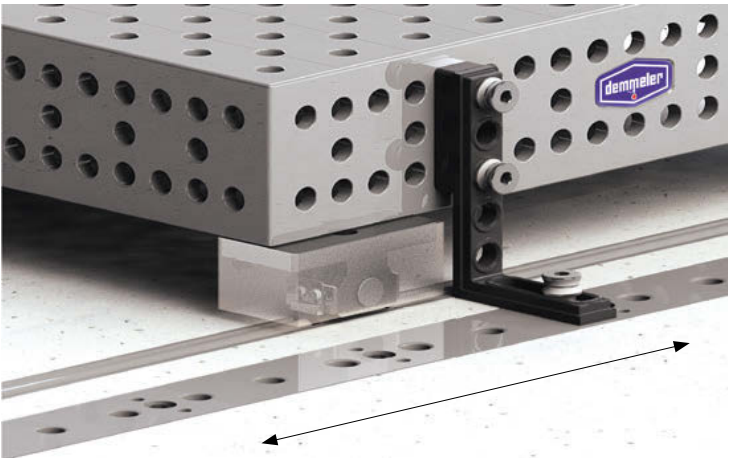
Support and base rail, DUO

- Setup of a traversing range over long distances is possible
- Exact reference level over the entire work area
- Shifting the system components after setup is possible even under load
- Precise positioning with D28 bores in a 100 mm grid
- Continuously variable positioning of superstructures
- **Screw set, dowels and shims included in the scope of delivery**
- Bearing load per metre up to 20 tonnes (depending on the number of guiding wagons)
- Allowable tensile load in crack-free concrete 1.0 ton per dowel



Also compatible with:

Table leg for spacer block	Shifting foot	Holding frame	3D table / system components	Guiding wagon
Description ▲ Application ▼			Application ▼	



L in mm	Description	Item no.
3000		D28-02003-069 + D28-02008-002
6000	2 piece	D28-02003-072 + D28-02008-002

Other lengths available by request!

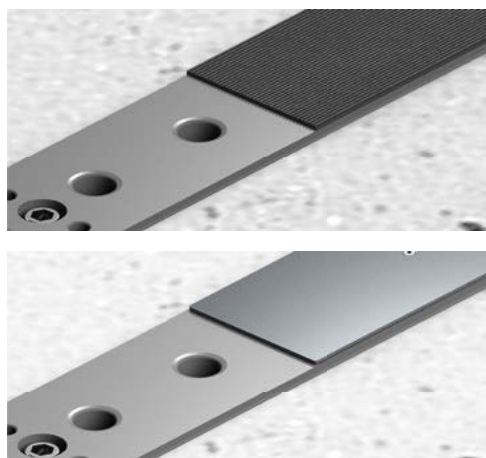
Rubber mat / cover plate

Plug

- Protects the system bores against dirt.
Easy to remove with the D28-10003-002 magnet.



Application ▼

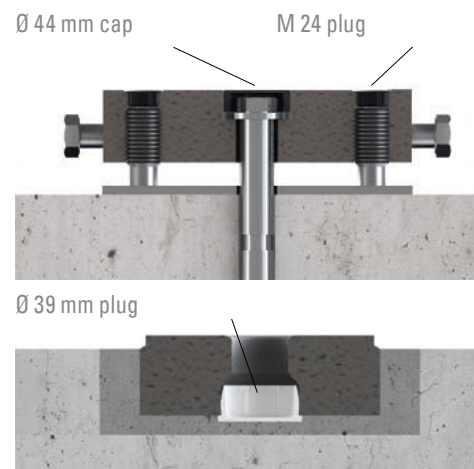


Application ▼



D28 plug

Application ▼



Support and base rail	Item no.
Rubber mat 1000 mm	00092901
Cover plate 1000 mm	00092904

Plug	Item no.
D28 plug	D28-10003-006
10x D28 plugs	D28-10003-007
Magnet for D28 plug Ø 32 mm	D28-10003-002
Ø 39 mm plug	00092929
Support and base rail XL	Item no.
Ø 44 mm cap	00023584
M24 cap	00068955

Foot type variant - ordering

Equip the **PP / PL** and **PE** table with holding frame, leg for spacer block or shifting foot!

NOTE:

Since the tables have additional bores on the underside to attach these leg versions, you have to select the table with the corresponding article number from the chart below!

**PROFI Premium LINE (PP)**

L in mm	W in mm	H in mm	Weight in kg	Solid	Hardened DEMONT 760 M	Hardened DEMONT 860 M
1000	1000	200	290	PP28-01001-007	PP28-01001-017	PP28-01001-027
1200	1200	200	380	PP28-01056-007	PP28-01056-017	PP28-01056-027
1500	1000	200	390	PP28-01011-007	PP28-01011-017	PP28-01011-027
1500	1500	200	530	PP28-01031-007	PP28-01031-017	PP28-01031-027
2000	1000	200	500	PP28-01002-007	PP28-01002-017	PP28-01002-027
2000	2000	200	1000	PP28-01006-007	PP28-01006-017	PP28-01006-027
2400	1200	200	710	PP28-01003-007	PP28-01003-017	PP28-01003-027
3000	1500	200	1010	PP28-01004-007	PP28-01004-017	PP28-01004-027
4000	2000	200	1780	PP28-01005-007	PP28-01005-017	PP28-01005-027
4800	2400	200	2550	PP28-11085-007	PP28-11085-017	PP28-11085-027

**PROFI Plus LINE (PL)**

L in mm	W in mm	H in mm	Weight in kg	Solid	Hardened DEMONT 760 M	Hardened DEMONT 860 M
1000	1000	200	310	PL28-01001-007	PL28-01001-017	PL28-01001-027
1200	1200	200	410	PL28-01056-007	PL28-01056-017	PL28-01056-027
1500	1000	200	430	PL28-01011-007	PL28-01011-017	PL28-01011-027
1500	1500	200	590	PL28-01031-007	PL28-01031-017	PL28-01031-027
2000	1000	200	550	PL28-01002-007	PL28-01002-017	PL28-01002-027
2000	2000	200	1050	PL28-01006-007	PL28-01006-017	PL28-01006-027
2400	1200	200	790	PL28-01003-007	PL28-01003-017	PL28-01003-027
3000	1500	200	1150	PL28-01004-007	PL28-01004-017	PL28-01004-027
4000	2000	200	1980	PL28-01005-007	PL28-01005-017	PL28-01005-027
4800	2400	200	2830	PL28-11085-007	PL28-11085-017	PL28-11085-027

**PROFI Eco LINE (PE)**

L in mm	W in mm	H in mm	Weight in kg	Solid	Hardened DEMONT 760 M	Hardened DEMONT 860 M
1000	1000	200	330	PE28-01001-007	PE28-01001-017	PE28-01001-027
1200	1200	200	430	PE28-01056-007	PE28-01056-017	PE28-01056-027
1500	1000	200	450	PE28-01011-007	PE28-01011-017	PE28-01011-027
1500	1500	200	610	PE28-01031-007	PE28-01031-017	PE28-01031-027
2000	1000	200	570	PE28-01002-007	PE28-01002-017	PE28-01002-027
2000	2000	200	1100	PE28-01006-007	PE28-01006-017	PE28-01006-027
2400	1200	200	820	PE28-01003-007	PE28-01003-017	PE28-01003-027
3000	1500	200	1180	PE28-01004-007	PE28-01004-017	PE28-01004-027
4000	2000	200	2090	PE28-01005-007	PE28-01005-017	PE28-01005-027
4800	2400	200	2980	PE28-11085-007	PE28-11085-017	PE28-11085-027

Holding frame / leg for spacer block / shifting foot

ORDERING EXAMPLE:

(1) Select the desired worktop on page 154, which results in order article no. 1:



e.g. 1 x PL28-01002-007

+

(2) From the existing page, select the leg you want in the corresponding quantity, which results in order article no. 2:



e.g. 4 x D00-10017-000

=



The two order article numbers make up your order to DEMMELER.

e.g. 1 x PL28-01002-007
e.g. 4 x D00-10017-000

Holding frame

For table sizes	Holding frame size	Item no.	Weight in kg Holding frame	Max. load in kg
1000x1000 1200x1200 1500x1000 1500x1500	1000x1000x600	PL00-02004-000	158	15000
2000x1000 2000x2000 2400x1200 3000x1500 4000x2000	2000x1000x600	PL00-02004-001	229	15000
4000x2000 4800x2400	4000x2000x600	PL00-02004-002	516	20000

Leg for spacer block (for all table sizes)

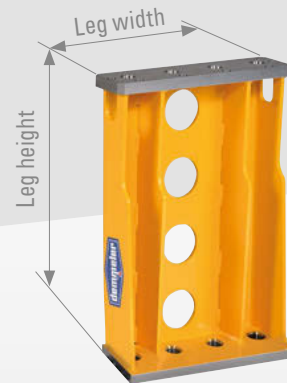
Leg width	Leg height	Number of legs	Item no.	Weight in kg per leg	Max. load in kg (per leg)
200	200	4	D00-10017-000	14	3500
200	400	4	D00-10017-001	19	3500
200	600	4	D00-10017-002	24	3500
400	200	4	D00-10017-010	24	3500
400	400	4	D00-10017-011	33	3500
400	600	4	D00-10017-012	41	3500

Shifting foot (for all table sizes)

Leg width	Leg height	Number of legs	Item no.	Weight in kg per Shifting foot	Max. load in kg (per leg)
200	200	4	D00-10017-025	18	3500
200	400	4	D00-10017-026	24	3500
200	600	4	D00-10017-027	29	3500
400	200	4	D00-10017-028	33	3500
400	400	4	D00-10017-029	41	3500
400	600	4	D00-10017-030	50	3500

Table leg for spacer block

- Connecting elements between spacer block U-form or 3D worktable and support and base rail
- Different setup heights can be adapted to the work piece by simply exchanging the table legs
- Includes 2x fitted shoulder screws M12-16 H8x30 for attachment on system components



Also compatible with:

Support and base rail



Support and base rail XL



Support and base rail, DUO



Description ▲ Application

Leg versions ▼



Attachment to system components

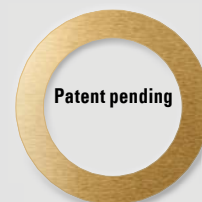
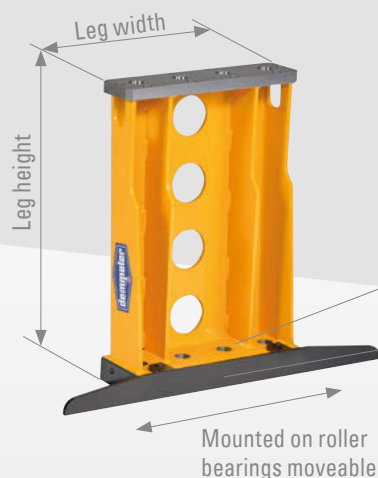


Leg width	Leg height	Weight per leg in kg	Max. load per leg in kg	Item no.
200	200	14	3500	D00-10017-000
200	400	19	3500	D00-10017-001
200	600	22	3500	D00-10017-002
400	200	22	3500	D00-10017-010
400	400	33	3500	D00-10017-011
400	600	41	3500	D00-10017-012

Other heights by request! Observe internal safety directives when repositioning the system components!



- Moving installed system components is possible without using hoisting equipment or a crane
- Different setup heights can be adapted to the work piece by simply exchanging the table legs
- Highest load capacity in the working position thanks to full-faced support of the foot on the rail
- **Tilt safety device included in the scope of delivery**
- Includes 2x fitted shoulder screws M12-16 H8x30 for attachment on system components
- Observe stability when moving system components



Also compatible with:

Support and base rail



Description ▲ Application ▼

Leg versions ▼



Roller



Tilt safety device



Leg width	Leg height	Weight per leg in kg	Max. load per leg in kg	Item no.
200	200	18	3500	D00-10017-025
200	400	24	3500	D00-10017-026
200	600	29	3500	D00-10017-027
400	200	33	3500	D00-10017-028
400	400	41	3500	D00-10017-029
400	600	50	3500	D00-10017-030

Other heights by request! Observe internal safety directives when repositioning the system components!

Holding frame

- Exact positioning of 3D worktables in lengthwise and crosswise direction on the support and base rail is possible
- Very stable version for extremely high loads



Also compatible with:



Description ▲ Application ▼

Application ▼



Setup in lengthwise / crosswise direction

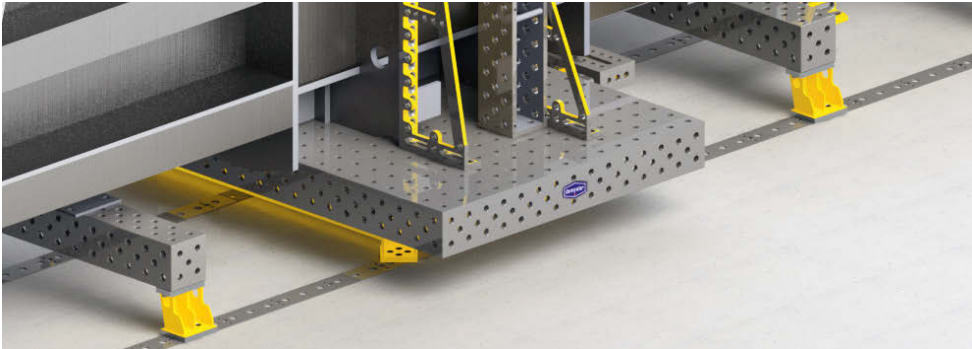
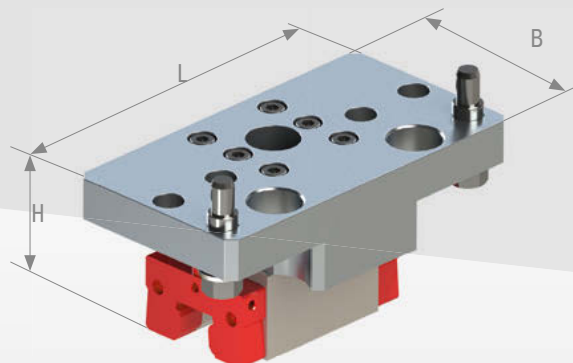


Table size	Lane width	H	Weight in kg	Max. load in kg	Item no.
1000 / 1000	1000/1000	600	158	15000	PL00-02004-000
1200 / 1200					
1500 / 1000					
1500 / 1500					
2000 / 1000	2000/1000	600	229	15000	PL00-02004-001
2000 / 2000					
2400 / 1200					
3000 / 1500					
4000 / 2000	4000/2000	600	516	20000	PL00-02004-002
4000 / 2000					
4800 / 2400					

Other sizes by request!

- Superstructures can be shifted even under load
- Tip-resistance thanks to wrap-around guide
- Stripper prevents accumulation of dirt on the rolling element
- Cladding plate included in the scope of delivery
- Shifting possible under load



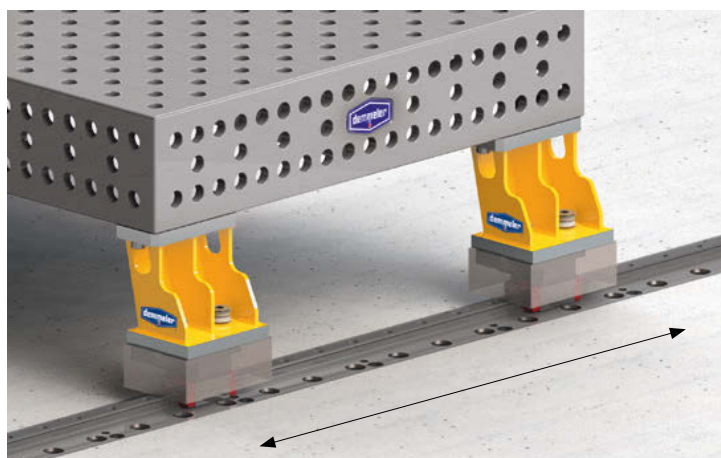
Also compatible with:

Support and base rail, **LINEAR**

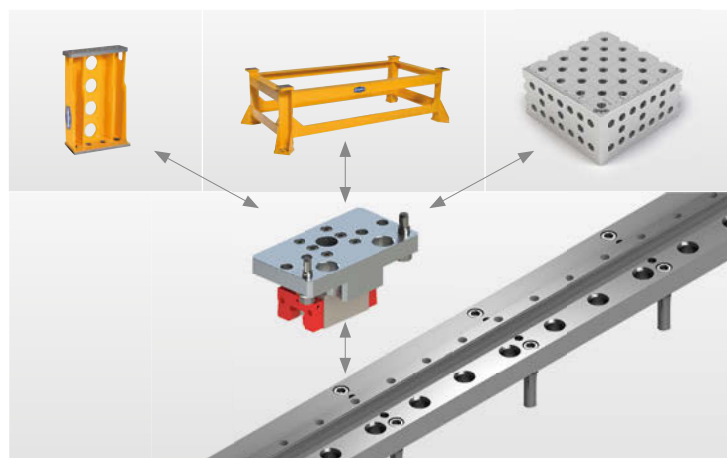


Description ▲ Application ▼

Application ▼



Guiding carriage including cladding plate



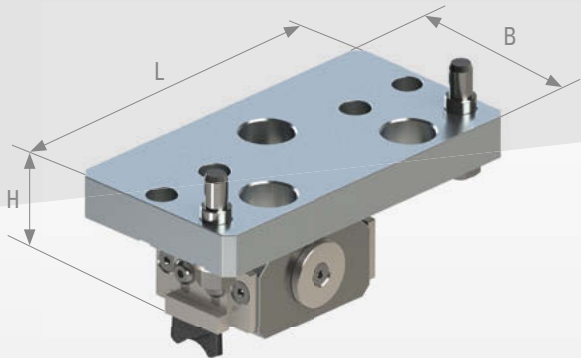
L in mm	B in mm	H	Maximum load in kg per guiding carriage		Item no.
			Static	Dynamic	
200	110	100	3870	8440	D28-10018-000
400	110	100	7740	16880	D28-10018-001

Observe internal safety directives when repositioning the system components!

Guiding wagons

Shifting possible under load!

- Superstructures can be shifted even under load
- Extremely smooth-running thanks to ball bearings
- Roller in hardened version
- High bearing load thanks to robust design
- Cladding plate included in the scope of delivery
- Observe stability while moving system components
- Shifting possible under load



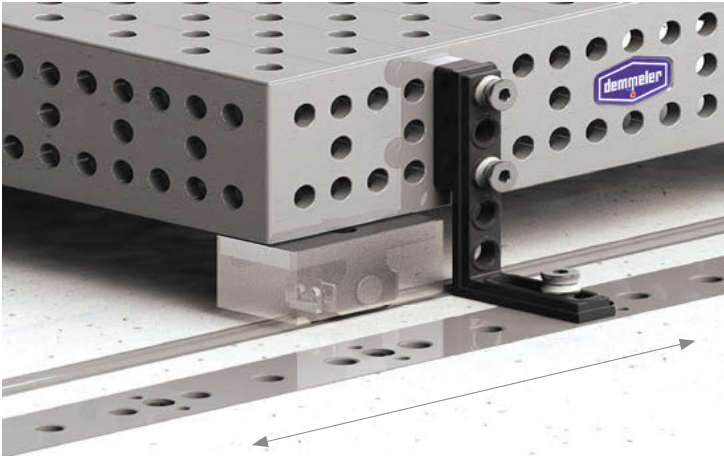
Also compatible with:

Base rail, **ROUND**

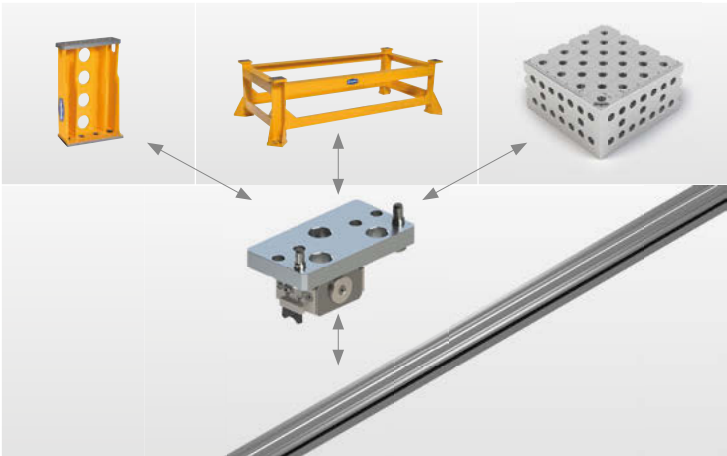


Description ▲ Application ▼

Application ▼

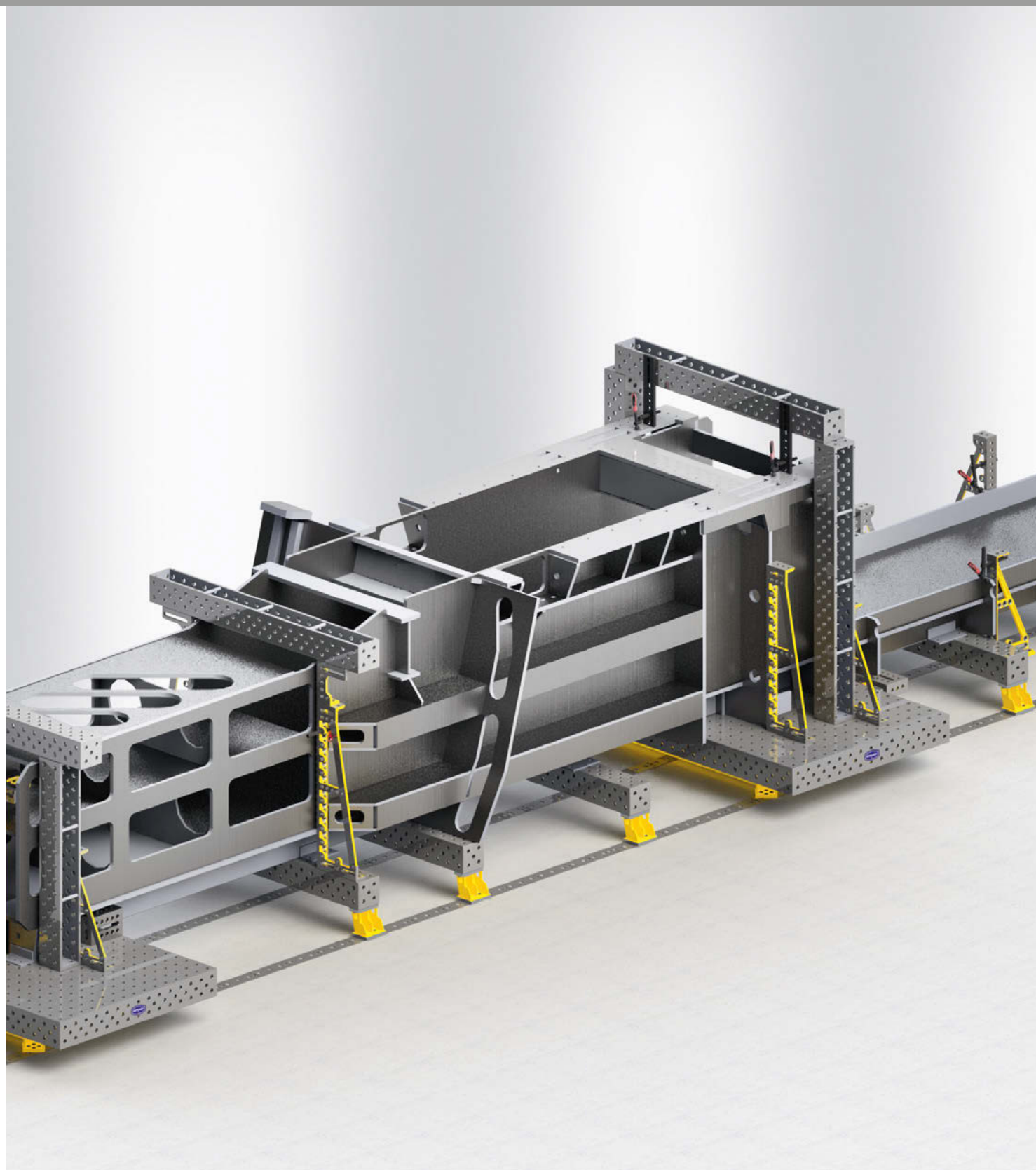


Guiding wagon including cladding plate



L in mm	B in mm	H in mm	Max. load in kg per guiding wagon	Item no.
200	110	100	1640	D28-10019-000
400	110	100	3280	D28-10019-001

Observe internal safety directives when repositioning the system components!



Transforming the hall floor into a stress field

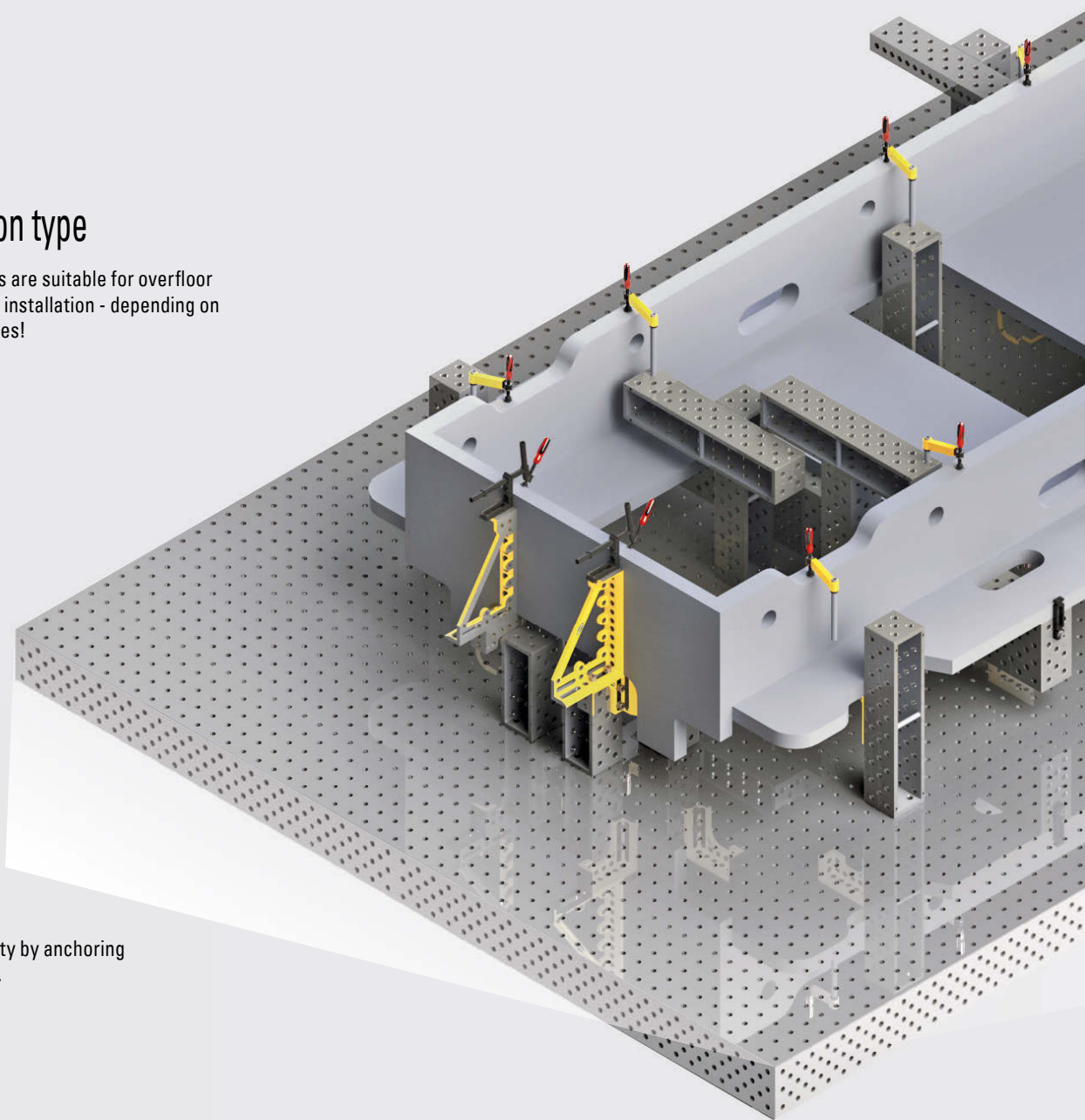
With the permanently installed floor plates, you can transform your hall into a giant clamping system. Ideal for large and heavy work pieces.

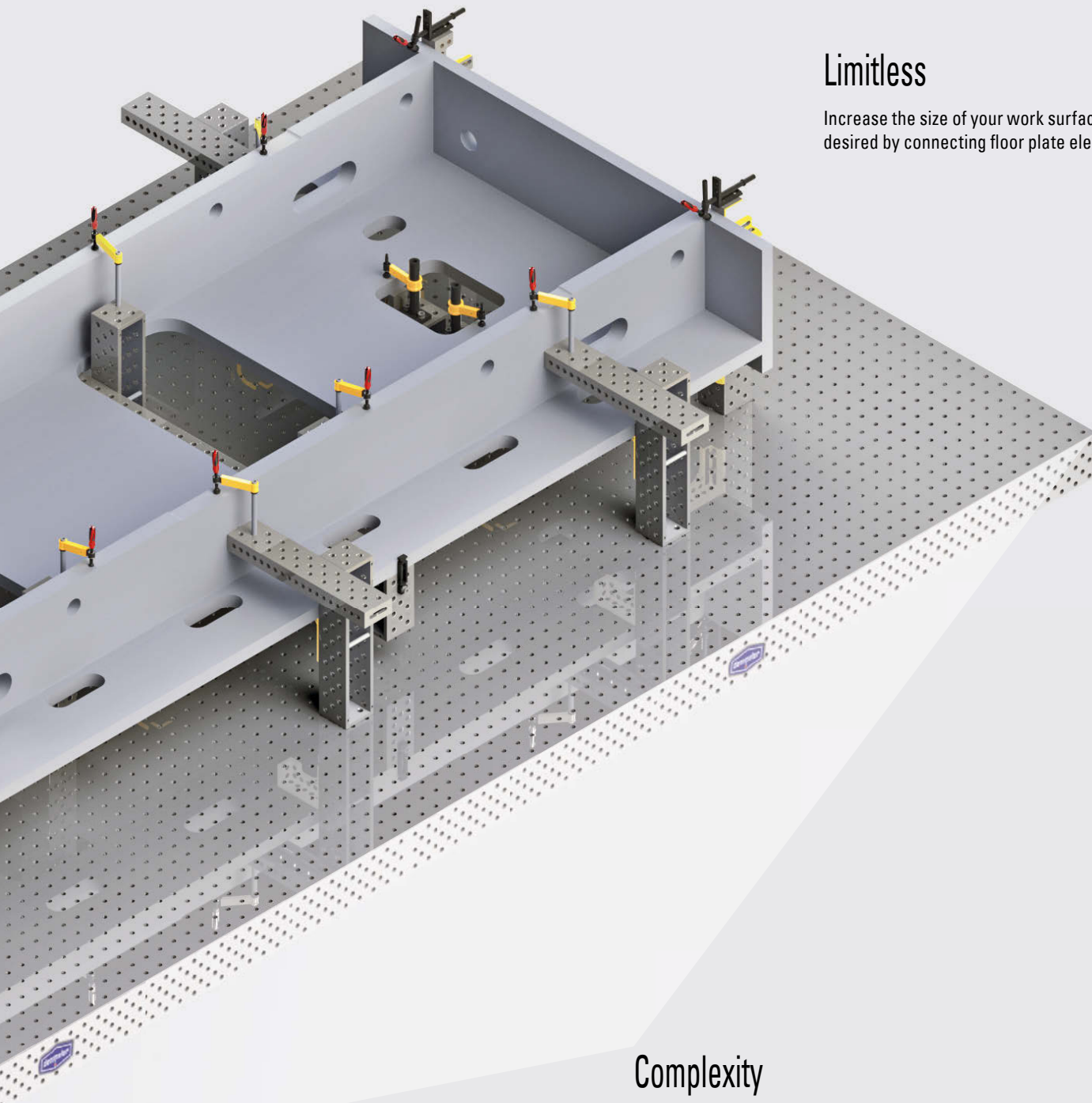
Installation type

The floor plates are suitable for overfloor and underfloor installation - depending on your preferences!

Stability

Ultimate stability by anchoring to the hall floor.





Limitless

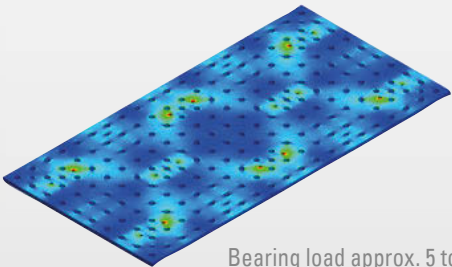
Increase the size of your work surface as desired by connecting floor plate elements.

Complexity

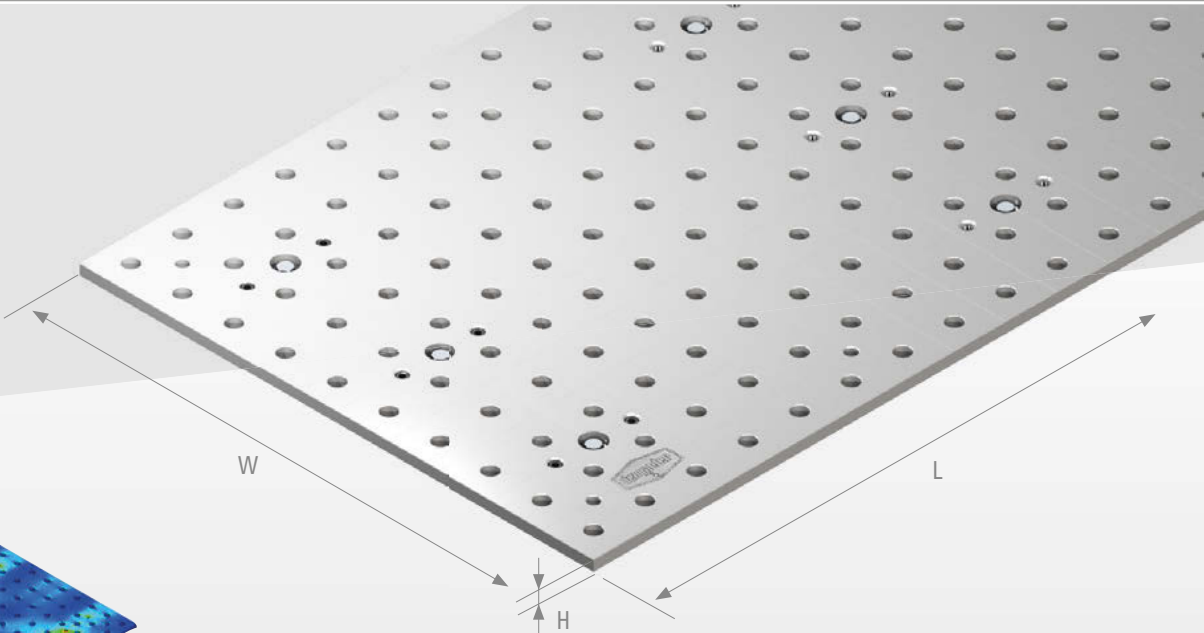
Continuous clamping surface with system grid for large, complex set-ups.

Clamping floor plate

- Two-dimensional grid system for large, complex components
- Various grid types optionally possible
- **Includes screw set, dowels and shims**
- 100 x 100 mm grid, D28 system bores
- Allowable tensile load in crack-free concrete approx. 1.0 ton per dowel

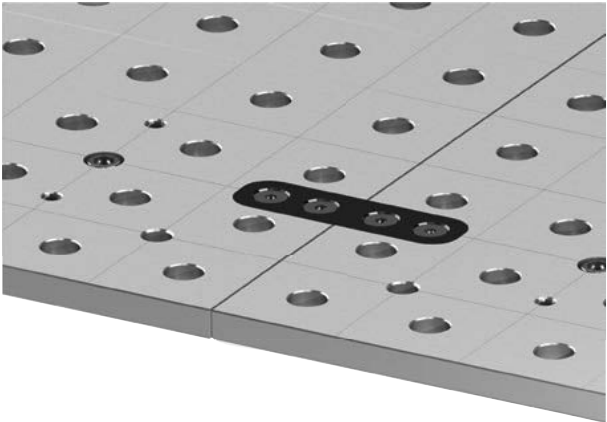


Bearing load approx. 5 tons per m²



Description ▲ Application ▼

Overfloor / underfloor ▼



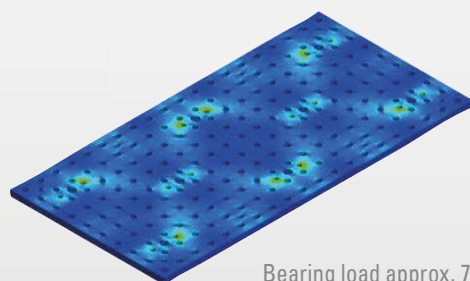
Connection / expansion of individual elements.



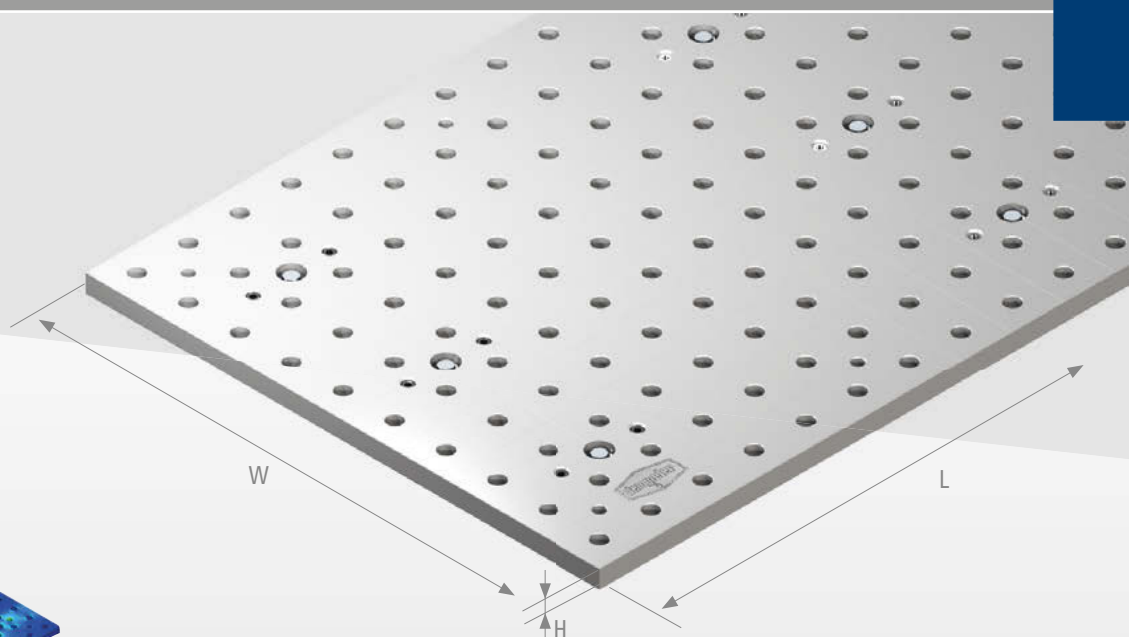
L in mm	W in mm	H in mm approx.	Item no.
1000	1000	23	D28-02010-000
1200	1200	23	D28-02010-001
1500	1000	23	D28-02010-002
1500	1500	23	D28-02010-003
2000	1000	23	D28-02010-004
2400	1200	23	D28-02010-005
3000	1500	23	D28-02010-006
4000	2000	23	D28-02010-007

Other sizes by request!

- Two-dimensional grid system for large, complex components
- Various grid types optionally possible
- **Includes screw set, dowels and shims**
- 100 x 100 mm grid, D28 system bores
- Allowable tensile load in crack-free concrete approx. 1.8 tons per dowel

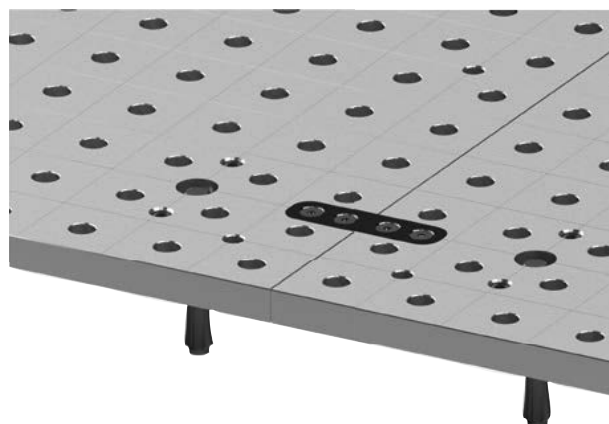


Bearing load approx. 7.5 tons per m²

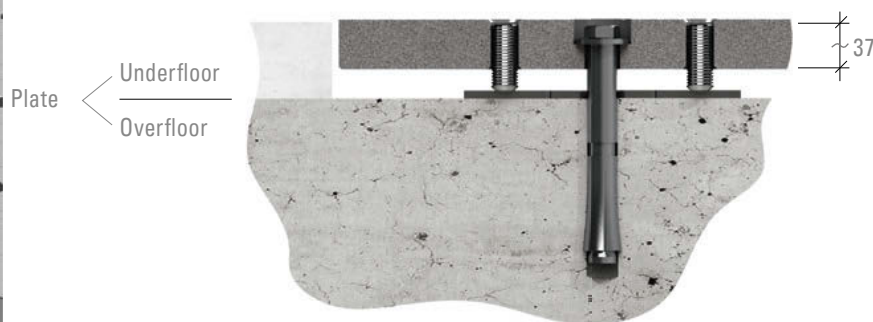


Description ▲ Application ▼

Overfloor / underfloor ▼



Connection / expansion of individual elements.

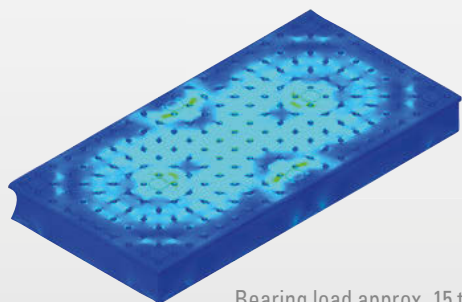


L in mm	W in mm	H in mm approx.	Item no.
1000	1000	37	D28-02011-000
1200	1200	37	D28-02011-001
1500	1000	37	D28-02011-002
1500	1500	37	D28-02011-003
2000	1000	37	D28-02011-004
2400	1200	37	D28-02011-005
3000	1500	37	D28-02011-006
4000	2000	37	D28-02011-007

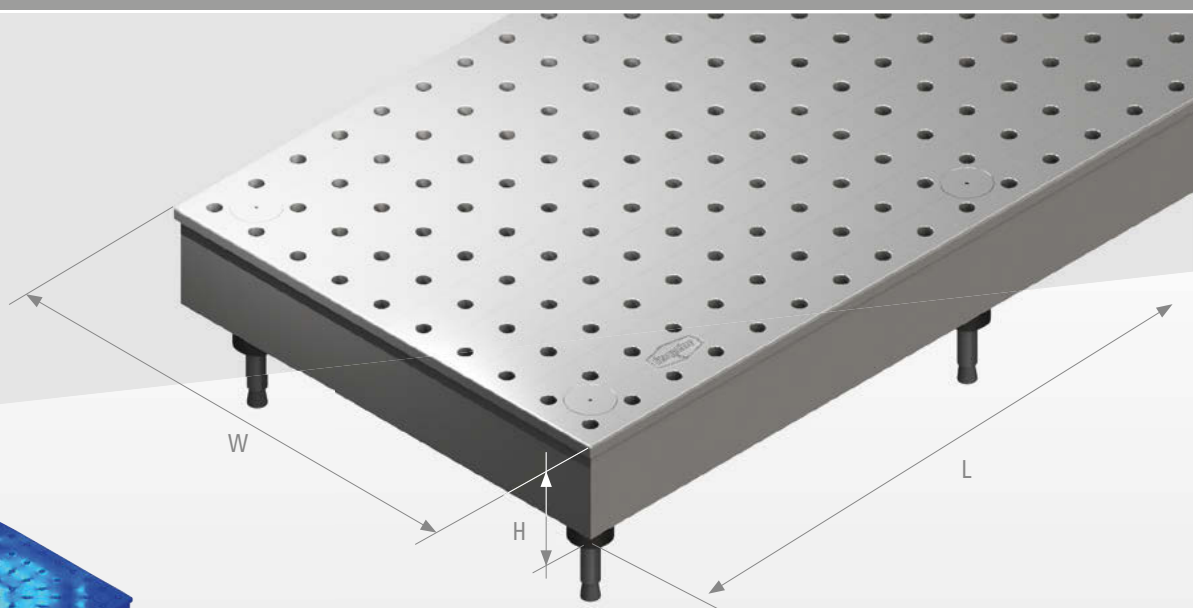
Other sizes by request!

Clamping floor plate ProfiLINE

- Two-dimensional grid system for extremely large, complex components
- Various grid types optionally possible
- Can be expanded as desired
- **Includes screw set, dowels and washers**
- Fine thread to adjust legs for exact levelling
- Bearing load approx. 15 tons per m²
- 100 x 100 mm grid, D28 system bores
- Allowable tensile load in crack-free concrete approx. 1.8 tons per dowel

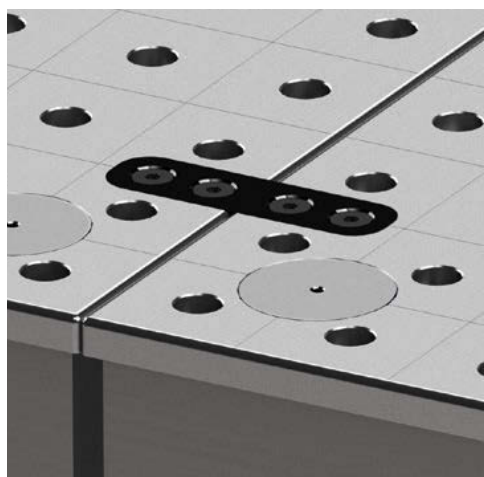


Bearing load approx. 15 tons per m²

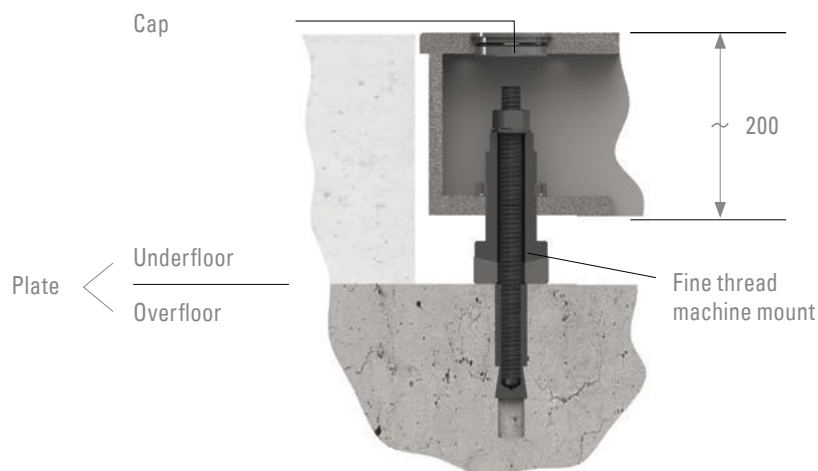


Description ▲ Application ▼

Overfloor / underfloor ▼

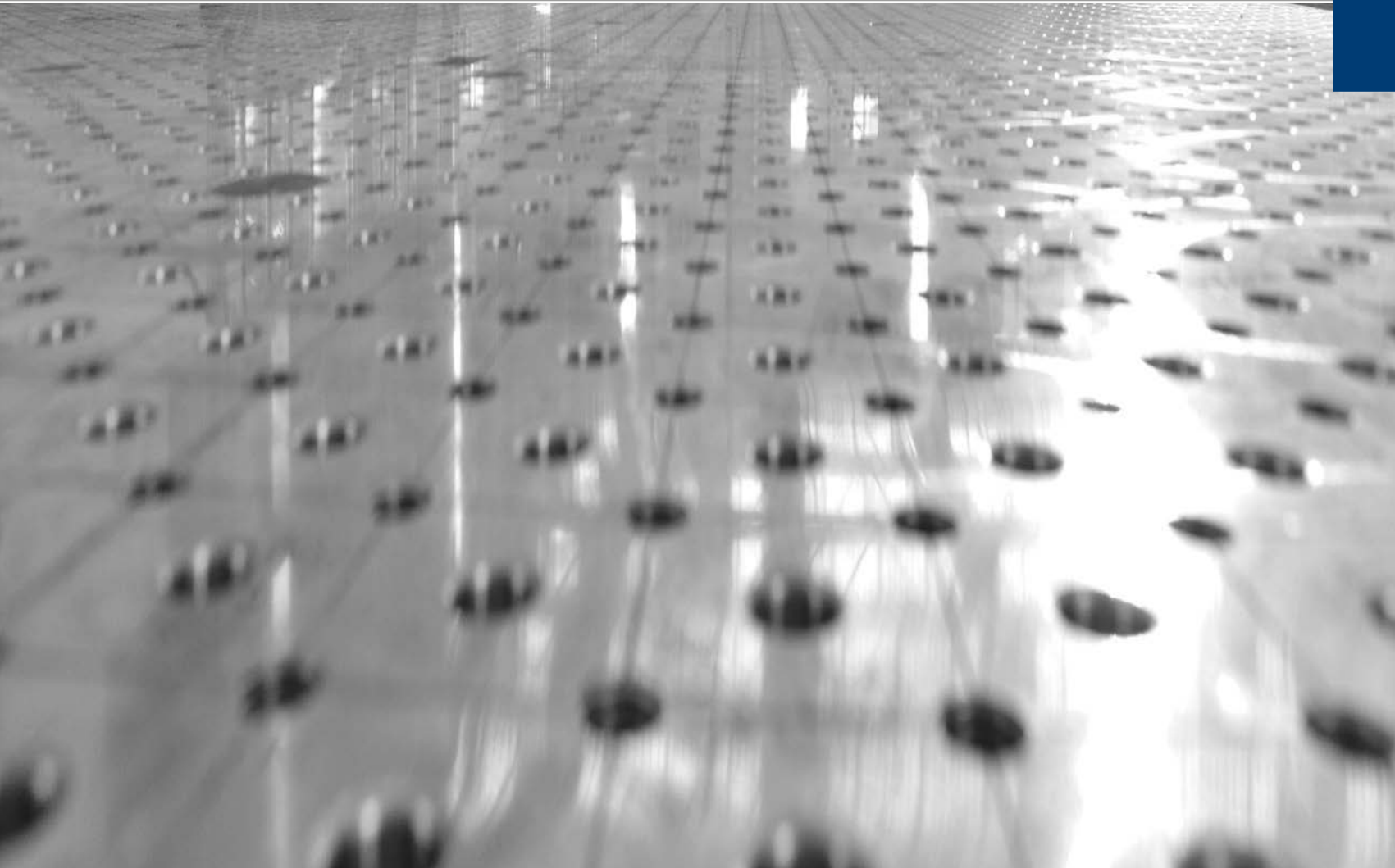


Connection / expansion of individual elements.

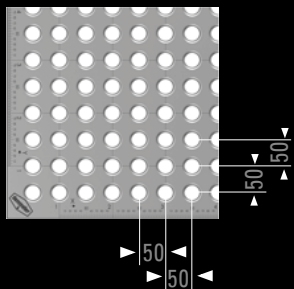


L in mm	W in mm	H in mm	Item no.
1000	1000	200	D28-02012-000
1200	1200	200	D28-02012-001
1500	1000	200	D28-02012-002
1500	1500	200	D28-02012-003
2000	1000	200	D28-02012-004
2400	1200	200	D28-02012-005
3000	1500	200	D28-02012-006
4000	2000	200	D28-02012-007

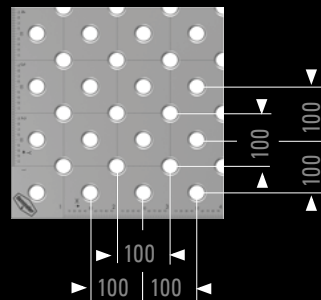
Other sizes by request!



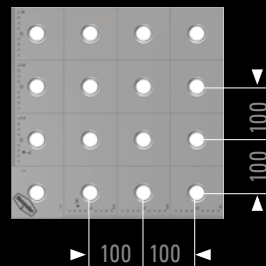
PROFIPremiumLINE (PP)



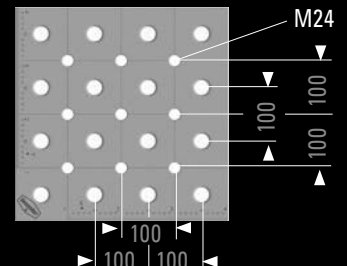
PROFIPlusLINE (PL)



PROFIEcoLINE (PE)



PL-M24 grid







Bolts

Bolts - overview	170
Benefits of the PPC bolt	173
PPC bolt D28, short	174
PPC bolt D28, long	175
PPC-countersunk bolt D28, short	176
PPC countersunk bolt D28, long	177
PC-bolt D28, short	178
PC-bolt D28, long	179
Cordless power screwdriver	180
Cordless power screwdriver set	181
PC-countersunk bolt D28, short	182
PC-countersunk bolt D28, long	183
FCP-bolts with handle D28	184
EcoLINE bolt D28, short	185
Stop and positioning bolt D28	186
Connecting bolt D28, short with screw	187
Connecting bolt D28, long with screw	187
Connecting bolt D28, short with collar	188
Adapter for PC-bolts	189
Reduction plate for clamping tubes	190

Bolts - overview

28 PPC bolt, short

PAGE 174



28 PPC bolt, long

PAGE 175



28 PPC countersunk head bolt, short

PAGE 176



28 PPC-countersunk bolt, long

PAGE 177



28 PC-bolt, short

PAGE 178



28 PC-bolt, long

PAGE 179



28 Power screwdriver

PAGE 181



28 PC-countersunk bolt / short

PAGE 182



28 PC-countersunk bolt, long

PAGE 183



28 FCP-bolts with handle

PAGE 184



28 ECOLine bolt, short

PAGE 185



28 Stop and positioning bolt

PAGE 186



28 Connecting bolt, short with screw

PAGE 187



28 Connecting bolt, long with screw

PAGE 187



28 Connecting bolt, short with collar

PAGE 188



28 Adapter for PC-bolt

PAGE 189



28 Reduction plate for clamping tube

PAGE 190



The perfect connection

Self-centring, force-locked and low-wear clamping – possible thanks to the original DEMMELER clamping bolt



Very high-speed clamping and unclamping of

the clamping elements

Form-fitting through full-area contact

with the reciprocal surface

Reduces material wear

even when aluminium and plastic elements are used – no system bore deformation



Low susceptibility to dirt

because sensitive parts such as clamp threads etc. are fully encapsulated by O-rings

Extremely robust

made from high-quality hardened steel, maximum precision thanks to grinding

Long service life guaranteed

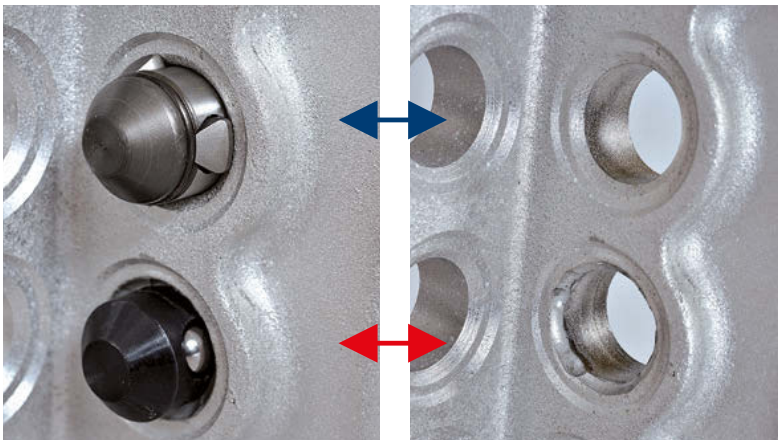
in everyday applications



The PPC bolt meets all expectations!



Comparison between clamping pins and the new polygon bolt from DEMMELER



CONE INSTEAD OF BALLS –
MORE FORCE, LESS WEAR

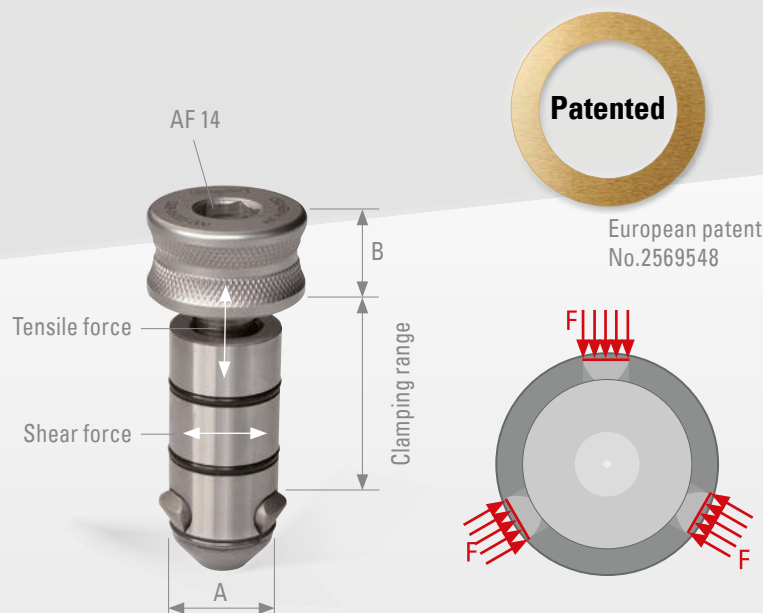
Thanks to the new cone clamping system of the DEMMELER PPC bolt, the bearing surface is 100 times larger. This results in much higher contact pressure, therefore securing work pieces more reliably. Even force distribution also reduces bore hole wear compared to conventional bolts.

Using the PPC bolt prevents serious damage to the bores that can be caused by clamping pins, for example with aluminium-titanium blocks.

PPC bolt, short

Bauart
geprüft

- Highest clamping force with large stroke. Polygon expansion elements are full-faced, force-locked, and exactly self-centring, thereby reducing the surface load
- Self-locking
- Easy on materials
- Straightforward, fast and safe handling
- Low susceptibility to dirt
- DEMMELER system lock for DEMMELER power screwdriver for inserting and tightening as well as loosening and pulling
- With marking grooves for DEMMELER power screwdriver
- High-quality hardened steel, maximum precision thanks to grinding
- O-ring prevents simultaneous rotation while tightening and cleans the system bore at the same time



Description ▲ Application ▼

Minimum clamping range ▼

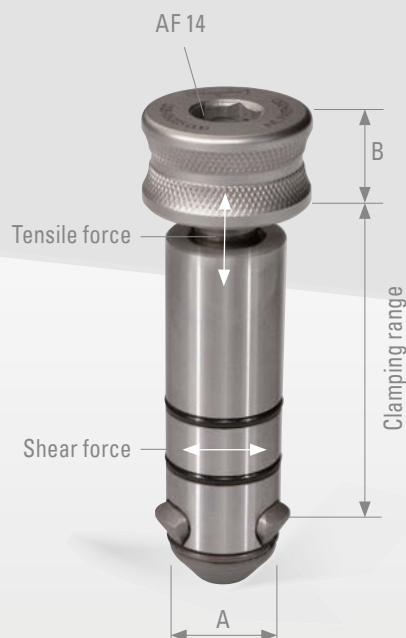
Maximum clamping range ▼



The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

28	Clamping range	Ø A in mm	B in mm	~ Weight in kg	Design	Item no.
	41-47	28-0.02	24	0.5	tensile force: max. 25 kN shear force: max. 200 kN tightening torque: 70 Nm	D28-06025-000

- Highest clamping force with large stroke. Polygon expansion elements are full-faced, force-locked, and exactly self-centring, thereby reducing the surface load
- Self-locking
- Easy on materials
- Straightforward, fast and safe handling
- Low susceptibility to dirt
- DEMMELER system lock for DEMMELER power screwdriver for inserting and tightening as well as loosening and pulling
- With marking grooves for DEMMELER power screwdriver
- High-quality hardened steel, maximum precision thanks to grinding
- O-ring prevents simultaneous rotation while tightening and cleans the system bore at the same time



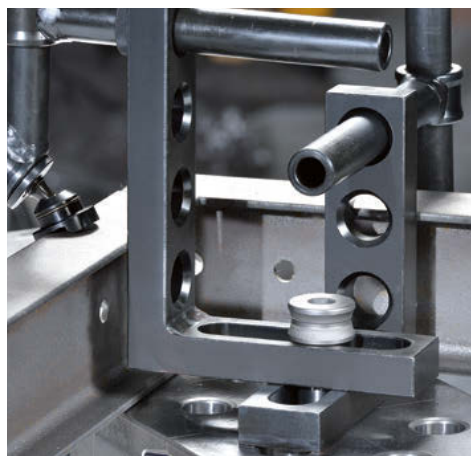
European patent
No.2569548



Description ▲ Application ▼

Minimum clamping range ▼

Maximum clamping range ▼

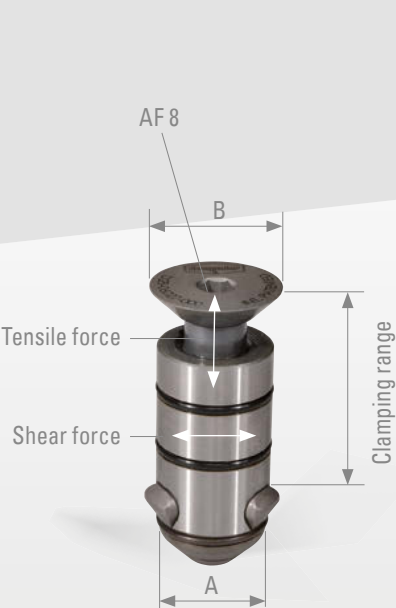


The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

28	Clamping range	Ø A in mm	B in mm	~ Weight in kg	Design	Item no.
	66-72	28-0.02	24	0.6	tensile force: max. 25 kN shear force: max. 200 kN tightening torque: 70 Nm	D28-06026-000

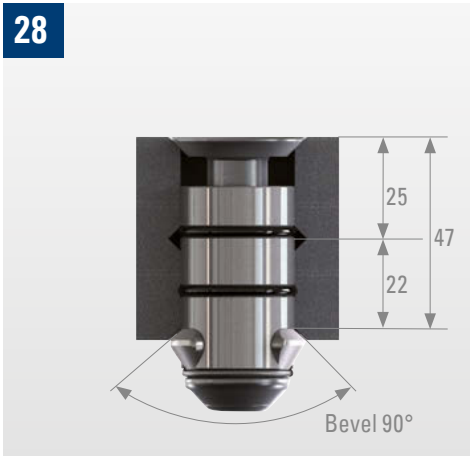
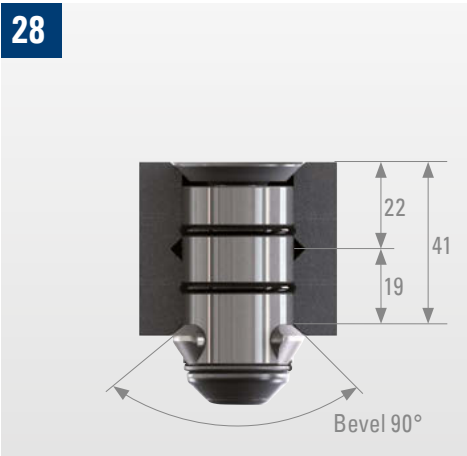
PPC countersunk head bolt, short

- Made especially for Demmeler power screwdriver
- Used for simultaneous clamping of two system components
- Easy, comfortable clamping through optimised force distribution in the expansion segments
- Minimal susceptibility to dirt due to polygon shape
- Standard with Demmeler for a long service life: high-strength, hardened and ground
- With optimum force distribution, Demmeler opens up a new dimension of application possibilities
- Countersunk head bolts may only be used in bores but not in oblong holes



European patent
No.2569548

Description ▲ Application ▼	Minimum clamping range ▼	Maximum clamping range ▼
-----------------------------	--------------------------	--------------------------

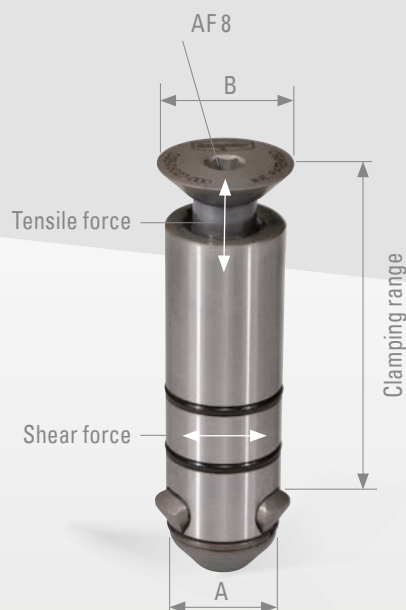


The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

28	Clamping range	Ø A in mm	Ø B in mm	~ Weight in kg	Design	Item no.
	41-47	28-0.02	32	0.3	tensile force: max. 10 kN shear force: max. 200 kN tightening torque: 50 Nm	D28-06027-000

PPC-countersunk bolt, long

- Made especially for Demmeler power screwdriver
- Used for simultaneous clamping of two system components
- Connecting element for all system components on tables, perforated plates etc. or for special fixtures
- Easy, comfortable clamping through optimised force distribution in the expansion segments
- Minimal susceptibility to dirt due to polygon shape
- Standard with Demmeler for a long service life: high-strength, hardened and ground
- With optimum force distribution, Demmeler opens up a new dimension of application possibilities
- Countersunk head bolts may only be used in bores but not in oblong holes



European patent
No.2569548



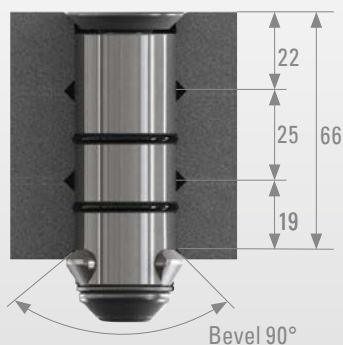
Description ▲

Minimum clamping range ▼

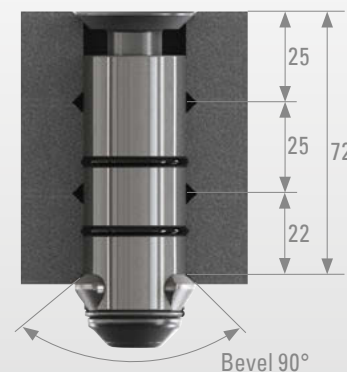
Maximum clamping range ▼



28



28



The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

28	Clamping range	Ø A in mm	Ø B in mm	~ Weight in kg	Design	Item no.
	66-72	28-0.02	32	0.6	tensile force: max. 10 kN shear force: max. 200 kN tightening torque: 50 Nm	D28-06028-000

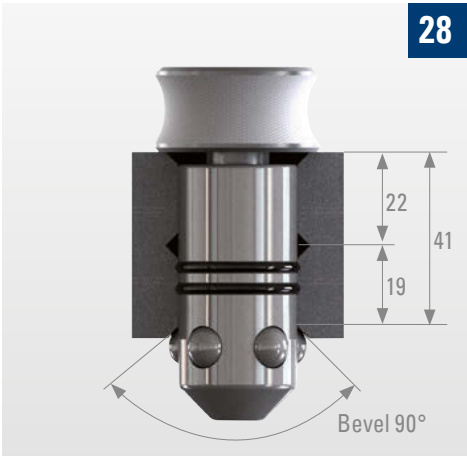

PC-bolt, short


**Bauart
geprüft**

- Connecting element for all system components on tables, perforated plates etc. or for special fixtures
- Very fast connection with simultaneous large stroke
- Very high clamping force due to planetary gear effect and by avoiding a double thread
- Force-fit and form-fitting, O-ring for self-centring connection
- With clamping range



The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

Description ▲ Our ideas ▼		Minimum clamping range ▼			Maximum clamping range ▼	
<ul style="list-style-type: none">• Highest clamping force with large stroke using Allen key with double hexagonal AF 14 or with torque wrench• Ergonomically shaped bolt head with recessed grip for fast one-hand operation• High-quality hardened steel, maximum precision thanks to grinding• O-rings prevent simultaneous rotation while tightening and clean the system bore at the same time• 5 clamping balls, mechanically secured against falling out, to ensure even clamping						
28	Clamping range	Ø A in mm	B in mm	~ Weight in kg	Design	Item no.
	41-47	28-0.02	20	0.40	tensile force: max. 25 kN shear force: max. 200 kN tightening torque: 70 Nm	D28-06001-000

- Used for simultaneous clamping of two system components
- Connecting element for all system components on tables, perforated plates etc. or for special fixtures
- Very fast connection with simultaneous large stroke
- Very high clamping force due to planetary gear effect and by avoiding a double thread
- Force-fit and form-fitting, O-ring for self-centring connection
- With clamping range



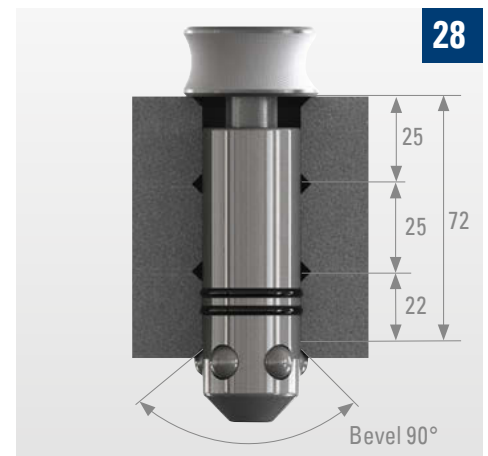
The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

Description ▲ Functional principle ▼

Turning the ergonomically shaped bolt head causes the balls of the patented PC-bolt to make point contact with the bevel on the underside of the worktable. Continued turning clamps the original DEMMELER PC-bolt.

Minimum clamping range ▼

Maximum clamping range ▼



28	Clamping range	Ø A in mm	B in mm	~ Weight in kg	Design	Item no.
	63-72	28-0.02	20	0.50	tensile force: max. 25 kN shear force: max. 200 kN tightening torque: 70 Nm	D28-06002-000

Power screwdriver with quick-change coupling for the PPC bolt



Power screwdriver with quick-change coupling for the PPC bolt 10 x faster than conventional! Designed especially for use with the PPC bolt:

- Thanks to DEMMELER system locking between the PPC bolt and impact screwdriver, inserting and tightening as well as loosening and pulling the bolt is possible with just one hand. This always keeps your other hand free
- Minimum expenditure of energy for maximum clamping force
- Straightforward, efficient care of the table thanks to included cleaning plate and round brush attachment
- Clamping with maximum force and speed

The power screwdriver including accessory package

- Cordless impact screwdriver with defined torque, including exchangeable lithium-ion battery and charger
- Quick-change coupling to hold the PPC bolts and accessories
- Socket for tightening and loosening the short boring spindles of screw clamps etc., fits quick-change coupling
- Cleaning plate Ø 125 mm for fast cleaning of the tabletop, adapter fits quick-change coupling
- Round brush attachment Ø 28 mm for efficient cleaning of the system bores, fits quick-change coupling
- Practical carrying case for all accessories

Quantity	Description	Item no.
1	Cordless screwdriver (incl. 1 charger + 2 batteries)	00072273
1	Round brush attachment Ø28*	D28-10002-001
1	Fast connector for PPC bolts*	00105155
1	Socket adapter AF 14 to AF 13*	00074097
1	Cleaning plate Ø125*	00074053
1	Plastic case*	00072479
1	3M Velour polishing pad Ø127*	00082427
1	Fast assembling set, complete*	00066667

* Only available in the set



Description ▲ Application ▼

Application ▼

Application ▼

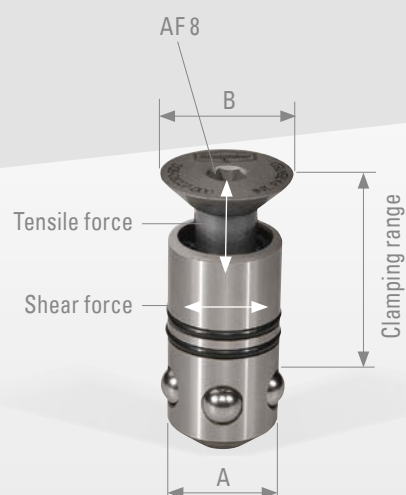


28	Quantity	Design	Item no.
	1	Power screwdriver	D28-13050-000

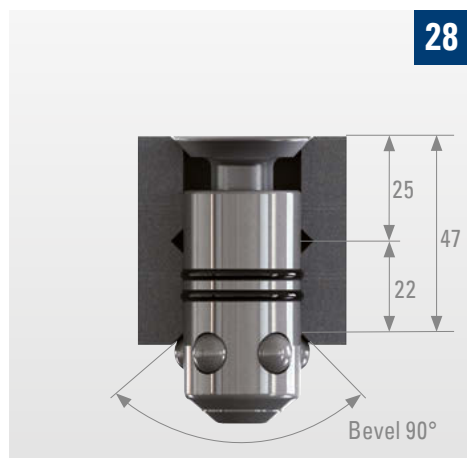
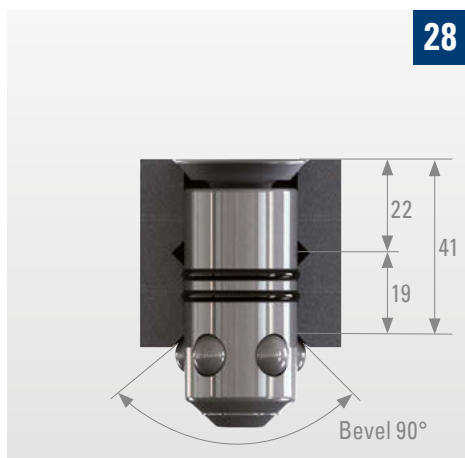
PC-countersunk bolt, short


**Bauart
geprüft**

- Countersunk bolt head (no interfering edges)
- Only for connecting bores (no oblong holes)
- Clamping by means of Allen key AF 8 or torque wrench
- Countersunk head bolts may only be used in bores but not in oblong holes



The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

Description ▲ Application ▼
Minimum clamping range ▼
Maximum clamping range ▼

28
Clamping range

41-47

Ø A in mm

28-0.02

Ø B in mm

31.6

~ Weight in kg

0.25

Design

 tensile force: max. 10 kN
 shear force: max. 200 kN
 tightening torque: 50 Nm

Item no.

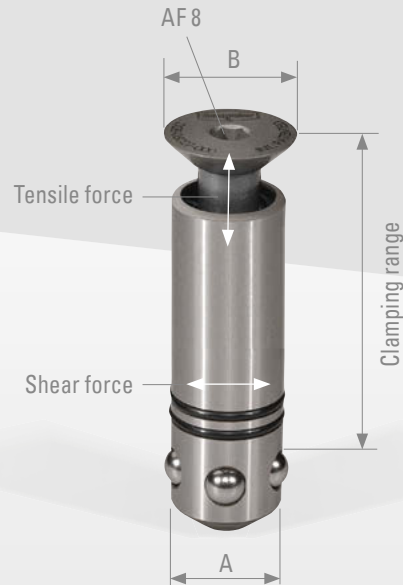
D28-06004-000

PC-countersunk bolt, long


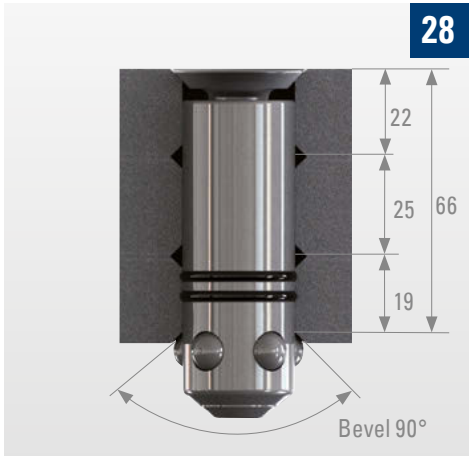



Bauart
geprüft

- Countersunk bolt head (no interfering edges)
- Only for connecting bores (no oblong holes)
- Clamping by means of Allen key AF 8 or torque wrench
- For simultaneous clamping of two system components on top of each other on the worktable
- Countersunk head bolts may only be used in bores but not in oblong holes

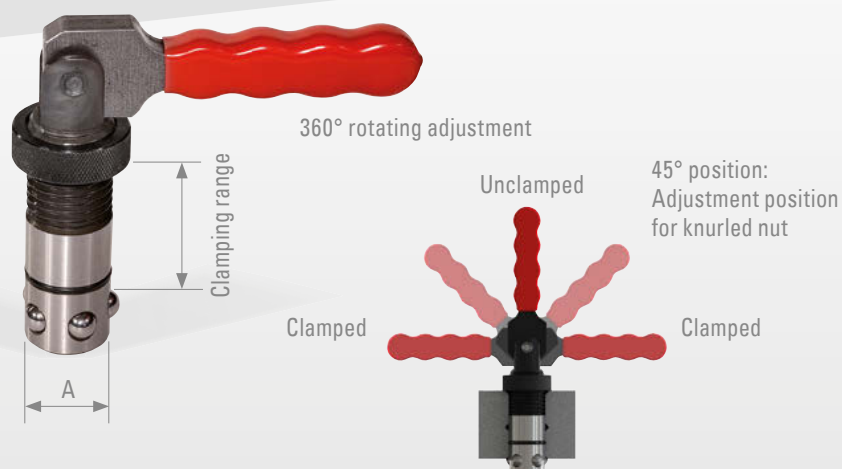


The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

Description ▲	Minimum clamping range ▼	Maximum clamping range ▼
<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  </div> <div style="text-align: center;">  <p>28</p> </div> <div style="text-align: center;">  <p>28</p> </div> </div>		
28 Clamping range	66-72	
Ø A in mm	28-0.02	
Ø B in mm	31.6	
~ Weight in kg	0.36	
Design	tensile force: max. 10 kN shear force: max. 200 kN tightening torque: 50 Nm	
Item no.	D28-06005-000	

FCP-bolts with handle

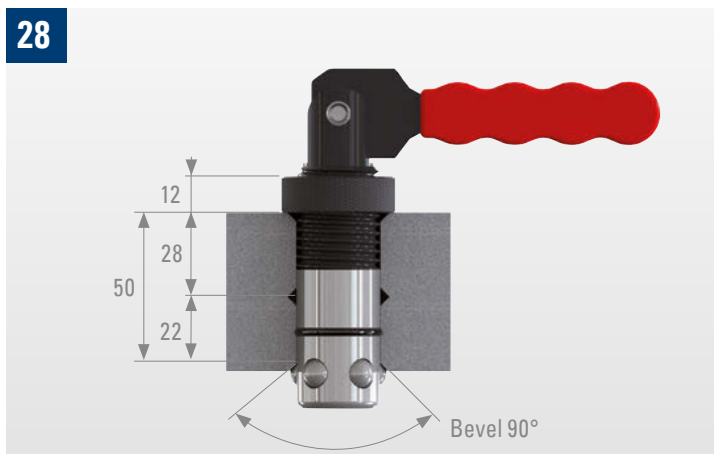
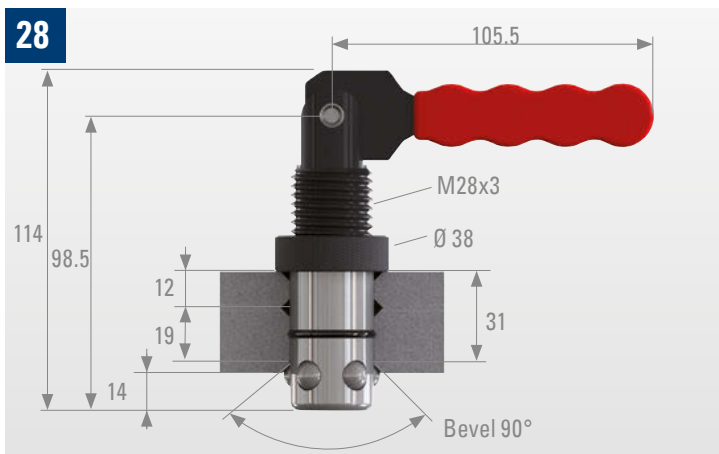
- Connecting element for all system components on tables, perforated plates etc. or for special fixtures
- Defined adjustment position and optimum implementation to ensure constant maximum clamping force
- High closing and shear force
- Used without additional tools
- For quick clamping of the system components



Description ▲

Minimum clamping range ▼

Maximum clamping range ▼



28

Clamping range
31 - 50Ø A in mm
28-0.01~ Weight in kg
0.62Item no.
D28-06007-000

- Connecting element for system components
- For clamping one system component on the worktable or to connect 2 system components
- Simple version without clamping range



Description ▲

Clamping range, minimum ▼

Clamping range, maximum ▼



28	Clamping range	Ø A in mm	B in mm	~ Weight in kg	Item no.
	41-44	28 -0.02	20	0.44	E28-06001-000

Stop and positioning bolts

- For marking the system components
- For fixation e.g. of blocks and stops, cost-effective replacement for a second clamping pin
- Blackened
- Also suitable as adapter for system 16 screw clamps thanks to D16 system bore in the head



Description ▲

Application ▼



28	Ø A in mm	Ø B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	28	40	74	23	0.4	D28-06009-000

Connection bolt, short with screw

- For use as long-term connection
- With self-centring countersunk head on both sides
- Suitable for system bores
- Clamping with Allen key AF 10
- Ideal for connecting worktables with U-spacers etc.
- Blackened

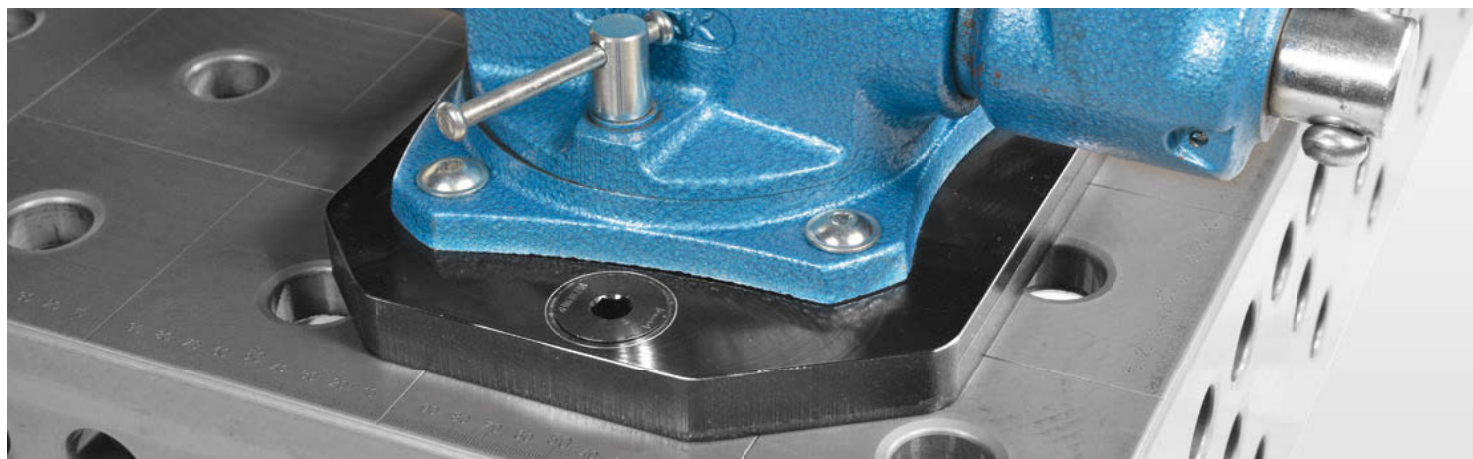


Connecting bolt, long with screw

- For use as long-term connection
- With self-centring countersunk head on both sides
- Suitable for system bores
- Clamping with Allen key AF 10
- For connecting three system components or two system components on the worktable
- Blackened



Description ▲ Application ▼

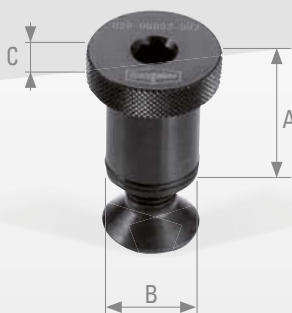


28	A in mm	Ø B in mm	~ Weight in kg	Item no.
	35.5	28	0.18	D28-06003-000

28	A in mm	Ø B in mm	~ Weight in kg	Item no.
	60	28	0.26	D28-06006-000

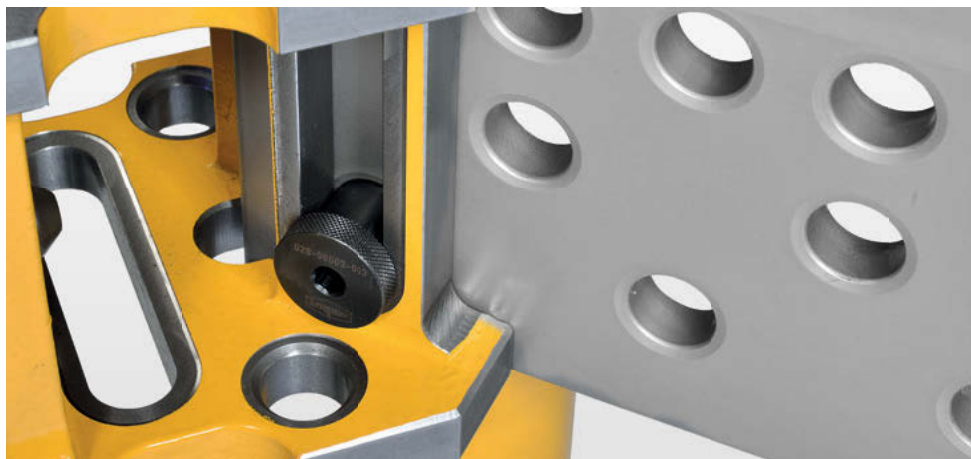
Connecting bolt, short with collar

- For use as long-term connection
- For connecting two system components
- Suitable for system bore / oblong hole
- Clamping with Allen key AF 10



Description ▲

Application ▼



28

A in mm
35Ø B in mm
28C in mm
10~ Weight in kg
0.26Item no.
D28-06003-003

Adapter for PC-bolt D16 to D28

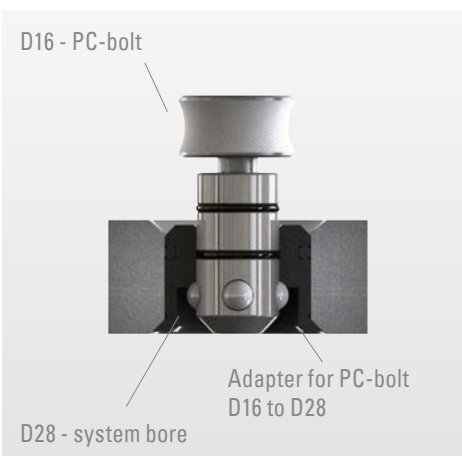
- Interface between system D28 and D16
- Fully compatible with system D28 and D16
- Force-fit and form-fitting with O-ring, self-centring connection
- O-ring prevents simultaneous rotation while tightening
- O-ring cleans the system bore



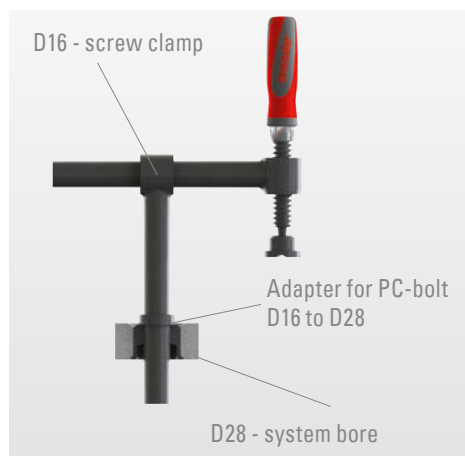
Description ▲ Application ▼



Application ▼



Application ▼

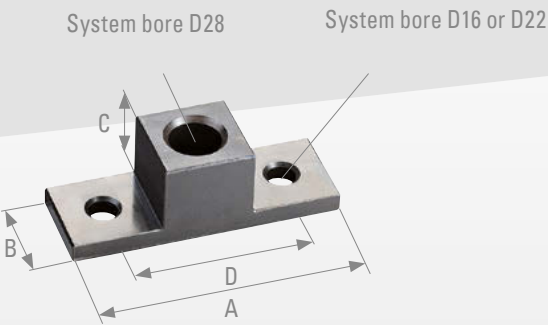


Adapter for PC-bolt D28 to D16

28	Ø A in mm	B in mm	~ Weight in kg	Item no.
	20.5	28-0.02	0.05	D00-06010-002

Reduction plate for clamping tubes D28 to D16 / D22 to D28

- Interface between system 28 and system 16 or system 28 and system 22



Description ▲ Application ▼



Reduction plate for clamping tubes D28 to D16

A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
150	50	50	100	1.04	D00-06015-000

Reduction plate for clamping tubes D22 to D28

A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
150	50	50	100	1.2	D00-06015-001



- Spacer block
- Consoles
- Corner module
- Clamping block / rail

Spacer block overview	192
Spacer block U-form, steel, D28.....	196
Spacer block U-form, aluminium-titanium, D28...	198
Mounting plate for spacer block U-form D28.....	199
Spacer block C-form, aluminium-titanium, D28...	200
Spacer block C-form, steel, D28.....	201
Spacer block L-form D28.....	202
Connection angle D28	203
Console, cast iron, D28	204
Console, aluminium-titanium, D28	205
Console, aluminium-titanium, D28	206
Corner module, cast iron, D28	207
Corner module, aluminium-titanium D28	208
Clamping track D28.....	209

Spacer block overview

28 Spacer block U-form Steel

PAGE 196



28 Spacer block U-form Aluminium-titanium

PAGE 198



28 Mounting plate for spacer block U-form

PAGE 199



28 Spacer block C-form Aluminium-titanium

PAGE 200



28 Spacer block C-form Steel

PAGE 201



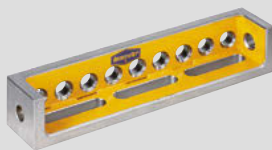
28 Spacer block L-form

PAGE 202



28 Connection angle

PAGE 203



28 Console Cast iron

PAGE 204



28 Console Aluminium-titanium

PAGE 205



28 Console Aluminium-titanium

PAGE 206



28 Corner module, Cast iron

PAGE 207



28 Corner module, aluminium-titanium

PAGE 208





OUR PERFORMANCE
makes THE DIFFERENCE

28 Clamping track

PAGE 209



Spacer block

Setup with spacer block



Setup with spacer block



Thinking beyond the edge of the table

There are situations where having a bigger table would be nice. We developed the spacer block so the clamping table can grow with your needs. A smart system for extending your table temporarily. When you use our rail system, you can extend the supporting surface with spacer blocks as far as the rails reach.

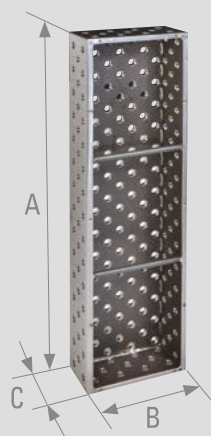
These add-on components increase your flexibility without permanently taking up space.

Spacer block U-form, steel

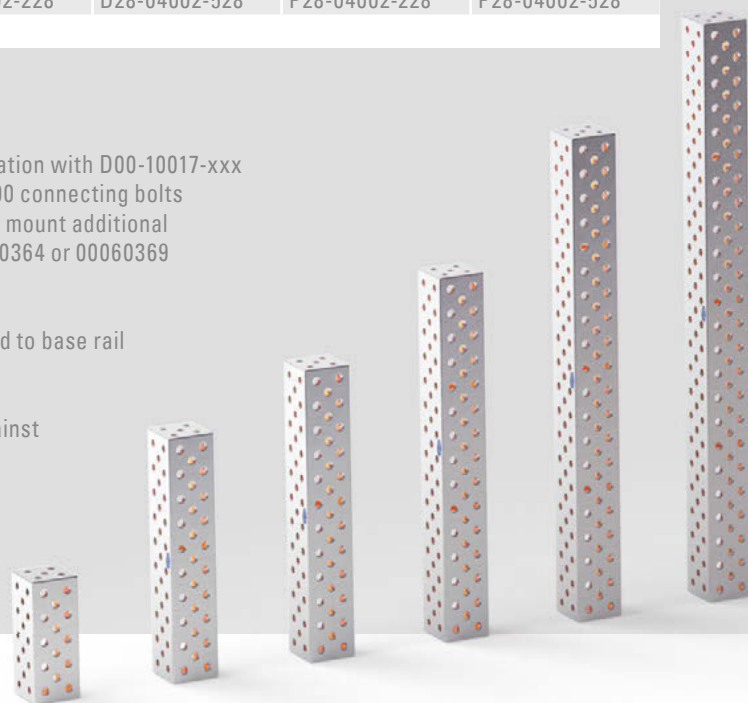
28

A in mm	B in mm	C in mm	~ Weight in kg	Description	Face sides Diagonal grid Item no.	Face sides Diagonal grid hardened Item no.	Face sides Bore/oblong hole Item no.	Face sides Bore/oblong hole hardened Item no.
500	200	200	55	Diagonal grid 100x100	D28-04002-000	D28-04002-500	P28-04002-000	P28-04002-500
1000	200	200	102	Diagonal grid 100x100	D28-04002-001	D28-04002-501	P28-04002-001	P28-04002-501
1200	200	200	120	Diagonal grid 100x100	D28-04002-018	D28-04002-518	P28-04002-018	P28-04002-518
1500	200	200	150	Diagonal grid 100x100	D28-04002-002	D28-04002-502	P28-04002-002	P28-04002-502
2000	200	200	200	Diagonal grid 100x100	D28-04002-003	D28-04002-503	P28-04002-003	P28-04002-503
2400	200	200	235	Diagonal grid 100x100	D28-04002-032	D28-04002-532	P28-04002-032	P28-04002-532
3000	200	200	285	Diagonal grid 100x100	D28-04002-004	D28-04002-504	P28-04002-004	P28-04002-504
4000	200	200	374	Diagonal grid 100x100	D28-04002-005	D28-04002-505	P28-04002-005	P28-04002-505
500	400	200	81	Diagonal grid 100x100	D28-04002-211	D28-04002-511	P28-04002-211	P28-04002-511
1000	400	200	149	Diagonal grid 100x100	D28-04002-222	D28-04002-522	P28-04002-222	P28-04002-522
1200	400	200	174	Diagonal grid 100x100	D28-04002-223	D28-04002-523	P28-04002-223	P28-04002-523
1500	400	200	215	Diagonal grid 100x100	D28-04002-224	D28-04002-524	P28-04002-224	P28-04002-524
2000	400	200	272	Diagonal grid 100x100	D28-04002-225	D28-04002-525	P28-04002-225	P28-04002-525
2400	400	200	320	Diagonal grid 100x100	D28-04002-226	D28-04002-526	P28-04002-226	P28-04002-526
3000	400	200	400	Diagonal grid 100x100	D28-04002-227	D28-04002-527	P28-04002-227	P28-04002-527
4000	400	200	526	Diagonal grid 100x100	D28-04002-228	D28-04002-528	P28-04002-228	P28-04002-528

Other dimensions on request



- Optimum application on rail system (page 148) in combination with D00-10017-xxx (page 156-157). Also to build a frame using D28-06003-000 connecting bolts
- For use as a table extension; length 1 m and up, option to mount additional PL28-10010-xxx supporting leg in combination with 00060364 or 00060369 mounting plate
- Application: 5-sided
- Bore spacing for fitted shoulder screws, bottom, matched to base rail width 1000, 2000, 3000 and 4000
- With grid lines
- Spacer blocks with hardened surfaces are protected against weld spatter adhesion, thus reducing wear



Both face sides 200 x 200 mm with diagonal grid



↑ Open side

Optional both face sides 200 x 200 mm with bore / oblong hole



↑ Open side

Both face sides 400 x 200 mm with diagonal grid

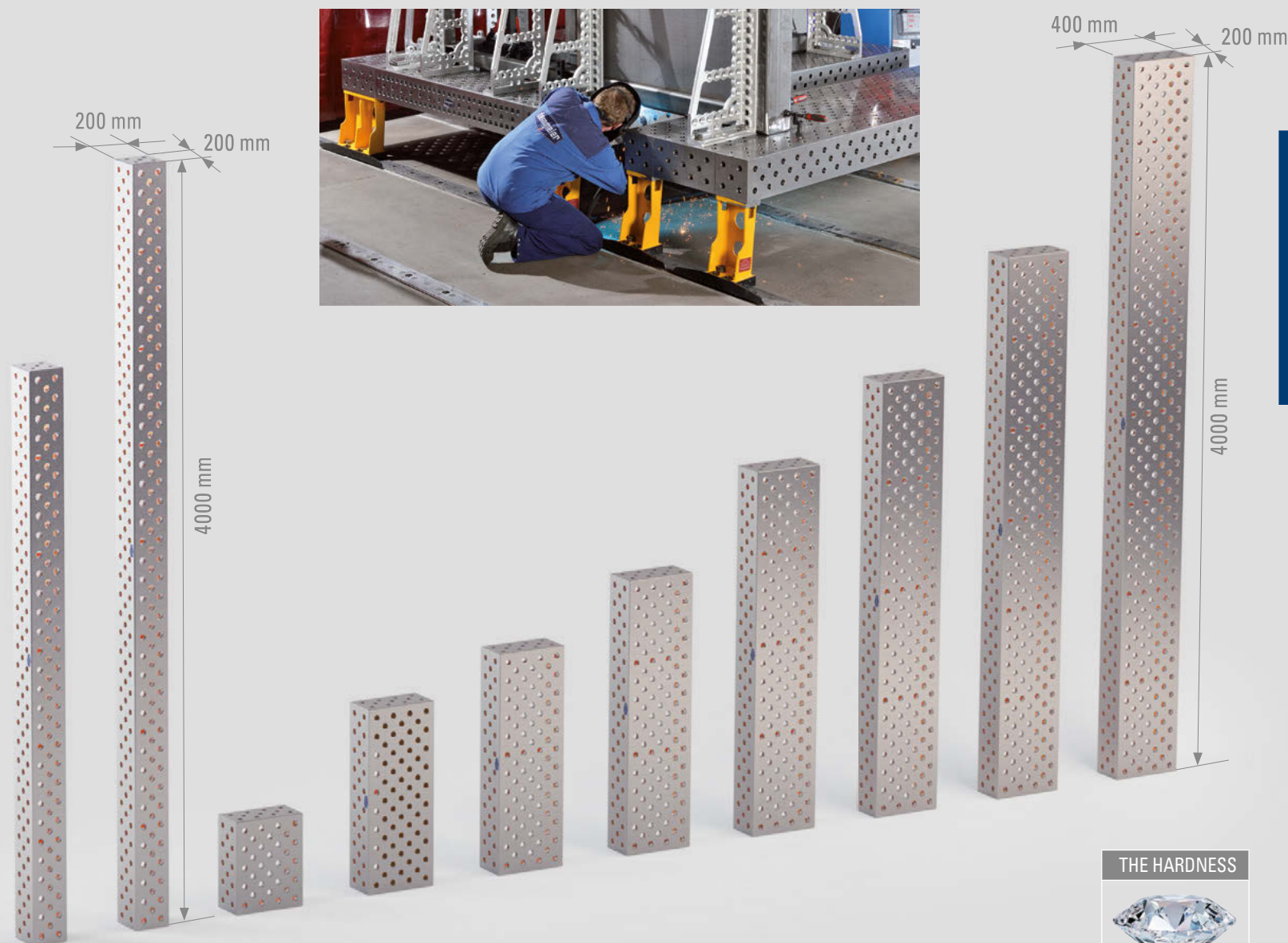


↑ Open side

Optionally both face sides 400 x 200 mm with bore/oblong hole



↑ Open side



THE HARDNESS



DEMONT 760 M

Fitted bores with M12 thread to attach the D00-10017-xxx*1 table legs (see figure above) or the 00060364 / 00060369 mounting plate with fitted shoulder screws

*1 see page 156-157



Spacer block U-form, aluminium-titanium

- Optimum application on rail system (page 148) in combination with D00-10017-xxx (page 156-157). Also to build a frame (see figure to the right) using D28-06003-000 connecting bolts
- For use as a table extension
- Option to mount additional PL28-10010-xxx supporting leg in combination with 00060364 mounting plate
- Application: 5-sided
- Bore spacing for fitted shoulder screws, bottom, matched to base rail width 1000 (for length of 1000 mm)
- With grid lines



Description ▲▼

Fitted bores with M12 thread to attach the table legs for spacer block / shifting foot PL28-10017-xxx*1 or the 00060364 mounting plate with fitted shoulder screws
*1 see page 156-157

Application ▼



28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	500	200	200	20	Diagonal grid 100x100	D28-04002-270
	1000	200	200	35	Diagonal grid 100x100	D28-04002-271

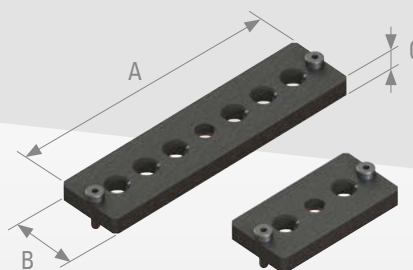
Other dimensions on request

Mounting plate for spacer block U-form

- Mounting plate for spacer block U-form D28-04002-xxx
- For supporting leg attachment PL28-10010-xxx from 1 m length
- incl. 2x fitted shoulder screws M12-16 H8x30

2x fitted bores for fitted shoulder screws

Bore for supporting leg PL28-10010-xxx (page 100) Other bores are D28 system bores



Description ▲

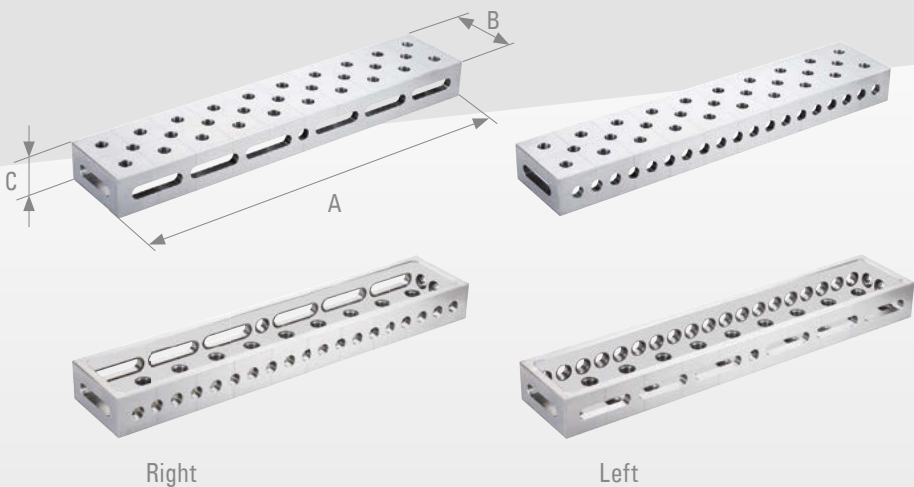
Application ▼



28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	200	100	25	3.6	00060364
	400	100	25	7	00060369

Spacer block C-form, aluminium-titanium

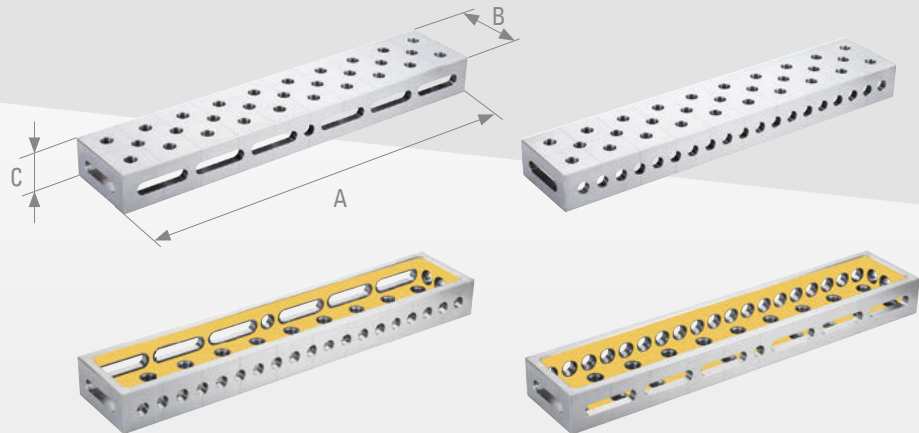
- High-strength aluminium-titanium alloy for approx. 60 % weight reduction
- Approx. 10 % higher bending strength compared to cast iron
- Table extension between two 3D work-tables with the help of D28-06003-000 connecting bolts, permanent screw connection
- Connection of system components
- As table stop
- Continuously adjustable with oblong holes
- Application: 5-sided
- With grid lines



Description ▲

28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	500	200	100	11	Diagonal grid 100x100, left	D28-04003-024
	500	200	100	11	Diagonal grid 100x100, right	D28-04003-025
	1000	200	100	19	Diagonal grid 100x100, left	D28-04003-026
	1000	200	100	19	Diagonal grid 100x100, right	D28-04003-027

- Table extension between two 3D worktables with the help of D28-06003-000 connecting bolts,
- permanent screw connection
- Connection of system components
- As table stop
- Continuously adjustable with oblong holes
- Application: 5-sided
- With grid lines



D28-04003-010
D28-04003-011
Right

D28-04003-002
D28-04003-003
Left

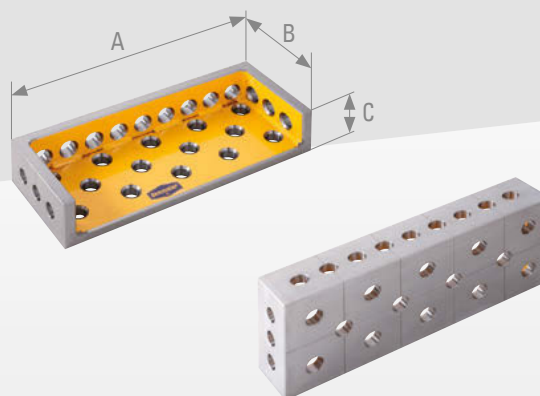
Description ▲

28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	500	200	100	31	Right	D28-04003-010
	500	200	100	31	Left	D28-04003-002
	1000	200	100	58	Right	D28-04003-011
	1000	200	100	58	Left	D28-04003-003

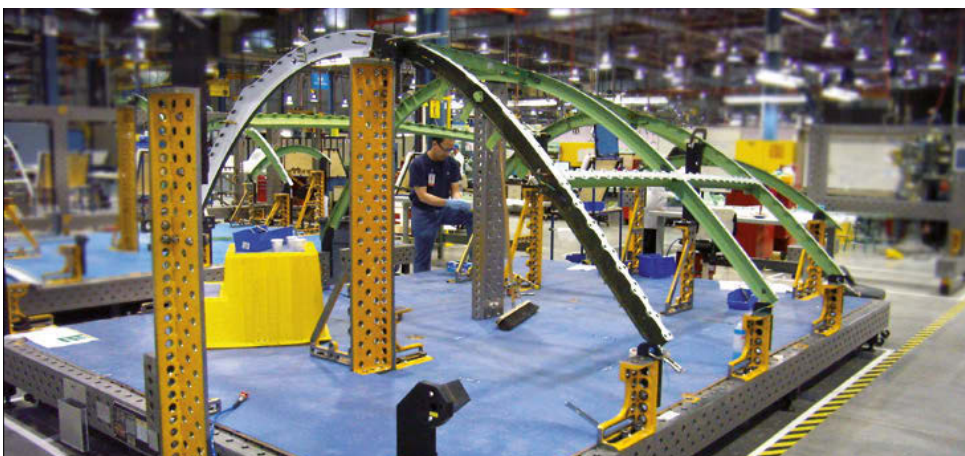
Other dimensions on request

Spacer block L-form

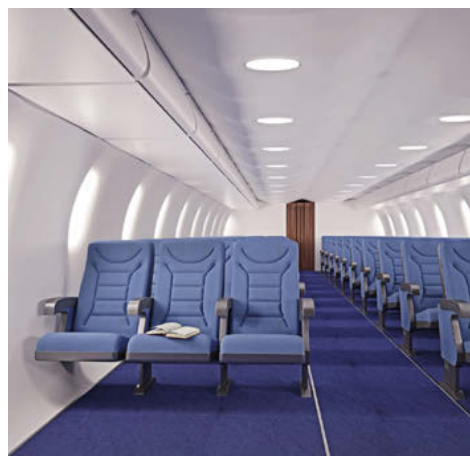
- Table extension / table connection several 3D worktables
- Third axis for expansion as clamping tower or laterally as exact table stop
- Connection of system components
- Application: 4-sided
- Approx. 25 kg per 500 mm
- With grid lines



Description ▲ Application



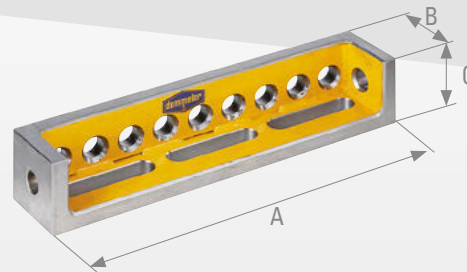
Application ▼



28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	500	200	100	26	Diagonal grid 100x100	D28-04001-000
	1000	200	100	52	Diagonal grid 100x100	D28-04001-001

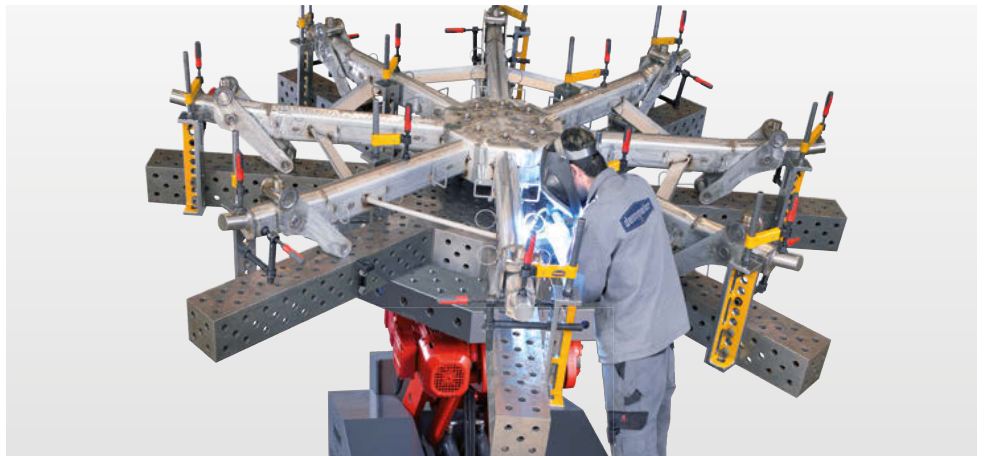
Other dimensions on request

- Used as a bridge between clamping and locating angles or 3D worktables
- As stop-strip or table expansion, 4-sided application
- For use in confined available space
- Numerous application possibilities with system bores and oblong holes
- With grid lines



Description ▲

Application ▼



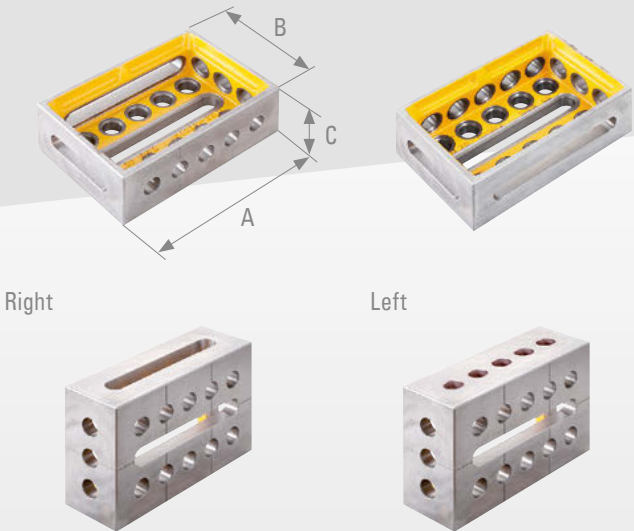
28

A in mm	B in mm	C in mm	~ Weight in kg	Item no.
500	100	100	15	D28-04004-000

Other dimensions on request

Consoles, cast iron

- Five full clamping sides with system bores result in numerous application possibilities
- As connecting elements between various system components
- Highly versatile in combination
 - >> Through system bore
 - >> Variable displacement with oblong hole
- Of one piece for high stability and durability
- Use as console or extension
- Powder-coated
- With grid lines



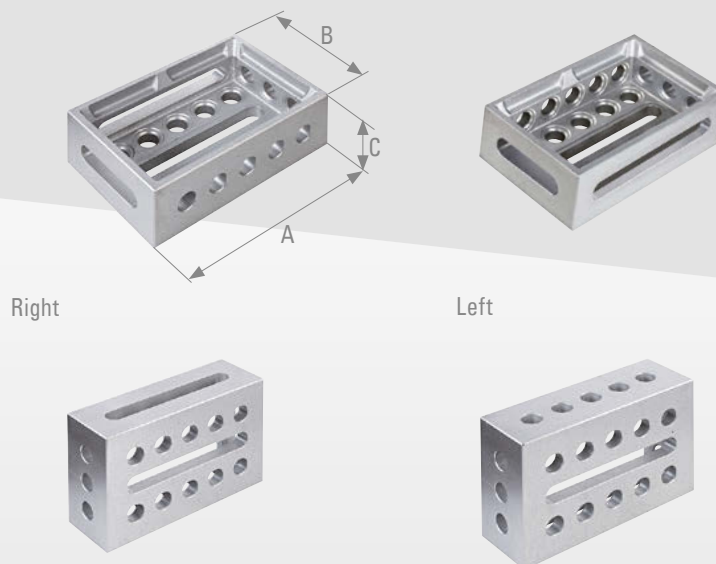
Description ▲

Application ▼



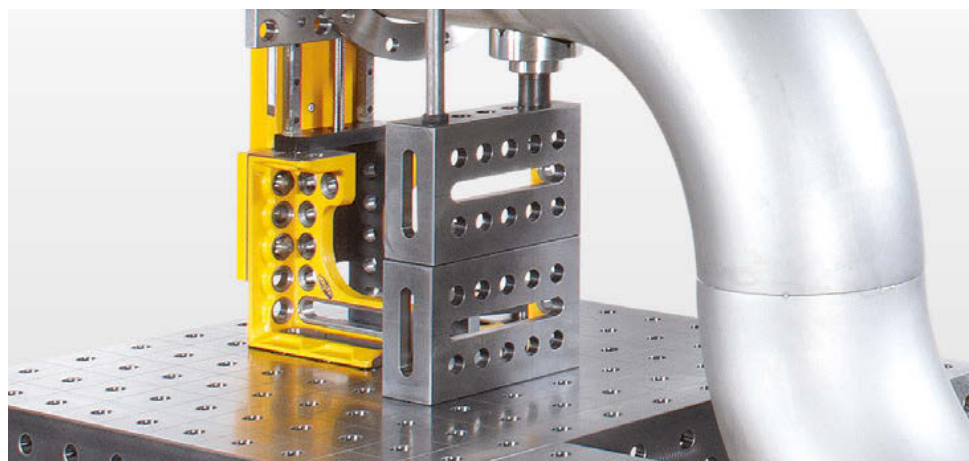
28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	300	200	100	16.00	Right	D28-03005-001
	300	200	100	16.00	Left	D28-03005-004

- High-strength aluminium-titanium alloy for approx. 60 % weight reduction and approx. 10 % higher bending strength compared to cast iron
- Five full clamping sides enable numerous clamping possibilities
- Variable displacement with oblong holes
- Anodised



Description ▲

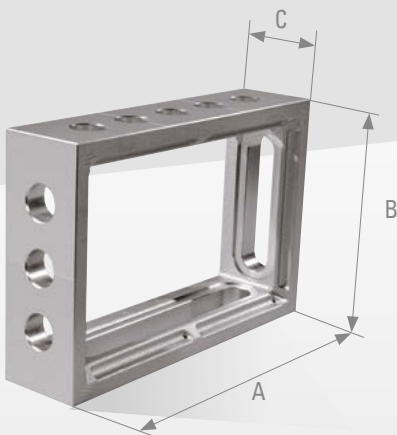
Application ▼



28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	300	200	100	5.80	Right	D28-03005-011
	300	200	100	5.80	Left	D28-03005-012

Console, aluminium-titanium

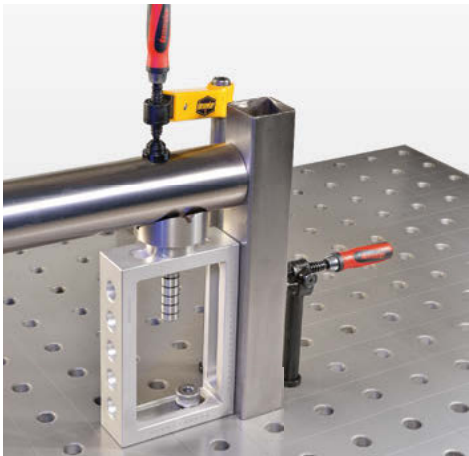
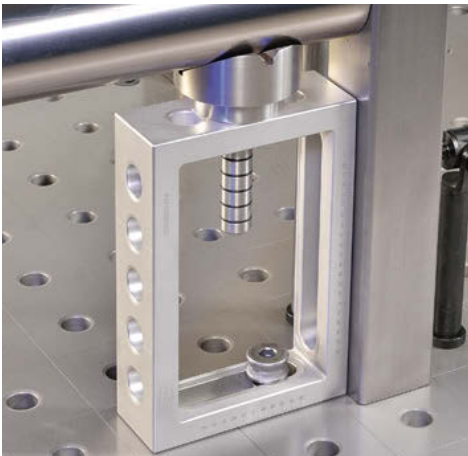
Console in high-strength aluminium-titanium alloy, 4-sided application, 6 sides machined, with oblong hole as well as grid bores both in X-Y direction. Extremely variable. The precision scaling in the X and Y-directions meets all needs.



Description ▲

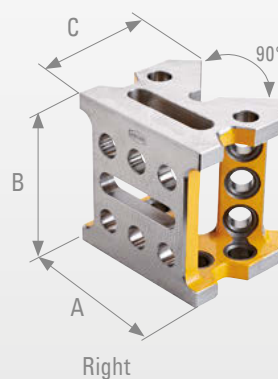
Application ▼

Application ▼



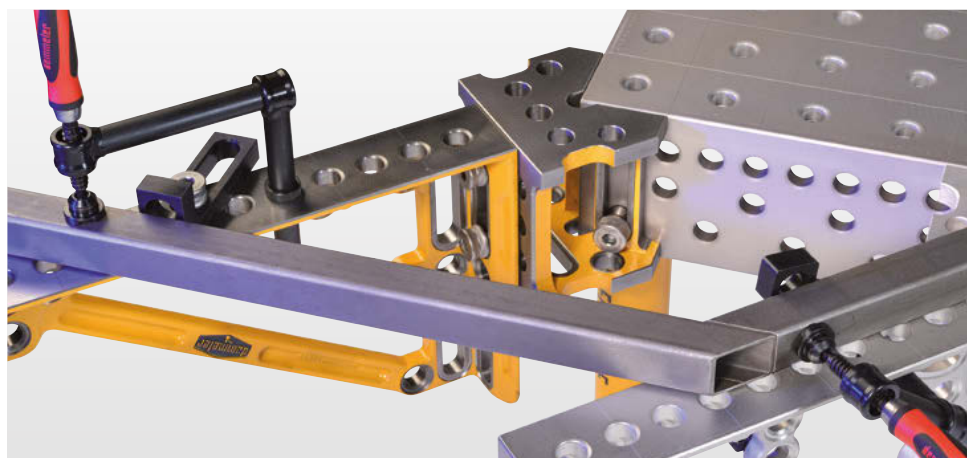
28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	300	200	75	3.1	Right	D28-03005-014

- Diagonal table expansion
- Flexible in application as V-block, support, stop and more



Description ▲

Application ▼

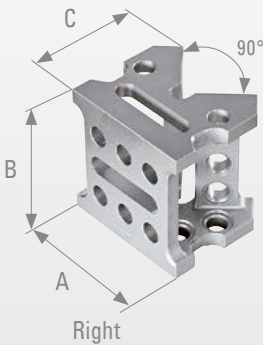


28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	200	200	170	13	Right	D28-04005-000
	200	200	170	13	Left	D28-04005-003

Corner module, aluminium-titanium

Diagonal table expansion

- High-strength aluminium-titanium alloy for approx. 60 % weight reduction and approx. 10 % higher bending strength compared to cast iron
- Diagonal table expansion
- Flexible in application as V-block, support, stop and more



Left

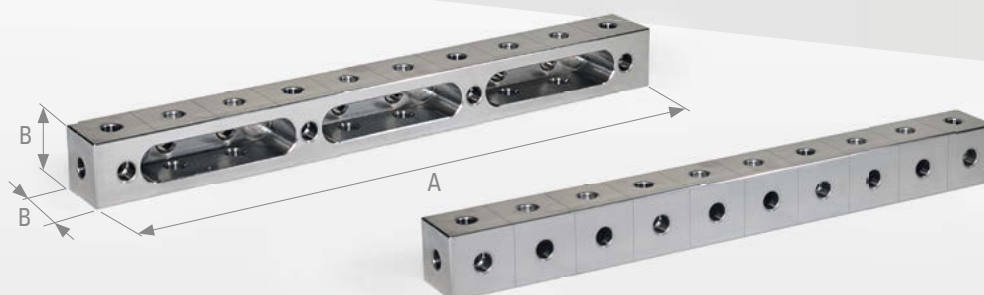
Description ▲ Application ▼



With the DEMMELER corner modules, long profiles and girders can be clamped even on smaller worktables – corner module positioned in the corner and extended with two angles. You get maximum expansion options for clamping.

28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	200	200	170	4.9	Right	D28-04005-004
	200	200	170	4.9	Left	D28-04005-005

- 6 clamping sides
- 3 rows of system bores, 100 x 100 grid
- With grid lines



Description ▲

Versions ▼



28	A in mm	B in mm	~ Weight in kg	Description	Item no.
	1000	100	49	Grid 100 x 100	D28-04010-001
	2000	100	97	Grid 100 x 100	D28-04010-002
	3000	100	145	Grid 100 x 100	D28-04010-003



Clamping and locating angle

Clamping and locating angle overview	212
Clamping and locating angle aluminium-titanium 300	218
Clamping and locating angle aluminium-titanium 600	219
Clamping and locating angle aluminium-titanium 800	220
Clamping and locating angle aluminium-titanium 1200	221
PP Cast angle 300 – hardened Demont 760 M D28	222
PP cast angle 600 – hardened Demont 760 M D28	223
PP Cast angle 800 – hardened Demont 760 M D28	223
Clamping and locating angle aluminium-titanium 300	224
PL clamping and locating angle aluminium-titanium 600	224
Clamping and locating angle aluminium-titanium 800	225
PL clamping and locating angle aluminium-titanium 1200	225
PL clamping and locating angle cast 300 D28	226
PL clamping and locating angle cast 600 D28	227
PL clamping and locating angle cast 800 D28	227
PP clamping and locating angle 2000 D28	228
PE clamping and locating angle casting 600	229
PE clamping and locating angle cast 800 D28	229
Universal pivot and tilt angle D28	230
Universal pivot and tilt angle aluminium-titanium D28	231
Clamping and locating angle small bore / bore D28	233
Clamping and locating angle small bore / oblong hole D28	234
Clamping and locating angle bore / oblong hole D28	235
Clamping and locating angle oblong hole / oblong hole D28	236
Clamping and locating angle bore / bore D28	237
Clamping and locating angle 200 bore / bore / oblong hole D28	238
Clamping and locating angle 300 bore / bore / oblong hole D28	239
Clamping and locating angle 300x250 aluminium-titanium D28	240
Clamping and locating angle large bore / oblong hole D28	242
Angle bracket D28	243
Angle bracket D28	244
Flat angle trim D28	245
Universal stop, small, D28	246
Displacement stop D28	247
EcoLINE universal stop, small, D28	248
EcoLINE universal stop, large, D28	249
Universal stop large with precision scaling D28	250
Universal stop / large D28	251
Universal stop / large with plunger D28	252
Universal stop L 165 / L 300 / L 500 D28	253
Contour stop	254
Stop strip D28	255
Angle-setting template D28	256
Adapter plate D28	257
Locating disk D28	258

Clamping and locating angle overview

28 PROFIPremiumLINE
Clamping and locating angle
aluminium-titanium 300

PAGE 218



28 PROFIPremiumLINE
Clamping and locating angle
aluminium-titanium 600

PAGE 219



28 PROFIPremiumLINE
Clamping and locating angle
aluminium-titanium 800

PAGE 220



28 PROFIPremiumLINE
Clamping and locating angle
aluminium-titanium alloy 1200

PAGE 221



28 PROFIPremiumLINE
Clamping and locating angle
hardened casting 300

PAGE 222



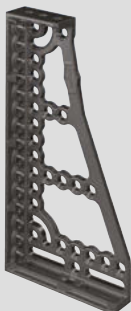
28 PROFIPremiumLINE
Clamping and locating angle
hardened casting 600

PAGE 223



28 PROFIPremiumLINE
Clamping and locating angle
hardened casting 800

PAGE 223



28 PROFIPlusLINE
Clamping and locating angle
aluminium-titanium 300

PAGE 224



28 PROFIPlusLINE
Clamping and locating angle
aluminium-titanium 600

PAGE 224



28 PROFIPlusLINE
Clamping and locating angle
aluminium-titanium 800

PAGE 225



28 PROFIPlusLINE
Clamping and locating angle
aluminium-titanium 1200

PAGE 225



28 PROFIPlusLINE
Clamping and locating angle
hardened casting 300

PAGE 226



- 28** **PROFIPlusLINE**
Clamping and locating angle
hardened casting 600

PAGE 227



- 28** **PROFIPlusLINE**
Clamping and locating angle
hardened casting 800

PAGE 227



- 28** **PROFIPremiumLINE**
Clamping and locating angle 2000

PAGE 228



- 28** **PROFIEcoLINE**
Clamping angle
hardened casting 600

PAGE 229



- 28** **PROFIEcoLINE**
Clamping angle
hardened casting 800

PAGE 229



- 28** **Universal pivot and tilt angle, steel**

PAGE 230



- 28** **Universal pivot and tilt angle aluminium-titanium**

PAGE 231



- 28** **Clamping and locating angle small bore / bore**

PAGE 233



- 28** **Clamping and locating angle small bore / oblong hole**

PAGE 234



- 28** **Clamping and locating angle bore / oblong hole**

PAGE 235



- 28** **Clamping and locating angle oblong hole / oblong hole**

PAGE 236



- 28** **Clamping and locating angle bore / bore**

PAGE 237



Clamping and locating angle overview

28 Clamping and locating angle 200
bore / bore / oblong hole

PAGE 238



28 Clamping and locating angle 300
bore / bore / oblong hole

PAGE 239



28 Clamping and locating angle 300x250
aluminium-titanium

PAGE 240



28 Clamping and locating angle, large
bore / oblong hole

PAGE 242



28 Angle bracket

PAGE 243



28 Angle bracket

PAGE 244



28 Flat angle trim

PAGE 245



28 Universal stop small

PAGE 246



28 Displacement stop

PAGE 247



28 EcoLINE universal stop small

PAGE 248



28 EcoLINE universal stop large

PAGE 249



28 Universal stop large
with precision scaling

PAGE 250



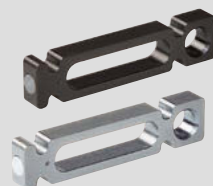
28 Universal stop large

PAGE 251



28 Universal stop large with plunger

PAGE 252



28 Universal stop L 165 / L 300 / L 500

PAGE 253



28 Contour stop

PAGE 254



28 Stop-strip

PAGE 255



28 Angle-setting template

PAGE 256



28 Adapter plate

PAGE 257



28 Locating disk

PAGE 258



PP ⇄ PL ⇄ PE = 100% compatible

Thus, for example, a PP angle can be used on a PE table.

Clamping and locating angle

Work can be so easy!





Work can be so easy!

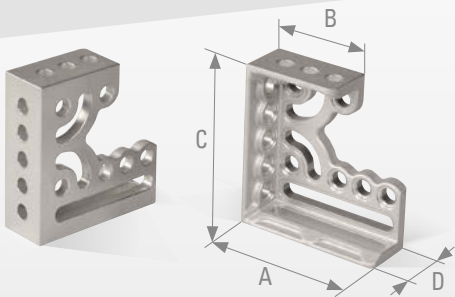
As a stop, table expansion or to secure angled work pieces at 90° – the new series of PROFIPremiumLINE angles with their unique grooves in a 90° kidney shape expands the application possibilities several times over. With the new design, stability was increased by up to 40 % depending on the loading case. With the integrated system bores in the size 50 grid on all faces and the extended face plate, all requirements are covered. Extremely lightweight yet sturdy implementation in aluminium-titanium alloy.

- Reinforcement in the corners with 90° system groove in kidney shape supports continuously variable use, also with angular adjustment
- Improved rigidity
- Higher number of cross braces with bores
- Extended face plate with additional bore
- 50 mm bore hole grid on all faces

Clamping and locating angle aluminium-titanium 300

PROFIPremiumLINE

- Reinforcement in the corners with 90° system groove in kidney shape supports continuously variable use, also with angular adjustment
- 40% better rigidity
- Extended face plate with additional bore
- 50 mm bore hole grid on all faces
- 4 stop faces / usable surfaces
- D28 bore hole grid with 50 mm spacing
- 2x system groove 200 mm
- 2x system groove in 90° kidney shape
- With precision scaling
- Anodised



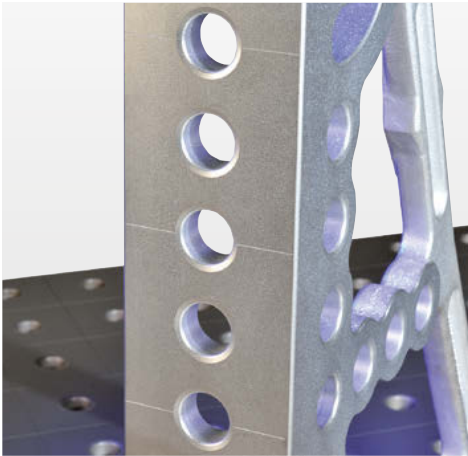
Right
P28-03002-002

Left
P28-03002-003

Description ▲ Application ▼	Application ▼	Protective countersink ▼
-----------------------------	---------------	--------------------------



1 mm precision scaling



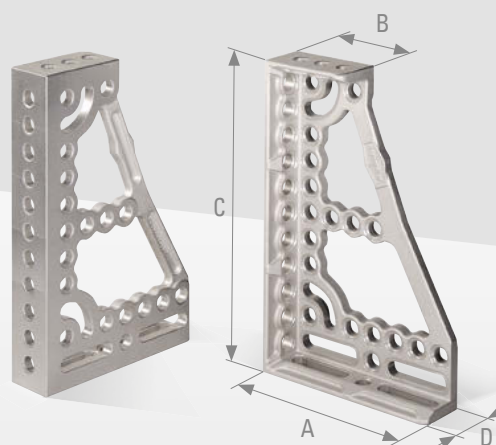
With grid lines



Optimum bolt and clamp insertion with simultaneous protection of the tabletop against damage from materials, even in case of extreme strain on the system bore or when used with aluminium.

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	275	180	300	100	5	Right	P28-03002-002
	275	180	300	100	5	Left	P28-03002-003

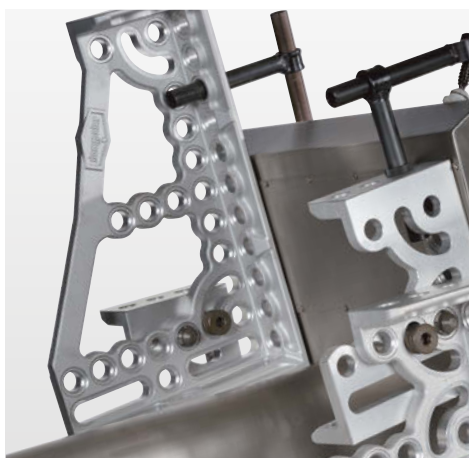
- Reinforcement in the corners with 90° system groove in kidney shape supports continuously variable use, also with angular adjustment
- 40% better rigidity
- Higher number of cross braces with bores
- Extended face plate with additional bore
- 50 mm bore hole grid on all faces
- 4 stop faces / usable surfaces
- D28 bore hole grid with 50 mm spacing
- 4x system groove 100 mm
- 2x system groove in 90° kidney shape
- With precision scaling
- Anodised



Right
P28-03003-002

Left
P28-03003-003

Description ▲ Application ▼



Application ▼

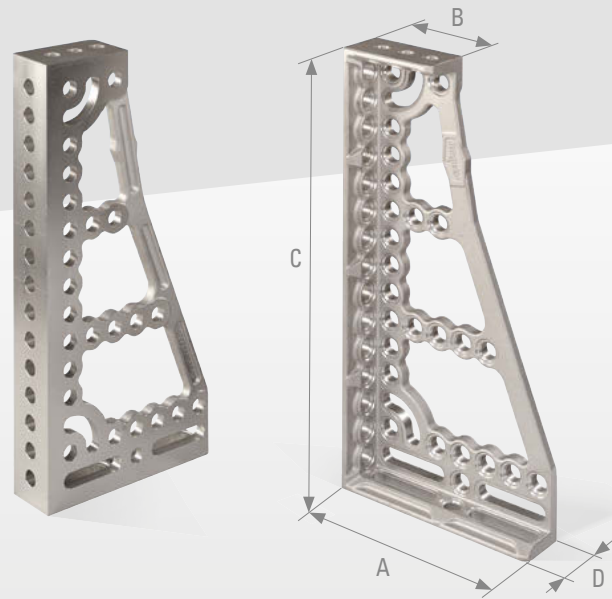


Application ▼



28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	375	180	600	100	9.3	Right	P28-03003-002
	375	180	600	100	9.3	Left	P28-03003-003

- Reinforcement in the corners with 90° system groove in kidney shape supports continuously variable use, also with angular adjustment
- 40% better rigidity
- Higher number of cross braces with bores
- Extended face plate with additional bore
- 50 mm bore hole grid on all faces
- 4 stop faces / usable surfaces
- D28 bore hole grid with 50 mm spacing
- 4x system groove 100 mm
- 2x system groove in 90° kidney shape
- With precision scaling
- Anodised

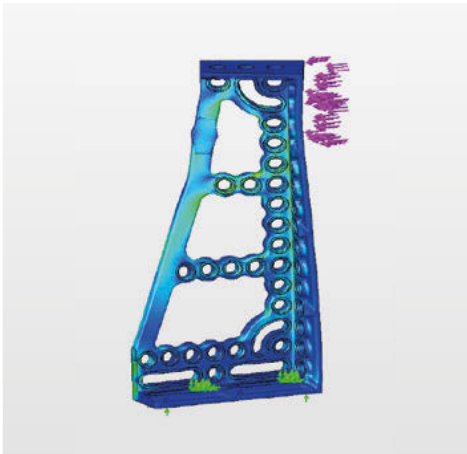


Right
P28-03004-000

Left
P28-03004-001

Description ▲

Application ▼

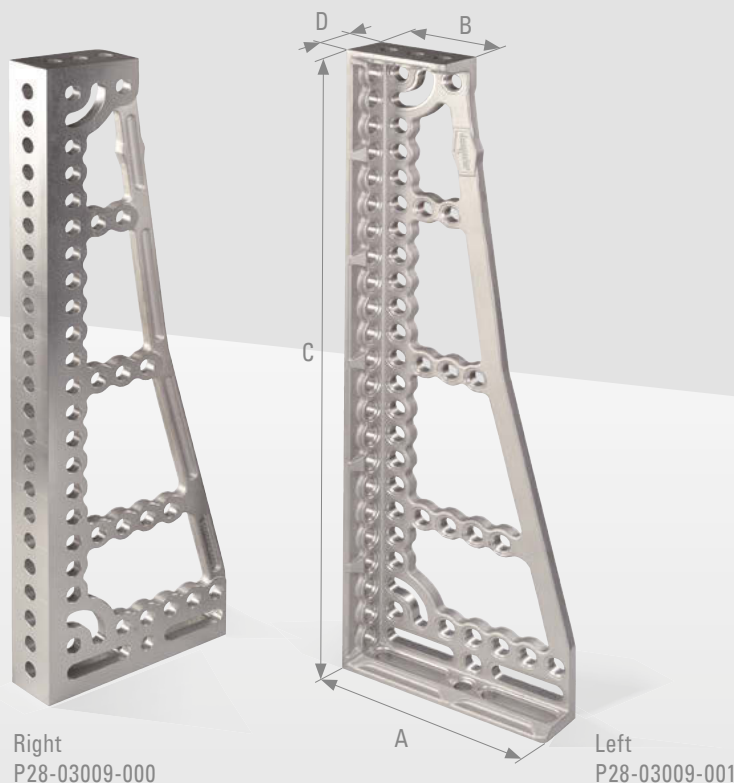


Dimensioned with highly modern finite element calculation with up to 40 % increased rigidity.



28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	375	180	800	100	11.5	Right	P28-03004-000
	375	180	800	100	11.5	Left	P28-03004-001

- Reinforcement in the corners with 90° system groove in kidney shape supports continuously variable use, also with angular adjustment
- 40% better rigidity
- Higher number of cross braces with bores
- Extended face plate with additional bore
- 50 mm bore hole grid on all faces
- 4 stop faces / usable surfaces
- D28 bore hole grid with 50 mm spacing
- 4x system groove 100 mm
- 2x system groove in 90° kidney shape
- With precision scaling
- Anodised



Description ▲ Application ▼

Application ▼



28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	375	180	1200	100	15.3	Right	P28-03009-000
	375	180	1200	100	15.3	Left	P28-03009-001

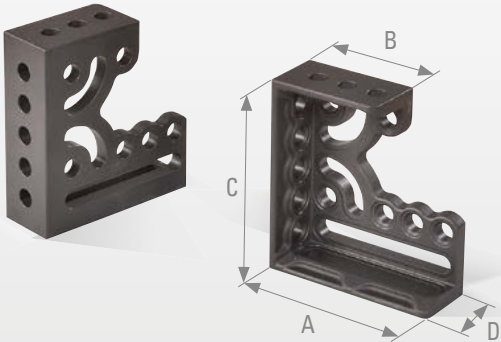
Clamping and locating angle hardened casting 300

PROFIPremiumLINE



As a stop, table expansion or to secure angled work pieces at 90° – the new generation of PROFIPremiumLINE angles with their unique grooves in a 90° kidney shape expands the application possibilities several times over. With the new design, stability was increased by up to 40 % depending on the loading case.

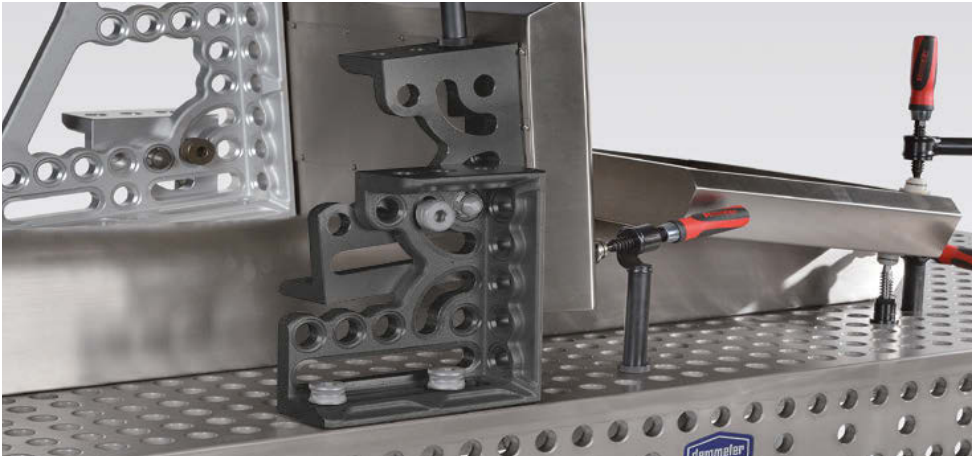
With the integrated system bores in the size 50 grid on all faces and the extended face plate, all requirements are covered. High-quality casting material available in DEMONT 760 M. With precision scaling.



Right
P28-03002-000

Left
P28-03002-001

Description ▲ Application ▼



28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	275	180	300	100	13.3	Right	P28-03002-000
	275	180	300	100	13.3	Left	P28-03002-001

Clamping and locating angle casting hardened 600

Clamping and locating angle hardened casting 800

PROFIPremiumLINE



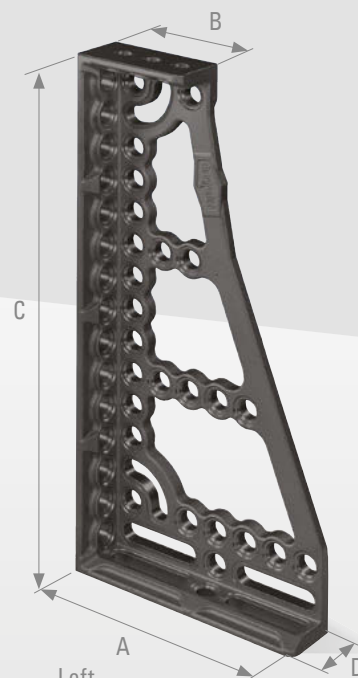
Right
P28-03003-000



Left
P28-03003-001



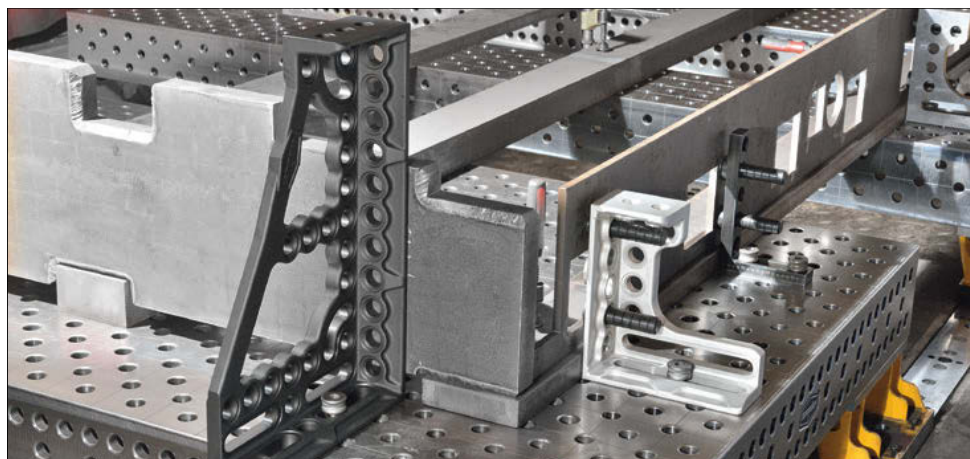
Right
P28-03004-002



Left
P28-03004-003

Application ▼

Application ▼



Clamping and locating angle 600

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	375	180	600	100	25	Right	P28-03003-000
	375	180	600	100	25	Left	P28-03003-001

Clamping and locating angle 800

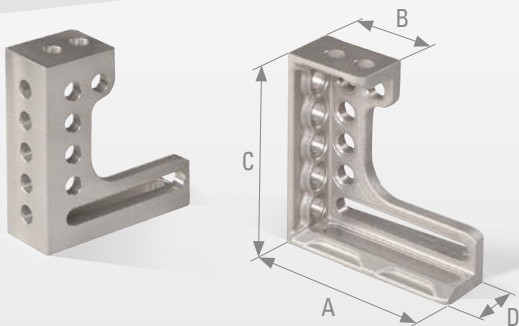
28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	375	180	800	100	30.7	Right	P28-03004-002
	375	180	800	100	30.7	Left	P28-03004-003

Clamping and locating angle aluminium-titanium 300

Clamping and locating angle aluminium-titanium 600

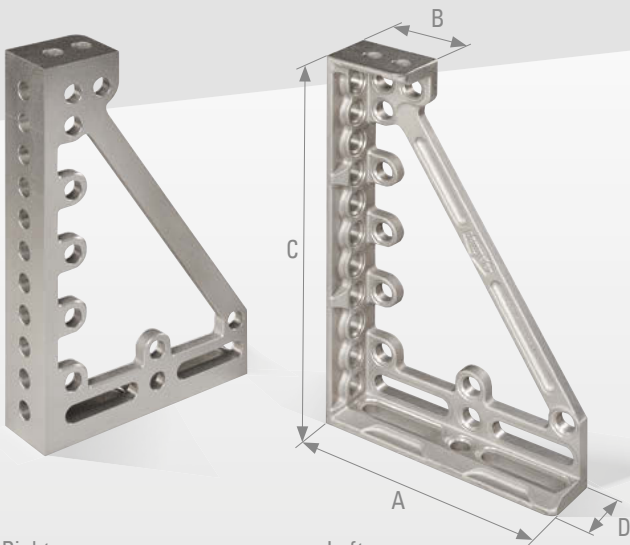
PROFIPlusLINE

- High-strength aluminium-titanium alloy for ~ 60 % weight reduction and ~ 10 % higher bending strength
- Very easy to handle compared to cast iron
- Ordering in pairs (left and right) is recommended
- With precision scaling
- Anodised



Right
PL28-03002-010

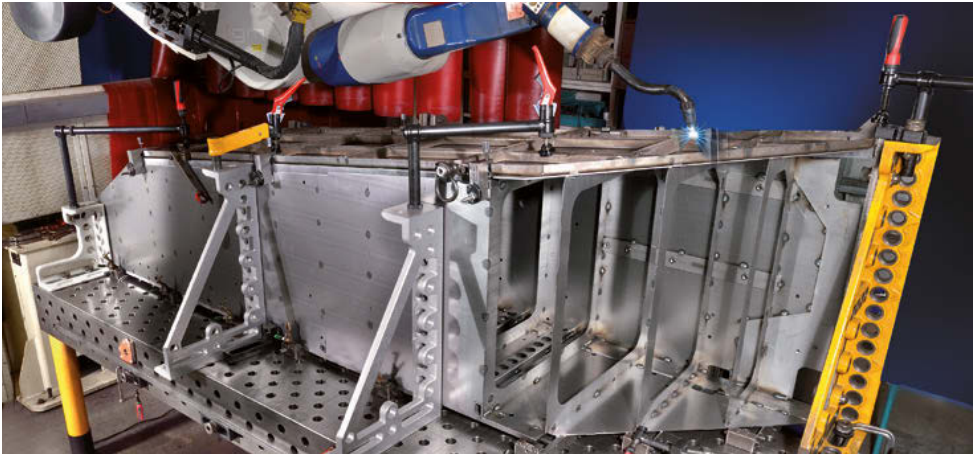
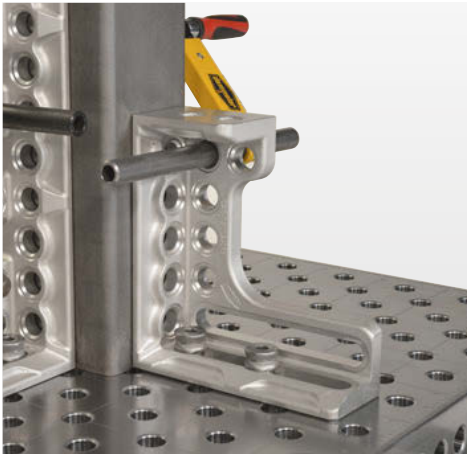
Left
PL28-03002-011



Right
PL28-03003-022

Left
PL28-03003-023

Description ▲	Application ▼	Application ▼
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Clamping and locating angle aluminium-titanium 300

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	275	130	300	100	4.2	Right	PL28-03002-010
	275	130	300	100	4.2	Left	PL28-03002-011

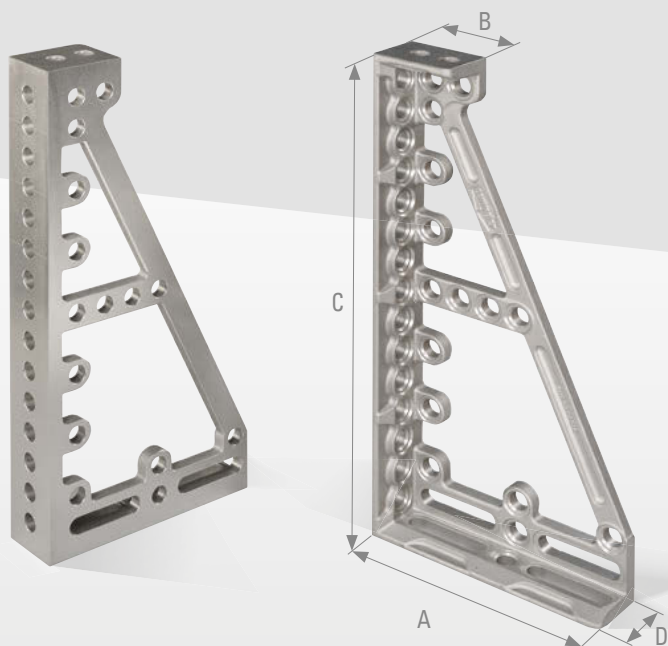
Clamping and locating angle aluminium-titanium 600

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	375	130	600	100	7.5	Right	PL28-03003-022
	375	130	600	100	7.5	Left	PL28-03003-023

Clamping and locating angle aluminium-titanium 800

Clamping and locating angle aluminium-titanium 1200

PROFIPlusLINE



Right
PL28-03004-014

Left
PL28-03004-015



Right
PL28-03009-000

Left
PL28-03009-001

Application ▼

Application ▼



Clamping and locating angle aluminium-titanium 800

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	375	130	800	100	9.5	Right	PL28-03004-014
	375	130	800	100	9.5	Left	PL28-03004-015

Clamping and locating angle aluminium-titanium 1200

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	375	130	1200	100	14	Right	PL28-03009-000
	375	130	1200	100	14	Left	PL28-03009-001

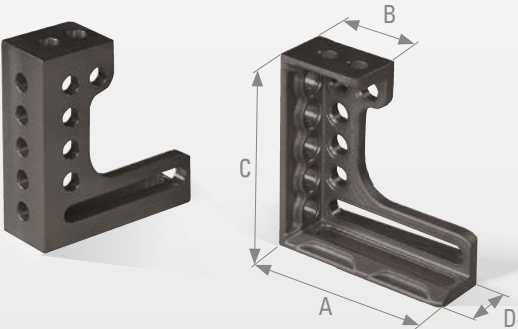
Clamping and locating angle hardened casting 300

PROFIPlusLINE



DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Continuous adjustment and locking
- Three full clamping sides with system bores
- With oblong holes for continuous adjustment
- Incl. precision scaling to adjust the stop dimensions
- Improved sliding behaviour through the combination of cast iron on steel
- Grid lines reduce the setup time
- With face plate for additional superstructures
- Hardened casting: ultimate stability and ductility
- For use e.g. as a tall stop or table extension
- Ordering in pairs is recommended
- with precision scaling and clamping strip
- With grid lines

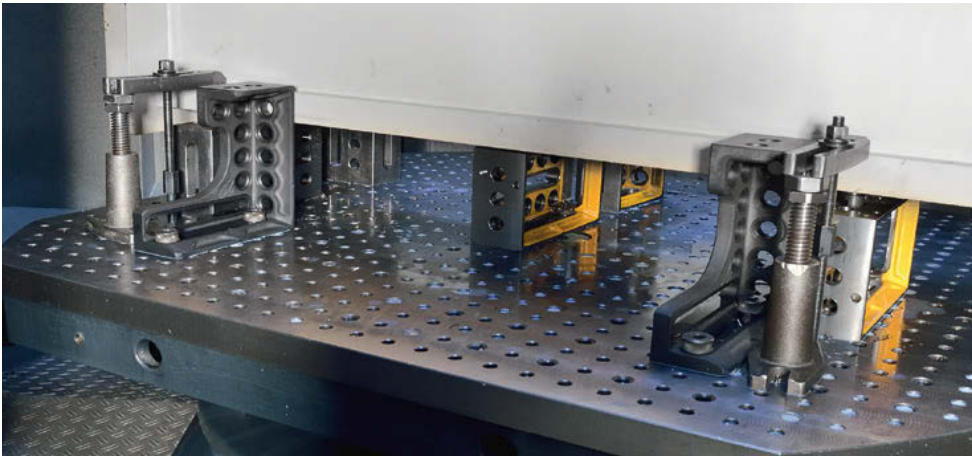


Right
PL28-03002-000

Left
PL28-03002-001

Description ▲

Application ▼



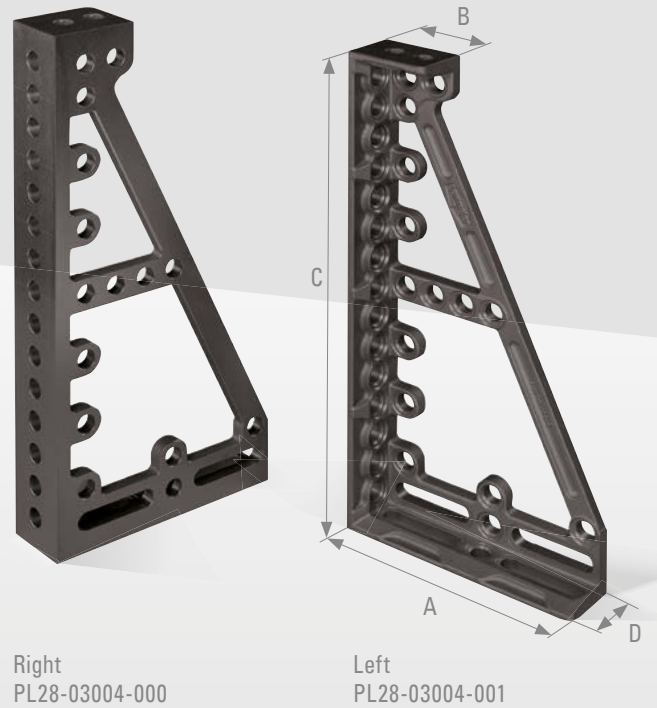
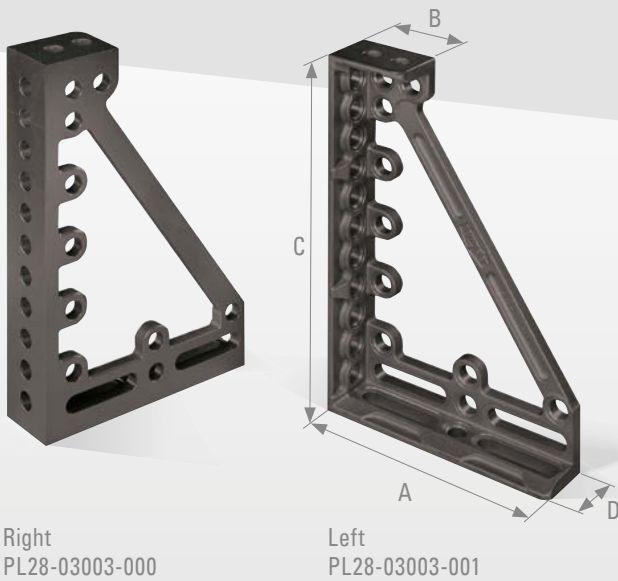
Clamping and locating angle 300

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	275	130	300	100	11.4	Right	PL28-03002-000
	275	130	300	100	11.4	Left	PL28-03002-001

Clamping and locating angle casting hardened 600

Clamping and locating angle casting hardened 800

PROFIPlusLINE



Clamping and locating angle 600

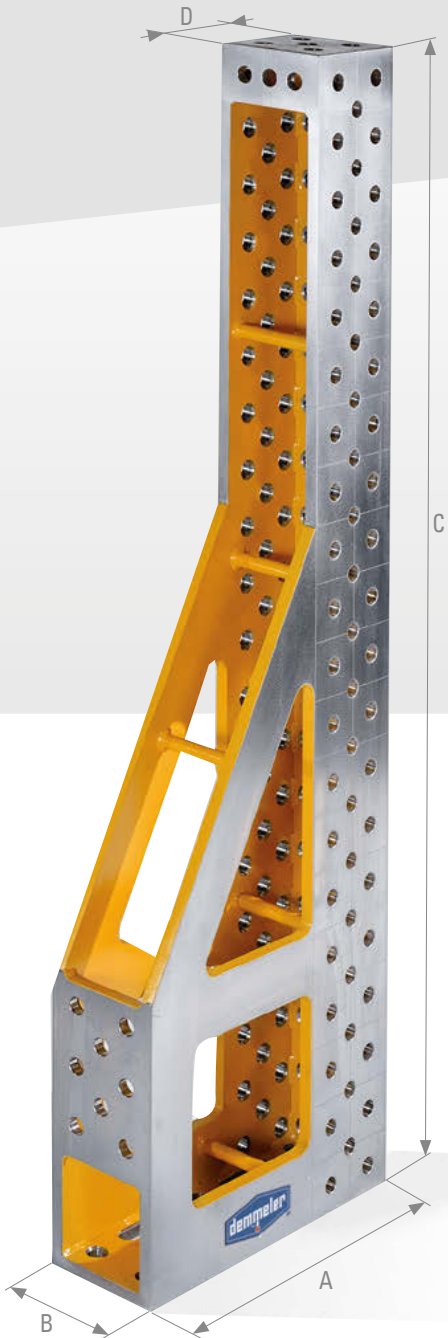
28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	375	130	600	100	19.9	Right	PL28-03003-000
	375	130	600	100	19.9	Left	PL28-03003-001

Clamping and locating angle 800

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	375	130	800	100	24.5	Right	PL28-03004-000
	375	130	800	100	24.5	Left	PL28-03004-001

For very large and heavy applications, extremely sturdy version with system bores on all sides in double 100 size grid.

Description ▲ Application ▼



28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	600	200	2000	200	272	D28-50099-008
Other dimensions on request						

Clamping and locating angle hardened casting 600

Clamping and locating angle casting hardened 800



DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

PROFIEcoLINE



Right
PE28-03003-000

Left
PE28-03003-001



Right
PE28-03004-000

Left
PE28-03004-001

Description ▼

- ECO series - Reduced to the essentials, yet tremendously flexible. Designed for all common stop and clamping applications with system bores in a size 50 grid and 3 usable stop faces, yet truly affordable. The solution for anyone who just doesn't need more.
- Hardened casting
- Cost-effective version
- Three supporting surfaces
- With precision scaling
- In the face plate

PROFIEcoLINE clamping and locating angle hardened casting 600

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	275	190	600	80	19	Right	PE28-03003-000
	275	190	600	80	19	Left	PE28-03003-001

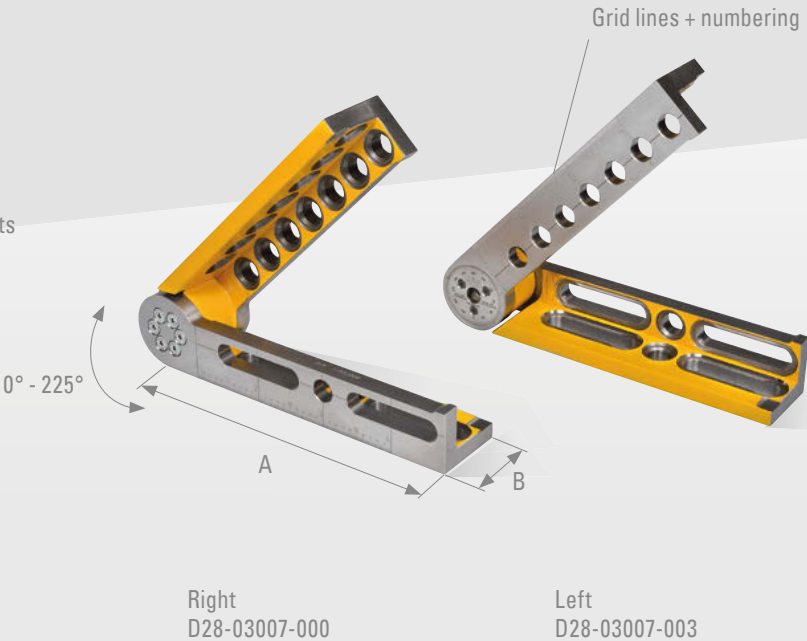
PROFIEcoLINE clamping and locating angle hardened casting 800

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	275	190	800	80	24	Right	PE28-03004-000
	275	190	800	80	24	Left	PE28-03004-001

Universal pivot and tilt angle

Continuous tilt from 0° to 225°

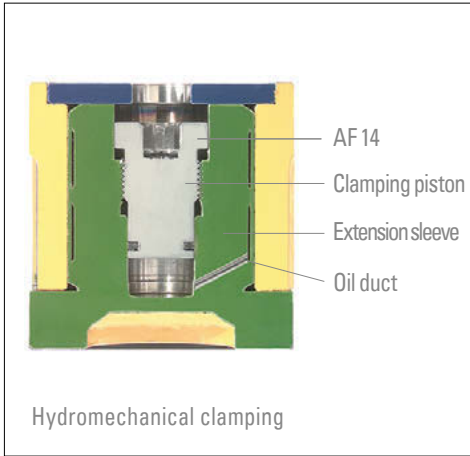
- Continuously adjustable from 0° to 225° with precision scaling
- Hydromechanical clamping:
 - >> absolutely maintenance-free
 - >> Holding force up to 1600 Nm torque
- Can be combined with other system components
- Horizontal and vertical use possible
- Powder-coated
- With precision scaling



Description ▲

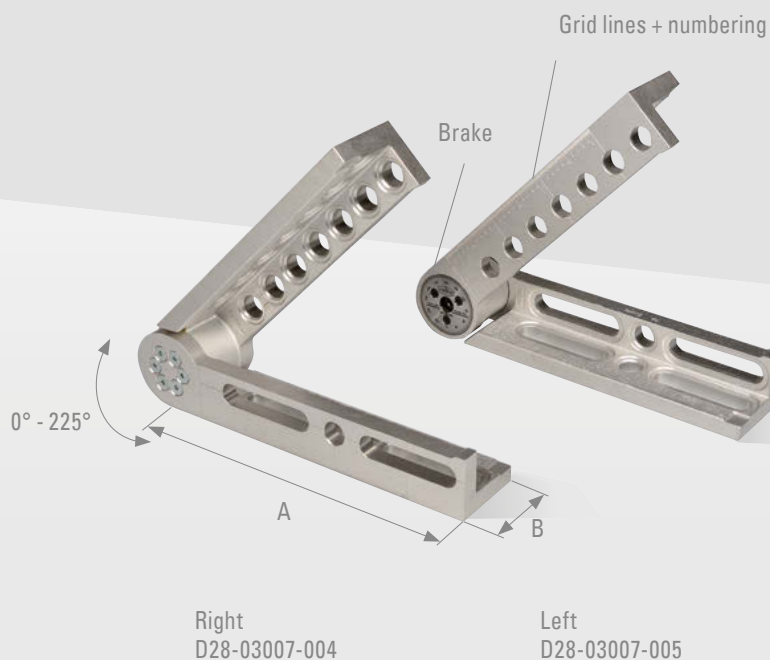
Sectional view ▼

Application ▼



28	A in mm	B in mm	~ Weight in kg	Description	Item no.
	425	100	22	Right	D28-03007-000
	425	100	22	Left	D28-03007-003

- High-strength aluminium-titanium alloy for approx. 60 % weight reduction and approx. 10 % higher bending strength compared to cast iron
- Continuously adjustable from 0° to 225° with precision scaling
- Hydromechanical clamping:
 >> absolutely maintenance-free
 >> Holding force up to 1600 Nm torque
- Can be combined with other system components
- Horizontal and vertical use possible
- Anodised
- With precision scaling



Description ▲ Application ▼

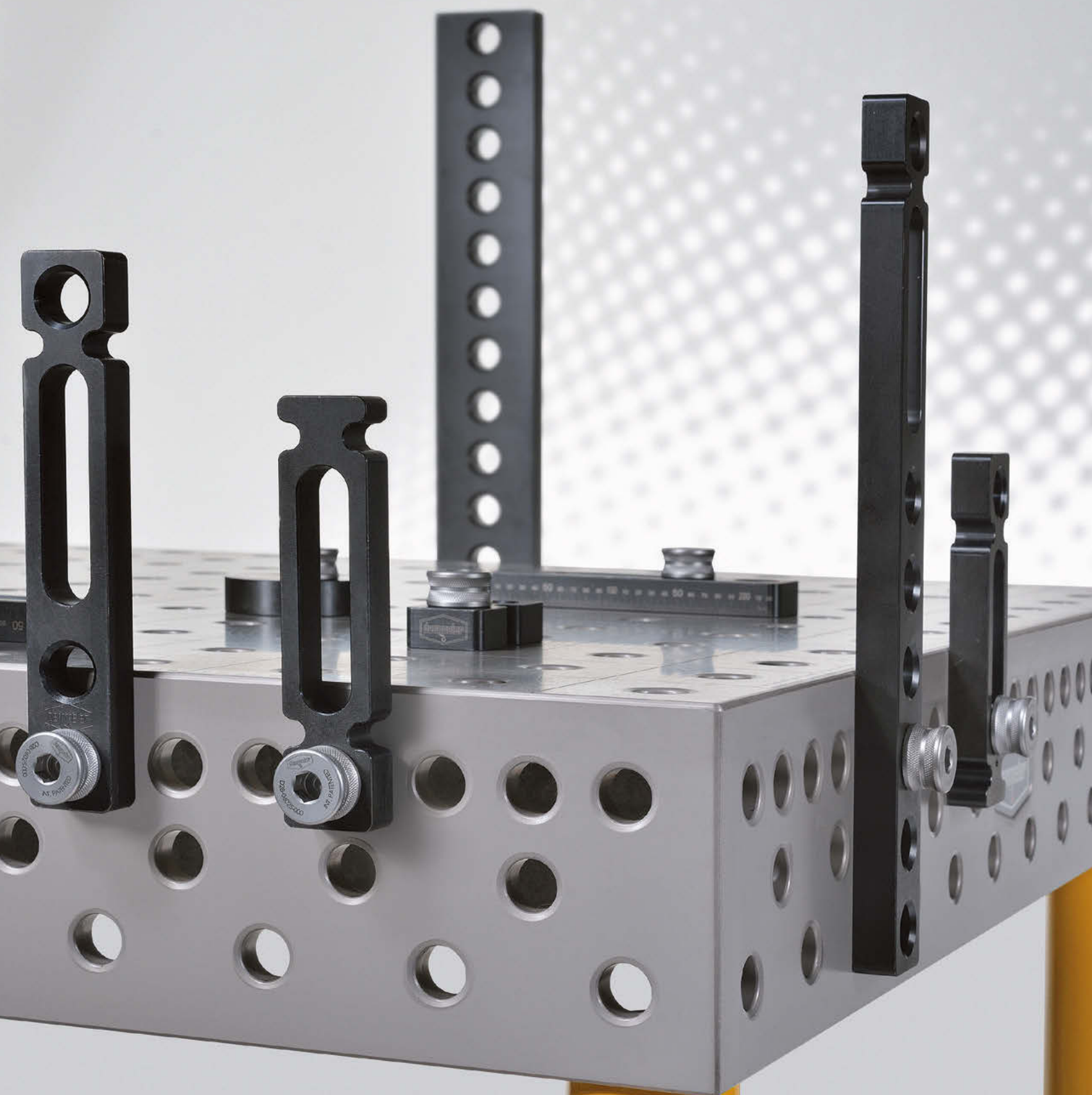
Application ▼



With 1° precision scaling



28	A in mm	B in mm	~ Weight in kg	Description	Item no.
	425	100	9	Right	D28-03007-004
	425	100	9	Left	D28-03007-005

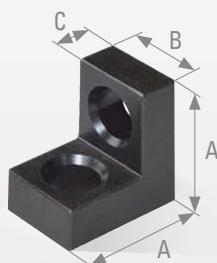




DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

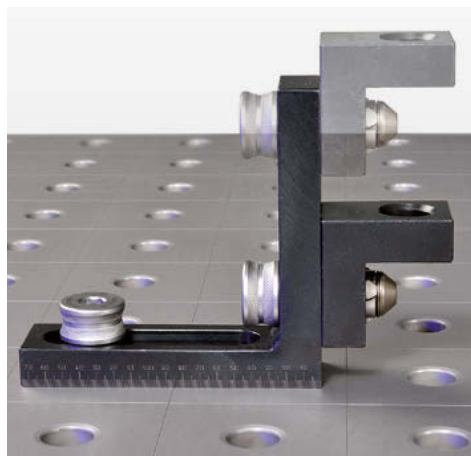
PROFIPlusLINE

- Ideal for confined spaces
- Continuously adjustable support surfaces e.g. in combination with D28-03001-003 (page 236)
- Steel, hardened



Description ▲ Application ▼

Application ▼



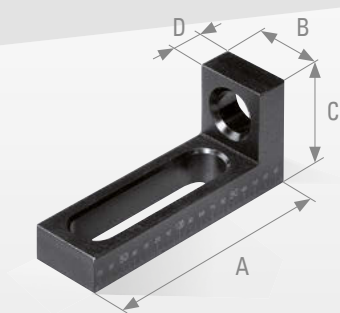
28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	75	50	25	0.98	Steel, hardened	D28-03001-008

Clamping and locating angle small bore / oblong hole

PROFIPlusLINE



- Dimension adjustment using grid lines on 3D worktable possible
- Continuous adjustment and locking via oblong hole
- Ideal for confined spaces
- Combination bore / oblong hole
- Steel, hardened
- Precision scaling on both sides



Description ▲

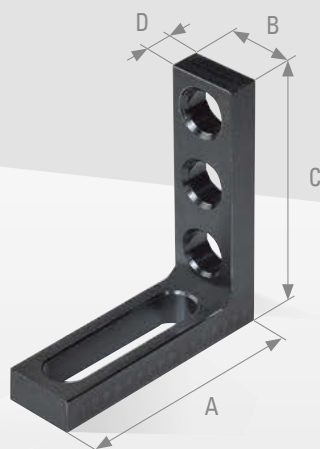
Application ▼



Exact adjustment with precision scaling

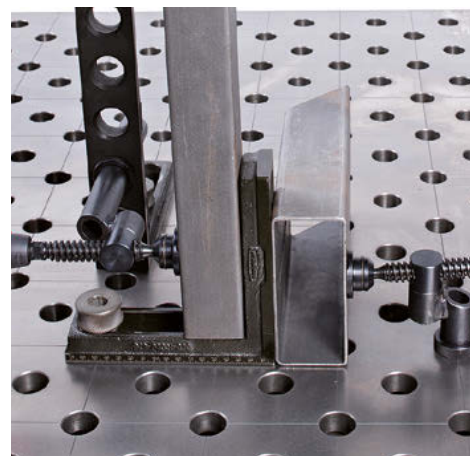
28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	175	50	75	25	1.40	Steel, hardened	D28-03001-005

- Combination system bores / oblong hole for numerous clamping possibilities
- Hardened casting
- Two full angle surfaces, therefore can be used from both sides
- Dimension adjustment using grid lines on 3D worktable possible
- Compatible with all clamping and locating angles so that the oblong hole can be used to form a height-adjustable support
- Precision scaling on both sides



Description ▲ Application ▼

Application ▼



Two full angle surfaces - therefore usable on both sides

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	175	50	175	25	1.8	Hardened casting	PE28-03001-000

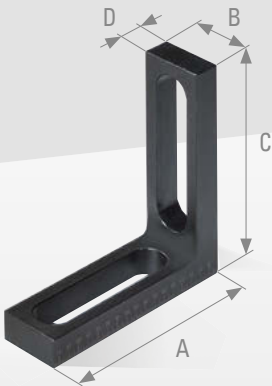
Clamping and locating angle oblong hole / oblong hole

PROFIPlusLINE

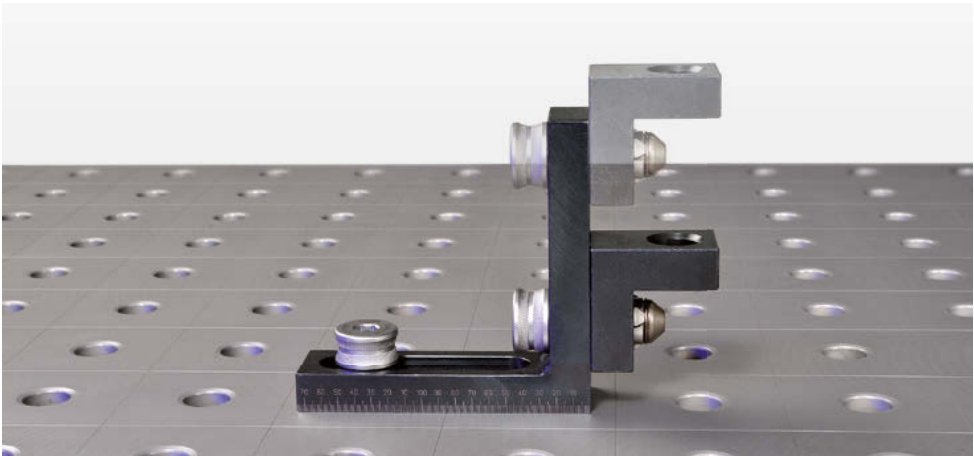


DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Dimension adjustment using grid lines on 3D worktable possible
- Continuous adjustment and locking
- Ideal for confined spaces
- Hardened casting
- Precision scaling on both sides

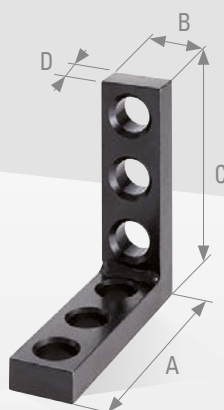


Description ▲ Application ▼ Application ▼



28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	175	50	175	25	1.5	Hardened casting	D28-03001-003

- Dimension adjustment using grid lines on 3D worktable possible
- Ideal for confined spaces
- Hardened casting
- Precision scaling on both sides



Description ▲ Application ▼

Application ▼



28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	175	50	175	25	2.1	Hardened casting	D28-03001-004

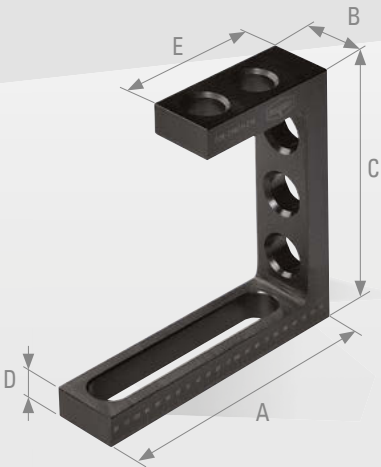
Clamping and locating angle 200 bore / bore / oblong hole

PROFIPlusLINE



DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Extended face plate with two bores in the face plate
- Extended mounting plate with oblong hole 150 – therefore moveable on 50 mm grid
- Precision scaling on both sides
- Hardened casting



Description ▲▼

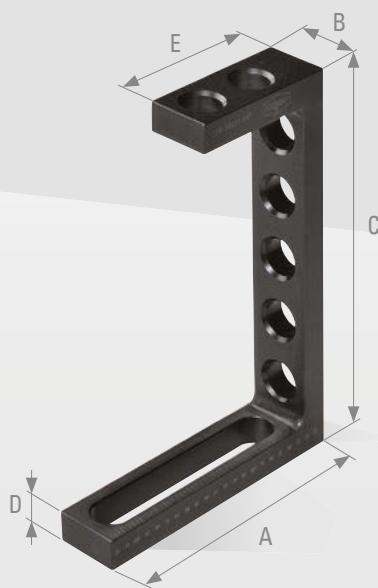
Double bore in size 50 grid on the face plate and mounting plate with 150 mm oblong hole. This makes it possible to change the angle using the oblong hole without changing holes. The precision scaling on both sides makes adjustment much easier.

Application ▼



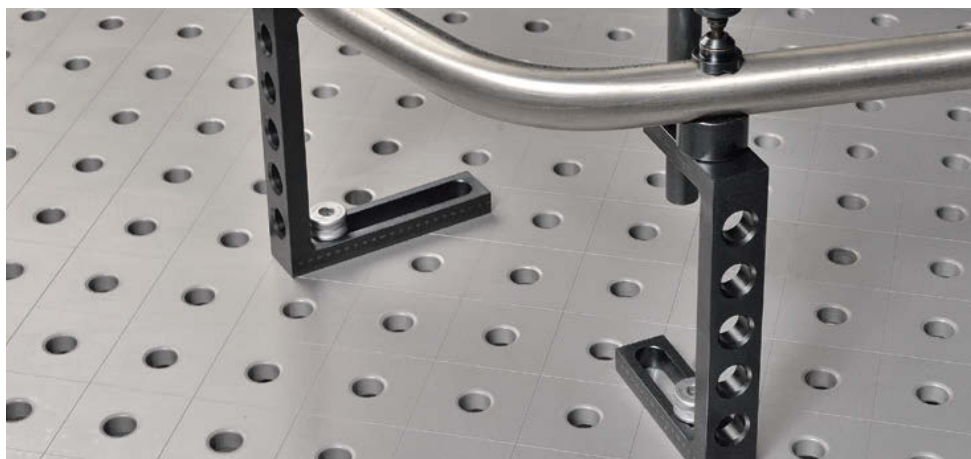
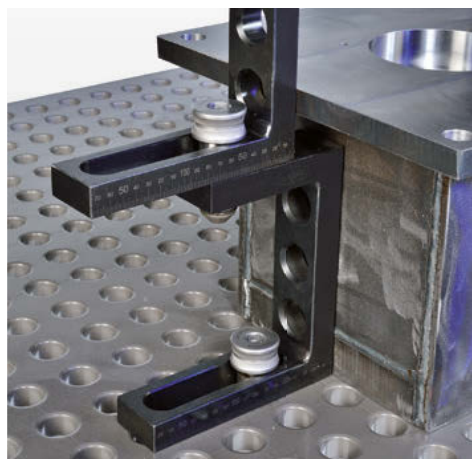
28	A in mm	B in mm	C in mm	D in mm	E in mm	~ Weight in kg	Description	Item no.
	225	50	200	25	125	2.8	Hardened casting	PL28-03001-015

- Extended face plate with two bores in the face plate
- Mounting plate with oblong hole 100
- Precision scaling on both sides
- Hardened casting



Description ▲ Application ▼

Application ▼



28	A in mm	B in mm	C in mm	D in mm	E in mm	~ Weight in kg	Description	Item no.
	175	50	300	25	125	3.2	Hardened casting	PL28-03001-016

Clamping and locating angle 300x250 aluminium-titanium

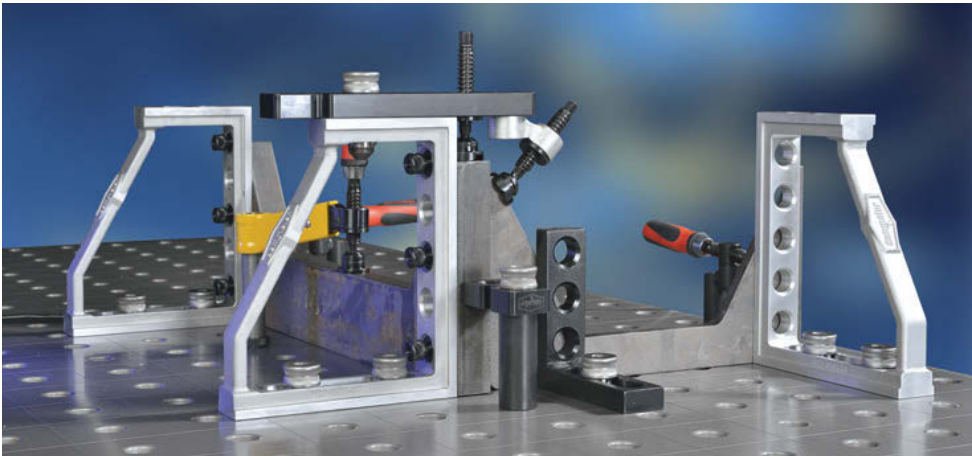
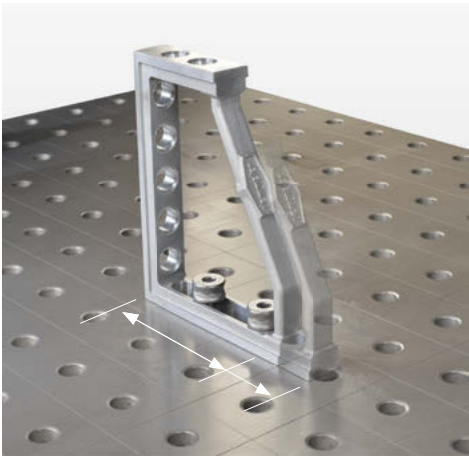
PROFIPlusLINE

- Extended face plate with two bores in the face plate
- Extended mounting plate with oblong hole 150 – therefore moveable on 50 mm grid
- With precision scaling

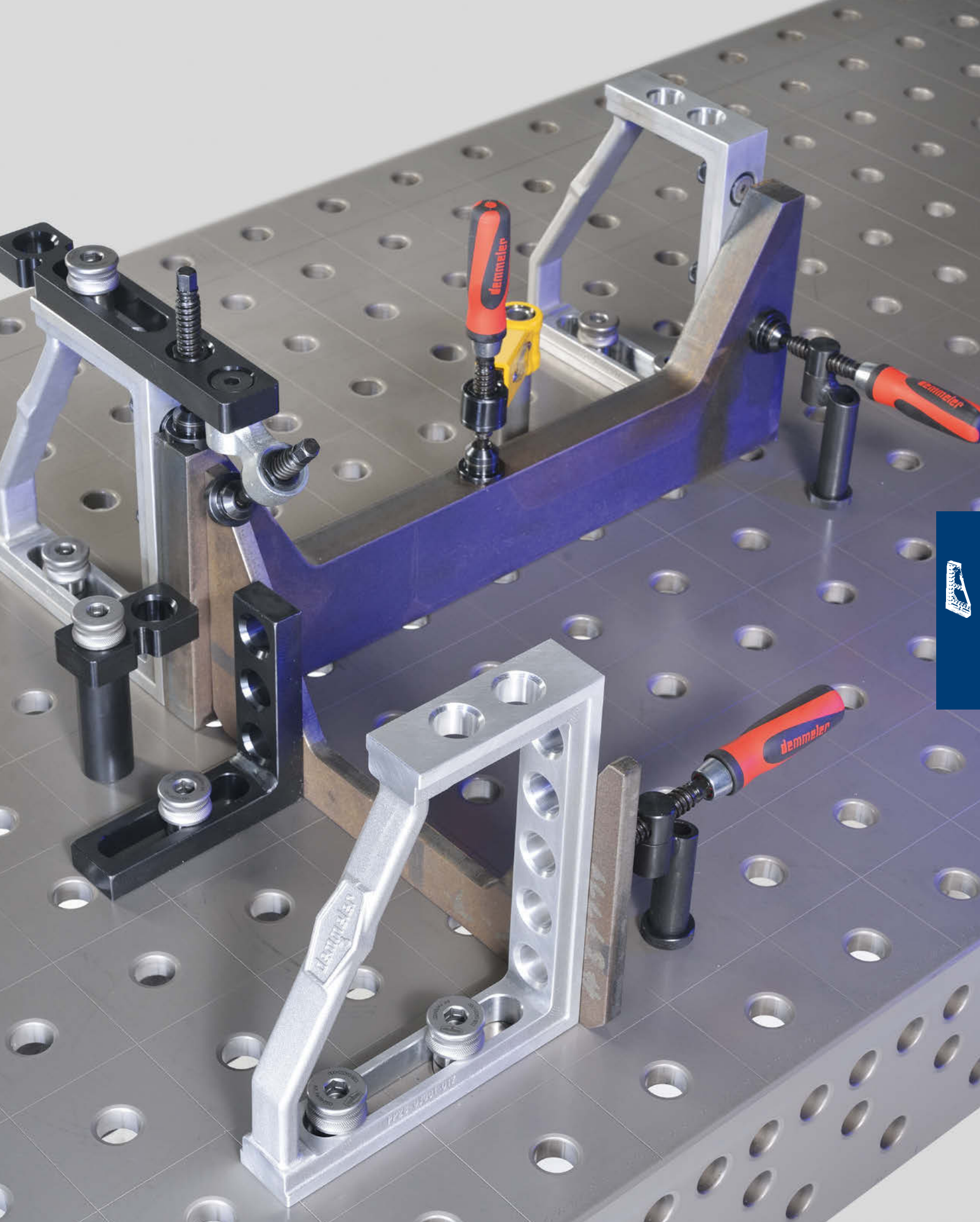


Description ▲ Application ▼

Application ▼



28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	250	50	300	150	1.8	PP28-03001-017



Clamping and locating angle large bore / oblong hole

PROFIEcoLINE

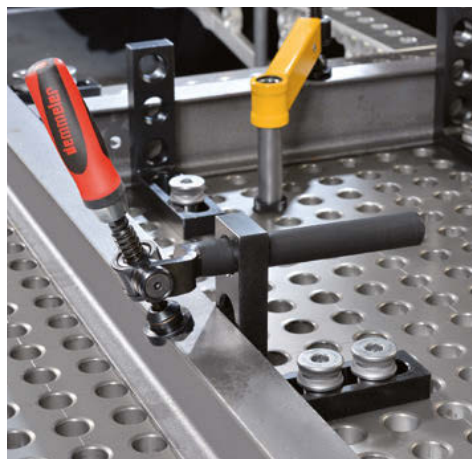

DEMONT 760 M
BLACK EDITION
 THE NEW HARDNESS

- Combination system bores / oblong hole for numerous clamping possibilities
- Precision scaling on both sides
- Two full angle surfaces, therefore can be used from both sides
- Dimension adjustment using grid lines on 3D worktable possible
- Compatible with all clamping and locating angles so that the oblong hole can be used to form a height-adjustable support
- Hardened casting



Description ▲ Application ▼

Application ▼

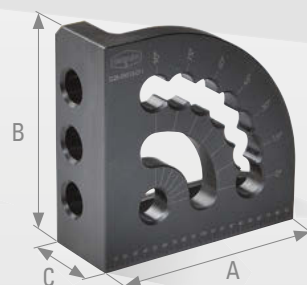


28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	175	50	275	25	2.4	Hardened casting	PE28-03008-000

- The new angle bracket with an incredible range of applications. Only as a stop, or for clamping angled parts. With our combination of freely adjustable angle setting, 15° increments form-fitting or as 90° stop, you will always find the right solution
- With precision scaling
- Steel, hardened



Left
P28-05013-012



Right
P28-05013-011

Description ▲ Application ▼

Application ▼



28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	200	200	75	7.3	Right	P28-05013-011
	200	200	75	7.3	Left	P28-05013-012

Angle bracket

Strong connection of work pieces



DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Highly robust stop and locking angle for work pieces and system components
- Direct connection of 3D worktable and base rail
- Steel, hardened



Description ▲

Application ▼



Connection to base rail possible

28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	150	75	25	2.90	Steel, hardened	D28-50003-000

- Full locating surfaces inside and outside
- Numerous possibilities thanks to oblong holes and system bores
- Continuously moveable with oblong holes
- Steel, hardened



Description ▲

Application ▼



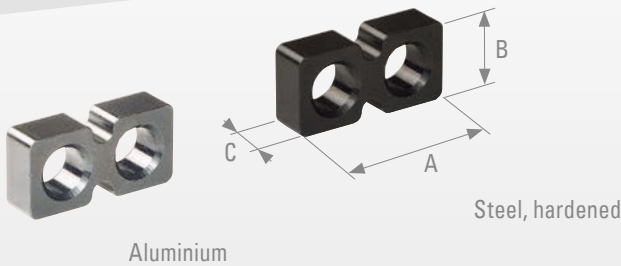
28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	375	500	25	12	Steel, hardened	D28-03006-000

Universal stop small



DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Preferred use in confined work areas
- Also usable for corner connections thanks to notching



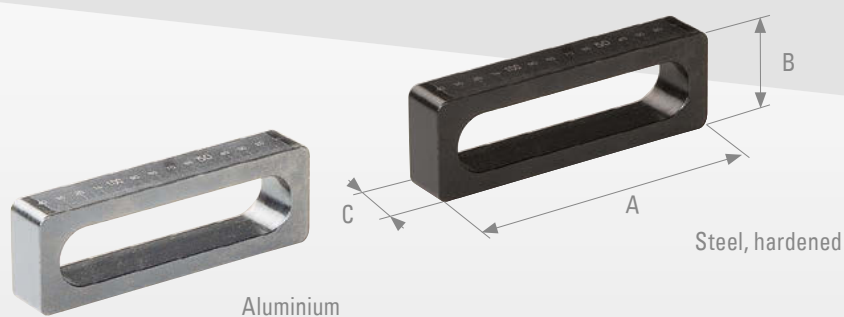
Description ▲

Application ▼



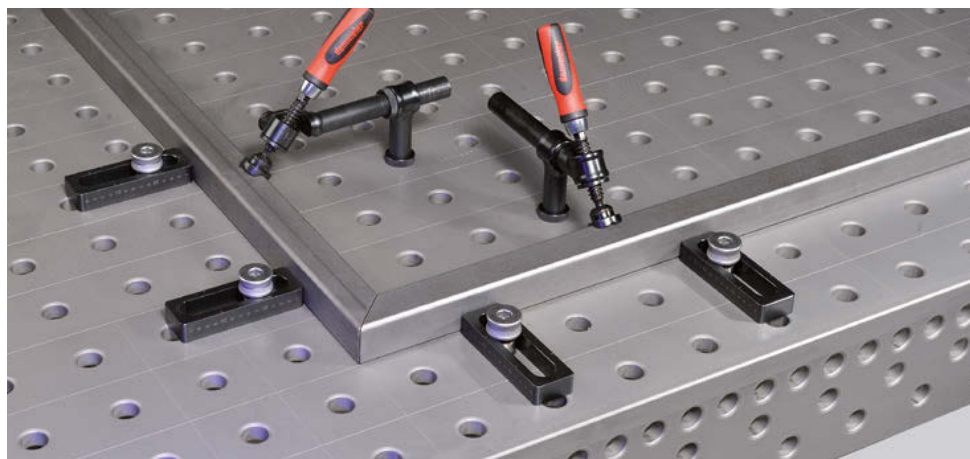
28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	100	50	25	0.64	Steel, hardened	D28-05002-000
	100	50	25	0.23	Aluminium	D28-05002-010

- Precision scaling on both sides
- Continuously adjustable with scale on both sides



Description ▲

Application ▼



28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	150	50	25	0.9	Steel, hardened	D28-05015-000
	150	50	25	0.28	Aluminium	D28-05015-003

EcoLINE universal stop small



DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Preferred use in confined work areas
- Simple version
- Steel, hardened



Description ▲ Application ▼

Application ▼



28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	100	50	25	0.72	E28-05002-000

- Combination system bore / oblong hole for numerous clamping possibilities
- Simple version without scale
- With precision scaling
- Steel, hardened



Description ▲ Application ▼

Application ▼



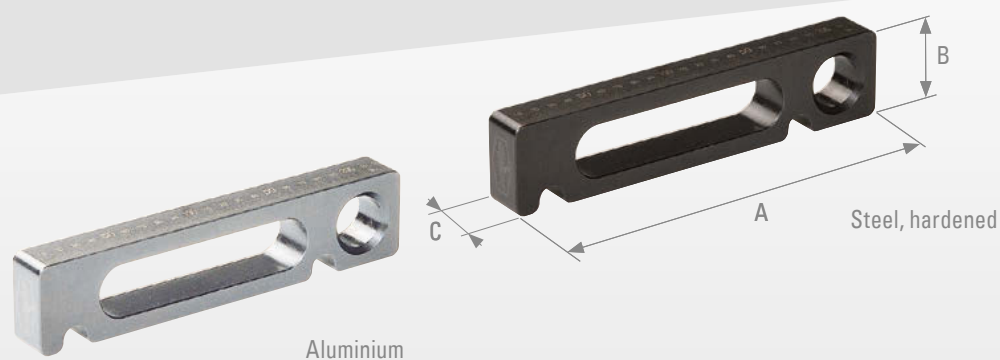
28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	225	50	25	1.40	E28-05001-000

Universal stop large with precision scaling

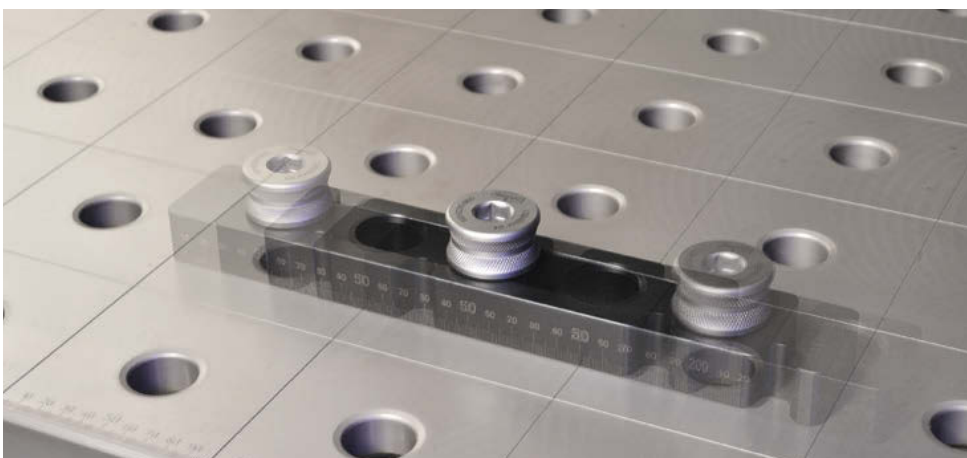


DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Combination system bore / oblong hole for numerous clamping possibilities
- Incl. 1 mm precision scaling



Description ▲ Application ▼

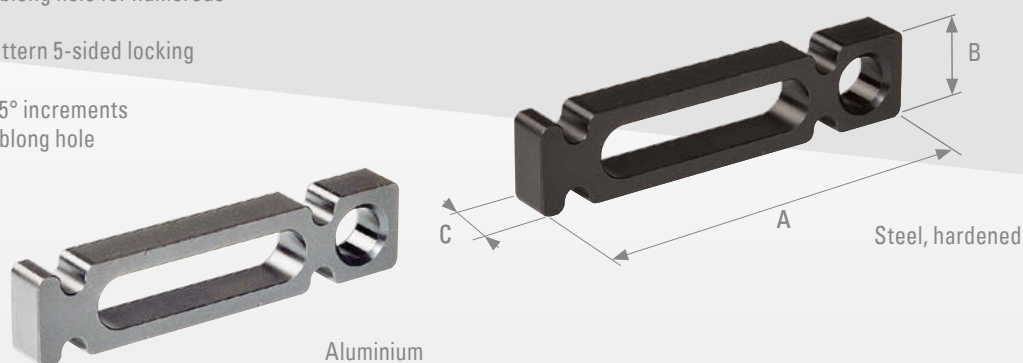


Description ▼

- Fine adjustable with precision scaling possible using grid lines
- 360° adjustable position
- Additional notch for attachment, ideal as corner stop
- Continuous adjustment via oblong hole

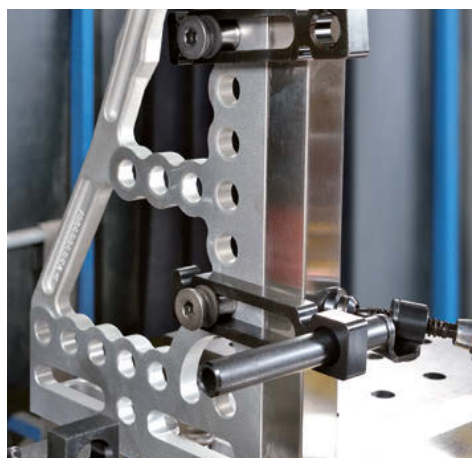
28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	225	50	25	1.32	Steel, hardened	D28-05001-010
	225	50	25	0.47	Aluminium	D28-05001-021

- Combination system bore / oblong hole for numerous clamping possibilities
- With PC-bolt in table hole pattern 5-sided locking and fixation in 25 mm grid
- 360° adjustable position in 45° increments
- Continuous adjustment via oblong hole
- With precision scaling



Description ▲ Application ▼

Application ▼



28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	225	50	25	1.2	Steel, hardened	D28-05001-000
	225	50	25	0.44	Aluminium	D28-05001-022

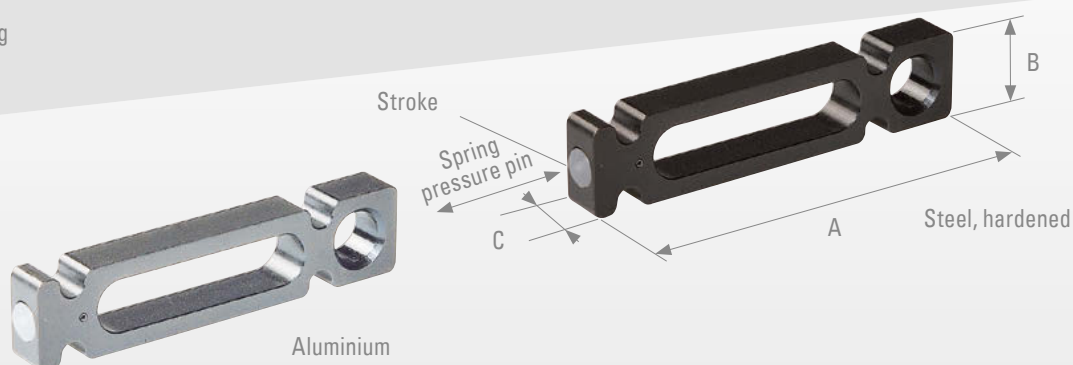
Universal stop large with plunger

Exact fixation of the work pieces

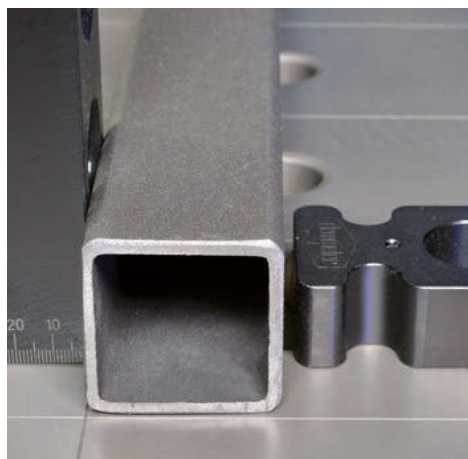
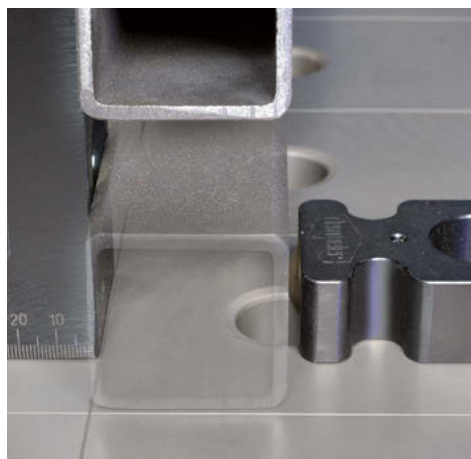


DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Like universal stop large
- With additional spring pressure pin especially for clamping sheet metal and moulded parts, so that no additional fixation of work pieces is necessary
- Large stroke 3.5 mm
- With precision scaling

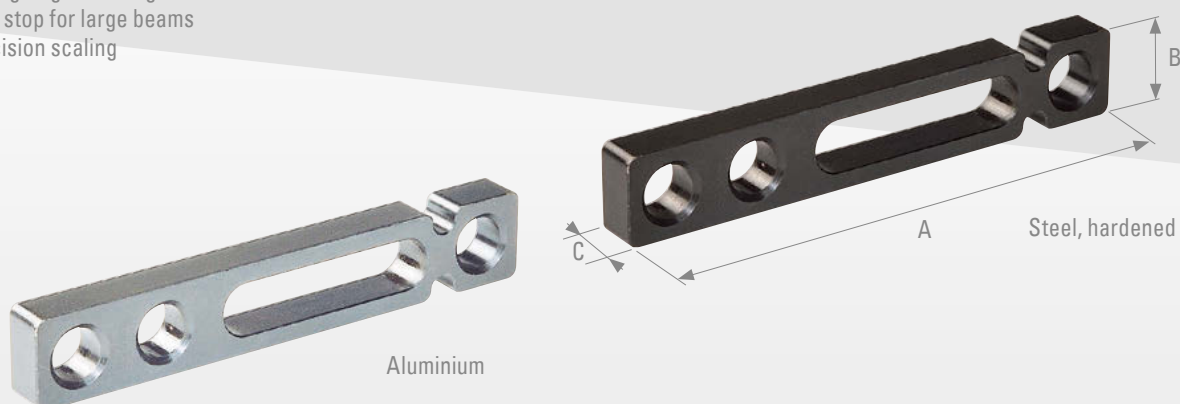


Description ▲ Application ▼



28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	225	50	25	1.2	Steel, hardened	D28-05001-001
	225	50	25	0.45	Aluminium	D28-05001-020

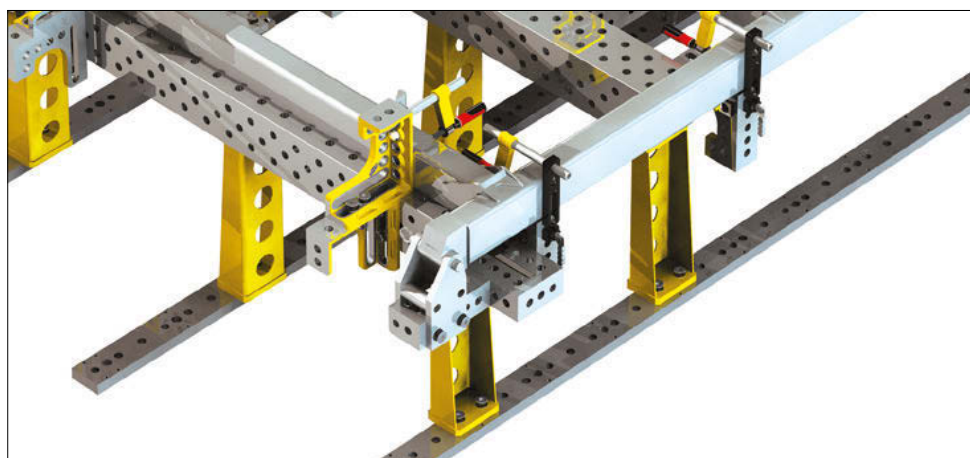
- Larger stop range than universal stop large
- Three or seven system bores
- For bridging larger bearing surfaces
- As lateral stop for large beams
- With precision scaling



Description ▲ Application ▼



As lateral stop



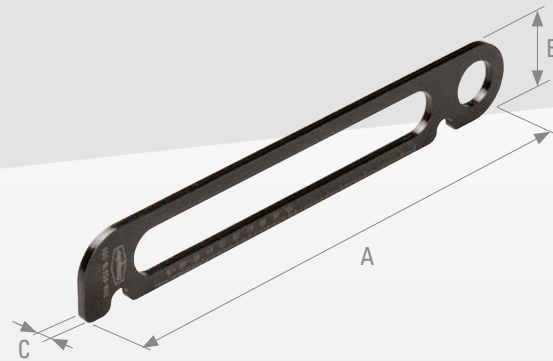
For bridging larger distances

28	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	300	50	25	1.8	Steel, hardened	D28-05009-000
	500	50	25	3.22	Steel, hardened	D28-05009-008
	300	50	25	0.63	Aluminium	D28-05009-013
	500	50	25	1.14	Aluminium	D28-05009-014

Contour stop

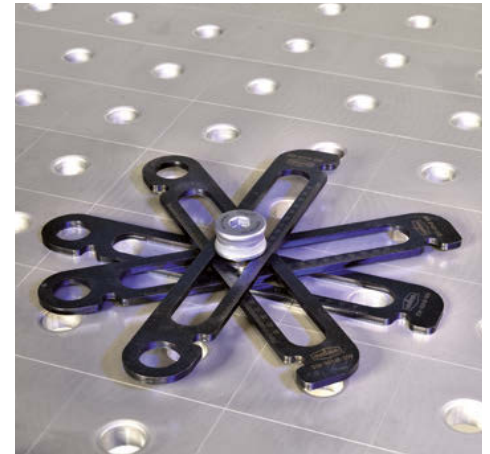
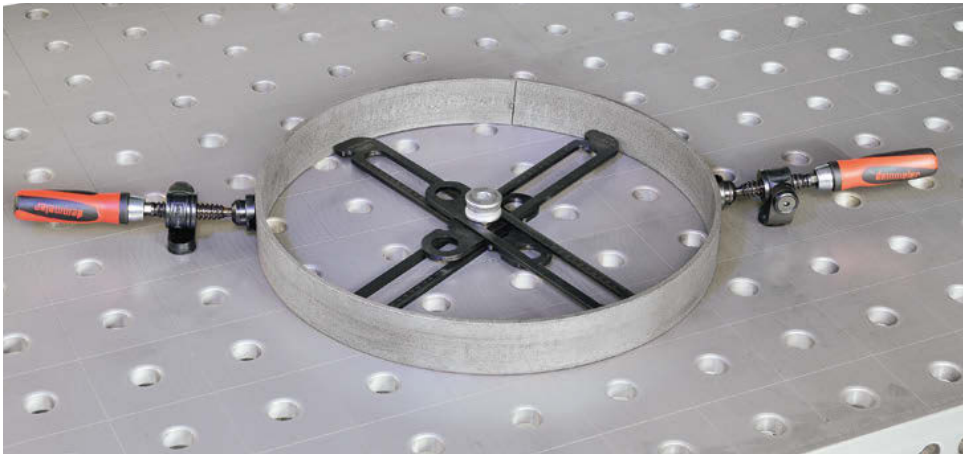
With 1 mm precision scaling

- Serves as stop element for light work pieces
- Clamping via PC-bolt and spacer washer of the spacer set
- Cost-effective
- With 1 mm precision scaling



Description ▲ Application ▼

Application ▼

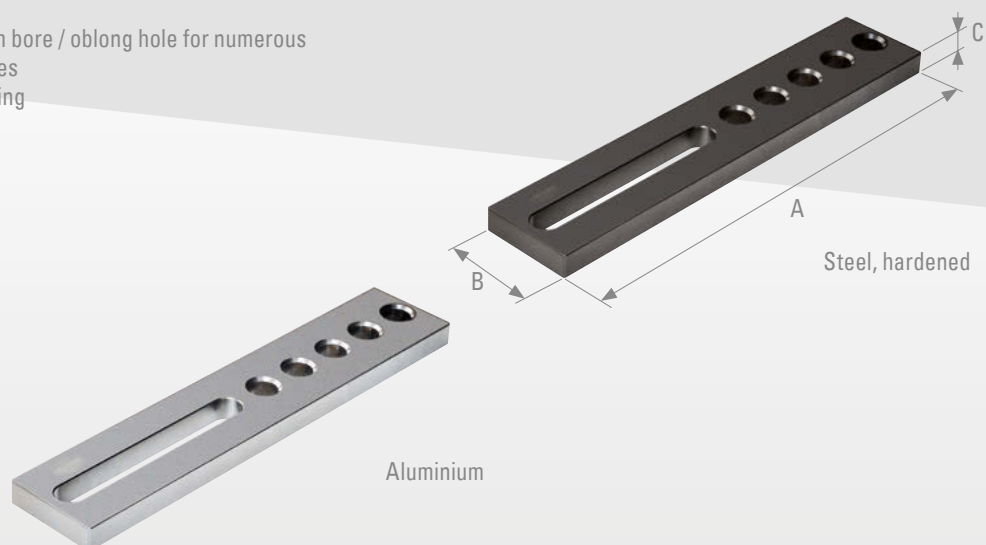


28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	325	50	6	0.85	D28-05016-000



DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Combination system bore / oblong hole for numerous clamping possibilities
- With precision scaling



Description ▲ ▼

- Very long and sturdy version with large bearing surfaces for large components or long distances
- Continuous adjustment via oblong hole
- Combination system bore / oblong hole for numerous clamping possibilities

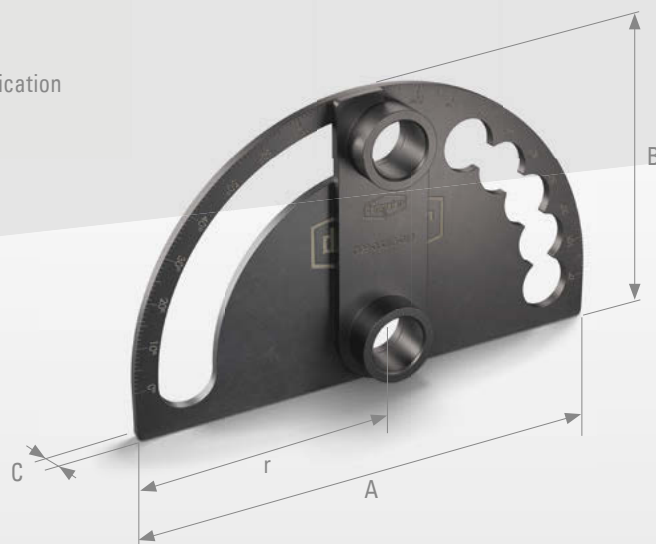
28	A in mm	B in mm	C in mm	Description	~ Weight in kg	Item no.
	500	100	25	Steel, hardened	8.00	D28-05003-000
	800	100	25	Steel, hardened	13.00	D28-05003-001
	1000	100	25	Steel, hardened	16.48	D28-05003-008
	500	100	25	Aluminium	2.78	D28-05003-016
	800	100	25	Aluminium	4.57	D28-05003-017
	1000	100	25	Aluminium	5.76	D28-05003-018

Angle-setting template

Precision scaling on both sides

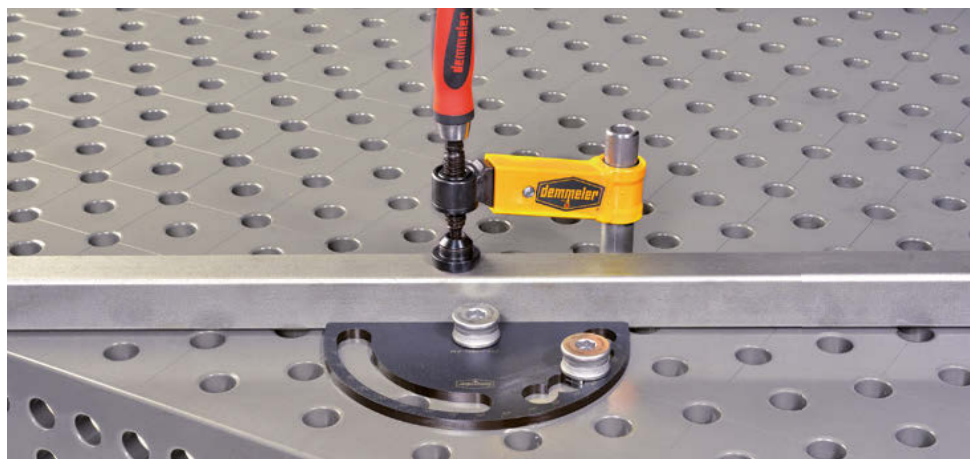

DEMONT 760 M
BLACK EDITION
 THE NEW HARDNESS

- The angle-setting template is flexible in application with the 1° precision scaling on both sides
- Continuous 0°-90°
- Fixed setting out 0-60° (15° increments)
- r = Radius 125 mm
- Steel, hardened



Description ▲

Application ▼

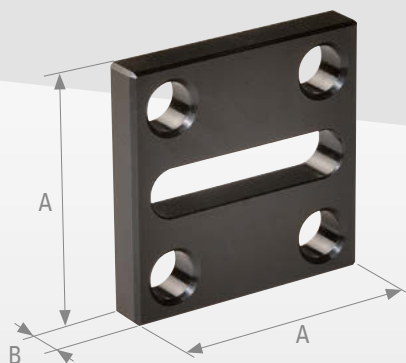


Fixed setting out in 15° increments (0° - 60°) and continuous 0° - 90°

28

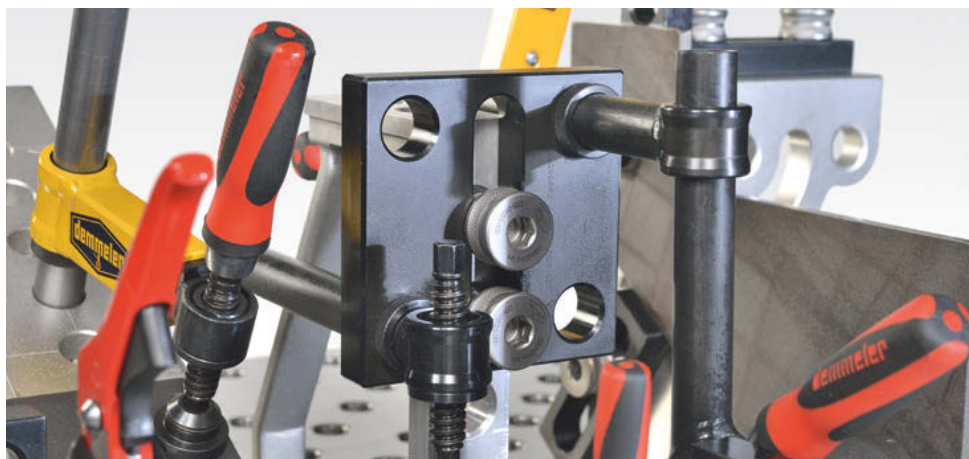
A in mm
250B in mm
150C in mm
12~ Weight in kg
1.2Item no.
D28-05013-010

- As interface between 3D system and individual components, i.e. for welding / screwing on special customer elements
- Steel, hardened



Description ▲

Application ▼



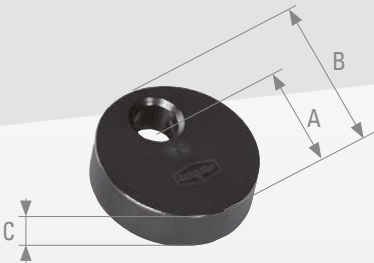
28	A in mm	B in mm	~ Weight in kg	Item no.
	150	25	3.2	D28-05010-000

Locating disk



DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Can be used as stop or support
- Fixation with PC-bolt or connecting bolt
- Continuous adjustment by turning (adjustment path A)
- Low space requirements

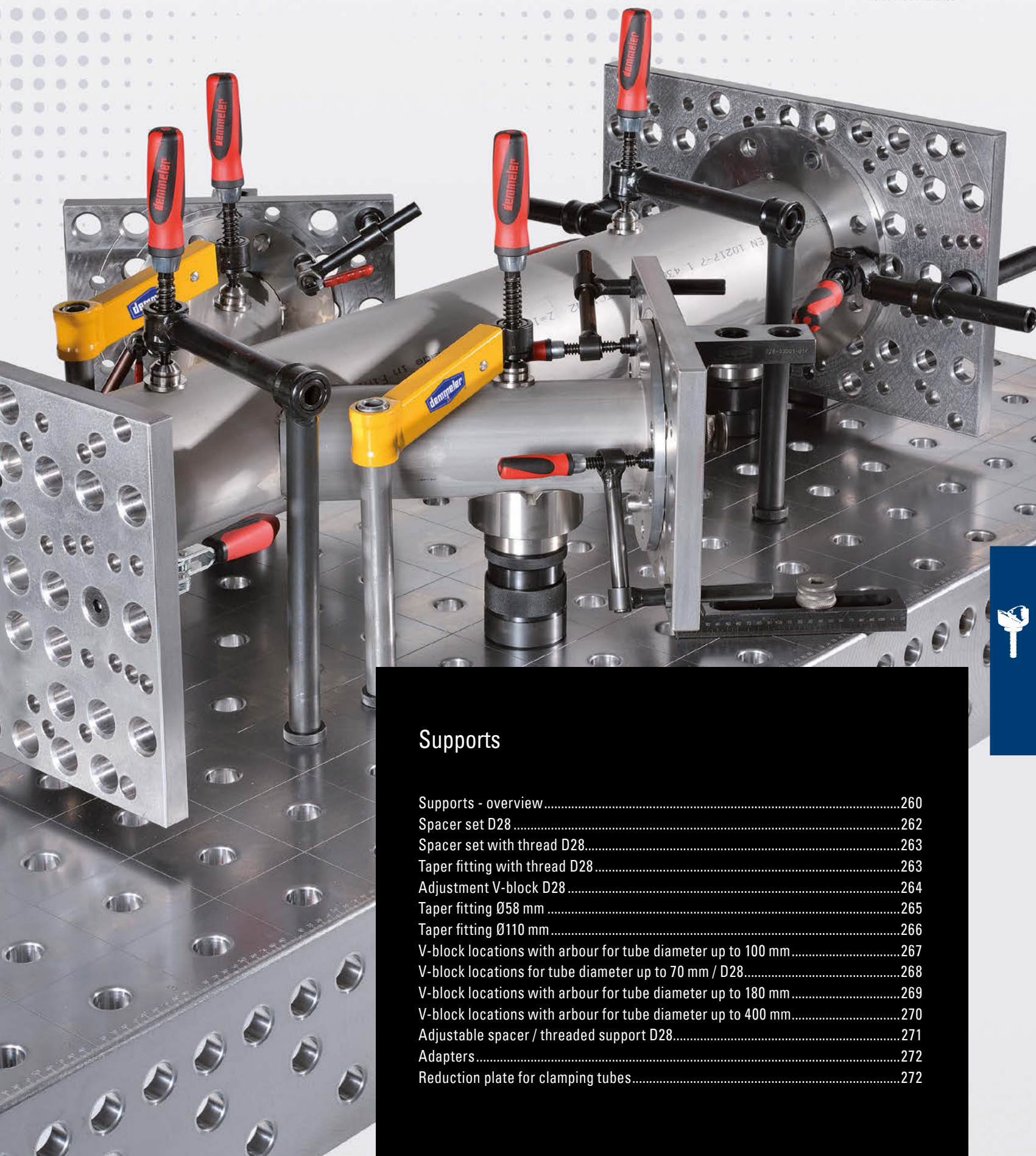


Description ▲

Application ▼



28	A in mm	B in mm	C in mm	Description	~ Weight in kg	Item no.
	50	75	25	Steel, hardened	0.7	D28-05013-000
	75	100	25	Steel, blackened	1.3	E28-05013-000
	75	100	25	Steel, hardened	1.3	D28-05013-001



Supports

Supports - overview.....	260
Spacer set D28	262
Spacer set with thread D28.....	263
Taper fitting with thread D28	263
Adjustment V-block D28	264
Taper fitting Ø58 mm	265
Taper fitting Ø110 mm	266
V-block locations with arbour for tube diameter up to 100 mm	267
V-block locations for tube diameter up to 70 mm / D28.....	268
V-block locations with arbour for tube diameter up to 180 mm	269
V-block locations with arbour for tube diameter up to 400 mm.....	270
Adjustable spacer / threaded support D28.....	271
Adapters.....	272
Reduction plate for clamping tubes.....	272

Supports - overview

28 Spacer set

PAGE 262



28 Spacer set with thread

PAGE 263



28 Taper fitting with thread

PAGE 263



28 Adjustment V-block

PAGE 264



28 Taper fitting Ø58 mm

PAGE 265



28 Taper fitting Ø110 mm

PAGE 266



28 V-block locations with arbour for tube diameter up to 100 mm

PAGE 267



28 V-block locations for tube diameter up to 70 mm

PAGE 268



28 V-block locations with arbour for tube diameter up to 180 mm

PAGE 269



28 V-block locations with arbour for tube diameter up to 400 mm

PAGE 270



28 Adjustable spacer / threaded support

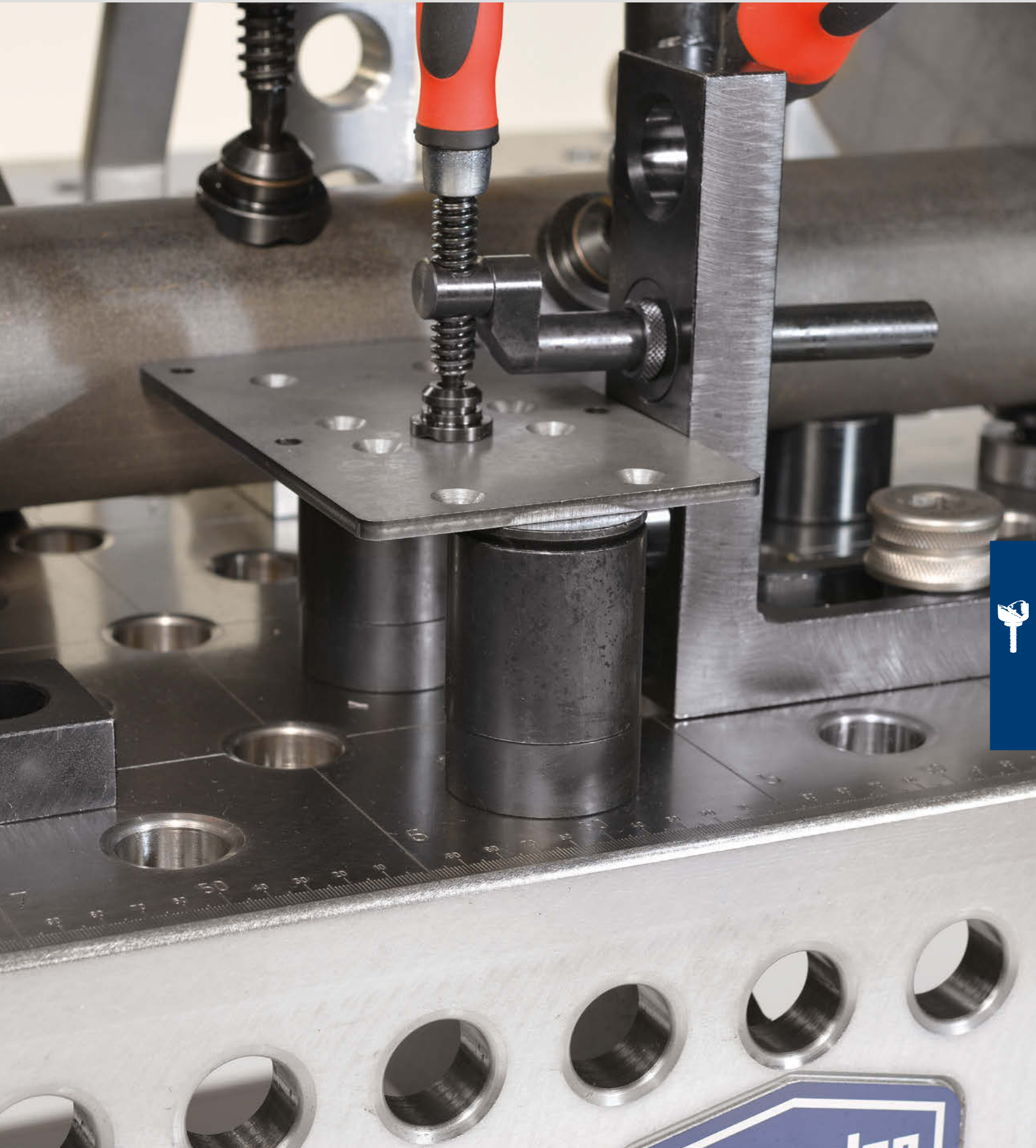
PAGE 271



28 Adapters/reduction plate for clamping tubes

PAGE 272





Spacer set

Height compensation in mm range

- For 5-100 mm height compensation on the respective support surface
- Smallest increment 1 mm
- Includes 1/10 inch disk (2.54 mm)
- With dimensions of the compensating disks
- Support mandrel fitting each system bore 28
- Self-locking with O-Ring
- On the top of the support mandrel M12 thread for customer-specific elements available on request
- Support prisms consisting of: Individual support mandrel + bearer sleeves L1-L50 + V-block location (as of page 268)



Description ▲ Details ▼

- Exact positioning of height via bearer sleeves in various lengths or with continuously adjustable threaded spacer set (see D28-09001-005, page 263)

28	A in mm	Ø B in mm	~ Weight in kg	Description	Item no.
	120+5	28	1.96	11-piece spacer set	D28-09001-000
	120+5	28	0.60	individual support mandrel	00043256
	1	50	0.02	bearer sleeve L1	00000132
	2	50	0.02	bearer sleeve L2	00000131
	2.5	50	0.02	bearer sleeve L2.5	00003933
	3	50	0.04	bearer sleeve L3	00000130
	4	50	0.04	bearer sleeve L4	00000129
	5	50	0.04	bearer sleeve L5	00000128
	10	50	0.08	bearer sleeve L10	00000127
	20	50	0.20	bearer sleeve L20	00000126
	40	50	0.40	bearer sleeve L40	00000125
	50	50	0.48	bearer sleeve L50	00000124

Spacer set with thread

Taper fitting with thread

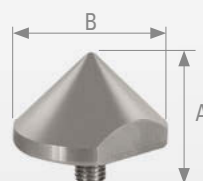
Height compensation, continuous

Tube diameter range Ø5 - Ø55 mm

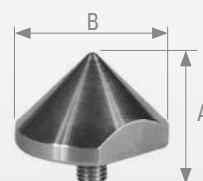
- As support surface on system components or directly on the table
- Adjustment path 22-105 mm continuous
- With 0.1 mm precision scaling
- Max. load capacity 500 kg
- Blackened
- Includes counter nut M28



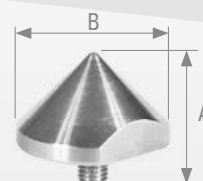
- Taper fitting for M12 threaded bolt
- to hold tubes on the interior diameter combined with spacer set item no.: D28-09001-005
- Securing work piece using reference bores
- Also for use as point support
- Diameter range Ø5 - Ø55 mm



Steel, hardened
D28-09003-017

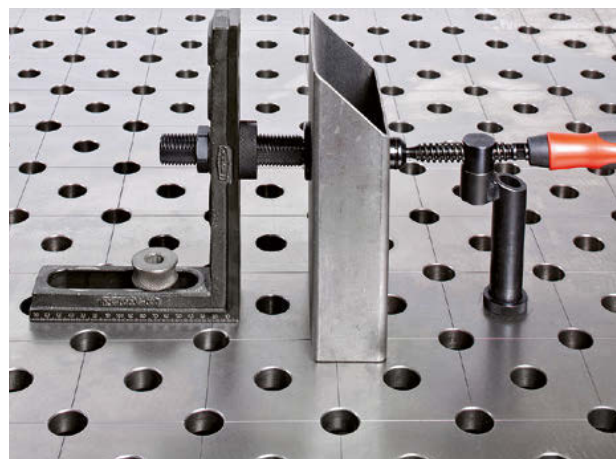


Stainless steel
D28-09003-018

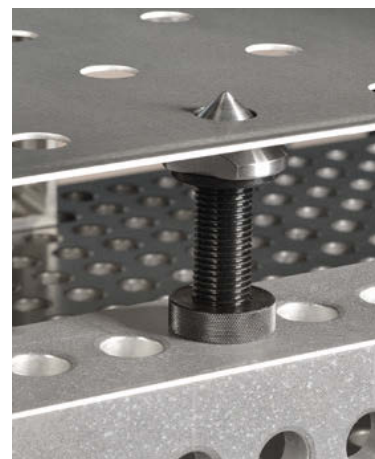
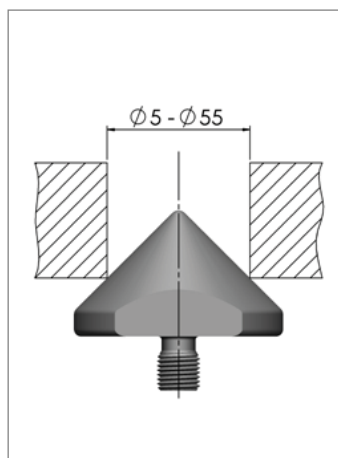


Aluminium
D28-09003-019

Description ▲ Application ▼



Description ▲ Application ▼



28	A in mm	Ø B in mm	~ Weight in kg	Item no.
	120+5	50	approx. 0.8	D28-09001-005

28	A in mm	Ø B in mm	~ Weight in kg	Angle	Description	Item no.
	35	58	0.34	90°	Steel, hardened	D28-09003-017
	35	58	0.34	90°	Stainless steel	D28-09003-018
	35	58	0.12	90°	Aluminium	D28-09003-019

Adjustment V-block

- Eccentric setting via sliding plate
- Flexible angle adjustment from 180 to 90 °
- Height secured with clamping bush
- Synchronous adjustment via toothing



Description ▲

Application ▼

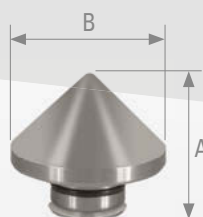


28	A in mm	B in mm	~ Weight in kg	Description	Item no.
	200	100	1.4	Adjustment V-block	D28-09015-000

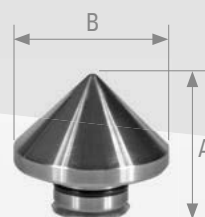
Taper fitting Ø58 mm

For interior tube diameter Ø5 - Ø55 mm

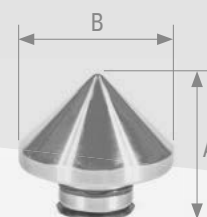
- Pressure and contact taper to hold tubes by the interior diameter
- Screwed in with countersunk head screw
- Diameter range Ø5 - Ø55 mm



Steel, hardened
D28-09003-011

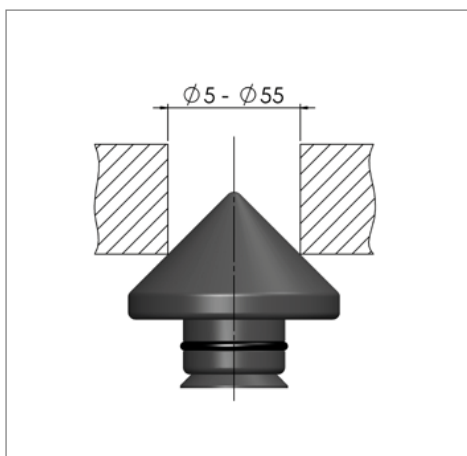


Stainless steel
D28-09003-012

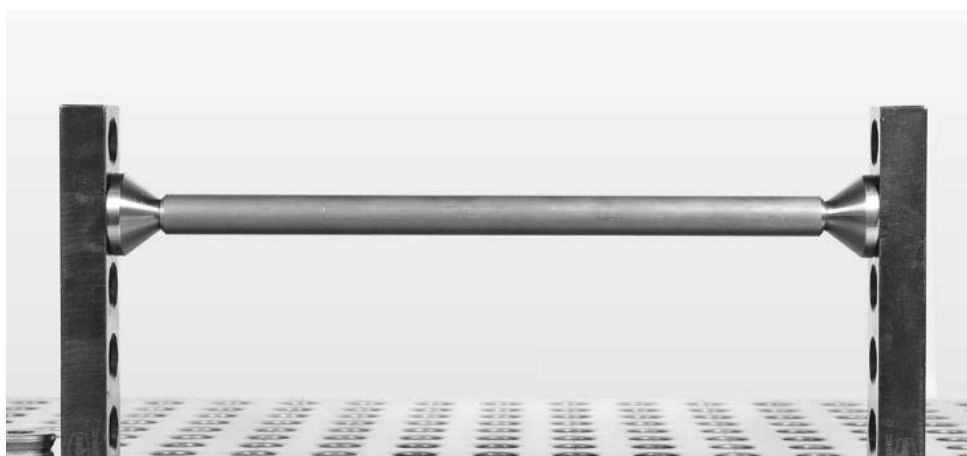


Aluminium
D28-09003-013

Description ▲



Application ▼

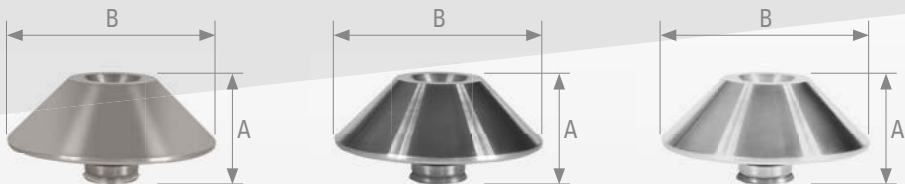


28	A in mm	Ø B in mm	~ Weight in kg	Angle	Description	Item no.
	35	58	0.37	90°	Steel, hardened	D28-09003-011
	35	58	0.37	90°	Stainless steel	D28-09003-012
	35	58	0.13	90°	Aluminium	D28-09003-013

Taper fitting Ø110 mm

For interior tube diameter Ø 50 - Ø 105 mm or exterior diameter Ø 10 - Ø 30 mm

- Pressure and contact taper to hold tubes at the interior or exterior diameter
- Screwed in with countersunk head screw
- Diameter range inside: Ø50 - Ø105 mm
- Diameter range outside: Ø10 - Ø30 mm



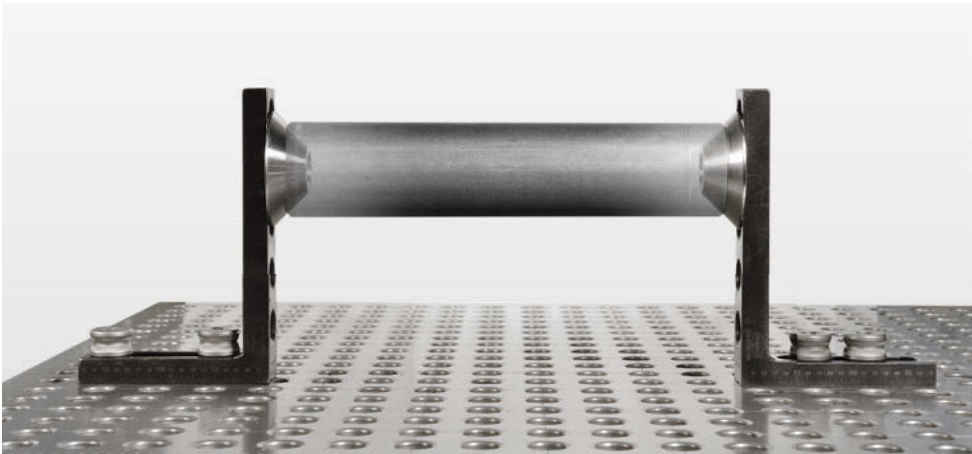
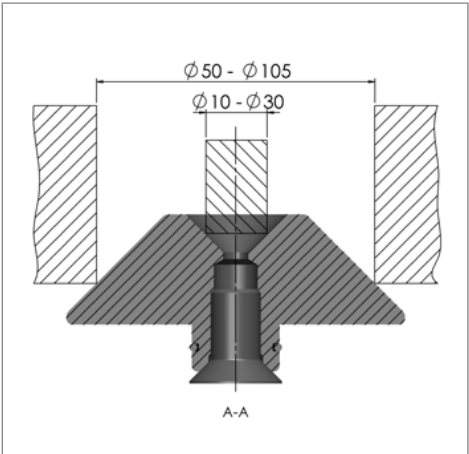
Steel, hardened
D28-09003-014

Stainless steel
D28-09003-015

Aluminium
D28-09003-016

Description ▲

Application ▼



28	A in mm	Ø B in mm	~ Weight in kg	Angle	Description	Item no.
	35	110	1.44	90°	Steel, hardened	D28-09003-014
	35	110	1.44	90°	Stainless steel	D28-09003-015
	35	110	0.49	90°	Aluminium	D28-09003-016

V-block locations with arbour for tube diameter up to 100 mm

With double V-block

- With threaded support tower
- For tube diameter up to 100 mm
- Also suitable for rectangular tubes
- Double V-block for more possibilities



Steel, blackened
D28-09004-000



Stainless steel
D28-09004-003



POM
D28-09004-001

Description ▲

Height adjustment via bearer sleeves for arbour (page 262) or continuous adjustment using spacer set with thread D28-09001-005 (page 263) or with adjustable spacer D28-09009-000 (page 271)

Application ▼

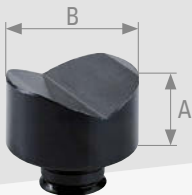


28	A in mm	Ø B in mm	C in mm	~ Weight in kg	Angle	Description	Item no.
	180	80	60	2.16	90 / 90°	Steel, blackened	D28-09004-000
	180	80	60	2.18	90 / 90°	Stainless steel	D28-09004-003
	180	80	60	0.88	90 / 90°	POM	D28-09004-001

V-block locations for tube diameter up to 70 mm

Precise holding of tube elements

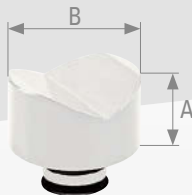
- Screwed in with countersunk head screw
- For tube diameter up to 70 mm



Steel, blackened
D28-09003-000



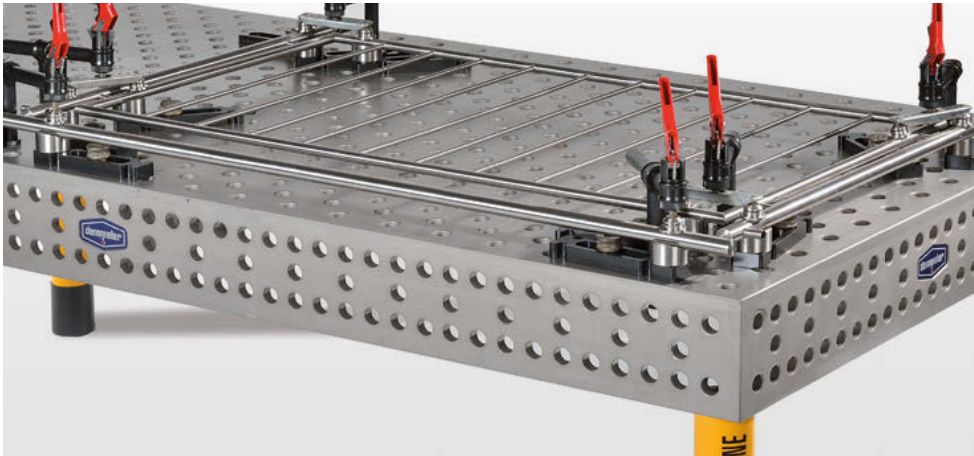
Stainless steel
D28-09003-002



POM
D28-09003-001

Description ▲

Application ▼



28	A in mm	Ø B in mm	~ Weight in kg	Angle	Description	Item no.
	35	58	0.68	130°	Steel, blackened	D28-09003-000
	35	58	0.70	130°	Stainless steel	D28-09003-002
	35	58	0.14	130°	POM	D28-09003-001

V-block locations with arbour for tube diameter up to 180 mm

Precise holding of tube elements

- With threaded support tower
- For tube diameter up to 180 mm
- Double V-block for more possibilities
- Height adjustment via bearer sleeves for arbour (page 262) or continuous adjustment using spacer set with thread D28-09001-005 (page 263) or with adjustable spacer D28-09009-000 (page 271)



Steel, blackened
D28-09005-000



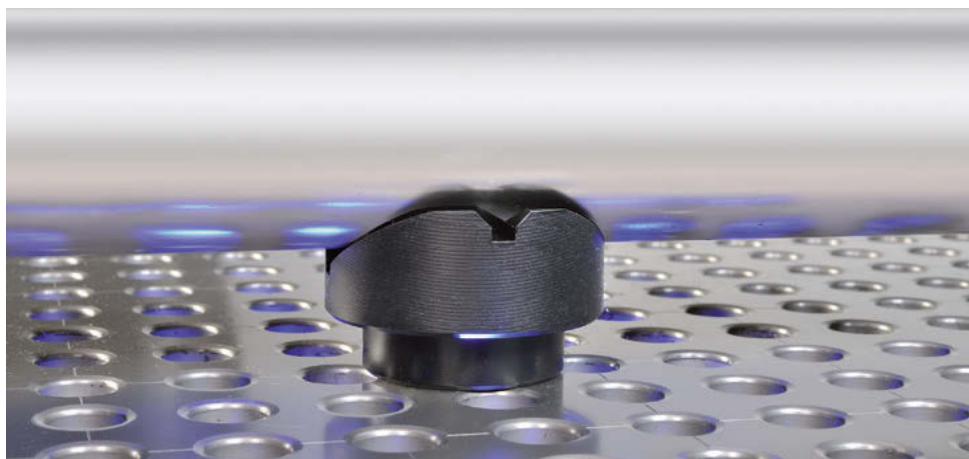
Stainless steel
D28-09005-002



POM
D28-09005-001

Description ▲

Application ▼

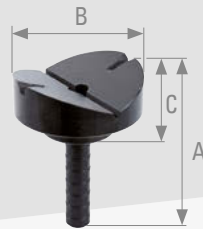


28	A in mm	Ø B in mm	C in mm	~ Weight in kg	Angle	Description	Item no.
	190	110	70	3.70	120 / 90°	Steel, blackened	D28-09005-000
	190	110	70	3.82	120 / 90°	Stainless steel	D28-09005-002
	190	110	70	1.10	120 / 90°	POM	D28-09005-001

V-block locations with arbour for tube diameter up to 400 mm

Precise holding of tube elements

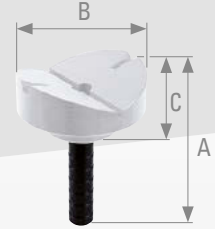
- With threaded support tower
- For tube diameter up to 400 mm
- Double V-block for more possibilities
- Height adjustment via bearer sleeves for arbour (page 262) or continuous adjustment using spacer set with thread D28-09001-005 (page 263) or with adjustable spacer D28-09009-000 (page 271)



Steel, blackened
D28-09006-000



Stainless steel
D28-09006-002



POM
D28-09006-001

Description ▲

Application ▼

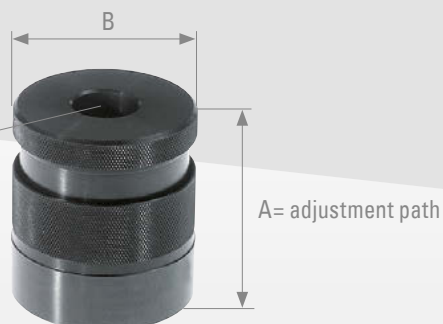


28	A in mm	Ø B in mm	C in mm	~ Weight in kg	Angle	Description	Item no.
	190	140	70	5.22	140 / 90°	Steel, blackened	D28-09006-000
	190	140	70	5.30	140 / 90°	Stainless steel	D28-09006-002
	190	140	70	1.32	140 / 90°	POM	D28-09006-001

Adjustable spacer / threaded support

- Support continuously adjustable from 75 to 95 mm
- Especially well suited for V-block locations with arbourFor direct insertion in the adjustable spacer
- Stops etc. with PC-bolt can also be clamped in the system bore

Clamping
option for
PC-bolts



Description ▲

Application ▼

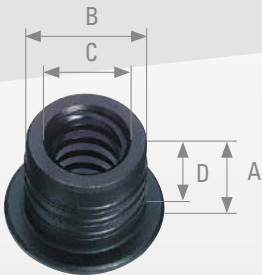


28	A in mm	Ø B in mm	~ Weight in kg	Description	Item no.
	75-95	80	2.5	With adjustment path A	D28-09009-000

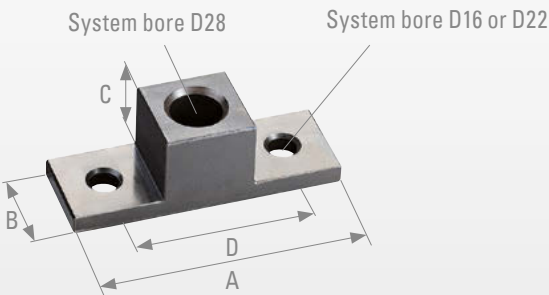
Adapters

Reduction plate for clamping tubes

- Used to hold Ø 16 mm screw clamps in D28 system bores
- D16 quick-action clamping cylinder can be used in system D28
- Can be used as support or stop simultaneously
- Threaded bushing for D28 screw clamp
- Note: If bolts are used then long D16 bolts are required



- Interface between D28 and D16 or D22



Description ▲

Description ▲

Adapter D28 to D16

28	A in mm	Ø B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	30	28	16	25	0.10	D00-06012-000

Reduction plate for clamping tubes D28 to D16

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	150	50	50	100	1.04	D00-06015-000

Reduction plate for clamping tubes D28 to D22

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	150	50	50	100	1.2	D00-06015-001



- Clamps
- Quick release skewer
- Pneumatic toggle clamp
- Magnetic clamp

Clamps - overview.....	274
Compensating swing clamp with spindle D28	280
Compensating swing clamp with quick-action clamping cylinder D28..	281
Compensating swing clamp with short boring spindle D28	282
Performance screw clamp with spindle D28	284
Performance screw clamp with quick-action clamping cylinder D28....	285
Performance screw clamp with short boring spindle D28	286
Compensating clamping arm with short boring spindle D28	287
Multi-clamping and support tower D28.....	287
Screw clamp 180° with spindle D28.....	288
Screw clamp 180° with quick-action clamping cylinder D28.....	290
Screw clamp 180° with short boring spindle D28	291
Variable screw clamp 90° D28.....	292
Variable screw clamp 45° with spindle D28	293
Variable screw clamp 45° with quick-action clamping cylinder D28...	294
Variable screw clamp 45° with short boring spindle D28.....	295
Spindle with bushing and clamping pads.....	296
Short boring spindle with bushing and clamping pads D28	296
Quick-action clamping cylinder with clamping pad D28.....	297
Adapter for PC-bolts D28 to D16.....	297
Clamping pad with V-block D28.....	298
Plunger and contact piece D28	299

Plunger and contact piece / clamping pad with taper D28.....	300
Clamping pad, steel double-sided D28	301
Adjusting spindle D28.....	301
Clamping pad with ball form D28	302
Clamping pad blank D28.....	303
Reduction plate for clamping tubes.....	304
Adapter for PS-bolts.....	305
2P. Clamping bridge with 2 clamping pads, steel D28.....	306
VARIO stop ring for round screw clamp tubes D28.....	307
Clamping tube D28	307
Angle bushing 90° D28.....	308
Angle bushing 45° D28.....	308
Angle bushing 90° with precision scaling in 15° increments D28.....	309
Angle bushing 45° with precision scaling in 15° increments D28.....	309
Adapter tube D28	310
Extension sleeve D28	311
Ball clamp bushing with countersunk head D28	311
Toggle clamp with threaded bushing with large stroke 32 mm.....	312
Toggle clamp with adapter and countersunk screw.....	313
Universal toggle clamp (with universal stop).....	314
2-point clamp with adapter	315
Vertical toggle clamp with adapter and countersunk screw.....	316
Vertical toggle clamp with universal stop	317
Horizontal toggle clamp with universal stop	318
Adapter for quick release skewer with countersunk screw.....	319
Pneumatic toggle clamp S.....	320
Pneumatic toggle clamp XL.....	321
Manifold with hand valve	322
Pressure force booster.....	323
Magnetic clamp.....	325

Clamps - overview D28

28 Compensating swing clamp
with spindle

PAGE 280



28 Compensating swing clamp
with quick-action clamping cylinder

PAGE 281



28 Compensating swing clamp
with short boring spindle

PAGE 282



28 Performance screw clamp
with spindle

PAGE 284



28 Performance screw clamp
with quick-action clamping cylinder

PAGE 285



28 Performance screw clamp
with short boring spindle

PAGE 286



28 Compensating clamping arm
with short boring spindle

PAGE 287



28 Multi-clamping and support tower

PAGE 287



28 Screw clamp 180°
with spindle

PAGE 288



28 Screw clamp 180°
with quick-action clamping cylinder

PAGE 290



28 Screw clamp 180°
with short boring spindle

PAGE 291



28 Variable screw clamp 90°

PAGE 292



28 Variable screw clamp 45°
with adjusting screw

PAGE 293



28 Variable screw clamp 45°
with quick-action clamping cylinder

PAGE 294



28 Variable screw clamp 45°
with short boring spindle

PAGE 295



28 Adjustment screw
with bushing and clamping pads

PAGE 296



28 Short boring spindle
with bushing and clamping pads

PAGE 296



28 Quick-action clamping cylinder
with clamping pads

PAGE 297



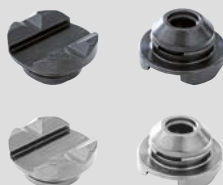
28 Adapter for PC-bolts

PAGE 297



28 Plunger and contact piece /
clamping pad with V-block

PAGE 298



28 Plunger and contact piece

PAGE 299



28 Plunger and contact piece /
clamping pad with taper

PAGE 300



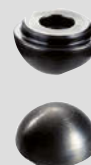
28 Clamping pad blackened steel
-doubleside / Adjusting spindle

PAGE 301



28 Clamping pad
with ball form

PAGE 302



Clamping pad
Blank

PAGE 303



Clamps - overview D28

28 Reduction plate for clamping
tube adapter tube for PS-bolts

PAGE 304
PAGE 305



28 2P. Clamping bridge
with 2 steel clamping pads

PAGE 306



28 VARIO stop ring
for round screw clamp tubes

PAGE 307



28 Clamping tube

PAGE 307



28 Angle bushing 90°

PAGE 308



28 Angle bushing 45°

PAGE 308



28 Angle bushing 90°
with precision scaling

PAGE 309



28 Angle bushing 45°
with precision scaling

PAGE 309



28 Adapter-tube

PAGE 310



28 Extension sleeve

PAGE 311



28 Ball clamp bushing
with countersunk head

PAGE 311



28 Toggle clamp
with threaded bushing

PAGE 312



28 Toggle clamp with adapter

PAGE 313



28 Universal toggle clamp

PAGE 314



28 2-point clamp with adaptor

PAGE 315



28 Vertical toggle clamp with adaptor and countersunk screw

PAGE 316



28 Vertical toggle clamp with universal stop

PAGE 317



28 Horizontal toggle clamp with universal stop

PAGE 318



28 Adapter for toggle clamps with countersunk screw

PAGE 319



28 Pneumatic toggle clamp S

PAGE 320



28 Pneumatic toggle clamp XL

PAGE 321



28 Manifold with hand valve

PAGE 322



28 Pressure force booster

PAGE 323



28 Magnetic clamp

PAGE 325



Flexible down to the details

Thanks to the modular system, the clamps adapt perfectly to the respective clamping situation. Select from various materials for the clamping pad and different spindle lengths, also for small installation spaces. The latch lever makes quick and precise clamping possible even with one hand. With three different tube lengths and exchangeable arms, you can handle any clamping task.

- Slip-proof handle thanks to rubberised inserts
- Clamping with standard hexagon wrench
- Threaded bushings fit all system bores
- Clamping pad exchangeable and usable as support in system bores

Vertically insertable tubes

Exchangeable

Difference equalisation

Difference equalisation prevents tipping of the work piece

Arm length exchangeable



- **Secure locking mechanism:**
The locking mechanism ensures controlled, fast and vibration-proof clamping.
- **Ultimate stability:**
Enables the even build-up of clamping force with large power reserves. The self-centring support and pressure piece clamps the work piece and can be exchanged.
- **The powder-coated clamping lever** features a highly ergonomic shape and swivels 360° degrees to circumvent all interfering edges. The plastic-coated, non-slip release lever ensures a secure grip while loosening the clamp.
- **Large stroke: 9 mm**

Exchangeable

Exchangeable

Horizontally insertable tubes

Insertable clamping pad

Vertically insertable tubes

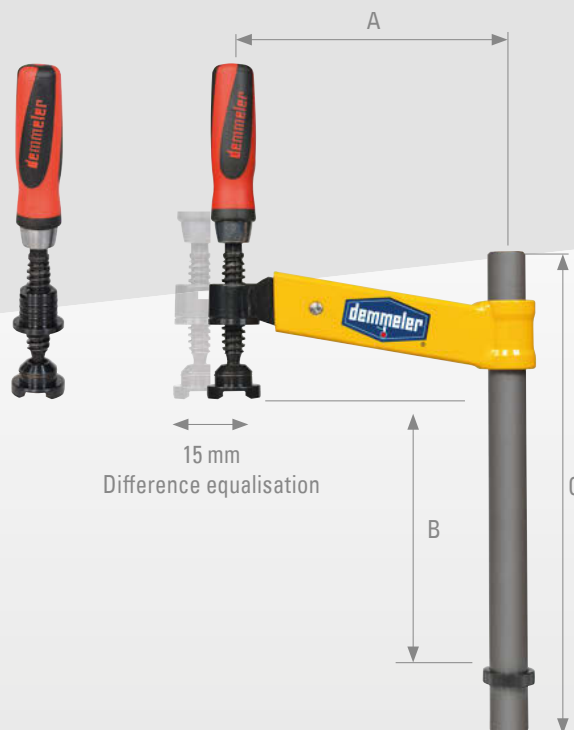
Compensating swing clamp with spindle

For profiles that tend to tip

Top seller

- For fast, powerful and accurately positioned clamping of many different work pieces
- With difference equalisation for accurately oriented and positioned work piece clamping
- With stop ring for height fixation
- Exchangeable actuator (e.g. spindle, short boring spindle or quick-action clamping cylinder)
- Clamping pad can be exchanged for clamping other materials such as stainless steel – the D28-07018-000 clamping bridge can also be used
- New standard clamping pad – added value for your screw clamps
- Exchangeable clamping tubes, available in different lengths

Exchangeable spindle



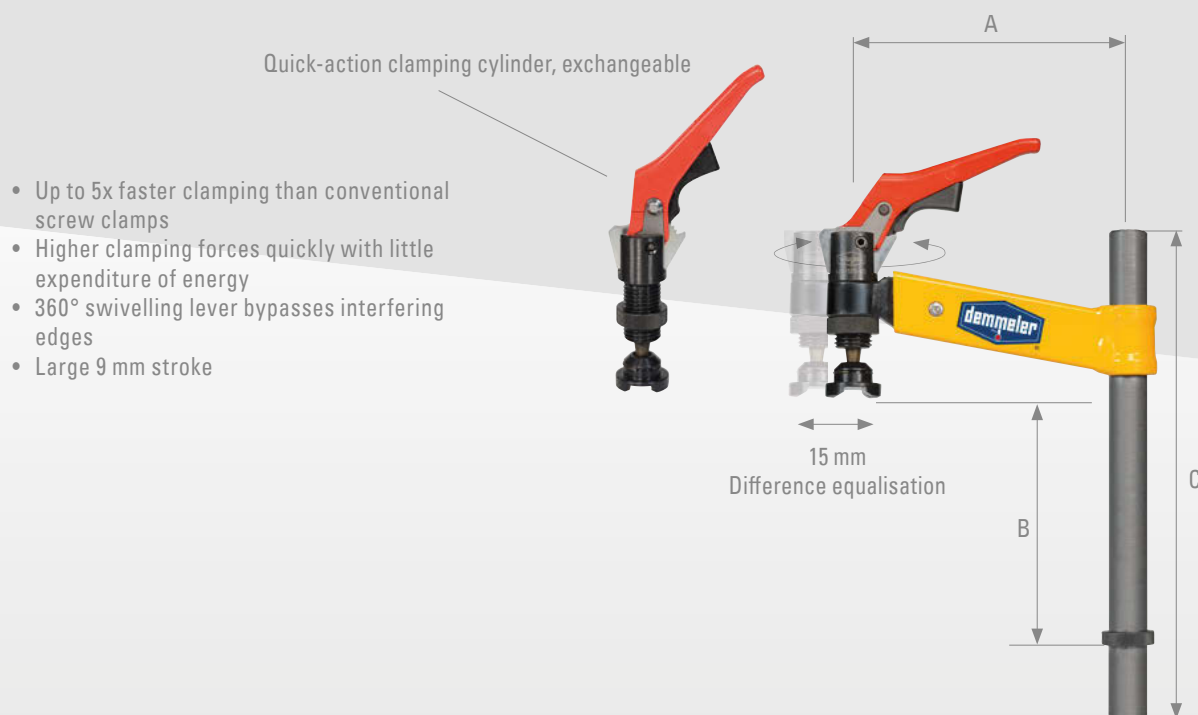
Description ▲

Application ▼



28	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	150	max. 280	350	2.62	D28-07001-000
	200	max. 280	350	2.88	D28-07002-000

Compensating swing clamp with quick-action clamping cylinder



Description ▲ Application ▼

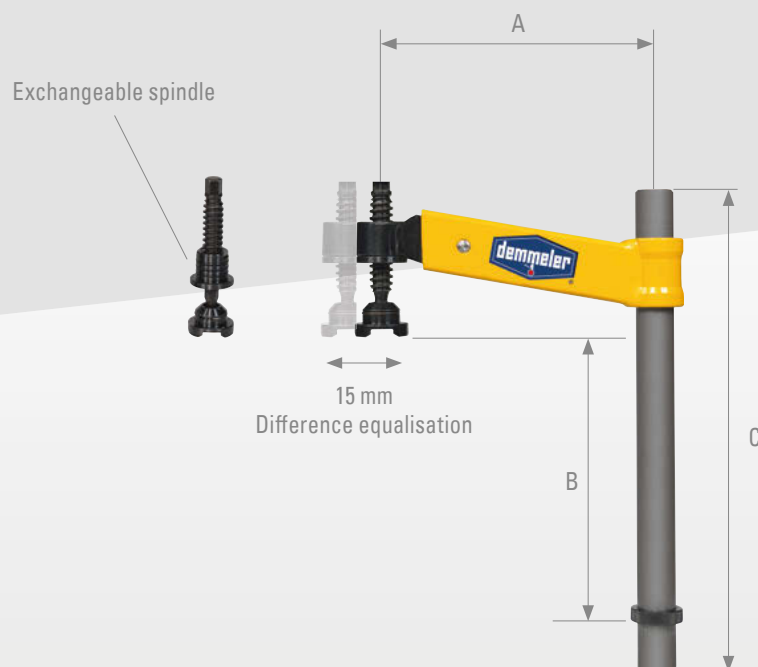
Application ▼



28	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	150	max. 280	350	2.92	D28-07001-001
	200	max. 280	350	3.12	D28-07002-001

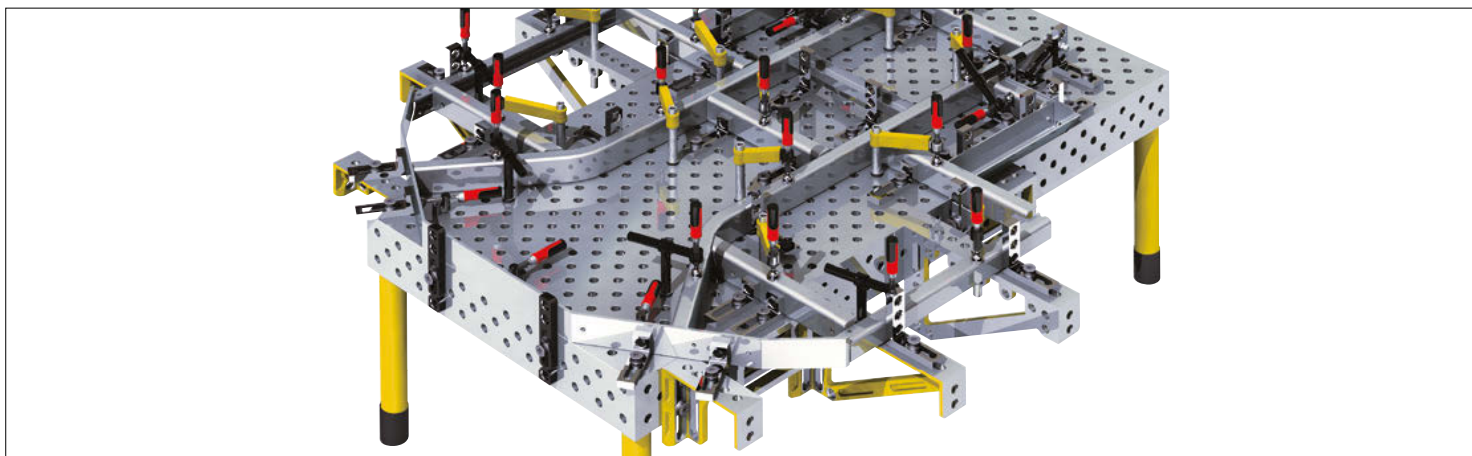
Compensating swing clamp with short boring spindle

- Operation with open-end wrench AF 13
- Highly recommended for confined spaces



Description ▲

Application ▼



28	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	150	max. 280	350	2.54	D28-07001-002
	200	max. 280	350	2.74	D28-07002-002



OUR PERFORMANCE
makes THE DIFFERENCE

One screw clamp for any angle with three exchangeable actuators.

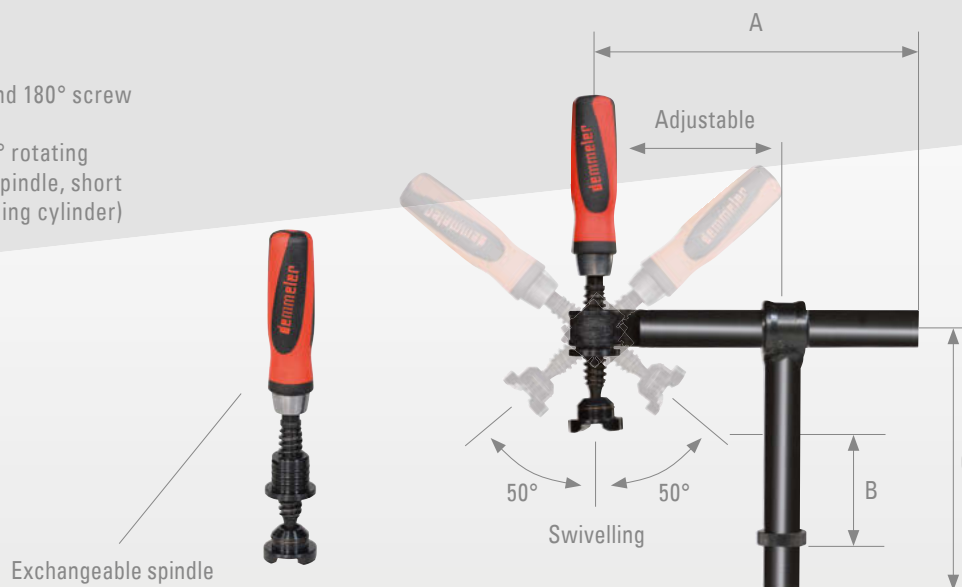
Covers the functions of the 45°, 90° and 180° screw clamps.
Continuously swivelling $\pm 50^\circ$ and 360° rotating.
With three exchangeable actuators (spindle, short boring spindle
and quick-action clamping cylinder). Individual, or can be combined
with 90°.



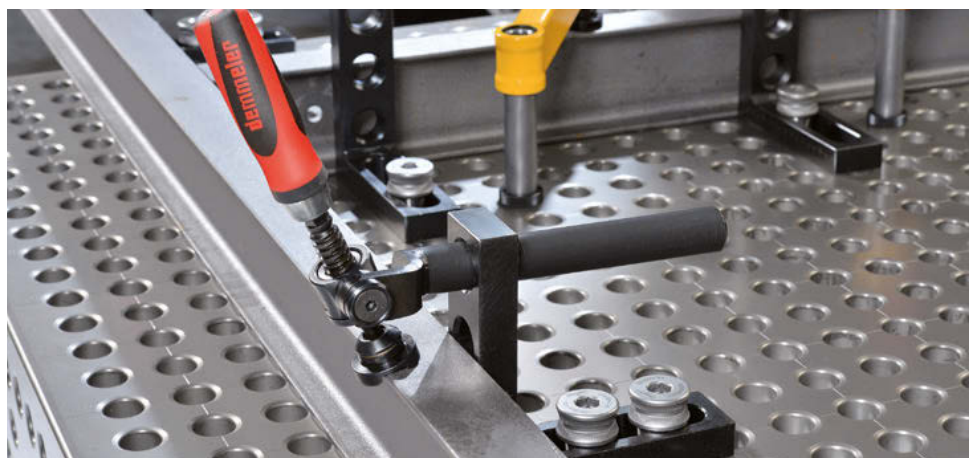
Performance screw clamp with spindle

A screw clamp for any angle with three exchangeable actuators

- Covers the functions of the 45°, 90° and 180° screw clamps
- Continuously swivelling $\pm 50^\circ$ and 360° rotating
- With three exchangeable actuators (spindle, short boring spindle and quick-action clamping cylinder)



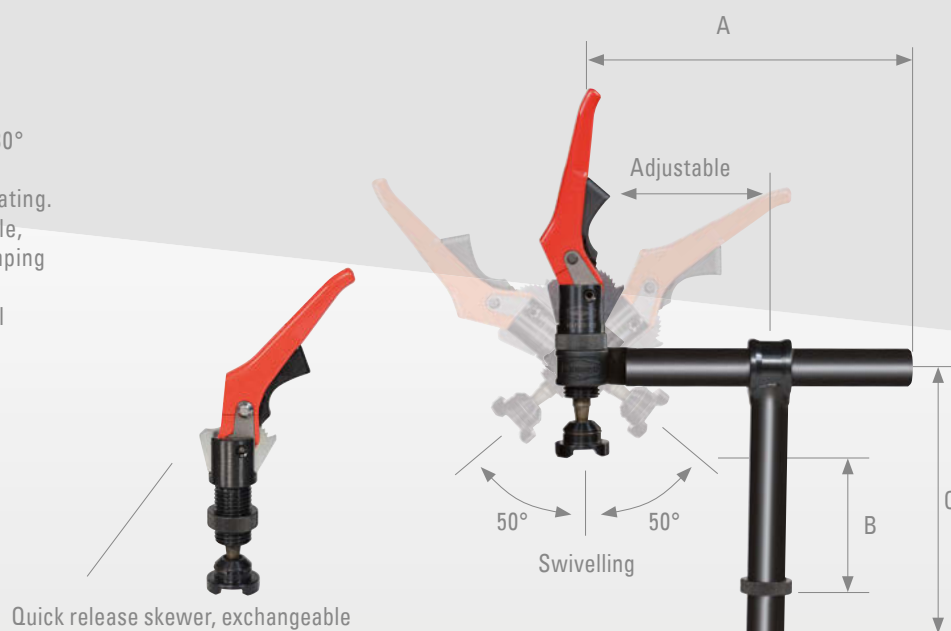
Description ▲ Application ▼



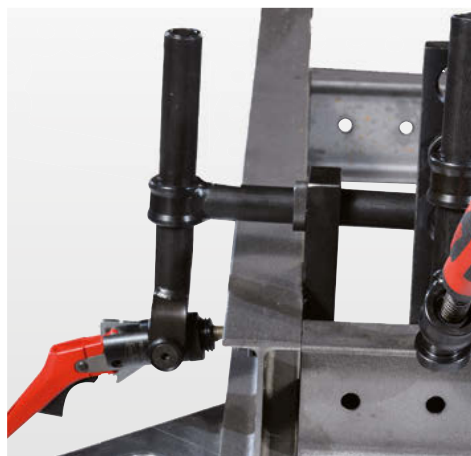
28	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	240	max. 180	270	2.9	D28-07009-033

Performance screw clamp with quick-action clamping cylinder

- Covers the functions of the 45°, 90° and 180° screw clamps
- Continuously swivelling $\pm 50^\circ$ and 360° rotating.
- With three exchangeable actuators (spindle, short boring spindle and quick-action clamping cylinder)
- Up to 5x faster clamping than conventional screw clamps
- Higher clamping forces quickly with little expenditure of energy



Description ▲ Application ▼



28

A in mm
240

B clamping width in mm
max. 180

C in mm
270

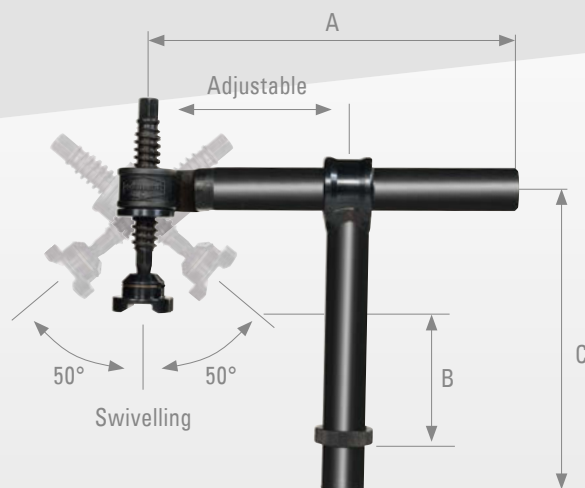
~ Weight in kg
2.6

Item no.
D28-07009-035

Performance screw clamp with short boring spindle

- Covers the functions of the 45°, 90° and 180° screw clamps
- Continuously swivelling $\pm 50^\circ$ and 360° rotating
- With three exchangeable actuators (spindle, short boring spindle and quick-action clamping cylinder).
- Operation with open-end wrench AF 13
- Entire clamping mechanism is exchangeable

Exchangeable spindle



Description ▲ Application ▼

▼ Application



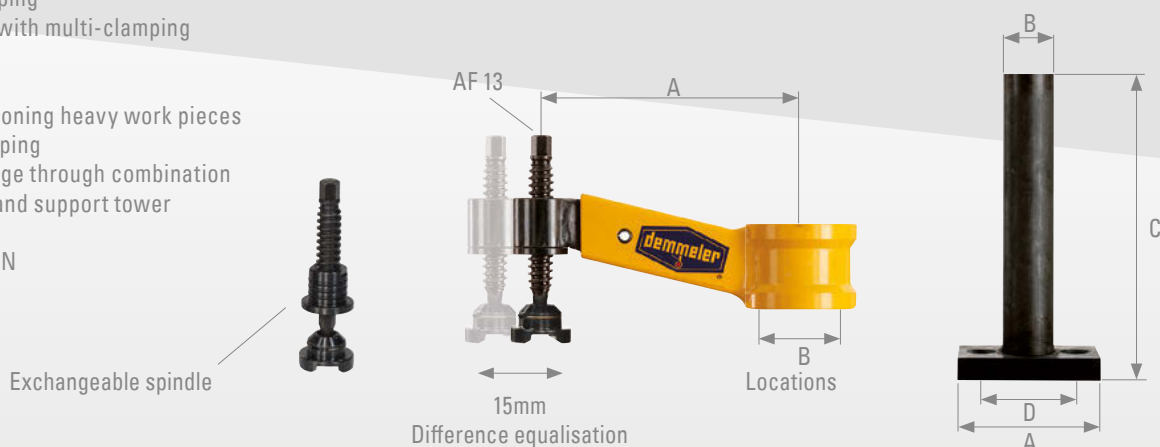
28

A in mm
240B clamping width in mm
max. 180C in mm
270~ Weight in kg
2.2Item no.
D28-07009-034

Compensating clamping arm with short boring spindle for heavy work pieces

Multi-clamping and support tower

- With difference equalisation for distortion-free work piece clamping
- Used in combination with multi-clamping and support tower
- Very heavy model
- Suitable for pre-tensioning heavy work pieces
- Fast and secure clamping
- Large adjustment range through combination with multi-clamping and support tower (see below)
- Clamping force ~ 20 kN
- Powder-coated



Description ▲ Application ▼

Compensating clamping arm ▲

Multi-clamping and support tower ▲ Description ▼



- For compensating clamping arm with hexagonal
- Bolts to the table
- Very sturdy version
- Can be combined with other system components such as stops thanks to system bores
- Blackened

Compensating clamping arm

28	A in mm	B in mm	~ Weight in kg	Item no.
	180	55	2.26	D28-05007-000

Multi-clamping and support tower

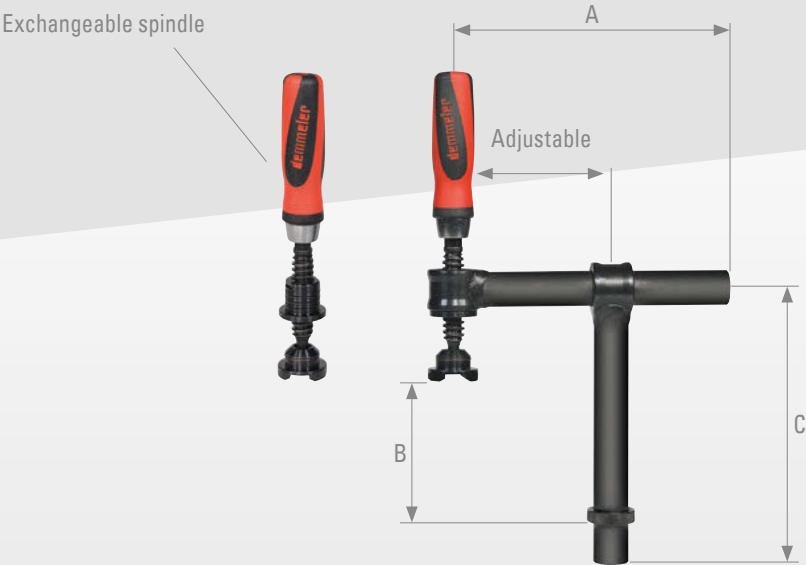
28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	150	55	200	100	4.00	D28-05004-003
	150	55	350	100	5.30	D28-05004-000
	150	55	700	100	8.38	D28-05005-000
	150	55	1000	100	11.00	D28-05006-000

Screw clamp 180° with spindle

With adjustable, sturdy round tube

Top seller

- Each tube can be used individually
- Adjustable projection
- Can be inserted through system bores, eliminating avoidable interfering edges
- Highest force transmission with sturdy round tubes
- Entire clamping mechanism is exchangeable



Description ▲

Application ▼



28	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	220	max. 190	270	2.80	D28-07005-000
	220	max. 270	350	3.10	D28-07005-014
	220	max. 420	500	3.80	D28-07005-033

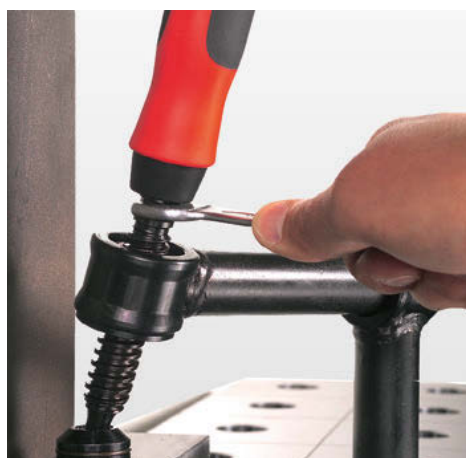
Screw clamp 180° with spindle



Application ▲

Clamping with hexagon wrench ▼

Application ▼

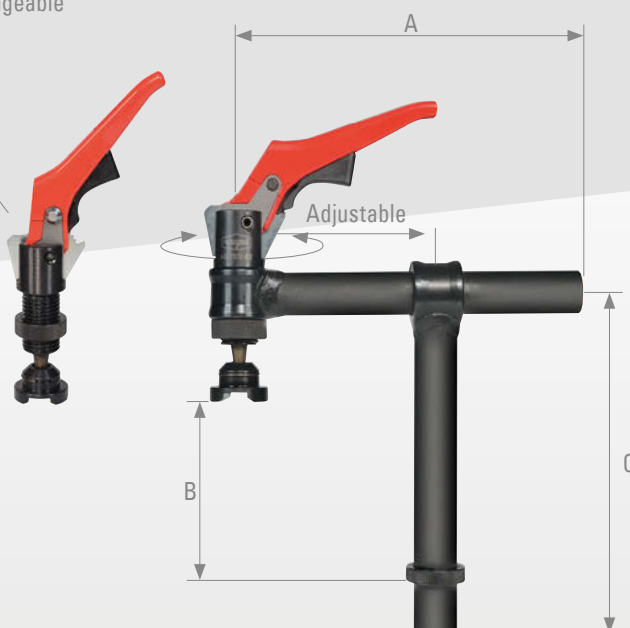


Screw clamp 180° with quick-action clamping cylinder

With adjustable, sturdy round tube

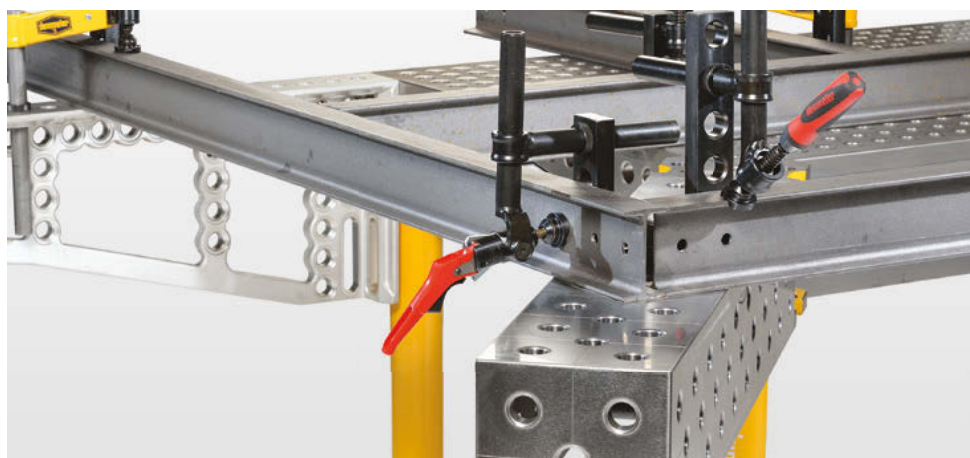
Quick release skewer, exchangeable

- Up to 5x faster clamping than conventional screw clamps
- Higher clamping forces quickly with little expenditure of energy
- 360° swivelling lever bypasses interfering edges
- Highest force transmission with sturdy round tubes
- Entire clamping mechanism is exchangeable
- Large 9 mm stroke



Description ▲ Benefits of the clamping cylinder ▼ Application ▼

- Secure locking mechanism: The locking mechanism ensures controlled, fast and vibration-proof clamping
- Ultimate stability: Enables the even build-up of clamping force with large power reserves. The self-centring support and pressure piece clamps the work piece and can be exchanged
- The powder-coated clamping lever features a highly ergonomic shape and swivels 360° degrees to circumvent all interfering edges. The plastic-coated, non-slip release lever ensures a secure grip while loosening the clamp
- Large stroke: 9 mm

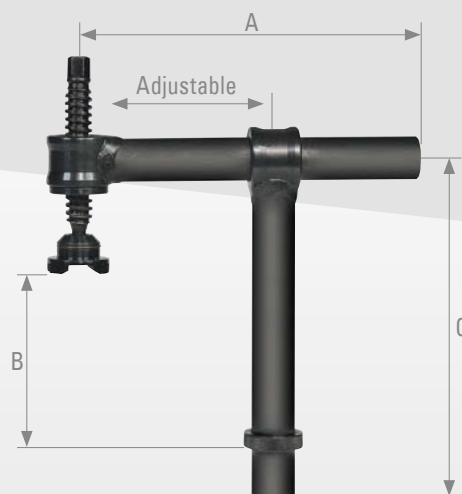


28	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	220	max. 190	270	2.50	D28-07005-001
	220	max. 270	350	2.80	D28-07005-015
	220	max. 420	500	3.40	D28-07005-041

Screw clamp 180° with short boring spindle

- Highest force transmission with sturdy round tubes
- Operation with open-end wrench AF 13
- Highly recommended for confined spaces
- Each tube can be used individually.
- Entire clamping mechanism is exchangeable

Exchangeable spindle



Description ▲ Application ▼

Application ▼

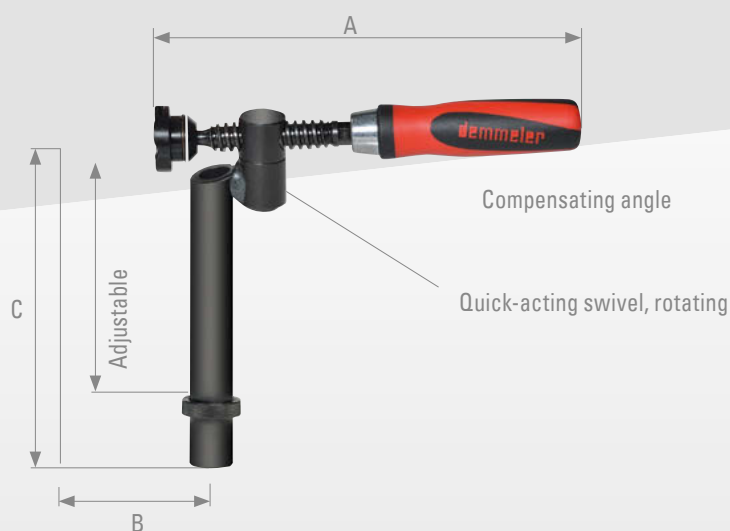


28	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	220	max. 190	270	2.10	D28-07005-002
	220	max. 270	350	2.30	D28-07005-016
	220	max. 420	500	3.00	D28-07005-036

Variable screw clamp 90°

Top seller

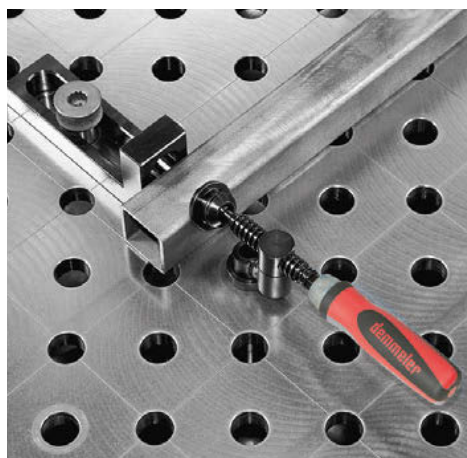
- Pressure direction 90° to the system bore
- Spindle stroke ~ 70 mm
- 180° quick-acting swivel with ball stop in the joint
- With stop ring for height fixation
- Use of clamping bridges possible
- Highest force transmission with sturdy round tube
- 180° quick-acting swivel with ball stop in the joint
- With stop ring for height fixation
- Clamping pad exchangeable



Description ▲ Application ▼

Application ▼

Application ▼

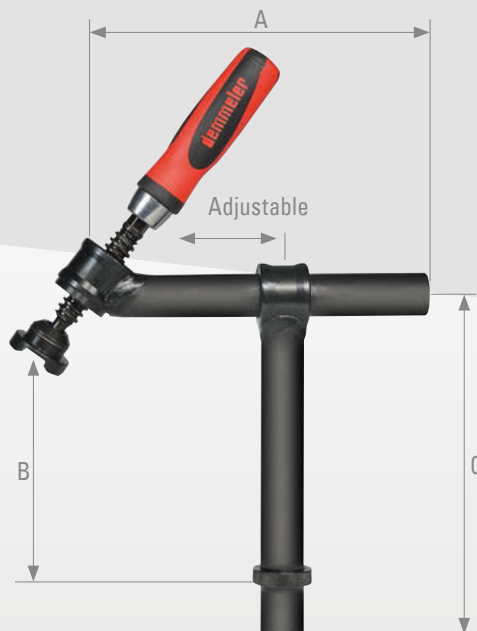


28	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	250	max. 100	220	1.22	D28-07008-000
	250	max. 100	350	1.65	D28-07008-010
	250	max. 100	500	2.08	D28-07008-012

Variable screw clamp 45° with spindle

- Highest force transmission with sturdy round tubes
- Ideal for clamping prismatic profiles as well as rectangular and square profiles
- Entire clamping mechanism is exchangeable

Exchangeable spindle



Description ▲

Application ▼



Perfect positioning on all locating surfaces thanks to optimum action of force!

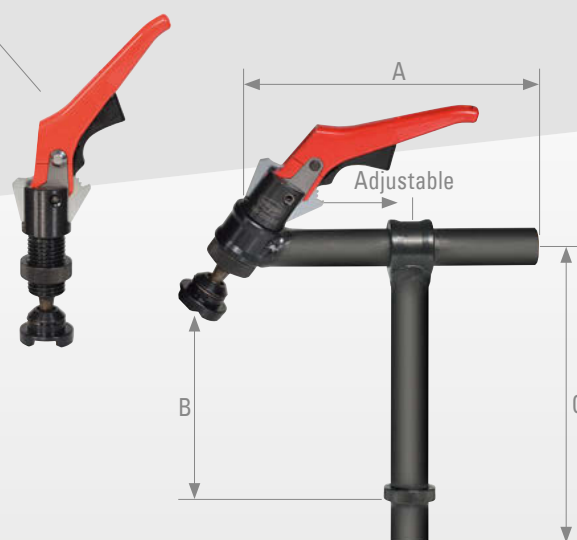
28	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	220	max. 190	270	2.80	D28-07009-000
	220	max. 270	350	3.00	D28-07009-011
	220	max. 420	500	3.70	D28-07009-026

Variable screw clamp 45° with quick-action clamping cylinder

With adjustable, sturdy, rotating round tube

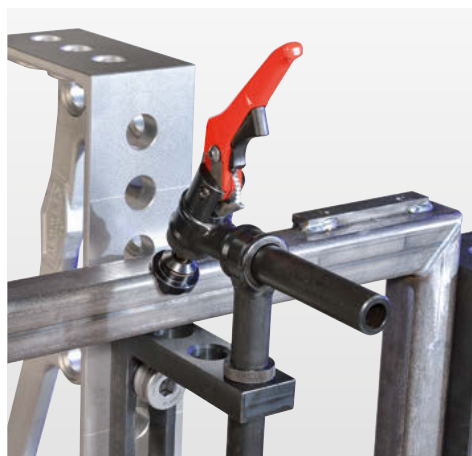
Quick release skewer, exchangeable

- Up to 5x faster clamping than conventional screw clamps
- Higher clamping forces quickly with little expenditure of energy
- 360° swivelling lever bypasses interfering edges
- Highest force transmission with sturdy round tubes
- Entire clamping mechanism is exchangeable
- Large 9 mm stroke



Description ▲ Application ▼

Application ▼



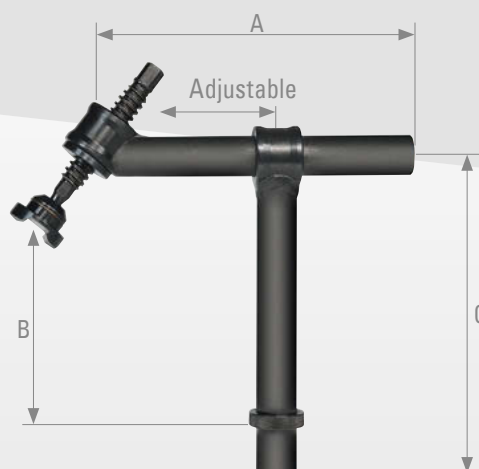
28	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	220	190	270	2.50	D28-07009-001
	220	270	350	2.70	D28-07009-012
	220	420	500	3.20	D28-07009-027

Variable screw clamp 45° with short boring spindle

With adjustable, sturdy, rotating round tube

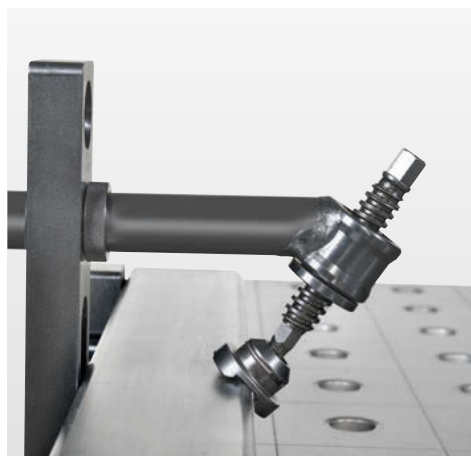
- Highest force transmission with sturdy round tubes
- Operation with open-end wrench AF 13
- Highly recommended for confined spaces
- Entire clamping mechanism is exchangeable

Exchangeable spindle



Description ▲ Application ▼

Application ▼

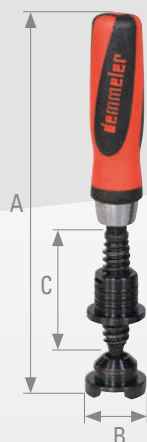


28	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	220	190	270	2.10	D28-07009-002
	220	270	350	2.30	D28-07009-013
	220	420	500	3.00	D28-07009-028

Adjustment screw with bushing and clamping pads

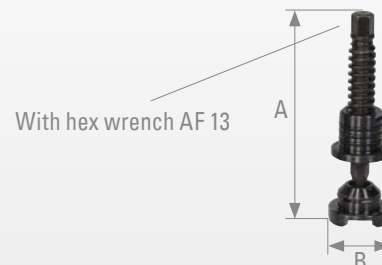
Short boring spindle with bushing and clamping pads

- High-quality 2-component plastic handle
- Long threaded spindle
- Threaded bushing works with any system bore
- Exchangeable clamping pad (plastic, stainless steel - see page 298)
- Suitable to pretension work pieces



Clamping pad with cross prism

- Highly recommended for confined spaces
- Operation with open-end wrench AF 13
- Direct use in system bores possible
- Ideal to pretension work pieces



Clamping pad with cross prism

Description ▲ Application ▼



Description ▲ Application ▼



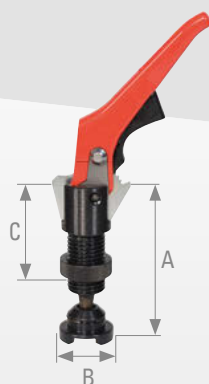
28	A in mm	Ø B in mm	C in mm	~ Weight in kg	Item no.
	~ 255	40	70	0.5	D28-07020-000

28	A in mm	Ø B in mm	~ Weight in kg	Item no.
	138	40	0.36	D28-07022-000

Quick-action clamping cylinder with clamping pads

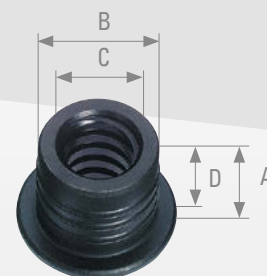
Adapter for PC-bolts D28 to D16

- Up to 5x faster clamping than conventional screw clamps
- The locking mechanism ensures controlled, fast and vibration-proof clamping
- Higher clamping forces quickly with little expenditure of energy
- Large 9 mm stroke
- The self-centring support and pressure piece clamps the work piece and can be exchanged
- The powder-coated clamping lever features a highly ergonomic shape
- The plastic-coated, non-slip release lever ensures a secure grip while loosening the clamp



Clamping pad with cross prism

- Used to hold Ø 16 mm screw clamps in D28 system bores
- D16 quick-action clamping cylinder can be used in system D28
- Can be used as support or stop simultaneously
- Threaded bushing for D28 screw clamp



Description ▲ Application ▼



Description ▲ Application ▼

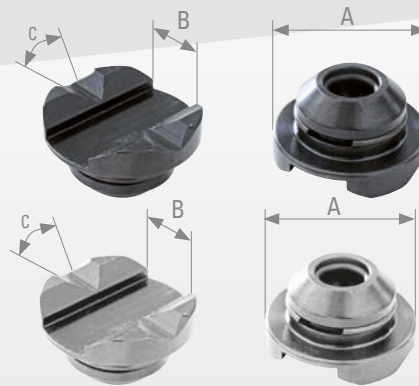


28	A in mm	Ø B in mm	C in mm	~ Weight in kg	Item no.
	~ 105+9	40	70	0.88	D28-07021-004

28	A in mm	Ø B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	30	28	16	25	0.10	D00-06012-000

Plunger and contact piece / clamping pad with V-block

- Clamping pad with V-block



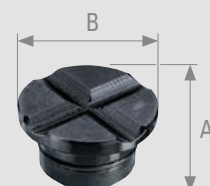
Description ▲	Application ▼	
Flat upright positioning 	Self-centring clamping on the work piece 	Also as contact piece in the system bore
Clamping larger diameters without problems 	No slipping and tipping possible 	... no matter where the force is applied! No slipping

Plunger and contact piece / clamping pad with V-block

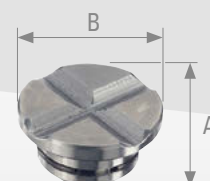
28	A in mm	B in mm	C in °	Description	Qty.	Item no.
	40	15.5	120	Steel, blackened	1 piece	D28-07011-022
	40	15.5	120	Steel, blackened	10 piece	D28-07011-023
	40	15.5	120	Aluminium	1 piece	D28-07011-025
	40	15.5	120	Aluminium	10 piece	D28-07011-026

- Lightning-fast replacement: no tools, no screws
- O-ring prevents dirt from getting into the joint
- Produced in various materials
- Exact work piece support thanks to pendulum compensation
- With cross prism for clamping round / rectangular tubes
- Can also be used as a support in any system bore

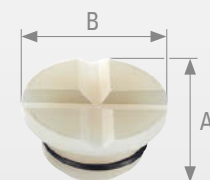
Steel, blackened



Stainless steel

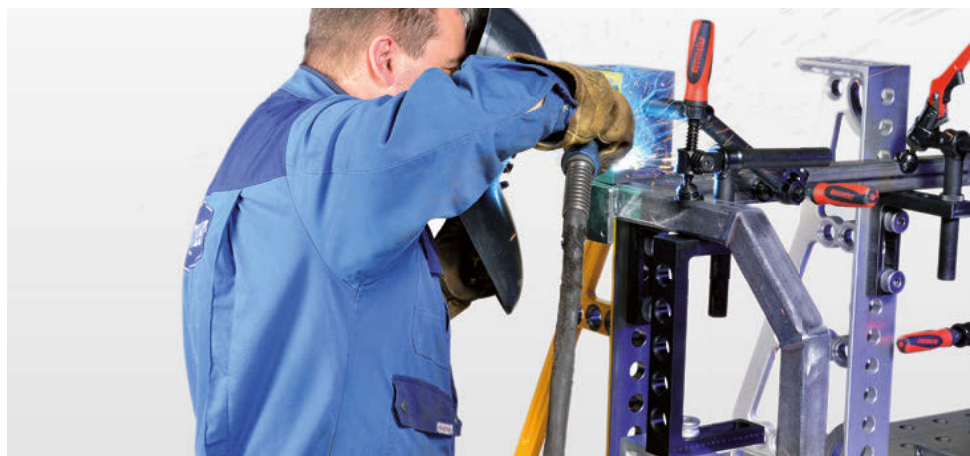


POM



Description ▲

Application ▼

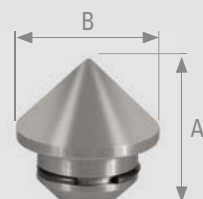


28	A in mm	Ø B in mm	~ Weight in kg	Description	Item no.
	22	40	0.10	Steel, blackened	D28-07011-000
	22	40	0.10	Stainless steel	D28-07011-001
	22	40	0.018	POM	D28-07011-002

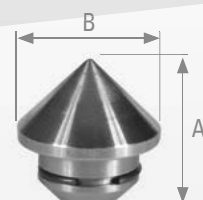
Plunger and contact piece with taper

- Lightning-fast replacement: no tools, no screws
- O-ring prevents dirt from getting into the joint
- Produced in various materials
- Exact work piece support thanks to pendulum compensation
- With 90° taper to clamp tubes on the interior diameter $\varnothing 10 - \varnothing 58$ mm

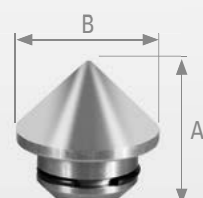
Steel, hardened



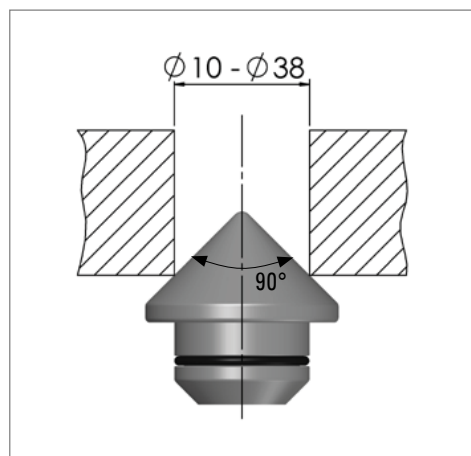
Stainless steel



Aluminium



Description ▲



28	A in mm	Ø B in mm	~ Weight in kg	Angle	Description	Item no.
	40	40	0.16	90°	Steel, hardened	D28-07011-027
	40	40	0.16	90°	Stainless steel	D28-07011-028
	40	40	0.16	90°	Aluminium	D28-07011-029

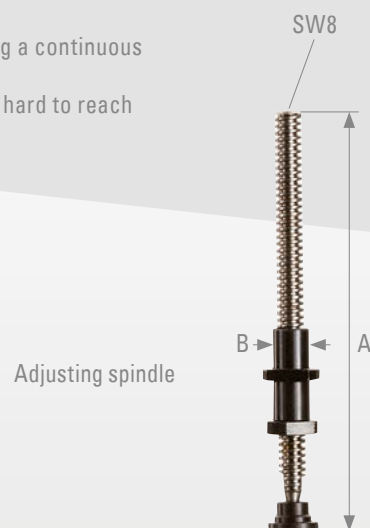
Clamping pad blackend steel -doubleside

- Lightning-fast replacement: no tools, no screws
- O-ring prevents dirt from getting into the joint
- Exact work piece support thanks to pendulum compensation
- With cross prism for clamping round / rectangular tubes
- Can also be used as a support in any system bore
- Double-sided application



Adjusting spindle

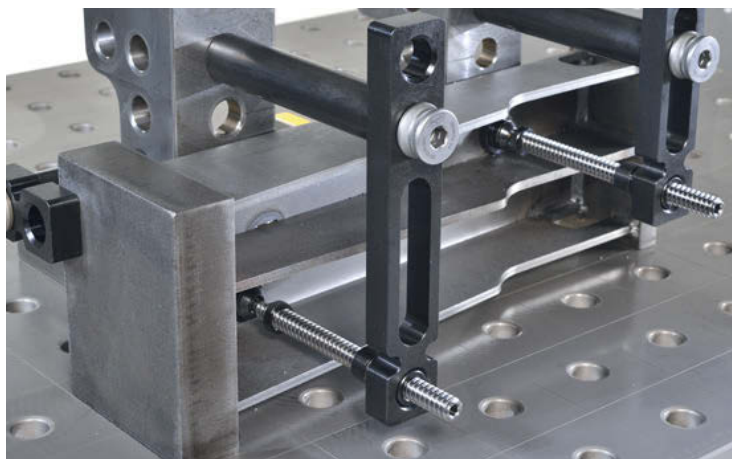
- For adjusting a continuous support
- Clamping in hard to reach positions



Description ▲ Application ▼



Description ▲ Application ▼

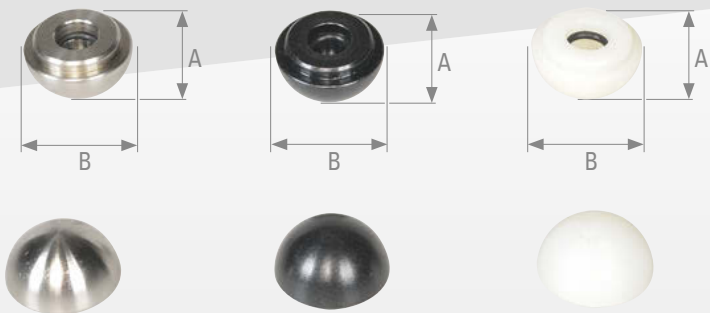


28	A in mm	B in mm	~ Weight in kg	Item no.
	25	40	0.11	D28-07011-010

28	A in mm	B in mm	~ Weight in kg	Item no.
	255	28	0.64	D28-09008-000

Clamping pad with ball form

- Lightning-fast replacement: no tools, no screws
- O-ring prevents dirt from getting into the joint
- Produced in various materials
- With ball, specially for clamping corner profiles
- Clamping pad compensates angle errors
- Exact work piece support thanks to pendulum compensation



Description ▲ Application ▼



28	A in mm	Ø B in mm	~ Weight in kg	Description	Item no.
	21	35	0.09	Steel, blackened	D28-07011-004
	21	35	0.09	Stainless steel	D28-07011-005
	21	35	0.014	POM	D28-07011-006
	21	35	0.035	Aluminium	D28-07011-020

- For customer-specific adaptation
- Locations for Demmeler system screw clamps already included
- Steel, blackened



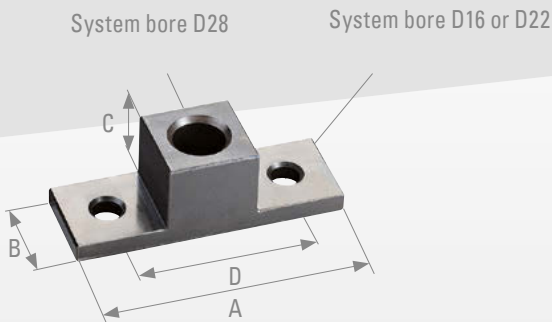
Description ▲

28	A in mm	Ø B in mm	~ Weight in kg	Description	Item no.
	35	50	0.32	Steel, blackened	D28-07014-000



Reduction plate for clamping tubes D28 to D16 / D22 to D28

- Interface between system 28 and system 16 or system 28 and system 22



Description ▲ Application ▼



Reduction plate for clamping tubes D28 to D16

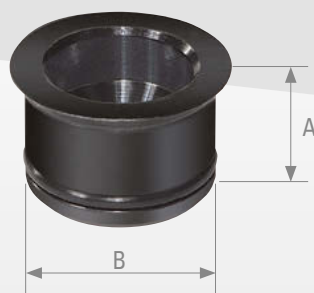
28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	150	50	50	100	1.04	D00-06015-000

Reduction plate for clamping tubes D28 to D22

28	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	150	50	50	100	1.2	D00-06015-001

Adapter for PC-bolt D28 to D16

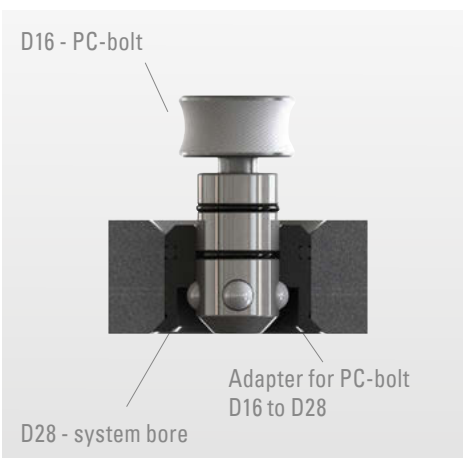
- Interface between system D28 and D16
- Fully compatible with system D28 and D16
- Force-fit and form-fitting with O-ring, self-centring connection
- O-ring prevents simultaneous rotation while tightening
- O-ring cleans the system bore



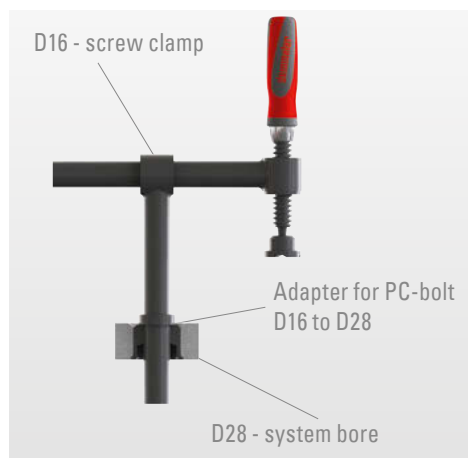
Description ▲ Application ▼



Application ▼



Application ▼



Adapter for PC-bolt D28 to D16

28	A in mm	Ø B in mm	~ Weight in kg	Item no.
	20.5	28-0.02	0.05	D00-06010-002

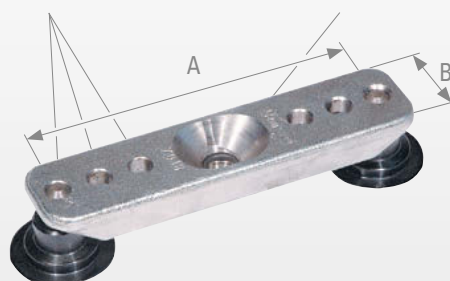
2P. 2P clamping bridge with 2 clamping pads, steel

- Two clamping points simultaneously
- Clamping in hard to reach positions
- Simultaneous clamping of more than one component
- Clamping of uneven surfaces with pendulum compensation
- Clamping pad distance displaceable with self-locking ball pins
- Exchangeable clamping pad
- For attachment to any ball holder
- Very sturdy design
- Scope of delivery: Clamping bridge, 2 ball pins and 2 clamping pads (steel)

OUR IDEAS – YOUR BENEFITS!

- Two clamping points
- Clamping uneven surfaces or 2 different heights
- Clamping pad exchangeable
- Adjustable clamping width
- Galvanised

Displaceable clamping points Suitable for screw clamp spindle



Description ▲ Application ▼

Round tubes or flat stock ▼

Clamping bridge ▼



28

A in mm
130/97/65

B in mm
35

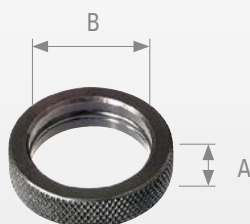
~ Weight in kg
0.56

Item no.
D28-07018-000

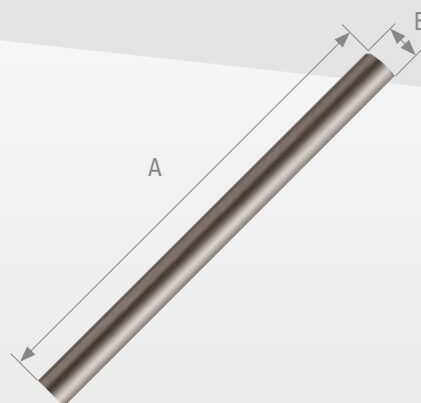
VARIO stop ring for round screw clamp tubes

Clamping tube

- For height fixation of screw clamps
- Included in the scope of delivery for all round tube screw clamps



- Precision clamping tube to fit all system bores
- e.g. for compensating swing clamps (starting on page 280)



Description ▲ Application ▼



Description ▲

28	A in mm	Ø B in mm	~ Weight in kg	Item no.
	10	28	0.034	D28-07003-000

28	A in mm	Ø B in mm	~ Weight in kg	Item no.
	200	28	0.57	D28-07004-000
	350	28	1.00	D28-07004-001
	600	28	1.70	D28-07004-002
	1000	28	2.85	D28-07004-003

Angle bushing 90°

Angle bushing 45°

- Can be used as corner stop
- Axis distance 50 mm



- Can be used as corner stop
- Axis distance 50 mm



Description ▲

Description ▲ Application ▼



28	A in °	Ø B in mm	~ Weight in kg	Item no.
	90	28	0.28	D28-07034-000

28	A in °	Ø B in mm	~ Weight in kg	Item no.
	45	28	0.26	D28-07035-000

Angle bushing 90°

with precision scaling in 15° increments

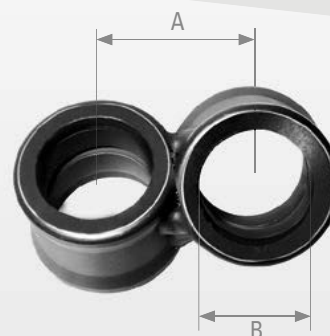
- User-friendly 360° precision scaling
- Especially handy in combination with toggle clamps (starting on page 312)
- Can also be used in combination with short or normal spindle with threaded bushing
- Axis distance 38 mm



Angle bushing 45°

with precision scaling in 15° increments

- User-friendly 360° precision scaling
- Especially handy in combination with toggle clamps (starting on page 312)
- Can also be used in combination with short or normal spindle with threaded bushing
- Axis distance 38 mm



Description ▲ Application ▼



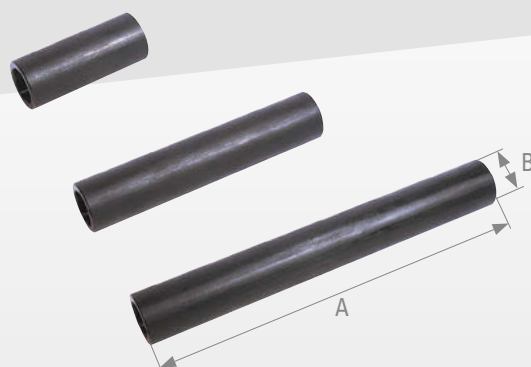
Description ▲

28	A in mm	Ø B in mm	~ Weight in kg	Item no.
	38	28	0.31	D28-07034-010

28	A in mm	Ø B in mm	~ Weight in kg	Item no.
	38	28	0.31	D28-07035-010

Adapter-tube

- Extension of support and clamping points
- Adaptable with screw clamp tube
- Clamping on both sides possible with PC-bolt



Description ▲ Application ▼

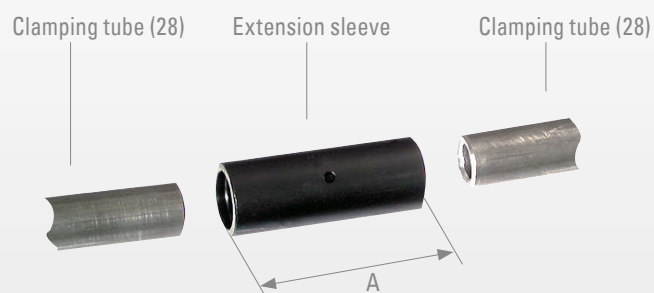
Adapter-tube 200 mm with screw clamp ▼



28	A in mm	Ø B in mm	~ Weight in kg	Item no.
	100	28 / 40	0.36	D28-09010-000
	200	28 / 40	0.6	D28-09010-001
	300	28 / 40	0.85	D28-09010-002

Extension sleeve

- As connecting piece between two clamping tubes
- As connecting piece between screw clamp and clamping tube
- Blackened



Ball clamp bushing with countersunk head

- High-quality stainless steel pressure piston
- Self-locking in any position with O-ring
- 4 mm stroke
- 120 N clamping force



Description ▲ Application ▼



Description ▲ Application ▼

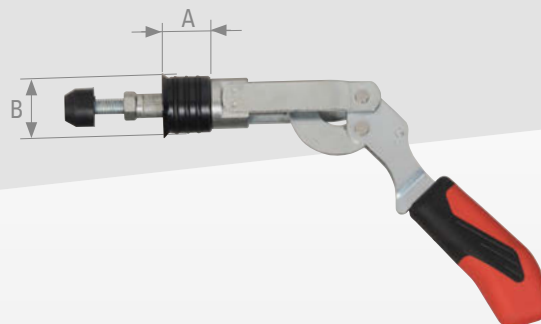


28	A in mm	Ø B in mm	~ Weight in kg	Item no.
	100	28 / 34	0.36	D28-07010-000

28	A in mm	Ø B in mm	Description	Item no.
	43	28	with countersunk head	D28-07017-010

Toggle clamp with threaded bushing with large stroke 32 mm

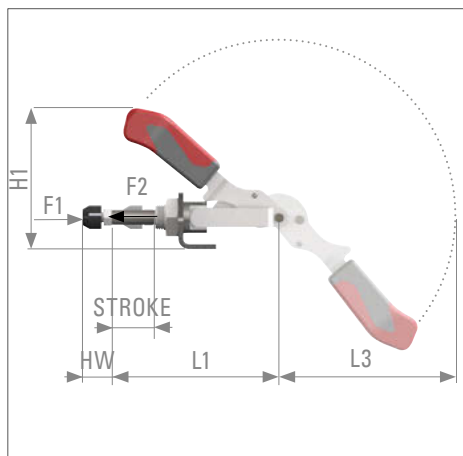
- Long toggle clamp guide with mounting thread and nut
- Ergonomic, oil-resistant handle with large grip and soft component
- With tempered, galvanised clamping screw
- Includes threaded bushing for use in any system bore
- 32 mm stroke
- Toggle clamp galvanised and passivated, adapter blackened



For all D28 system bores

Description ▲ Toggle clamp ▼

Application ▼



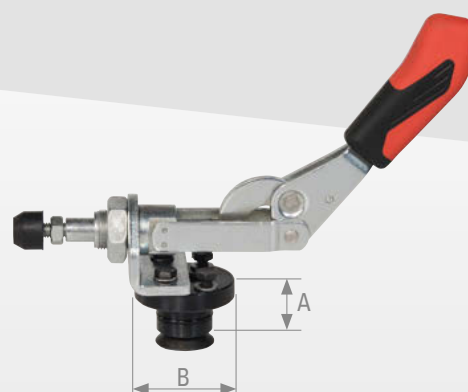
28	A in mm	B Ø in mm	~ Weight in kg	Item no.
	30	28	0.4	D28-08000-000

Toggle clamp data

28	H1	L1	L3	HW	STROKE	F1 in kN	F2 in kN
	110	140	129	22 to 35	32	2.5	2.5

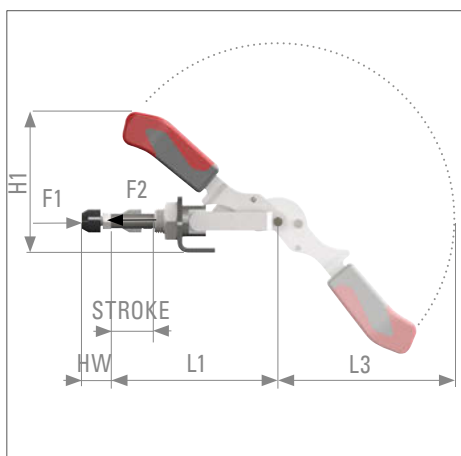
Toggle clamp with adapter and countersunk screw

- Long toggle clamp guide with mounting thread and nut
- Ergonomic, oil-resistant handle with large grip and soft component
- With tempered, galvanised clamping screw
- 32 mm stroke
- With adapter and countersunk screw to fit any system bore
- Toggle clamp galvanised and passivated, adapter blackened
- With universal stop for indirect locations, therefore continuously adjustable



Description ▲ Toggle clamp ▼

Application ▼



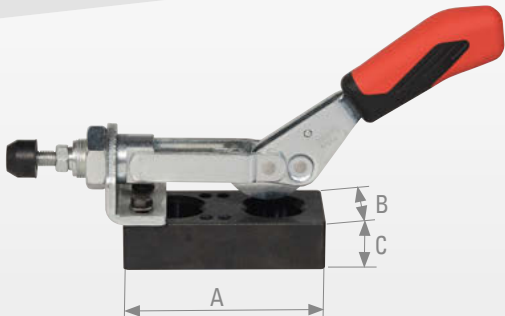
28	A in mm	B Ø in mm	Description	~ Weight in kg	Item no.
	27	50	Thread spacing = 32x20 mm	0.74	D28-08002-000

Toggle clamp data

28	H1	L1	L3	HW	STROKE	F1 in kN	F2 in kN
	110	140	129	22 to 35	32	2.5	2.5

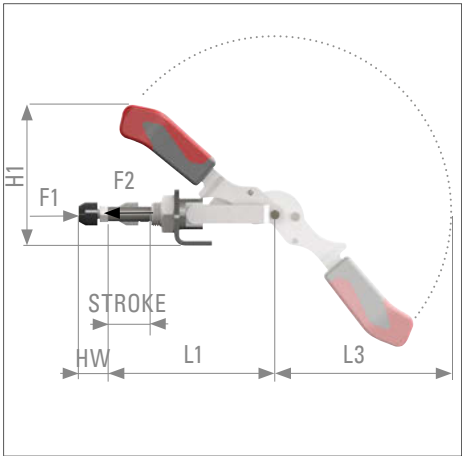
Universal toggle clamp

- Long toggle clamp guide with mounting thread and nut
- Ergonomic, oil-resistant handle with large grip and soft component
- With tempered, galvanised clamping screw
- 32 mm stroke
- Includes universal stop with thread for displacing the toggle clamp
- Toggle clamp galvanised and passivated, stop blackened



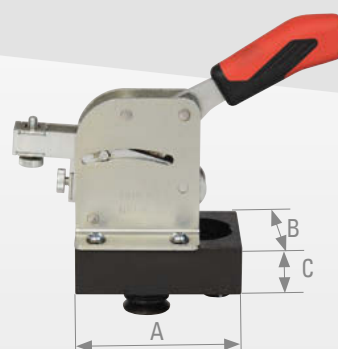
Description ▲ Application ▼

Toggle clamp ▼



28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.		
	100	50	25	1.08	D28-08001-010		
Toggle clamp data							
28	H1	L1	L3	HW	STROKE	F1 in kN	F2 in kN
	110	140	129	22 to 35	32	2.5	2.5

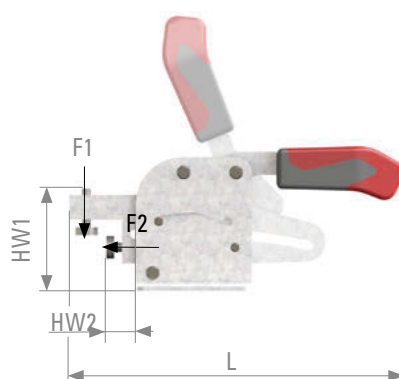
- Positioning and clamping in one process step
Explanation: The combination clamp converts the movement of the lever arm to a horizontal and vertical clamping movement, so the work piece is positioned and clamped simultaneously for tremendous potential savings.
- Robust and stable design
- Easy removal of the work piece by fully retracting the clamping arm
- With adapter to fit any system bore Continuously adjustable
- Toggle clamp galvanised and passivated, adapter blackened



Description ▲ Application ▼

2-point clamp with adaptor ▼

Adaptor ▼



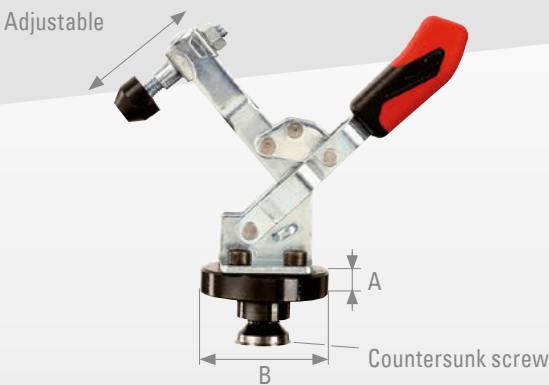
28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	100	70	30	1.8	D28-08007-000

Data - 2-point clamp with adaptor

28	H1	H2	L1	HW1	HW2	F1 in kN	F2 in kN
	94	87	219	30 to 40	10 to 20	2	2

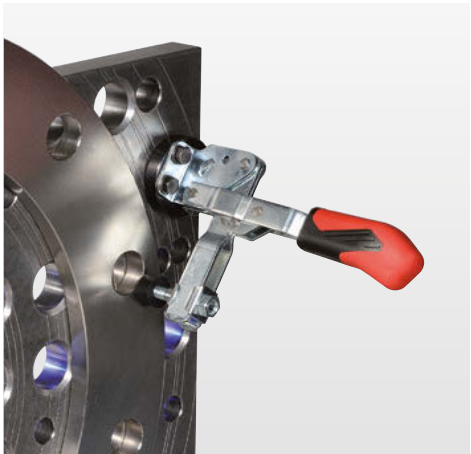
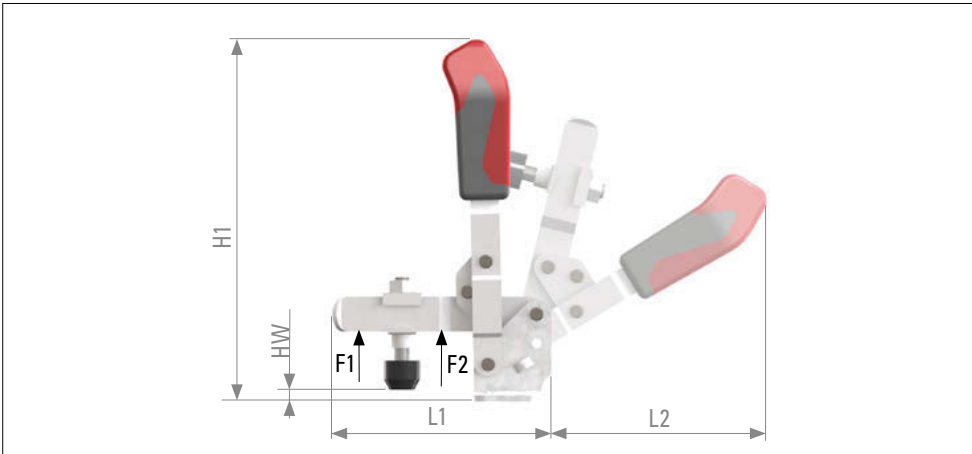
Vertical toggle clamp with adaptor and countersunk screw

- With open support arm and horizontal leg
- Ergonomic, oil-resistant handle with large grip and soft component
- Safety clamping piece with finger protection
- Captive clamping screw at clamping arm end
- With adapter and countersunk screw to fit any system bore
- Clamping range 0-50 mm
- Toggle clamp galvanised and passivated, adapter blackened
- With universal stop for indirect locations, therefore continuously
- Adjustable



Description ▲ Vertical toggle clamp ▼

Application ▼



28	A in mm	B Ø in mm	Description	~ Weight in kg	Item no.
	27	50	Thread spacing = 32x20 mm	0.74	D28-08001-000

Data - vertical toggle clamp

28	H1	L1	L2	HW	F1 in kN	F2 in kN
	186	112	112	2 to 11	1.1	2.5

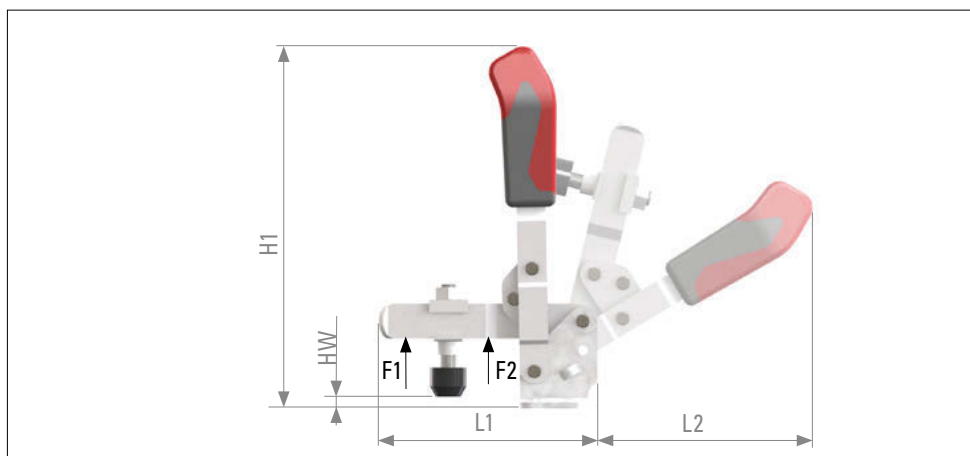
Vertical toggle clamp with universal stop

- With open support arm and horizontal leg
- Greased bearing points
- Ergonomic, oil-resistant handle with large grip and soft component
- Safety clamping piece with finger protection
- Captive clamping screw at clamping arm end
- Clamping range 0-50 mm
- Includes universal stop with thread for displacing the vertical toggle clamp
- Toggle clamp galvanised and passivated, adapter blackened



Description ▲ Application ▼

Vertical toggle clamp ▼



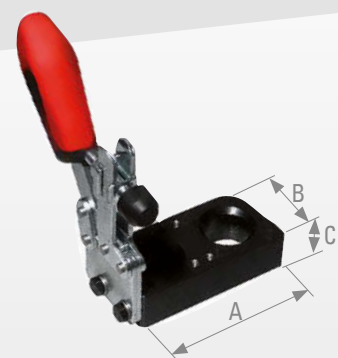
28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	100	50	25	0.98	D28-08003-010

Data - vertical toggle clamp

28	H1	L1	L2	HW	F1 in kN	F2 in kN
	186	112	112	2 to 11	1.1	2.5

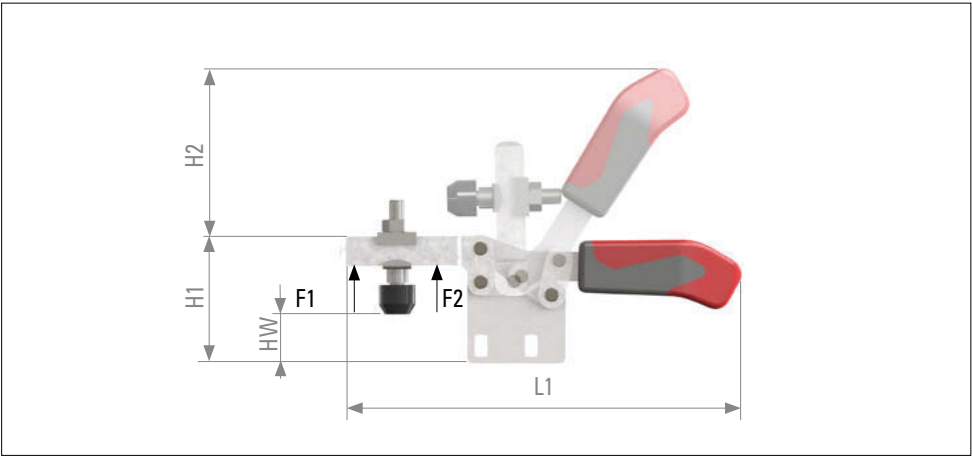
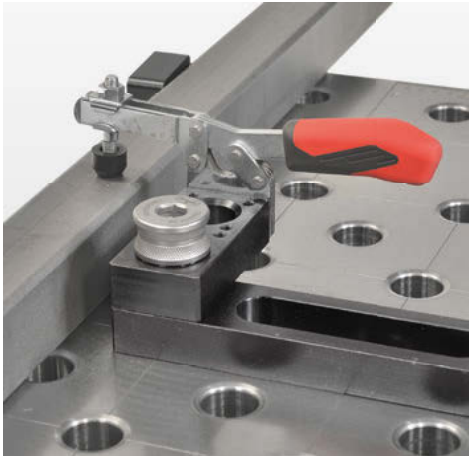
Horizontal toggle clamp with universal stop

- With open support arm and vertical leg
- Greased bearing points
- Ergonomic, oil-resistant handle with large grip and soft component
- With captive clamping screw
- Includes universal stop with thread for displacing the horizontal toggle clamp
- Toggle clamp galvanised and passivated, stop blackened



Description ▲ Application ▼

Horizontal toggle clamp ▼



28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	100	50	25	0.98	D28-08002-010

Data - horizontal toggle clamp

28	H1	L1	L2	HW	F1 in kN	F2 in kN
	65	86	206	14.5 to 26	1.8	2.5

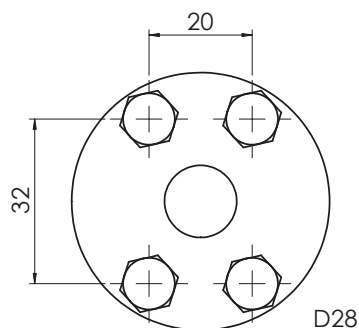
Adapter for toggle clamps with countersunk screw

- Adapter to fit conventional quick release skewers
- Scope of delivery: 1 x adapter, 4 x Allen screw M6 x 12, 1 x countersunk screw M16 x 30



Description ▲ Application ▼

Adapter for toggle clamps with countersunk screw ▼



28	A in mm	B Ø in mm	~ Weight in kg	Description	Item no.
	27	50	0.26	Thread spacing = 32 x 20 mm	D28-08005-000

Pneumatic toggle clamp S

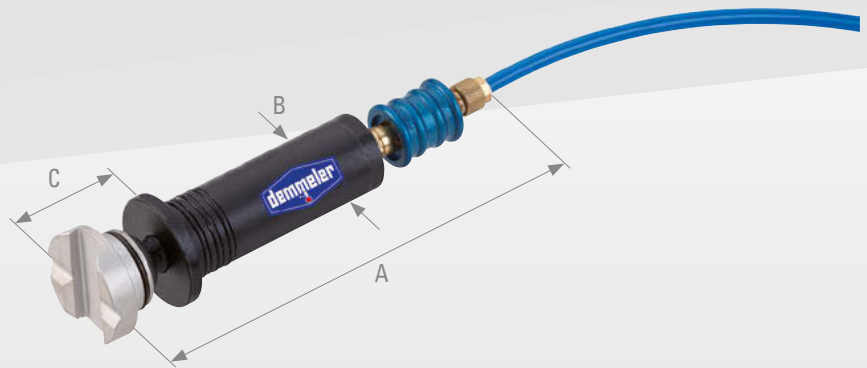
Automate your clamping system

- Single-action pneumatic cylinder
- With compression spring retraction and 3/2-way valve!
- Fits all D28 bores
- Stroke 30 mm

Force:

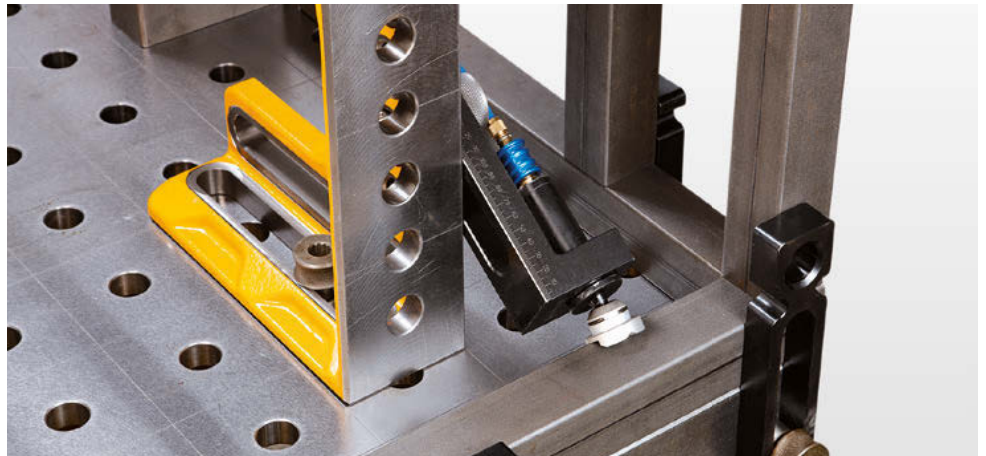
$F_6 = 41 \text{ N at 6 bar}$
 $F_8 = 117 \text{ N at 8 bar}$
 $F_{10} = 193 \text{ N at 10 bar}$
 $F_{20} = 573 \text{ N at 20 bar}$
 $F_{30} = 953 \text{ N at 30 bar}$
 $F_{40} = 1146 \text{ N at 40 bar}$

- Recommended accessory, pressure force booster
page 323



Description ▲

Application ▼



28	A in mm	Ø B in mm	C in mm	Item no.
	159	28	34	D28-13010-000

- Single-action pneumatic cylinder
- With compression spring retraction and 3/2-way valve!
- Fits D28 bore with quick adjustment and 35 mm grid
- Stroke 40 mm

Force:

$F_6 = 680 \text{ N}$ at 6 bar

$F_8 = 931 \text{ N}$ at 8 bar

$F_{10} = 1182 \text{ N}$ at 10 bar

$F_{20} = 2364 \text{ N}$ at 20 bar

$F_{40} = 4728 \text{ N}$ at 40 bar



Description ▲ Application ▼

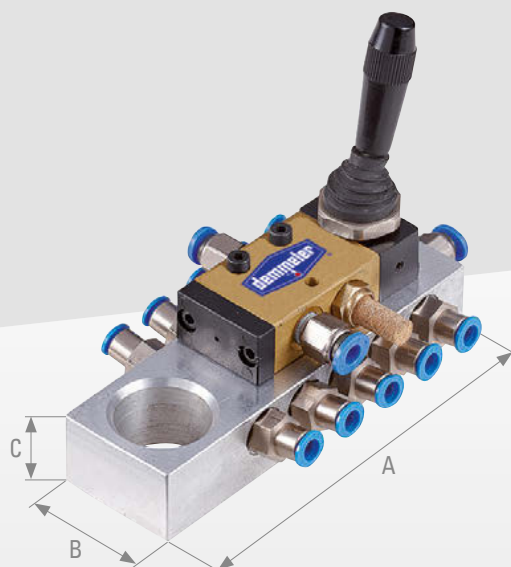
Application ▼



28	A in mm	Ø B in mm	C in mm	Item no.
	193	50	33.52	D28-13015-000

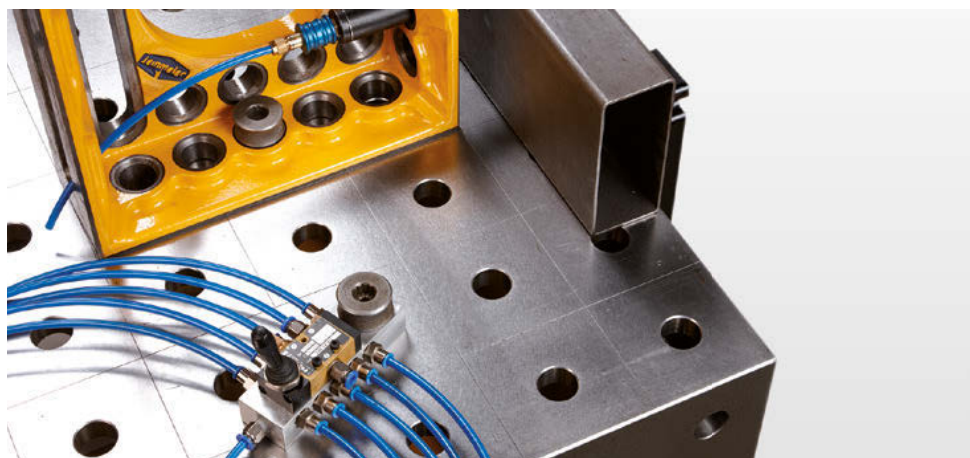
Manifold with hand valve

- 10-connection valve block with 1/8" non-return valve
- Hand valve: 3/2-way valve 1/8"
- Includes 20 m hose



Description ▲

Application ▼



28	A in mm	B Ø in mm	C in mm	Item no.
	130	40	25	D28-13020-000

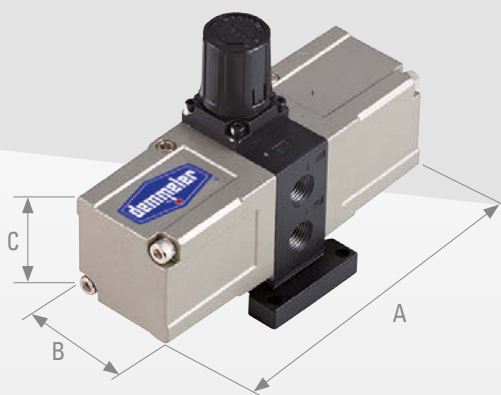


OUR PERFORMANCE
makes THE DIFFERENCE

Pneumatic toggle clamp

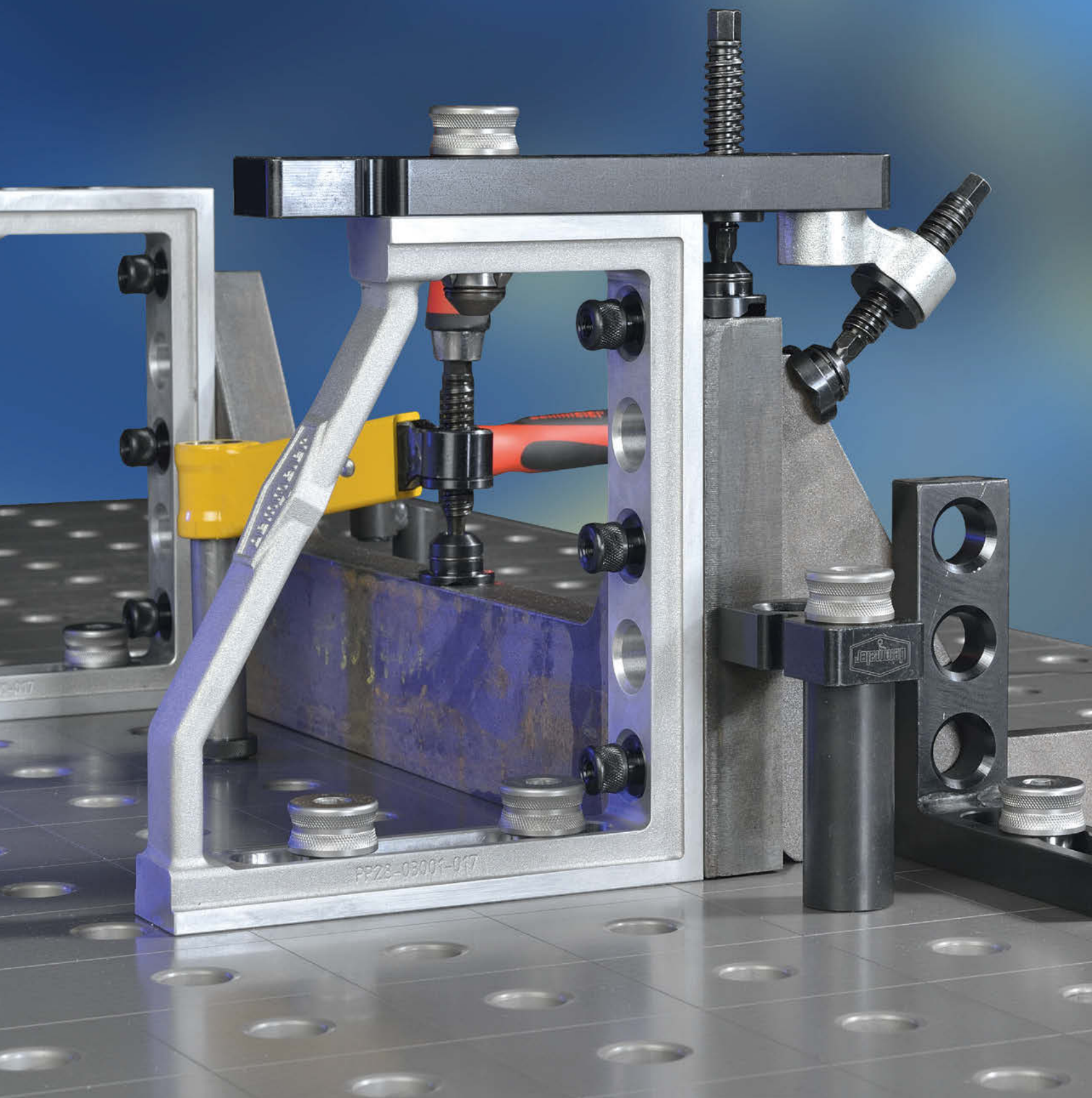
Pressure force booster

- For doubling or quadrupling the pneumatic clamping force:
Pressure booster 2 : 1 max. 20 bar
Pressure force booster 4: 1 max. 41 bar
- Includes couplings and hoses

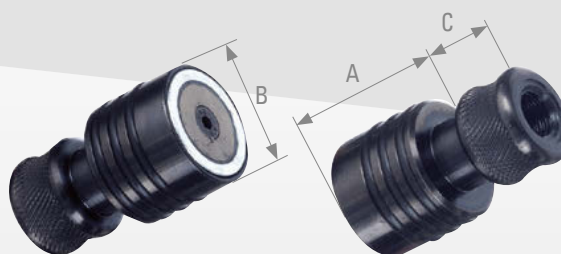


Description ▲

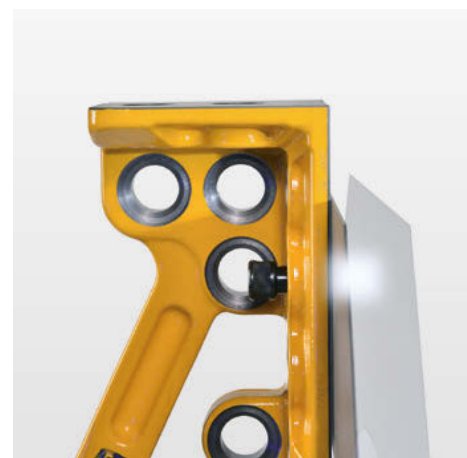
28	A in mm	B in mm	C in mm	Description	Item no.
	150	50	65	2 : 1	D28-13020-001
	200	150	140	4 : 1	D28-13020-002



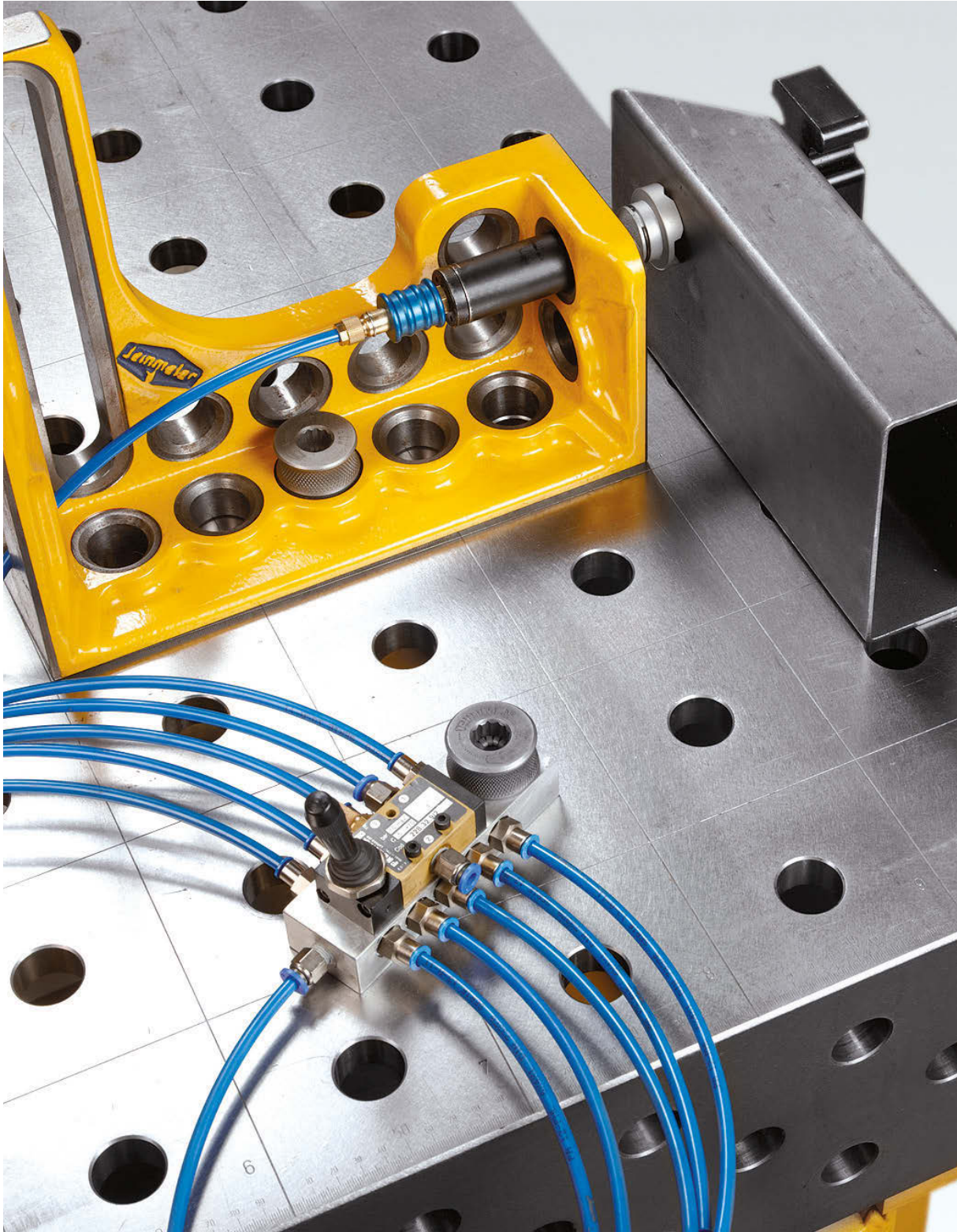
- Direct use in all system bores
- Holding force ~ 70 N



Description ▲ Application ▼



28	A in mm	Ø B in mm	C in mm	~ Weight in kg	Item no.
	24	28	25	0.16	D28-13001-002
	47	28	25	0.26	D28-13001-003



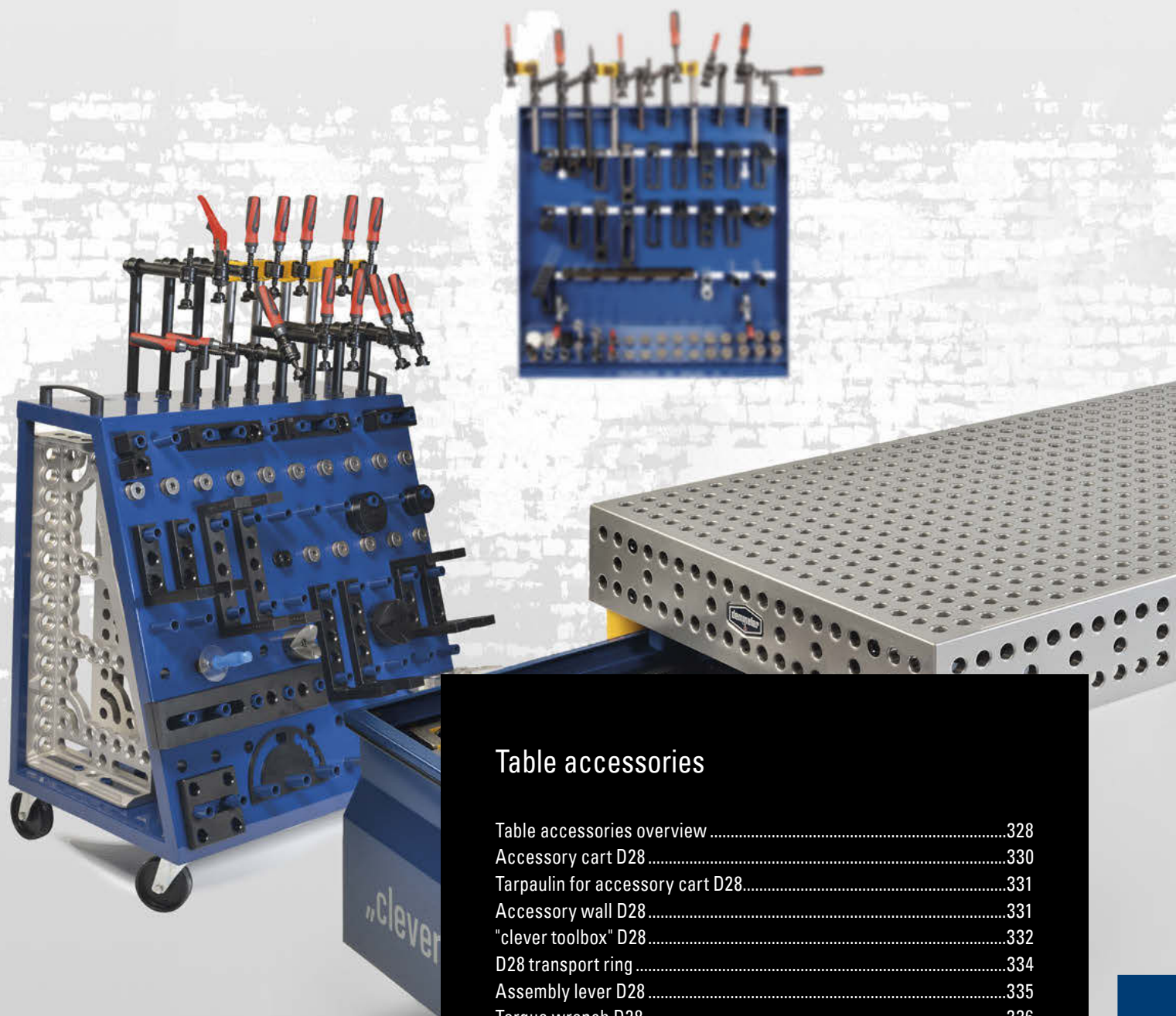


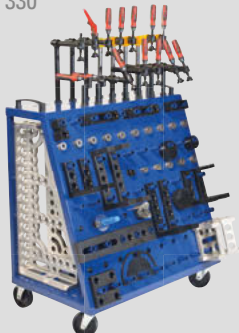
Table accessories

Table accessories overview	328
Accessory cart D28	330
Tarpaulin for accessory cart D28	331
Accessory wall D28	331
"clever toolbox" D28	332
D28 transport ring	334
Assembly lever D28	335
Torque wrench D28	336
Allen key D28	337
Allen key with cross-handle D28	337
Round brush D28	338
Protective plate for PROFIPremiumLINE (PP) worktable D28	339
Protective plate for PROFIPlusLINE (PL) worktable D28	340
Protective plate for PROFIEcoLINE (PE) worktable D28	341
Ground connector	342
Bench stone	343
Tarpaulin	343
Pump bottle with worktable system protective spray	344
Worktable system protective spray in a canister	344

Table accessories overview

28 Accessory cart

PAGE 330



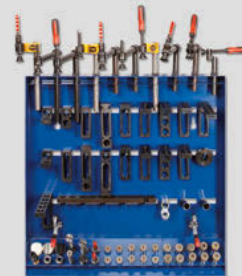
28 Tarpaulin for accessory cart

PAGE 331



28 Accessory wall

PAGE 331



28 clever toolbox

PAGE 332



28 Transport ring

PAGE 334



28 Assembly lever

PAGE 335



28 Torque wrench

PAGE 336



28 Allen key

PAGE 337



Allen key with cross-handle

PAGE 337



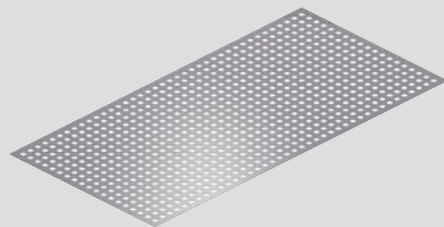
28 Round brush

PAGE 338



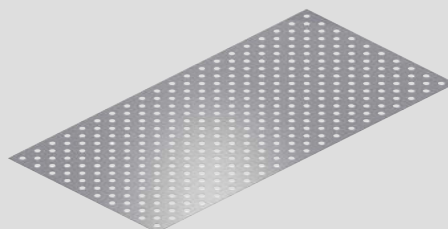
28 Protective plate for worktable PP

PAGE 339



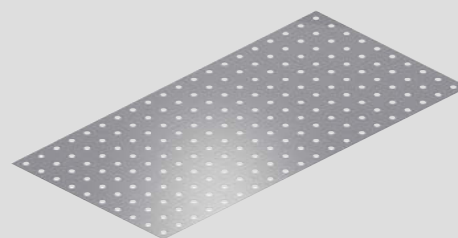
28 Protective plate for worktable PL

PAGE 340



28 Protective plate for worktable PE

PAGE 341





OUR PERFORMANCE
makes THE DIFFERENCE

Table accessories overview

Ground connector

PAGE 342



Bench stone

PAGE 343



Worktable tarpaulin

PAGE 343



Pump bottle with protective spray

PAGE 344



Protective spray in a canister

PAGE 344



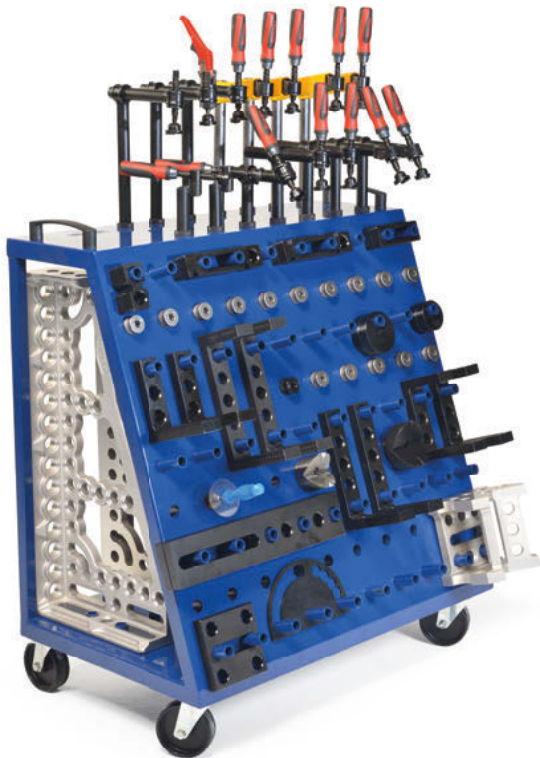
Accessory cart D28

- Establishes a tidy and orderly workstation
- Faster access to the system components
- Large angles are safely and conveniently stored inside the cart
- Fast to transport thanks to four sturdy 360° swivelling casters, one of them locking.



Description ▲ Application ▼

Application ▼



System components not included

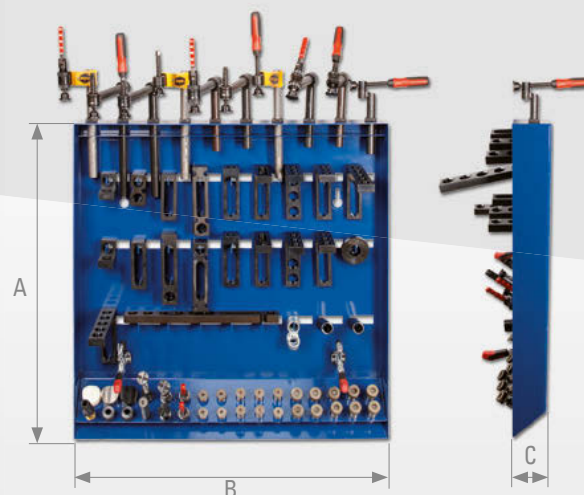
28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	~ 1000	~ 650	~ 1010	60	D28-11001-000

Tarpaulin for accessory cart

- Very sturdy tarpaulin
- Protects your accessory cart against dirt and wetness
- Firmly sewn at the corners
- Front with 2 robust zippers for removal The front can be removed without the entire tarpaulin
- For accessory cart D28-11001-000



Accessory wall, to mount on the wall or table



Description ▲ Application ▼

Description ▼ Application ▲

- Establishes a tidy and orderly workstation
- The accessory wall can either be mounted on the table with 2x D28-06001-000 PC-bolts (see page 178) or on the wall.



System components not included

28	A in mm	B in mm	C in mm	Item no.
-	-	-	-	D28-11001-020

System components not included

28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
~ 1010	1000	~ 105	45		D28-11001-010

"clever toolbox"

To make sure your tools are always where you need them!

"clever toolbox"

Ingenious, a clever extendible accessory box! Saves space, saves time, protects tools, lockable.
(LxWxH: 980 mm x 780 mm x 520 mm)



Lock

- Mounting of the "clever toolbox" using connecting bolts on the side stanchions.
- Retrofitting older table models is possible!



10 locking pins, bottom are included in the scope of delivery.

28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	980	780	520	65	D28-11001-015

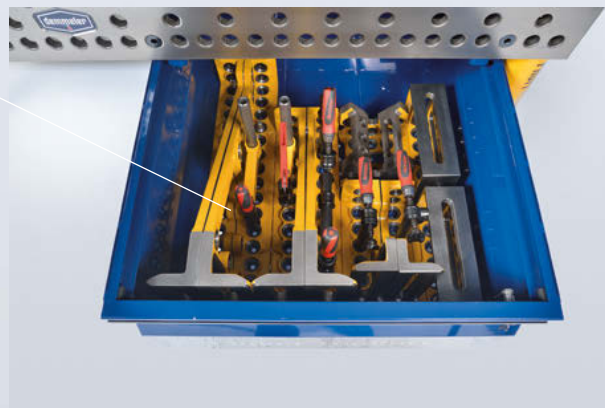
From a table size of 1000 x 1000 mm

28	Item no.
Locking pins, bottom	D28-11001-018

The "clever toolbox" can be mounted on all four sides and has a load capacity of up to 170 kg. Thanks to its ground clearance (10 cm), the "clever box" is readily accessible. The protective plate integrated under the table protects against dirt and weld spatter.



All angles can be stored in the grid system with locking pins to save space.

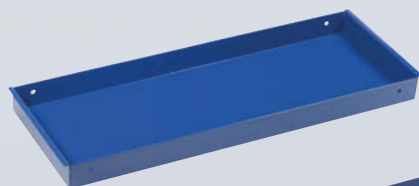


Available options:

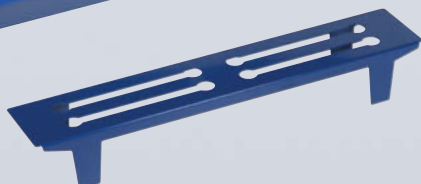
Bolt magazine and universal box, removable and mobile. Not included in the scope of delivery!



Universal box



Bolt magazine

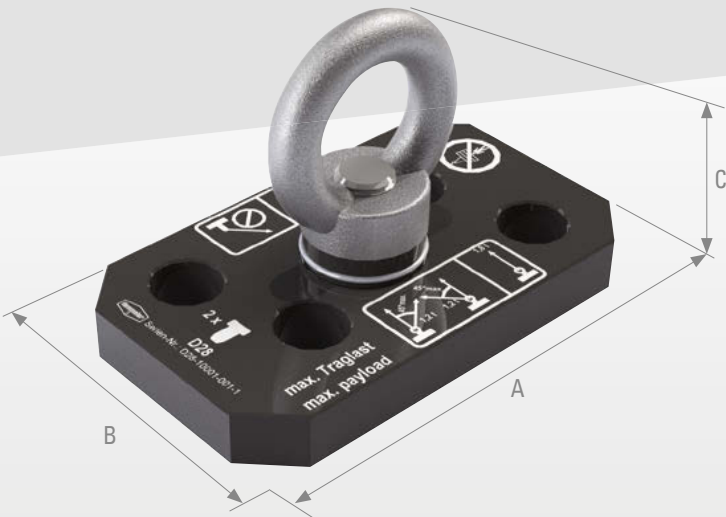


Locking pins, side



D28 transport ring

- For fast, easy and safe transportation of all heavy system components (e.g. worktable)
- Attachment with 2x PPC bolts / PC-bolts (D28-06001-000; D28-06025-000 (28))



Description ▲ Application ▼

Max. Transport weight in [t] with different attachment methods			
Transport ring			
Tilt angle	0°	0°	0° - 45°
Number of transport rings	1	2	2
D28 system	1.8 t	3.6 t	2.4 t

- D00-10001-000 transport ring must be attached with at least 2x PPC / PC-bolts!
- Max. tightening torque D28: 70 Nm (Bolts are not included in the scope of delivery of the transport ring).
- Countersunk head bolts may not be used!
- Transport ring may only be used for DEMMELER 3D systems!
- Internal operating instructions must be observed!
- Only undamaged Transport ring and PPC / PC-bolts may be used!
- The transport ring must be fastened centrally on the worktop. When using two transport rings, these must be fastened centrally and symmetrically on the worktop. The maximum diagonal pull may not exceed 45° here (see warnings).
- The general regulations for means of transport have to be observed when using the transport ring!
- Depending on the application, the load capacity may be significantly reduced.
- Loads may only be applied to the transport ring in the ring plane! Do not exceed the load capacity!
- Do not allow personnel to stand underneath suspended loads.
- Observe the warnings on the transport ring!

28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	200	120	129	4.7	D28-10001-001

- Suitable for clamping and releasing D28-06001-000 PS-bolts and PPC-bolts D28-06025-000
- For easy removal of PC-bolts and PPC bolts
- Handle simultaneously used for pre-centring



Description ▲

Application ▼

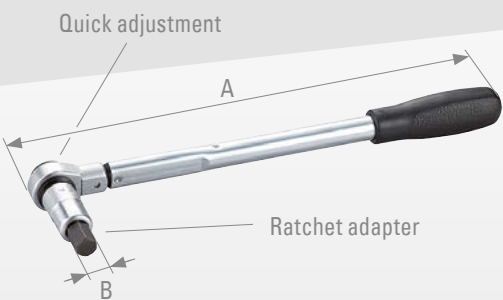


28	A in mm	B in mm	~ Weight in kg	Item no.
	250	45	0.72	D00-10016-001

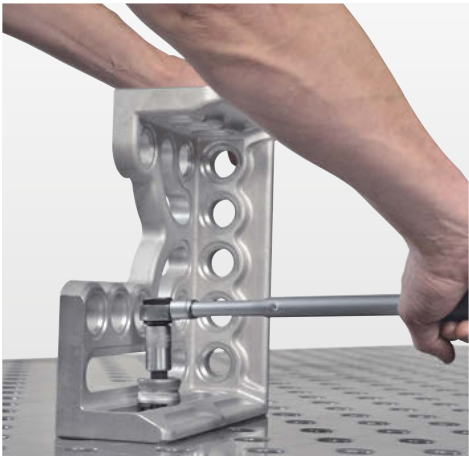
Torque wrench

Clamping and releasing made easy

- Pre-set to 70 Nm (28), for controlled tightening of the PC-bolt, avoiding damage to the system bore and bolt by over-tightening.
- Includes 1 x ratchet adapter, adjustable (left/right) 1/2" and 2 x sockets AF 8 and 14



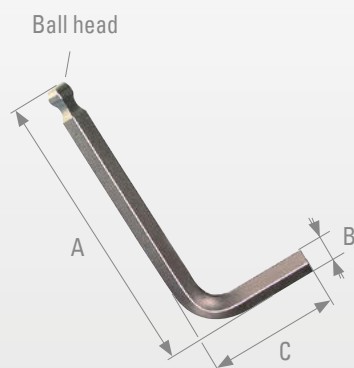
Description ▲ Application ▼



28	A in mm	B in mm	~ Weight in kg	Item no.
	348	AF 8 / AF 14	0.76	D28-10015-000
	212	AF 4 / AF 8	0.52	D16-10015-000

Allen key

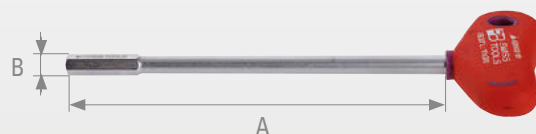
- For PC-bolt and compensating clamp arm with hexagonal
- Good accessibility due to additional ball head



Description ▲

Allen key with cross-handle

- Ergonomic handle for optimum tightening



Description ▲

28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	~ 104	AF 8	~ 42	0.06	D28-10008-005
	~ 112	AF 10	~ 55	0.10	D28-10008-001
	~ 150	AF 14	~ 69	0.26	D28-10008-000

28	A in mm	B in mm	~ Weight in kg	Item no.
	150	AF 8	0.12	D28-10008-004
	200	AF 10	0.18	D28-10008-003

Round brush

- For cleaning the system bores
- With splash guard



Description ▲ Application ▼

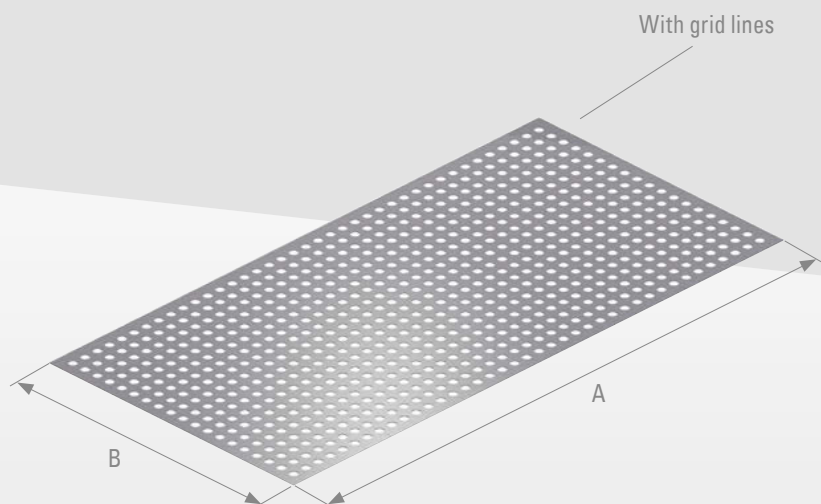


28	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	200	28	45	0.12	D28-10002-000

Protective plate for worktable

Especially for PROFIPremiumLine (PP) tables

- The protective plate are especially well suited for stainless steel welding
- With 50 x 50 mm grid
- Incl. grid lines
- t=3



Description ▲ Application ▼

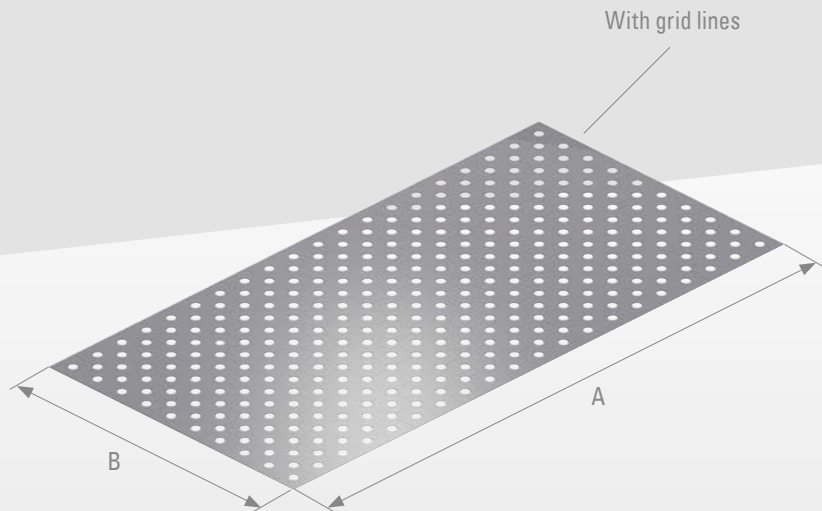


28	A in mm	B in mm	Description	Item no.
	1000	1000	Stainless steel	PP28-50021-001
	1000	1000	Aluminium	PP28-50021-002
	1200	800	Stainless steel	PP28-50021-017
	1200	800	Aluminium	PP28-50021-018
	1200	1200	Stainless steel	PP28-50021-003
	1200	1200	Aluminium	PP28-50021-004
	1500	1000	Stainless steel	PP28-50021-005
	1500	1000	Aluminium	PP28-50021-006
	1500	1500	Stainless steel	PP28-50021-007
	1500	1500	Aluminium	PP28-50021-008
	2000	1000	Stainless steel	PP28-50021-009
	2000	1000	Aluminium	PP28-50021-010
	2000	2000	Stainless steel	PP28-50021-019
	2000	2000	Aluminium	PP28-50021-020
	2400	1200	Stainless steel	PP28-50021-011
	2400	1200	Aluminium	PP28-50021-012
	3000	1500	Stainless steel	PP28-50021-013
	3000	1500	Aluminium	PP28-50021-014
	4000	2000	Stainless steel	PP28-50021-015
	4000	2000	Aluminium	PP28-50021-016
	4800	2400	Stainless steel	PP28-50021-021
	4800	2400	Aluminium	PP28-50021-022

Protective plate for worktable

Especially for PROFIPlusLINE (PL) tables

- The protective plate are especially well suited for stainless steel welding.
- with diagonal grid 100 × 100 mm
- Incl. grid lines
- System 28 t=3



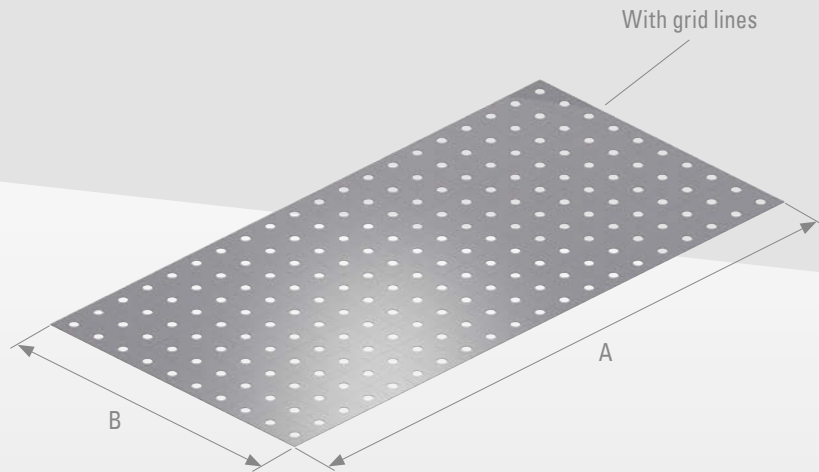
Description ▲

28	A in mm	B in mm	Description	Item no.
	1000	1000	Stainless steel	P28-50021-001
	1000	1000	Aluminium	P28-50021-002
	1200	800	Stainless steel	P28-50021-017
	1200	800	Aluminium	P28-50021-018
	1200	1200	Stainless steel	P28-50021-003
	1200	1200	Aluminium	P28-50021-004
	1500	1000	Stainless steel	P28-50021-005
	1500	1000	Aluminium	P28-50021-006
	1500	1500	Stainless steel	P28-50021-007
	1500	1500	Aluminium	P28-50021-008
	2000	1000	Stainless steel	P28-50021-009
	2000	1000	Aluminium	P28-50021-010
	2000	2000	Stainless steel	P28-50021-019
	2000	2000	Aluminium	P28-50021-020
	2400	1200	Stainless steel	P28-50021-011
	2400	1200	Aluminium	P28-50021-012
	3000	1500	Stainless steel	P28-50021-013
	3000	1500	Aluminium	P28-50021-014
	4000	2000	Stainless steel	P28-50021-015
	4000	2000	Aluminium	P28-50021-016
	4800	2400	Stainless steel	P28-50021-021
	4800	2400	Aluminium	P28-50021-022

Protective plate for worktable

Especially for PROFIEcoLINE tables (PE)

- The protective plate are especially well suited for stainless steel welding
- With 100 x 100 mm grid
- Incl. grid lines
- System 28 t=3

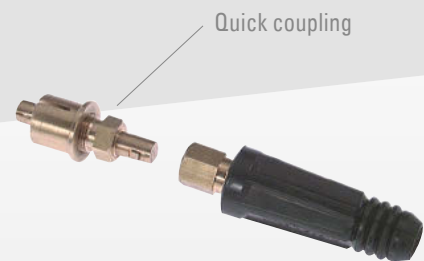


Description ▲

28	A in mm	B in mm	Description	Item no.
	1000	1000	Stainless steel	D28-50021-012
	1000	1000	Aluminium	D28-50021-019
	1200	800	Stainless steel	D28-50021-028
	1200	800	Aluminium	D28-50021-029
	1200	1200	Stainless steel	D28-50021-020
	1200	1200	Aluminium	D28-50021-013
	1500	1000	Stainless steel	D28-50021-018
	1500	1000	Aluminium	D28-50021-008
	1500	1500	Stainless steel	D28-50021-007
	1500	1500	Aluminium	D28-50021-011
	2000	1000	Stainless steel	D28-50021-005
	2000	1000	Aluminium	D28-50021-003
	2000	2000	Stainless steel	D28-50021-030
	2000	2000	Aluminium	D28-50021-031
	2400	1200	Stainless steel	D28-50021-010
	2400	1200	Aluminium	D28-50021-006
	3000	1500	Stainless steel	D28-50021-014
	3000	1500	Aluminium	D28-50021-015
	4000	2000	Stainless steel	D28-50021-021
	4000	2000	Aluminium	D28-50021-022
	4800	2400	Stainless steel	D28-50021-032
	4800	2400	Aluminium	D28-50021-033

Ground connector

- Fits any system bore
- 100 % contact, therefore no overheating of the ground cable >> High efficiency factor
- For cable cross-section 50 - 70 mm², for loads up to 355 A at 100 % duty cycle, 400 A at 60 % duty cycle
- Simple and safe installation (without interfering edges)
- Compatible with common ground cables



Description ▲

Application ▼



A in mm	B in mm	C in mm	~ Weight in kg	Item no.
-	-	-	0.34	D00-10009-000

Bench stone

- To care for the system surfaces of worktables and system components



Tarpaulin for your original DEMMELER 3D worktable

Protected against dirt

- Very sturdy tarpaulin
- Protects your table against dirt and wetness
- Firmly sewn at the corners



System components not included

Description ▲ Application ▼



A in mm	B in mm	C in mm	~ Weight in kg	Item no.
200	50	25	0.56	D00-10007-000

Description ▲ Application ▼



A in mm	B in mm	C in mm	Description	Item no.
1000	1000	200	Tarpaulin for table	D00-10030-000
1200	800	200	Tarpaulin for table	D00-10030-008
1200	1200	200	Tarpaulin for table	D00-10030-001
1500	1000	200	Tarpaulin for table	D00-10030-002
1500	1500	200	Tarpaulin for table	D00-10030-003
2000	1000	200	Tarpaulin for table	D00-10030-004
2000	2000	200	Tarpaulin for table	D00-10030-009
2400	1200	200	Tarpaulin for table	D00-10030-005
3000	1500	200	Tarpaulin for table	D00-10030-006
4000	2000	200	Tarpaulin for table	D00-10030-007
4800	2400	200	Tarpaulin for table	D00-10030-010

Pump bottle with worktable system protective spray

Worktable system protective spray in a canister

- Pressurised, sturdy version
- Includes anti-spatter spray for welding table systems
- Capacity: 1 litre
- Attention: Cannot be diluted with water!

ADVANTAGES FOR YOU:

- Prevents the adhesion of weld spatter on the surface
- Temporary corrosion protection for approx. one day
- Good cleaning effect
- Not combustible
- No chlorinated hydrocarbons
- Biodegradable
- Silicone-free



- Properties:
- Parting agent for welding thin and/or pre-heated sheets and for multi-layer welding
 - Protection for worktables, system components, welding nozzles and other welding accessories

- Areas of application:
- For welding VA materials, steel and other metals



Description ▲ Application ▼

Description ▲

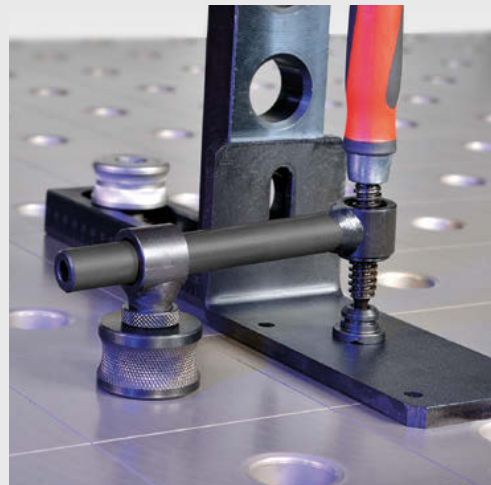
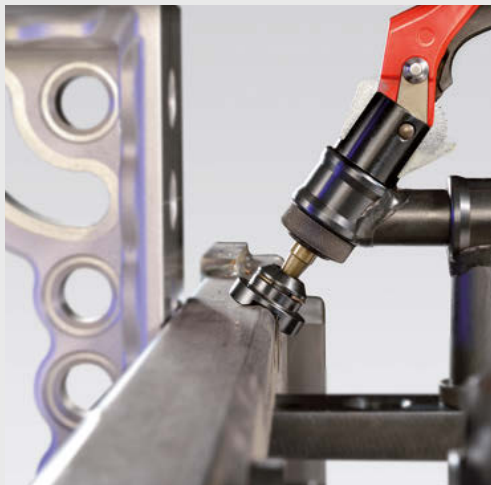


A in mm	B in mm	Description	Item no.
280	100	without welding spray	D00-10004-000
280	100	with 1 litre welding spray	D00-10005-000

A in mm	B in mm	Description	Item no.
230	200	5 litre canister	D00-10006-000
310	200	10 litre canister	D00-10006-001
400	350	30 litre canister	D00-10006-002

D22



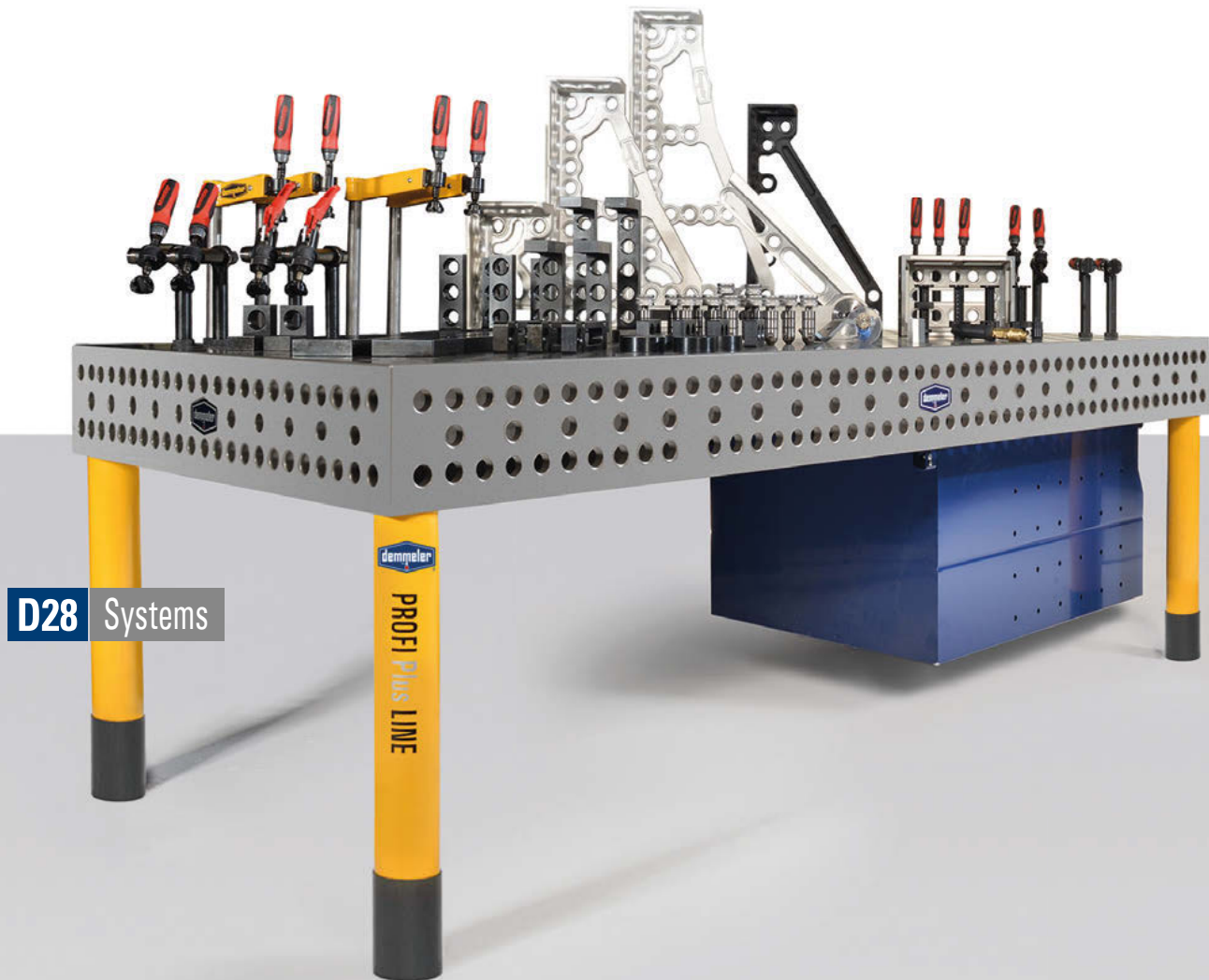




3D clamping system

3D clamping system overview.....	348
D22 3D clamping system overview.....	350
Benefits of the Demmeler system tables	352
DEMONT 760 M	354
Leg type variant overview.....	358
D22 table sizes	360
Overview of D22 table lines	362
PROFIPlusLINE 22 (PP) 3D table.....	364
PROFIPlusLINE 22 (PL) 3D table.....	366
PROFIPlusLINE 22 (PL) aluminium-titanium 3D table	368
Ordering summary for D22 table legs	370
Okto 100 3D worktable	374
Adapter plate D22	375

The optimum 3D worktable for every application – the intelligent system grids boost productivity



D28 / For everyday, large welded constructions



D28 PROFIPremiumLINE (PP)

- Grid 50 x 50 mm
- 3-hole drilling pattern in the table side plates, 50 mm grid in the top and bottom rows with additional 100 mm grid in the middle



D28 PROFIPlusLINE (PL)

- Diagonal grid 100 x 100 mm
- 3-hole drilling pattern in the table side plates, 50 mm grid in the top and bottom rows with additional 100 mm grid in the middle



D28 ProfiEco Line (PE)

- Grid 100 x 100 mm
- 3-hole drilling pattern in the table side plates, 50 mm grid in the top row with additional 100 mm grid in the middle and bottom rows



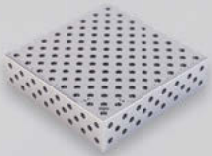
D28 HobbyLINE (H)

- Grid 100 x 100 mm
- Worktop approx. 25 mm high with system bores in a 100 mm x 100 mm grid



D16 Systems

D16 / For delicate applications



D16 PROFiPlusLINE (PL)

- Diagonal grid 50 x 50 mm
- 3-row bore pattern on the table side plates, 50 mm grid in the top, middle and bottom row



D16 ProfiEco Line (PE)

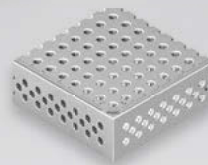
- Grid 50 x 50 mm
- 3-row bore pattern on the table side plates, 50 mm grid in the top, middle and bottom row



D22 Systems

D22 / For light and medium-duty applications

Particularly suited for use in the automation field (thanks to very lightweight, robust versions in high-strength aluminium-titanium alloy)



D22 PROFiPremiumLINE (PP)

- Grid 50 x 50 mm
- 3-row bore pattern on the table side plates, 50 x 50 mm diagonal grid



D22 PROFiPlusLINE (PL)

- Diagonal grid 100 x 100 mm
- 2-row bore pattern on the table side plates, 50 mm grid



22 PROFIPremiumLINE (PP) 3D table

PAGE 364



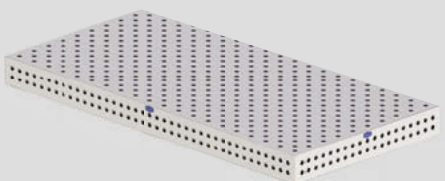
22 PROFIPlusLINE (PL) 3D table

PAGE 366



22 PROFIPlusLINE (PL) aluminium-titanium 3D table

PAGE 368



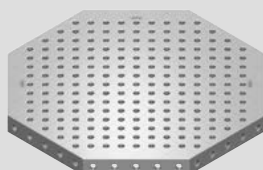
22 Standard leg / telescoping leg / heavy-duty wheel / anchoring leg

PAGE 370



22 3D Okto 100 worktable

PAGE 374



22 Adapter plate

PAGE 375



22 D22 sets

PAGE 378



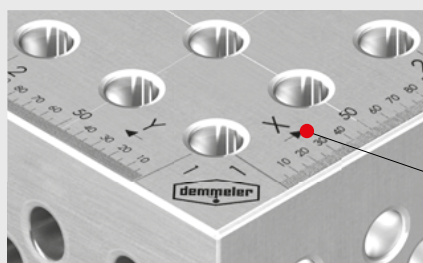
3D clamping system

Benefits of the D22 3D system tables

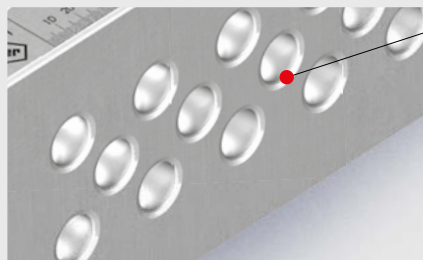


The benefits of a 3D clamping system from DEMMELER!

With our 3D clamping system, you have the right solution for clamping and positioning work pieces near at hand. Optimum positioning of the work piece not only makes work more accurate but also much more effective. In particular, the intelligent system grids give you unlimited clamping capabilities.



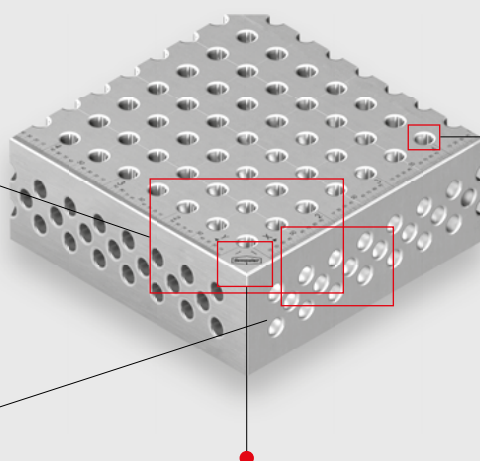
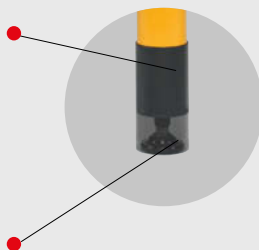
Axis designation in X and Y-direction and precision scaling are present as standard.



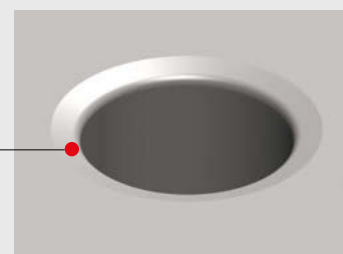
Additional bores in the side stanchion for even more clamping options.

Foot sleeve prevents pinching the welding hose and protects the threaded spindle against dirt.

Pivoting foot with stable M30x2 threaded spindle, finely adjustable ± 30 mm travel path.



Radius for improved ergonomics and better design



Protective countersink: Optimum bolt and clamp insertion with simultaneous protection of the tabletop against damage from materials, even in case of extreme strain on the system bore or when used with aluminium.

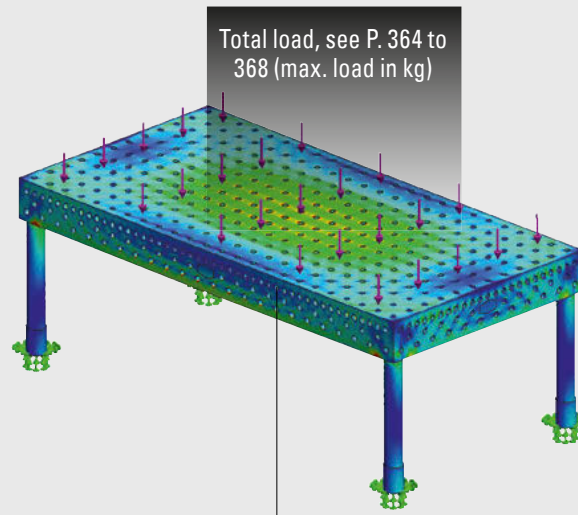


D22 system: Surface load per leg 3 tonnes

DEMMELEER trademark



OUR PERFORMANCE
makes THE DIFFERENCE



Total load, see P. 364 to 368 (max. load in kg)

All our tables are generously sized, super sturdy and optimised with FEM calculations on principle.

3D clamping system

The **HARDNESS** of DEMMELER

Hardness comparison



SOLID

High-strength base material

DEMONT 760 M

Hardened high-strength tool steel up to 760 Vickers



THE hardness of DEMMELER – for the toughest requirements

THE HARDNESS



DEMONT 760 M

- + Less wear
- + Protection against adherence of weld spatter
- + Extremely tough and durable
- + Optimum surface qualities

DEMONT 760 M

Stands for the combination of the specified base material and the new DEMMELER hardening process optimised especially for worktables. This results in outstanding material characteristics. A hardness of up to 760 Vickers can be achieved, reducing wear for an even longer service life of your worktable.

		DEMONT 760 M	SOLID
Load	high bearing loads	◀◀◀◀◀◀	◀◀◀◀◀◀
Evenness	for outstanding tool quality	◀◀◀◀◀	◀◀◀◀◀◀
Conductivity	for excellent welding results when using the ground connector	◀◀◀◀◀	◀◀◀◀◀◀
Base hardness	for high impact resistance	◀◀◀◀◀	◀◀◀◀
Surface hardness	resistant to weld spatter	◀◀◀◀◀	◀◀◀◀

◀◀◀◀◀◀ = outstanding
◀ = adequate

3D clamping system

Planned down to the tiniest details – The 3D clamping system from DEMMELER

Welding results

When using the 3D clamping system, the optimum flow of electricity between the electrode / filler wire and ground connector is vitally important. That is why DEMMELER optimises the material properties of its worktables and accessories and guarantees outstanding precision for optimum form fits. Although hardened worktables are even more robust and better protected against weld spatter, the conductivity also falls slightly. Here again, DEMMELER has developed an optimum solution in the form of the DEMONT 760 M variants. In this way, DEMMELER provides optimum conditions for ideal welding results!

- **DEMONT 760 M ①**

Very good conductivity for optimum welding results, extremely tough design and outstanding protection against weld spatter

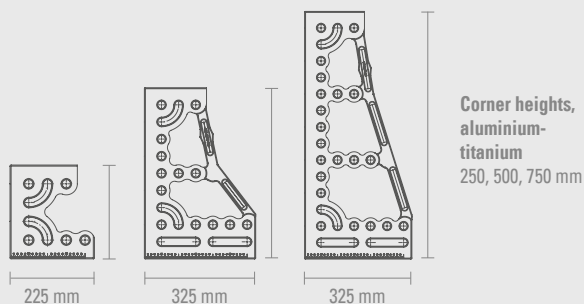
- **SOLID standard hardness ②**

Excellent conductivity for optimum welding results, extremely tough design and high protection against weld spatter

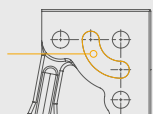
PROFIPremiumLINE clamping and locating angle

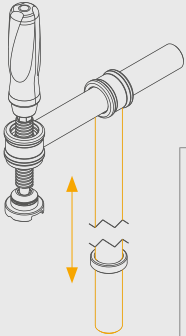
The aluminium-titanium design is lightweight enough to permit optimised, extremely simple handling. Only by using the patented PPC clamping pin is it possible to clamp the angles without causing wear. This permits an unlimited service life. The kidney-shaped 90° system groove makes continuous angle adjustment possible. The extended face plate and increased number of cross braces provide additional bores for clamping. The precision scaling makes adjustment much easier.

4 stop faces and usable surfaces



Reinforcement in the corners with 90° system groove in kidney shape supports continuously variable use, also with angular adjustment





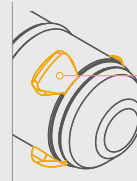
Screw clamp

The DEMMELER screw clamps are constructed using round tubes. This makes them extremely tough and the greatest possible clamping forces are achieved. DEMMELER screw clamps can be extended on a modular basis – for example, use as a 270° screw clamp is possible.

Using the performance screw clamp, it is also possible to clamp very high components with the same precision.

PPC bolts – The perfect connection

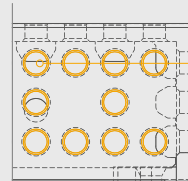
- Self-centring, force-locked and low-wear clamping
- Very quick to clamp and unclamp
- Force-locking through full-area contact
- Easy on materials
- Low susceptibility to dirt
- Extremely tough – long service life guaranteed



Even force distribution across the polygon bolts also reduces bore hole wear compared to conventional bolts. The cone clamping system permits a bearing surface that is 100 times larger.

Intelligent system grid

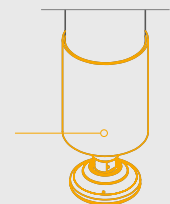
Thanks to the hole pattern on the side stanchions, DEMMELER worktables can be extended on a modular basis – and offer outstanding stability, toughness and very high bearing capacity.



Additional bores in the side stanchion for even more clamping options

Pivoting leg

The extremely solid design ensures very high load-bearing capacity – 3,000 kg per leg. The foot sleeve prevents pinching and reduces wear at the cable-hose assembly. This also provides a convenient way of using the ground connector. It also protects the threaded spindle against dirt and wear. Fine adjustments are possible and fixing is stable and simple.



Foot sleeves prevent pinching the welding hose and protect the threaded spindle against dirt.



Leg type variant overview



Standard leg

- Pivoting feet, ± 30 mm finely adjustable
- Sturdy M30x2 threaded spindle
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly
- Also suitable as supporting leg in combination with overhung spacer block U-form, length 1 m and up
- Including countersunk M24 x 60 mounting screw
- Leg tube powder coated
- To order standard legs, see page 370



Telescoping leg

- Pivoting feet, ± 30 mm finely adjustable
- Sturdy M30x2 threaded spindle
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly
- Telescope adjustment range 350 mm in 50-mm increments
- For flexible height adjustment of the worktable
- Including countersunk M24 x 60 mounting screw
- Leg tube powder coated
- To order telescoping legs, see page 370



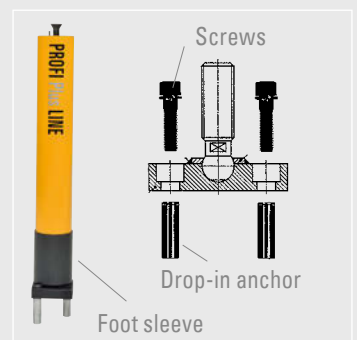
Heavy-duty wheel

- Finely adjustable ± 30 mm
- Sturdy M30x2 threaded spindle
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly
- Robust version
- With 360° caster
- Max. load capacity 600 kg
- Including countersunk M24 x 60 mounting screw
- Leg tube powder coated
- To order heavy duty wheels, see page 370



Anchoring leg

- Finely adjustable ± 30 mm
- Sturdy M30x2 threaded spindle
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly
- For firm attachment to the hall floor against tension, pressure and shifting (e.g. robot use)
- Includes M24 x 60 countersunk mounting screw and, for firm anchoring to the floor, 2 x drop-in anchor, 2 x cap screw M16 x 40
- Leg tube powder coated
- To order anchoring legs, see page 370





OUR PERFORMANCE
makes THE DIFFERENCE

3D clamping system



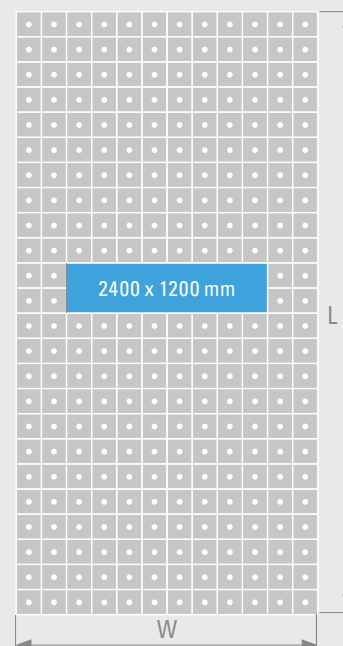
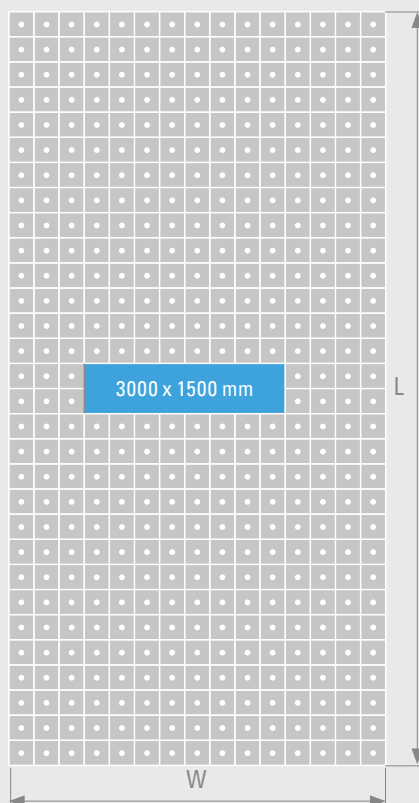
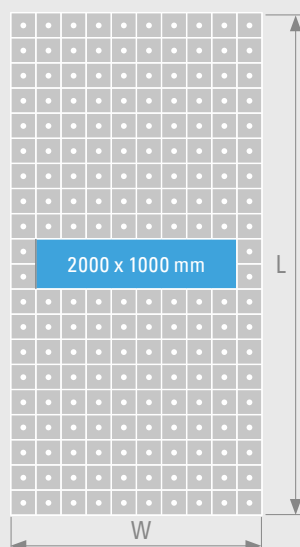
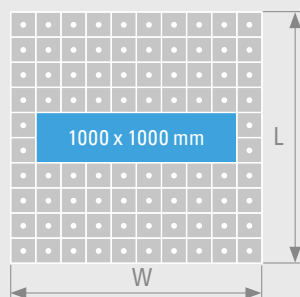
The right leg for any application



3D clamping system

D22 system table sizes





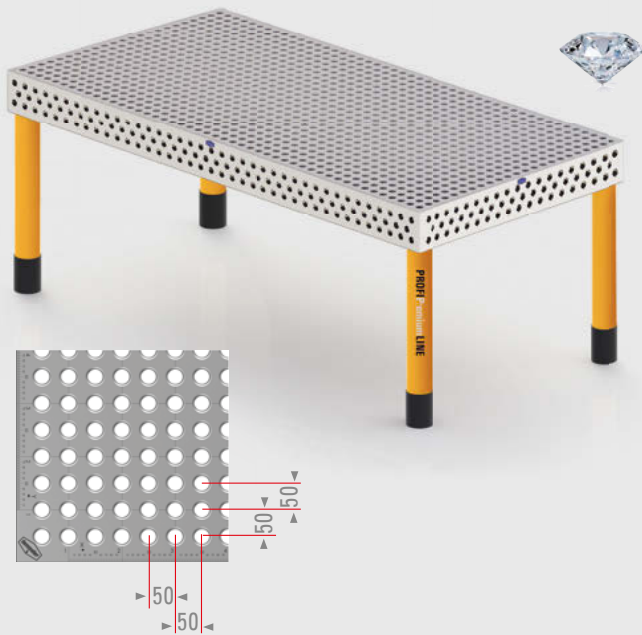
22	L in mm	W in mm	H in mm
	1000	1000	150
	2000	1000	150
	2400	1200	150
	3000	1500	150

Custom dimensions and materials
(e. g. stainless steel) available on request!

PROFIPremiumLINE (PP) 3D table

PROFIPlusLINE (PL) 3D table

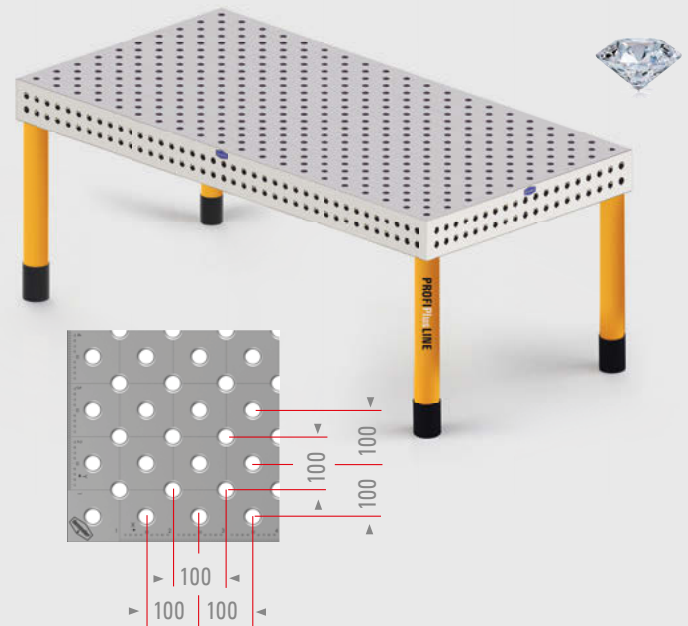
Worktop with D22 system bores
in a 50 mm x 50 mm grid



Description: PROFIPremiumLINE ▼

- D22 table plate with system bores in a 50 mm x 50 mm grid. This results in 200 % more clamping options than with PROFIPlusLINE
- 3-hole drilling pattern in the table side plates with D22 system bores in the 50 x 50 mm diagonal grid. This doubles the expansion and clamping options
- All table dimensions are available as an option with the hardened DEMONT 760 M version with hardness of up to 760 Vickers
- All system bores with protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous gridlines in X and Y-direction, 100 mm spacing
- Precision scaling with millimetre division, also available with the DEMONT 760 M option
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo displayed on all 4 sides of the side plate
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

Worktop with D22 system bores
in a 100 mm x 100 mm diagonal grid



Description: PROFIPlusLINE ▼

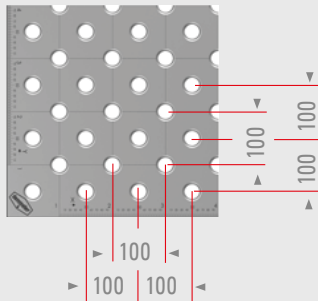
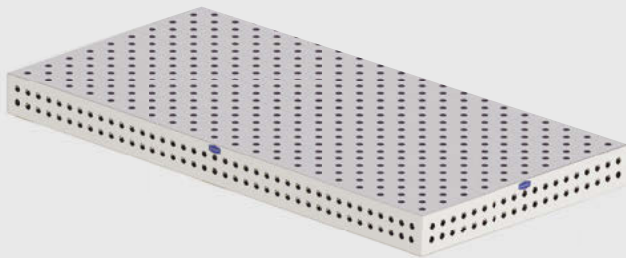
- Worktop with D22 system bores in a 100 mm x 100 mm diagonal grid
- 2-hole drilling pattern in the table side plates with D22 system bores in 50 mm grid
- All table dimensions are available as an option with the hardened DEMONT 760 M version with hardness of up to 760 Vickers
- All system bores with protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous gridlines in X and Y-direction, 100 mm spacing
- Precision scaling with millimetre division, also available with the DEMONT 760 M option
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo displayed on all 4 sides of the side plate
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly



PROFIPlusLINE (PL) aluminium-titanium 3D table

Description of the D22 table line

Worktop with D22 system bores
in a 100 mm x 100 mm diagonal grid

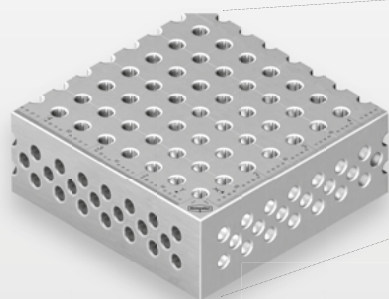
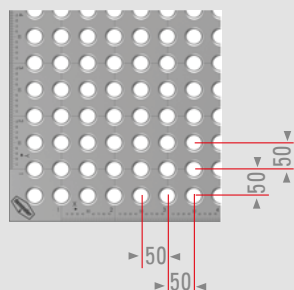


Description: PROFILusLINE aluminium-titanium

- Worktop with D22 system bores in a 100 mm x 100 mm diagonal grid
- 2-hole drilling pattern in the table side plates with D22 system bores in 50 mm grid
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous gridlines in X and Y-direction, 100 mm spacing (for rectangular tables)
- Precision scaling with millimetre divisions (for rectangular tables)
- Coordinate marking of the bores in the X and Y-direction (for rectangular tables)
- DEMMELER logo displayed on all 4 sides of the side plate
- Prepared for DEMMELER table legs
- Adapter plate available for connection to existing manipulator or robot, see page 375

PROFI PremiumLINE (PP) 3D table

Grid 50 x 50 mm



Custom dimensions and material (e. g. stainless steel) available on request

Table without leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	1000	150	200		
	2000	1000	150	350		
	2400	1200	150	500		
	3000	1500	150	735		

Table with standard leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	1000	850 ±30	234	12000	
	2000	1000	850 ±30	423	12000	
	2400	1200	850 ±30	534	12000	
	3000	1500	850 ±30	786	18000	

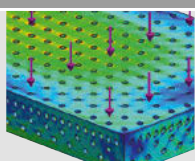
PROFIPremiumLINE (PP) 3D table



Precision scaling



Protective countersink



Max. load



DEMONT 760 M



Leg with sleeve



Additional bores

DESCRIPTION

- D22 table plate with system bores in a 50 mm × 50 mm grid. This results in 200 % more clamping options than with PROFIPlusLINE
- 3-hole drilling pattern in the table side plates with D22 system bores in 50 × 50 mm diagonal grid. This doubles the expansion and clamping options
- All table dimensions are available as an option with the DEMONT 760 M hardness of up to 760 Vickers
- All system bores with protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous gridlines in X and Y-direction, 100 mm spacing
- Precision scaling with millimetre division, also available with the DEMONT 760 M option
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo displayed on all 4 sides of the side plate
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

THE HARDNESS



DEMONT 760 M

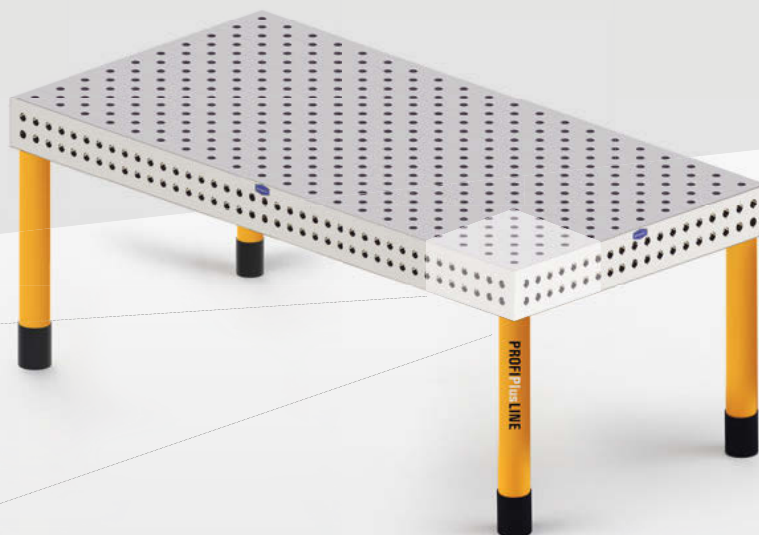
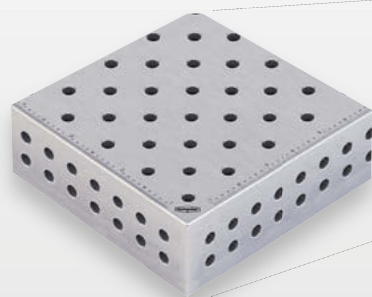
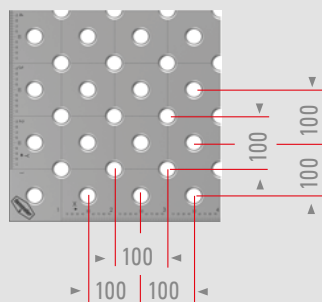
	Number of legs	SOLID	DEMONT 760 M hardened
	without legs	PP22-01001-000	PP22-01001-500
	without legs	PP22-01002-000	PP22-01002-500
	without legs	PP22-01003-000	PP22-01003-500
	without legs	PP22-01004-000	PP22-01004-500

	Number of legs	SOLID	DEMONT 760 M hardened
	4	PP22-01001-001	PP22-01001-011
	4	PP22-01002-001	PP22-01002-011
	4	PP22-01003-001	PP22-01003-011
	6	PP22-01004-001	PP22-01004-011

Selection list for
other leg variants
as of page 370

PROFIPlusLINE (PL) 3D table

Diagonal grid 100 × 100 mm



Custom dimensions and material (e. g. stainless steel) available on request

Table without leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	1000	150	210		
	2000	1000	150	375		
	2400	1200	150	535		
	3000	1500	150	785		

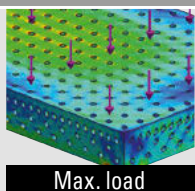
Table with standard leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	1000	850 ±30	244	12000	
	2000	1000	850 ±30	409	12000	
	2400	1200	850 ±30	569	12000	
	3000	1500	850 ±30	836	18000	



Precision scaling



Protective countersink



Max. load



DEMONT 760 M



Leg with sleeve



Additional bores

DESCRIPTION

- Worktop with D22 system bores in a 100 mm × 100 mm diagonal grid
- 2-hole drilling pattern in the table side plates with D22 system bores in 50 mm grid
- All table dimensions are available as an option in the DEMONT 760 M hardness of up to 760 Vickers
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous gridlines in X and Y-direction, 100 mm spacing
- Precision scaling with millimetre division, also available with the DEMONT 760 M option
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo displayed on all 4 sides of the side plate
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

THE HARDNESS



DEMONT 760 M

	Number of legs	SOLID	DEMONT 760 M hardened
	without legs	PL22-01001-000	PL22-01001-500
	without legs	PL22-01002-000	PL22-01002-500
	without legs	PL22-01003-000	PL22-01003-500
	without legs	PL22-01004-000	PL22-01004-500

	Number of legs	SOLID	DEMONT 760 M hardened
	4	PL22-01001-001	PL22-01001-011
	4	PL22-01002-001	PL22-01002-011
	4	PL22-01003-001	PL22-01003-011
	6	PL22-01004-001	PL22-01004-011

Selection list for
other leg variants
as of page 370

3D-Tisch PROFIPlusLINE (PL) aluminium-titanium 3D table



Diagonal grid 100 × 100 mm

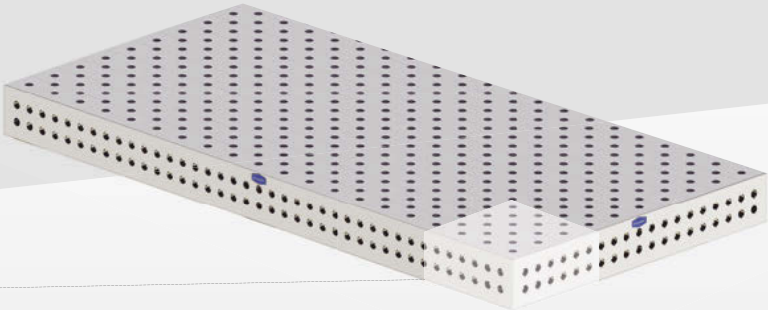
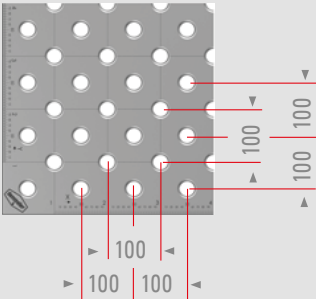


Table without leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	1000	150	75		
	2000	1000	150	130		



PROFIPlusLINE (PL) aluminium-titanium 3D table

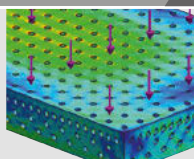
Recommended for automation solutions and robotics applications



Precision scaling



Protective countersink



Max. load



Additional bores

DESCRIPTION

- Worktop with D22 system bores in a 100 mm × 100 mm diagonal grid
- 2-hole drilling pattern in the table side plates with D22 system bores in 50 mm grid
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous gridlines in X and Y-direction, 100 mm spacing (for rectangular tables)
- Precision scaling with millimetre divisions (for rectangular tables)
- Coordinate marking of the bores in the X and Y-direction (for rectangular tables)
- DEMMELER logo displayed on all 4 sides of the side plate
- Prepared for DEMMELER table legs
- Adapter plate available for connection to existing manipulator or robot, see page 375

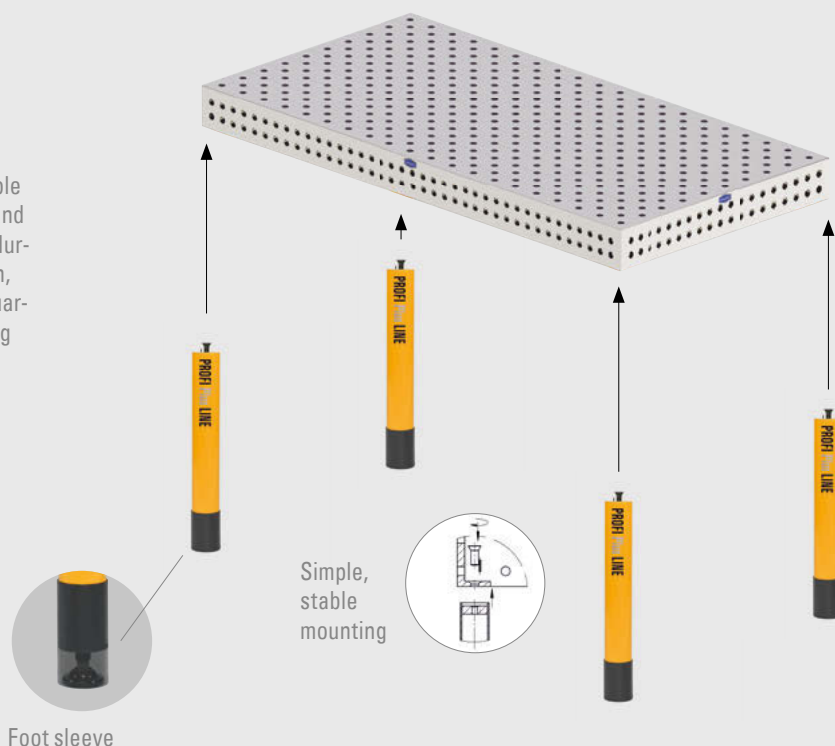
Number of legs	Aluminium-titanium
without legs	PL22-01001-003
without legs	PL22-01002-003

Ordering summary for table legs

D22 system 3D welding tables with suitable standard legs

Legs you can rely on.

Efficient working guaranteed! Starting with the finely adjustable standard leg and on through the mobile heavy-duty wheel, a variable selection of table legs are available for the various table systems and permit any application. This offers you greatest possible freedom during your manufacturing operations. Thanks to the intelligent design, the legs can be fixed simply and stably. The robust construction guarantees a long service life. To this end, foot sleeves prevent pinching the welding hose and protect the threaded spindle against dirt.



Ordering example:

1. On page 364 - 368, select the desired worktop, resulting in order item no. 1:
e.g. **1x** PL22-01002-000



+

2. From the current page, select the leg you want in the corresponding quantity, which results in order item no. 2:
e.g. **4x** PL22-10010-001



=


3. Together the two order item numbers result in your order to DEMMELER.
e.g. **1x** PL22-01002-000
+ e.g. **4x** PL22-10010-001



The right table legs for any application


System	Standard leg	Telescoping leg	Heavy-duty wheel	Anchoring leg
	22	22	22	22
PROFIPremiumLINE	●	●	●	●
PROFIPlusLINE	●	●	●	●

Standard leg / telescoping leg / heavy-duty wheel / anchoring leg

Standard leg		Quantity Legs	22			
For table size			Item number	H in mm	Weight in kg	Max. load in kg
	1000x1000	4	PL22-10010-000	700 ± 30	8.5	3000
	2000x1000					
	2400x1200					
	3000x1500	6				




Finely adjustable
pivoting foot

Telescoping leg		Quantity Legs	22			
For table size			Item number	H in mm	Weight in kg	Max. load in kg
	1000x1000	4	PL22-10010-001	600 to 950 ± 30	12	3000
	2000x1000					
	2400x1200					
	3000x1500	6				




Adjustable height
Grid 50 mm

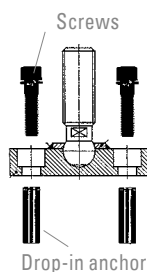
Finely adjustable
pivoting foot

Heavy-duty wheel		Quantity Legs	22			
For table size			Item number	H in mm	Weight in kg	Max. load in kg
	1000x1000	4	(2x) PL22-10010-002* ¹	700 ±30	12	600
	2000x1000		+			
	2400x1200		(2x) PL22-10010-003* ²		11	
	3000x1500	6	(2x) PL22-10010-002* ¹	12	11	
			+			

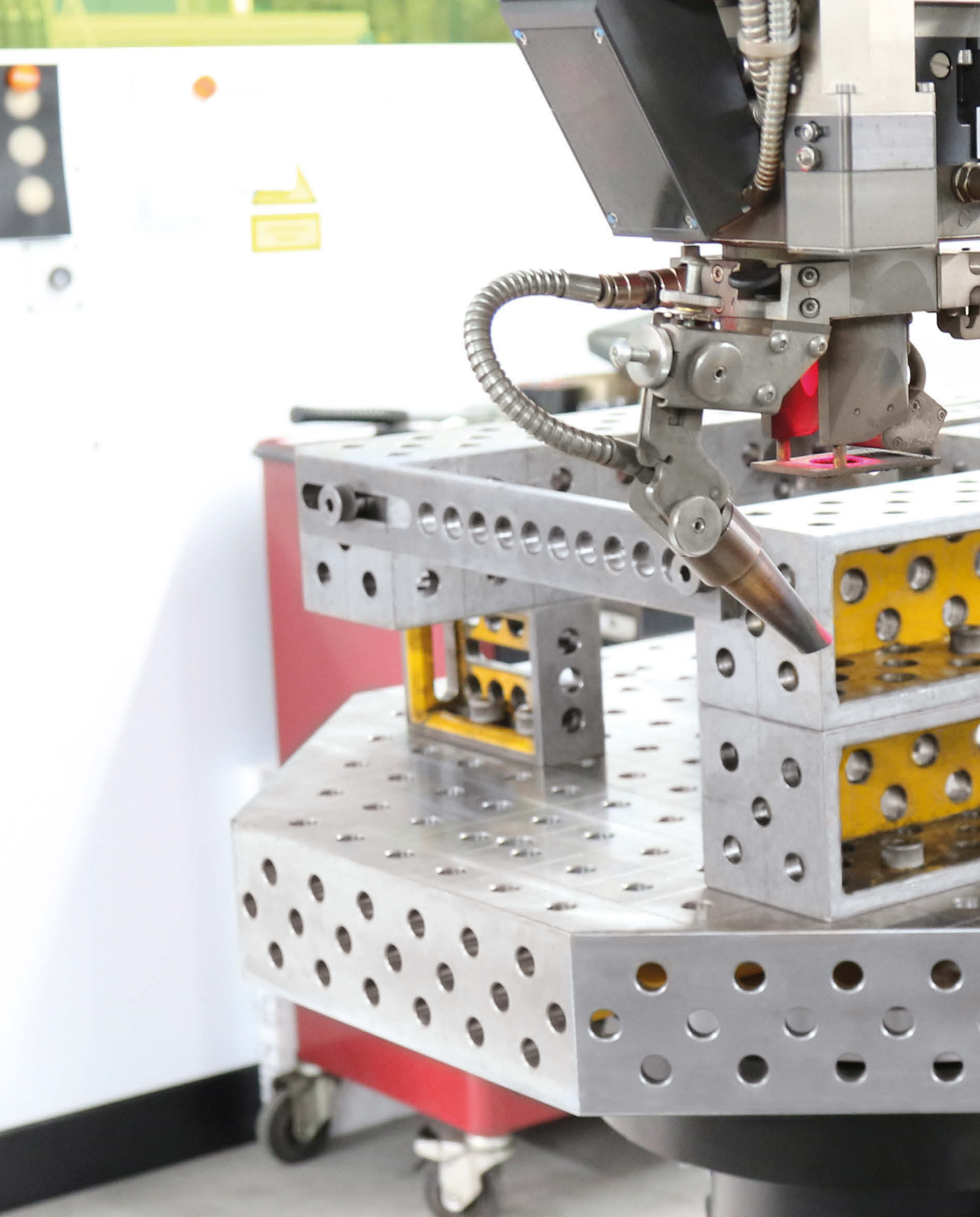


^{*1} wheel with brake
^{*2} wheel without
brake

Anchoring leg		Quantity Legs	22			
For table size			Item number	H in mm	Weight in kg	Max. load in kg
	1000x1000	4	PL22-10010-004	700 ± 30	11	3000
	2000x1000					
	2400x1200					
	3000x1500	6				



Drop-in anchor



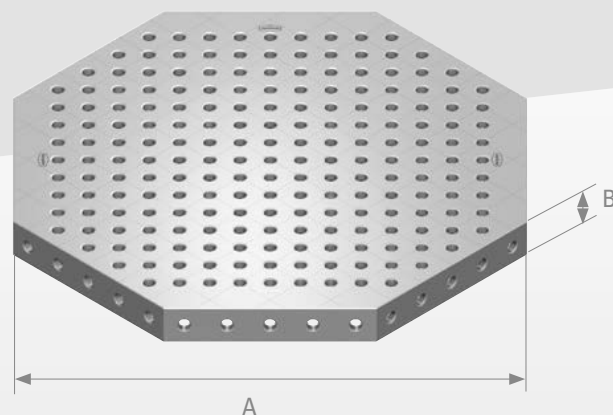


OUR PERFORMANCE
makes THE DIFFERENCE



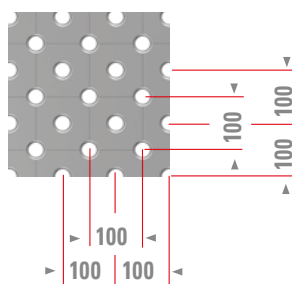
Okto 100 3D worktable

- Preferred use with manipulators in robot cells
- Numerous clamping possibilities on all nine clamping surfaces
- In the D22 bore grid 100x100
- Diagonal boring in M16 version
- High-strength aluminium-titanium alloy for ~ 60 % weight reduction and ~ 10 % higher bending strength
- Together with adapter plate, with special connection drilling pattern, adapted to the face plate of your manipulator (please include manipulator type and drawing of the face plate with enquiry)



Description ▲ Application ▼

Diagonal grid 100 x 100 ▼



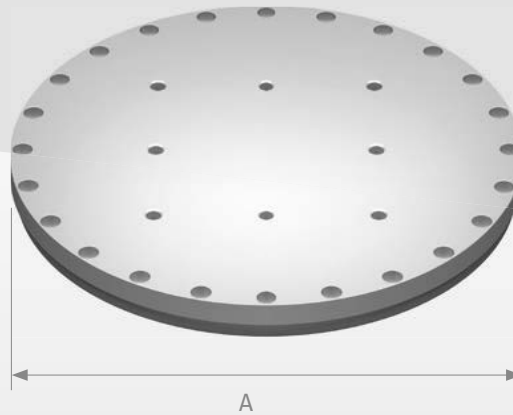
22	A in mm	B in mm	Description	Item no.
	AF 600	100	Diagonal grid 100 x 100	PL22-11008-001
	AF 800	100	Diagonal grid 100 x 100	PL22-01013-001
	AF 1000	100	Diagonal grid 100 x 100	PL22-01038-001



Adapter plate

Recommended for automation solutions and robotics applications

- Interface element for adaptation of Okto 100 D22 3D worktable to welding robot or manipulator
- Interface hole pattern produced in accordance with customer's wishes
- Incl. mounting screws



Description ▲

22	A in mm	Description	Item no.
	AF 600	Adapter plate for table AF 600	00116157
	AF 800	Adapter plate for table AF 800	00116159
	AF 1000	Adapter plate for table AF 1000	00116160





Sets

PROFIPlusLINE set 710 D22	378
PROFIPlusLINE set 720 D22	379
PROFIPlusLINE set 730 D22	380

PROFIPlusLINE set 710 (System 22)

Item number: D22-52000-710 (26-piece)



Quantity ▼	Item no. ▼	Item description ▼
10	E22-06025-000	EcoLINE bolt/short – Ø 22, AF 6, clamping range 32-33.5 mm
4	D22-05015-000	Displacement stop – 100 × 50 × 18 mm, scale on both sides
4	D22-05001-000	Universal stop /size 225 × 50 × 18 mm
2	D22-05009-000	Universal stop L 300 - 300 × 50 × 18 mm
4	D22-07005-000	Variable screw clamp 180° with spindle – vertical pipe 250 mm
1	D22-10002-000	Round brush Ø 22 with protective cap, for cleaning the system bore
1	D22-10016-001	Extraction tool – 250 × 45 mm, AF 10

You can individually assemble or supplement your sets with the large selection of DEMMELER accessories!

PROFIplusLINE set 720 (System 22)

Item number: D22-52000-720 (57-piece)

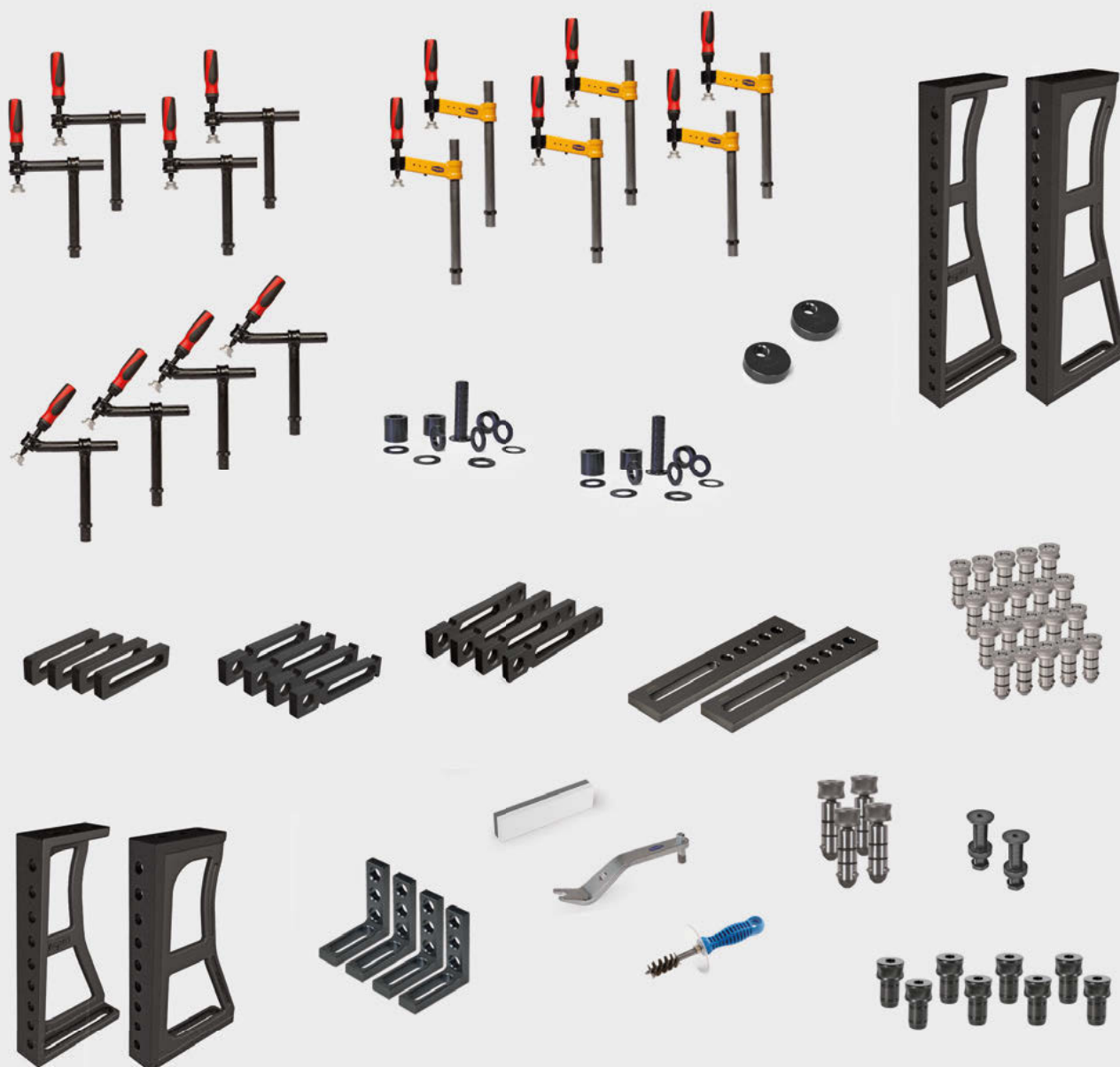


Quantity ▼	Item no. ▼	Item description ▼
16	E22-06025-000	EcoLINE bolt/short – Ø 22, AF 6, clamping range 32-33.5 mm
6	D22-06009-000	Stop and positioning bolts Ø 22/31 × 52 mm
2	D22-09001-005	Spacer set with thread – Ø 45 × 125 mm, height compensation 22-105 mm, continuous
2	D22-05013-000	Stop washer Ø 75 – stop dimension 25-50 mm, continuous
2	D22-09001-000	Spacer set 11 pieces – Ø 50 × 125 mm, height compensation 5-100 mm increment 1 mm
4	D22-05015-000	Displacement stop – 150 × 50 × 18 mm, scale on both sides
4	D22-05009-000	Universal stop L 300 – 300 × 50 × 18 mm
4	PE22-03001-000	Clamping and locating angle 175 x 175 mm (bore/oblong hole)
2	D22-05003-000	Stop strip L 500 × 100 × 18 mm
4	D22-07009-000	Variable screw clamp 45° with spindle – vertical pipe 250 mm
4	D22-07005-000	Variable screw clamp 180° with spindle – vertical pipe 250 mm
4	D22-07001-000	Compensating swing clamp 180° with spindle – vertical pipe 300 mm
1	D22-10002-000	Round brush Ø 22 with protective cap, for cleaning the system bore
1	D22-10016-001	Extraction tool – 250 × 45 mm, AF 10
1	D00-10007-000	Bench stone 200 × 50 × 25 mm

You can individually assemble or supplement your sets with the large selection of DEMMELER accessories!

PROFIPlusLINE set 730 (System 22)

Item number: D22-52000-730 (77-piece)





PROFIplusLINE set 730 (System 22)

Item number: D22-52000-730 (77-piece)

Quantity ▼	Item no. ▼	Item description ▼
4	D22-06026-000	PPC bolt/long – Ø 22, AF 10, clamping range 49–52 mm
20	E22-06025-000	EcoLINE bolt/short – Ø 22, AF 6, clamping range 31-34 mm
8	D22-06009-000	Stop and positioning bolts Ø 22/31 × 52 mm
2	D22-09001-005	Spacer set with thread – Ø 45 × 125 mm, height compensation 22-105 mm, continuous
2	D22-05013-000	Stop washer Ø 75 – stop dimension 25-50 mm, continuous
2	D22-09001-000	Spacer set 11 pieces – Ø 50 × 125 mm, height compensation 5-100 mm increment 1 mm
4	D22-05015-000	Displacement stop – 150 × 50 × 18 mm, scale on both sides
4	D22-05001-000	Universal stop /size 225 × 50 × 18 mm
4	PE22-03001-000	Clamping and locating angle 175 x 175 mm (bore/oblong hole)
4	D22-05009-000	Universal stop L 300 - 300 × 50 × 18 mm
2	D22-05003-000	Stop strip L 500 – 500 × 100 × 18 mm
4	D22-07009-000	Variable screw clamp 45° with spindle – vertical pipe 250 mm
4	D22-07005-000	Variable screw clamp 180° with spindle – vertical pipe 250 mm
6	D22-07001-000	Compensating swing clamp 180° with spindle – vertical pipe 300 mm
1	D22-10002-000	Round brush Ø 22 with protective cap, for cleaning the system bore
1	D22-10016-001	Extraction tool – 250 × 45 mm, AF 10
1	D00-10007-000	Bench stone 200 × 50 × 25 mm
1	PE22-03003-000	Clamping and locating angle H 500, DEMONT 760 M Black Edition, hardened casting, right
1	PE22-03003-001	Clamping and locating angle H 500, DEMONT 760 M Black Edition, hardened casting, left
1	PE22-03004-000	Clamping and locating angle H 750, DEMONT 760 M Black Edition, hardened casting, right
1	PE22-03004-001	Clamping and locating angle H 750, DEMONT 760 M Black Edition, hardened casting, left

You can individually assemble or supplement your sets with the large selection of DEMMELER accessories!





Bolts

Bolts - overview.....	384
Benefits of the PPC bolt.....	387
PPC bolt D22, short.....	388
PPC bolt D22, long	389
PPC-countersunk bolt D22, short	390
PPC countersunk bolt D22, long.....	391
EcoLINE bolt D22, short.....	392
EcoLINE bolt D22, long.....	393
Stop and positioning bolt D22.....	394
Connecting bolt D22, short with screw	395
Connecting bolt D22, long with screw	396
Adapter D22 to D16.....	397
Interface plate D22 to D28	398

Bolts - overview

22 PPC bolt, short

PAGE 388



22 PPC bolt, long

PAGE 389



22 PPC countersunk head bolt, short

PAGE 390



22 PPC-countersunk bolt, long

PAGE 391



22 ECOLine bolt, short

PAGE 392



22 ECOLine bolt, long

PAGE 393



22 Stop and positioning bolt

PAGE 394



22 Connection bolt / short with screw

PAGE 395



22 Connecting bolt, long with screw

PAGE 396



22 Adapter D22 to D16

PAGE 397



22 Interface plate D22 to D28

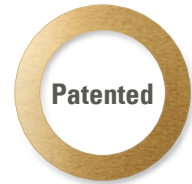
PAGE 398





The perfect connection

Self-centring, force-locked and low-wear clamping – possible thanks to the original DEMMELER clamping bolt



Very high-speed clamping and unclamping of

the clamping elements

Form-fitting through full-area contact

with the reciprocal surface

Reduces material wear

even when aluminium and plastic elements are used – no system bore deformation



Low susceptibility to dirt

because sensitive parts such as clamp threads etc. are full encapsulated by O-rings

Extremely robust

made from high-quality hardened steel, maximum precision thanks to grinding

Long service life guaranteed

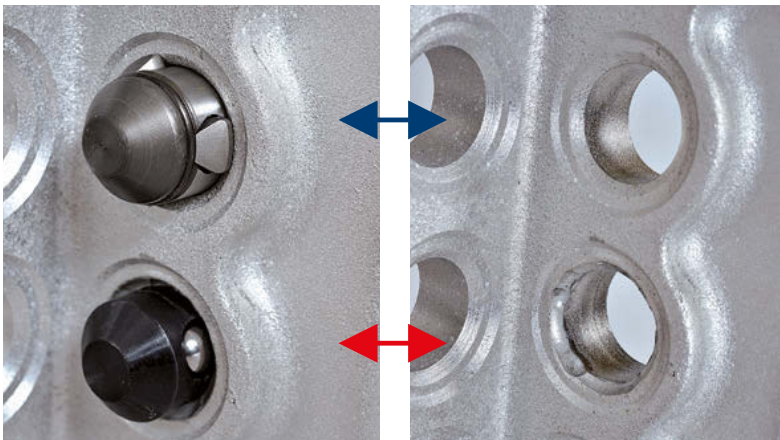
in everyday applications



The PPC bolt meets all expectations!



Comparison between clamping pins and the new polygon bolt from DEMMELER



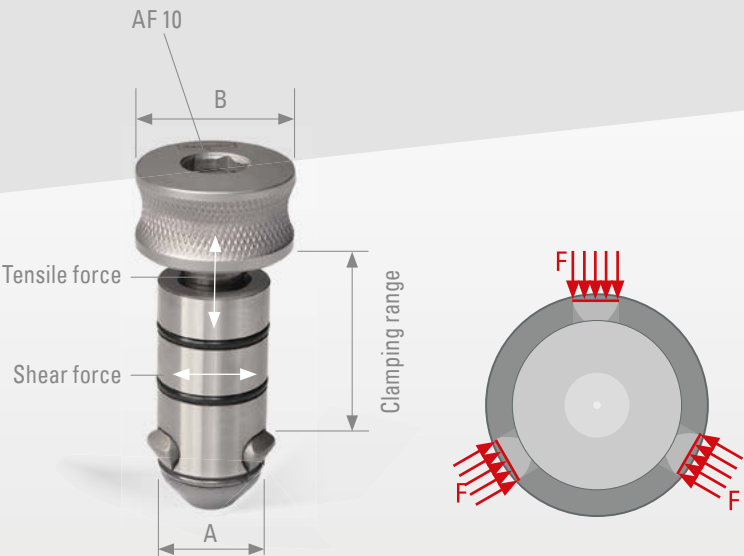
CONE INSTEAD OF BALLS –
MORE FORCE, LESS WEAR

Thanks to the new cone clamping system of the DEMMELER PPC bolt, the bearing surface is 100 times larger. This results in much higher contact pressure, therefore securing work pieces more reliably. Even force distribution also reduces bore hole wear compared to conventional bolts.

Using the PPC bolt prevents serious damage to the bores that can be caused by clamping pins, for example with aluminium-titanium blocks.

PPC bolt, short

- Highest clamping force with large stroke. Polygon expansion elements are full-faced, force-locked, and exactly self-centring, thereby reducing the surface load
- Self-locking
- Easy on materials
- Straightforward, fast and safe handling
- Low susceptibility to dirt
- High-quality hardened steel, maximum precision thanks to grinding
- O-ring prevents simultaneous rotation while tightening and cleans the system bore at the same time



Description ▲ Application ▼	Minimum clamping range ▼	Maximum clamping range ▼
-----------------------------	--------------------------	--------------------------

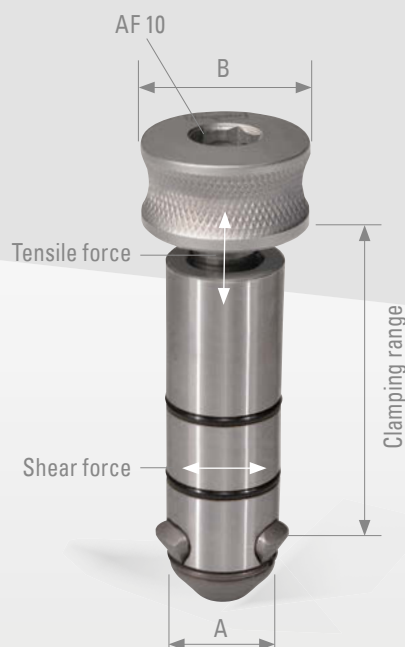


The specified loads must not be exceeded when using the clamping pins.
Avoid the induction of welding voltages, unfavourable leverage ratios and impacts during use.

22	Clamping range	Ø A in mm	B in mm	~ Weight in kg	Design	Item no.
	31-34	22-0.02	31	0.25	tensile force: max. 18 kN shear force: max. 100 kN tightening torque: 25 Nm	D22-06025-000



- Highest clamping force with large stroke. Polygon expansion elements are full-faced, force-locked, and exactly self-centring, thereby reducing the surface load
- Self-locking
- Easy on materials
- Straightforward, fast and safe handling
- Low susceptibility to dirt
- High-quality hardened steel, maximum precision thanks to grinding
- O-ring prevents simultaneous rotation while tightening and cleans the system bore at the same time



Description ▲

Minimum clamping range ▼

Maximum clamping range ▼

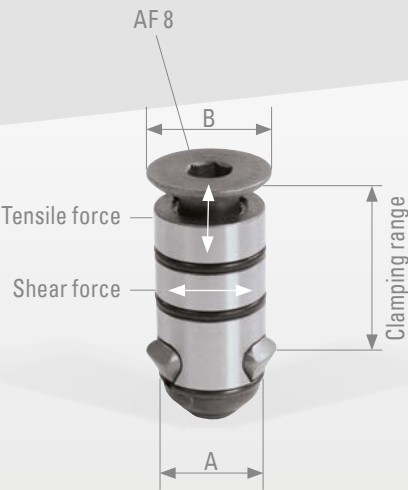


The specified loads must not be exceeded when using the clamping pins.
Avoid the induction of welding voltages, unfavourable leverage ratios and impacts during use.

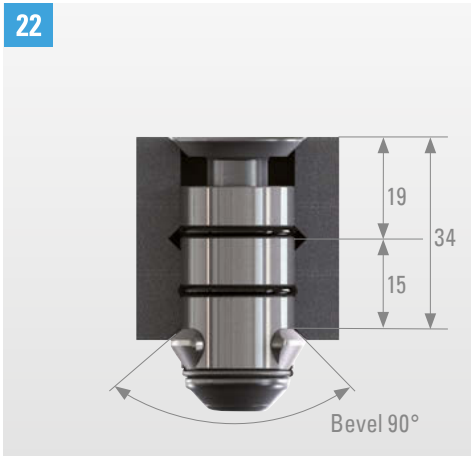
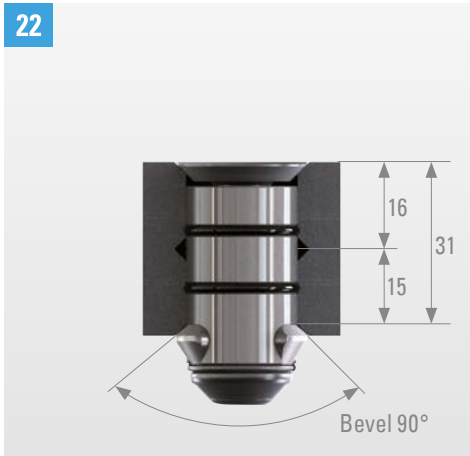
22	Clamping range	Ø A in mm	B in mm	~ Weight in kg	Design	Item no.
	49-52	22-0.02	31	0.3	tensile force: max. 18 kN shear force: max. 100 kN tightening torque: 25 Nm	D22-06026-000

PPC countersunk head bolt, short

- Used for simultaneous clamping of two system components
- Easy, comfortable clamping through optimised force distribution in the expansion segments
- Minimal susceptibility to dirt due to polygon shape
- Standard with Demmeler for a long service life: high-strength, hardened and ground
- With optimum force distribution, Demmeler opens up a new dimension of application possibilities
- Countersunk head bolts may only be used in bores but not in oblong holes



Description ▲	Minimum clamping range ▼	Maximum clamping range ▼
---------------	--------------------------	--------------------------



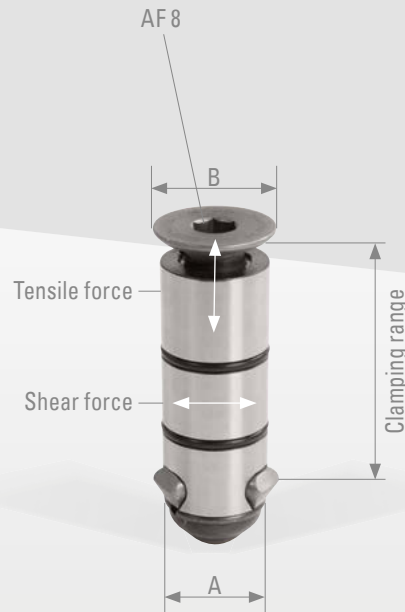
The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

22	Clamping range	Ø A in mm	Ø B in mm	~ Weight in kg	Design	Item no.
	31-34	22	25	0.2	tensile force: max. 4 kN shear force: max. 100 kN tightening torque: 15 Nm	D22-06027-000

PPC-countersunk bolt, long



- Used for simultaneous clamping of three system components
- Connecting element for all system components on tables, perforated plates etc. or for special fixtures
- Easy, comfortable clamping through optimised force distribution in the expansion segments
- Minimal susceptibility to dirt due to polygon shape
- Standard with Demmeler for a long service life: high-strength, hardened and ground
- With optimum force distribution, Demmeler opens up a new dimension of application possibilities
- Countersunk head bolts may only be used in bores but not in oblong holes

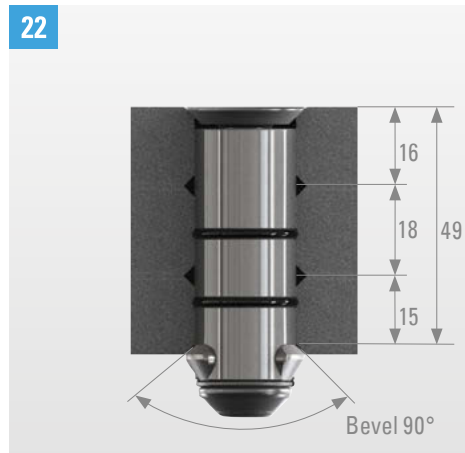


Description ▲

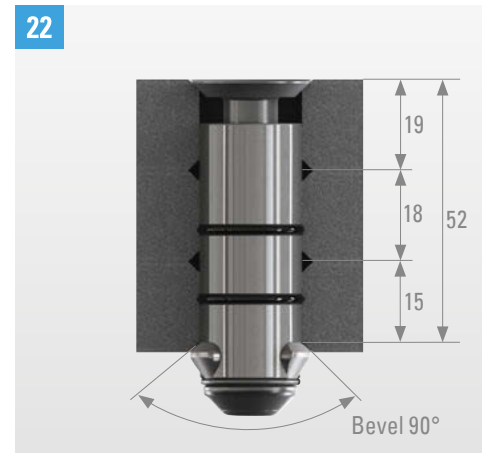
Minimum clamping range ▼

Maximum clamping range ▼

22



22

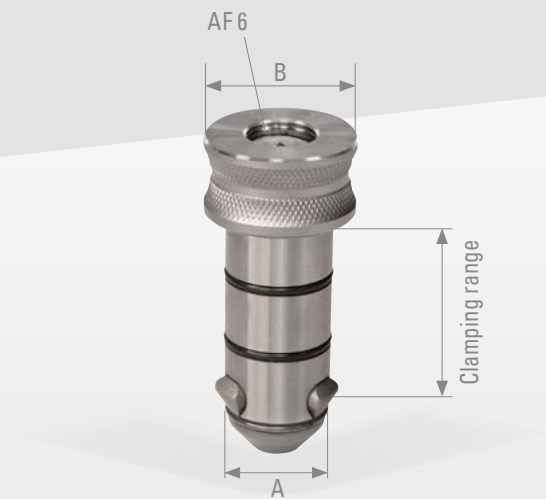


The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

22	Clamping range	Ø A in mm	Ø B in mm	~ Weight in kg	Design	Item no.
	49-52	22	25	0.2	tensile force: max. 4 kN shear force: max. 100 kN tightening torque: 15 Nm	D22-06028-000

ECOLine bolt, short

- Connecting element for system components
- For clamping one system component onto the welding table or for connecting 2 system components
- Simple version without expanded clamping range



Description ▲	Minimum clamping range ▼	Maximum clamping range ▼
---------------	--------------------------	--------------------------



The specified loads must not be exceeded when using the clamping pins.
Avoid the induction of welding voltages, unfavourable leverage ratios and impacts during use.

22	Clamping range	Ø A in mm	Ø B in mm	~ Weight in kg	Design	Item no.
	32-33.5	22	31	0.25	tensile force: max. 18 kN shear force: max. 100 kN tightening torque: 15 Nm	E22-06025-000



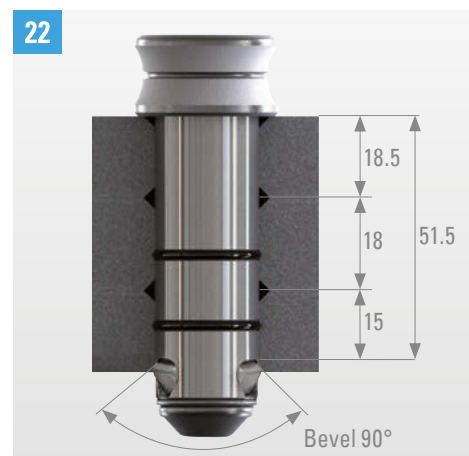
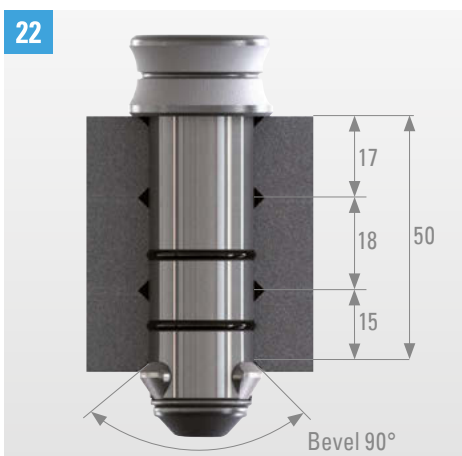
- Connecting element for system components
- For clamping one system component onto the welding table or for connecting 2 system components
- Simple version without expanded clamping range



Description ▲

Minimum clamping range ▼

Maximum clamping range ▼



The specified loads must not be exceeded when using the clamping pins.
Avoid the induction of welding voltages, unfavourable leverage ratios and impacts during use.

22	Clamping range	Ø A in mm	Ø B in mm	~ Weight in kg	Design	Item no.
	50-51.5	22	31	0.3	tensile force: max. 18 kN shear force: max. 100 kN tightening torque: 15 Nm	E22-06026-000

Stop and positioning bolts

- For marking the system components
- For fixation e.g. of blocks and stops, cost-effective replacement for a second clamping pin
- Blackened
- Also suitable as adapter for system 16 screw clamps thanks to D16 system bore in the head



Description ▲

Application ▼



22	Ø A in mm	Ø B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	22	31	52	19	0.2	D22-06009-000

Connection bolt, short with screw

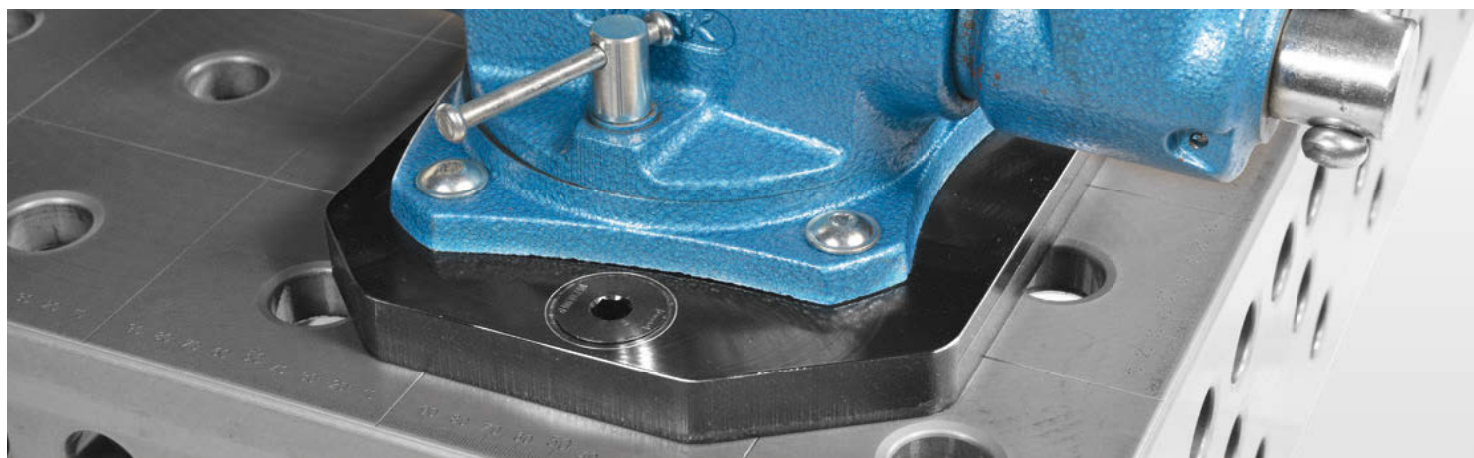


- For use as long-term connection
- With self-centring countersunk head on both sides
- Suitable for system bores
- Clamping with Allen key AF 8
- Ideal for connecting worktables with U-spacers etc.
- Blackened



Description ▲

Application ▼



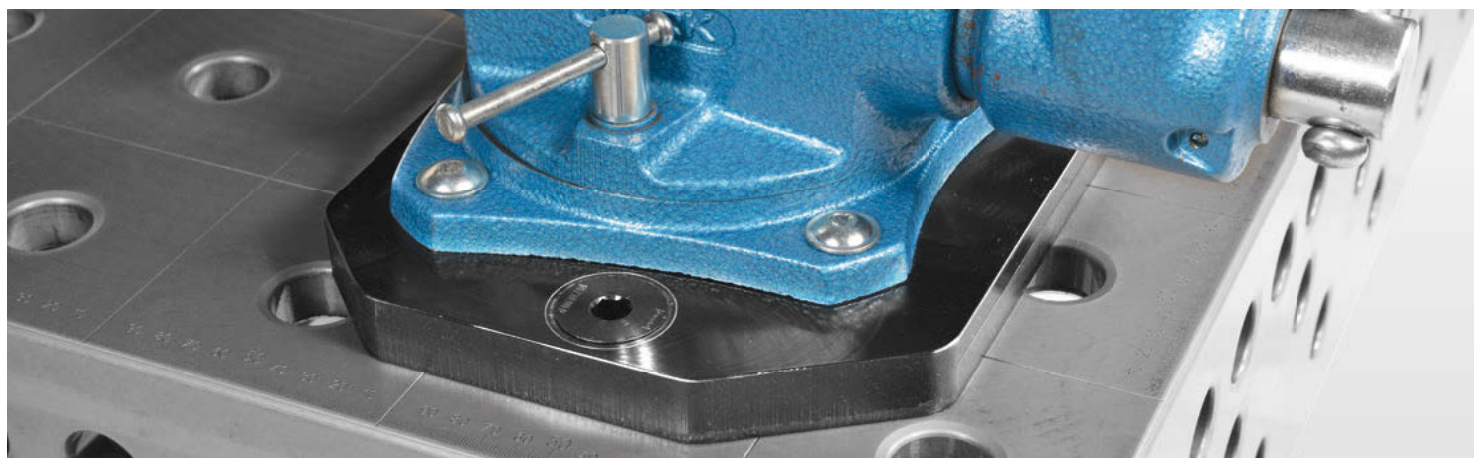
22	A in mm	Ø B in mm	~ Weight in kg	Item no.
	28.75	22	0.1	D22-06003-000

Connection bolt, long with screw

- For use as long-term connection
- With self-centring countersunk head on both sides
- Suitable for system bores
- Clamping with Allen key AF 8
- For connecting three system components or two system components on the worktable
- Blackened



Description ▲



22	A in mm	Ø B in mm	~ Weight in kg	Item no.
	48	22	0.2	D22-06006-000



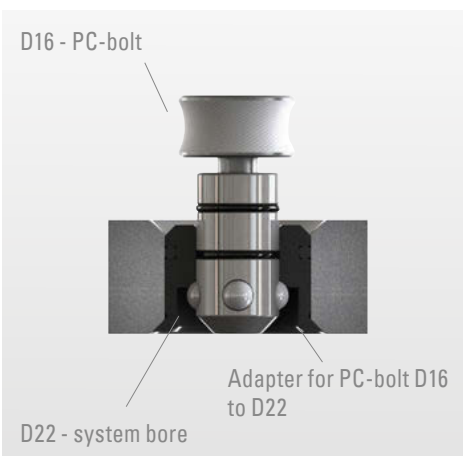
- Interface between system D22 and D16
- Fully compatible with system D22 and D16
- Force-fit and form-fitting with O-ring, self-centring connection
- O-ring prevents simultaneous rotation while tightening
- O-ring cleans the system bore



Description ▲ Application ▼

Application ▼

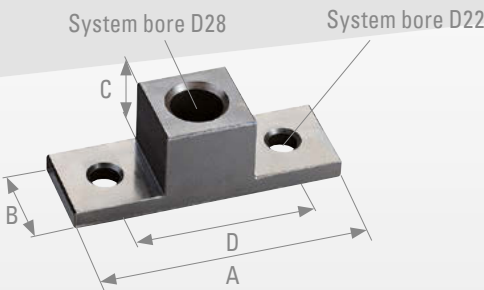
Application ▼



22	A in mm	Ø B in mm	~ Weight in kg	Item no.
	23	22	0.04	D00-06012-009

Interface plate D22 to D28

- Interface between D28 and D22
- To also make it possible to use system components from the D28 system such as V-blocks

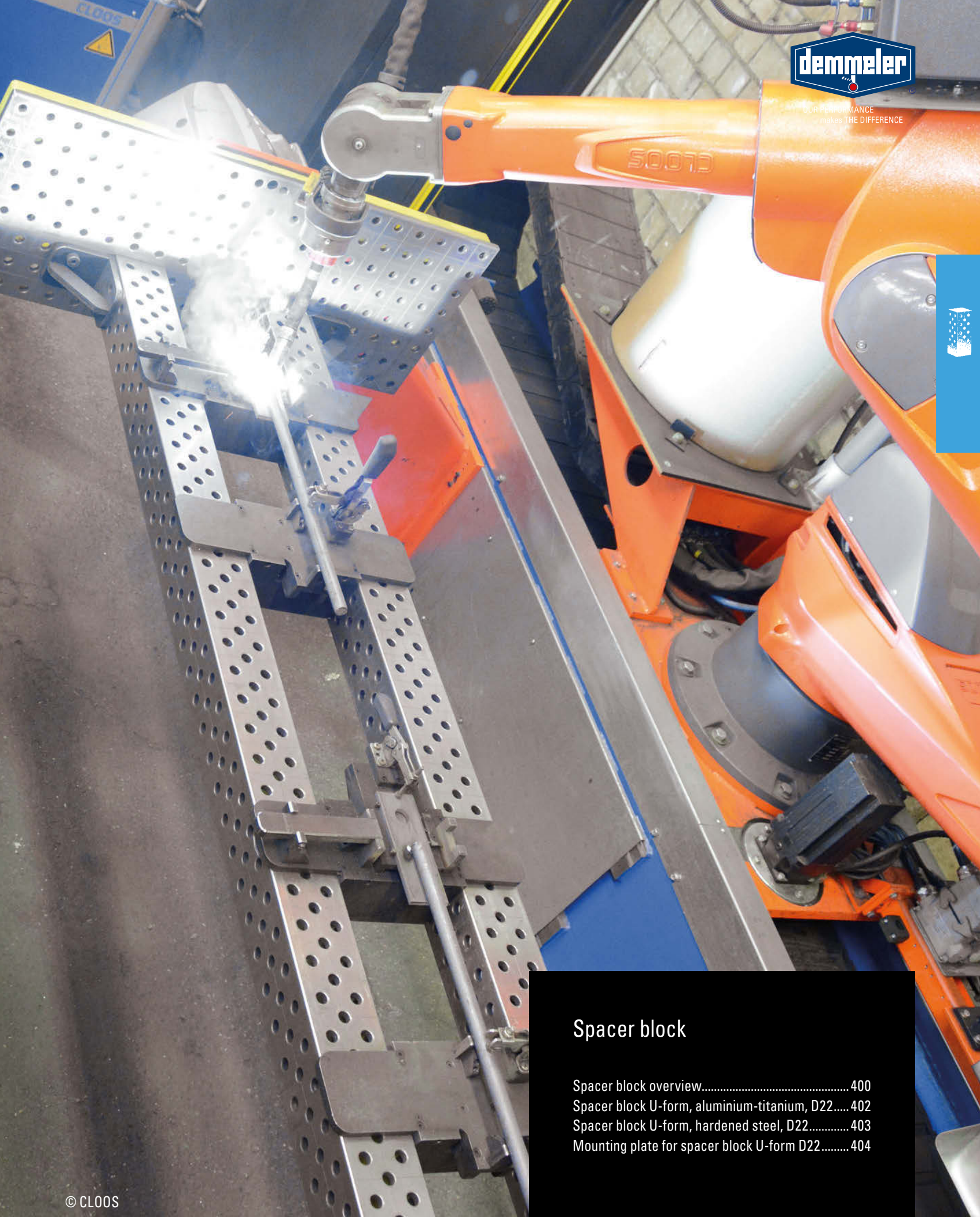


Description ▲

Application ▼



22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	150	50	50	100	1.2	D00-06015-001



Spacer block

Spacer block overview.....	400
Spacer block U-form, aluminium-titanium, D22.....	402
Spacer block U-form, hardened steel, D22.....	403
Mounting plate for spacer block U-form D22.....	404

Spacer block overview

22 Spacer block U-form, aluminium-titanium

PAGE 402



22 Spacer block U-form, steel, hardened

PAGE 403



22 Spacer block U-form, steel

PAGE 403



22 Mounting plate for spacer block U-form

PAGE 404



Thinking beyond the edge of the table

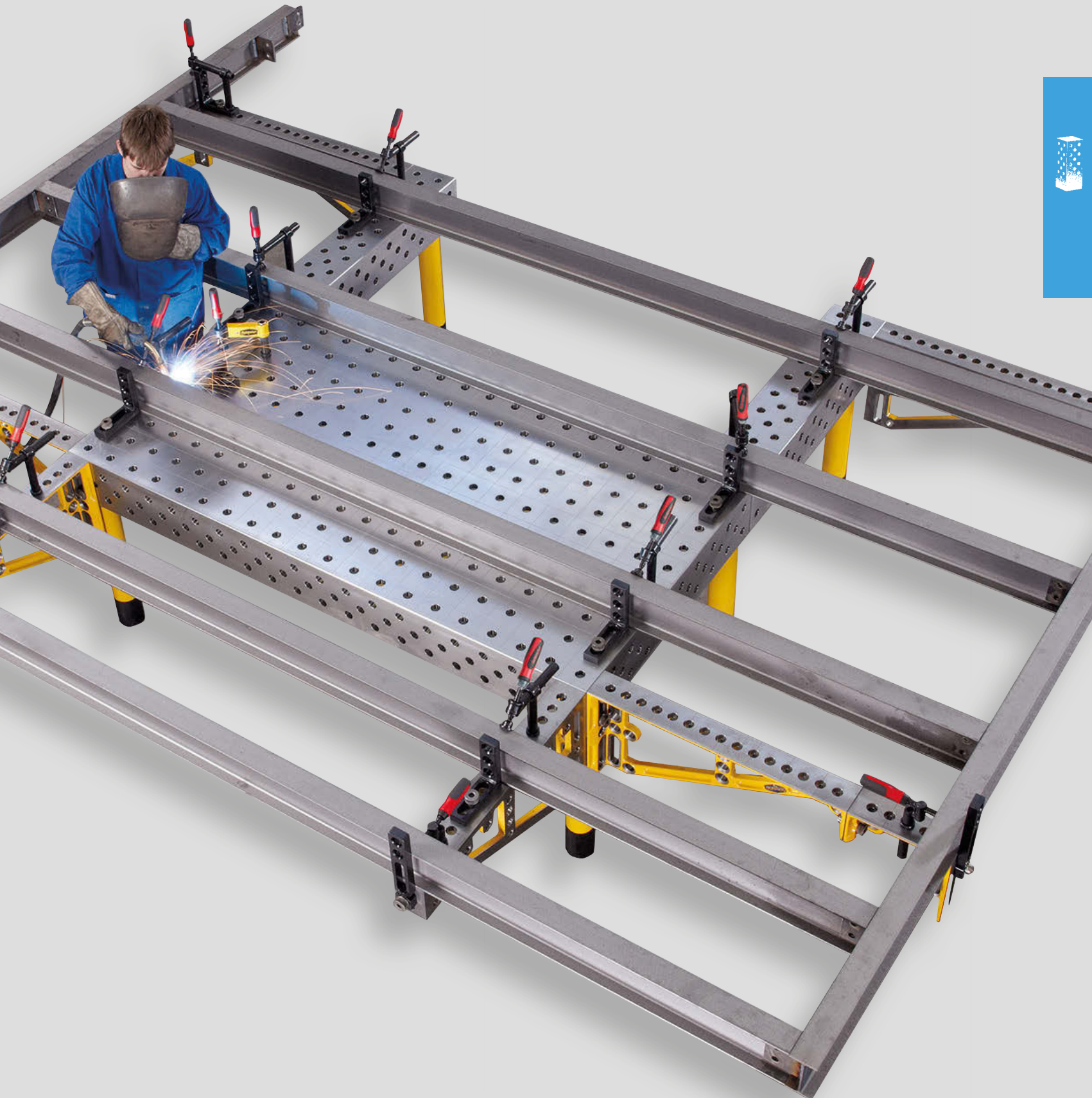
There are situations where having a bigger table would be nice. We developed the spacer block so the clamping table can grow with your needs. A smart system for the temporary expansion of your table. When you use our rail system, you can extend the supporting surface with spacer blocks as far as the rails reach.

These add-on components increase your flexibility without permanently taking up space.



OUR PERFORMANCE
makes THE DIFFERENCE

Application



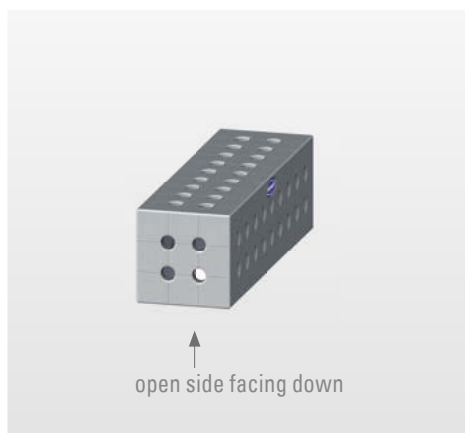
Spacer block U-form, aluminium-titanium

Recommended for automation solutions and robotics applications

- Up to ⅓ lighter than steel but nevertheless still stable
- Also suitable for use in robot cells
- Clamping surface: 5-sided
- Grid lines
- Grid 50 × 50 mm



Description ▲



22	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	250	150	150	6.5	50x50 grid	D22-04002-016
	500	150	150	11.5	50x50 grid	D22-04002-017
	1000	150	150	20.5	50x50 grid	D22-04002-018

Spacer block U-form, steel, hardened steel

- Hardened surface for less wear and for protection against adherence of weld spatters
- For use as a table extension
- Clamping surface: 5-sided
- Grid lines
- Grid 50 × 50 mm



Description ▲



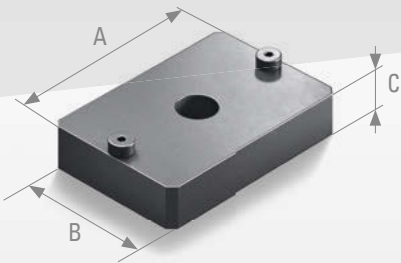
22	A in mm	B in mm	C in mm	~ Weight in kg	Description	Steel	Steel, hardened
						Item no.	Item no.
	250	150	150	17	50x50 grid	D22-04002-000	D22-04002-019
	500	150	150	30	50x50 grid	D22-04002-001	D22-04002-020
	1000	150	150	55	50x50 grid	D22-04002-002	D22-04002-021

Mounting plate for spacer block U-form

- Mounting plate for spacer block U-form D22-04002-xxx
- For supporting leg/table leg PL22-10010-xxx from 1 m length
- incl. 2x fitted shoulder screws M8 10h8x30

2x fitted bores for fitted shoulder screws

Bore for supporting leg PL22-10010-xxx (page 370)

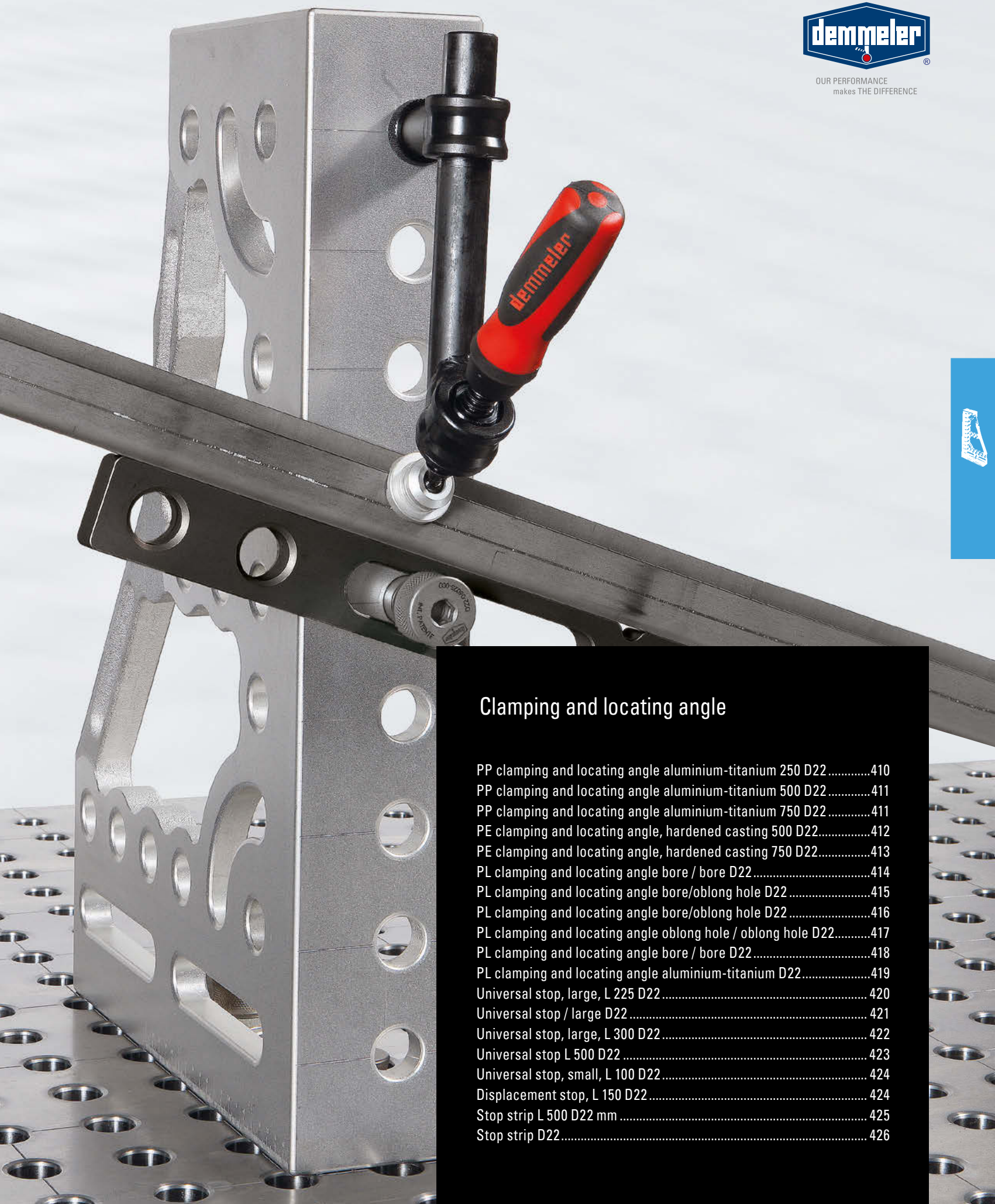


Description ▲

Application ▼



22	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	95	95	50	0.6	00108898



Clamping and locating angle

PP clamping and locating angle aluminium-titanium 250 D22	410
PP clamping and locating angle aluminium-titanium 500 D22	411
PP clamping and locating angle aluminium-titanium 750 D22	411
PE clamping and locating angle, hardened casting 500 D22	412
PE clamping and locating angle, hardened casting 750 D22	413
PL clamping and locating angle bore / bore D22	414
PL clamping and locating angle bore/oblong hole D22	415
PL clamping and locating angle bore/oblong hole D22	416
PL clamping and locating angle oblong hole / oblong hole D22	417
PL clamping and locating angle bore / bore D22	418
PL clamping and locating angle aluminium-titanium D22	419
Universal stop, large, L 225 D22	420
Universal stop / large D22	421
Universal stop, large, L 300 D22	422
Universal stop L 500 D22	423
Universal stop, small, L 100 D22	424
Displacement stop, L 150 D22	424
Stop strip L 500 D22 mm	425
Stop strip D22	426

Clamping and locating angle overview

22 PROFIPremiumLINE
Clamping and locating angle
aluminium-titanium 250

PAGE 410



22 PROFIPremiumLINE
Clamping and locating angle
aluminium-titanium 500

PAGE 411



22 PROFIPremiumLINE
Clamping and locating angle
aluminium-titanium 750

PAGE 411



22 PROFIEcoLINE
Clamping and locating angle
hardened cast iron 500

PAGE 412



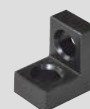
22 PROFIEcoLINE
Clamping and locating angle
hardened cast iron 750

PAGE 413



22 Clamping and locating angle, small
bore / bore

PAGE 414



22 Clamping and locating angle, small
bore / oblong hole

PAGE 415



22 Clamping and locating angle
bore / oblong hole

PAGE 416



22 Clamping and locating angle
oblong hole / oblong hole

PAGE 417



22 Clamping and locating angle
bore / bore

PAGE 418



22 Clamping and locating angle
300x250 aluminium-titanium

PAGE 419



22 Universal stop large

PAGE 420



22 Universal stop large with precision scaling

PAGE 421



22 Universal stop L 300

PAGE 422



22 Universal stop

PAGE 423



22 Universal stop small

PAGE 424



22 Displacement stop

PAGE 424



22 Stop strip

PAGE 425



22 Locating disk

PAGE 426



Clamping and locating angle

Work can be so easy!





Work can be so easy!

As a stop, table expansion or to secure angled work pieces at 90° – the new series of PROFIPremiumLINE angles with their unique grooves in a 90° kidney shape expands the application possibilities several times over. With the new design, stability was increased by up to 40 % depending on the loading case. With the integrated system bores in the size 50 grid on all faces and the extended face plate, all requirements are covered. Extremely lightweight yet sturdy implementation in aluminium-titanium alloy.

- Reinforcement in the corners with 90° system groove in kidney shape supports continuously variable use, also with angular adjustment
- Improved rigidity
- Higher number of cross braces with bores
- Extended face plate with additional bore
- 50 mm bore hole grid on all faces

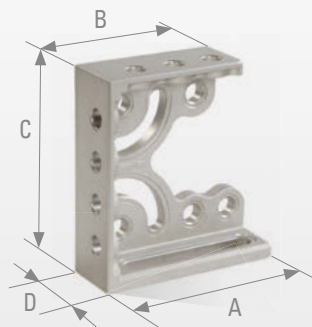
Clamping and locating angle aluminium-titanium 250

PROFIPremiumLINE

- Reinforcement in the corners with 90° system groove in kidney shape supports continuously variable use, also with angular adjustment
- 40% better rigidity
- Extended face plate with additional bore
- 50 mm bore hole grid on all faces
- 4 stop faces / usable surfaces
- D22 bore hole grid with 50 mm spacing
- 2x system groove in 90° kidney shape
- With precision scaling
- Anodised



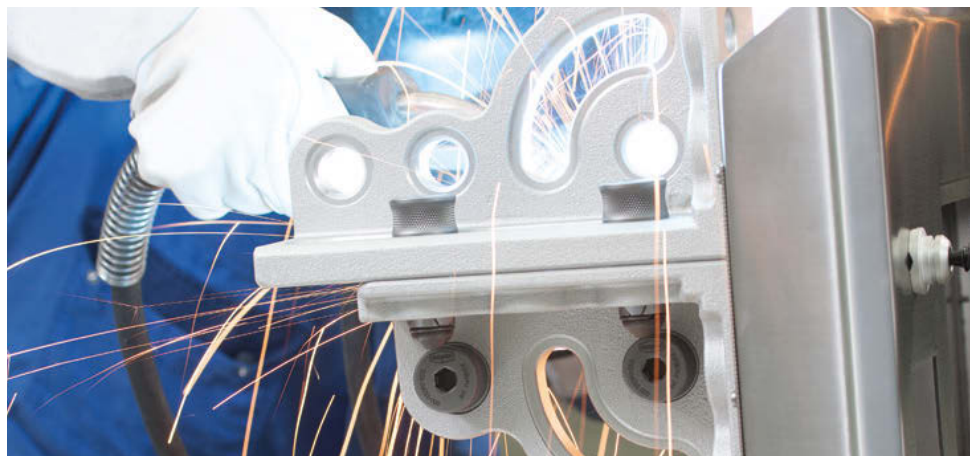
Right
P22-03002-002



Left
P22-03002-003

Description ▲ Protective countersink ▼

Application ▼

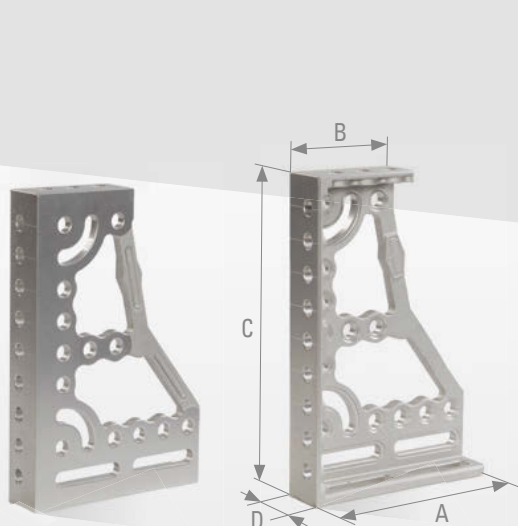


Optimum bolt and clamp insertion with simultaneous protection of the tabletop against damage from materials, even in case of extreme strain on the system bore or when used with aluminium.

22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	225	180	250	80	3.3	Right	P22-03002-002
	225	180	250	80	3.3	Left	P22-03002-003

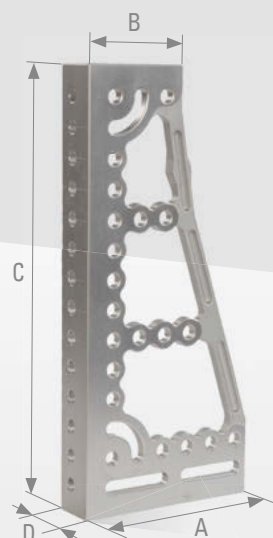
Clamping and locating angle aluminium-titanium 500

Clamping and locating angle aluminium-titanium 750



Right
P22-03003-002

Left
P22-03003-003

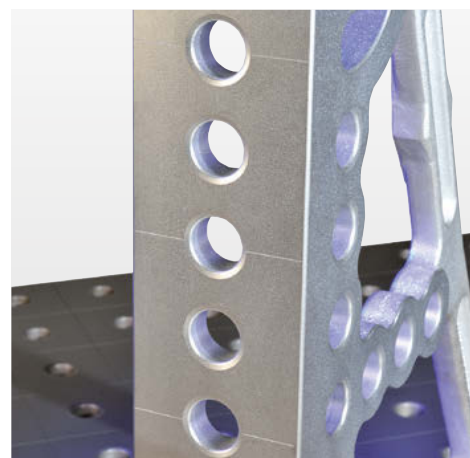


Right
P22-03004-000



Left
P22-03004-001

Application ▼



Clamping and locating angle aluminium-titanium 500

22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	325	180	500	80	6.4	Right	P22-03003-002
	325	180	500	80	6.4	Left	P22-03003-003

Clamping and locating angle aluminium-titanium 750

22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	325	180	750	80	8.3	Right	P22-03004-000
	325	180	750	80	8.3	Left	P22-03004-001

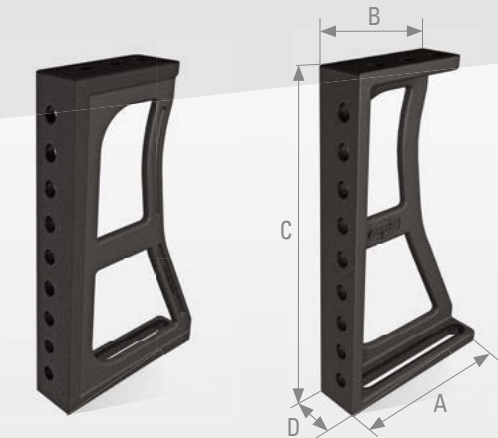
Clamping and locating angle casting hardened 500

PROFIEcoLINE



DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- DEMONT 760 M Black Edition – Hardened casting
- The Eco series. Reduced to the essentials, yet tremendously flexible. Designed for all common stop and clamping applications with system bores in a size 50 grid and 3 usable stop faces, yet truly affordable. The solution for anyone who just doesn’t need more
- Cost-effective version
- Three supporting surfaces
- With precision scaling

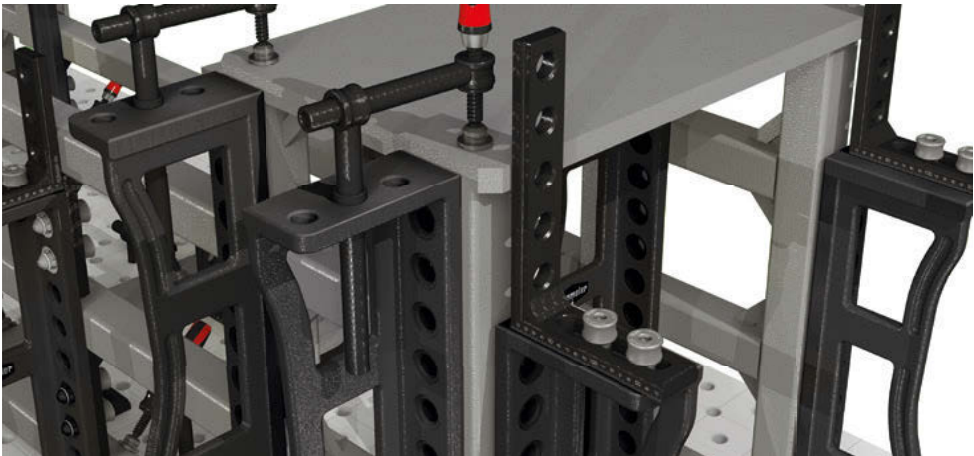


Right
PE22-03003-000

Left
PE22-03003-001

Description ▲

Application ▼



22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	275	175	500	80	13.5	Right	PE22-03003-000
	275	175	500	80	13.5	Left	PE22-03003-001

- DEMONT 760 M Black Edition – Hardened casting
- The Eco series. Reduced to the essentials, yet tremendously flexible. Designed for all common stop and clamping applications with system bores in a size 50 grid and 3 usable stop faces, yet truly affordable. The solution for anyone who just doesn't need more
- Cost-effective version
- Three supporting surfaces
- With precision scaling



Right
PE22-03004-000

Left
PE22-03004-001

Description ▲

22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	275	175	750	80	18.5	Right	PE22-03004-000
	275	175	750	80	18.5	Left	PE22-03004-001

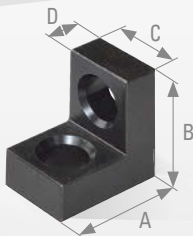
Clamping and locating angle 75 x 75 mm (bore/bore)

PROFIPlusLINE



DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Ideal for confined spaces
- Continuously adjustable support surfaces, for example in combination with D22-03001-003 (page 417)
- Steel, hardened



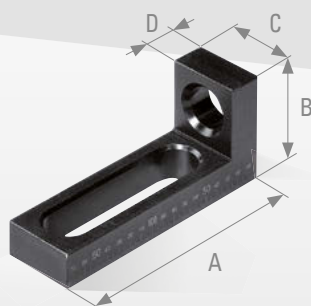
Description ▲

Application ▼



22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	75	75	50	18	0.9	Steel, hardened	D22-03001-008

- Dimension adjustment using grid lines on 3D worktable possible
- Continuous adjustment and locking via oblong hole
- Ideal for confined spaces
- Combination bore / oblong hole
- Steel, hardened
- With precision scaling on both sides



Description ▲

Application ▼



22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	175	75	50	18	1.1	Steel, hardened	D22-03001-005

Clamping and locating angle 175 x 175 mm bore/oblong hole

PROFIPlusLINE

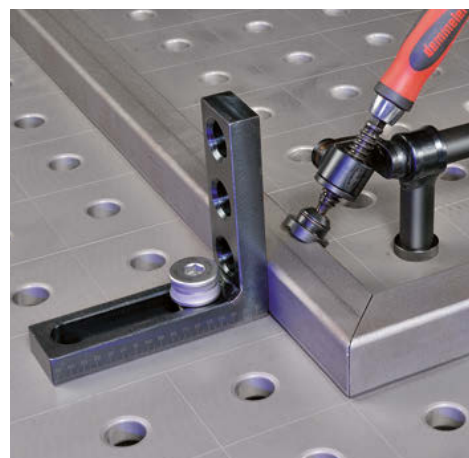

DEMONT 760 M
BLACK EDITION
 THE NEW HARDNESS

- Combination system bores / oblong hole for numerous clamping possibilities
- Steel, hardened
- Two full angle surfaces, therefore can be used from both sides
- Dimension adjustment using grid lines on 3D worktable possible
- Compatible with all clamping and locating angles so that the oblong hole can be used to form a height-adjustable support
- Precision scaling on both sides



Description ▲

Application ▼



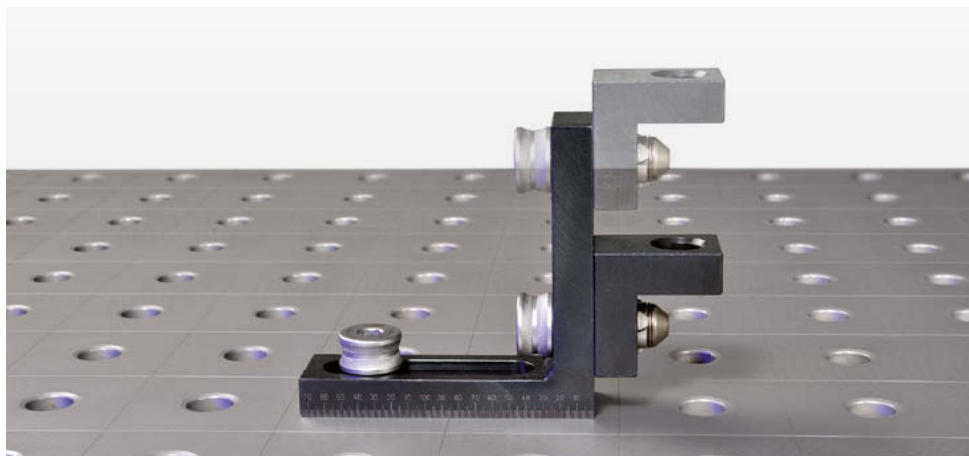
22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	175	175	50	18	1.7	Steel, hardened	PE22-03001-000

- Dimension adjustment using grid lines on 3D worktable possible
- Continuous adjustment and locking
- Ideal for confined spaces
- Steel, hardened
- Precision scaling on both sides



Description ▲

Application ▼



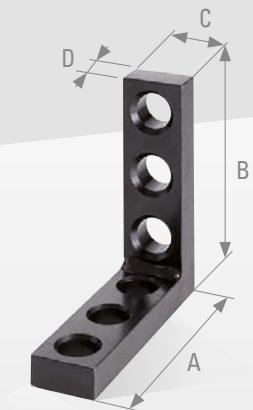
22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	175	175	50	18	1.5	Steel, hardened	D22-03001-003

Clamping and locating angle 175 x 175 mm (bore/bore)

PROFIPlusLINE



- Ideal for confined spaces
- Steel, hardened



Description ▲

Application ▼



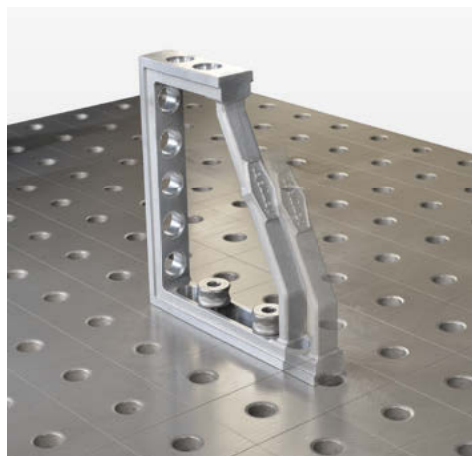
22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	175	175	50	18	1.8	Steel, hardened	D22-03001-004

- Extended face plate with two bores in the face plate
- Extended mounting plate with oblong hole 150 – therefore moveable on 50 mm grid
- Precision scaling on both sides



Description ▲

Application ▼



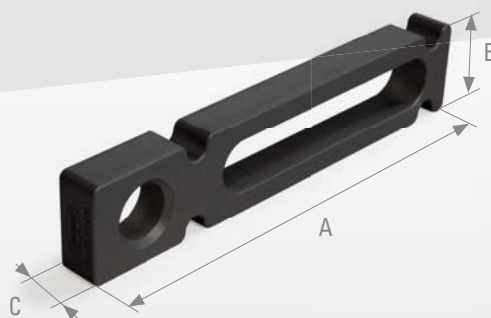
22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	250	300	50	150	1.7	Aluminium-titanium	PP22-03001-017

Universal stop, large, L 225



DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Combination system bore / oblong hole for numerous clamping possibilities
- 360° adjustable position in 45° increments
- Continuous adjustment via oblong hole
- Steel, hardened
- With precision scaling



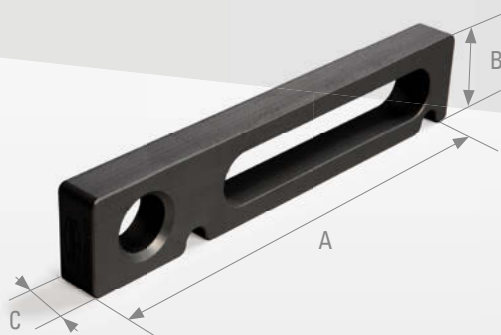
Description ▲

Application ▼



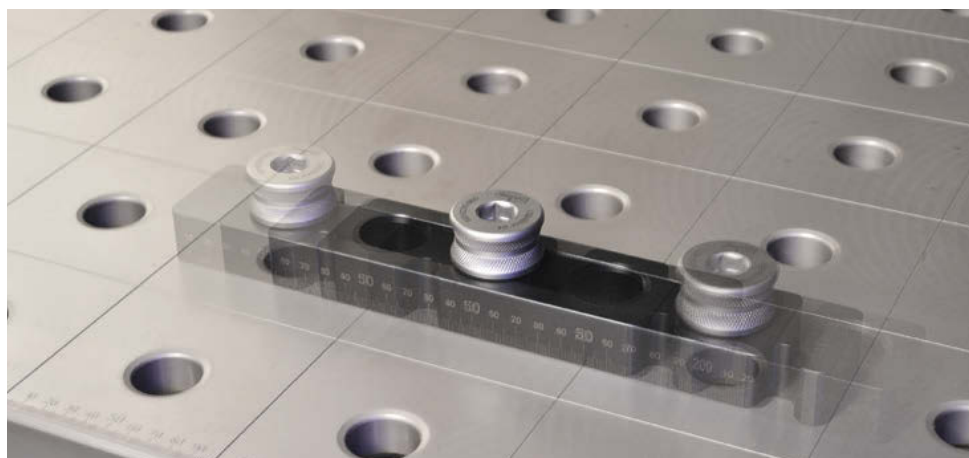
22	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	225	50	18	1.0	Steel, hardened	D22-05001-000

- Combination system bore / oblong hole for numerous clamping possibilities
- Precision scaling
- Steel, hardened
- With precision scaling



Description ▲

Application ▼



- Fine adjustable with precision scaling possible using grid lines
- 360° adjustable position
- Additional notch for attachment, ideal as corner stop
- Continuous adjustment via oblong hole

Setting out with bores in 25 mm grid

22	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	225	50	18	1.1	Steel, hardened	D22-05001-010

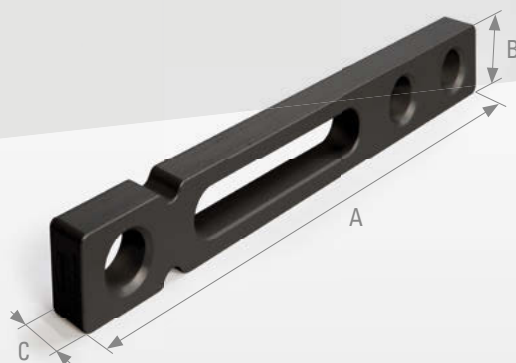
Universal stop, large, L 300

With precision scaling



DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Larger stop range than universal stop large
- Three system bores
- For bridging larger bearing surfaces
- As lateral stop for large beams
- Steel, hardened
- With precision scaling

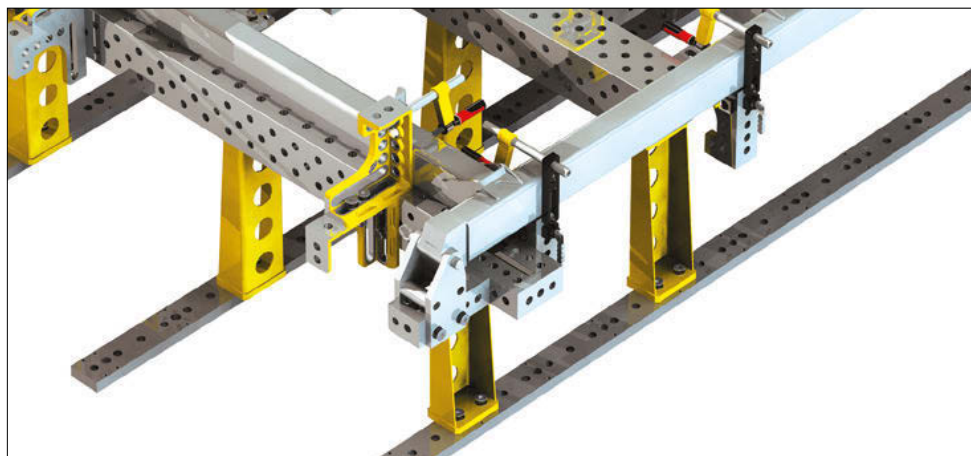


Description ▲



As lateral stop

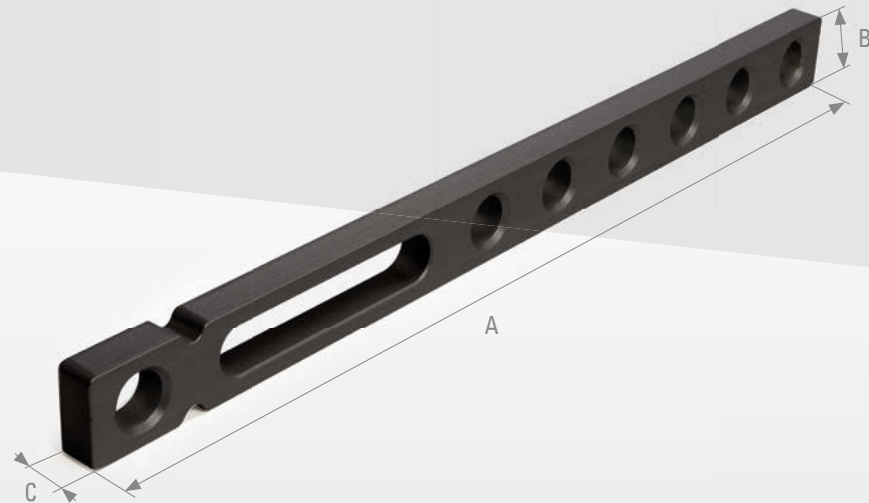
Application ▼



For bridging larger distances

22	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	300	50	18	1.5	Steel, hardened	D22-05009-000

- Larger stop range than universal stop large
- Seven system bores
- For bridging larger bearing surfaces
- As lateral stop for large beams
- With precision scaling
- Steel, hardened



Description ▲

22	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	500	50	18	3.3	Steel, hardened	D22-05009-008

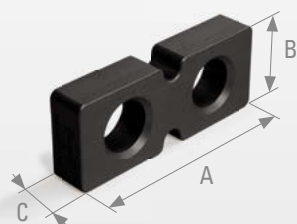
Universal stop, small, L 100

Displacement stop, L 150

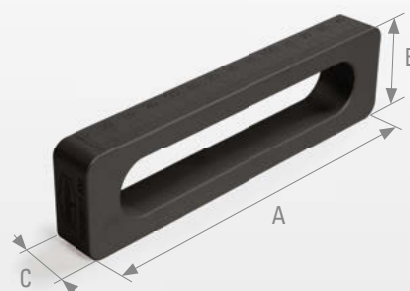


DEMONT 760 M
BLACK EDITION
THE NEW HARDNESS

- Preferred use in confined work areas
- Simple version
- Steel, hardened



- Precision scaling on both sides
- Continuously adjustable with scale on both sides
- Steel, hardened



Description ▲ Application ▼



Description ▲ Application ▼



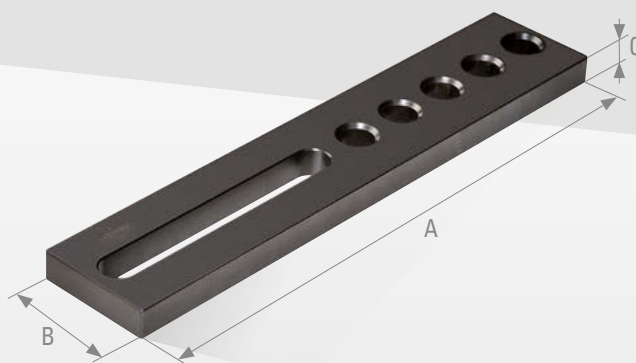
Universal stop, small, L 100

22	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	100	50	18	0.55	Steel, hardened	D22-05002-000

Displacement stop, L 150

22	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	150	50	18	0.7	Steel, hardened	D22-05015-000

- Very long and sturdy version with large bearing surfaces for large components or long distances
- Continuous adjustment via oblong hole
- Combination system bore / oblong hole for numerous clamping possibilities
- Steel, hardened
- With precision scaling

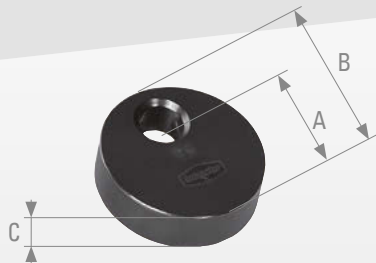


Description ▲

22	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	500	100	18	6.0	Steel, hardened	D22-05003-000

Locating disk

- Can be used as stop or support
- Attached with a connecting bolt
- Continuous adjustment by turning (adjustment path A)
- Low space requirements
- Precision scaling
- Steel, hardened



Description ▲

Application ▼



22	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	50	75	20	0.6	Steel, hardened	D22-05013-000



Supports

Spacer set D22	428
Spacer set with thread.....	429
Adapter D22 to D16.....	430
Interface plate D22 to D28	430

Spacer set 11 pieces

Height compensation in mm range

- For 5-100 mm height compensation on the respective support surface
- Smallest increment 1 mm
- Includes 1/10 inch disk (2.54 mm)
- With dimensions of the compensating disks
- Support mandrel fits system bore 22
- Self-locking with O-Ring



Description ▲ Details ▼

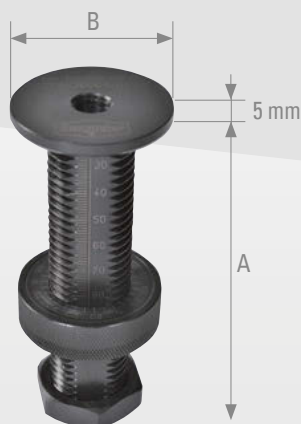
- Exact positioning to your height via bearer sleeves in various lengths or with continuously adjustable threaded spacer set

22	A in mm	Ø B in mm	~ Weight in kg	Description	Item no.
	120+5	28	2	11-piece spacer set	D22-09001-000
	5	22	0.38	individual support mandrel	00097259
	1	50	0.01	bearer sleeve L1	00097269
	2	50	0.02	bearer sleeve L2	00097268
	2.5	50	0.03	bearer sleeve L2.5	00097267
	3	50	0.04	bearer sleeve L3	00097266
	4	50	0.05	bearer sleeve L4	00097265
	5	50	0.06	bearer sleeve L5	00097264
	10	50	0.12	bearer sleeve L10	00097263
	20	50	0.24	bearer sleeve L20	00097262
	40	50	0.47	bearer sleeve L40	00097261
	50	50	0.59	bearer sleeve L50	00097260

Spacer set with thread

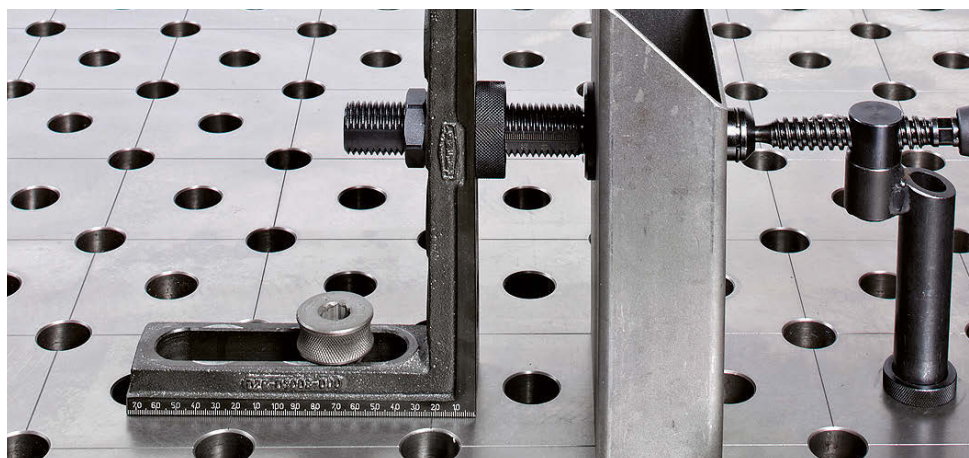
Height compensation, continuous

- As support surface on system components or directly on the table
- Adjustment path 22-105 mm continuous
- With 0.1 mm precision scaling
- Max. load capacity 500 kg
- Blackened
- Includes counter nut M22



Description ▲

Application ▼

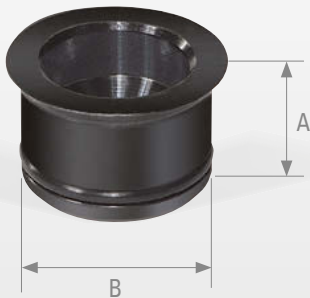


22	A in mm	Ø B in mm	~Weight in kg	Item no.
	120+5	45	0.8	D22-09001-005

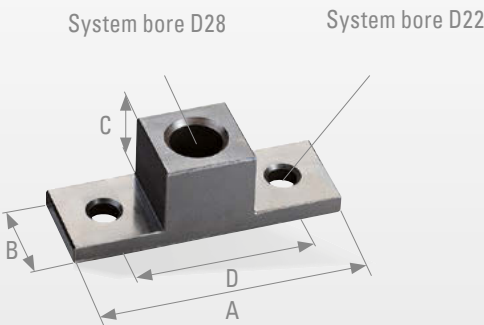
Adapter for PC-bolts D22 to D16

Interface plate D22 to D28

- Used to hold Ø 16 mm screw clamps in D22 system bores
- D16 quick-action clamping cylinder can be used in system D22
- Used to insert F16 bolts in D22 system bore



- Interface between system D28 and D22



Description ▲

Description ▲

Adapter D22 to D16

22	A in mm	Ø B in mm	~ Weight in kg	Item no.
	23	22	0.04	D00-06012-009

Interface plate D22 to D28

22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	150	50	50	100	1.2	D00-06015-001



D22 clamps

Compensating swing clamp with spindle D22	437
Compensating swing clamp with quick-action clamping cylinder D22 ..	438
Compensating swing clamp with short boring spindle D22	439
Screw clamp 180° with spindle D22	440
Screw clamp 180° with quick-action clamping cylinder D22	441
Screw clamp 180° with short boring spindle D22	442
Variable screw clamp 45° with spindle D22	443
Variable screw clamp 45° with quick-action clamping cylinder D22 ...	444
Variable screw clamp 45° with short boring spindle D22	445
Spindle with bushing and clamping pad D22	446
Short boring spindle with bushing and clamping pad D22	446
Quick-action clamping cylinder with clamping pad D22	447
Threaded bushing D22	447
Clamping pad with V-block D22	448
Interface plate D22 to D28	449
Adapter D22 to D16	450

D22 clamps overview

22 Compensating swing clamp with spindle

PAGE 437



22 Compensating swing clamp with quick-action clamping cylinder

PAGE 438



22 Compensating swing clamp with short boring spindle

PAGE 439



22 Screw clamp 180° with spindle

PAGE 440



22 Screw clamp 180° with quick-action clamping cylinder

PAGE 441



22 Screw clamp 180° with short boring spindle

PAGE 442



22 Variable screw clamp 45° with adjusting screw

PAGE 443



22 Variable screw clamp 45° with quick-action clamping cylinder

PAGE 444



22 Variable screw clamp 45° with short boring spindle

PAGE 445



22 Short boring spindle with bushing and clamping pads

PAGE 446



22 Threaded bushing D22

PAGE 447



22 Interface plate D22 to D28

PAGE 449



22 Adjustment screw with bushing and clamping pads

PAGE 446



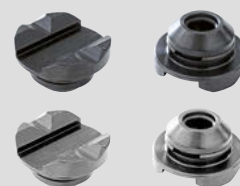
22 Quick-action clamping cylinder with clamping pads

PAGE 447



22 Plunger and contact piece / clamping pad with V-block

PAGE 448



22 Adapter D22 to D16

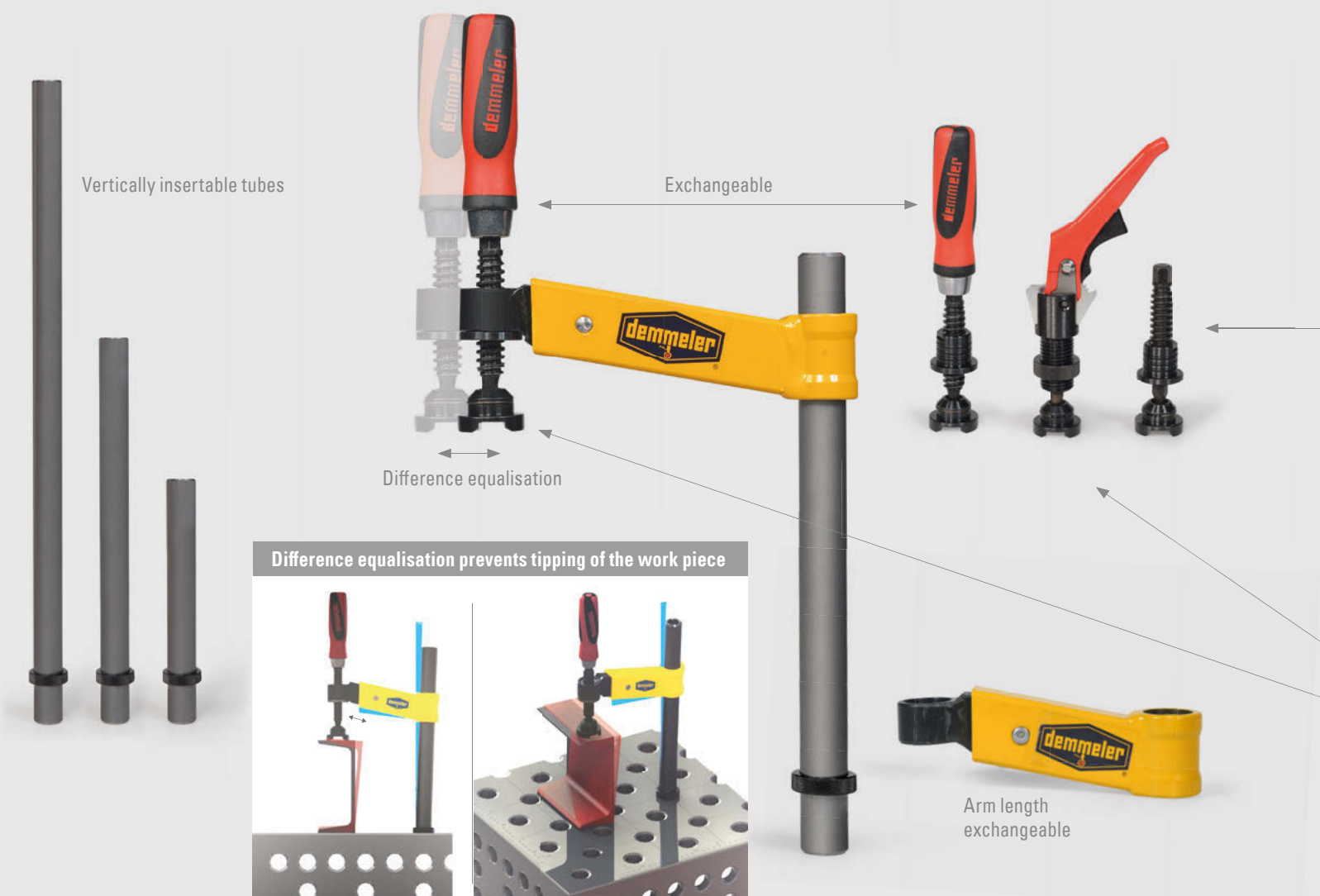
PAGE 450



Flexible down to the details

Thanks to the modular system, the clamps adapt perfectly to the respective clamping situation. Select from various materials for the clamping pad and different spindle lengths, also for small installation spaces. The latch lever makes quick and precise clamping possible even with one hand. With three different tube lengths and exchangeable arms, you can handle any clamping task.

- Slip-proof handle thanks to rubberised inserts
- Clamping with standard hexagon wrench
- Threaded bushings fit all system bores
- Clamping pad exchangeable and usable as support in system bore





- **Secure locking mechanism:**
The locking mechanism ensures controlled, fast and vibration-proof clamping.
- **Ultimate stability:**
Enables the even build-up of clamping force with large power reserves. The self-centring support and pressure piece clamps the work piece and can be exchanged.
- **The powder-coated clamping lever** features a highly ergonomic shape and swivels 360° degrees to circumvent all interfering edges. The plastic-coated, non-slip release lever ensures a secure grip while loosening the clamp.
- **Large stroke: 9 mm**

Exchangeable

Exchangeable

Horizontally insertable tubes

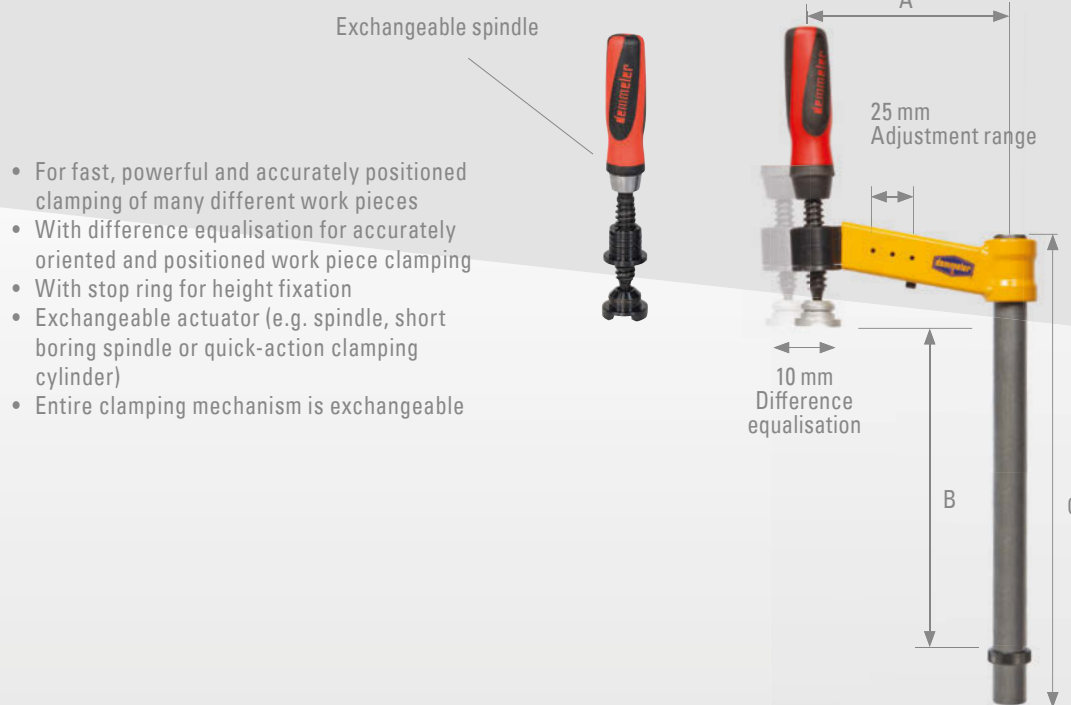
Insertable clamping pad

Vertically insertable tubes



Compensating swing clamp with spindle

For profiles that tend to tip



Description ▲

Application ▼

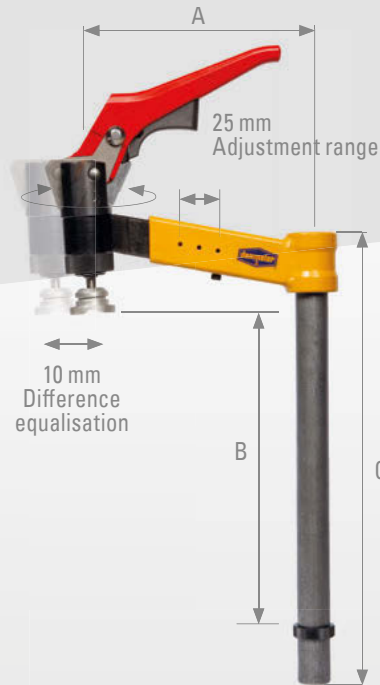


22	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	125-150	max. 210	300	1.5	D22-07001-000

Compensating swing clamp with quick-action clamping cylinder

Quick-action clamping cylinder, exchangeable

- Up to 5x faster clamping than with conventional screw clamps
- Higher clamping forces quickly with little expenditure of energy
- 360° swivelling lever bypasses interfering edges
- Large stroke
- Entire clamping mechanism is exchangeable



Description ▲

Application ▼

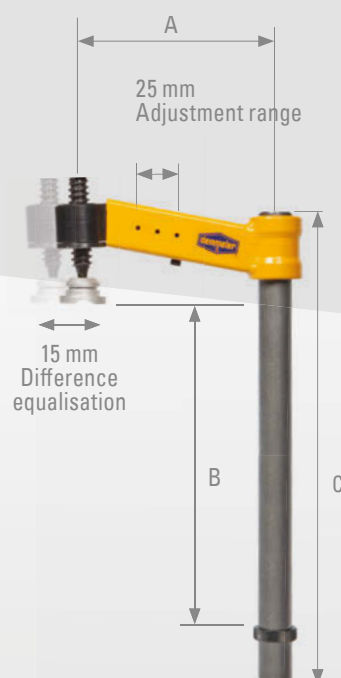


22	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	125-150	max. 210	300	1.8	D22-07001-001

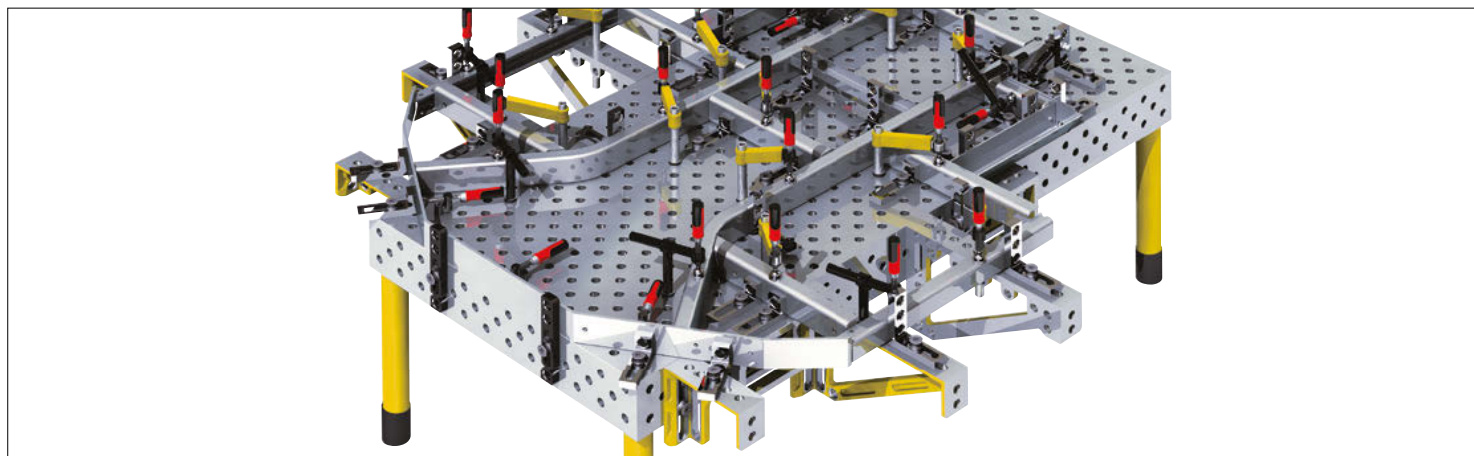
Compensating swing clamp with short boring spindle

- Clamping with open-end wrench AF 10
- Highly recommended for confined spaces

Exchangeable spindle



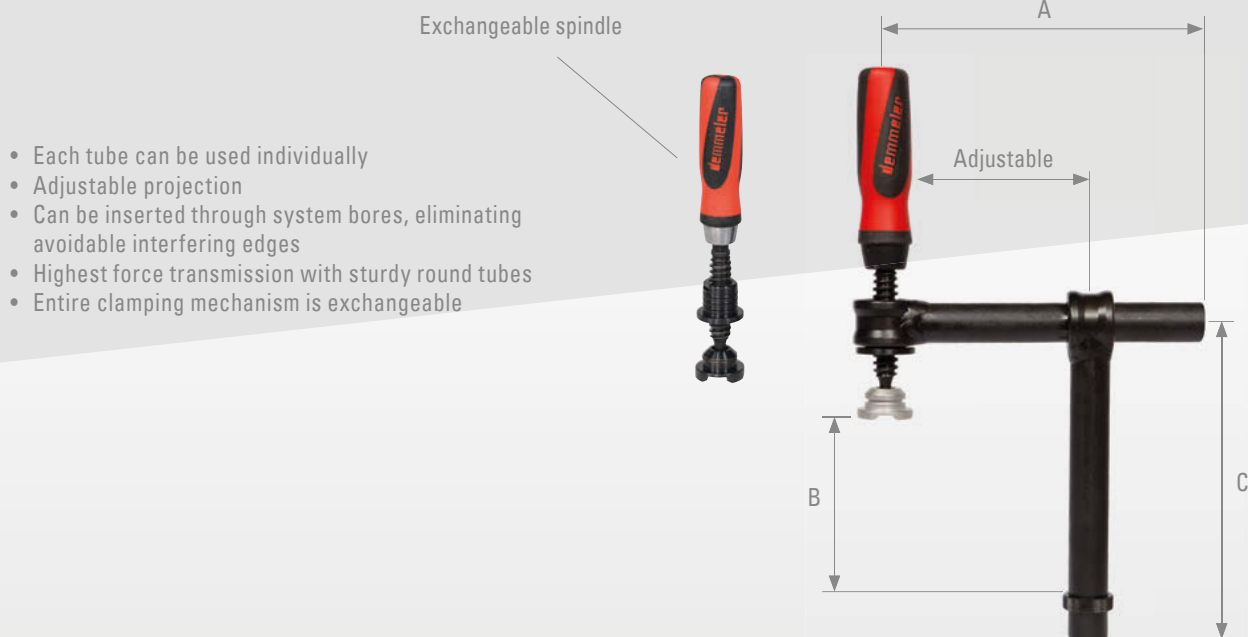
Description ▲ Application ▼



22	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	125-150	max. 210	300	1.3	D22-07001-002

Screw clamp 180° with spindle

With adjustable, sturdy round tube



Description ▲ Application ▼

Application ▼



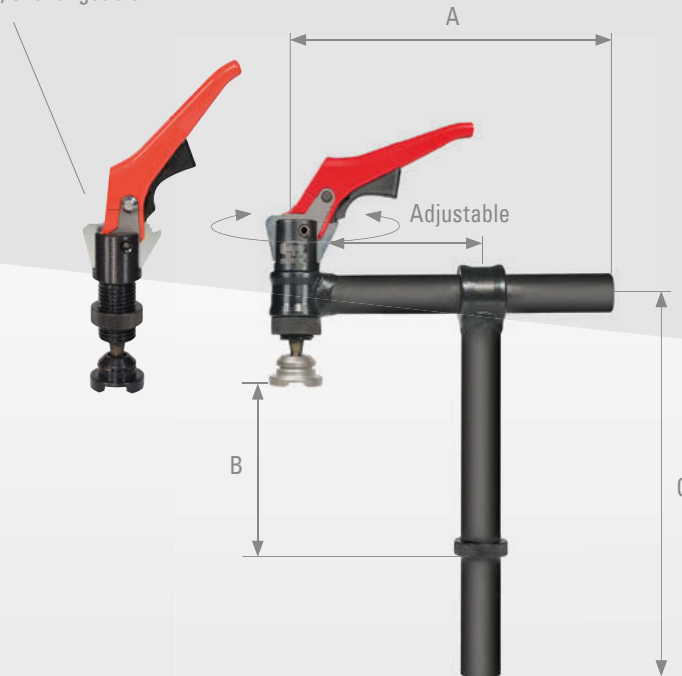
22	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	175	max. 200	300	1.2	D22-07005-000

Screw clamp 180° with quick-action clamping cylinder

With adjustable, sturdy round tube

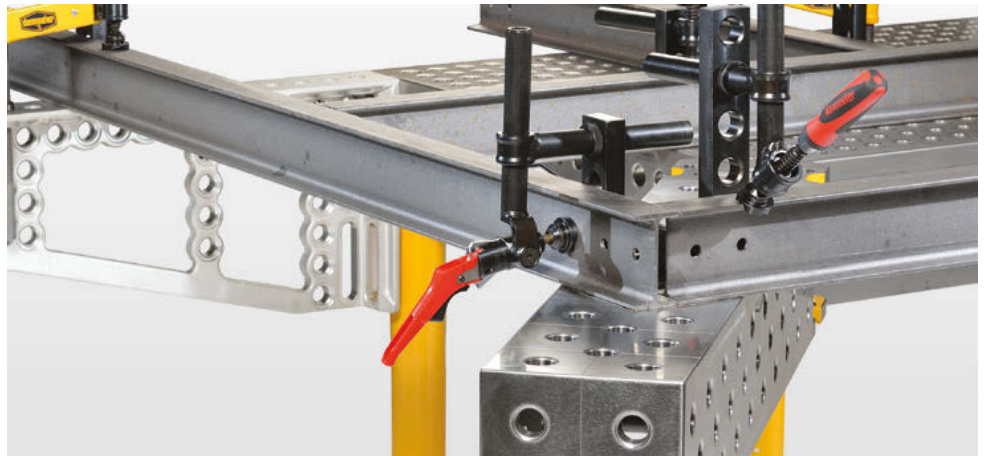
Quick release skewer, exchangeable

- Up to 5x faster clamping than with conventional screw clamps
- Higher clamping forces quickly with little expenditure of energy
- 360° swivelling lever bypasses interfering edges
- Highest force transmission with sturdy round tubes
- Entire clamping mechanism is exchangeable
- Large stroke



Description ▲

Application ▼

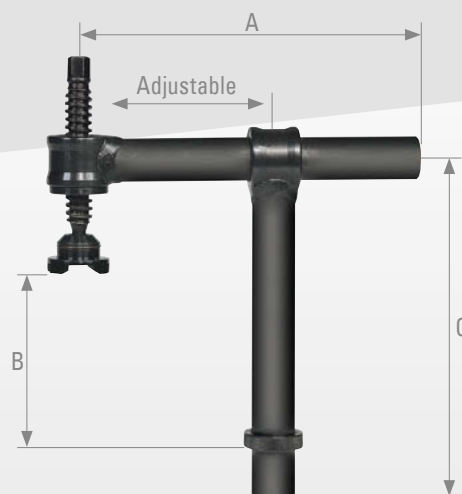


22	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	175	max. 200	300	1.5	D22-07005-001

Screw clamp 180° with short boring spindle

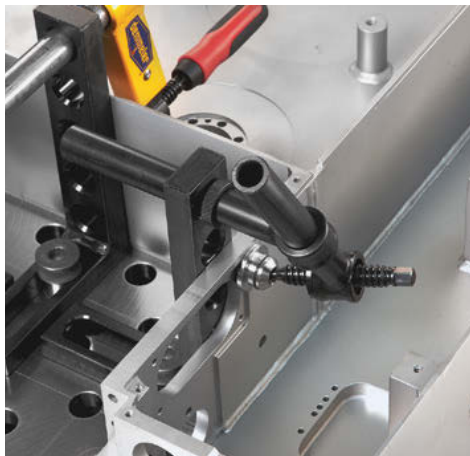
- Highest force transmission with sturdy round tubes
- Operation with open-end wrench AF 10
- Highly recommended for confined spaces
- Each tube can be used individually.
- Entire clamping mechanism is exchangeable

Exchangeable spindle



Description ▲

Application ▼



22

A in mm
175B clamping width in mm
max. 200C in mm
300~ Weight in kg
2.10Item no.
D22-07005-004

Variable screw clamp 45° with spindle

- Highest force transmission with sturdy round tubes
- Ideal for clamping prismatic profiles as well as rectangular and square profiles
- Entire clamping mechanism is exchangeable

Exchangeable spindle



Description ▲ Application ▼

Application ▼



Perfect positioning on all locating surfaces thanks to optimum action of force!



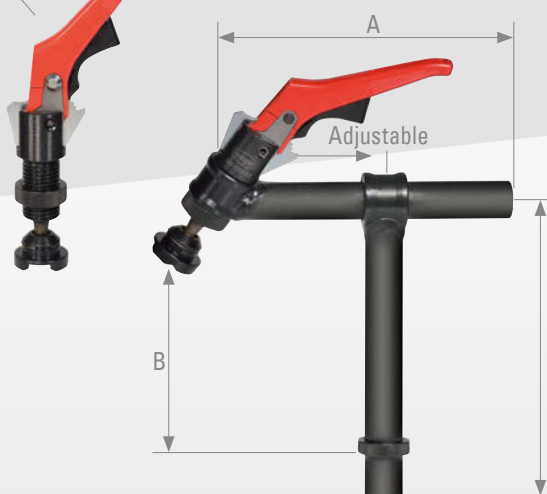
22	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	175	max. 200	300	1.2	D22-07009-000

Screw clamp 45° with quick-action clamping cylinder

With adjustable, sturdy, rotating round tube

- Up to 5x faster clamping than with conventional screw clamps
- Higher clamping forces quickly with little expenditure of energy
- 360° swivelling lever bypasses interfering edges
- Highest force transmission with sturdy round tubes
- Entire clamping mechanism is exchangeable
- Large stroke

Quick release skewer, exchangeable



Description ▲

Application ▼



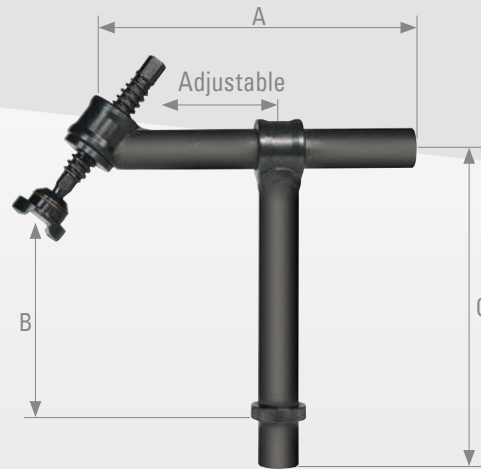
22	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	175	max. 200	300	1.5	D22-07009-001

Variable screw clamp 45° with short boring spindle

With adjustable, sturdy, rotating round tube

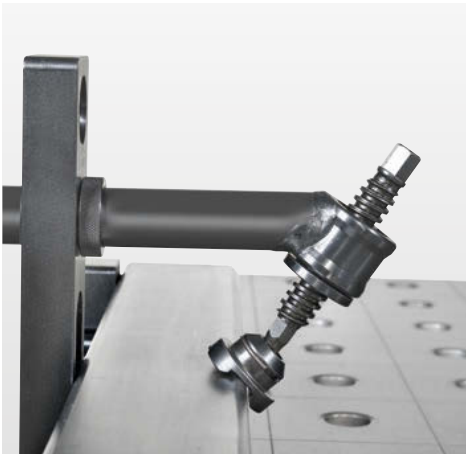
- Highest force transmission with sturdy round tubes
- Operation with open-end wrench AF 10
- Highly recommended for confined spaces
- Entire clamping mechanism is exchangeable

Exchangeable spindle



Description ▲ Application ▼

Application ▼

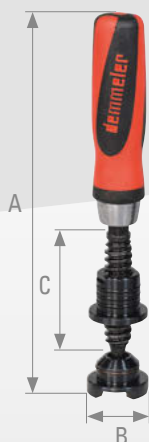


22	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	175	max. 200	300	2.10	D22-07009-004

Spindle with bushing and clamping pad

Short boring spindle with bushing and clamping pad

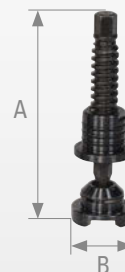
- High-quality 2-component plastic handle
- Long threaded spindle
- Threaded bushing works with any system bore
- Exchangeable clamping pad (see page 448 ff)
- Suitable to pretension work pieces



Clamping pad with cross prism

- Highly recommended for confined spaces
- Operation with open-end wrench AF 11
- Direct use in system bores possible
- Ideal to pretension work pieces

With hexagonal wrench AF 11



Clamping pad with cross prism

Description ▲ Application ▼



Description ▲ Application ▼



22	A in mm	Ø B in mm	C in mm	~ Weight in kg	Item no.
	200	32	70	0.538	D22-07020-001

22	A in mm	Ø B in mm	~ Weight in kg	Item no.
	110	32	0.2	D22-07022-000

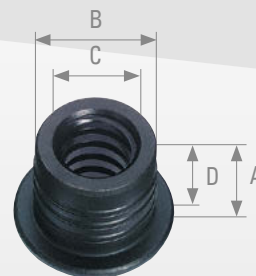
Quick-action clamping cylinder with clamping pad

Threaded bushing D22

- Up to 5x faster clamping than conventional screw clamps
- The locking mechanism ensures controlled, fast and vibration-proof clamping
- Higher clamping forces quickly with little expenditure of energy
- Large 9 mm stroke
- The self-centring support and pressure piece clamps the work piece and can be exchanged
- The powder-coated clamping lever features a highly ergonomic shape
- The plastic-coated, non-slip release lever ensures a secure grip while loosening the clamp



Clamping pad with cross prism



Description ▲ Application ▼



Application ▼



22	A in mm	Ø B in mm	~ Weight in kg	Item no.
	25	32	0.6	D22-07021-000

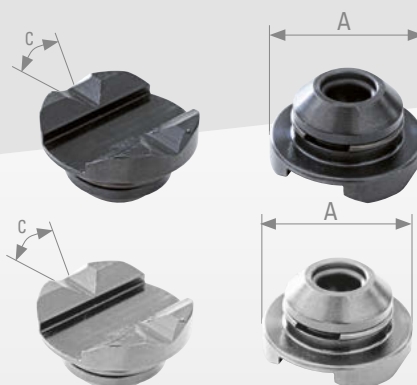
22	A in mm	Ø B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	28.5	22	14	25	0.07	D22-06012-000

Plunger and contact piece / clamping pad with V-block

- Clamping pad with V-block

Steel, blackened

Aluminium

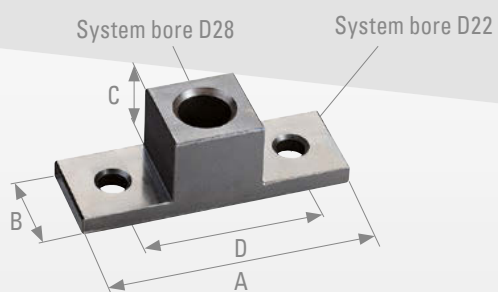


Description ▲ Application ▼

Flat or upright positioning	Self-centring clamping on the work piece	Also as contact piece in the system bore
Clamping larger diameters without problems	No slipping and tipping possible	... no matter where the force is applied! No slipping

22	A in mm	C in °	Description	Quantity	Item no.
	32	120	Steel, blackened	1 units	D22-07011-001
	32	120	Aluminium	1 units	D22-07011-000

- Interface between D28 and D22
- To also make it possible to use system components from the D28 system such as V-blocks



Description ▲

Application ▼



22	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	150	50	50	100	1.2	D00-06015-001

Adapter D22 to D16

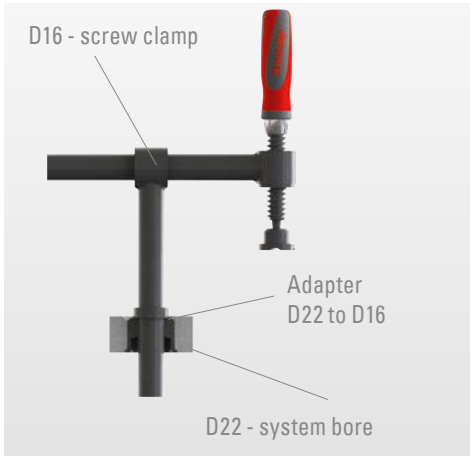
- Interface between system D22 and D16
- Fully compatible with system D22 and D16
- Force-fit and form-fitting with O-ring, self-centring connection
- O-ring prevents simultaneous rotation while tightening
- O-ring cleans the system bore



Description ▲ Application ▼

Application ▼

Application ▼



22	A in mm	Ø B in mm	~ Weight in kg	Item no.
	23	22	0.04	D00-06012-009

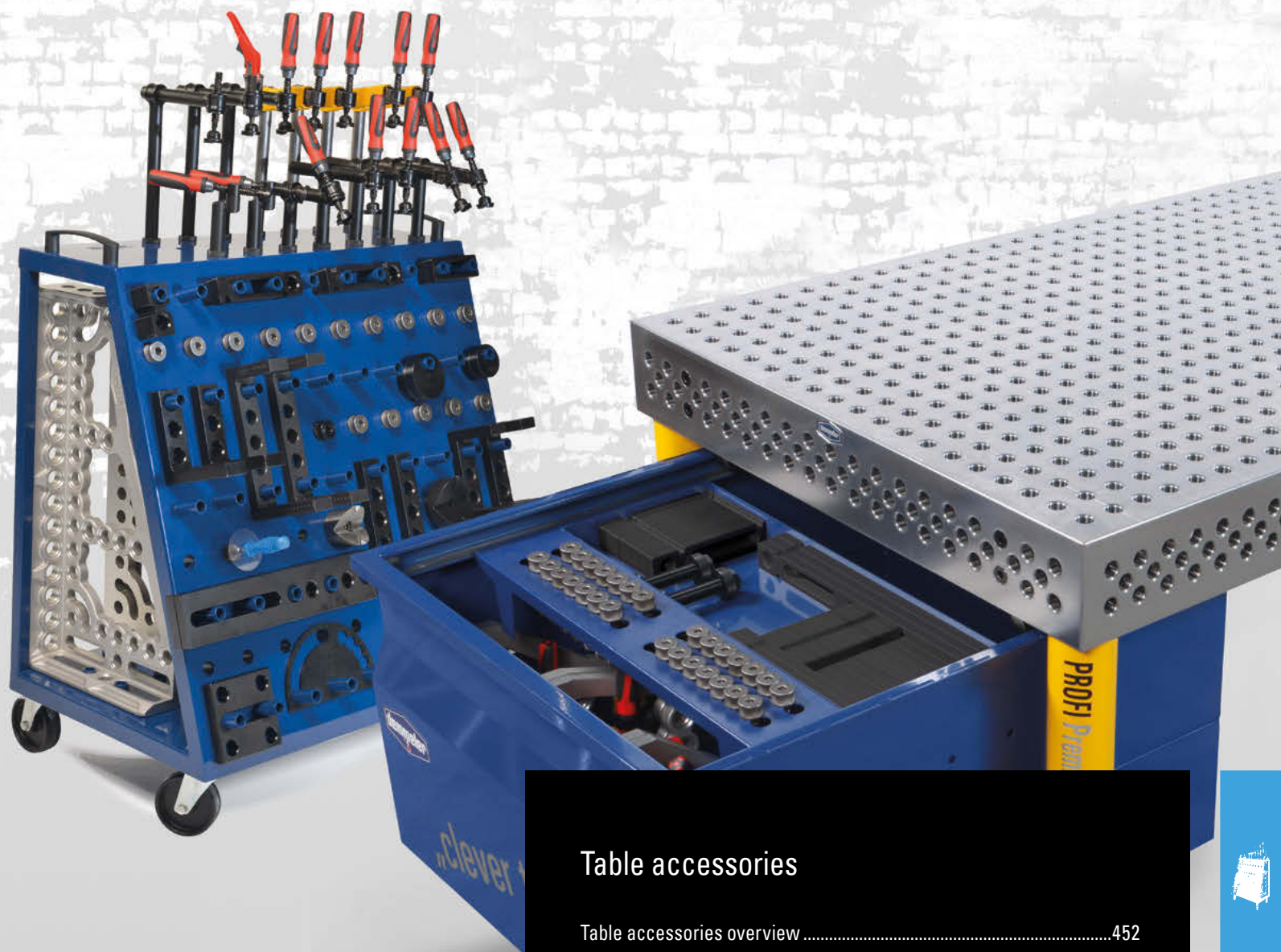


Table accessories

Table accessories overview	452
Accessory cart D22	454
"clever toolbox" D22	455
Transport ring D22	456
Assembly lever D22	457
Torque wrench D22.....	458
Allen key D22.....	458
Allen key with cross-handle D22	459
Round brush D22 mm.....	459
Ground connector	460
Bench stone	461
Tarpaulin.....	461
Pump bottle with worktable system protective spray	462
Worktable system protective spray in a canister	462

Table accessories overview

22 Accessory cart

PAGE 454



22 clever toolbox

PAGE 455



22 Transport ring

PAGE 456



22 Assembly lever

PAGE 457



22 Torque wrench

PAGE 458



22 Allen key

PAGE 458



22 Allen key with cross-handle

PAGE 459



22 Round brush

PAGE 459



Ground connector

PAGE 460



Bench stone

PAGE 461



Worktable tarpaulin

PAGE 461



Pump bottle with protective spray

PAGE 462



Protective spray in a canister

PAGE 462



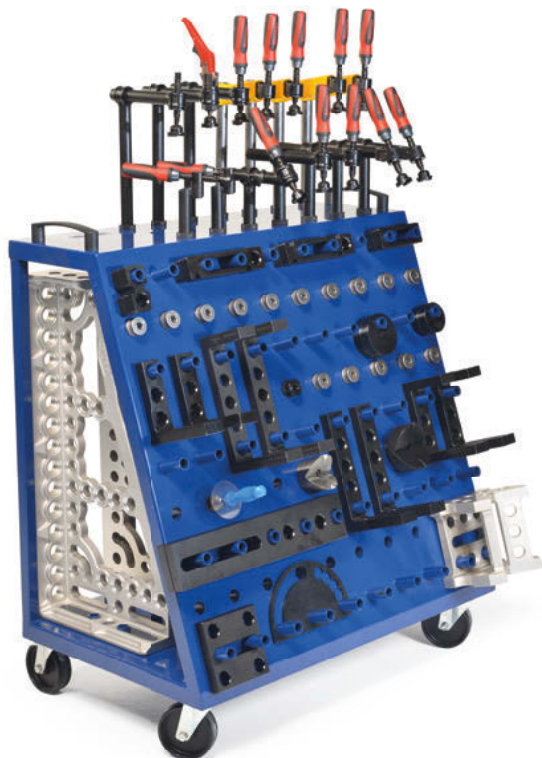
Accessory cart D22

- Establishes a tidy and orderly workstation
- Faster access to the system components
- Large angles are safely and conveniently stored inside the cart.
- Fast to transport thanks to four sturdy 360° swivelling casters, one of them locking.



Description ▲ Application ▼

Application ▼

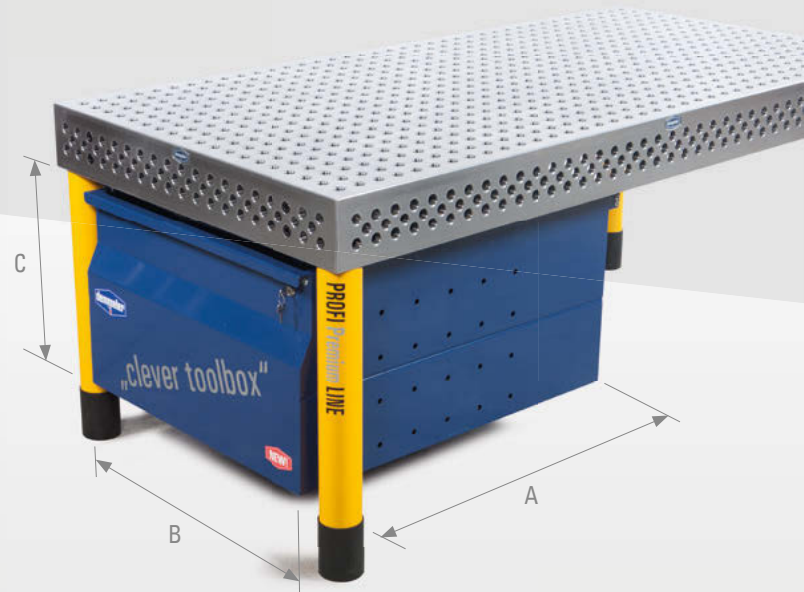


System components not included

22	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	800	503	1068	55	D22-11001-000

"clever toolbox"

- An ingeniously-designed extendible accessory box
- Saves space and time, protects tools and can be locked
- The "clever toolbox" can be mounted on all four sides and has a load capacity of up to 170 kg
- The "clever toolbox" is easy to access thanks to its ground clearance (10 cm)
- The protective plate integrated under the table protects it from dirt and weld spatter



Description ▲

Application ▼



From a table size of 1000 x 1000 mm

22	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	980	780	520	65	D22-11001-015

Transport ring D22

- For fast and safe transport of all system components (e.g. welding table)
- Attachment with 2 x PPC bolts (D22-06025-000 or E22-06025-000)



Description ▲	Note ▼
---------------	--------

Max. transport weight in [t] with different attachment methods			
Transport ring			
Tilt angle	0°	0°	0° - 45°
Number of transport rings	1	2	2
D22 system	1.8 t	3.6 t	2.4 t

- Transport ring D00-10001-000 must always be attached with at least 2 x PPC bolts.
- Max. tightening torque D22: 25 Nm (Bolts are not included in the scope of delivery of the transport ring).
- Countersunk head bolts may not be used!
- Only use transport ring for DEMMELER 3D systems.
- Internal operating instructions must be observed!
- Only undamaged transport ring and PPC bolts may be used!
- The transport ring must be fixed centrally on the worktop. If two transport rings are used, these must be fixed symmetrically in the middle of the worktop. The maximum diagonal pulling angle must not exceed 45° (see warning notes).
- The general regulations for means of transport have to be observed when using the transport ring!
- Depending on the application, the load capacity may be significantly reduced.
- Loads may only be applied to the transport ring in the ring plane! Do not exceed the load capacity!
- Do not allow personnel to stand underneath suspended loads.
- Observe the warning notes on the transport ring!

22	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	200	120	130	4.1	D22-10001-000

Assembly lever

Clamping and releasing made easy

- Suitable for clamping and releasing D22 PPC bolts
- For easy removal of D22 PPC bolts
- Handle simultaneously used for pre-centring



Description ▲

Application ▼



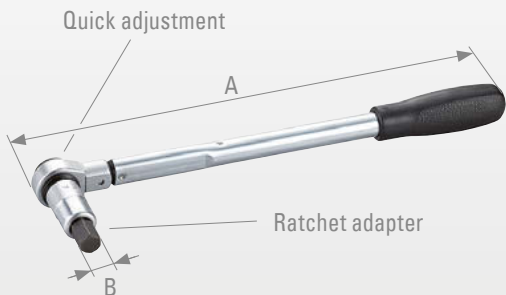
22	A in mm	B in mm	~ Weight in kg	Item no.
	250	45	0.72	D22-10016-001

Torque wrench

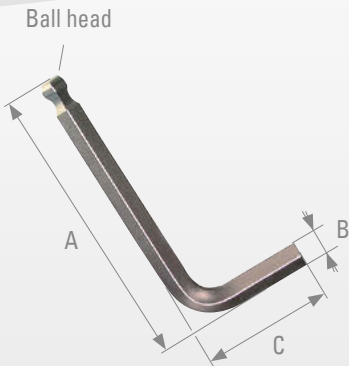
Allen key

Clamping and releasing made easy

- Pre-set to 25 Nm for controlled tightening of PPC bolts, avoiding damage to the system bore and bolt by over-tightening
- Includes 1 x ratchet adapter, adjustable (left/right) and 2 x sockets AF 8



- Good accessibility due to additional ball head



Description ▲ Application ▼

Description ▲

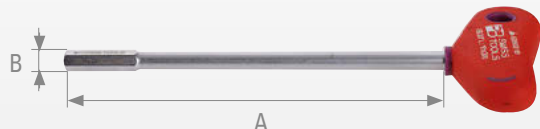


22	A in mm	B in mm	~ Weight in kg	Item no.
	348	AF 6 / AF 8	0.8	D22-10015-000

22	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	~ 112	AF 10	~ 55	0.10	D22-10008-001

Allen key with cross-handle

- Ergonomic handle for optimum tightening



Round brush

- For cleaning the system bores
- With splash guard



Description ▲

Description ▲ Application ▼

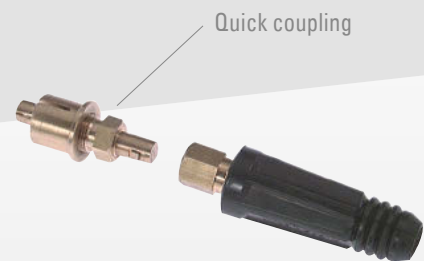


22	A in mm	B in mm	~ Weight in kg	Item no.
	200	AF 10	0.18	D22-10008-003

22	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	200	22	50	0.12	D22-10002-000

Ground connector

- Fits any system bore
- 100 % contact, therefore no overheating of the ground cable >> High efficiency factor
- For cable cross-section 50 - 70 mm², for loads up to 355 A at 100 % duty cycle, 400 A at 60 % duty cycle
- Simple and safe installation (without interfering edges)
- Compatible with common ground cables



Description ▲

Application ▼



A in mm	B in mm	C in mm	~ Weight in kg	Item no.
-	-	-	0.34	D00-10009-000

Bench stone

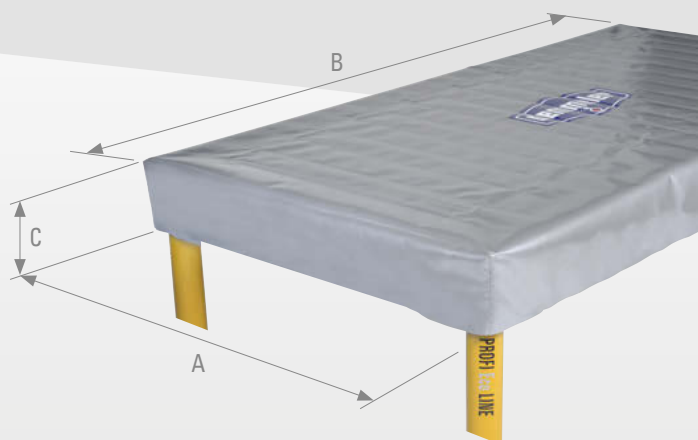
- To care for the system surfaces of worktables and system components



Tarpaulin for your original DEMMELER 3D worktable

Protected against dirt

- Very sturdy tarpaulin
- Protects your table against dirt and wetness
- Firmly sewn at the corners



System components not included

Description ▲ Application ▼



A in mm	B in mm	C in mm	~ Weight in kg	Item no.
200	50	25	0.56	D00-10007-000

Description ▲ Application ▼



A in mm	B in mm	C in mm	Description	Item no.
1000	1000	200	Tarpaulin for table	D00-10030-000
2000	1000	200	Tarpaulin for table	D00-10030-004
2400	1200	200	Tarpaulin for table	D00-10030-005
3000	1500	200	Tarpaulin for table	D00-10030-006

Pump bottle with worktable system protective spray

Worktable system protective spray in a canister

- Pressurised, sturdy version
- Includes anti-spatter spray for welding table systems
- Capacity: 1 litre
- Attention: Cannot be diluted with water!

ADVANTAGES TO YOU:

- Prevents the adhesion of weld spatter on the surface
- Temporary corrosion protection for approx. one day
- Good cleaning effect
- Not combustible
- No chlorinated hydrocarbons
- Biodegradable
- Silicone-free



- Properties:
- Parting agent for welding thin and/or pre-heated sheets and for multi-layer welding
 - Protection for worktables, system components, welding nozzles and other welding accessories

- Areas of application:
- For welding VA materials, steel and other metals



Description ▲ Application ▼

Description ▲



A in mm	B in mm	Description	Item no.
280	100	Without welding spray	D00-10004-000
280	100	With 1 litre welding spray	D00-10005-000

A in mm	B in mm	Description	Item no.
230	200	5 litre canister	D00-10006-000
310	200	10 litre canister	D00-10006-001
400	350	30 litre canister	D00-10006-002

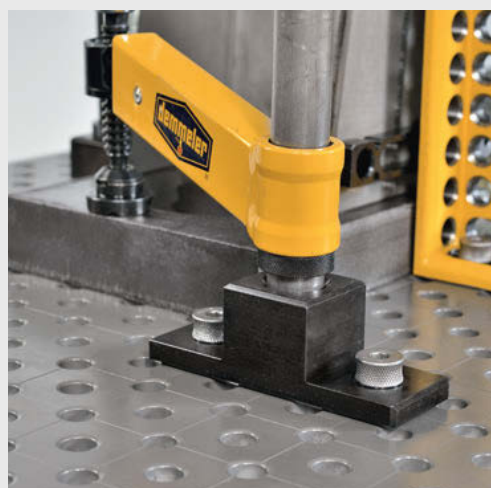
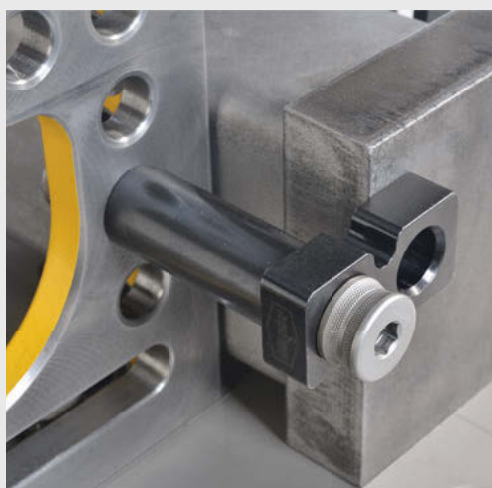
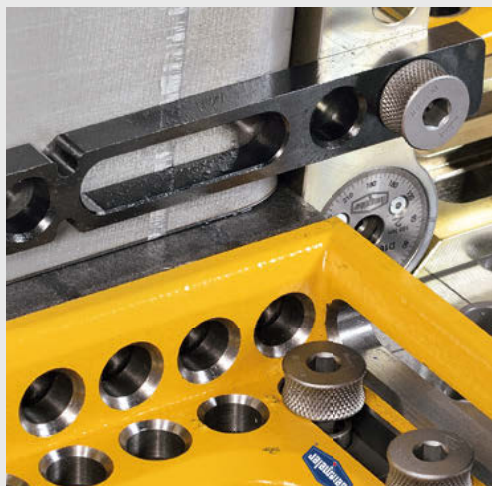


OUR PERFORMANCE
makes THE DIFFERENCE

D16



D16

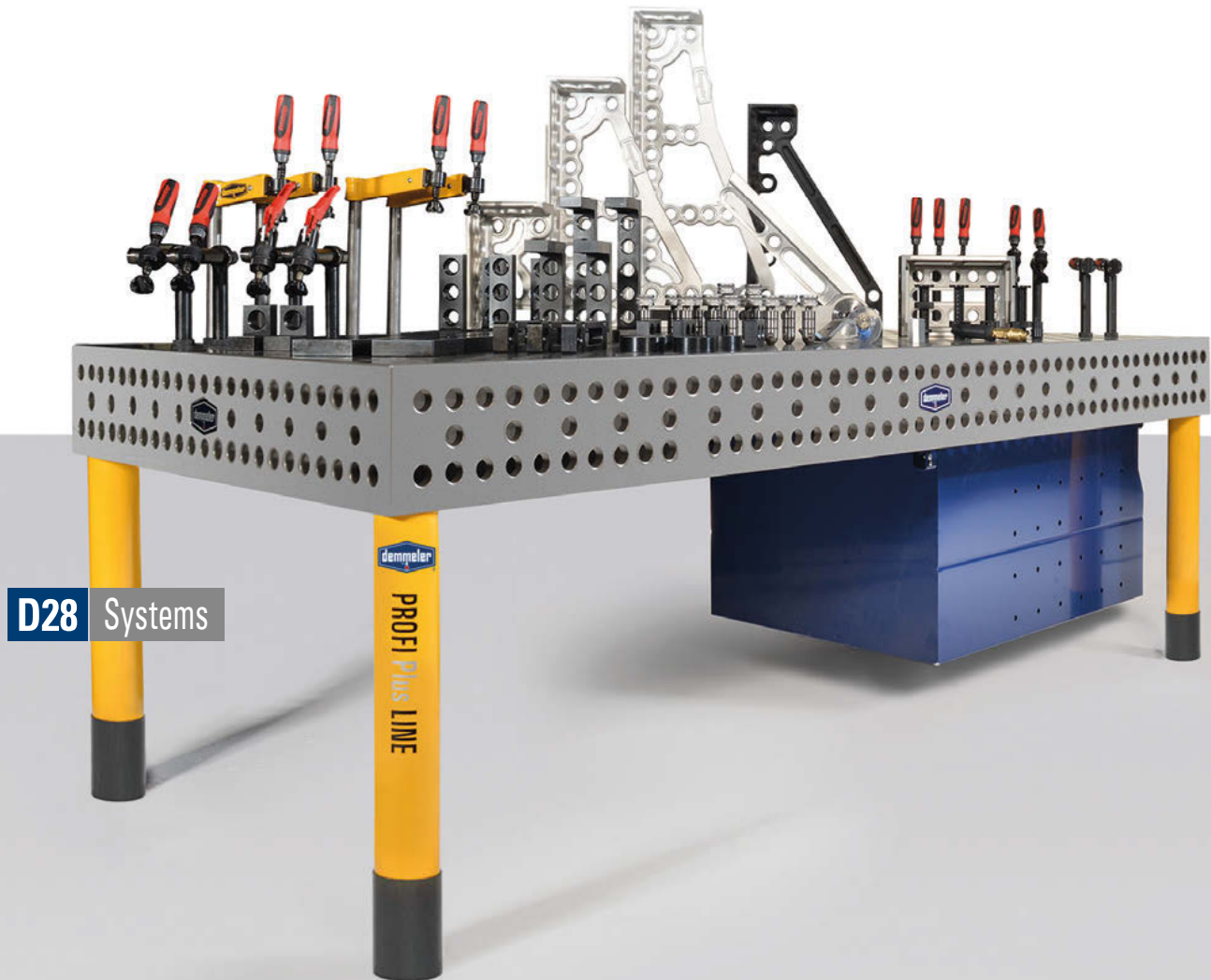




3D clamping system

3D clamping system overview	466
D16 3D clamping system overview	468
Benefits of the Demmeler system tables	470
DEMONT 760 M	472
Leg type variant overview	474
D16 table sizes	476
Overview of D16 table line	477
PROFIPlusLINE 16 (PL) 3D table	478
PROFIEcoLINE 16 (PE) 3D table	480
Ordering summary for D16 table legs	482
D16 3D worktable Okto 50	486
D16 3D worktable Okto 100	487
D16 clamping and adapter plate Okto AF	488
D16 base bridges	489
D16 segmented grid plate	490

The optimum 3D worktable for every application – the intelligent system grids boost productivity



D28 Systems

D28 / For everyday, large welded constructions



D28 PROFIPremiumLINE (PP)

- Grid 50 x 50 mm
- 3-hole drilling pattern in the table side plates, 50 mm grid in the top and bottom rows with additional 100 mm grid in the middle



D28 PROFIPlusLINE (PL)

- Diagonal grid 100 x 100 mm
- 3-hole drilling pattern in the table side plates, 50 mm grid in the top and bottom rows with additional 100 mm grid in the middle



D28 ProfiEco Line (PE)

- Grid 100 x 100 mm
- 3-hole drilling pattern in the table side plates, 50 mm grid in the top row with additional 100 mm grid in the middle and bottom rows



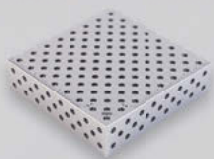
D28 HobbyLINE (H)

- Grid 100 x 100 mm
- Worktop approx. 25 mm high with system bores in a 100 mm x 100 mm grid



D16 Systems

D16 / For delicate applications



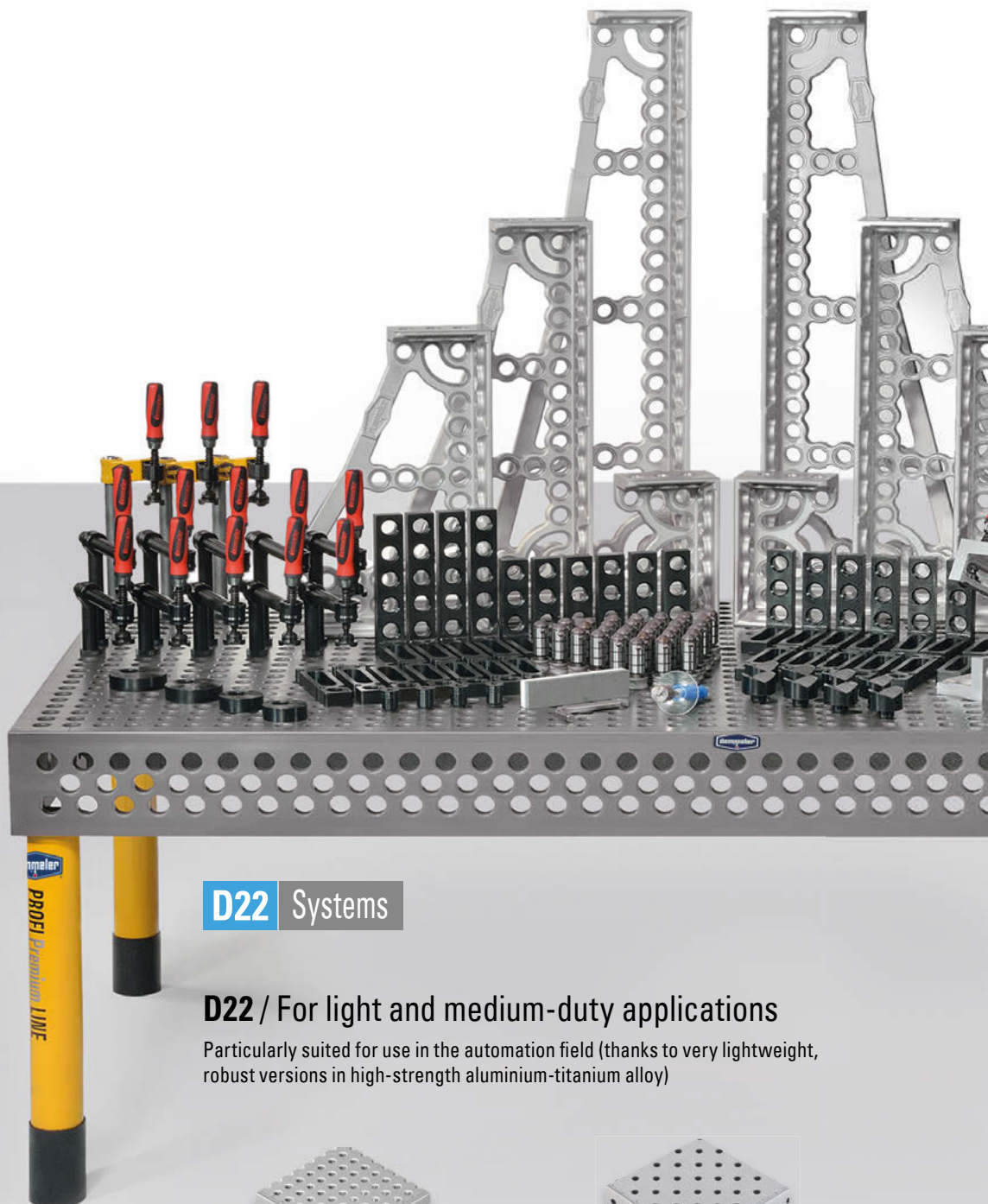
D16 PROFIPlusLINE (PL)

- Diagonal grid 50 x 50 mm
- 3-row bore pattern on the table side plates, 50 mm grid in the top, middle and bottom row



D16 ProfiEco Line (PE)

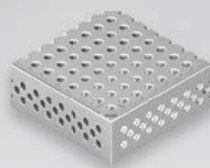
- Grid 50 x 50 mm
- 3-row bore pattern on the table side plates, 50 mm grid in the top, middle and bottom row



D22 Systems

D22 / For light and medium-duty applications

Particularly suited for use in the automation field (thanks to very lightweight, robust versions in high-strength aluminium-titanium alloy)



D22 PROFIPremiumLINE (PP)

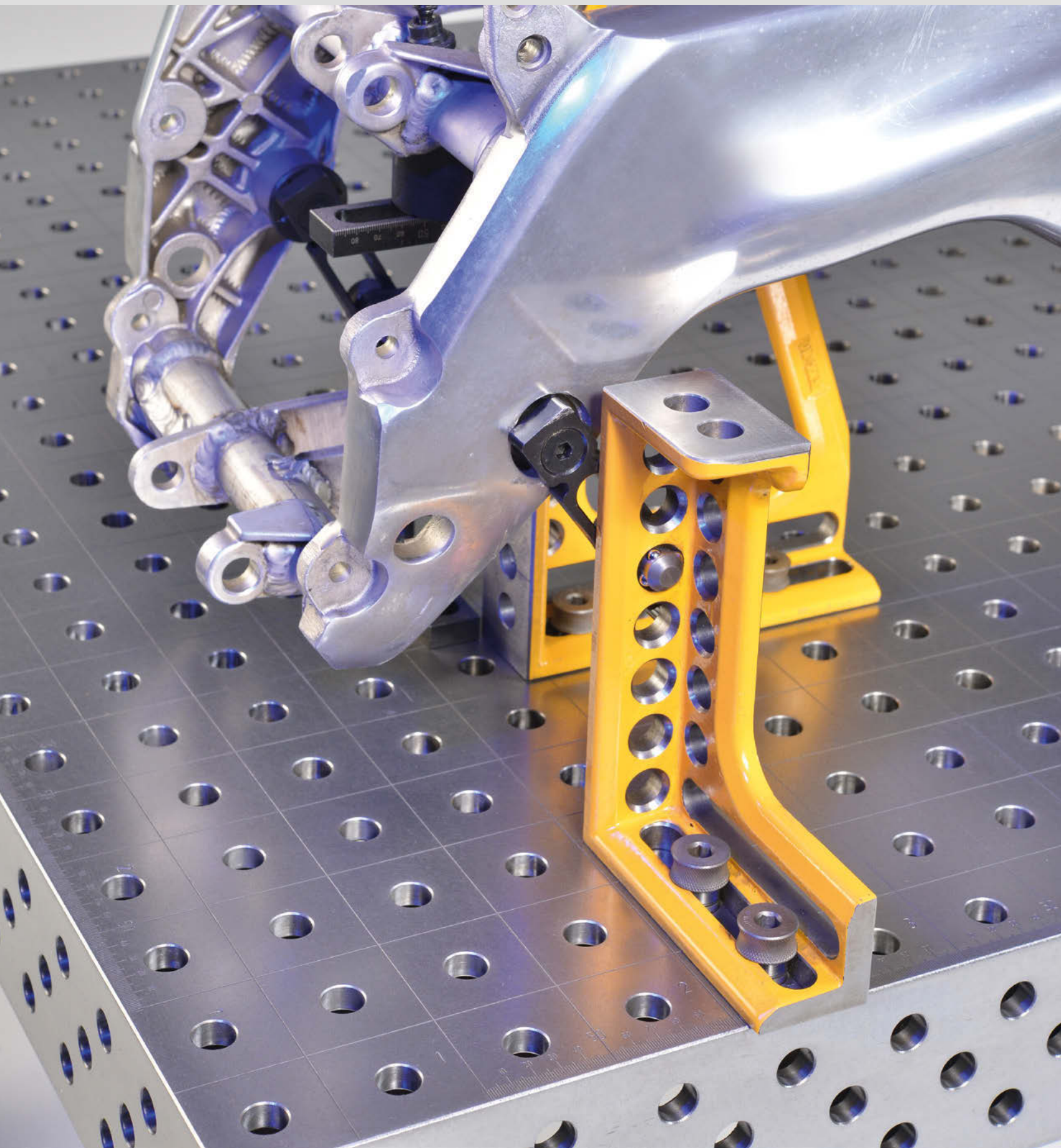
- Grid 50 x 50 mm
- 3-row bore pattern on the table side plates, 50 x 50 mm diagonal grid



D22 PROFIPlusLINE (PL)

- Diagonal grid 100 x 100 mm
- 2-row bore pattern on the table side plates, 50 mm grid

D16 3D clamping system overview





16 3D table
PROFIplusLINE (PL)

PAGE 478



16 3D table
PROFIEcoLINE (PE)

PAGE 480



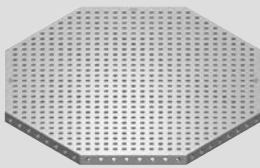
16 Standard leg / telescoping leg /
heavy-duty wheel / anchoring leg

PAGE 482



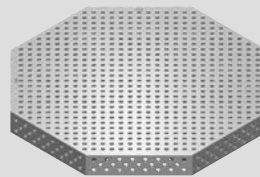
16 3D worktable
Okto 50

PAGE 486



16 3D worktable
Okto 100

PAGE 487



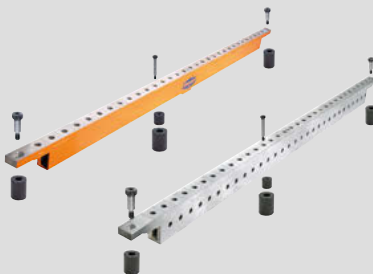
16 Clamping and adapter plate
Okto AF

PAGE 488



16 Base bridges

PAGE 489



16 Segmented grid plate

PAGE 490



16 D16 sets

PAGE 492



3D clamping system

Benefits of the D16 3D system tables



The benefits of a 3D clamping system from DEMMELER!

With our 3D clamping system, you have the right solution for clamping and positioning work pieces near at hand. Optimum positioning of the work piece not only makes work more accurate but also much more effective. In particular, the intelligent system grids give you unlimited clamping capabilities.



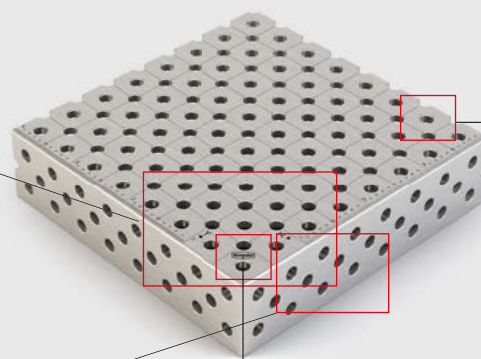
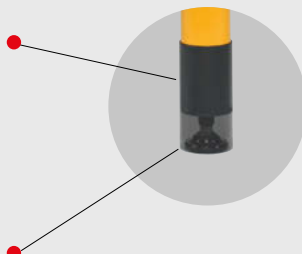
Axis designation in X and Y-direction.
Standard version includes precision scaling.



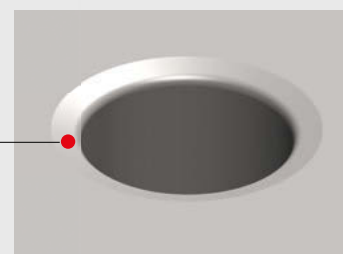
Additional bores in the side stanchion for
even more clamping options.

Foot sleeve prevents
pinching the welding hose
and protects the threaded
spindle against dirt.

Pivoting foot with stable
M24x2 (D16) threaded
spindle, finely adjustable
30 mm travel path.



Radius for improved ergonomics
and better design



Protective countersink: Optimum
bolt and clamp insertion with simul-
taneous protection of the tabletop
against damage from materials,
even in case of extreme strain on
the system bore or when used with
aluminium.

D16 system: Surface load
per leg 2 tonnes

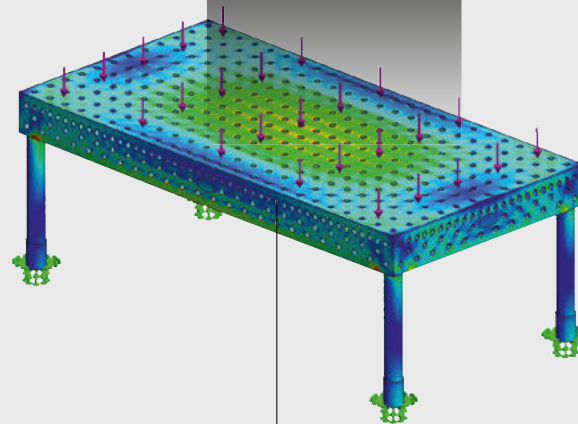


DEMMELEER trademark



OUR PERFORMANCE
makes THE DIFFERENCE

Total load, see P. 478
to 480 (max. load in kg)



All our tables are generously sized,
super sturdy and optimised with
FEM calculations on principle.

3D clamping system

The hardness of DEMMELER

Hardness comparison



SOLID

High-strength base
material

DEMONT 760 M

Hardened high-
strength tool steel
up to 760 Vickers



THE hardness of DEMMELER – for the toughest requirements

THE HARDNESS



DEMONT 760 M

- + Less wear
- + Protection against adherence of weld spatter
- + Extremely tough and durable
- + Optimum surface qualities

DEMONT 760 M

Stands for the combination of the specified base material and the new DEMMELER hardening process optimised especially for worktables. This results in outstanding material characteristics. A hardness of up to 760 Vickers can be achieved, reducing wear for an even longer service life of your worktable.

		DEMONT 760 M	SOLID
Load	high bearing loads	◊◊◊◊◊◊	◊◊◊◊◊◊
Evenness	for outstanding tool quality	◊◊◊◊◊	◊◊◊◊◊◊
Conductivity	for excellent welding results when using the ground connector	◊◊◊◊◊	◊◊◊◊◊◊
Base hardness	for high impact resistance	◊◊◊◊◊	◊◊◊◊
Surface hardness	resistant to weld spatter	◊◊◊◊◊	◊◊◊◊

◊◊◊◊◊◊ = outstanding
◊ = adequate

Leg type variant overview



Standard leg

- Pivoting feet, ± 30 mm fine adjustable
- Sturdy M24 x 2 threaded spindle
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly
- Also suitable as supporting leg in combination with overhung spacer block U-form, length 1 m and up
- Including countersunk M24 x 60 mounting screw
- Leg tube powder coated
- To order standard legs, see page 482



Telescoping leg

- Pivoting feet, ± 30 mm fine adjustable
- Sturdy M24 x 2 threaded spindle
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly
- Telescope adjustment range 350 mm in 50-mm increments
- For flexible height adjustment of the worktable
- Including countersunk M24 x 60 mounting screw
- Leg tube powder coated
- To order telescoping legs, see page 482



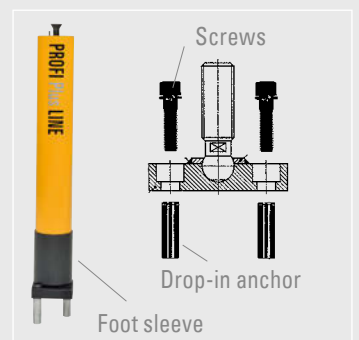
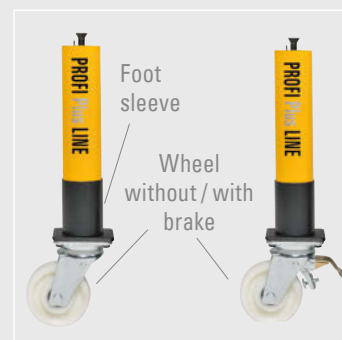
Heavy-duty wheel

- Fine adjustable ± 30 mm
- Sturdy M24 x 2 threaded spindle
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly
- Robust version
- With 360° caster
- Max. load capacity 600 kg
- Including countersunk M24 x 60 mounting screw
- Leg tube powder coated
- To order heavy duty wheels, see page 482



Anchoring leg

- Fine adjustable ± 30 mm
- Sturdy M24 x 2 threaded spindle
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly
- For firm attachment to the hall floor against tension, pressure and shifting (e.g. robot use)
- Includes M24 x 60 countersunk mounting screw and, for firm anchoring to the floor, 2 x drop-in anchor, 2 x cap screw M16 x 40
- Leg tube powder coated
- To order anchoring legs, see page 482

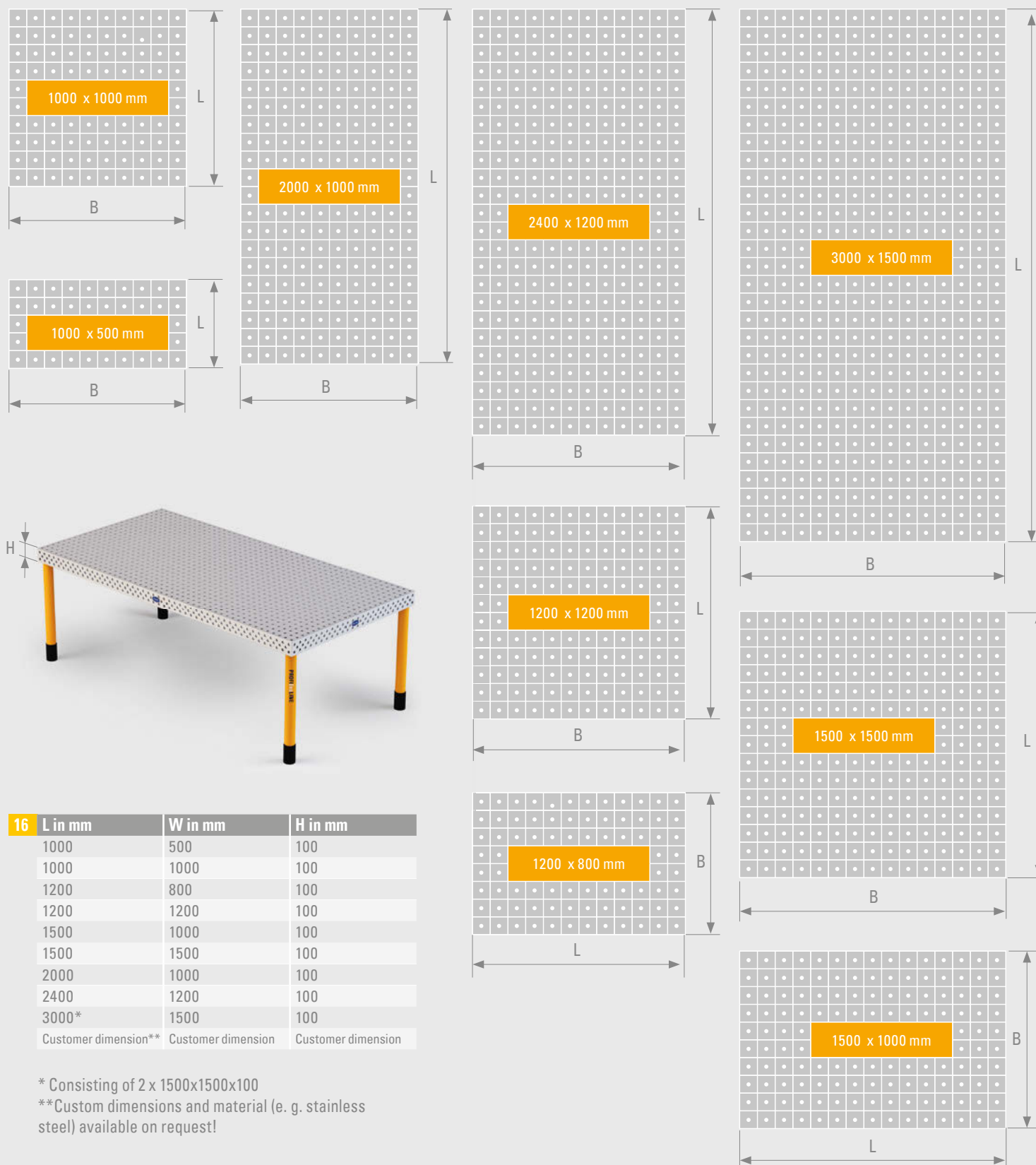




The right leg for any application



D16 system table sizes



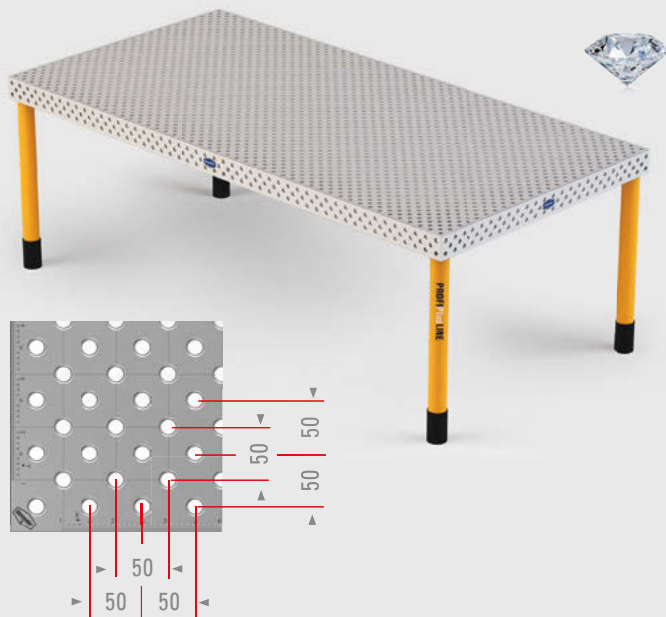


PROFIPlusLINE (PL) 3D table

PROFIEcoLINE (PE) 3D table

Description of the D16 table line

Worktop with D16 system bores in diagonal 50 mm x 50 mm grid



Worktop with D16 system bores in a 50 mm x 50 mm grid



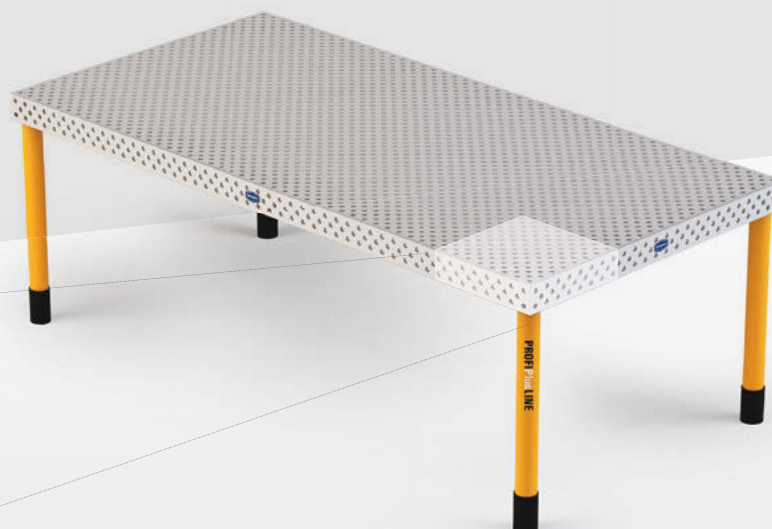
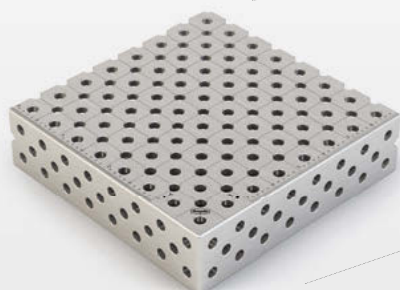
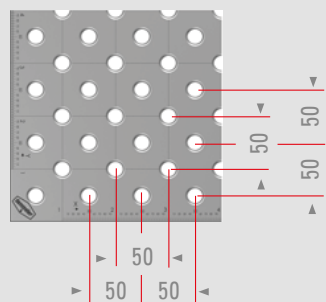
Description: PROFIPlusLINE

- Worktop with D16 system bores in a diagonal 50 mm x 50 mm grid, resulting in approx. 80% more clamping options than PROFIEcoLINE and conventional worktables
- 3-hole drilling pattern in the table side plates with D16 system bores in 50 x 50 mm diagonal grid
- All table sizes optionally available in hardened version, DEMONT 760 M in up to 760 Vickers
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Continuous gridlines in X and Y-direction, 50 mm spacing
- Precision scaling with millimetre graduation
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo recessed in all 4 side plates
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

Description: PROFIEcoLINE

- Worktop with D16 system bores in a 50 mm x 50 mm grid
- 3-hole drilling pattern in the table side plates with D16 system bores in 50 x 50 mm diagonal grid
- All table sizes optionally available in hardened version, DEMONT 760 M in up to 760 Vickers
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Continuous gridlines in X and Y-direction, 50 mm spacing
- Precision scaling with millimetre graduation
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo recessed in all 4 side plates
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

PROFIPlusLINE (PL) 3D table



On request the table is also available in other materials!

Table without leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	500	100	70		
	1000	1000	100	119		
	1200	800	100	123		
	1200	1200	100	162		
	1500	1000	100	179		
	1500	1500	100	253		
	2000	1000	100	223		
	2400	1200	100	326		
	3000*	1500	100	506		



Custom dimensions and material (e. g. stainless steel) available on request

Table with standard leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	500	850 ± 30	104	8000	
	1000	1000	850 ± 30	154	8000	
	1200	800	850 ± 30	154	8000	
	1200	1200	850 ± 30	194	8000	
	1500	1000	850 ± 30	204	8000	
	1500	1500	850 ± 30	274	8000	
	2000	1000	850 ± 30	264	8000	
	2400	1200	850 ± 30	364	8000	
	3000*	1500	850 ± 30	548	16000	

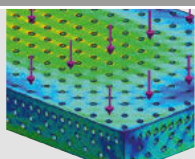




Precision scaling



Protective countersink



Max. load



DEMONT 760 M



Leg with sleeve

DESCRIPTION

- Worktop with D16 system bores in a double 50 mm x 50 mm grid, resulting in approx. 80 % more clamping options than PROFIEcoLINE and conventional worktables
- 3-row bore pattern on the table side plates with D16 system bores, 50 mm grid in the top, middle and bottom row
- All table sizes optionally available in new hardness, DEMONT 760 M in up to 760 Vickers
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Continuous gridlines in X and Y-direction, 50 mm spacing
- Precision scaling with millimetre division, also available with the DEMONT 760 M option
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo recessed in all 4 side plates
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

THE HARDNESS



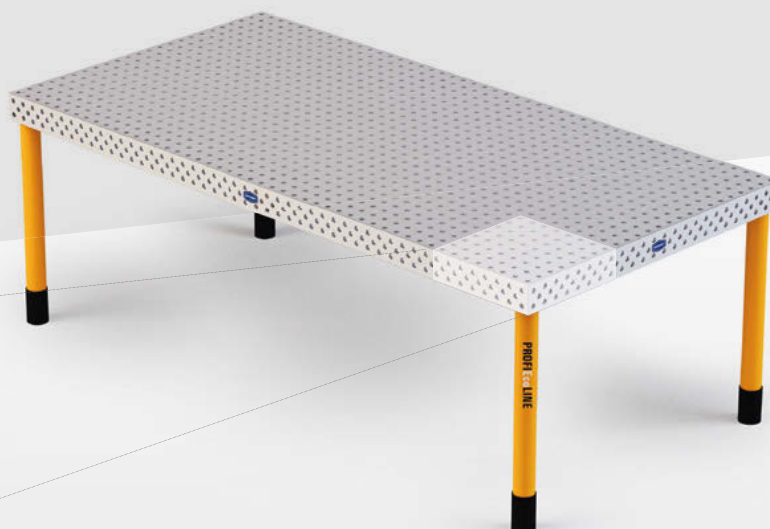
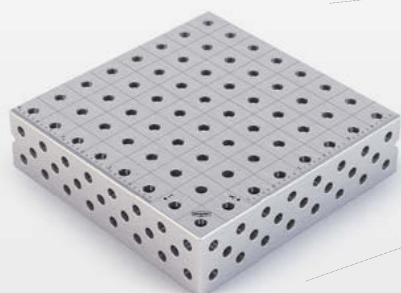
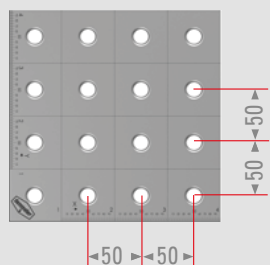
DEMONT 760 M

	Number of legs	SOLID	DEMONT 760 M hardened
	without legs	PL16-01000-000	PL16-01000-500
	without legs	PL16-01001-000	PL16-01001-500
	without legs	PL16-11019-000	PL16-11019-500
	without legs	PL16-01056-000	PL16-01056-500
	without legs	PL16-01017-000	PL16-01017-500
	without legs	PL16-01011-000	PL16-01011-500
	without legs	PL16-01002-000	PL16-01002-500
	without legs	PL16-01003-000	PL16-01003-500
	without legs	PL16-01004-000	PL16-01004-500

	Number of legs	SOLID	DEMONT 760 M hardened	Selection list for other leg variants as of page 482
	4	PL16-01000-001	PL16-01000-011	
	4	PL16-01001-001	PL16-01001-011	
	4	PL16-11019-001	PL16-11019-011	
	4	PL16-01056-001	PL16-01056-011	
	4	PL16-01017-001	PL16-01017-011	
	4	PL16-01011-001	PL16-01011-011	
	4	PL16-01002-001	PL16-01002-011	
	4	PL16-01003-001	PL16-01003-011	
	8	PL16-01004-001	PL16-01004-011	

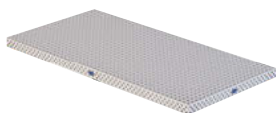
* Consisting of 2 x 1500x1500x100

PROFI^{Eco}LINE (PE) 3D table



On request the table is also available in other materials!

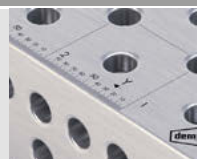
Table without leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	500	100	74		
	1000	1000	100	127		
	1200	800	100	131		
	1200	1200	100	173		
	1500	1000	100	190		
	1500	1500	100	270		
	2000	1000	100	238		
	2400	1200	100	347		
	3000*	1500	100	540		



Custom dimensions and material (e. g. stainless steel) available on request

Table with standard leg	L in mm	W in mm	H in mm	~ Weight of table in kg	Max. load in kg	
	1000	500	850 ± 30	109	8000	
	1000	1000	850 ± 30	164	8000	
	1200	800	850 ± 30	164	8000	
	1200	1200	850 ± 30	204	8000	
	1500	1000	850 ± 30	214	8000	
	1500	1500	850 ± 30	284	8000	
	2000	1000	850 ± 30	274	8000	
	2400	1200	850 ± 30	384	8000	
	3000*	1500	850 ± 30	568	16000	

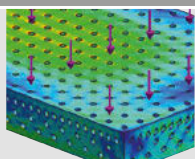




Precision scaling



Protective countersink



Max. load



DEMONT 760 M



Leg with sleeve

DESCRIPTION

- Worktop with D16 system bores in a 50 mm x 50 mm grid
- 3-row bore pattern on the table side plates with D16 system bores, 50 mm grid in the top, middle and bottom row
- All table sizes optionally available in new hardness, DEMONT 760 M in up to 760 Vickers
- All system bores with new protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Continuous gridlines in X and Y-direction, 50 mm spacing
- Precision scaling with millimetre division, also available with the DEMONT 760 M option
- Coordinate marking of the bores in the X and Y-direction
- DEMMELER logo recessed in all 4 side plates
- Table legs with fine adjustment, round design with pivoting foot
- Foot sleeve to protect the cable-hose assembly

THE HARDNESS



DEMONT 760 M

	Number of legs	SOLID	DEMONT 760 M hardened
	without legs	PE16-01000-000	PE16-01000-500
	without legs	PE16-01001-000	PE16-01001-500
	without legs	PE16-11019-000	PE16-11019-500
	without legs	PE16-01056-000	PE16-01056-500
	without legs	PE16-01017-000	PE16-01017-500
	without legs	PE16-01011-000	PE16-01011-500
	without legs	PE16-01002-000	PE16-01002-500
	without legs	PE16-01003-000	PE16-01003-500
	without legs	PE16-01004-000	PE16-01004-500

	Number of legs	SOLID	DEMONT 760 M hardened
	4	PE16-01000-001	PE16-01000-011
	4	PE16-01001-001	PE16-01001-011
	4	PE16-11019-001	PE16-11019-011
	4	PE16-01056-001	PE16-01056-011
	4	PE16-01017-001	PE16-01017-011
	4	PE16-01011-001	PE16-01011-011
	4	PE16-01002-001	PE16-01002-011
	4	PE16-01003-001	PE16-01003-011
	8	PE16-01004-001	PE16-01004-011

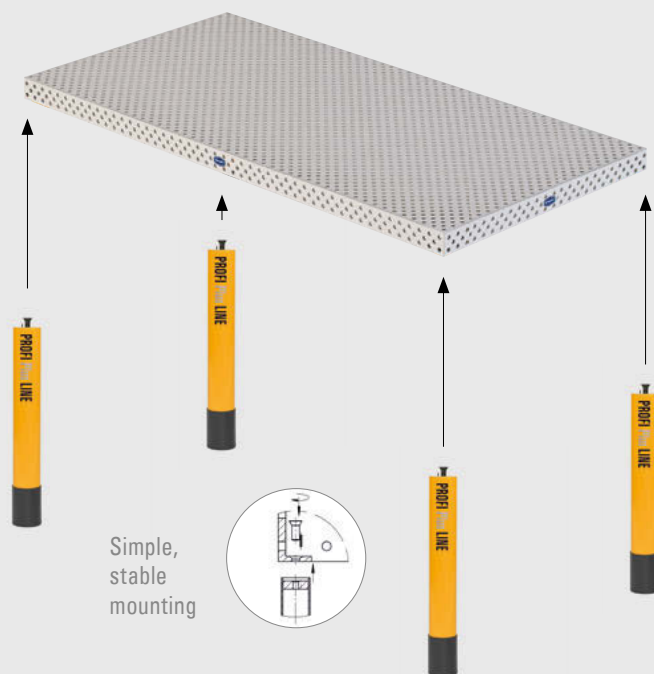
Selection list for
other leg variants as
of page 482

* Consisting of 2 x 1500x1500x100

Ordering summary for table legs


D16 system 3D welding tables with suitable standard legs

- Simple, stable mounting of table legs
- Foot sleeve prevents pinching the welding hose and protects the threaded spindle against dirt
- Pivoting foot with stable M24x2 threaded spindle
- Finely adjustable 30 mm travel path




Ordering example:

1. On page 478 - 480, select the desired worktop, resulting in order item no. 1:
e.g. **1x** PL16-01002-000



+

2. From the current page, select the leg you want in the corresponding quantity, which results in order item no. 2:
e.g. **4x** PL16-10010-001



=

3. The two order item numbers make up your order to DEMMELER.
e.g. **1x** PL16-01002-000
+ e.g. **4x** PL16-10010-001



The right table legs for any application

System	Standard leg	Telescoping leg	Heavy-duty wheel	Anchoring leg
	16	16	16	16
PROFIPlusLINE	●	●	●	●
PROFIEcoLINE	●	●	●	●

● available

● by request




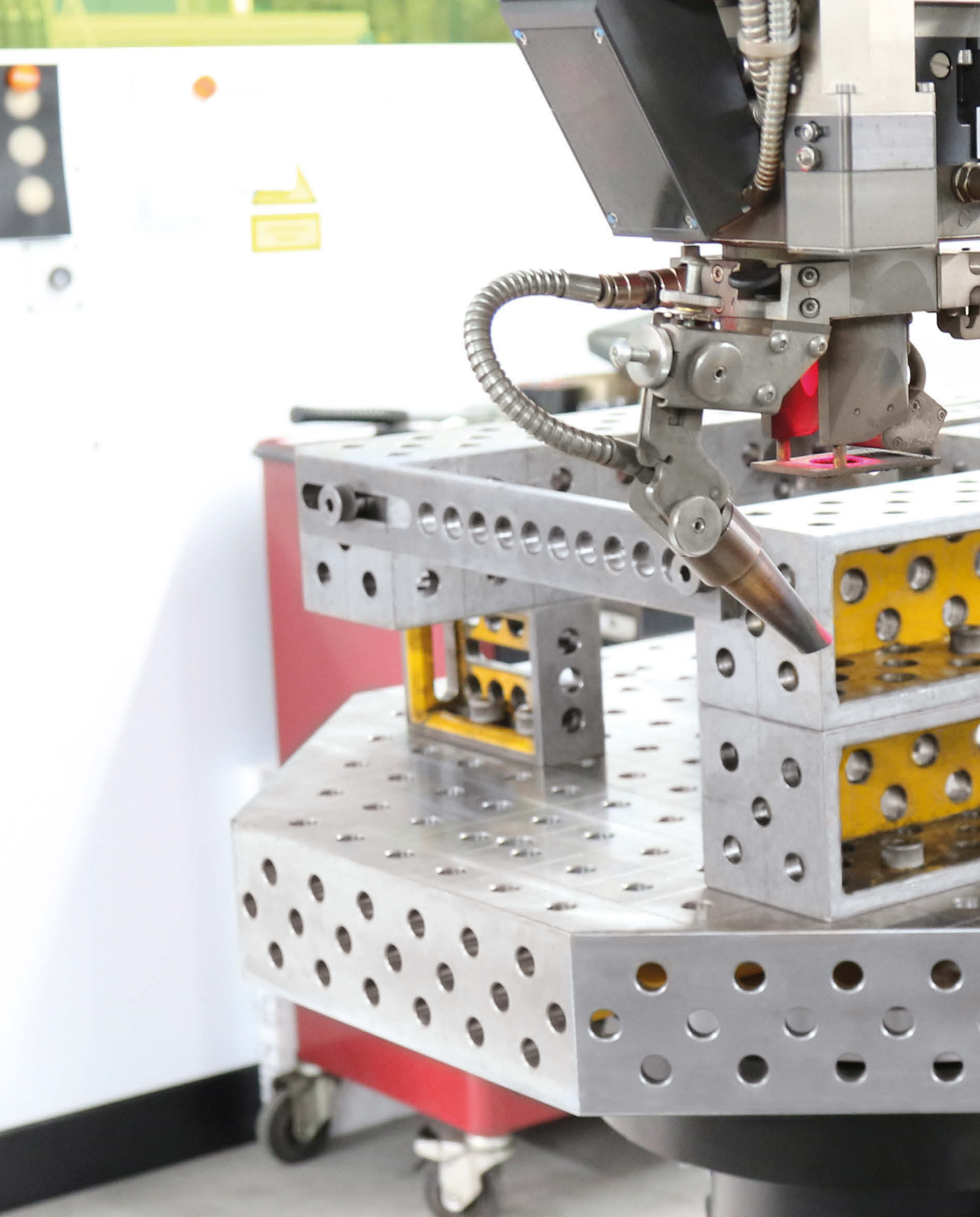
Standard leg / telescoping leg / heavy-duty wheel / anchoring leg

Standard leg		Quantity	16			
	For table size	Legs	Item number	H in mm	Weight in kg	Max. load in kg
 <p>Finely adjustable pivoting foot</p>	1000x500	4	PL16-10010-000	750 ± 30	6	2000
	1000x1000					
	1200x800					
	1200x1200					
	1500x1000					
	1500x1500					
	2000x1000					
	2400x1200					
	3000x1500	6				

Telescoping leg		Quantity	16			
	For table size	Legs	Item number	H in mm	Weight in kg	Max. load in kg
 <p>Adjustable height Grid 50 mm</p> <p>Finely adjustable pivoting foot</p>	1000x500	4	PL16-10010-001	550 to 900 ± 30	7	2000
	1000x1000					
	1200x800					
	1200x1200					
	1500x1000					
	1500x1500					
	2000x1000					
	2400x1200					
	3000x1500	6				

Heavy-duty wheel		Quantity	16			
	For table size	Legs	Item number	H in mm	Weight in kg	Max. load in kg
 <p>Wheel with brake*¹ Wheel without brake*²</p>	1000x500	4	(2x) PL16-10010-002* ¹ + (2x) PL16-10010-003* ²	750 ± 30	9	300
	1000x1000				8	
	1200x800					
	1200x1200					
	1500x1000					
	1500x1500					
	2000x1000					
	2400x1200					
	3000x1500	6	(2x) PL16-10010-002* ¹ + (4x) PL16-10010-003* ²		9 8	

Anchoring leg		Quantity	16			
	For table size	Legs	Item number	H in mm	Weight in kg	Max. load in kg
 <p>Screws</p> <p>Drop-in anchor</p>	1000x500	4	PL16-10010-004	750 ± 30	8	2000
	1000x1000					
	1200x800					
	1200x1200					
	1500x1000					
	1500x1500					
	2000x1000					
	2400x1200					
	3000x1500	6				





OUR PERFORMANCE
makes THE DIFFERENCE

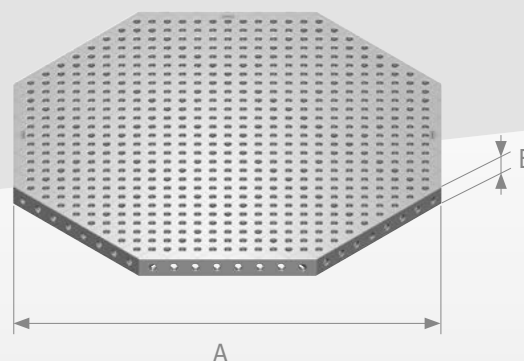


3D Okto 50 worktable

- Preferred use with manipulators in robot cells
- Numerous clamping possibilities on all nine clamping surfaces
- With diagonal grid 50x50

THE FOLLOWING ADDITIONAL OPTIONS ARE POSSIBLE ON REQUEST:

- High-strength aluminium-titanium alloy for ~ 60 % weight reduction and ~ 10 % higher bending strength
- With special connection drilling pattern, adapted to the face plate of your manipulator (please include manipulator type and drawing of the face plate with enquiry - can be offered for a surcharge!)
- Prepared for table legs

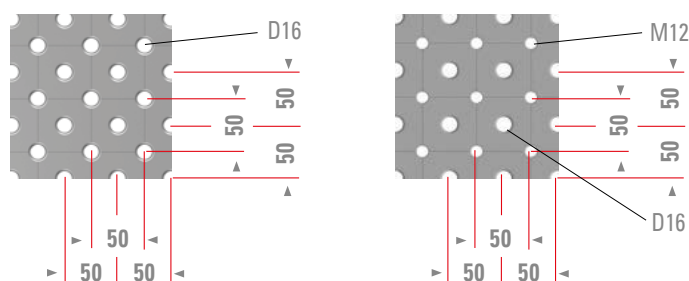


Description ▲ Application ▼

Diagonal grid 50x50 ▼



We can also supply the worktable with 50x50 diagonal grid with M12 thread

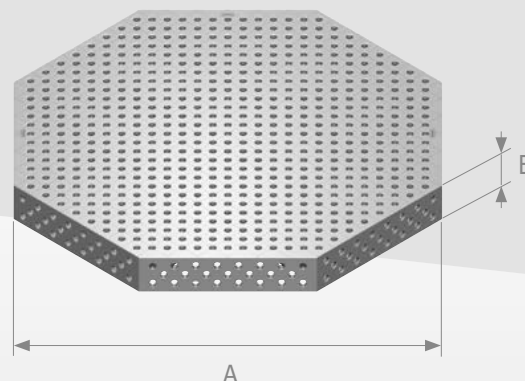


16	A in mm	B in mm	Description	Item no.
	AF 600	50	Diagonal grid 50 x 50	PL16-01009-001
	AF 800	50	Diagonal grid 50 x 50	PL16-01008-001
	AF 1000	50	Diagonal grid 50 x 50	PL16-01024-001
	AF 1200	50	Diagonal grid 50 x 50	PL16-01070-001

- Preferred use with manipulators in robot cells
- Numerous clamping possibilities on all nine clamping surfaces
- With diagonal grid 50x50

THE FOLLOWING ADDITIONAL OPTIONS ARE POSSIBLE ON REQUEST:

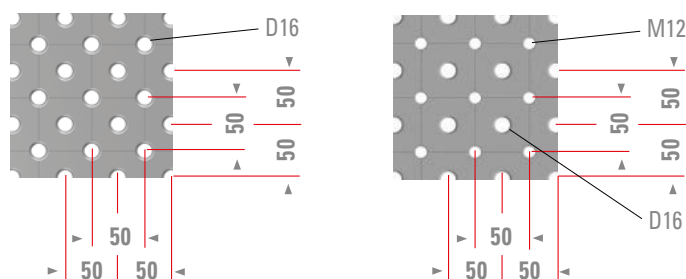
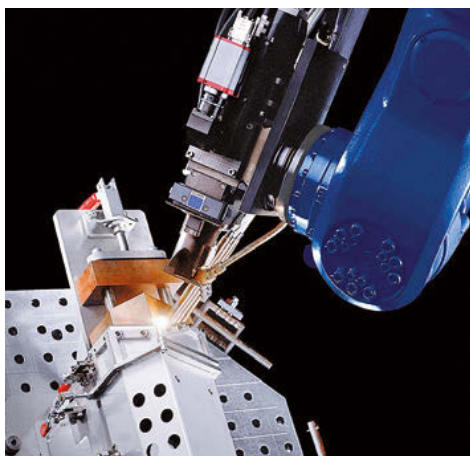
- High-strength aluminium-titanium alloy for ~ 60 % weight reduction and ~ 10 % higher bending strength
- With special connection drilling pattern, adapted to the face plate of your manipulator (please include manipulator type and drawing of the face plate with enquiry - can be offered for a surcharge!)
- Prepared for table legs



Description ▲ Application ▼

Diagonal grid 50x50 ▼

We can also supply the worktable with 50x50 diagonal grid with M12 thread



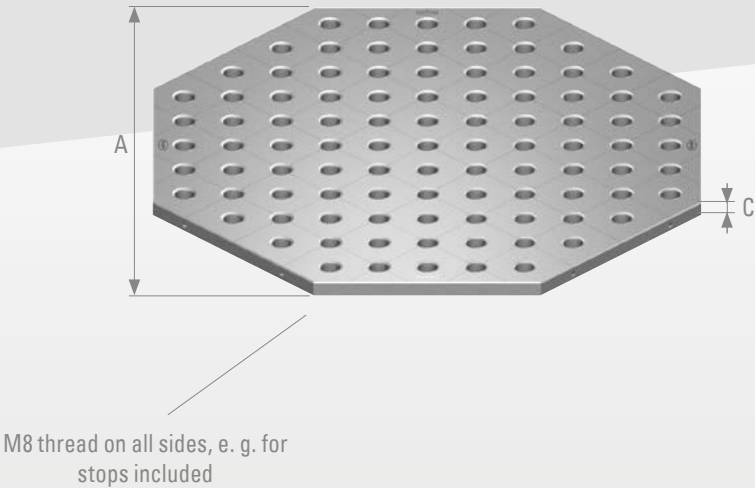
Other dimensions on request

16	A in mm	B in mm	Description	Item no.
	AF 600	100	Diagonal grid 50 x 50	PL16-01009-000
	AF 800	100	Diagonal grid 50 x 50	PL16-01008-000
	AF 1000	100	Diagonal grid 50 x 50	PL16-01024-000
	AF 1200	100	Diagonal grid 50 x 50	PL16-01070-000

Clamping and adapter plate Okto AF

The miniature worktable with grid lines

- Used in combination with 3D worktables and welding positioners



Other dimensions on request

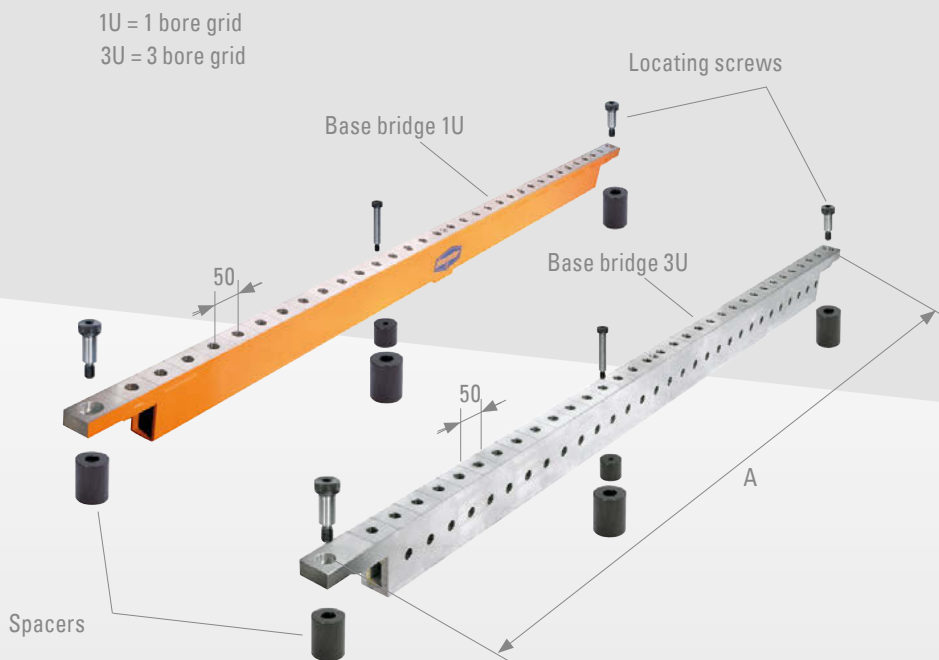
Description ▲

16	A in mm	C in mm	~ Weight in kg	Description	Item no.
	AF 400	12	11	Diagonal grid 50 x 50	D16-02100-106
	AF 600	12	25	Diagonal grid 50 x 50	D16-02100-107
	AF 800	12	45	Diagonal grid 50 x 50	D16-02100-108



Powerful in application on 3D laser machines

- Specially for use on laser machines (e. g. Trumpf Lasercell 105, 1005, 6005, 7040) designed
- In combination with segmented grid plate D16-02100-000 for many clamping options
- Direct holding of clamping components possible
- Incl. assembly accessories such as locating screws and spacers for mounting on the laser machine
- Grid lines every 50 mm, system bores every 50 mm



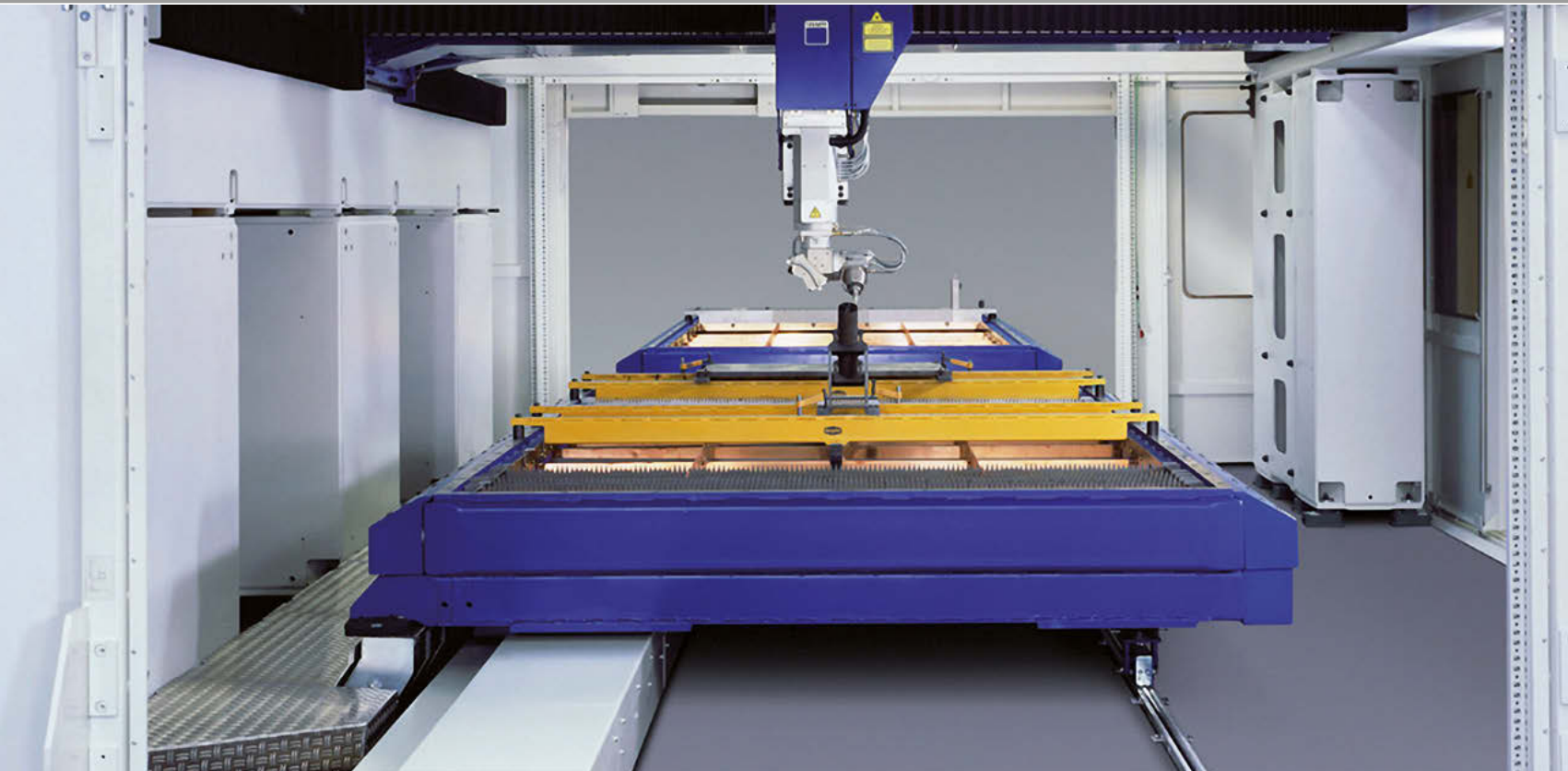
Spacers and locating screws depending on the version.
Figure similar

Description ▲

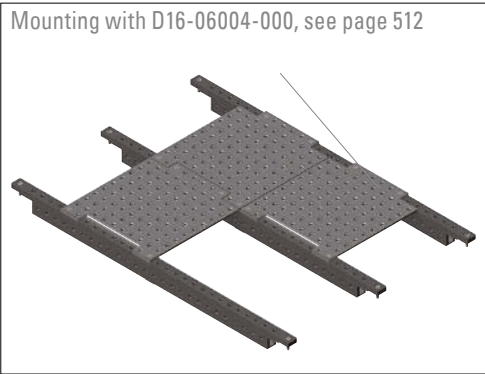
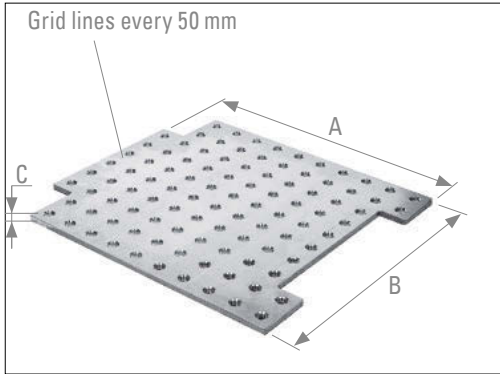
16	A in mm	~ Weight in kg	Description	Item no.
	1000	7	1 bore grid, for Trumpf Lasercell 1000	D16-04100-002
	1366	16	1 bore grid, for Trumpf Lasercell 105	D16-04100-010
	1500	17	1 bore grid, for Trumpf Lasercell 7000	D16-04100-049
	1682	20	1 bore grid, for Trumpf Lasercell 1005	D16-04100-009
	2182	24	1 bore grid, for Trumpf Lasercell 6005	D16-04100-013
	1500	17	1 bore grid, for Trumpf Lasercell 7040	D16-04100-027
	1366	30	3 bore grid, for Trumpf Lasercell 105	D16-04100-008
	1682	36	3 bore grid, for Trumpf Lasercell 1005	D16-04100-005
	2000	22	1 bore grid, for Trumpf Lasercell 7020	D16-04100-036
	2000	22	1 bore grid, for Trumpf Lasercell 7000	D16-04100-050
	2182	48	3 bore grid, for Trumpf Lasercell 6005	D16-04100-012
	1500	30	3 bore grid, for Trumpf Lasercell 7040	D16-04100-026

Other dimensions also available on request.

Segmented grid plate



Grid lines every 50 mm ▼	Segmented grid plates ▼	Description ▼
--------------------------	-------------------------	---------------



- Highly flexible clamping options with 50 mm grid
- Nesting the contours inside each other enables a continuous clamping field
- Especially for use in combination with base bridges on 3D laser machines

Segmented grid plates mounted on base bridges D16-04100-xxx enable a continuous floor plate

16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	548	498	12	22	Grid 50 x 50	D16-02100-000



PL ⇌ PE
= 100% compatible

Thus, for example, accessories from the PROFiPlus set
can be used on a PROFiEcoLINE table.

Sets

PROFiPlusLINE set 155 D16.....	492
PROFiPlusLINE set 255 D16	493
PROFiPlusLINE set 720 D16.....	494
PROFiPlusLINE set 355 D16	496
PROFiEcoLINE set 200 D16.....	498
PROFiEcoLINE set 710 D16.....	499
PROFiEcoLINE set 720 D16.....	500
PROFiEcoLINE set 730 D16.....	502
PROFiEcoLINE set 300 D16	504

PROFIPlusLINE set 155 (System 16)

Item number: D16-52000-155 (39-piece)

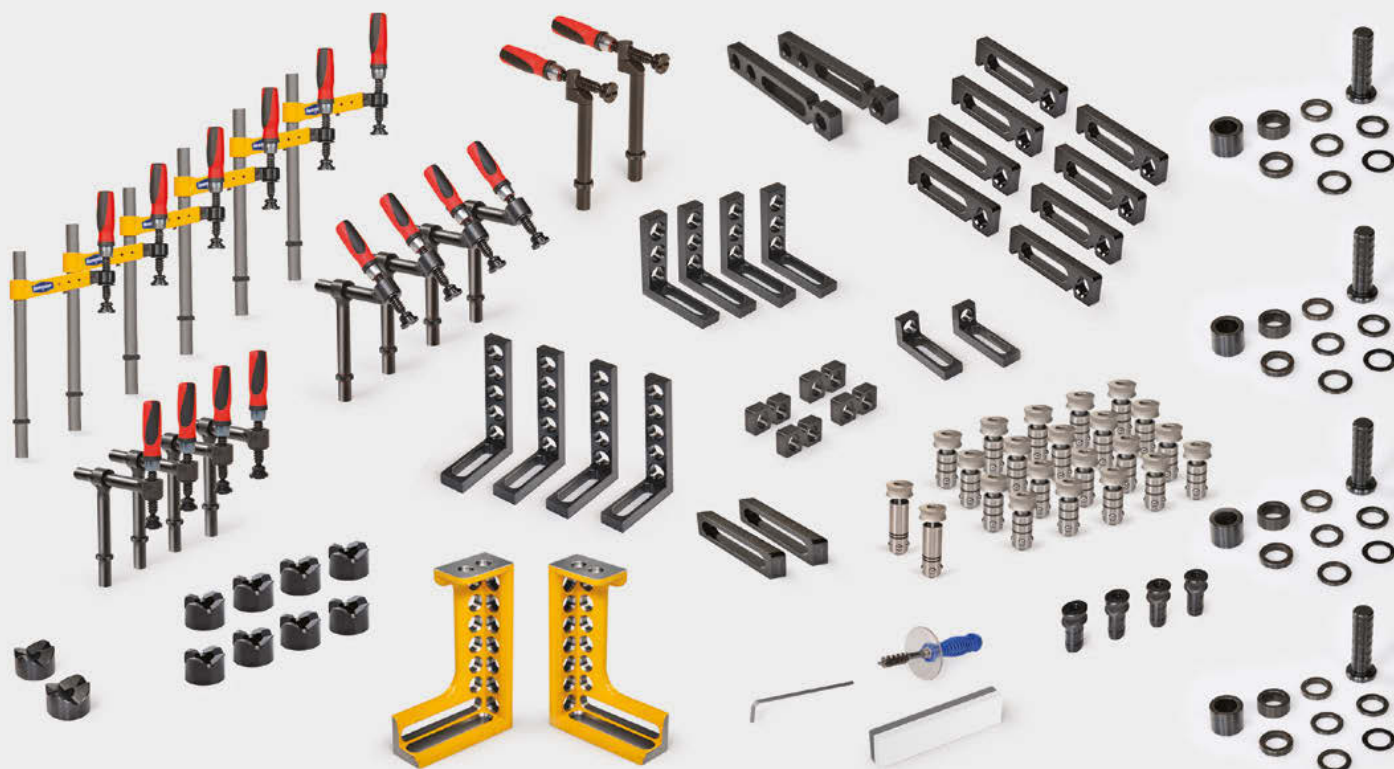


Quantity ▼	Item no. ▼	Item description ▼
2	D16-05002-000	Universal stop / small / L55
6	D16-05001-004	Universal stop with scale / L115
2	D16-05009-000	Universal stop / 165
2	D16-03001-002	Clamping and locating angle bore / oblong hole / H 37.5
4	D16-03001-000	Clamping and locating angle bore / oblong hole / H 90
2	D16-09001-000	Spacer set 9 pieces
10	D16-06001-000	PC-bolt / short
4	D16-07001-000	Compensating swing clamp 180° with spindle
2	D16-07005-000	Screw clamp 180° with spindle
2	D16-07008-000	Variable screw clamp 90° with adjusting screw
1	D16-10008-000	Ball end hex wrench AF8
1	D16-10002-000	Round brush 16 mm
1	D00-10007-000	Bench stone

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFIPlusLINE set 255 (System 16)

Item number: D16-52000-255 (87-piece)

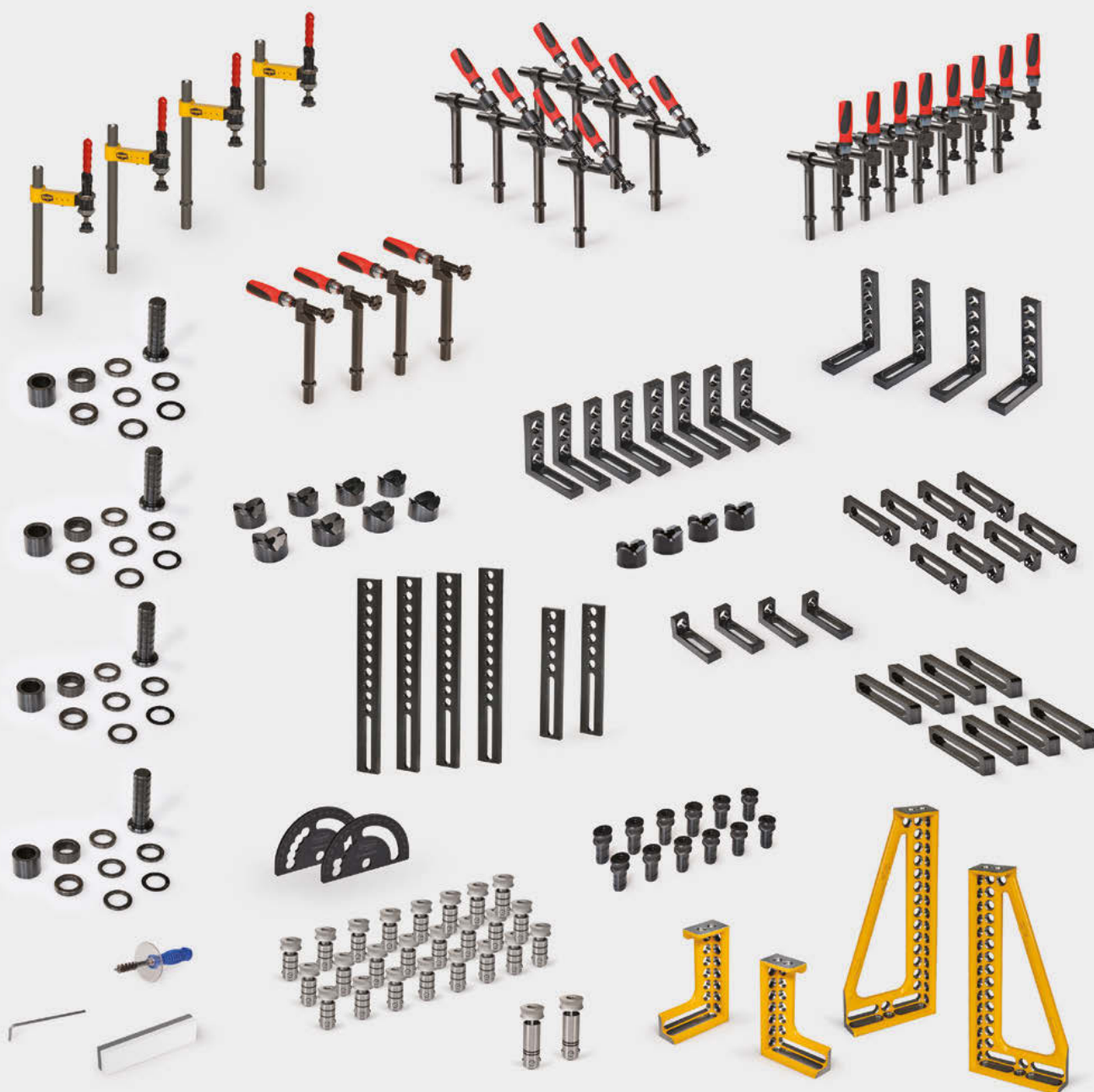


Quantity ▼	Item no. ▼	Item description ▼
4	D16-05002-000	Universal stop / small / L55
8	D16-05001-004	Universal stop with scale / L115
2	D16-05015-000	Displacement stop / L150
2	D16-05009-000	Universal stop / L165
2	D16-03001-002	Clamping and locating angle bore / oblong hole / H 37.5
4	D16-03001-000	Clamping and locating angle bore / oblong hole / H 90
4	D16-03008-000	Clamping and locating angle H140
1	D16-03002-000	Clamping and locating angle, right, casting 200
1	D16-03002-001	Clamping and locating angle, left, casting 200
4	D16-09001-000	Spacer set 9 pieces
8	D16-09004-000	V-block locations blackened steel up to 70 mm tubes
2	D16-09003-000	V-block locations blackened steel up to 140 mm tubes
20	D16-06001-000	PC-bolt / short
2	D16-06002-000	PC-bolt / long
4	D16-06009-000	Stop and positioning bolt
6	D16-07001-000	Compensating swing clamp 100 mm with spindle
4	D16-07005-000	Screw clamp 180° with spindle
2	D16-07008-000	Variable screw clamp 90°
4	D16-07009-000	Variable screw clamp 45° with adjusting screw
1	D16-10008-000	Ball end hex wrench AF8
1	D16-10002-000	Round brush 16 mm
1	D00-10007-000	Bench stone

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFIPlusLINE set 720 (System 16)

Item number: D16-52000-720 (125-piece)





PROFIPlusLINE set 720 (System 16)

Item number: D16-52000-720 (125-piece)

Quantity ▼	Item no. ▼	Item description ▼
8	D16-03001-000	Clamping and locating angle 90x90x25 mm (bore / oblong hole)
4	D16-03001-002	Clamping and locating angle / small 90x37.5x25 mm, scale on both sides
1	D16-03002-000	Clamping and locating angle, right 200x137.5x50 mm
1	D16-03002-001	Clamping and locating angle, left 200x137.5x50 mm
1	D16-03003-000	Clamping and locating angle, right 400x187.5x50 mm
1	D16-03003-001	Clamping and locating angle, left 400x187.5x50 mm
4	D16-03008-000	Clamping and locating angle 140x90x25 mm
8	D16-05001-004	Universal stop with scale - 115x25x12 mm
2	D16-05003-000	Stop-strip L 250 - 250x50x12 mm
4	D16-05003-001	Stop-strip L 400 - 400x50x12 mm
2	D16-05013-010	Angle-setting template, scale on both sides, 0 - 90°, 15°, 30°, 45°, 60°
8	D16-05015-000	Displacement stop - 150x25x12 mm
24	D16-06001-000	PC-bolt / short - Ø 16-0.01, AF 8, clamping range 20-24 mm, 10/50 kN
2	D16-06002-000	PC-bolt / long - Ø 16-0.01, AF 8, clamping range 32-36 mm, 10/50 kN
12	D16-06009-000	Stop and positioning bolt Ø 16 / 25x37
4	D16-07001-001	Compensating swing clamp with quick-action clamping cylinder
8	D16-07005-000	Screw clamp 180° with spindle - vertical tube 130 mm
4	D16-07008-000	Variable screw clamp 90°
8	D16-07009-000	Variable screw clamp 45° with adjusting screw - vertical tube 130 mm
4	D16-09001-000	Spacer set 9 pieces - Ø 25x60 mm
8	D16-09003-000	V-block locations blackened steel, Ø 80 mm - 120°/90° - for tubes up to Ø 140 mm
4	D16-09004-000	V-block locations blackened steel, Ø 58 mm - 120°/90° - for tubes up to Ø 70mm
1	D16-10002-000	Round brush Ø 16x260 mm, with protective cap
1	D00-10007-000	Bench stone 200x50x25 mm, 2-sided
1	D16-10008-000	Ball end hex wrench AF 8x104 mm

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFIPlusLINE set 355 (System 16)

Item number: D16-52000-355 (161-piece)





PROFIPlusLINE set 355 (System 16)

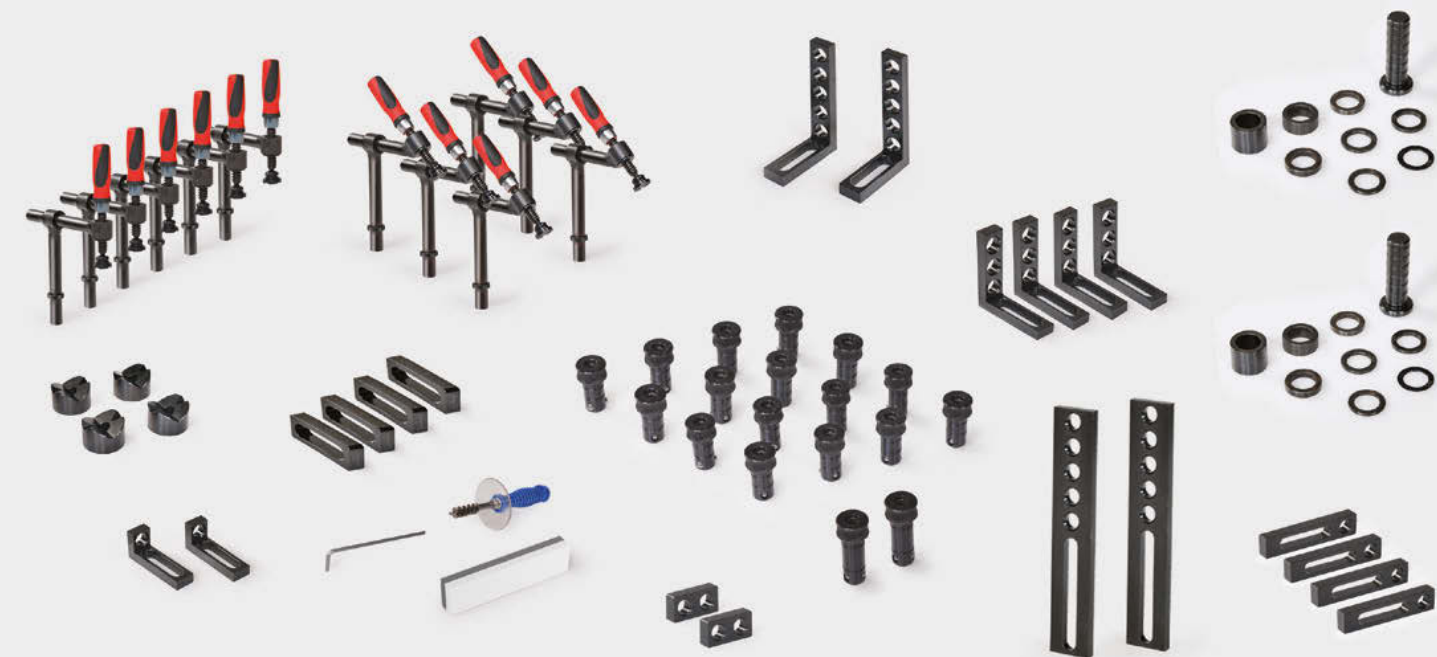
Item number: D16-52000-355 (161-piece)

Quantity ▼	Item no. ▼	Item description ▼
4	D16-05002-000	Universal stop / small / L55
14	D16-05001-004	Universal stop with scale / L115
6	D16-05015-000	Displacement stop L150
6	D16-05009-000	Universal stop L165
4	D16-05003-001	Stop-strip L400
4	D16-03001-002	Clamping and locating angle bore / oblong hole / H 37.5
12	D16-03001-000	Clamping and locating angle bore / oblong hole / H 90
4	D16-03008-000	Clamping and locating angle H140
1	D16-03002-000	Clamping and locating angle, right, casting 200
1	D16-03002-001	Clamping and locating angle, left, casting 200
1	D16-03004-000	Clamping and locating angle, right, casting 600
1	D16-03004-001	Clamping and locating angle, left, casting 600
1	D16-03005-001	Console right casting
1	D16-03007-000	Universal pivot and tilt angle, right
4	D16-09001-000	Spacer set 9 pieces
8	D16-09004-000	V-block locations blackened steel up to 70 mm tubes
4	D16-09003-000	V-block locations blackened steel up to 140 mm tubes
34	D16-06001-000	PC-bolt / short
4	D16-06002-000	PC-bolt / long
4	D16-06004-000	PC-countersunk bolt / short
6	D16-06009-000	Stop and positioning bolt
2	D16-06003-000	Connection bolt / short with screw
12	D16-07001-000	Compensating swing clamp 100 mm with spindle
8	D16-07005-000	Screw clamp 180° with spindle
2	D16-07008-000	Variable screw clamp 90°
6	D16-07009-000	Variable screw clamp 45° with adjusting screw
1	D16-09008-000	Adjusting spindle
1	D16-11001-000	Accessory cart
1	D16-10008-000	Ball end hex wrench AF8
1	D16-10008-001	Ball end hex wrench AF6
1	D16-10008-002	Ball end hex wrench AF4
1	D16-10002-000	Round brush 16 mm
1	D00-10007-000	Bench stone

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFI^{Eco}LINE set 200 (System 16)

Item number: E16-52000-200 (59-piece)



Depicted set also available with PC bolts instead of ECOLine bolts:
Item no. E16-52000-201

Quantity ▼	Item no. ▼	Item description ▼
4	E16-03001-000	ECO clamping and locating angle H = 90
2	E16-03001-002	ECO clamping and locating angle H = 37.5
2	E16-03008-000	ECO clamping and locating angle H = 140
4	E16-05001-000	ECO universal stop, large
2	E16-05002-000	ECO universal stop, small
2	E16-05003-000	ECO stop strip 250 mm
4	E16-05015-000	ECO displacement-stop
16	E16-06001-000	ECOLine bolt / short
2	E16-06002-000	ECOLine bolt / long
6	E16-07005-000	ECO screw clamp 180° with spindle
6	E16-07009-000	ECO variable screw clamp 45° with spindle
2	E16-09001-000	ECO spacer set 9 pieces
4	E16-09003-000	ECO V-block locations blackened steel
1	E16-10002-000	ECO round brush 16 mm
1	E00-10007-000	ECO bench stone
1	E16-10008-000	ECO Ball end hex wrench AF 5

DEMMELEER welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFI^{Eco}LINE set 710 (System 16)

Item number: E16-52000-710 (29-piece)



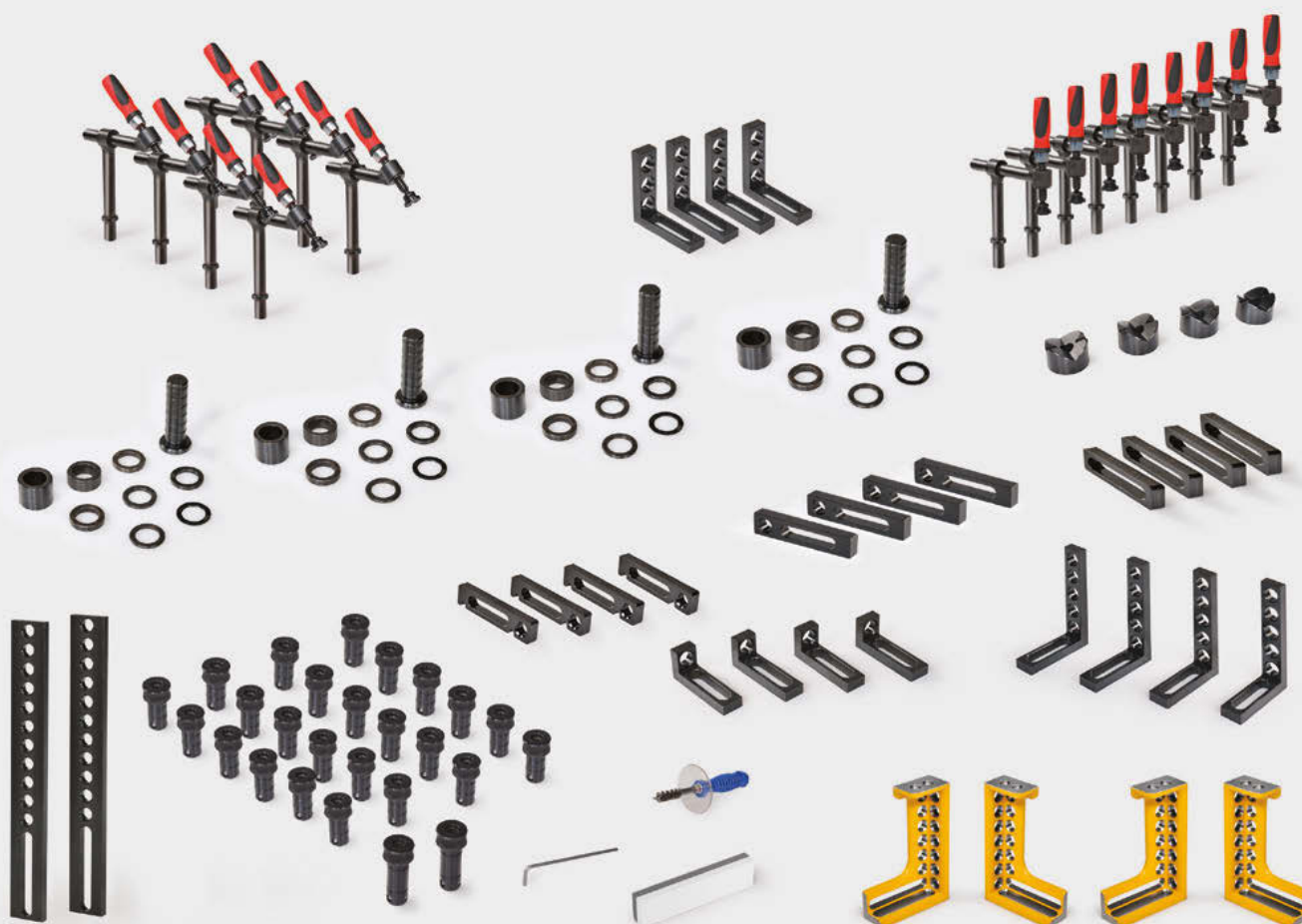
Depicted set also available with PC bolts instead of ECOline bolts:
Item no. E16-52000-711

Quantity ▼	Item no. ▼	Item description ▼
4	E16-03001-000	ECO clamping and locating angle 90 x 90 x 25 mm
2	E16-03001-002	ECO clamping and locating angle 90 x 37.5 x 25 mm
2	E16-05002-000	ECO universal stop / small L55
4	E16-05001-000	ECO universal stop / large L115
4	E16-07005-000	Screw clamp 180° with spindle
2	E16-07009-000	Variable screw clamp 45° with adjusting screw
1	D16-10002-000	Round brush ø 16 mm
1	D16-10007-000	Bench stone
1	E16-10008-000	Hexagonal wrench AF 5
8	E16-06001-000	ECO clamping pin / short

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIplusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFI^{Eco}LINE set 720 (System 16)

Item number: E16-52000-720 (79-piece)



Depicted set also available with PC bolts instead of ECOLine bolts:
Item no. E16-52000-721



PROFI^{Eco}LINE set 720 (System 16)

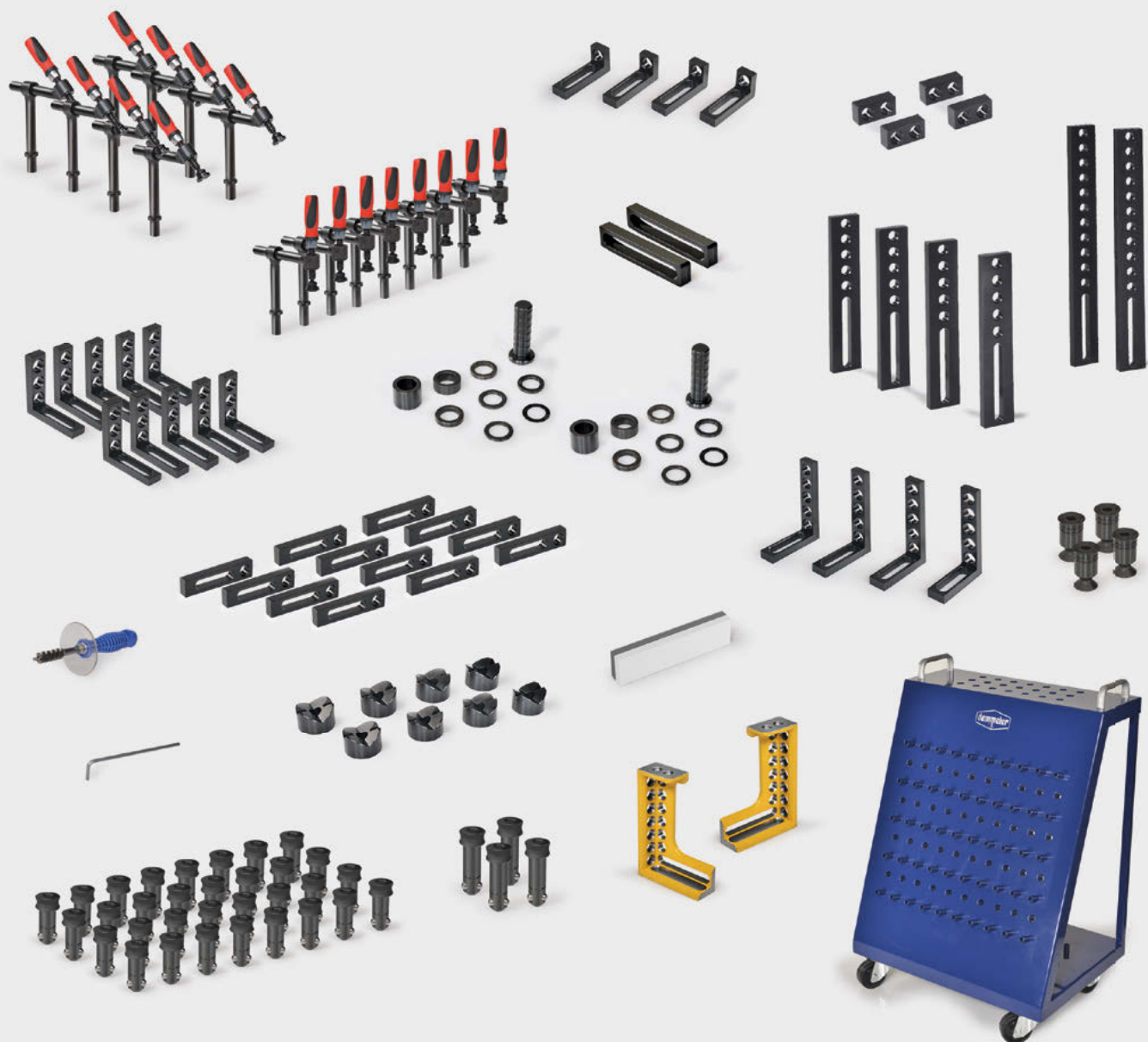
Item number: E16-52000-720 (79-piece)

Quantity ▼	Item no. ▼	Item description ▼
4	E16-03001-000	ECO clamping and locating angle 90x90x25 mm
2	E16-03002-000	ECO clamping and locating angle, right 200x137.5 mm
2	E16-03002-001	ECO clamping and locating angle, left 200x137.5 mm
4	E16-03001-002	ECO clamping and locating angle / small 90x37.5x25 mm
4	E16-03008-000	ECO clamping and locating angle 140x90x25 mm
4	E16-05001-000	ECO universal stop / large 115x25x12 mm
2	E16-05003-001	ECO stop-strip L 400 - 400x50x12 mm
4	E16-05015-000	ECO displacement stop L 150 - 150x25x12 mm
24	E16-06001-000	ECOLine bolt / short Ø 16x50 mm
2	E16-06002-000	ECOLine bolt / long Ø 16x65 mm
8	E16-07005-000	ECO screw clamp 180° with spindle
8	E16-07009-000	ECO variable screw clamp 45° with spindle
4	E16-09001-000	ECO spacer set 9 pieces - Ø 25x60 mm
4	E16-09003-000	ECO V-block locations blackened steel Ø 80 mm Ø 120° for tubes up to Ø 140 mm
1	E16-10002-000	ECO round brush Ø 16 mm
1	E16-10007-000	ECO bench stone
1	E16-10008-000	ECO ball-head Allen key AF 5x120 mm

DEMMELE welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIplusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFI^{Eco}LINE set 730 (System 16)

Item number: E16-52000-730 (114-piece)



Depicted set also available with PC bolts instead of ECOline bolts:
Item no. E16-52000-731



PROFIEcoLINE set 730 (System 16)

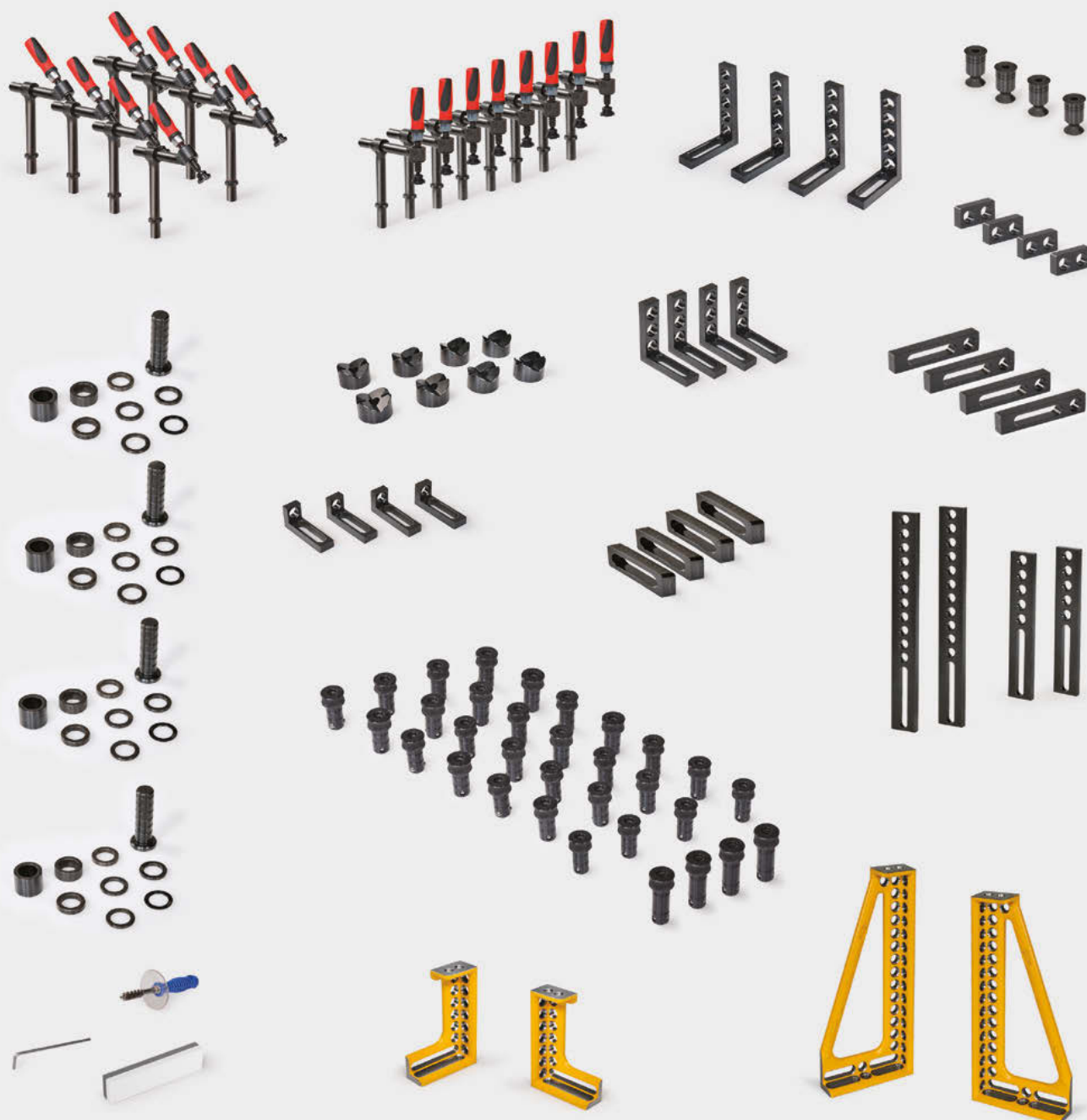
Item number: E16-52000-730 (114-piece)

Quantity ▼	Item no. ▼	Item description ▼
4	E16-03008-000	ECO clamping and locating angle 140 x 90 x 25 mm
10	E16-03001-000	ECO clamping and locating angle 90 x 90 x 25 mm
4	E16-03001-002	ECO clamping and locating angle 90 x 37.5 x 25 mm
1	E16-03002-000	ECO clamping and locating angle R 200 x 137.5 x 50 mm
1	E16-03002-001	ECO clamping and locating angle L 200 x 137.5 x 50 mm
4	E16-05002-000	ECO universal stop / small L55
12	E16-05001-000	ECO universal stop / large L115
2	D16-09001-000	Spacer set 9 pieces
2	E16-05015-000	ECO displacement-stop L150
4	D16-05003-000	Stop strip 250 mm
2	D16-05003-001	Stop strip 400 mm
8	E16-07005-000	Screw clamp 180° with spindle
8	E16-07009-000	Variable screw clamp 45° with adjusting screw
8	D16-09003-000	V-block location ø 80 mm
1	D16-10002-000	Round brush ø 16 mm
1	D00-10007-000	Bench stone
1	E16-10008-000	Hexagonal wrench AF 5
4	D16-06003-000	Connection bolt / short
4	E16-06002-000	ECO clamping pin / long
32	E16-06001-000	ECO clamping pin / short
1	D16-11001-002	Accessory cart D16

DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!

PROFI^{Eco}LINE set 300 (System 16)

Item number: E16-52000-300 (99-piece)



Depicted set also available with PC bolts instead of ECOLine bolts:
Item no. E16-52000-301



PROFIEcoLINE set 300 (System 16)

Item number: E16-52000-300 (99-piece)

Quantity ▼	Item no. ▼	Item description ▼
4	E16-03001-000	ECO clamping and locating angle H = 90
4	E16-03001-002	ECO clamping and locating angle H = 37.5
1	E16-03002-000	ECO clamping and locating angle casting 200
1	E16-03002-001	ECO clamping and locating angle casting 200
1	E16-03003-000	ECO clamping and locating angle casting 400
1	E16-03003-001	ECO clamping and locating angle casting 400
4	E16-03008-000	ECO clamping and locating angle H = 140
4	E16-05001-000	ECO universal stop, large
4	E16-05002-000	ECO universal stop, small
2	E16-05003-000	ECO stop strip 250 mm
2	E16-05003-001	ECO stop strip 400 mm
4	E16-05015-000	ECO displacement-stop
28	E16-06001-000	ECOLine bolt / short
4	E16-06002-000	ECOLine bolt / long
4	E16-06003-000	ECO connecting bolt / short
8	E16-07005-000	ECO screw clamp 180° with spindle
8	E16-07009-000	ECO variable screw clamp 45° with spindle
4	E16-09001-000	ECO spacer set 9 pieces
8	E16-09003-000	ECO V-block locations blackened steel
1	E16-10002-000	ECO round brush 16 mm
1	E16-10007-000	ECO bench stone
1	E16-10008-000	ECO Ball end hex wrench AF 5

DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used at all the 3D worktables within the system. In this way, for example, it is possible to use the accessories from the PROFIEco set at a PROFIPlusLINE table. What is more, you can individually assemble or supplement your sets with the large selection of Demmeler accessories!





Bolts

PC-bolt D16, short.....	510
PC-bolt D16, long.....	511
PC-countersunk bolt D16, short	512
PC-countersunk bolt D16, long	513
EcoLINE bolt D16, short	514
EcoLINE bolt D16, long	515
Stop and positioning bolt D16	516
Connecting bolt D16, short with collar.....	517
Connecting bolt D16, short with screw	518
Connecting bolt D16, long with screw.....	519
Adapter for PC-bolts	520
Reduction plate for clamping tubes.....	520

Bolts - overview

16 PC-bolt, short

PAGE 510



16 PC-bolt, long

PAGE 511



16 PC-countersunk bolt, short

PAGE 512



16 PC-countersunk bolt, long

PAGE 513



16 ECOLine bolt, short

PAGE 514



16 ECOLine bolt, long

PAGE 515



16 Stop and positioning bolt

PAGE 516



16 Connecting bolt, short with collar

PAGE 517



16 Connecting bolt, short with screw

PAGE 518



16 Connecting bolt, long with screw

PAGE 519



16 Adapter for PC-bolt

PAGE 520



16 Reduction plate for clamping tube

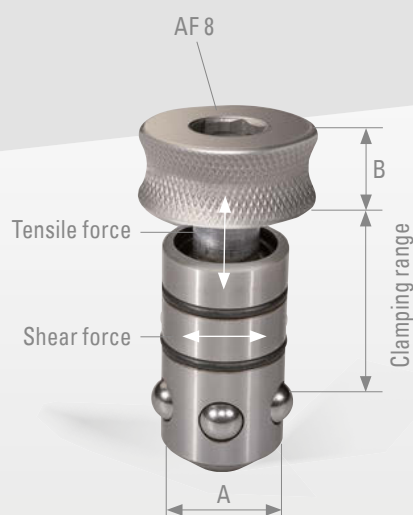
PAGE 520



PC-bolt, short


**Bauart
geprüft**

- Connecting element for all system components on tables, perforated plates etc. or for special fixtures
- Very fast connection with simultaneous large stroke
- Very high clamping force due to planetary gear effect and by avoiding a double thread
- Force-fit and form-fitting, O-ring for self-centring connection
- With clamping range



The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

Description ▲ Functional principle ▼

- Highest clamping force with large stroke using Allen key with double hexagonal AF 8 or with torque wrench
- Ergonomically shaped bolt head with recessed grip for fast one-hand operation
- High-quality hardened steel, maximum precision thanks to grinding
- O-rings prevent simultaneous rotation while tightening and clean the system bore at the same time
- 4 clamping balls, mechanically secured against falling out, to ensure even clamping

Minimum clamping range ▼

Maximum clamping range ▼

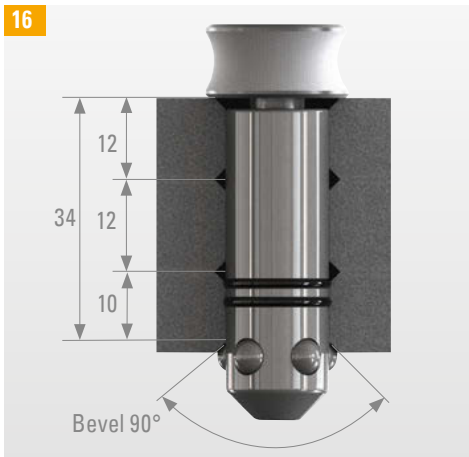


16	Clamping range	Ø A in mm	B in mm	~ Weight in kg	Design	Item no.
	22 - 24	16-0.01	12	0.08	tensile force: max. 10 kN shear force: max. 50 kN tightening torque: 20 Nm	D16-06001-000



- Used for simultaneous clamping of two system components
- Connecting element for all system components on tables, perforated plates etc. or for special fixtures
- Very fast connection with simultaneous large stroke
- Very high clamping force due to planetary gear effect and by avoiding a double thread
- Force-fit and form-fitting, O-ring for self-centring connection
- With clamping range



The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

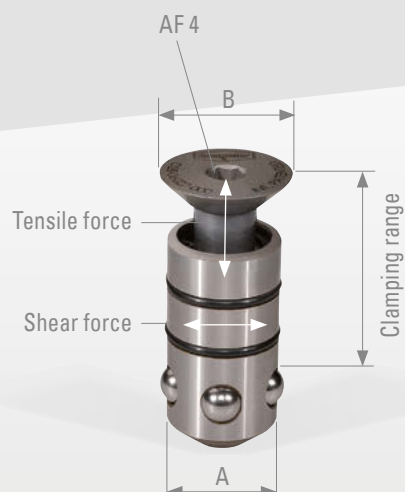
Description ▲ ▼	Minimum clamping range ▼	Maximum clamping range ▼
<p>Turning the ergonomically shaped bolt head causes the balls of the patented PC-bolt to make point contact with the bevel on the underside of the worktable. Continued turning clamps the original DEMMELER PC-bolt.</p>	<p>16</p> 	<p>16</p> 

16	Clamping range	Ø A in mm	B in mm	~ Weight in kg	Design	Item no.
	34-36	16-0.01	12	0.10	tensile force: max. 10 kN shear force: max. 50 kN tightening torque: 20 Nm	D16-06002-000

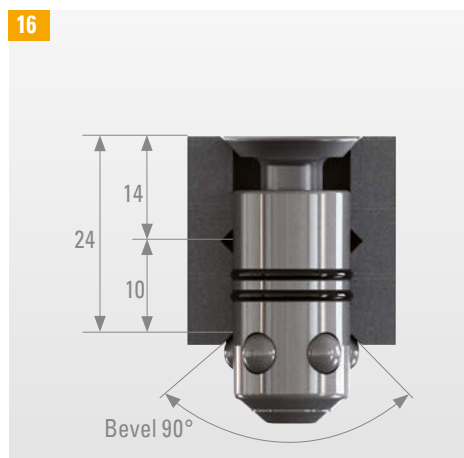
PC-countersunk bolt, short


**Bauart
geprüft**

- Countersunk bolt head (no interfering edges)
- Only for connecting bores (no oblong holes)
- Clamping by means of Allen key AF 4 or torque wrench
- Countersunk head bolts may only be used in bores but not in oblong holes



The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

Description ▲ Application ▼
Minimum clamping range ▼
Maximum clamping range ▼


16	Clamping range	Ø A in mm	Ø B in mm	~ Weight in kg	Design	Item no.
	22-24	16-0.01	19	0.04	tensile force: max. 3 kN shear force: max. 50 kN tightening torque: 10 Nm	D16-06004-000



- Countersunk bolt head (no interfering edges)
- Only for connecting bores (no oblong holes)
- Clamping by means of Allen key AF 4 or torque wrench
- For simultaneous clamping of two system components on top of each other on the worktable
- Countersunk head bolts may only be used in bores but not in oblong holes



The specified loads must not be exceeded when using the clamping pins.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

Description ▲	Minimum clamping range ▼	Maximum clamping range ▼
	<div>16</div> 	<div>16</div> 

16	Clamping range	Ø A in mm	Ø B in mm	~ Weight in kg	Design	Item no.
	34-36	16-0.01	19	0.06	tensile force: max. 3 kN shear force: max. 50 kN tightening torque: 10 Nm	D16-06005-000

ECOLine bolt, short

- Connecting element for system components
- For clamping one system component on the worktable or to connect 2 system components
- Simple version without clamping range



Description ▲

Clamping range ▼



16	Clamping range	Ø A in mm	B in mm	~ Weight in kg	Item no.
	22	16 - 0.01	12	0.08	E16-06001-000



- Connecting element for system components
- For clamping 2 system components on the worktable or to connect 3 system components
- Simple version without clamping range



Description ▲

Clamping range ▼



16	Clamping range	Ø A in mm	B in mm	~ Weight in kg	Item no.
	34	16	12	0.08	E16-06002-000

Stop and positioning bolts

- For marking the system components
- For fixation e.g. of blocks and stops, cost-effective replacement for a second clamping pin
- Blackened



Description ▲

Application ▼



16	Ø A in mm	Ø B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	16	23	37	12	0.09	D16-06009-000

Connecting bolt, short with collar



- For use as long-term connection
- For connecting two system components
- Suitable for system bore / oblong hole
- Clamping with Allen key AF 6



Description ▲

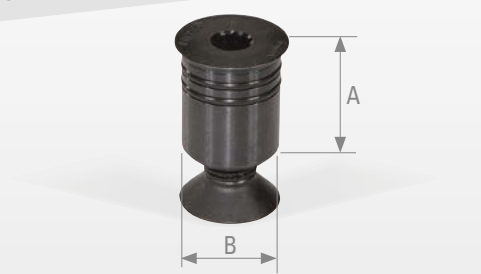
Application ▼



16	A in mm	Ø B in mm	C in mm	~ Weight in kg	Item no.
	22	16	5	0.05	D16-06003-002

Connection bolt, short with screw

- For use as long-term connection
- With self-centring countersunk head on both sides
- Suitable for system bores
- Clamping with Allen key AF 6
- Ideal for connecting worktables with U-spacers etc.
- Blackened



Description ▲

16	A in mm	Ø B in mm	~ Weight in kg	Item no.
	17	16	0.025	D16-06003-000

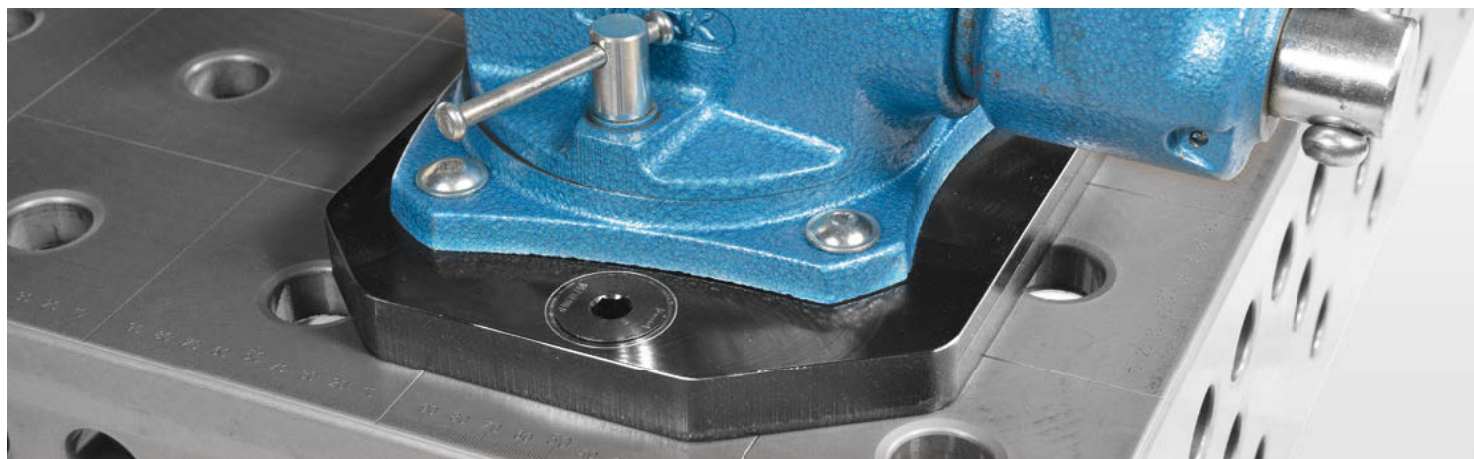
Connecting bolt, long with screw



- For use as long-term connection
- With self-centring countersunk head on both sides
- Suitable for system bores
- Clamping with Allen key AF 6
- For connecting three system components or two system components on the worktable
- Blackened



Description ▲ Application ▼

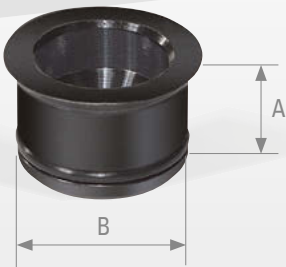


16	A in mm	Ø B in mm	~ Weight in kg	Item no.
	25	16	0.04	D16-06006-000

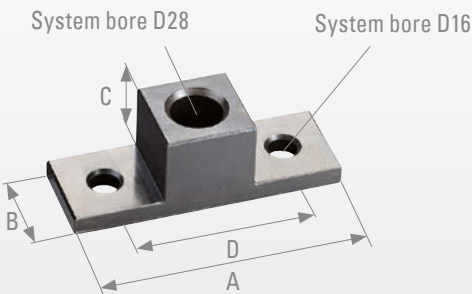
Adapter for PC-bolt D16 to D28

Reduction plate for clamping tubes D28 to D16

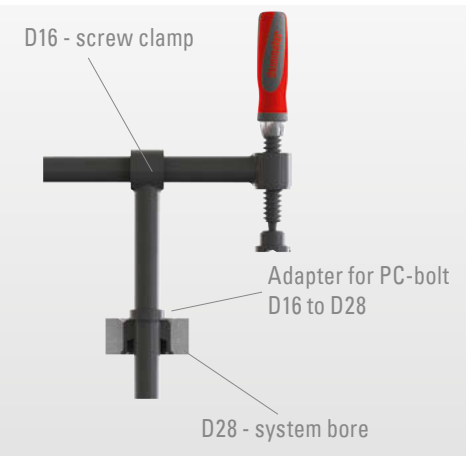
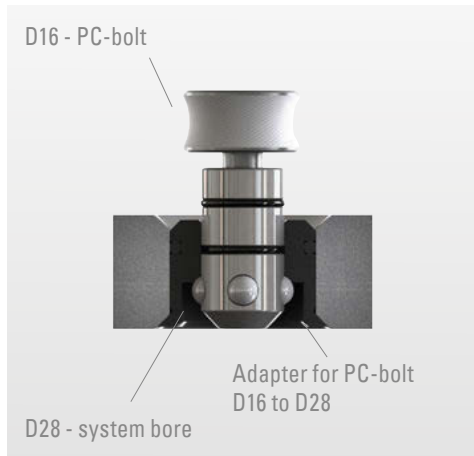
- Interface between system D28 and D16
- Fully compatible with system D28 and D16
- Force-fit and form-fitting with O-ring, self-centring connection
- O-ring prevents simultaneous rotation while tightening
- O-ring cleans the system bore



- Interface between system 28 and system 16



Description ▲	Application ▼	Application ▼	Application ▼
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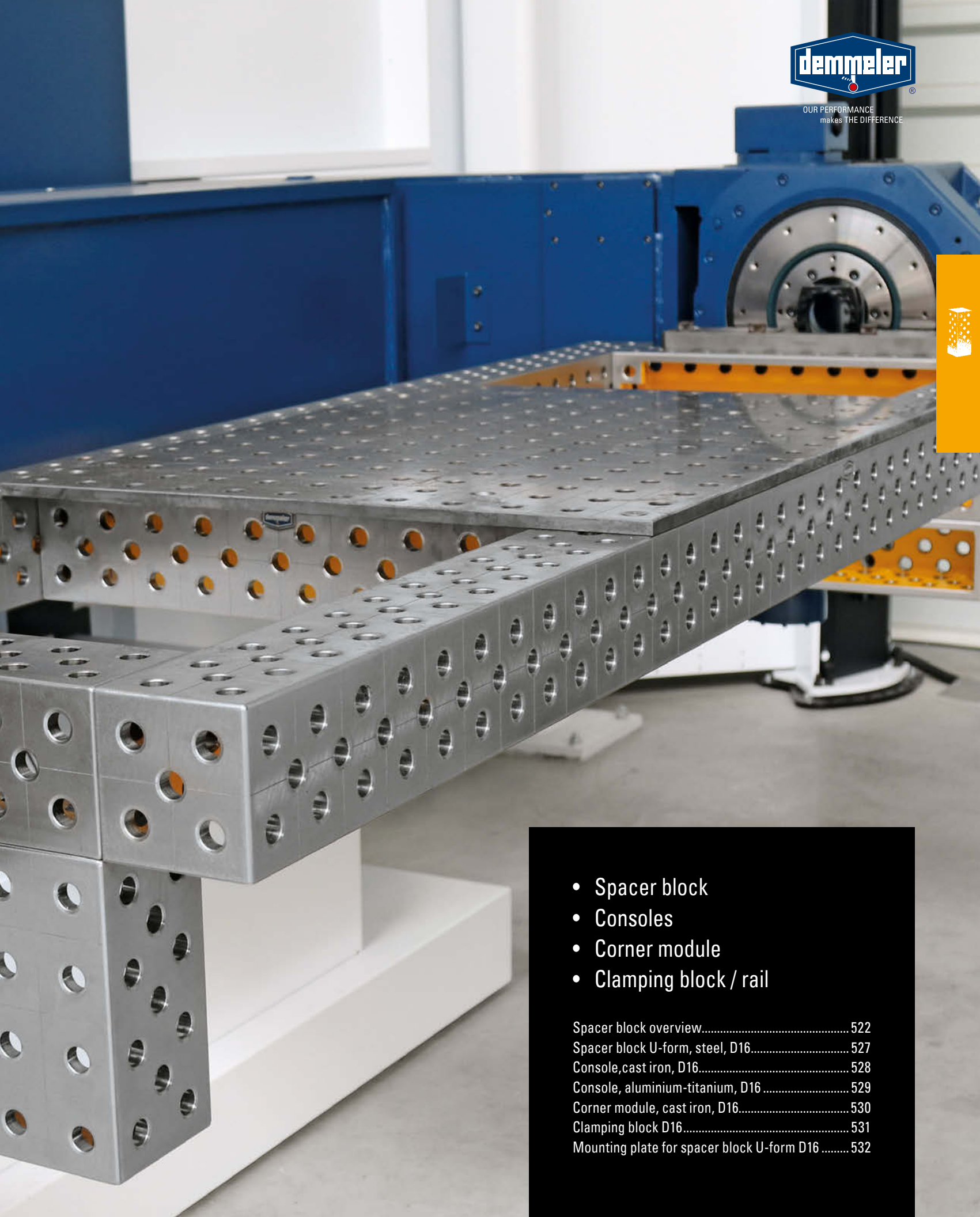


Adapter for PC-bolt D16 to D28

16	Ø A in mm	B in mm	~ Weight in kg	Item no.
	20.5	28-0.02	0.05	D00-06010-002

Reduction plate for clamping tubes D28 to D16

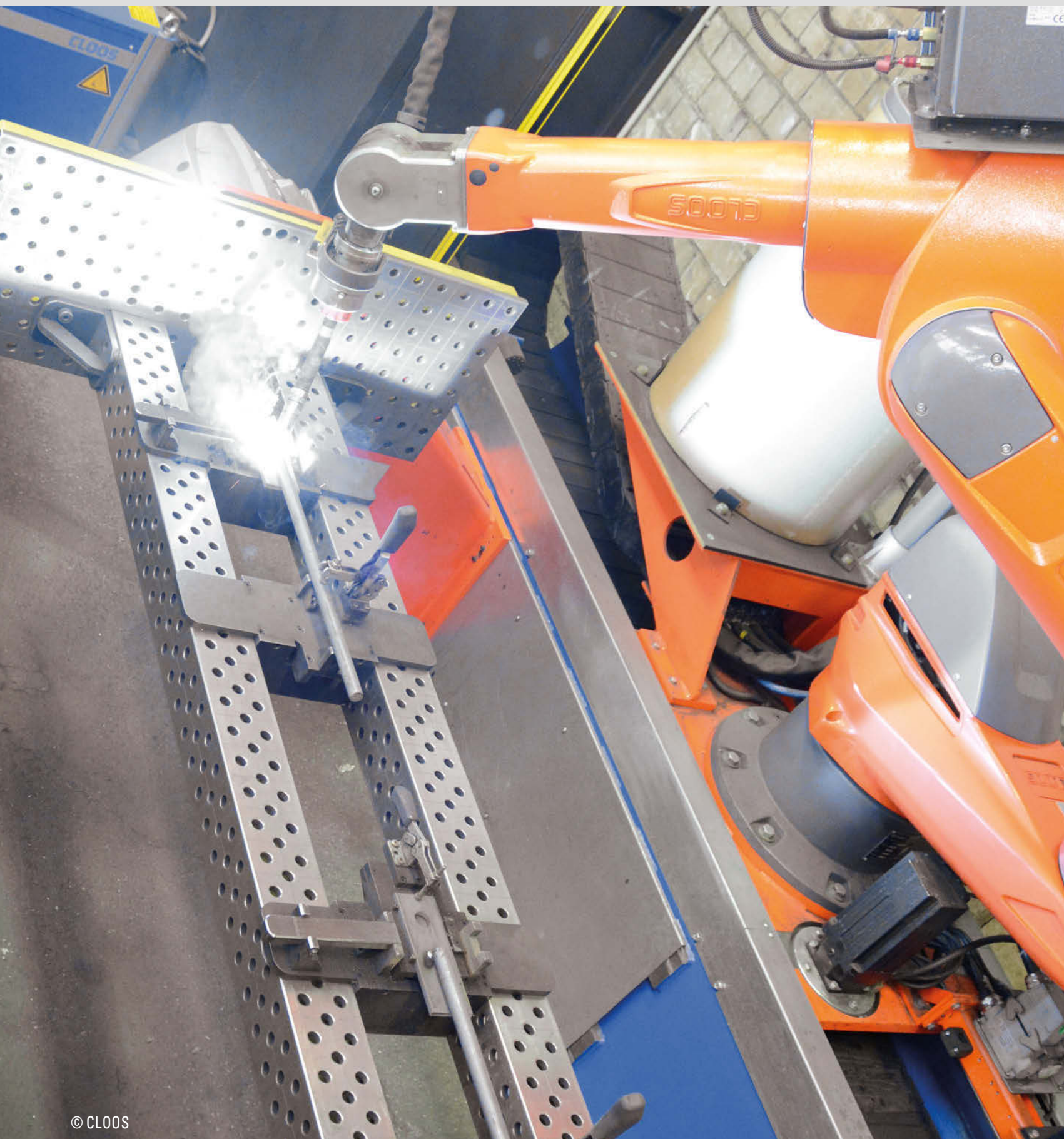
16	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	150	50	50	100	1.04	D00-06015-000



- Spacer block
- Consoles
- Corner module
- Clamping block / rail

Spacer block overview.....	522
Spacer block U-form, steel, D16.....	527
Console, cast iron, D16.....	528
Console, aluminium-titanium, D16	529
Corner module, cast iron, D16.....	530
Clamping block D16.....	531
Mounting plate for spacer block U-form D16	532

Spacer block overview



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OUR PERFORMANCE
makes THE DIFFERENCE

Spacer block overview

16 Spacer block U-form Steel

PAGE 527



16 Console Cast iron

PAGE 528



16 Console Aluminium-titanium

PAGE 529



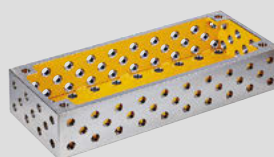
16 Corner module, Cast iron

PAGE 530



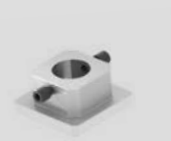
16 Clamping block

PAGE 531



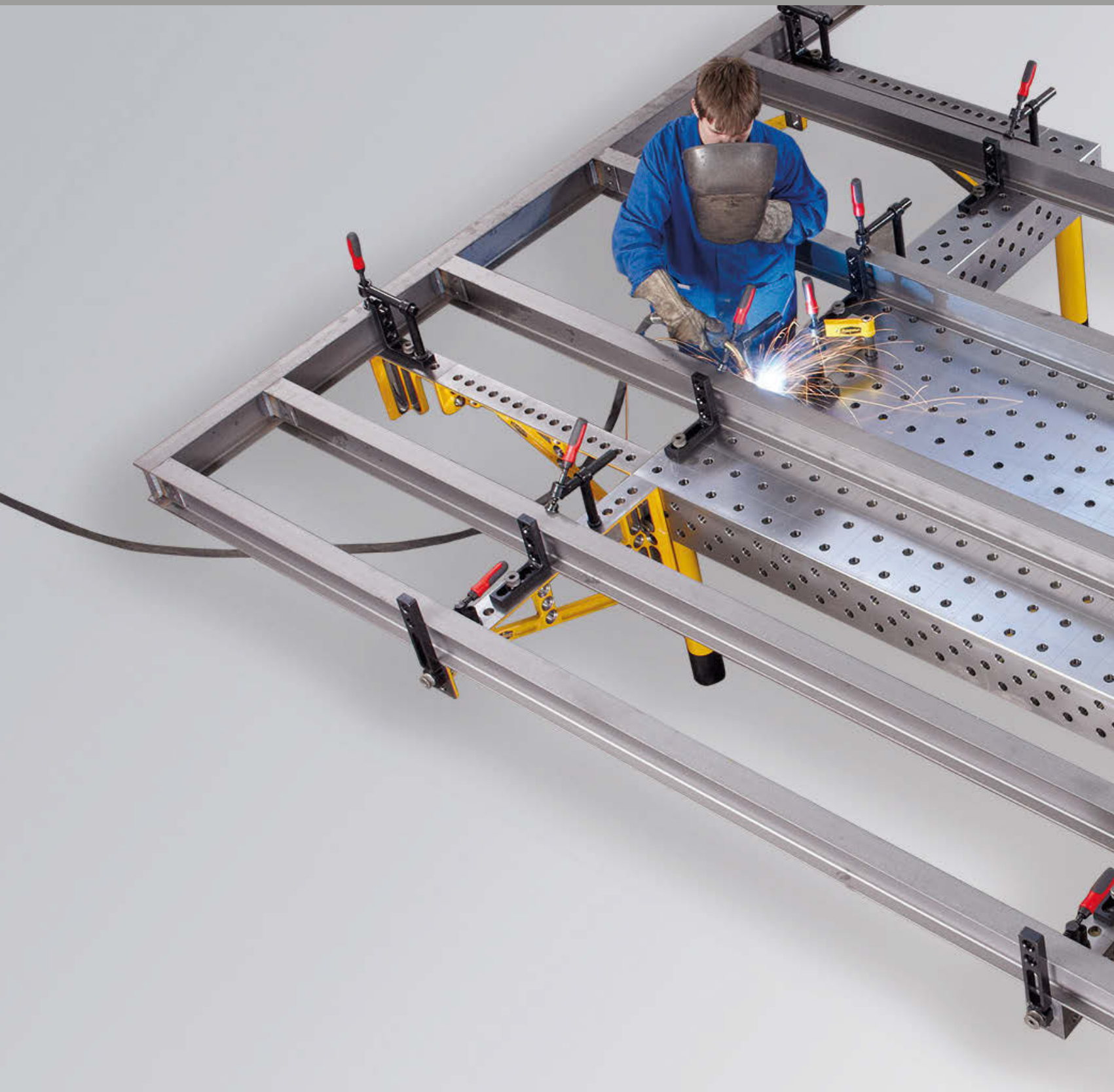
16 Mounting plate for spacer block U-form

PAGE 532



Spacer block

Setup with spacer block





Thinking beyond the edge of the table

There are situations where having a bigger table would be nice. We developed the spacer block so the clamping table can grow with your needs. A smart system for extending your table temporarily. When you use our rail system, you can extend the supporting surface with spacer blocks as far as the rails reach.

These add-on components increase your flexibility without permanently taking up space.

Spacer block



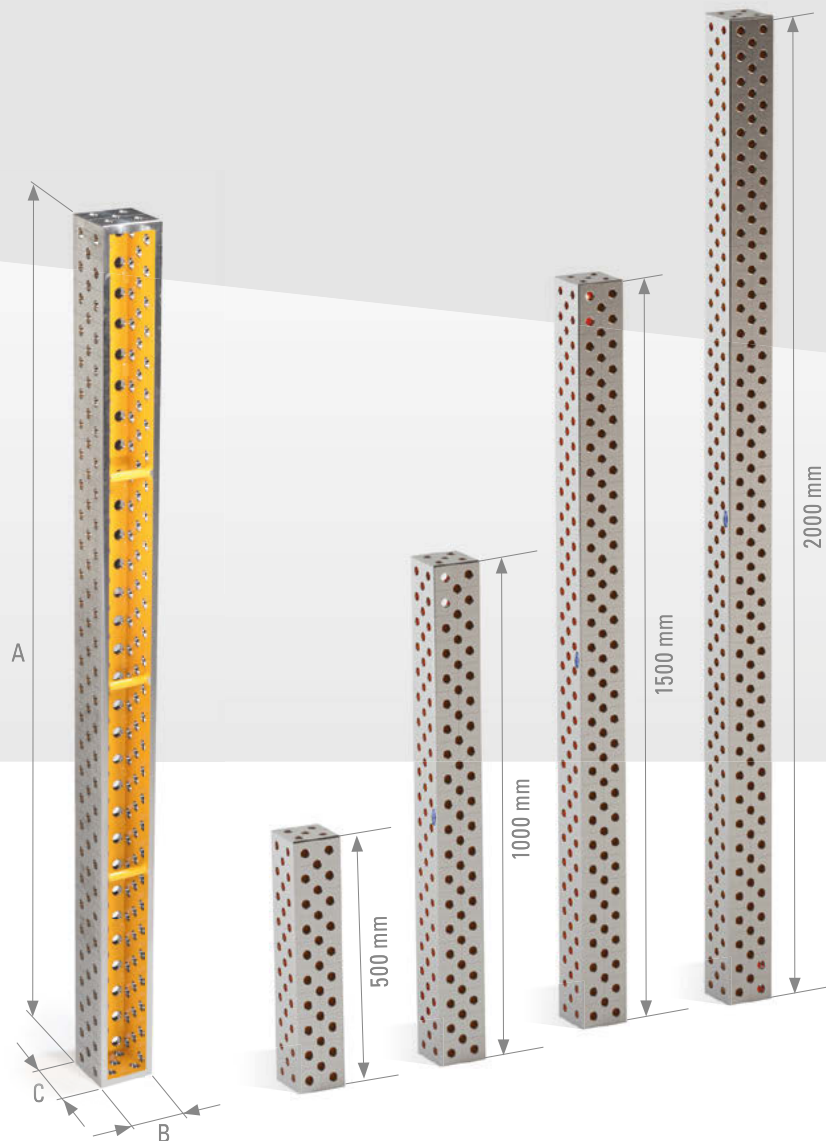
THE HARDNESS



DEMONT 760 M

- For use as a table extension
- Application: 5-sided
- With grid lines
- Spacer blocks with hardened surfaces are protected against weld spatter adhesion, thus reducing wear

Figure similar



Spacer block U-form, steel
Spacer block U-form, steel, hardened

16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.	Item no.
	500	100	100	13	Diagonal grid 50x50	D16-04002-000	D16-04002-300
	1000	100	100	25	Diagonal grid 50x50	D16-04002-001	D16-04002-301
	1500	100	100	37	Diagonal grid 50x50	D16-04002-002	D16-04002-302
	2000	100	100	50	Diagonal grid 50x50	D16-04002-003	D16-04002-303
	500	100	150	20	50x50 grid	D16-04003-026	D16-04003-326
	1000	100	150	37	50x50 grid	D16-04003-070	D16-04003-304
	1500	100	150	55	50x50 grid	D16-04003-071	D16-04003-323
	2000	100	150	72	50x50 grid	D16-04003-065	D16-04003-365

Other dimensions on request

Consoles, cast iron

- Five full clamping sides with system bores result in numerous application possibilities
- As connecting elements between various system components
- Highly versatile in combination
 - >> Through system bore
 - >> Variable displacement with oblong holes
- Of one piece for high stability and durability
- Use as console or extension
- Powder-coated
- With grid lines

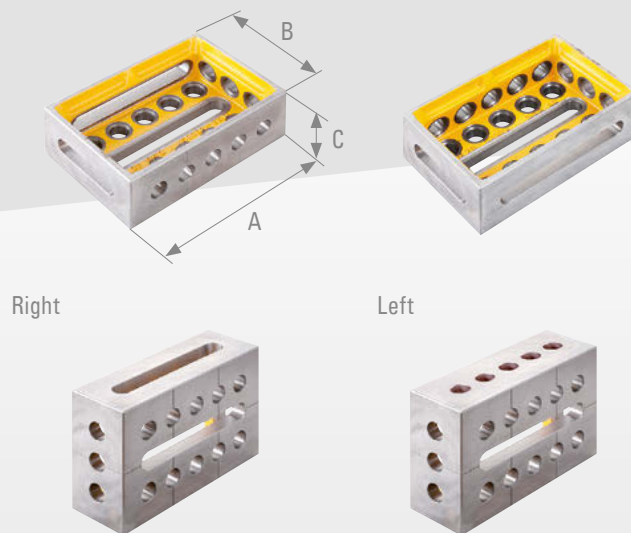


Figure similar

Description ▲

Application ▼



16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	150	100	50	2.10	Right	D16-03005-001
	150	100	50	2.10	Left	D16-03005-004

- High-strength aluminium-titanium alloy for approx. 60 % weight reduction and approx. 10 % higher bending strength compared to cast iron
- Five full clamping sides enable numerous clamping possibilities
- Variable displacement with oblong holes
- Anodised

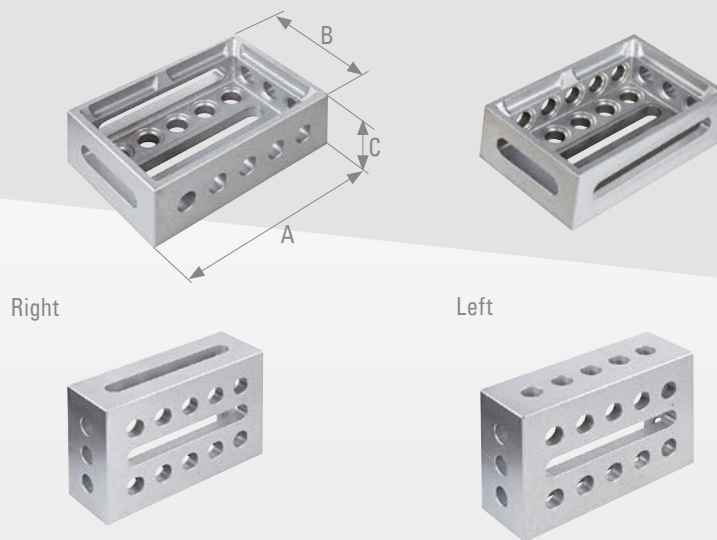
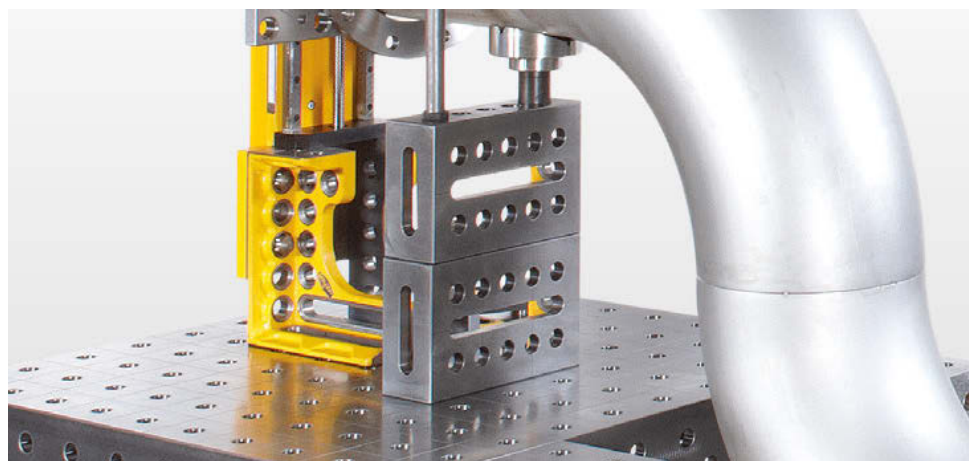


Figure similar

Description ▲

Application ▼



16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	150	100	50	0.78	Right	D16-03005-010
	150	100	50	0.78	Left	D16-03005-012

Corner module, cast iron

Diagonal table expansion

- Diagonal table expansion
- Flexible in application as V-block, support, stop and more

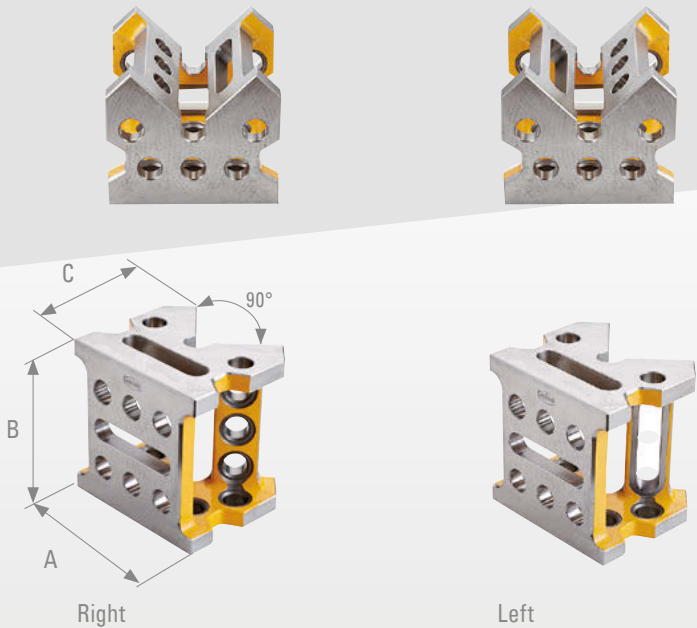
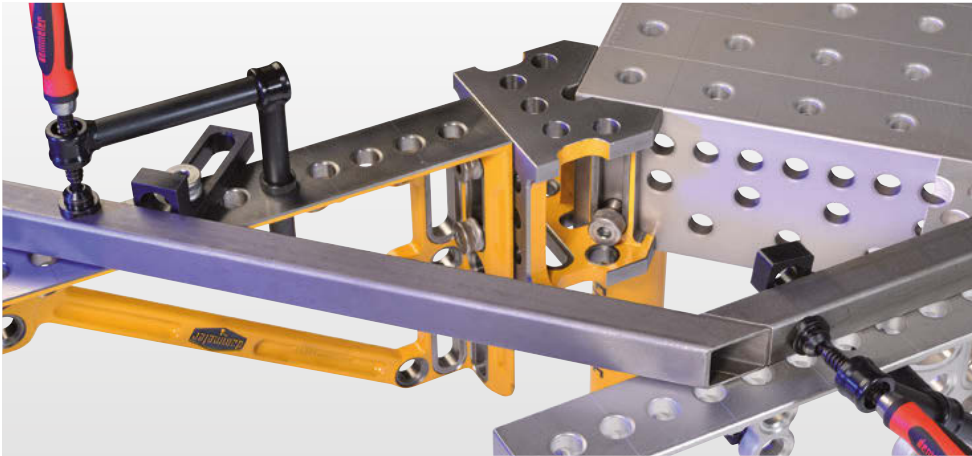


Figure similar

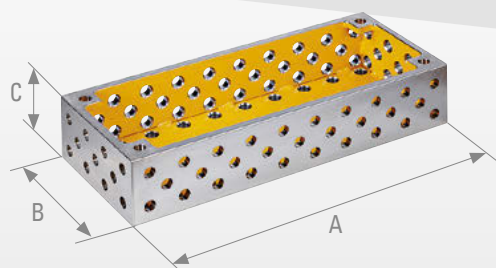
Description ▲

Application ▼



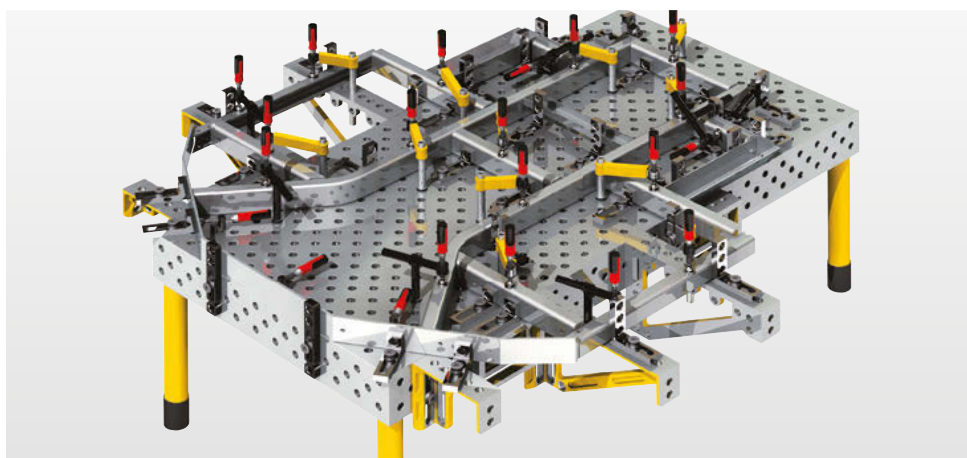
16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	100	100	85	1.9	Right	D16-04005-000
	100	100	85	1.9	Left	D16-04005-003

- Application: 5-sided
- Third axis for expansion as clamping tower or laterally as exact table stop
- Connection of system components
- With grid lines



Description ▲

Application ▼

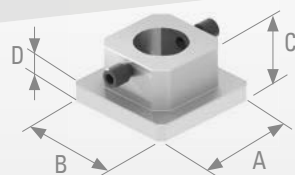


16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	500	200	100	19	50x50 grid	D16-04010-000
	500	500	100	39	50x50 grid	D16-04011-000

Other dimensions on request

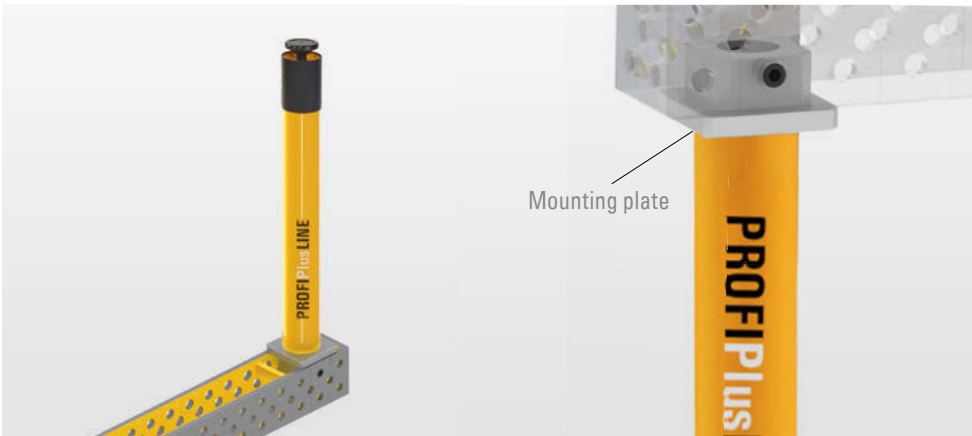
Mounting plate for spacer block U-form

- Mounting plate for spacer block U-form D16-04002-xxx and D16-04003-000
- For supporting leg attachment PL16-10010-xxx
- Incl. 2x mounting bolts



Description ▲

Application ▼



16	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
	95	95	50	15	0.7	00097469



Clamping and locating angle

PL clamping and locating angle casting 200 D16	537
PL clamping and locating angle casting 400 D16	538
PL clamping and locating angle casting 600 D16	539
Universal pivot and tilt angle D16.....	540
PL clamping and locating angle small bore / bore D16.....	541
PL clamping and locating angle, small bore / oblong hole D16	542
PL clamping and locating angle bore / oblong hole D16.....	543
PL clamping and locating angle oblong hole / oblong hole D16	544
PL clamping and locating angle bore / bore D16	545
PE clamping and locating angle, large bore / oblong hole D16	546
Flat angle trim D16	547
Universal stop small D16.....	548
Displacement-stop D16.....	549
EcoLINE universal stop small D16.....	550
EcoLINE universal stop large D16	551
Universal stop large with precision scaling D16	552
Universal stop / large D16.....	553
Universal stop large with plunger D16 mm	554
Universal stop L 165 D16	555
Contour stop	556
Stop-strip D16.....	557
Adapter plate D16	557
Angle-setting template D16	558

Clamping and locating angle overview

16 PROFIPlusLINE
Clamping and locating angle
cast iron 200

PAGE 537



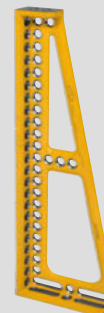
16 PROFIPlusLINE
Clamping and locating angle
cast iron 400

PAGE 538



16 PROFIPlusLINE
Clamping and locating angle
cast iron 600

PAGE 539



16 Universal pivot and tilt angle,
steel

PAGE 540



16 Clamping and locating angle,
small bore / bore

PAGE 541



16 Clamping and locating angle,
small bore / oblong hole

PAGE 542



16 Clamping and locating angle
bore / oblong hole

PAGE 543



16 Clamping and locating angle
oblong hole / oblong hole

PAGE 544



16 Clamping and locating angle
bore / bore

PAGE 545



16 Clamping and locating angle, large
bore / oblong hole

PAGE 546



16 Flat angle trim

PAGE 547



16 Universal stop small

PAGE 548



16 Displacement stop

PAGE 549



16 EcoLINE Universal stop small

PAGE 550



16 EcoLINE Universal stop large

PAGE 551



16 Universal stop large with precision scaling

PAGE 553



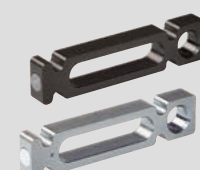
16 Universal stop large

PAGE 553



16 Universal stop large with plunger

PAGE 554



16 Universal stop L 165

PAGE 555



16 Contour stop

PAGE 556



16 Stop-strip

PAGE 557



16 Adapter plate

PAGE 557



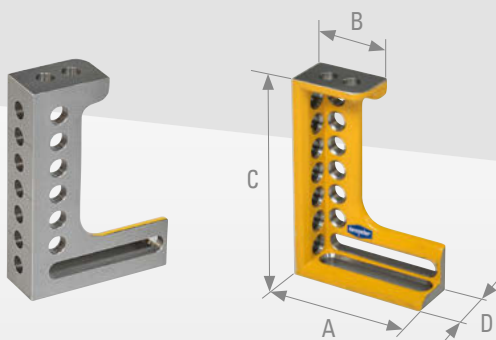
16 Angle-setting template

PAGE 558





- Continuous adjustment and locking
- Three full clamping sides with system bores
- With oblong holes for continuous adjustment
- Improved sliding behaviour through the combination of cast iron on steel
- Grid lines reduce the setup time
- With face plate for additional superstructures
- Special casting: ultimate stability and ductility
- Powder-coated
- For use e.g. as a tall stop or table extension
- Ordering in pairs is recommended
- With grid lines and precision scaling

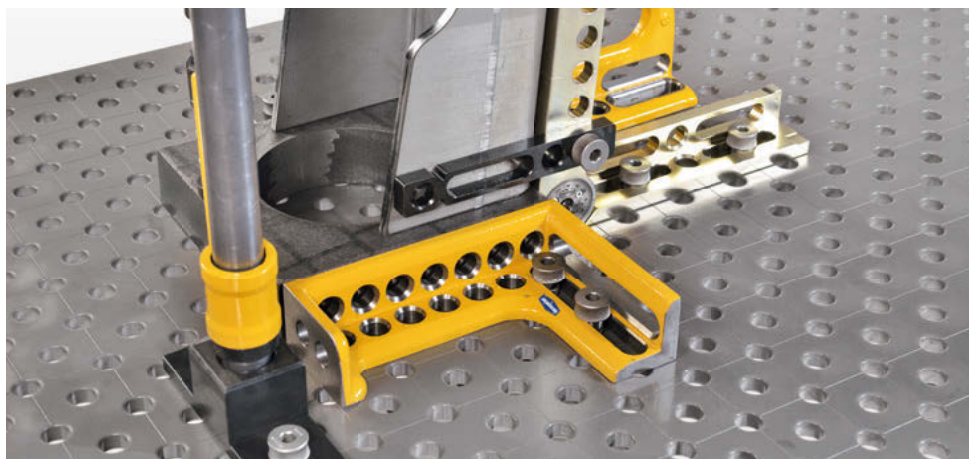


Right
D16-03002-000

Left
D16-03002-001

Description ▲

Application ▼



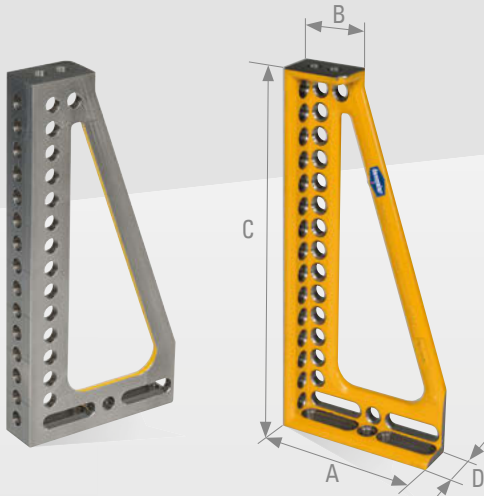
Clamping and locating angle 200

16	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	137.5	75	200	50	1.7	Right	D16-03002-000
	137.5	75	200	50	1.7	Left	D16-03002-001

Clamping and locating angle cast iron 400

PROFIPlusLINE

- Continuous adjustment and locking
- Three full clamping sides with system bores
- With oblong holes for continuous adjustment
- Improved sliding behaviour through the combination of cast iron on steel
- Grid lines reduce the setup time
- With face plate for additional superstructures
- Special casting: ultimate stability and ductility
- Powder-coated
- For use e.g. as a tall stop or table extension
- Ordering in pairs is recommended
- With grid lines and precision scaling



Right
D16-03003-000

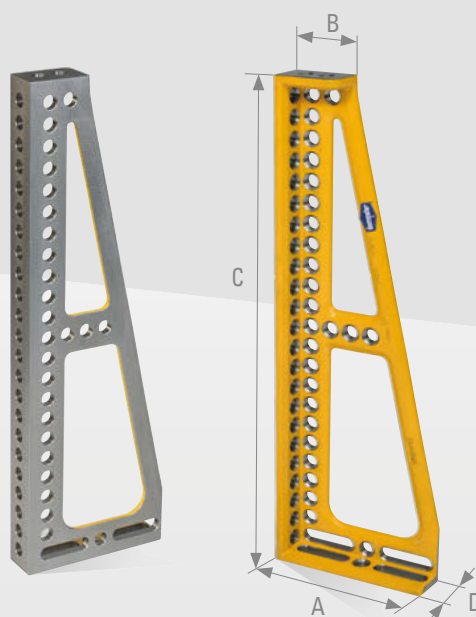
Left
D16-03003-001

Description ▲ Application ▼



16	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	187.5	75	400	50	4	Right	D16-03003-000
	187.5	75	400	50	4	Left	D16-03003-001

- Continuous adjustment and locking
- Three full clamping sides with system bores
- With oblong holes for continuous adjustment
- Improved sliding behaviour through the combination of cast iron on steel
- Grid lines reduce the setup time
- With face plate for additional superstructures
- Special casting: ultimate stability and ductility
- Powder-coated
- For use e.g. as a tall stop or table extension
- Ordering in pairs is recommended
- With grid lines and precision scaling

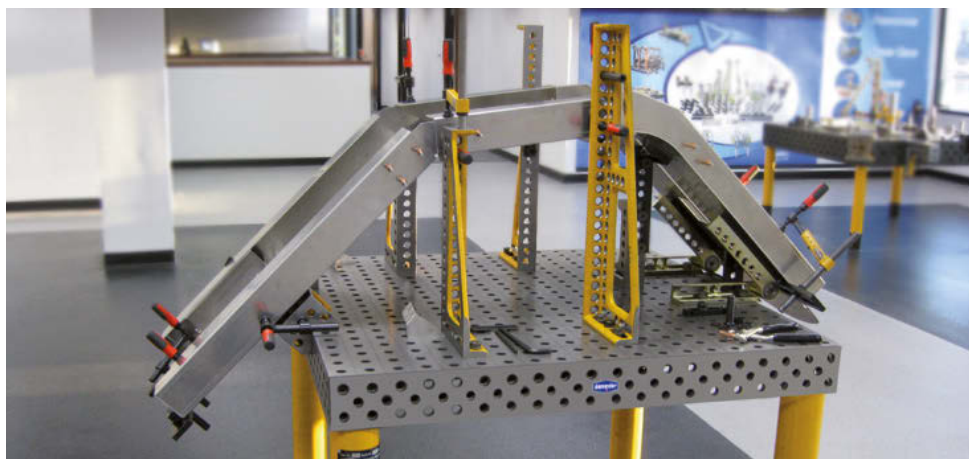


Right
D16-03004-000

Left
D16-03004-001

Description ▲

Application ▼

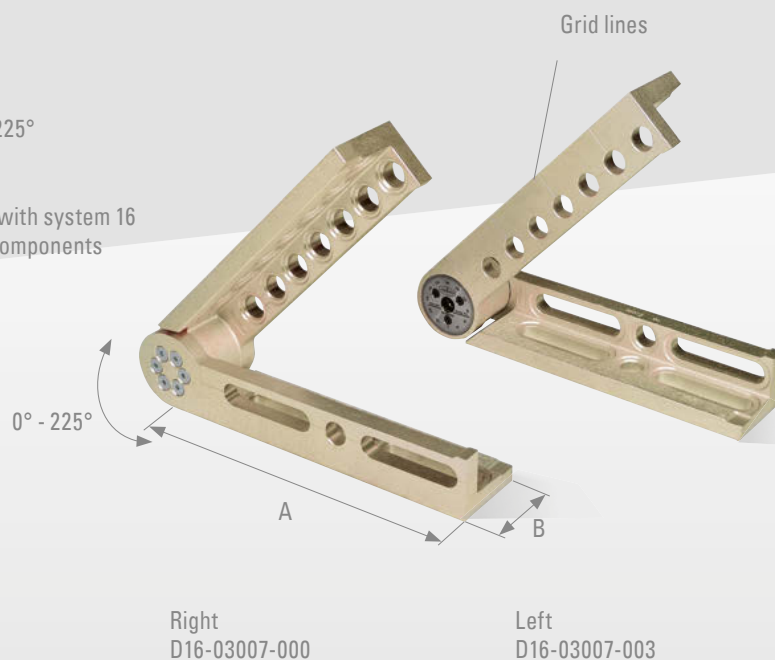


16	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	187.5	75	600	50	5.4	Right	D16-03004-000
	187.5	75	600	50	5.4	Left	D16-03004-001

Universal pivot and tilt angle

Continuous tilt from 0° to 225°

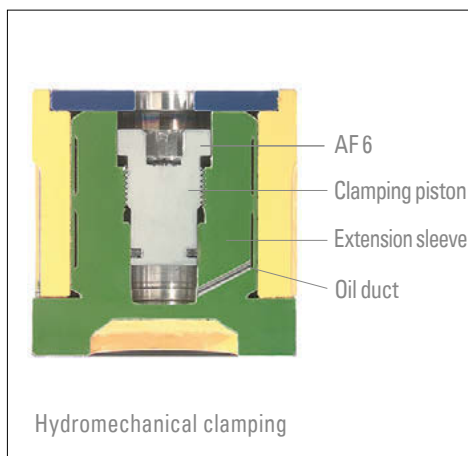
- Continuous
- Precision scaling adjustable from 0°-225°
- Hydromechanical clamping:
 - >> Completely maintenance-free
 - >> Holding force up to 160 Nm torque with system 16
- Can be combined with other system components
- Horizontal and vertical use possible



Description ▲

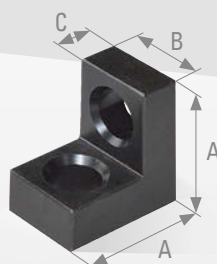
Sectional view ▼

Application ▼



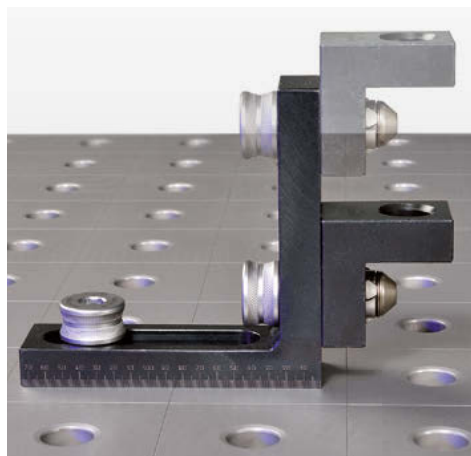
16	A in mm	B in mm	~ Weight in kg	Description	Item no.
	225	50	3	Right	D16-03007-000
	225	50	3	Left	D16-03007-003

- Ideal for confined spaces
- Continuously adjustable support surfaces e.g. in combination with D16-03001-003 (page 544)
- Blackened



Description ▲ Application ▼

Application ▼

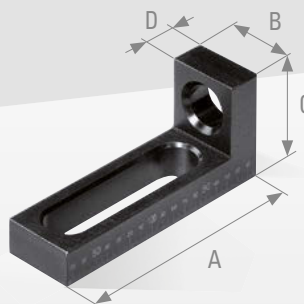


16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	37.5	25	12	0.12	Steel, blackened	D16-03001-008

Clamping and locating angle small bore / oblong hole

PROFIPlusLINE

- Dimension adjustment using grid lines on 3D worktable possible
- Continuous adjustment and locking via oblong hole
- Ideal for confined spaces
- Combination bore / oblong hole
- Blackened
- Precision scaling on both sides



Description ▲

Application ▼



Exact adjustment via precision scaling



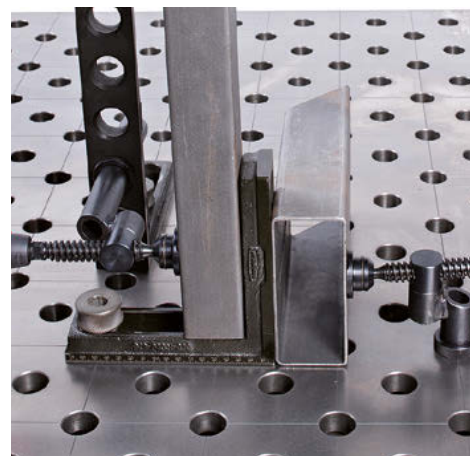
16	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	90	25	37.5	12	0.16	Steel, blackened	D16-03001-002

- Combination system bores / oblong hole for numerous clamping possibilities
- Blackened
- Dimension adjustment using grid lines on 3D worktable possible
- Compatible with all clamping and locating angles so that the oblong hole can be used to form a height-adjustable support
- Precision scaling on both sides



Description ▲

Application ▼



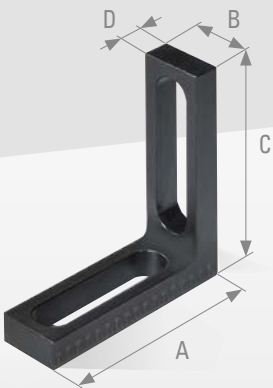
Two full angle surfaces – therefore usable on both sides

16	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	90	25	90	12	0.24	Steel, blackened	D16-03001-000

Clamping and locating angle oblong hole / oblong hole

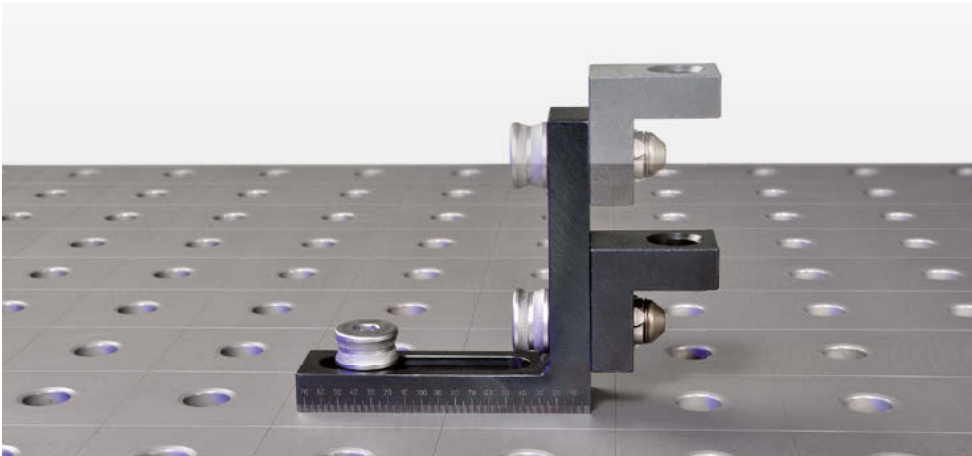
PROFIPlusLINE

- Dimension adjustment using grid lines on 3D worktable possible
- Continuous adjustment and locking
- Ideal for confined spaces
- Blackened
- Precision scaling on both sides



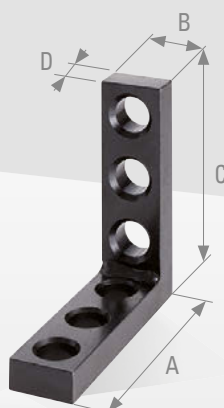
Description ▲

Application ▼



16	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	90	25	90	12	0.20	Steel, blackened	D16-03001-003

- Dimension adjustment using grid lines on 3D worktable possible
- Ideal for confined spaces
- Blackened
- Precision scaling on both sides



Description ▲ Application ▼

Application ▼



16	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	90	25	90	12	0.28	Steel, blackened	D16-03001-004

Clamping and locating angle large bore / oblong hole

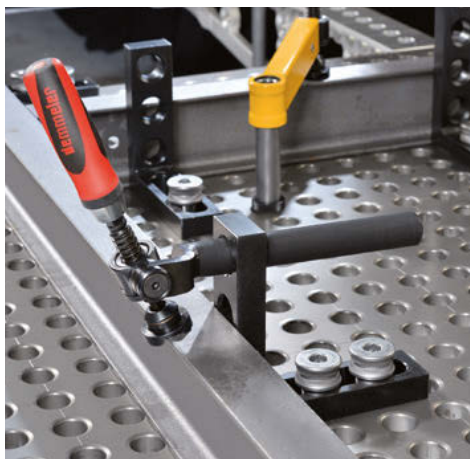
PROFIEcoLINE

- Combination system bores / oblong hole for numerous clamping possibilities
- Precision scaling on both sides
- Two full angle surfaces, therefore can be used from both sides
- Dimension adjustment using grid lines on 3D worktable possible
- Compatible with all clamping and locating angles so that the oblong hole can be used to form a height-adjustable support
- Blackened



Description ▲ Application ▼

Application ▼



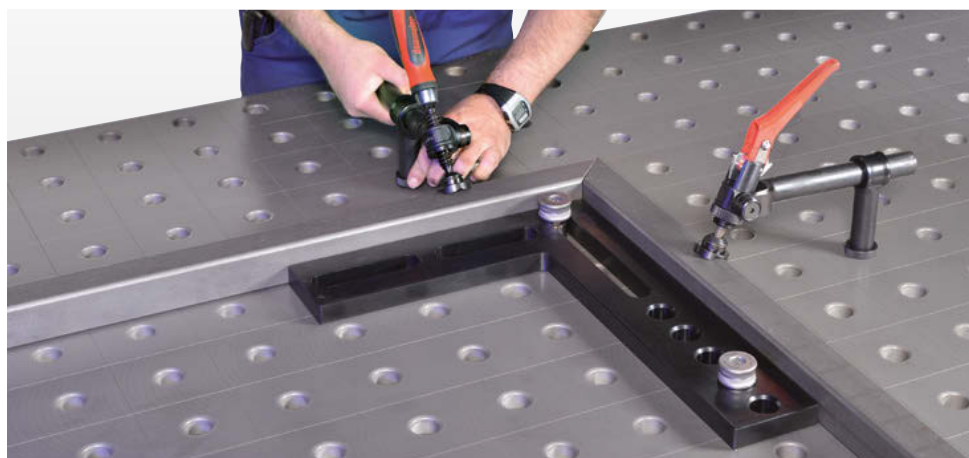
16	A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Description	Item no.
	90	25	140	12	0.32	Steel, blackened	D16-03008-000

- Full locating surfaces inside and outside
- Numerous possibilities thanks to oblong holes and system bores
- Continuously moveable with oblong holes
- Blackened



Description ▲

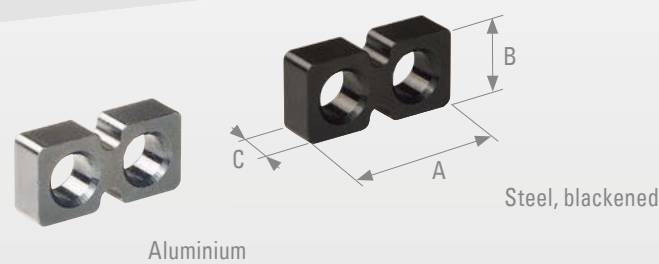
Application ▼



16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	187.5	250	12	1.46	Steel, blackened	D16-03006-000

Universal stop small

- Preferred use in confined work areas
- Also usable for corner connections thanks to notching



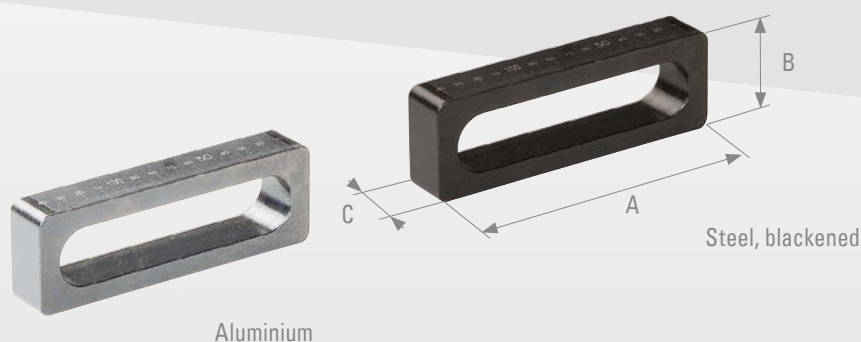
Description ▲

Application ▼



16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	55	25	12	0.08	Steel, blackened	D16-05002-000
	55	25	12	0.03	Aluminium	D16-05002-010

- Precision scaling on both sides
- Continuously adjustable with scale on both sides



Description ▲

Application ▼



16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	150	25	12	0.18	Steel, blackened	D16-05015-000
	150	25	12	0.06	Aluminium	D16-05015-001

EcoLINE universal stop small

- Preferred use in confined work areas
- Simple version



Description ▲ Application ▼

Application ▼



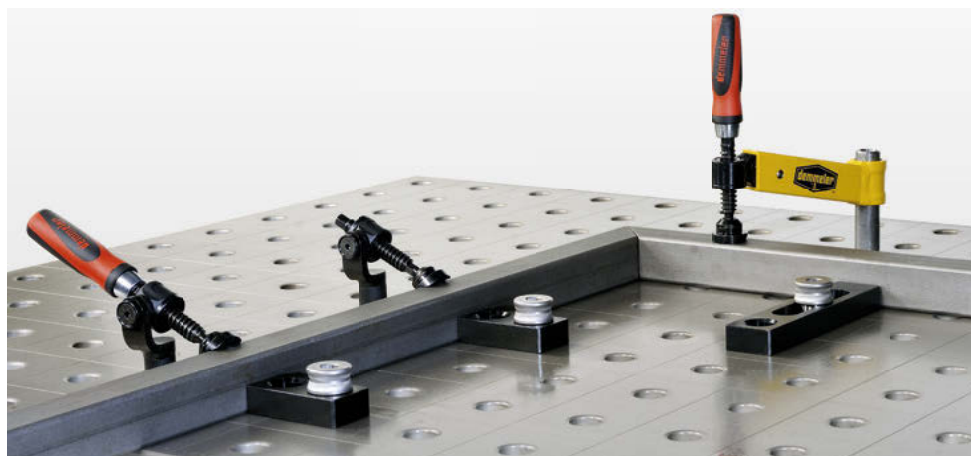
16	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	55	25	12	0.08	E16-05002-000

- Combination system bore / oblong hole for numerous clamping possibilities
- Simple version
- With precision scaling



Description ▲ Application ▼

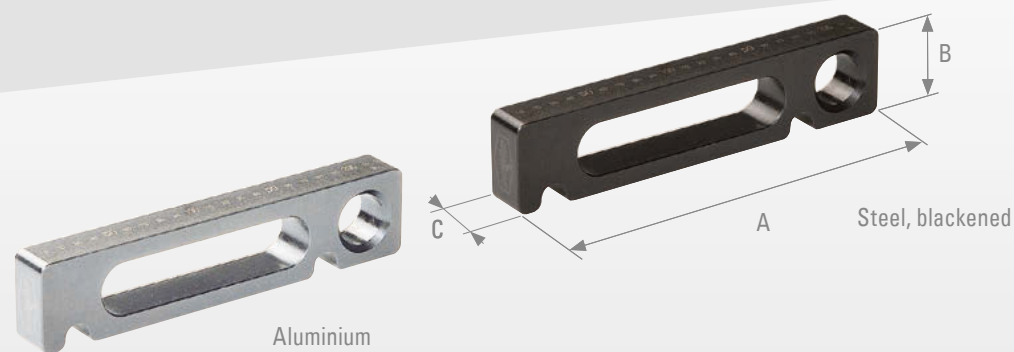
Application ▼



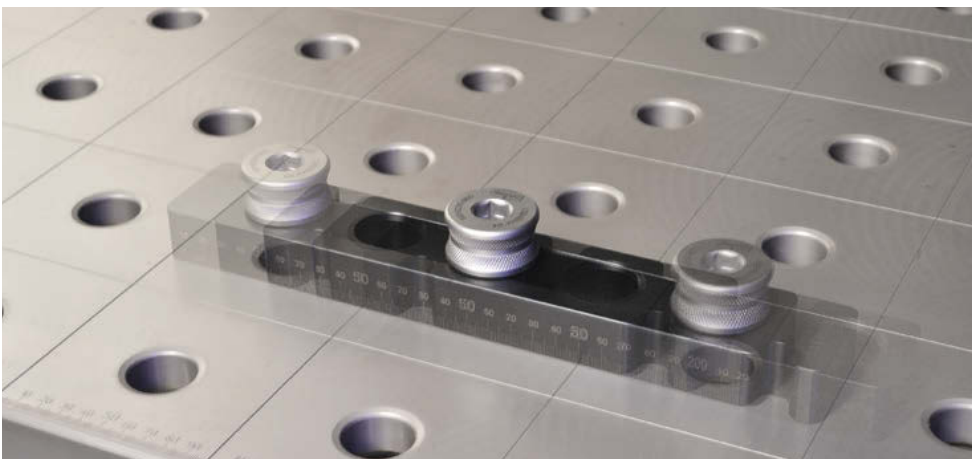
16	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	115	25	12	0.16	E16-05001-000

Universal stop large with precision scaling

- Combination system bore / oblong hole for numerous clamping possibilities
- With precision scaling



Description ▲ Application ▼

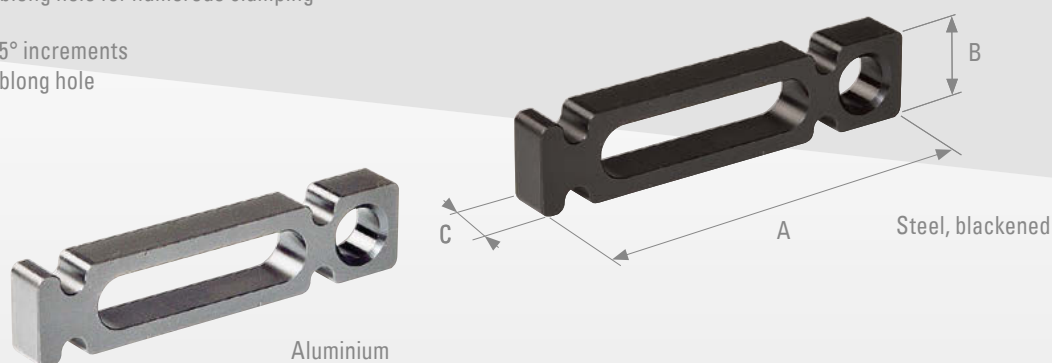


Our idea – the benefits to you ▼

- Fine adjustable with precision scaling possible using grid lines
- 360° adjustable position
- Additional notch for attachment, ideal as corner stop
- Continuous adjustment via oblong hole

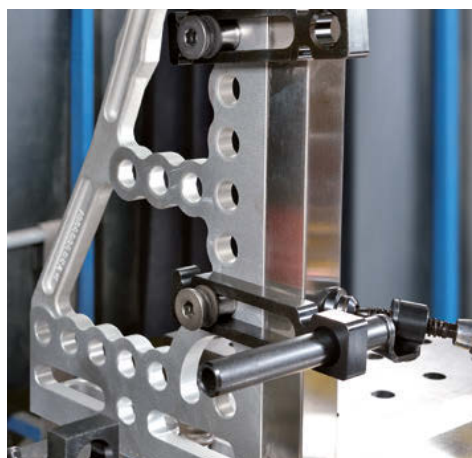
16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	115	25	12	0.14	Steel, blackened	D16-05001-004
	115	25	12	0.05	Aluminium	D16-05001-012

- Combination system bore / oblong hole for numerous clamping possibilities
- 360° adjustable position in 45° increments
- Continuous adjustment via oblong hole
- With precision scaling



Description ▲ Application ▼

Application ▼

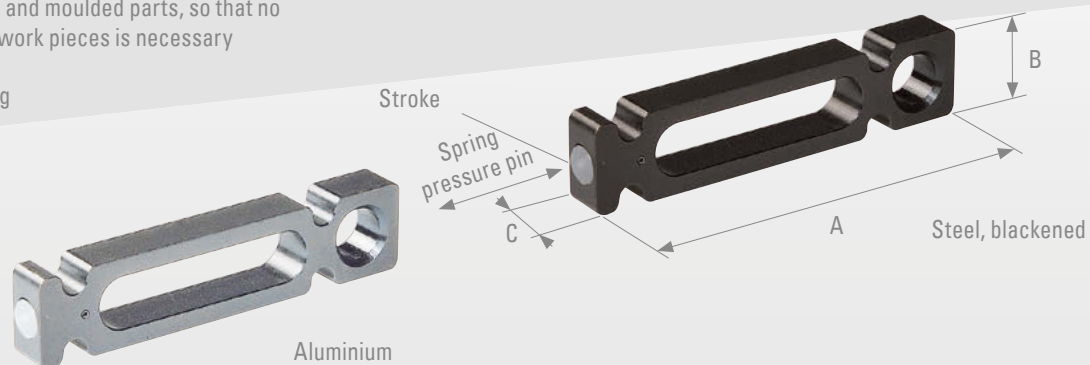


16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	115	25	12	0.14	Steel, blackened	D16-05001-000
	115	25	12	0.05	Aluminium	D16-05001-010

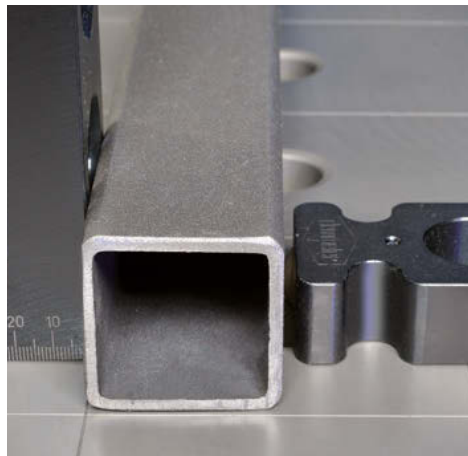
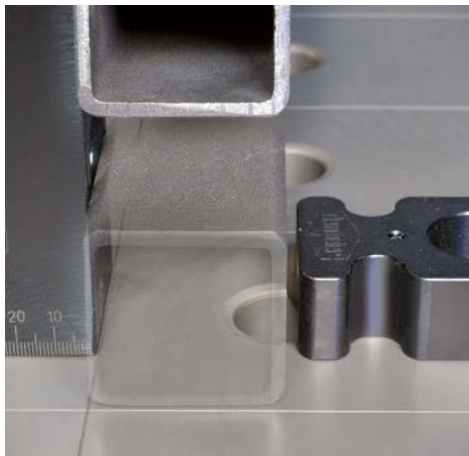
Universal stop large with plunger

Exact fixation of the work pieces

- Like universal stop large
- With additional spring pressure pin especially for clamping sheet metal and moulded parts, so that no additional fixation of work pieces is necessary
- Stroke 2.0 mm
- With precision scaling

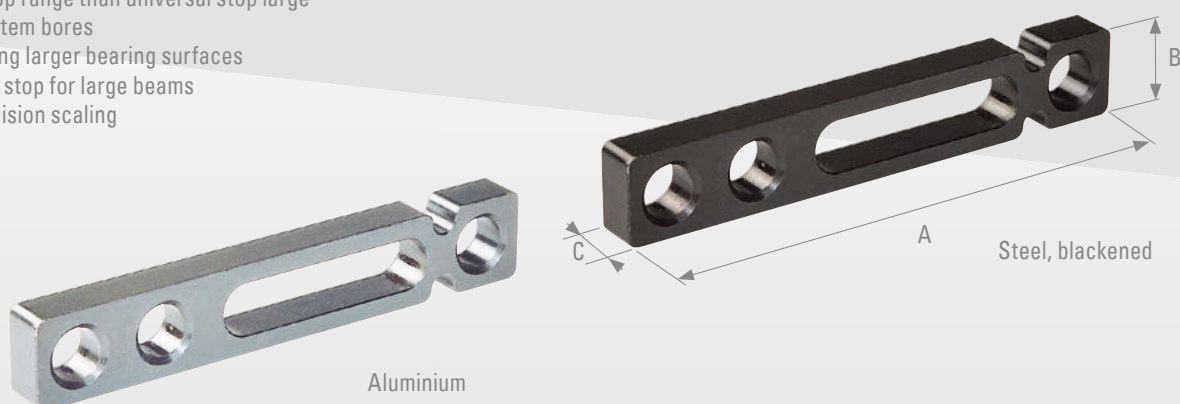


Description ▲ Application ▼

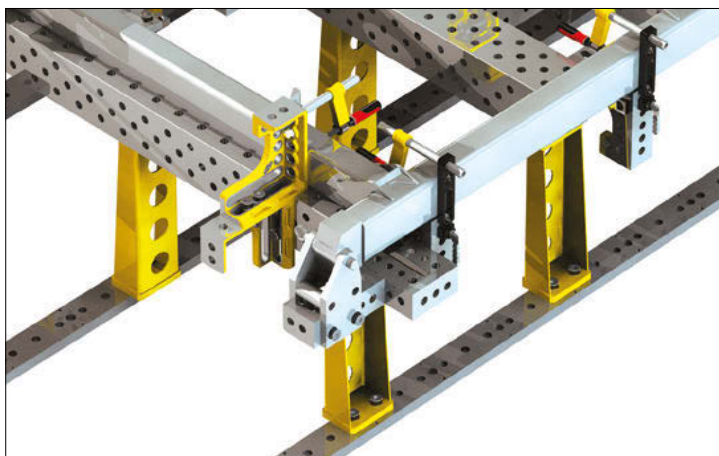


16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	115	25	12	0.14	Steel, blackened	D16-05001-001
	115	25	12	0.05	Aluminium	D16-05001-011

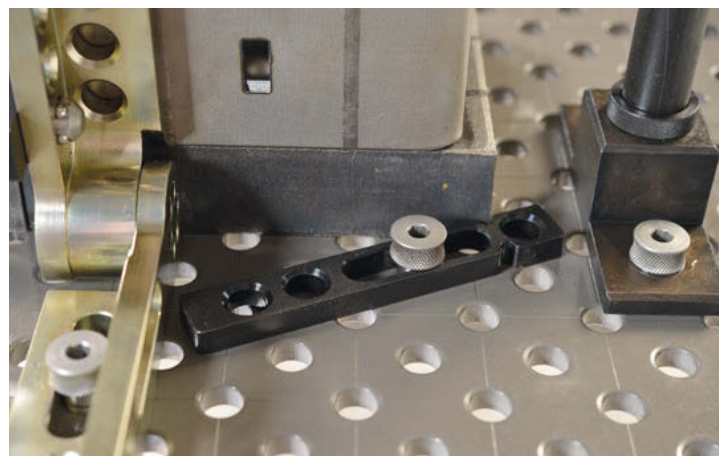
- Larger stop range than universal stop large
- Three system bores
- For bridging larger bearing surfaces
- As lateral stop for large beams
- With precision scaling



Description ▲ Application ▼



For bridging larger distances

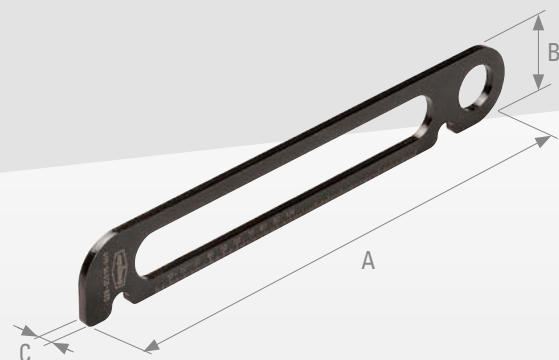


16	A in mm	B in mm	C in mm	~ Weight in kg	Description	Item no.
	165	25	12	0.22	Steel, blackened	D16-05009-000
	165	25	12	0.07	Aluminium	D16-05009-010

Contour stop

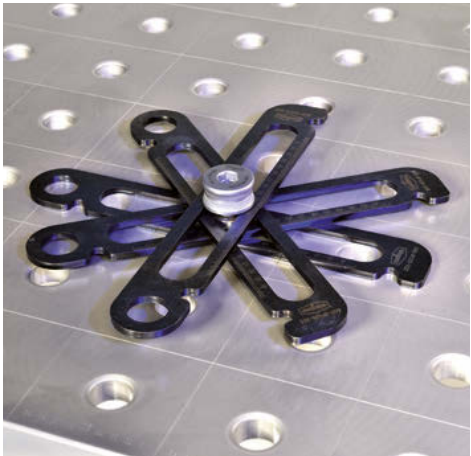
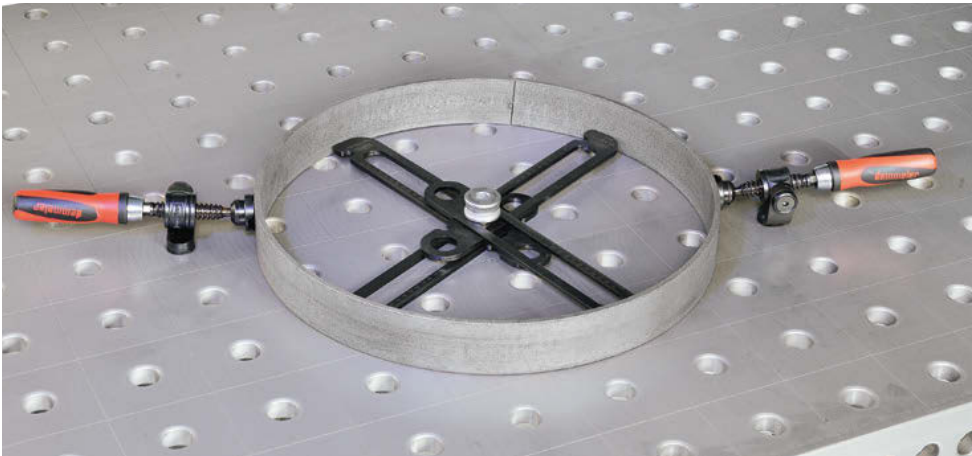
With 1 mm precision scaling

- As support and stop element for light work pieces
- Clamping via PC-bolt and spacer washer of the spacer set
- Cost-effective
- With 1 mm precision scaling



Description ▲ Application ▼

Application ▼

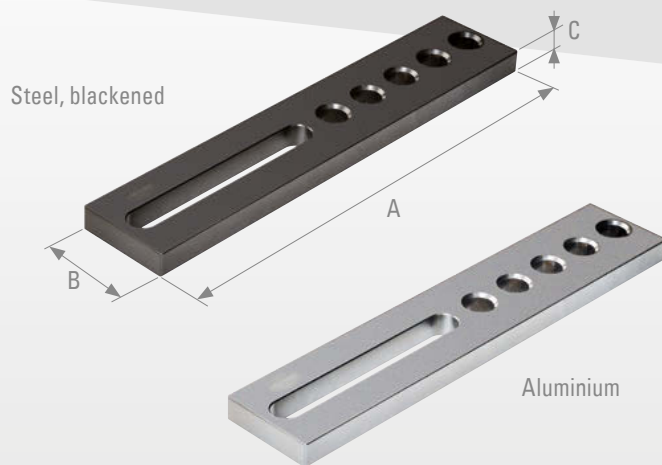


16	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	187.5	25	6	0.1	D16-05016-000

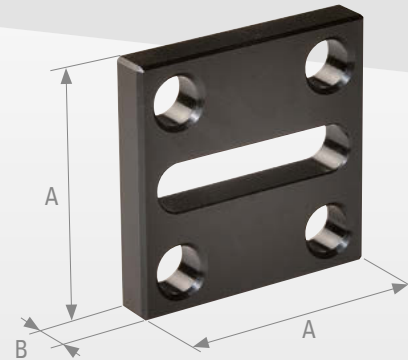
Stop-strip

Adapter plate

- Combination system bore / oblong hole for numerous clamping possibilities
- With precision scaling



- As interface between 3D system and individual components, i.e. for welding / screwing on special customer elements



Description ▲ ▼

- Very long and sturdy version with large bearing surfaces for large components or long distances
- Continuous adjustment via oblong hole
- Combination system bore / oblong hole for numerous clamping possibilities

Description ▲ Application ▼



Adapter plate

16	A in mm	B in mm	~ Weight in kg	Item no.
	75	12	0.36	D16-05010-000

Stop-strip

16	A in mm	B in mm	C in mm	Description	~ Weight in kg	Item no.
	250	50	12	Steel, blackened	0.90	D16-05003-000
	400	50	12	Steel, blackened	1.48	D16-05003-001
	250	50	12	Aluminium	0.3	D16-05003-010
	400	50	12	Aluminium	0.5	D16-05003-011

Angle-setting template

Precision scaling on both sides

- The angle-setting template is flexible in application with the 1° precision scaling on both sides
- Continuous 0°-90°
- Fixed setting out 0-60°(15° increments)
- r = Radius 75 mm



Description ▲ Application ▼



Fixed setting out in 15° increments (0° - 60°) and continuous 0° - 90°

Angle-setting template

16	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	150	87.5	12	0.45	D16-05013-010



Supports

Supports - overview	561
Spacer set D16	563
V-block locations for tube diameter up to 70 mm / D16	564
V-block locations for tube diameter up to 140 mm / D16	565
Reduction plates for clamping tubes	566



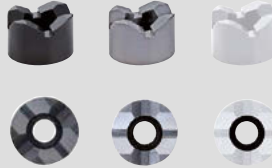
16 Spacer set 10 pieces

PAGE 563



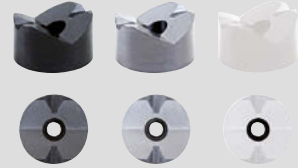
16 V-block locations for tube diameter up to 70 mm

PAGE 564



16 V-block locations for tube diameter up to 140 mm

PAGE 565



16 Reduction plate

PAGE 566





- For 5-50 mm height compensation on the respective support surface
- Smallest increment 1 mm
- Includes 1/10 inch disk (2.54 mm)
- With dimensions of the compensating disks
- Support mandrel fitting each system bore 16
- Self-locking with O-Ring
- On the top of the support mandrel M8 thread for customer-specific elements available on request
- Support prisms consisting of: Individual support mandrel + bearer sleeves L1-L20



Description ▲ Details ▼

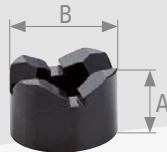
- Exact positioning to your desired height via bearer sleeves of different lengths

16	A in mm	Ø B in mm	~ Weight in kg	Description	Item no.
	55+5	16	0.220	9-piece spacer set	D16-09001-000
	55+5	16	0.100	individual support mandrel	00059333
	1	25	0.004	bearer sleeve L1	00000403
	2	25	0.008	bearer sleeve L2	00000402
	2.5	25	0.010	bearer sleeve L2.5	00003934
	3	25	0.015	bearer sleeve L3	00000401
	4	25	0.010	bearer sleeve L4	00000400
	5	25	0.010	bearer sleeve L5	00000399
	10	25	0.020	bearer sleeve L10	00000398
	20	25	0.040	bearer sleeve L20	00000397

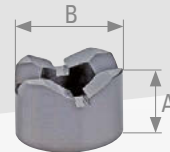
V-block locations for tube diameter up to 70 mm

With double V-block

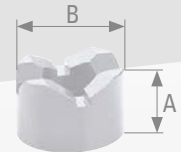
- Screwed in with PC-bolt
- For tube diameter up to 70 mm
- With double V-block for more possibilities
- Also suitable for rectangular tubes



Steel, blackened
D16-09004-000



Stainless steel
D16-09004-002



POM
D16-09004-003

Description ▲

Application ▼

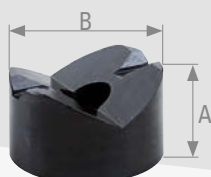


16	A in mm	Ø B in mm	~ Weight in kg	Angle	Description	Item no.
	35	50	0.36	120 / 90°	Steel, blackened	D16-09004-000
	35	50	0.38	120 / 90°	Stainless steel	D16-09004-002
	35	50	0.06	120 / 90°	POM	D16-09004-003

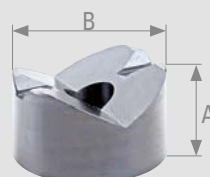
V-block locations for tube diameter up to 140 mm

With double V-block

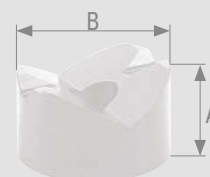
- Screwed in with PC-bolt
- For tube diameter up to 140 mm
- Double V-block for more possibilities
- Also suitable for rectangular tubes



Steel, blackened
D16-09003-000



Stainless steel
D16-09003-002

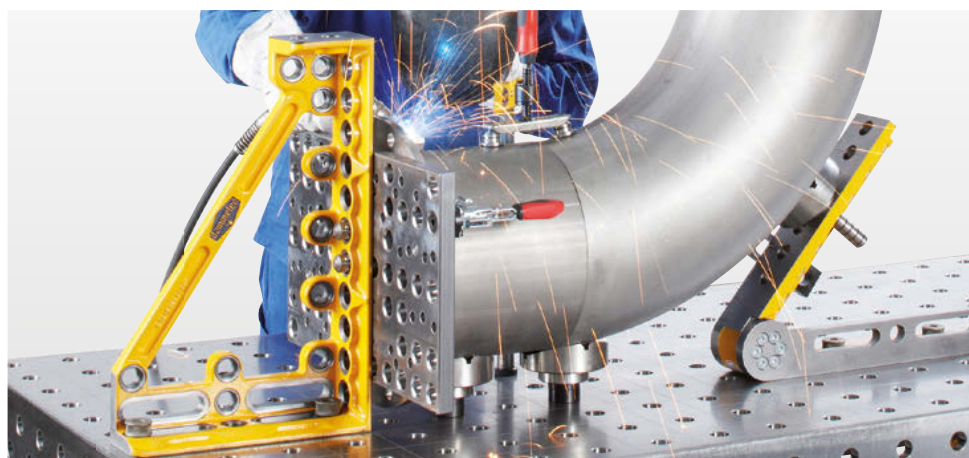


POM
D16-09003-003



Description ▲

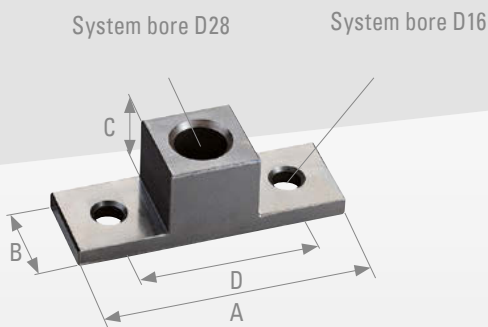
Application ▼



16	A in mm	Ø B in mm	~ Weight in kg	Angle	Description	Item no.
	50	80	1.46	120 / 90°	Steel, blackened	D16-09003-000
	50	80	1.46	120 / 90°	Stainless steel	D16-09003-002
	50	80	0.22	120 / 90°	POM	D16-09003-003

Reduction plate for clamping tubes

- Interface between D28 and D16



Description ▲

Application ▼



Reduction plate for clamping tubes D28 to D16

16	A in mm	W in mm	C in mm	D in mm	~Weight in kg	Item no.
	150	50	50	100	1.04	D00-06015-000



Clamps and quick release skewers

Compensating swing clamp with spindle D16.....	573	Clamping pad with V-block D16.....	585
Compensating swing clamp with quick-action clamping cylinder D16... 574		Plunger and contact piece D16.....	586
Compensating swing clamp with short boring spindle D16.....	575	Clamping pad in ball form D16.....	587
Screw clamp 180° with spindle D16.....	576	Adjusting spindle D16.....	588
Screw clamp 180° with quick-action clamping cylinder D16.....	577	Clamping pad blank D16.....	589
Screw clamp 180° with short boring spindle D16.....	578	VARIO stop ring for round screw clamp tubes D16.....	589
Variable screw clamp 90° D16.....	579	Clamping tube D16.....	590
Variable screw clamp 45° with spindle D16.....	580	Adapter tube D16.....	591
Variable screw clamp 45° with quick-action clamping cylinder D16 ... 581		Adapter for PC-bolts.....	592
Variable screw clamp 45° with short boring spindle D16.....	582	Reduction plate for clamping tubes.....	593
Spindle with bushing and clamping pad.....	583	Toggle clamp with adapter D16.....	594
Short boring spindle with bushing and clamping pad.....	583	Vertical toggle clamp with adaptor and countersunk screw D16.....	595
Quick-action clamping cylinder with clamping pad D16.....	584	Adapter for quick release skewers with countersunk screw D16.....	596

D16 clamping system overview

16 Compensating swing clamp with spindle

PAGE 573



16 Compensating swing clamp with quick-action clamping cylinder

PAGE 574



16 Compensating swing clamp with short boring spindle

PAGE 575



16 Screw clamp 180° with spindle

PAGE 576



16 Screw clamp 180° with quick-action clamping cylinder

PAGE 577



16 Screw clamp 180° with short boring spindle

PAGE 578



16 Variable screw clamp 90°

PAGE 579



16 Variable screw clamp 45° with adjusting screw

PAGE 580



16 Variable screw clamp 45° with quick-action clamping cylinder

PAGE 581



16 Variable screw clamp 45° with short boring spindle

PAGE 582



16 Adjustment screw with bushing and clamping pads

PAGE 583



16 Short boring spindle with bushing and clamping pads

PAGE 583



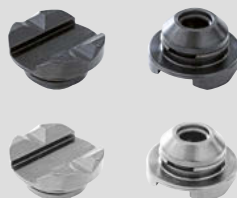
16 Quick-action clamping cylinder with clamping pads

PAGE 584



16 Plunger and contact piece / clamping pad with V-block

PAGE 585



16 Plunger and contact piece

PAGE 586



16 Clamping pad in ball form

PAGE 587



16 Adjusting spindle

PAGE 588



16 Clamping pad blank

PAGE 589



16 VARIO stop ring for round screw clamp tubes

PAGE 589



16 Clamping tube / adapter tube

PAGE 590 /
PAGE 591



16 Adapter for PC-bolts / reduction plate for clamping tubes

PAGE 592



16 Toggle clamp with adapter

PAGE 594



16 Vertical toggle clamp with adaptor and countersunk screw

PAGE 595



16 Adapter for quick release skewers with countersunk screw

PAGE 596



Flexible down to the details

Thanks to the modular system, the clamps adapt perfectly to the respective clamping situation. Select from various materials for the clamping pad and different spindle lengths, also for small installation spaces. The latch lever makes quick and precise clamping possible even with one hand. With three different tube lengths and exchangeable arms, you can handle any clamping task.

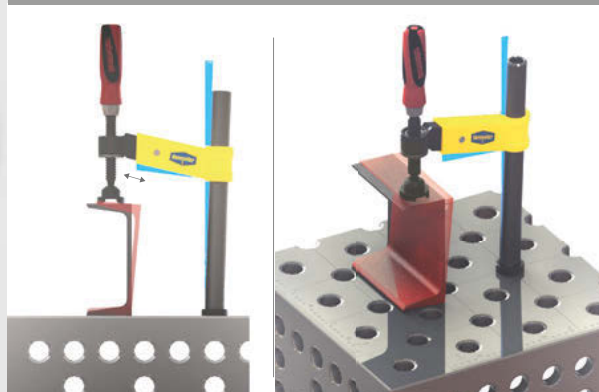


Vertically insertable tubes

Exchangeable

Difference equalisation

Difference equalisation prevents tipping of the work piece





- **Ultimate stability:**
Enables the even build-up of clamping force with large power reserves. The self-centring support and pressure piece clamps the work piece and can be exchanged.
- **The powder-coated clamping lever** features a highly ergonomic shape and swivels 360° degrees to circumvent all interfering edges.
- Large stroke: 3.5 mm

Exchangeable

Exchangeable

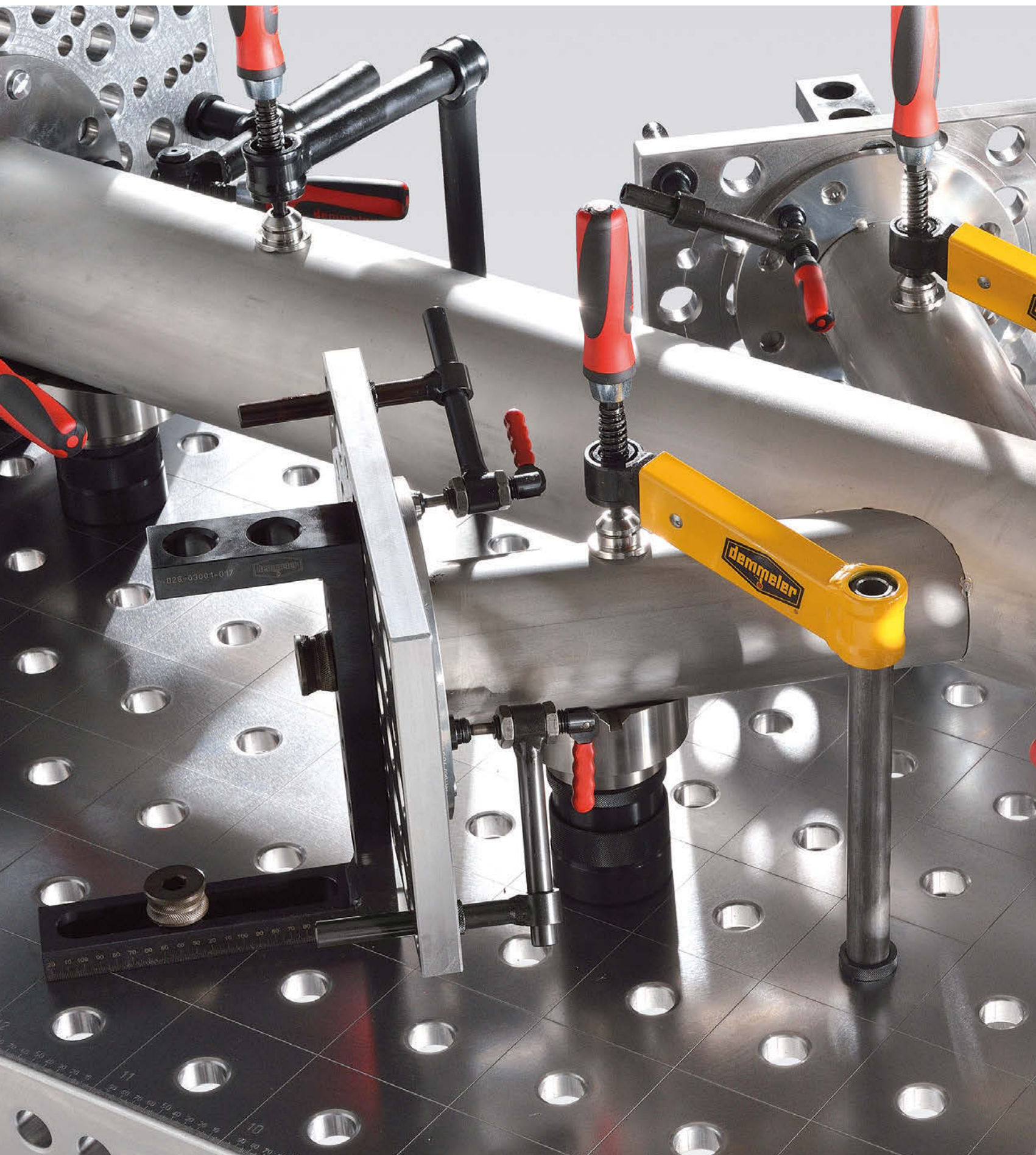
Horizontally insertable tubes

Insertable clamping pad

Vertically insertable tubes



Clamps



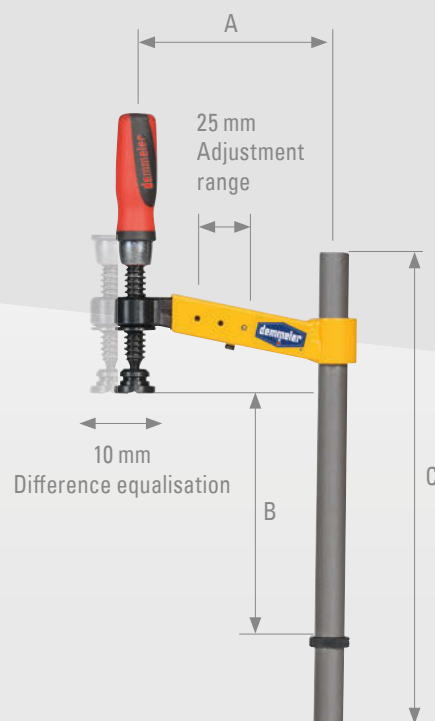
Compensating swing clamp with spindle

Top seller

For profiles that tend to tip

Exchangeable spindle

- For fast, powerful and accurately positioned clamping of many different work pieces
- With difference equalisation for accurately oriented and positioned work piece clamping
- With stop ring for height fixation
- Exchangeable actuator (e.g. spindle, short boring spindle or quick-action clamping cylinder)
- Clamping pad can be exchanged for clamping other materials such as stainless steel
- New standard clamping pad – added value for your screw clamps
- Exchangeable clamping tubes, available in different lengths



Description ▲

Application ▼

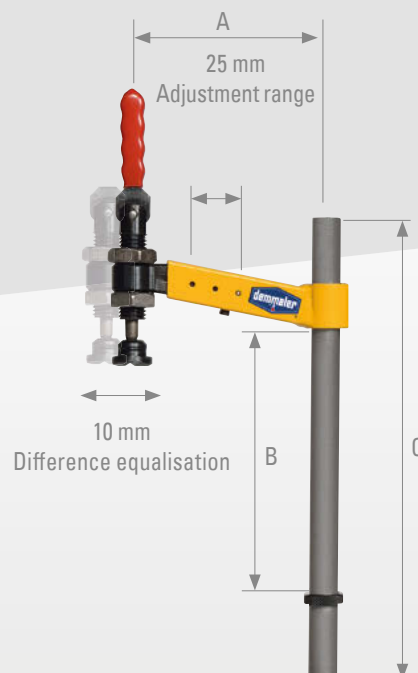


16	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	100-125	max. 200	250	0.66	D16-07001-000

Compensating swing clamp with quick-action clamping cylinder

- Up to 5x faster clamping than conventional screw clamps
- Higher clamping forces quickly with little expenditure of energy
- 360° swivelling lever bypasses interfering edges
- Large 3.5 mm stroke

Quick-action clamping cylinder, exchangeable



Description ▲

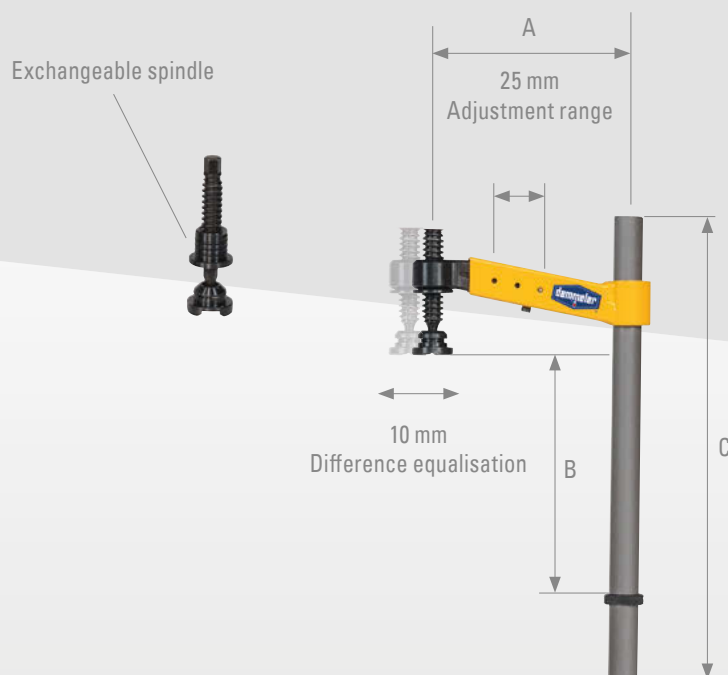
Application ▼



16	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	100-125	max. 200	250	0.68	D16-07001-001

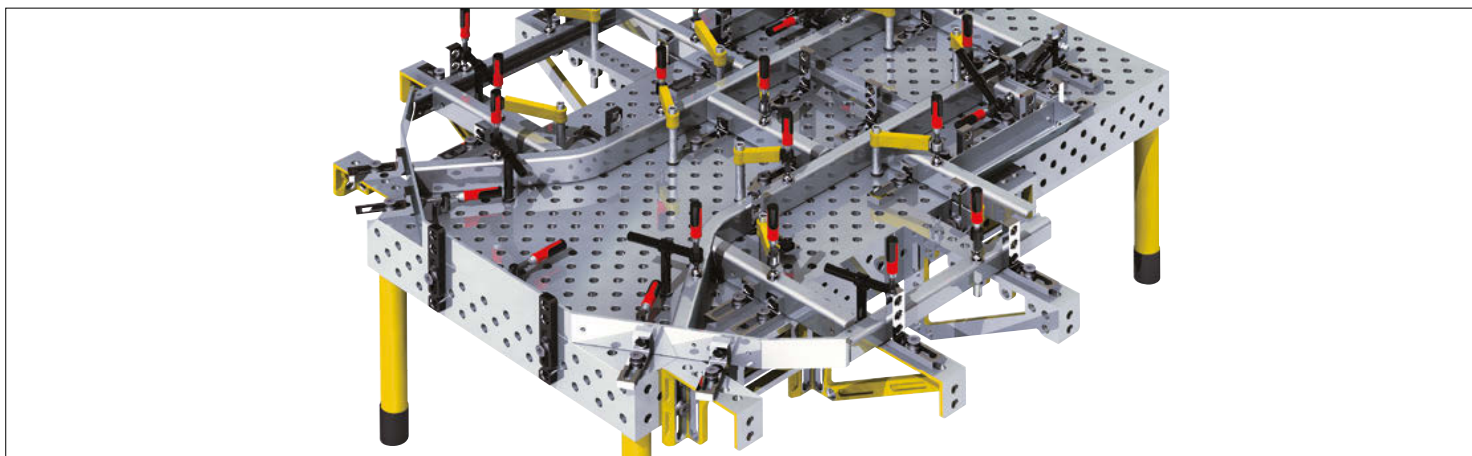
Compensating swing clamp with short boring spindle

- Operation with open-end wrench AF 14
- Highly recommended for confined spaces



Description ▲

Application ▼



16	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	100-125	max. 200	250	0.6	D16-07001-002

Screw clamp 180° with spindle

With adjustable, sturdy round tube

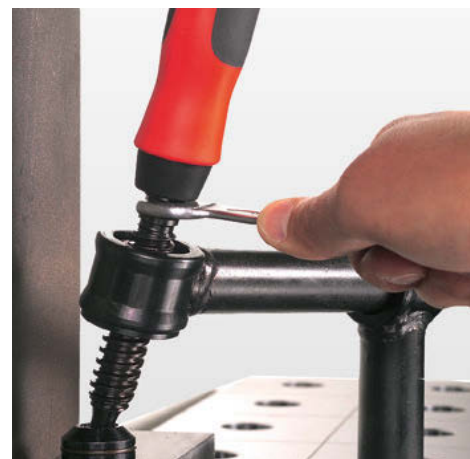
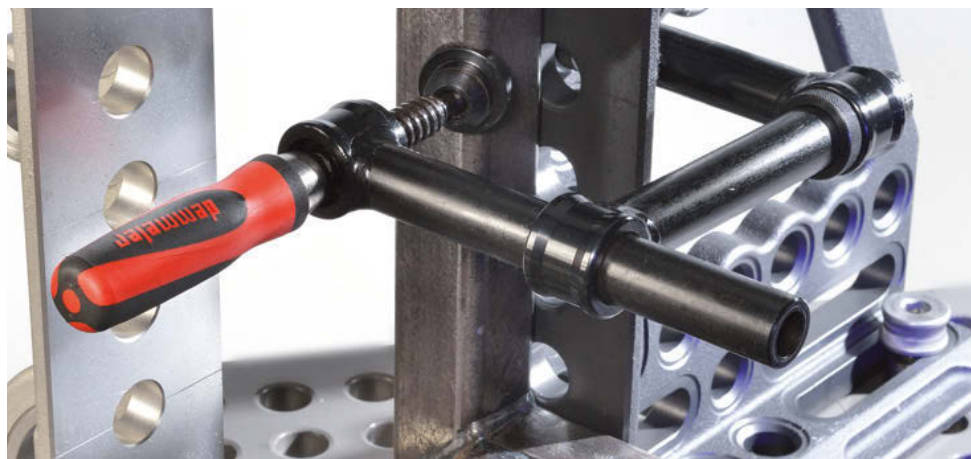
Top seller

Exchangeable spindle

- Each tube can be used individually
- Adjustable projection
- Can be inserted through system bores, eliminating avoidable interfering edges
- Highest force transmission with sturdy round tubes
- Entire clamping mechanism is exchangeable



Description ▲ Application ▼



16	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	130	max. 90	130	0.52	D16-07005-000

Screw clamp 180° with quick-action clamping cylinder

With adjustable, sturdy round tube

- Up to 5x faster clamping than with conventional screw clamps
- Higher clamping forces quickly with little expenditure of energy
- 360° swivelling lever bypasses interfering edges
- Highest force transmission with sturdy round tubes
- Entire clamping mechanism is exchangeable
- Large 3.5 mm stroke

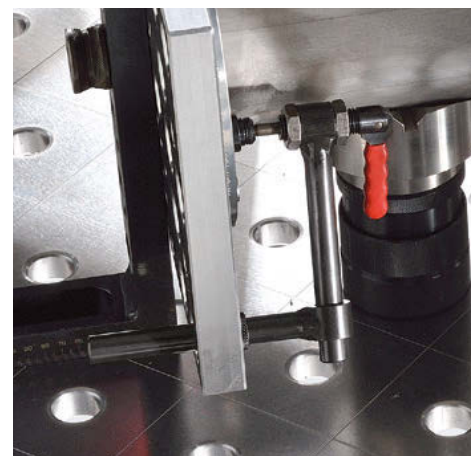
Quick release skewer, exchangeable



Description ▲ Benefits of the clamping cylinder ▼

Application ▼

- Ultimate stability:
Enables the even build-up of clamping force with large power reserves. The self-centring support and pressure piece clamps the work piece and can be exchanged.
- The coated clamping lever features a highly ergonomic shape and swivels 360° degrees to circumvent all interfering edges.
- Large stroke: 3.5 mm

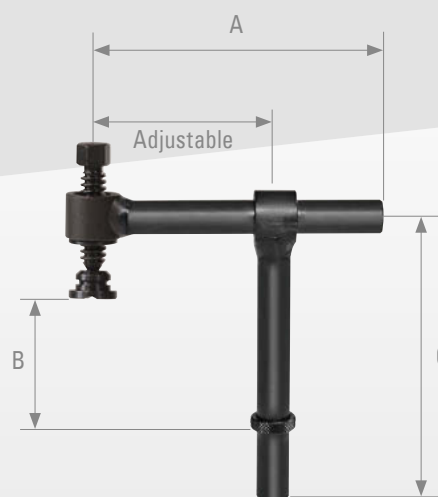


16	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	130	max. 90	130	0.58	D16-07005-001

Screw clamp 180° with short boring spindle

- Highest force transmission with sturdy round tubes
- Operation with open-end wrench AF 14
- Highly recommended for confined spaces
- Each tube can be used individually
- Entire clamping mechanism is exchangeable

Exchangeable spindle



Description ▲ Application ▼

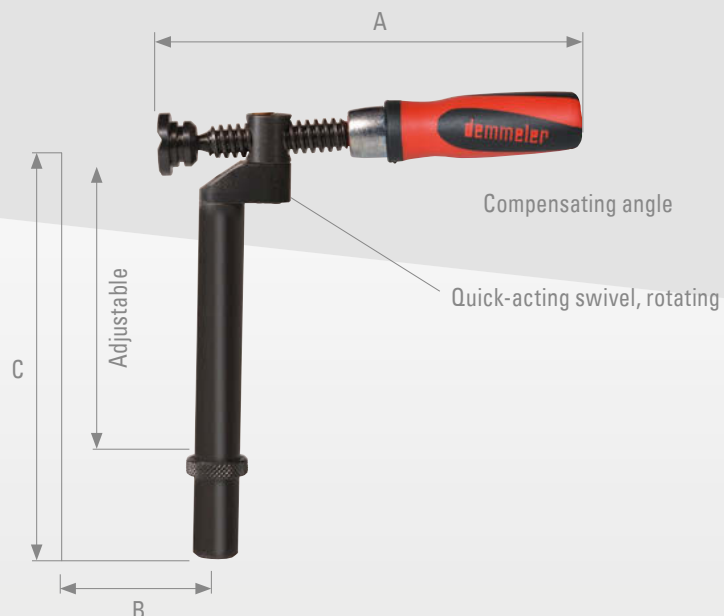


16	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	130	max. 90	130	0.50	D16-07005-002

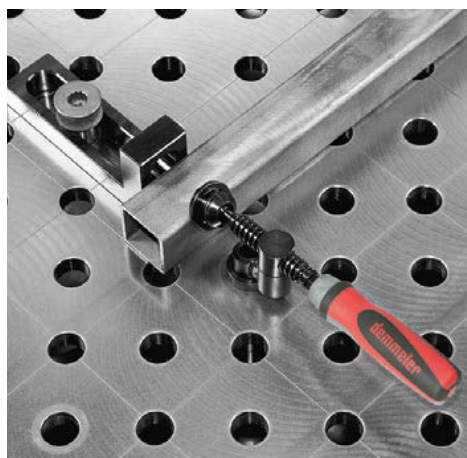
Variable screw clamp 90°

Top seller

- Pressure direction 90° to the system bore
- Spindle stroke ~ 30 mm
- 180° quick-acting swivel with ball stop in the joint
- With stop ring for height fixation
- Use of clamping bridges possible
- Highest force transmission with sturdy round tube
- Clamping pad exchangeable



Description ▲ Application ▼



16	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	150	max. 40	150	0.30	D16-07008-000

Variable screw clamp 45° with spindle

Exchangeable spindle

- Highest force transmission with sturdy round tubes
- Ideal for clamping prismatic profiles as well as rectangular and square profiles
- Entire clamping mechanism is exchangeable



Description ▲

Application ▼



Perfect positioning on all locating surfaces thanks to optimum action of force!

16	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	130	max. 90	130	0.50	D16-07009-000

Variable screw clamp 45° with quick-action clamping cylinder

With adjustable, sturdy, rotating round tube

Quick release skewer, exchangeable

- Up to 5x faster clamping than with conventional screw clamps
- Higher clamping forces quickly with little expenditure of energy
- 360° swivelling lever bypasses interfering edges
- Highest force transmission with sturdy round tubes
- Entire clamping mechanism is exchangeable
- Large 3.5 mm stroke



Description ▲

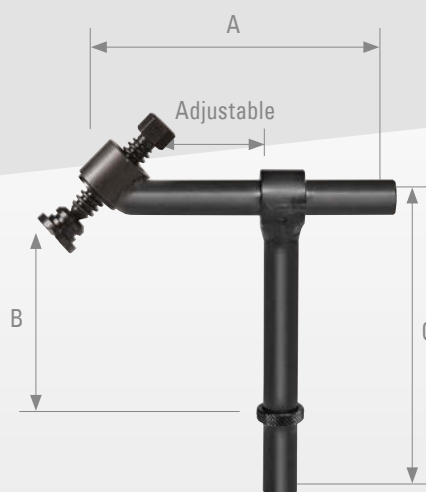
16	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	130	90	130	0.58	D16-07009-001

Variable screw clamp 45° with short boring spindle

With adjustable, sturdy, rotating round tube

- Highest force transmission with sturdy round tubes
- Operation with open-end wrench AF 14
- Highly recommended for confined spaces
- Entire clamping mechanism is exchangeable

Exchangeable spindle



Description ▲ Application ▼

Application ▼



16	A in mm	B clamping width in mm	C in mm	~ Weight in kg	Item no.
	130	90	130	0.46	D16-07009-002

Spindle with bushing and clamping pad

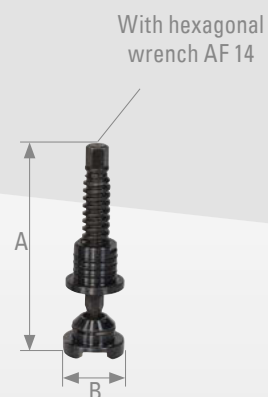
- High-quality 2-component plastic handle
- Long threaded spindle
- Threaded bushing works with any system bore
- Exchangeable clamping pad (plastic, stainless steel - see page 585 ff)
- Suitable to pretension work pieces



Clamping pad with cross prism

Short boring spindle with bushing and clamping pads

- Highly recommended for confined spaces
- Operation with open-end wrench AF 14
- Direct use in system bores possible
- Ideal to pretension work pieces



Clamping pad with cross prism

Description ▲ Application ▼



Description ▲ Application ▼



16	A in mm	Ø B in mm	C in mm	~ Weight in kg	Item no.
	~ 148	22	45	0.14	D16-07020-000

16	A in mm	Ø B in mm	~ Weight in kg	Item no.
	70	22	0.1	D16-07022-000

Quick-action clamping cylinder with clamping pad

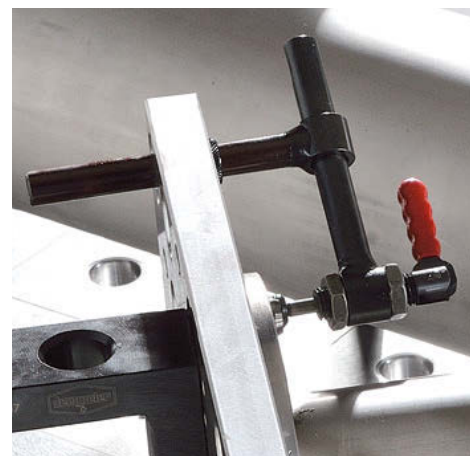
- Up to 5x faster clamping than conventional screw clamps
- Higher clamping forces quickly with little expenditure of energy
- Large 3.5 mm stroke
- The self-centring support and pressure piece clamps the work piece and can be exchanged



Clamping pad with V-block

Description ▲

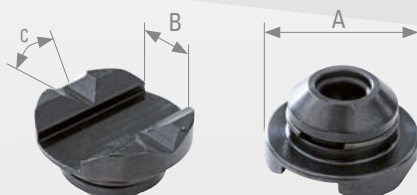
Application ▼



16	A in mm	Ø B in mm	C in mm	~ Weight in kg	Item no.
	~ 80+3	22	30	0.18	D16-07021-000

Plunger and contact piece / clamping pad with V-block

- Clamping pad with V-block



Description ▲ Application ▼

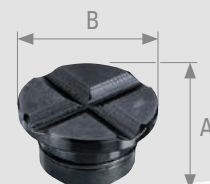
Flat or upright positioning	Self-centring clamping on the work piece	Also as contact piece in the system bore
Clamping larger diameters without problems	No slipping and tipping possible	... no matter where the force is applied! No slipping

16	A in mm	B in mm	C in °	Description	Quantity	Item no.
	22	8	120	Steel, blackened	1 units	D16-07011-015
	22	8	120	Steel, blackened	10 units	D16-07011-016

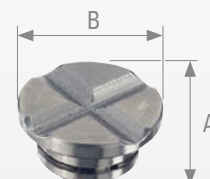
Plunger and contact piece

- Lightning-fast replacement: no tools, no screws
- O-ring prevents dirt from getting into the joint
- Produced in various materials
- Exact work piece support thanks to pendulum compensation
- With cross prism for clamping round / rectangular tubes
- Can also be used as a support in any system bore

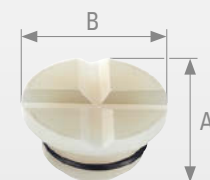
Steel, blackened



Stainless steel



POM



Description ▲

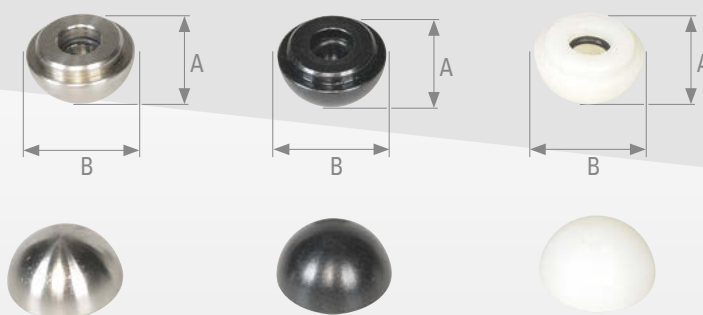
Application ▼



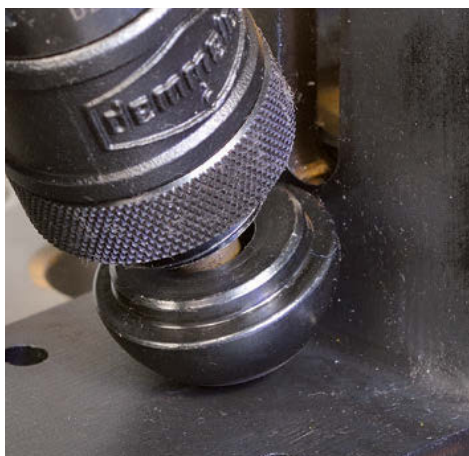
16	A in mm	Ø B in mm	~ Weight in kg	Description	Item no.
	13	22	0.019	Steel, blackened	D16-07011-000
	13	22	0.019	Stainless steel	D16-07011-001
	13	22	0.004	POM	D16-07011-002

Clamping pad in ball form

- Lightning-fast replacement: no tools, no screws
- O-ring prevents dirt from getting into the joint
- Produced in various materials
- With ball, specially for clamping corner profiles
- Clamping pad compensates angle errors
- Exact work piece support thanks to pendulum compensation



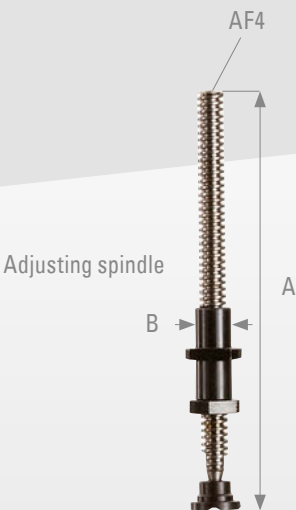
Description ▲ Application ▼



16	A in mm	Ø B in mm	~ Weight in kg	Description	Item no.
	14	20	0.018	Steel, blackened	D16-07011-005
	14	20	0.018	Stainless steel	D16-07011-006
	14	20	0.004	POM	D16-07011-007
	14	20	0.007	Aluminium	D16-07011-012

Adjusting spindle

- For adjusting a continuous support
- Clamping in hard to reach positions



Description ▲ Application ▼



16	A in mm	B in mm	~ Weight in kg	Item no.
	180	16	0.18	D16-09008-000

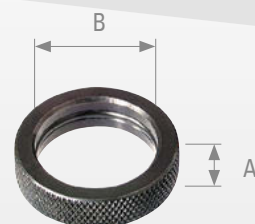
Clamping pad blank

VARIO stop ring for round screw clamp tubes

- For customer-specific adaptation
- Locations for Demmeler system screw clamps already included
- Steel, blackened



- For height fixation of screw clamps
- Included in the scope of delivery for all round tube screw clamps



Description ▲

Description ▲ Application ▼

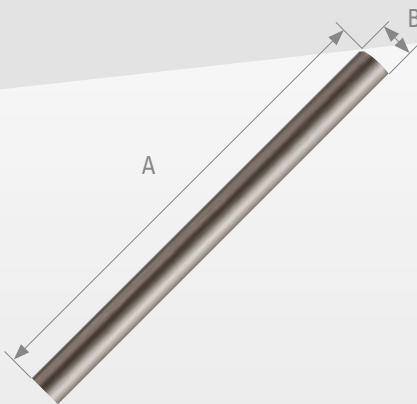


16	A in mm	Ø B in mm	~ Weight in kg	Description	Item no.
	25	22	0.05	Steel, blackened	D16-07014-000

16	A in mm	Ø B in mm	~ Weight in kg	Item no.
	6	16	0.006	D16-07003-000

Clamping tube

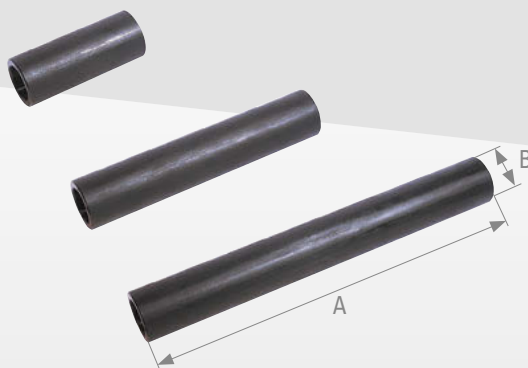
- Precision clamping tube to fit all system bores
- e.g. for compensating swing clamps (starting on page 573)



Description ▲

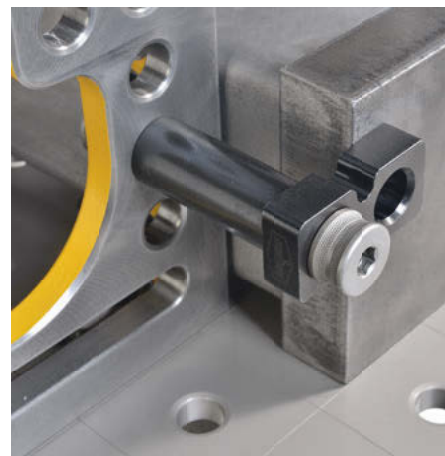
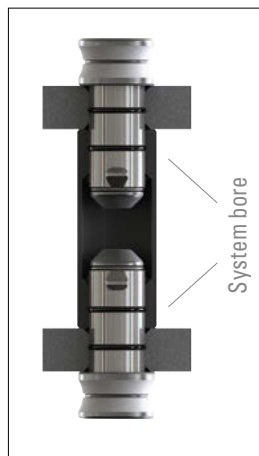
16	A in mm	Ø B in mm	~ Weight in kg	Item no.
	125	16	0.15	D16-07004-000
	250	16	0.30	D16-07004-001
	600	16	0.72	D16-07004-002
	1000	16	1.20	D16-07004-003

- Extension of support and clamping points
- Adaptable with screw clamp tube
- Clamping on both sides possible with PC-bolt



Description ▲

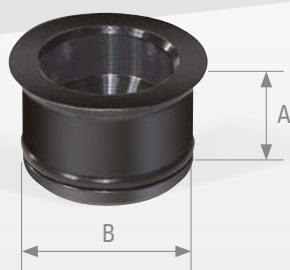
Adapter-tube 200 mm with screw clamp ▼



16	A in mm	Ø B in mm	~ Weight in kg	Item no.
	100	16 / 28	0.34	D16-09010-000
	200	16 / 28	0.76	D16-09010-001
	300	16 / 28	1.18	D16-09010-002

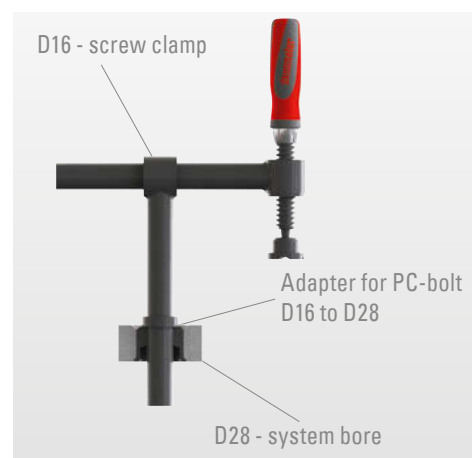
Adapter for PC-bolt D16 to D28

- Interface between system D28 and D16
- Fully compatible with system D28 and D16
- Force-fit and form-fitting with O-ring, self-centring connection
- O-ring prevents simultaneous rotation while tightening
- O-ring cleans the system bore



Description ▲

Application ▼

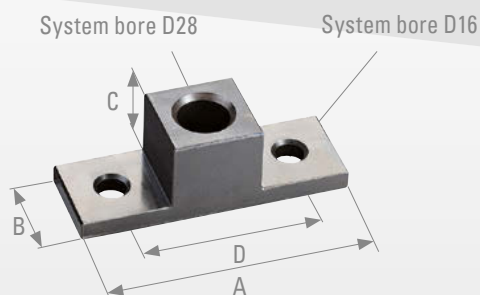


Adapter for PC-bolt D16 to D28

Ø A in mm	B in mm	~ Weight in kg	Item no.
20.5	28-0.02	0.05	D00-06010-002

Reduction plate for clamping tubes D28 to D16

- Interface between system 28 and system 16



Description ▲

Application ▼

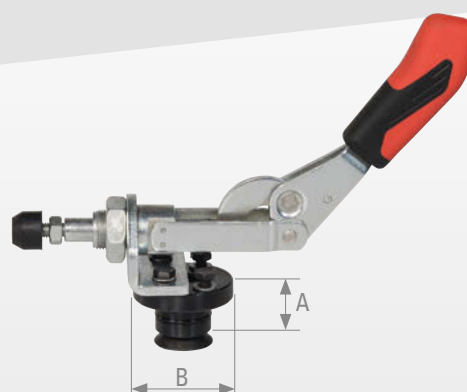


Reduction plate for clamping tubes D28 to D16

A in mm	B in mm	C in mm	D in mm	~ Weight in kg	Item no.
150	50	50	100	1.04	D00-06015-000

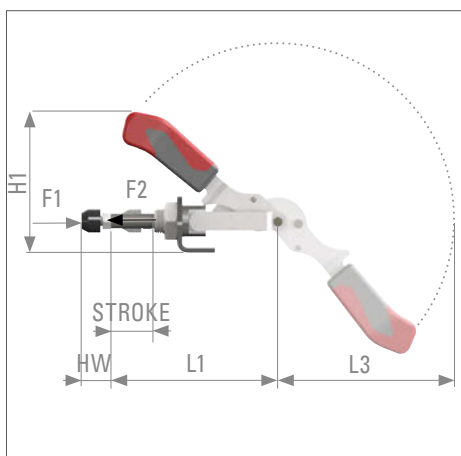
Toggle clamp with adapter

- Long toggle clamp guide with mounting thread and nut
- Ergonomic, oil-resistant handle with large grip and soft component
- With tempered, galvanised clamping screw
- 20 mm stroke
- With adapter and countersunk screw to fit any system bore
- Toggle clamp galvanised and passivated, adapter blackened
- With universal stop for indirect locations, therefore continuously adjustable



Description ▲ Toggle clamp ▼

Application ▼



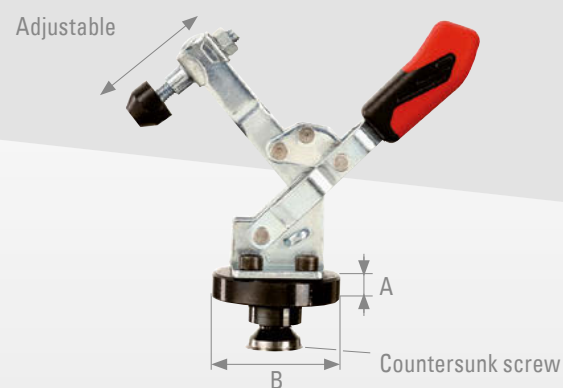
16	A in mm	B Ø in mm	Description	~ Weight in kg	Item no.
	15	38	Thread spacing = 24x16 mm	0.22	D16-08002-000

Toggle clamp data

16	H1	L1	L3	HW	STROKE	F1 in kN	F2 in kN
	60	91	72	12 - 20	20	1	1

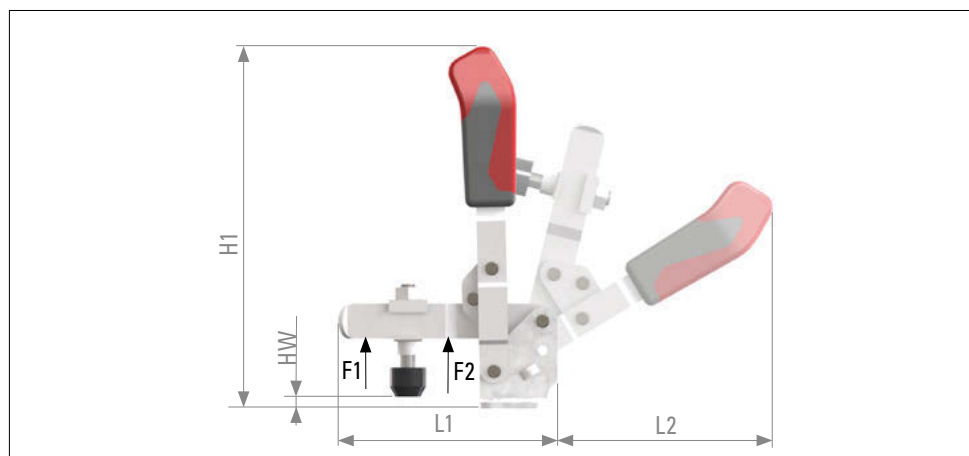
Vertical toggle clamp with adaptor and countersunk screw

- With open support arm and horizontal leg
- Ergonomic, oil-resistant handle with large grip and soft component
- Safety clamping piece with finger protection
- Captive clamping screw at clamping arm end
- With adapter and countersunk screw to fit any system bore
- Clamping range 0-25 mm
- Toggle clamp galvanised and passivated, adapter blackened
- With universal stop for indirect locations, therefore continuously adjustable



Description ▲ Vertical toggle clamp ▼

Application ▼



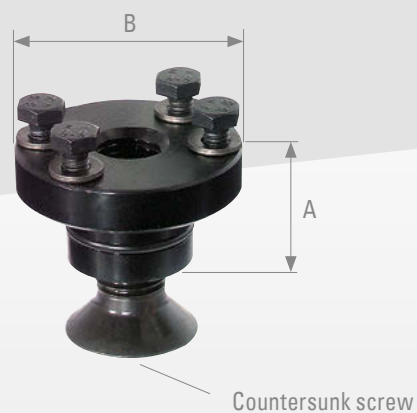
Data - vertical toggle clamp

16	A in mm	B Ø in mm	Description	~ Weight in kg	Item no.
	15	38	Thread spacing 24x16 mm	0.22	D16-08001-000

16	H1	L1	L2	HW	F1 in kN	F2 in kN
	98.5	61	59	-4 - 2	0.6	1.1

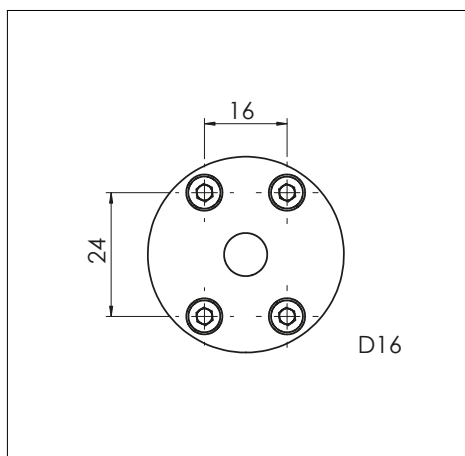
Adapter for quick release skewers with countersunk screw

- Adapter to fit conventional quick release skewers
- Scope of delivery: 1 x adapter 4 x cap screw M4 x 10
1 x countersunk screw M10 x 20



Description ▲ Application ▼

Adapter for quick release skewers with countersunk screw ▼



16	A in mm	B Ø in mm	~ Weight in kg	Description	Item no.
	15	38	0.08	Thread spacing 24 x 16 mm	D16-08005-000



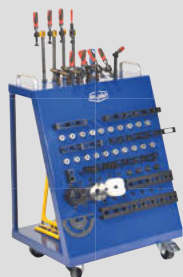
Table accessories

Accessory cart D16.....	600
Tool trolley system 16	601
Transport ring D16.....	602
Torque wrench D16	603
Allen key D16.....	603
Round brush D16 mm	604
Protective plate for PROFIPlusLINE (PL) worktable D16.....	605
Protective plate for PROFIEcoLINE (PE) worktable D16.....	606
Ground connector	608
Bench stone	609
Tarpaulin.....	609
Pump bottle with worktable system protective spray	610
Worktable system protective spray in a canister	610

Table accessories overview

16 Accessory cart

PAGE 600



16 Tool trolley

PAGE 601



16 Transport ring

PAGE 602



16 Torque wrench

PAGE 603



16 Allen key

PAGE 603



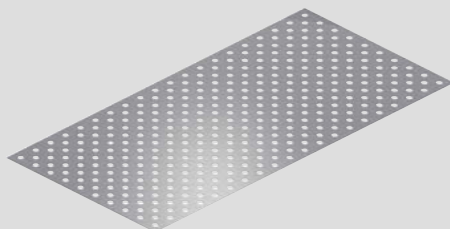
16 Round brush

PAGE 604



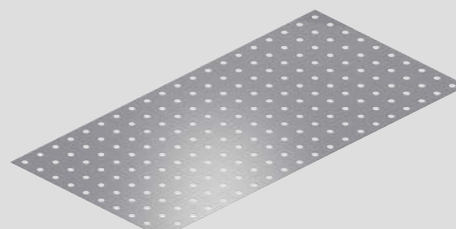
16 Protective plate for worktable PL

PAGE 605



16 Protective plate for worktable PE

PAGE 606



Ground connector

PAGE 608



Bench stone

PAGE 609



Worktable tarpaulin

PAGE 609



Pump bottle with protective spray

PAGE 610



Protective spray in a canister

PAGE 610



Accessory cart D16

- Tidy arrangement of your system components
- Safe and practical storage of large angles
- Fast to move with 4 sturdy swivelling casters
- Low centre of gravity through ideal positioning of the clamping tools



Description ▲ Application ▼

Application ▼

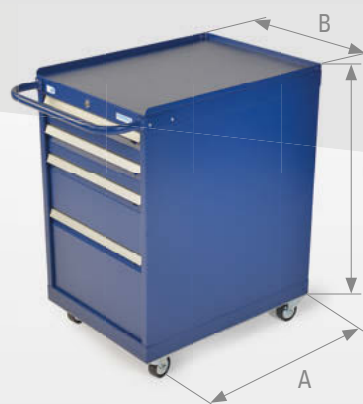


System components not included

16	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	~ 600	~ 450	~ 870	35	D16-11001-002

Tool trolley D16

- Establishes a tidy and orderly workstation
- Faster access to the system components
- Protects against dirt with four closed locking
- Drawers, mobile on four casters, two of them swivelling and locking



Description ▲ Application ▼

Application ▼



System components not included

16	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	740	560	970	-	D16-11001-000

Transport ring D16

- For fast and safe transport of all system components (e.g. welding table)
- Fixing using 2 PC-bolts (D16-06001-000)



Description ▲	Note ▼
---------------	--------

Max. transport weight in [t] with different attachment methods			
Transport ring			
Tilt angle	0°	0°	0° - 45°
Number of transport rings	1	2	2
D16 system	0.7 t	1.4 t	1.0 t

- Transport ring D00-10001-000 must always be attached with at least 2 x PC-bolts.
- Max. tightening torque D16: 20 Nm (Bolts are not included in the scope of delivery of the transport ring).
- Countersunk head bolts may not be used!
- Transport ring may only be used for DEMMELER 3D systems!
- Internal operating instructions must be observed!
- Only undamaged transport ring and PC-bolts may be used!
- The transport ring must be fixed centrally on the worktop.
If two transport rings are used, these must be fixed symmetrically in the middle of the worktop. The maximum diagonal pulling angle must not exceed 45° (see warning notes).

- The general regulations for means of transport have to be observed when using the transport ring!
- Depending on the application, the load capacity may be significantly reduced.
- Loads may only be applied to the transport ring in the ring plane! Do not exceed the load capacity!
- Do not allow personnel to stand underneath suspended loads.
- Observe the warning notes on the transport ring!

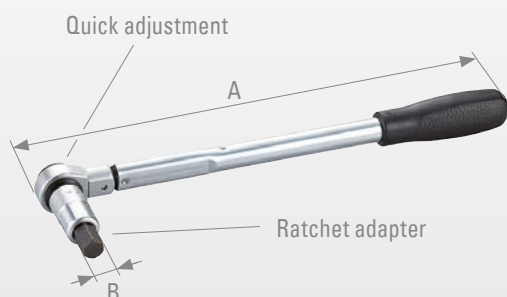
16	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	200	120	84	2.8	D16-10001-001

Torque wrench

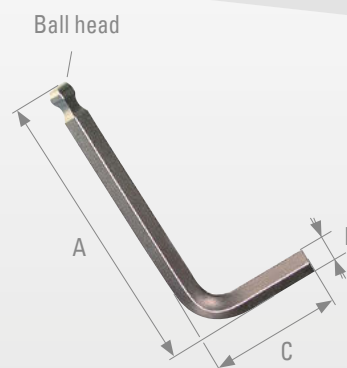
Allen key

Clamping and releasing made easy

- Pre-set to 20 Nm for controlled tightening of PC-bolts, avoiding damage to the system bore and bolt by over-tightening
- Includes 1 x ratchet adapter, adjustable (left/right) and 3/8" and 2 x sockets AF4 and AF 8



- For PC-bolt and compensating clamp arm with hexagonal
- Good accessibility due to additional ball head



Description ▲ Application ▼



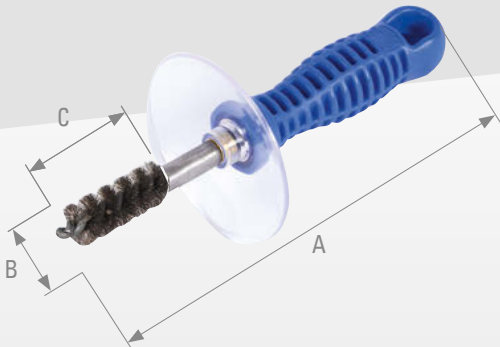
16	A in mm	B in mm	~ Weight in kg	Item no.
	212	AF 4 / AF 8	0.52	D16-10015-000

Description ▲

16	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	~ 71	AF 4	~ 25	0.01	D16-10008-002
	~ 94	AF 6	~ 38	0.02	D16-10008-001
	~ 104	AF 8	~ 42	0.06	D16-10008-000
	~ 75	AF 5	~ 35	0.02	E16-10008-000

Round brush

- For cleaning the system bores
- With splash guard



Description ▲ Application ▼

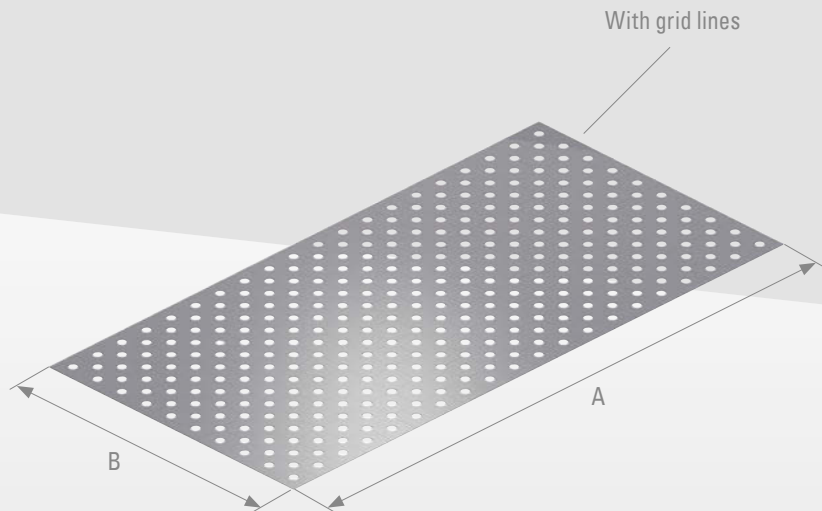


16	A in mm	B in mm	C in mm	~ Weight in kg	Item no.
	200	16	45	0.10	D16-10002-000

Protective plate for worktable

Especially for PROFILusLINE (PL) tables

- The protective plate are especially well suited for stainless steel welding
- With diagonal grid 50×50 mm
- Incl. grid lines
- $t=2$



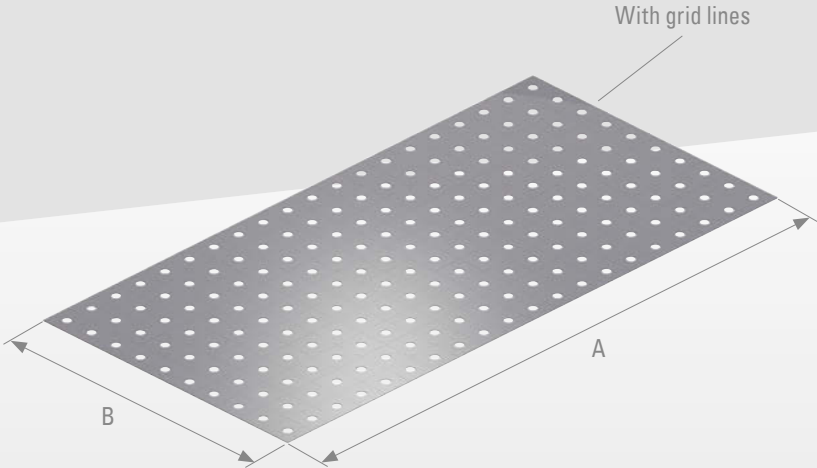
Description ▲

16	A in mm	B in mm	Description	Item no.
	1000	1000	Stainless steel	PL16-50030-000
	1000	1000	Aluminium	PL16-50030-001
	1200	800	Stainless steel	PL16-50030-012
	1200	800	Aluminium	PL16-50030-013
	1200	1200	Stainless steel	PL16-50030-002
	1200	1200	Aluminium	PL16-50030-003
	1500	1000	Stainless steel	PL16-50030-004
	1500	1000	Aluminium	PL16-50030-005
	1500	1500	Stainless steel	PL16-50030-006
	1500	1500	Aluminium	PL16-50030-007
	2000	1000	Stainless steel	PL16-50030-008
	2000	1000	Aluminium	PL16-50030-009
	2400	1200	Stainless steel	PL16-50030-010
	2400	1200	Aluminium	PL16-50030-011

Protective plate for worktable

Especially for PROFIEcoLINE tables (PE)

- The protective plate are especially well suited for stainless steel welding
- With 50 x 50 mm grid
- Incl. grid lines
- t=2



Description ▲

16	A in mm	B in mm	Description	Item no.
	1000	1000	Stainless steel	D16-50030-000
	1000	1000	Aluminium	D16-50030-008
	1200	800	Stainless steel	D16-50030-017
	1200	800	Aluminium	D16-50030-018
	1200	1200	Stainless steel	D16-50030-009
	1200	1200	Aluminium	D16-50030-004
	1500	1000	Stainless steel	D16-50030-010
	1500	1000	Aluminium	D16-50030-011
	1500	1500	Stainless steel	D16-50030-012
	1500	1500	Aluminium	D16-50030-013
	2000	1000	Stainless steel	D16-50030-005
	2000	1000	Aluminium	D16-50030-014
	2400	1200	Stainless steel	D16-50030-001
	2400	1200	Aluminium	D16-50030-015



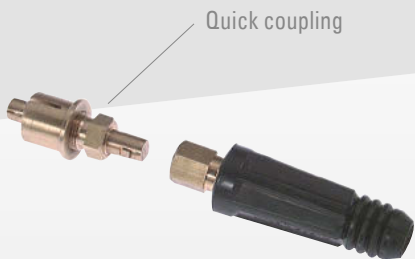
OUR PERFORMANCE
makes THE DIFFERENCE



Table accessories

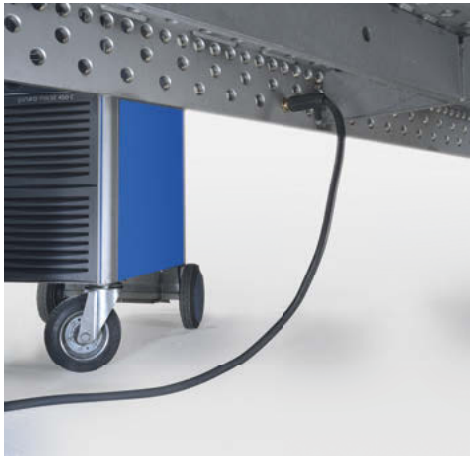
Ground connector

- Fits any system bore
- 100 % contact, therefore no overheating of the ground cable >> High efficiency factor
- For cable cross-section 50 - 70 mm², for loads up to 355 A at 100 % duty cycle, 400 A at 60 % duty cycle
- Simple and safe installation (without interfering edges)
- Compatible with common ground cables



Description ▲

Application ▼



A in mm	B in mm	C in mm	~ Weight in kg	Item no.
-	-	-	0.34	D00-10009-000

Bench stone

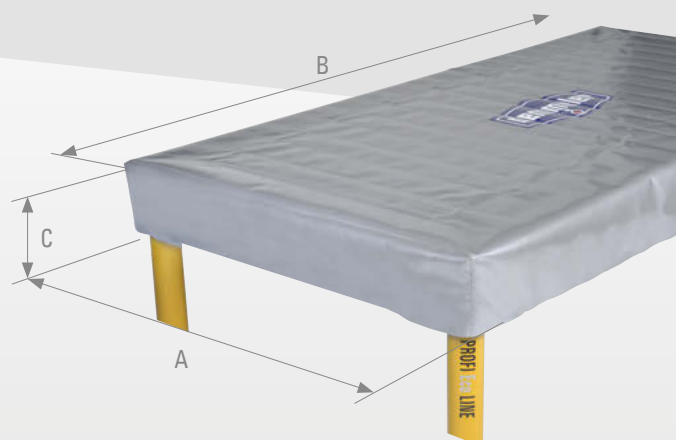
- To care for the system surfaces of worktables and system components



Tarpaulin for your original DEMMELER 3D worktable

Protected against dirt

- Very sturdy tarpaulin
- Protects your table against dirt and wetness
- Firmly sewn at the corners



System components not included

Description ▲ Application ▼



A in mm	B in mm	C in mm	~ Weight in kg	Item no.
200	50	25	0.56	D00-10007-000

Description ▲ Application ▼



A in mm	B in mm	C in mm	Description	Item no.
1000	1000	200	Tarpaulin for table	D00-10030-000
1200	800	200	Tarpaulin for table	D00-10030-008
1200	1200	200	Tarpaulin for table	D00-10030-001
1500	1000	200	Tarpaulin for table	D00-10030-002
1500	1500	200	Tarpaulin for table	D00-10030-003
2000	1000	200	Tarpaulin for table	D00-10030-004
2400	1200	200	Tarpaulin for table	D00-10030-005
3000	1500	200	Tarpaulin for table	D00-10030-006

Table accessories

Pump bottle with worktable system protective spray

- Pressurised, sturdy version
- Includes anti-spatter spray for welding table systems
- Capacity: 1 litre
- Attention: Cannot be diluted with water!

ADVANTAGES TO YOU:

- Prevents the adhesion of weld spatter on the surface
- Temporary corrosion protection for approx. one day
- Good cleaning effect
- Not combustible
- No chlorinated hydrocarbons
- Biodegradable
- Silicone-free



Worktable system protective spray in a canister

- Properties:
- Parting agent for welding thin and/or pre-heated sheets and for multi-layer welding
 - Protection for worktables, system components, welding nozzles and other welding accessories

- Areas of application:
- For welding VA materials, steel and other metals



Description ▲ Application ▼	Description ▲
-----------------------------	---------------



A in mm	B in mm	Description	Item no.
280	100	Without welding spray	D00-10004-000
280	100	with 1 litre welding spray	D00-10005-000

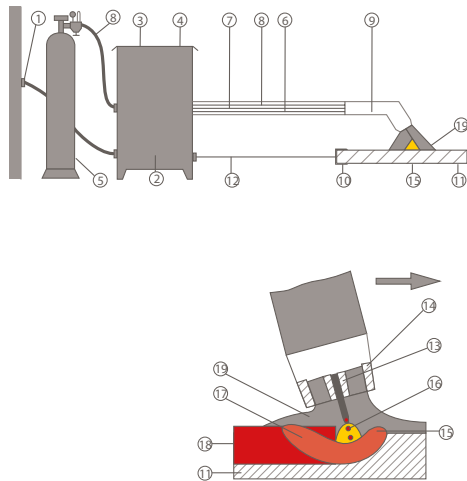
A in mm	B in mm	Description	Item no.
230	200	5 litre canister	D00-10006-000
310	200	10 litre canister	D00-10006-001
400	350	30 litre canister	D00-10006-002

Technical appendix

Gas-shielded metal-arc welding (GMAW; MIG/MAG).....	612
Adjustment range of the TIG power source	613
Purpose of the inert gas.....	614
Classification of inert gas welding methods	614
Classification of inert gas for joint welding	615
Welding joint	616
Manual arc welding - welding positions according to EN 287 / EN ISO 6947 ..	617
Welding method codes	618
Welding symbols for welded joints	619

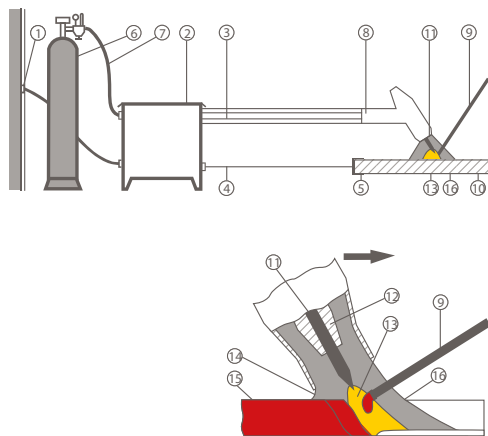
Gas-shielded metal-arc welding (GMAW; MIG/MAG)

Tungsten inert gas welding



All information, drawings and tables without guarantee

1. Mains connection
2. Welding power source
3. Spooled wire electrode
4. Wire feeding system
5. Inert gas cylinder with pressure reducer and gas meter
6. Welding current supply
7. Wire electrode
8. Inert gas supply
9. Welding torch
10. Work piece clamp
11. Work piece
12. Welding current return
13. Contact tube
14. Inert gas nozzle
15. Arc
16. Droplet transfer
17. Weld pool
18. Solid welding material
19. Inert gas layer



All information, drawings and tables without guarantee

1. Mains connection
2. Welding power source
3. Cable-hose assembly with welding current and inert gas supply
4. Welding current return
5. Work piece clamp
6. Inert gas cylinder with pressure reducer and gas meter
7. Inert gas hose
8. Welding torch
9. Welding rod
10. Work piece
11. Tungsten electrode
12. Clamping sleeve and power supply line
13. Arc
14. Liquid welding material
15. Solid welding material
16. Inert gas layer

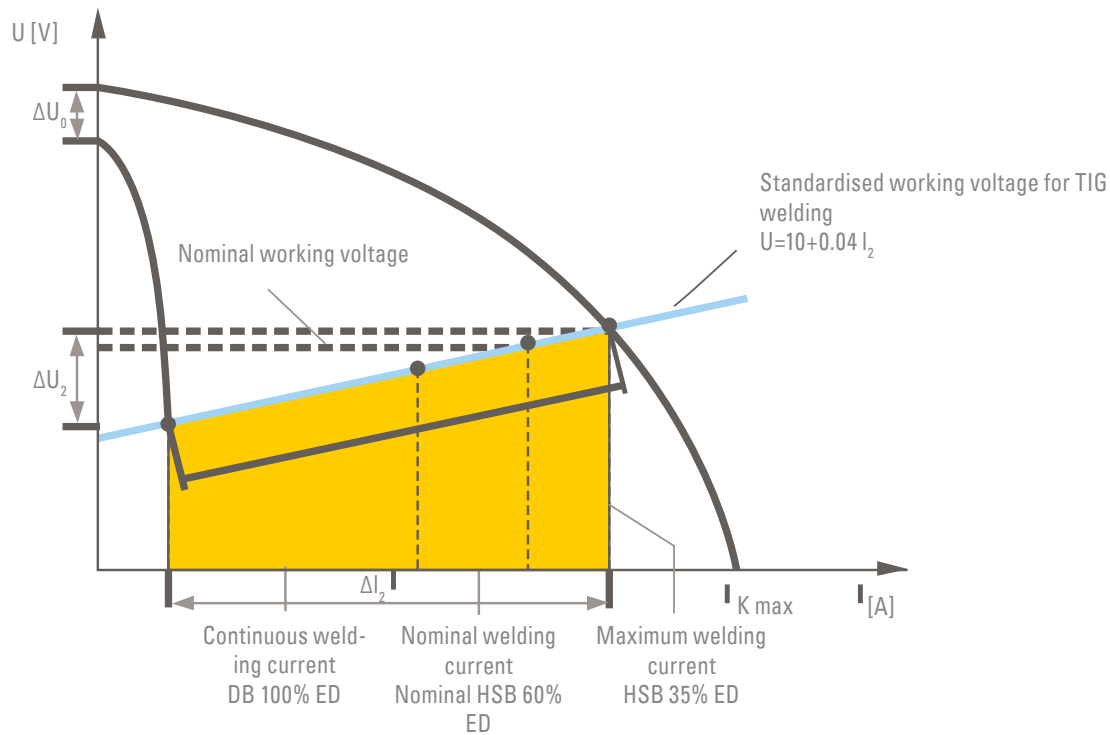
* ATTENTION - thorium oxide contains quantities of radioactive material

All information, drawings and tables without guarantee

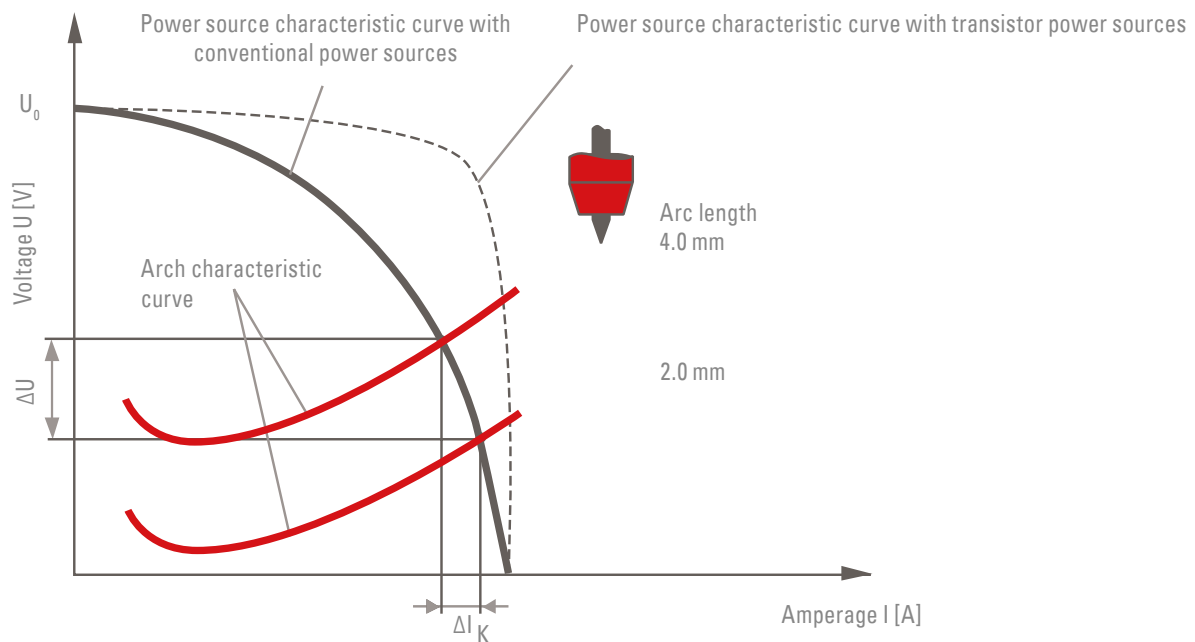
ABBREVIATION	MAIN OXIDE	PROPORTION IN %	CODE COLOUR
	None	-	
WCe 20	Cerium oxide	1.8 to 2.2	
WLa 10	Lanthanum oxide	0.8 to 1.2	
WLa 15	Lanthanum oxide	1.3 to 1.7	
WLa 20	Lanthanum oxide	1.8 to 2.2	
WTh 10*	Thorium oxide	0.8 to 1.2	
WTh 20*	Thorium oxide	1.7 to 2.2	
WTh 30*	Thorium oxide	2.8 to 3.2	
WZr 3	Zirconium oxide	0.15 to 0.5	
WZr 8	Zirconium oxide	0.7 to 0.9	

Adjustment range of the TIG power source

Adjustment range of a TIG power source with sharply falling characteristic curve



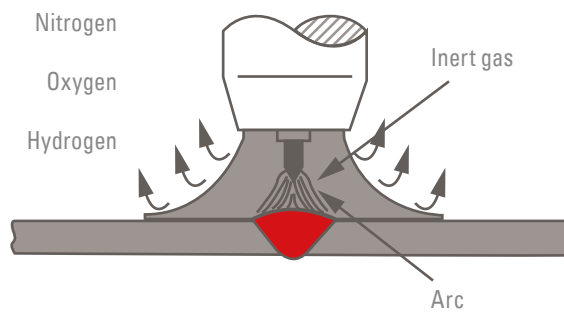
Power source characteristic curve, arc characteristic curve and operating points for TIG welding



All information, drawings and tables without guarantee

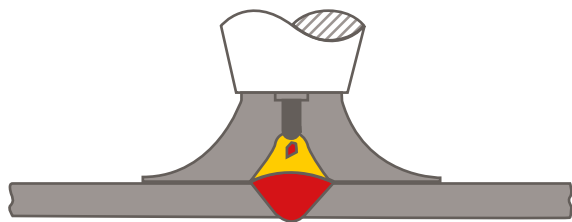
Purpose of the inert gas

Classification of inert gas welding methods



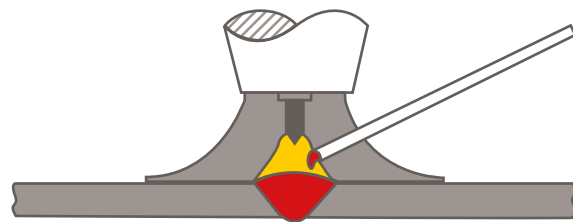
Inert gas welding

Gas-shielded metal-arc welding GMAW



Arcing between melting wire electrode and work piece

Tungsten inert gas welding TIG



Arcing between non-melting tungsten electrode and work piece

Metal active gas welding MAG
Characteristic number 135, 136 (with tubular covered electrode)

Tungsten inert gas welding TIG
Characteristic number 141

Metal inert gas welding MIG
Characteristic number 131

Plasma arc welding PAW
Characteristic number 15

All information, drawings and tables without guarantee

Classification of inert gas for joint welding according to DIN EN ISO 14175

Code designation		Component in percent by volume					
Main group	Subgroup	Oxidising		Inert		Reducing	Slow responding
		CO ₂	O ₂	Ar	He	H ₂	N ₂
I	1			100			
	2				100		
	3			Rest	0.5 ≤ He ≤ 95		
M1	1	0.5 ≤ CO ₂ ≤ 5		Rest ^{a)}		0.5 ≤ H ₂ ≤ 5	
	2	0.5 ≤ CO ₂ ≤ 5		Rest ^{a)}			
	3		0.5 ≤ O ₂ ≤ 3	Rest ^{a)}			
	4	0.5 ≤ CO ₂ ≤ 5	0.5 ≤ O ₂ ≤ 5	Rest ^{a)}			
M2	0	5 < CO ₂ ≤ 15		Rest ^{a)}			
	1	15 < CO ₂ ≤ 25		Rest ^{a)}			
	2		3 < O ₂ ≤ 10	Rest ^{a)}			
	3	0.5 ≤ CO ₂ ≤ 5	3 < O ₂ ≤ 10	Rest ^{a)}			
	4	5 < CO ₂ ≤ 15	0.5 ≤ O ₂ ≤ 3	Rest ^{a)}			
	5	5 < CO ₂ ≤ 15	3 < O ₂ ≤ 10	Rest ^{a)}			
	6	15 < CO ₂ ≤ 25	0.5 ≤ O ₂ ≤ 3	Rest ^{a)}			
M3	7	15 < CO ₂ ≤ 25	3 < O ₂ ≤ 10	Rest ^{a)}			
	1	25 < CO ₂ ≤ 50		Rest ^{a)}			
	2		10 < O ₂ ≤ 15	Rest ^{a)}			
	3	15 < CO ₂ ≤ 25	2 < O ₂ ≤ 10	Rest ^{a)}			
	4	5 < CO ₂ ≤ 25	10 < O ₂ ≤ 15	Rest ^{a)}			
C	5	25 < CO ₂ ≤ 50	10 < O ₂ ≤ 15	Rest ^{a)}			
	1	100					
R	2	Rest	0.5 ≤ O ₂ ≤ 30				
	1			Rest ^{a)}		0.5 ≤ H ₂ ≤ 15	
N	2			Rest ^{a)}		15 ≤ H ₂ ≤ 50	
	1						100
	2			Rest ^{a)}			0.5 ≤ N ₂ ≤ 5
	3			Rest ^{a)}			5 ≤ N ₂ ≤ 50
	4			Rest ^{a)}		0.5 ≤ H ₂ ≤ 10	0.5 ≤ N ₂ ≤ 5
O	5					0.5 ≤ H ₂ ≤ 50	Rest
	1		100				
Z	Mixed gases with components not listed in the table or mixed gases with a composition outside the specified ranges ^{b)}						

All information, drawings and tables without guarantee


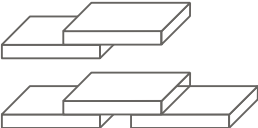

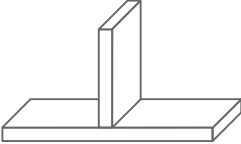
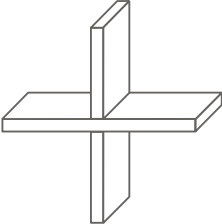
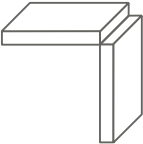
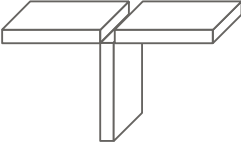

^{a)} For this classification, argon can be partly or entirely replaced with helium.

^{b)} Two mixed gases with the same Z classification cannot be exchanged.

Welding positions

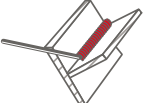
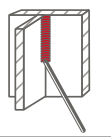
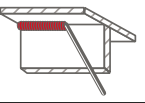
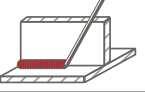
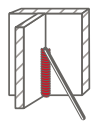
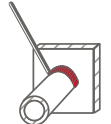
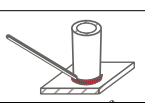
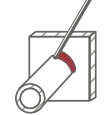
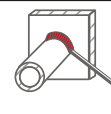

Welding joint

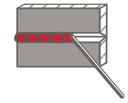
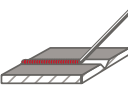
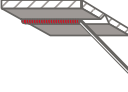

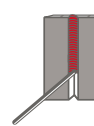
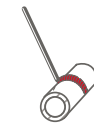
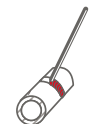
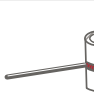


The welding joint is the area where the components are joined to each other by welding. Joint types can be differentiated by structural arrangement as shown here.

	Butt joint	The parts lie in one plane with their face sides touching
	Lap joint	The parts lie on top of each other parallel. They overlap.
	Parallel joint	The parts lie on top of each other parallel. One plate is fully covered by another.
	T-joint	The parts are positioned so that the face side of one part contacts another.
	Double-T joint	The face side of each of two parts lying in one plane contacts a third part lying between them at right angles.
	Corner joint	Two parts contact each other at any angle $> 30^\circ$ (corner). The face side of both plates are welded.
	Multiple joint	Three or more parts contact each other at any angle.
	Scarf joint	The end of one part contacts another at an angle.

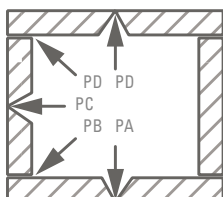
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Manual arc welding - welding positions according to EN 287 / EN ISO 6947

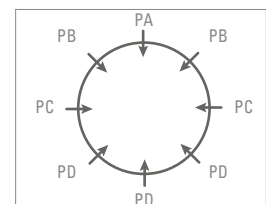
Fillet welds			
	PA	Flat position ASME 1F	
	PG	Vertical down position ASME 3Fd	
	PD	Horizontal-overhead position ASME 4F	
	PB	Horizontal-vertical position ASME 2F	
	PF	Vertical position ASME 3Fu	
	PB	Pipe Pipe axis Weld	rotated horizontal horizontal-vertical
	PB	Pipe Pipe axis Weld	fixed vertical horizontal-vertical
	PF	Pipe Pipe axis Weld	fixed horizontal vertical
	PG	Pipe Pipe axis Weld	fixed horizontal Vertical down
	PD	Pipe Pipe axis Weld	fixed vertical horizontal-overhead

Butt joints		
	PC	Horizontal position ASME 2G
	PA	Flat position ASME 1G
	PD	Overhead position ASME 4G
	PF	Vertical position ASME 3Gu
	PG	Vertical down position ASME 3Gd
	PA	Pipe rotated Pipe axis horizontal Flat weld
	PF	Pipe fixed Pipe axis horizontal Vertical weld
	PC	Pipe fixed Pipe axis vertical Horizontal weld
	PG	Pipe fixed Pipe axis horizontal Vertical down weld
	H-L 045	Variable axis Pipe fixed Pipe axis tilted Vertical weld

Key to abbreviations



PA	Horizontal welding of butt joints in flat position	PC	Horizontal position
		PD	Horizontal-overhead position
PB	Horizontal welding of fillet welds	PD	Overhead position
		PF	Vertical up position
		PG	Vertical down position



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Designations



Welding method codes

Welding method codes	
G	Gas fusion welding
E	Manual arc welding
SAW	Submerged arc welding
SMAW	Shielded metal arc welding
GSAW	Gas-shielded metal arc welding
GMAW	Gas metal arc welding
MIG	Metal inert gas welding
MAG	Metal active gas welding
GTAW	Gas tungsten arc welding

Welding method codes	
WIG	Tungsten inert gas welding
PAW	Plasma arc welding
AHW	Atomic hydrogen welding
USW	Ultrasonic welding
FRW	Friction welding
FOW	Forge welding
D	Diffusion welding
PGW	Pressure gas welding
CW	Cold pressure welding

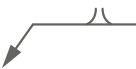


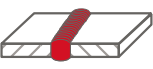
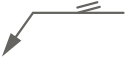

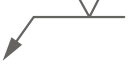






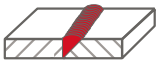



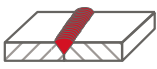








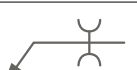



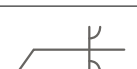










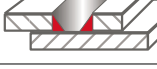

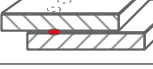

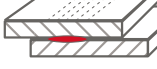
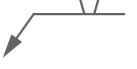



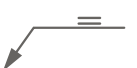


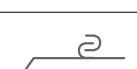


Supplementary symbols for surface seams according to DIN 1912 (excerpt) and ISO 2553

Additional symbols surface shape	
	Hollow (concave)
	Flat (usually refinished flat)
	Curved (convex)
	Sealing bead (opposing position)

Supplementary symbols course and type of seam	
	Circular seam
	Assembly seam

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Welding symbols for welded joints

Welding symbol	Welding seam	Illustration	Welding symbol	Welding seam	Illustration
	Edge-formed seam Flange edge			I-seam Square groove	
	Double I-seam Double square groove			V-seam V groove	
	VU-seam VU groove			Double V-seam Double V groove	
	HV-seam Bevel groove			Double HV-seam Double bevel groove	
	Y-seam Y groove			Double Y-seam Double Y groove	
	HY-seam J groove			Double HY-seam Double J groove	
	U-seam U groove			Double U-seam Double U groove	
	J-seam/HU-seam/Jot-seam J groove			Double J-seam Double J groove	
	Fillet weld Fillet			Double fillet weld Double fillet	
	Pitting seam Plug or slot			Spot welding Spot or projection	
	Continuous weld Seam			Steep side seam	
	Edge-joint weld			Surface joint	
	Deposit welding Surfacing			Folded seam	
	Circular fillet weld with seam thickness 5			Circular fillet weld	
	Interrupted fillet weld with seam thickness 5, 3 individual seams, individual seam length 10, seam spacing 20			Offset, interrupted fillet weld, seam thickness 5 or 4 on the counter sur- face, 5 individual seams respectively, individual seam length 100, seam spacing 50	

Overview of standards for fusion welding

Quality requirements for fusion welding

DIN EN ISO3834-1 to -5, DIN FB CEN ISO/TR 3834-6

Non-destructive testing

Qualifications for personnel	DIN EN 473 (ISO 9712)
Rules for ZIP	DIN EN 12062 (ISO 17635)
Visual inspection	DIN EN 970 (ISO 17637)
Ultrasound inspection	DIN EN 1714 (ISO 17640)
Penetration test	DIN EN 571-1; DIN EN ISO 3452-5, -6
Magnetic particle test	DIN EN ISO 17638
Eddy current test	DIN EN 1711 (ISO 17643)
Hardness test	DIN EN 1043-1, -2 (ISO 9015-1, -2)
Time of flight diffraction (TOFD) method	E DIN EN ISO 10863, DIN EN 583-6
Phrased array	E DIN EN 16018

Destructive testing

Transverse tensile test	DIN EN 895 (ISO 4136)
Longitudinal tensile test	DIN EN 876 (ISO 5178)
Crosswise tensile test	DIN EN ISO 9018
Bending test	DIN EN 910 (E DIN EN ISO 5173)
Fracture test	DIN EN 1320 (ISO 9017)
Notched bar impact test	DIN EN 875 (ISO 9016)
Hardness test	DIN EN 1043-1, -2 (ISO 9015-1, -2)
Microscopic and macroscopic tests	DIN EN 1321 (ISO 17639)
Etching for microscopic and macroscopic tests	DIN V 1739 (ISO/TR 16060)
Hot crack test method	DIN EN ISO 17641-1, -2, -3
Cold crack test method	DIN EN ISO 17642-1, -2, -3
Ferrite proportion test	DIN EN ISO 8249.17655



All information, drawings and tables without guarantee

Terms, definitions	
Symbolic representation	DIN EN 22553
Method and no.	DIN EN ISO 4063
Metal welding terms	DIN EN 14610 (ISO857-1, -2)
Terms and definitions	DIN FB CEN/TR 14599 DIN FB ISO/TR 25901
Multilingual designation with illustrations	DIN EN 1792, DIN EN ISO 17659
Welding positions	DIN EN ISO 6947 DIN V 2308 (CEN/TR 14633)
Welding tolerances	DIN EN ISO 13920

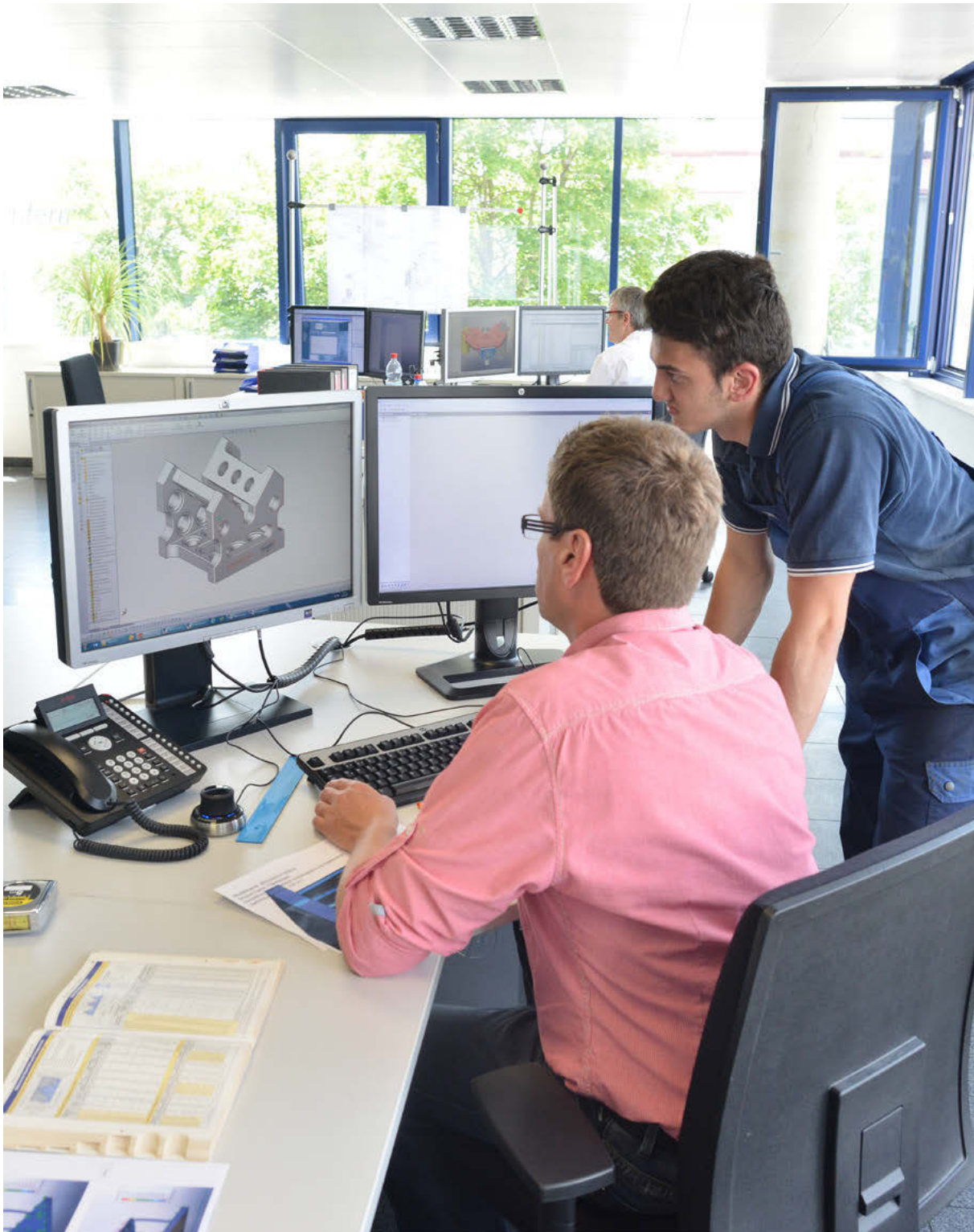
Other standards	
Welder's qualification test, copper	DIN EN ISO 9606-3
Welder's qualification test, nickel	DIN EN ISO 9606-4
Welder's qualification test, titanium	DIN EN ISO 9606-5
Welder's qualification test, cast iron	E DIN EN 287-6
Gas welding instruction	DIN EN ISO 15609-2
Welding procedure qualification, copper	DIN EN ISO 15614-6
Welding procedure qualification, nickel	DIN EN ISO 15614-1
Welding procedure qualification, titanium	DIN EN ISO 15614-5
Welding procedure qualification, cast iron	DIN EN ISO 15614-3
Welding procedure qualification, build-up welding	DIN EN ISO 15614-7
Welding procedure qualification, welding tubes in tube plates	DIN EN ISO 15614-8
Welding procedure qualification, production welding of cast steel	DIN EN ISO 11970
Welding cast iron	DIN EN 1011-8
Welding of plating	DIN EN 1011-5

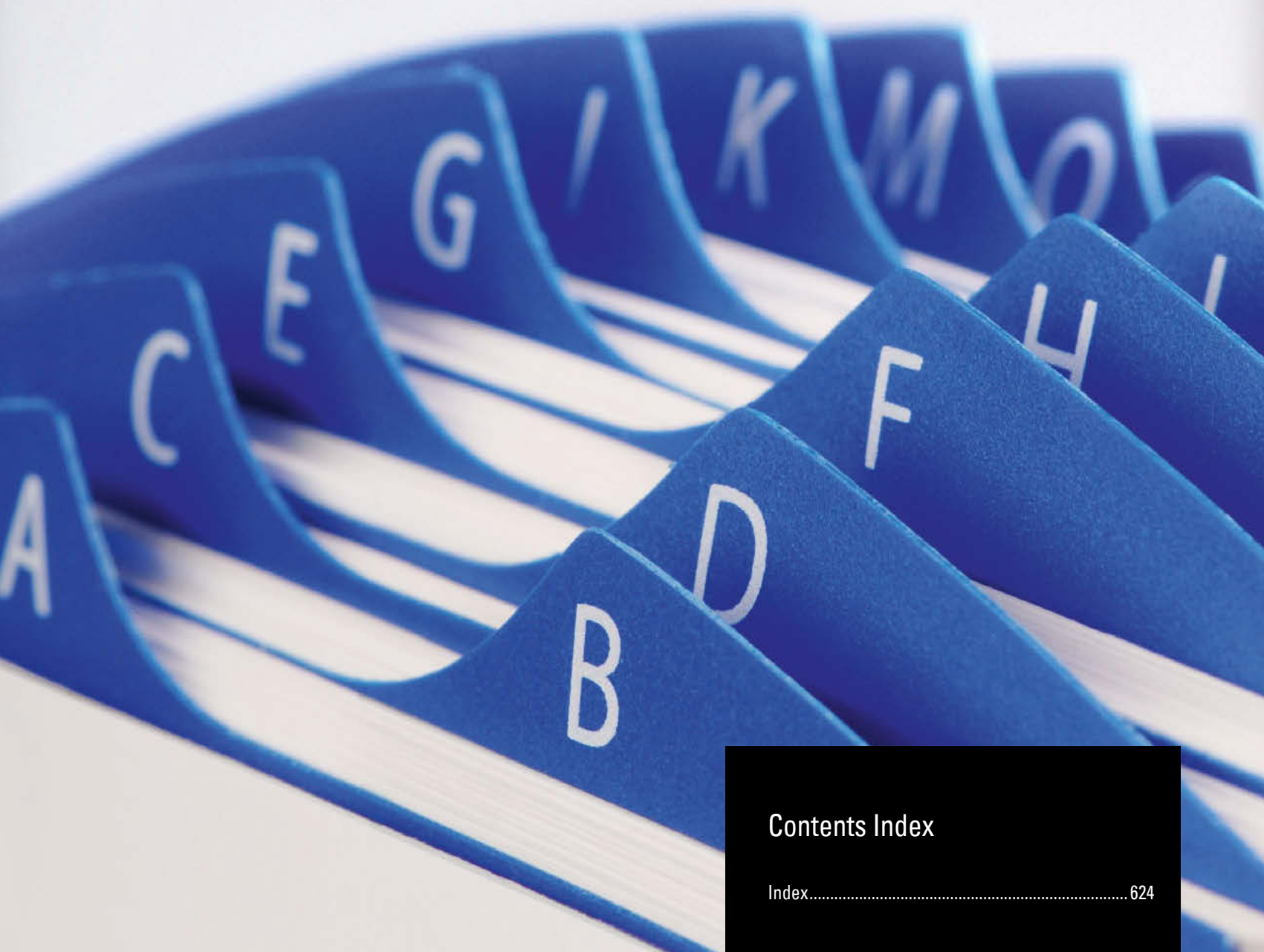
Exemption criteria for ZIP		
	Steel	Aluminium
VT	DIN EN ISO 5817	DIN EN ISO 10042
RT	DIN EN 12517-1 (ISO 16075-1)	DIN EN 12517-2
UT	DIN EN 1712, 1713, E DIN EN ISO 22825, DIN EN 15617 (for TOFD)	
PT	(E DIN EN ISO 23277)	
MT	DIN EN ISO 23278	
HT	DIN EN ISO 18265	

Welding additives	
General product standard	DIN EN 13479
QA requirements for production	DIN EN 12074
Technical delivery terms and conditions	DIN EN ISO 544
Guidelines for procurement	DIN EN ISO 14344
Test methods and QA	DIN EN 14532-1, -2, -3; DIN EN ISO 15792-1, -2, -3
Test methods	DIN EN ISO 15792-1, -2, -3 DIN EN ISO 684714372, 8249, 3690 DIN EN ISO 22401
Tungsten electrodes	DIN EN ISO 6848
Additives for hard coating	DIN EN 14700
Additives for cast iron	DIN EN ISO 1071

	Unalloyed / fine-grained steel	High-strength steel	High-temperature steel	Stainless steel	Nickel /	Copper /	Aluminium /	Titanium /
Welding rods (E)	DIN EN ISO 2560	DIN EN 757 (ISO 18275)	DIN EN ISO 3580	DIN EN 1600 (ISO3581)	DIN EN ISO 14172			
Wire electrodes (GMAW)	DIN EN ISO 14341	DIN EN ISO 16834	DIN EN ISO 21952	DIN EN ISO 14343	DIN EN ISO 18274	DIN EN ISO 24373	DIN EN ISO 18273	DIN EN ISO 24034
Rod/wire (TIG)	DIN EN ISO 636	DIN EN ISO 16834	DIN EN ISO 21952	DIN EN ISO 14343	DIN EN ISO 18274	DIN EN ISO 24373	DIN EN ISO 18273	DIN EN ISO 24034
Wire (SAW)	DIN EN 756 (E DIN EN ISO 14171)	DIN EN ISO 26304	DIN EN ISO 24598	DIN EN ISO 14343	DIN EN ISO 18274			
Powder (SAW)	DIN EN 760 (E DIN EN ISO 14174)							
Filler wire (GMAW)	DIN EN ISO 17632	DIN EN ISO 18276	DIN EN ISO 17634	DIN EN ISO 17633				
Autogenous rod (G)	DIN EN 12536		DIN EN 12536					
Inert gas	DIN EN ISO 14175, DIN EN 1089-3							

All information, drawings and tables without guarantee





Contents Index

Index..... 624

Symbole

2P. Clamping bridge 306
2-point clamp 315
3D measuring, assembly and adjustment table 98
3D welding table PROFIEcoLINE (PE) 16 system 477|480
3D welding table PROFIEcoLINE (PE) 28 system 94
3D welding table PROFIPlusLINE (PL) 16 System 477|478
3D welding table PROFIPlusLINE (PL) 22 System 366|368
3D welding table PROFIPlusLINE (PL) 28 System 92
3D welding table PROFIPremiumLINE (PP) 22 System 364
3D welding table PROFIPremiumLINE (PP) 28 System 90
3D work and welding table 96

A

Accessory cart 330|454|600
Accessory wall 331
Adapter 272|297|397|430|450
Adapter D16 to D28 189|305|520|592
Adapter D22 to D16 397
Adapter for quick release skewer 319|596
Adapter plate 257|375|557
Adapter-tube 310|591
Additional symbols 618
Adjustable spacer 271
Adjustment V-block 264
Aircraft industry 70
Allen key 337|458|603
Aluminium-titanium 198|200|205|208|218|220|224|240|351|
363|369|402|410|419|529
Anchoring leg 82|100|358|370|474|482
Angle bracket 243|244
Angle bushing 308
Angle-setting template 256|558

ANSI flange 113
Arbour 267|269
Artistic metalwork 57
Assembly lever 335|457
Automotive / fixture construction 27

B

Ball clamp bushing 311
Base bridges 489
Base rail 142|144|148|150|152|158
Bench stone 343|461|609
Bushing 296|446|583
Butt joints 617

C

Casting 204|222|226|229|235|236|238|242|412|413|528|537|538
Clamping and adapter plate 108|374|488
Clamping and locating angle 212|410|412|414|416|418|537|538|
541|542|544|546
Clamping block 209|531
Clamping floor plate 164
Clamping floor plate ProfiLINE 166
Clamping floor plate XL 165
Clamping pad 296|298|302|306|434|446|448|583|584|589
Clamping pad with ball form 302|587
Clamping pad with V-block 298|448|585
Clamping plates 112|113
Clamping track 209
Clamping tube 307|590
Clamps 278|280|282|284|286|288|290|292|294|434|436|438|440|
442|444|570|572|574|576|578|580|582
Clamps accessories 296|298|300|302|304|306|308|310|446|448|
450|583|584|586|588|590|592
Clever toolbox 332|455

Compensating clamping arm 287
Compensating swing clamp 282
Compensating swing clamp with quick-action clamping cylinder 281|438|574
Compensating swing clamp with short boring spindle 575
Compensating swing clamp with spindle 280|437|573
Connecting bolt 187|188|395|396|517|518
Consoles 204|206|528
Construction machines 49|51|53
Contour stop 254|556
Corner module 207|208|530

D

D16 to D28 520|592
D22 to D28 398|430|449
D28 to D16 189|190|272|297|304
Definitions 621
DEMONT - THE hardness 79|472
Device construction 27|70
Displacement stop 247|424|549
Double V-block 267|268|270|564

E

EcoLINE bolt 185|514
EcoLINE universal stop 248|550
Economic efficiency 16
Extension sleeve 311

F

FCP bolts with handle 184
Fillet welds 617
Fitter's shops 59
Flange 112|113

Flat angle trim 245|547
Floor plates 162|164|166
Food industry 67

G

Gas-shielded metal arc welding 612
General steel construction 31
Ground connector 342|460|608
Guiding carriage 159
Guiding wagons 160

H

Hardness 79|355|473
Heavy-duty wheel 82|101|358|371|474|483
HobbyLINE 96
HobbyLINE (H) worktop 88
Holding frame 83|104|155|158
Horizontal toggle clamp 318

I

Inert gas 614
Interface plate 398|430|449

J

Joint welding 615

L

Leg variants 82|358|474
Locating disk 258|426

M

Machine building and plant construction 41|45
Machine tools 65
Magnetic clamp 325
Manifold 277|322
Manual arc welding 617

Material properties 79|355|473

Metalworking 57|59|67

Mounting plate 199|404|532

Multi-clamping and support tower 287

O

Oblong hole 204|206|234|236|238|240|242|249|250|255|

415|416|417|419|420|425|542|544|546|551|552|557

Okto 109|110|374|486|488

Okto 3D worktable 110|374|486

P

PC bolt 178|510

PC countersunk bolt 182|512

Performance screw clamp 284|286

Pivoting leg 82|105|358|371|474|483

Plug 153

Plunger 252|554

Plunger and contact piece 298|300|448|585|586

Pneumatic toggle clamp 320

Power screwdriver 180

PPC bolt 174|386|388

PPC countersunk head bolt 176|390

Practical applications 21

Precision scaling 77|91|93|95|97|99|247|250|254|256|309|

353|365|367|369|422|471|479|481|549|552|556|558

Pressure force booster 323

PROFIEcoLINE 88|94|167|229|242|341|412|477|480|546

PROFIEcoLINE set 128|130|498|500|502|504

PROFIPlusLINE 87|92|167|224|226|233|234|236|238|240|243|

340|362|366|368|414|416|418|477|478|537|538|541|542|544

PROFIPlusLINE set 122|124|126|378|380|492|494|496

PROFIPremiumLINE 87|90|167|218|220|222|228|339|362|364|410

PROFIPremiumLINE Set 116|118|120

Protective countersink 77|353|471

Protective plate 339|340|605|606

Protective spray 344|462|610

Pump bottle 344|462|610

Q

Quick-action clamping cylinder 281|285|290|294|297|438|441|

444|447|574|577|581|584

Quick release skewer 312|314|316|318|594|596

R

Rail types 144

Rail vehicle construction 47

Reduction plate 190|272|304|520|566|593

Replacement parts 296|298|300|302|304|306|308|310|446|448|

450|583|584|586|588|590|592

Round brush 338|459|604

S

Scissor lift 83|100|102

Screw clamp 288|290|440|442|576|578

Segmented grid plate 490

Set 378|380

Sheet metal processing 29|43|47

Sheet metalworking 55

Shifting foot 83|155|157

Short boring spindle 282|284|286|291|295|296|439|442|445|446|
575|578|582

Spacer block 83|148|152|154|156|194|196|198|200|202|402|404|
527|532

Spacer set 262|563

Spare parts 296|298|300|302|304

Special sizes and materials 478|480

Spindle 280|284|288|293|296|437|440|446|573|576|580|583

Standard leg 82|100|358|370|474|482

Standards 620

Stop and positioning bolt 186|394|516

Stop ring 307|589

Stop-strip 255|425|557

Supplementary symbols 618

Support 204|528

Support and base rail 148

Support and base rail, duo 152

Support and base rail, linear 150

Support and base rail XL 149

Supports 259|427|564|566

System 16 sets 492|494|496|498|500|502|504

System 22 sets 378|380

System 28 sets 116|118|120|122|124|126|128|130

T

Table accessories 330|332|336|338|340|342|344|454|456|458|

460|462|600|602|604|606|608|610

Table expansion 207|208|530

Table leg for spacer block 83|156

Table sizes 16 system 476

Table sizes 22 system 360

Table sizes 28 system 84

Taper fitting 263|265|266

Tarpaulin 331|343|461|609

Telescoping leg 82|100|358|370|474|482

Testing 620

The advantages of the 3D clamping system 77|353|471

Threaded bushing 312|447

Threaded support 271

Tilt angle 230|334|456|540|602

Toggle clamp 312|314|594

Toolbox 332|455

Tool trolley 601

Torque wrench 336|458|603

Transport ring 334|456|602

Tungsten inert gas welding 612

U

Universal pivot and tilt angle 230|540

Universal stop 246|248|250|252|420|422|424|548|550|552|554

V

Variable screw clamp 292|294|443|444|579|580|582

Variant overview 154

V-block 298|448|585

V-block locations 267|268|270|564

Vehicle construction 23|25|33|35

Vertical toggle clamp 316|595

W

Welding additives 621

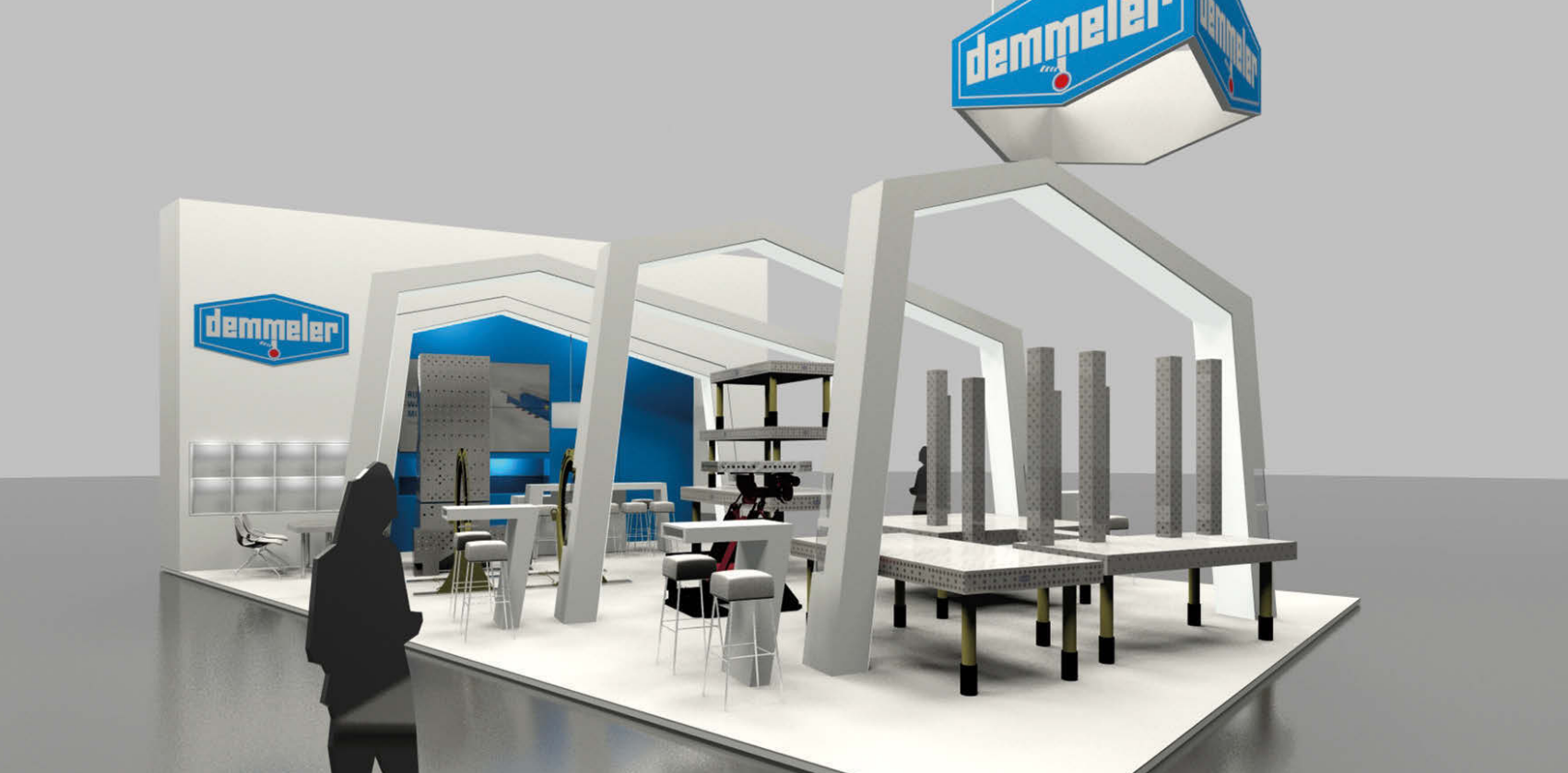
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Welding method codes 618

Welding symbols 619

WIG 613

Worktop 96



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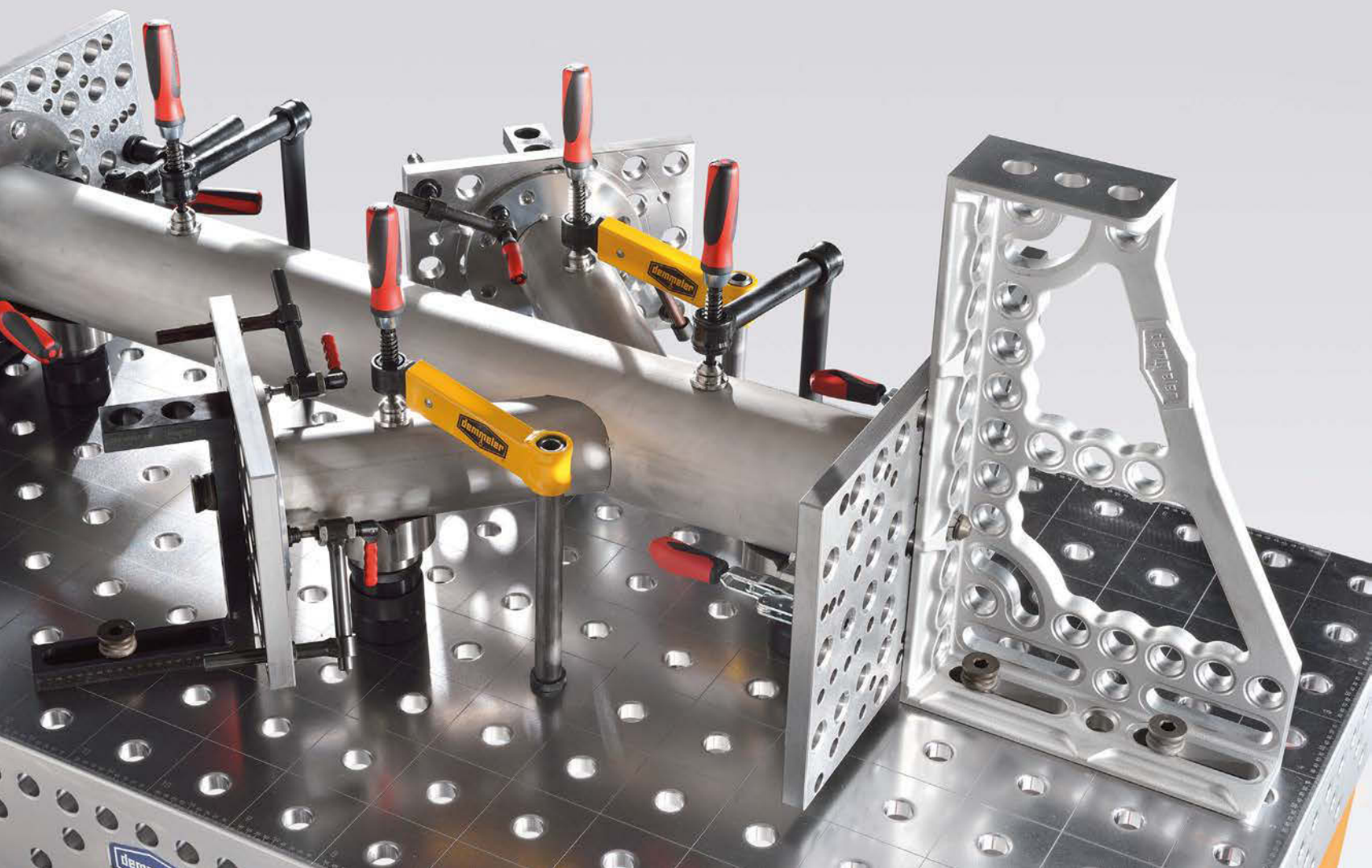
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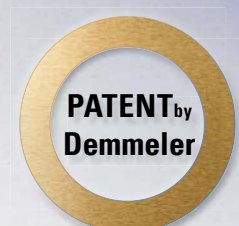


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