

ALLMATIC T-REX – MIND THE JAWS!

This compact vice sinks the sharp “teeth” of its gripper into your workpiece. The ALLMATIC T-REX is indispensable for clamping unmachined parts for 5-sided machining.



ALLMATIC GRIPP – MECHANICAL T-REX VERSION

Scope of application:

- Horizontal installation – suitable for vertical CNC-controlled milling machines
- Ideal for use on 5-axis machining centres
- Reliable and fast clamping of unmachined parts, flame-cut and sawn materials with gripper jaws
- Clamping of parallel pre-machined workpieces with optional step jaws
- Gripper studs suitable for materials with a strength of up to approx. 1000N/mm²



Product features:

- Optimum accessibility for 5-sided machining thanks to the combination of compact base and large clamping width
- Stamping and clamping in a single process, in the working area itself, without any additional accessories
- The movable/pivot support jaw allows different workpiece contours to be clamped
- Gripper studs can be changed without tools and are easy to adjust by hand
- Operation with a torque wrench – max. 30 Nm
- High-pressure spindle with power intensification

Robust and compact base made of GGG 60

M8 thread for workpiece stop


Hardened, ground and polished guideway



Holes in the clamping shoulder for fastening to the machine table itself

Precision aligning slots (longitudinal/transverse) and a positioning hole in the bottom surface for optimal alignment on the machine table

Outlet for coolant and chips

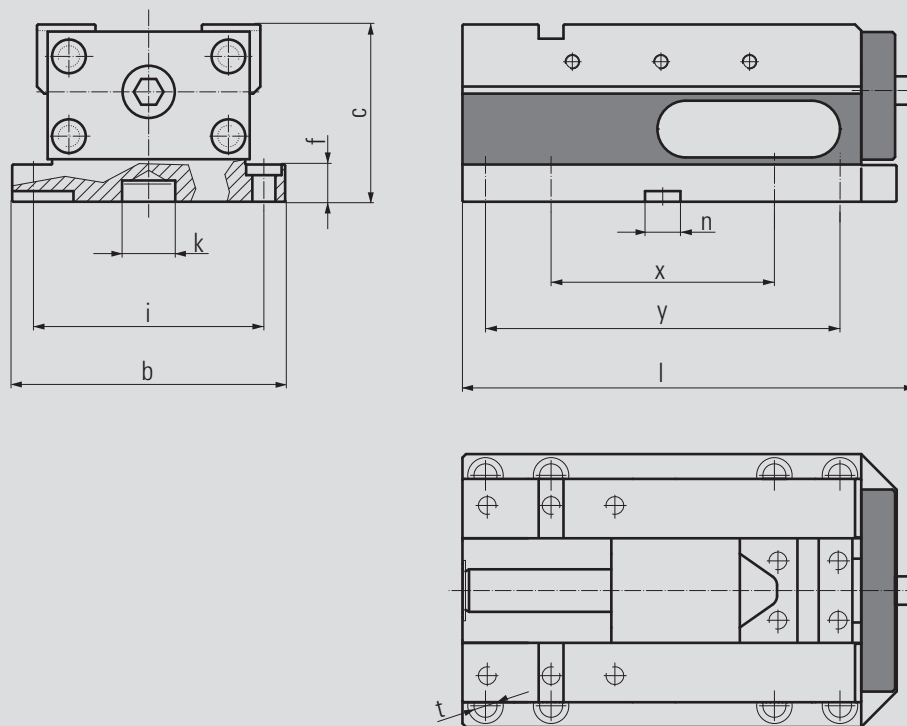
 Optional: mounting holes in the bottom surface for zero-point clamping systems are possible

Order no. jaw width 125: 6921888000155

Scope of supply:

- 1 high-pressure vice without jaws
- 4 fastening bolts M12 x 35 mm
- 3 socket screw wrenches
(Please order clamping jaws separately)

An overview of the clamping jaws and other accessories is given on the following pages.

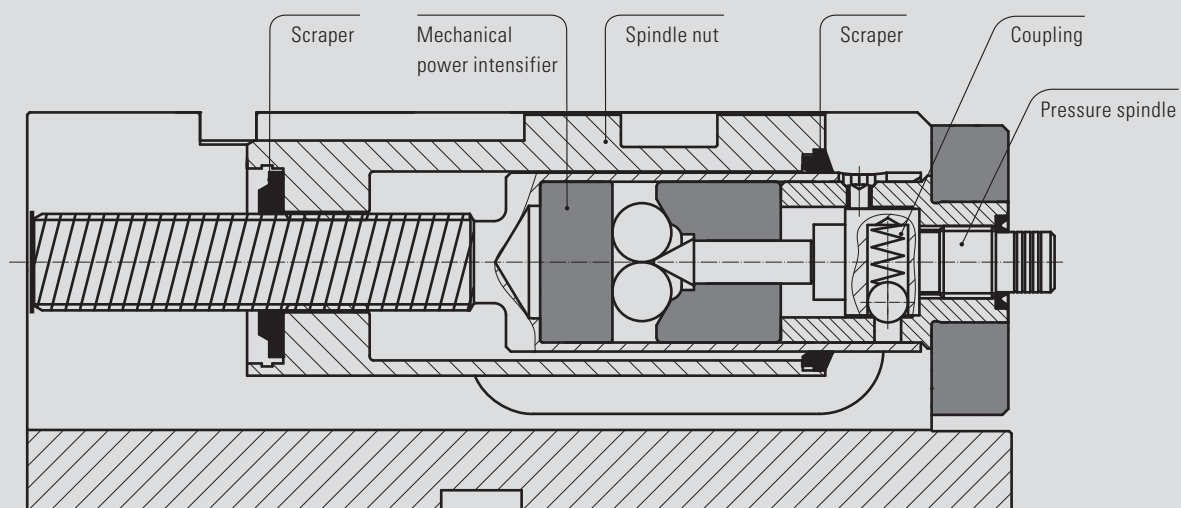


Technical data

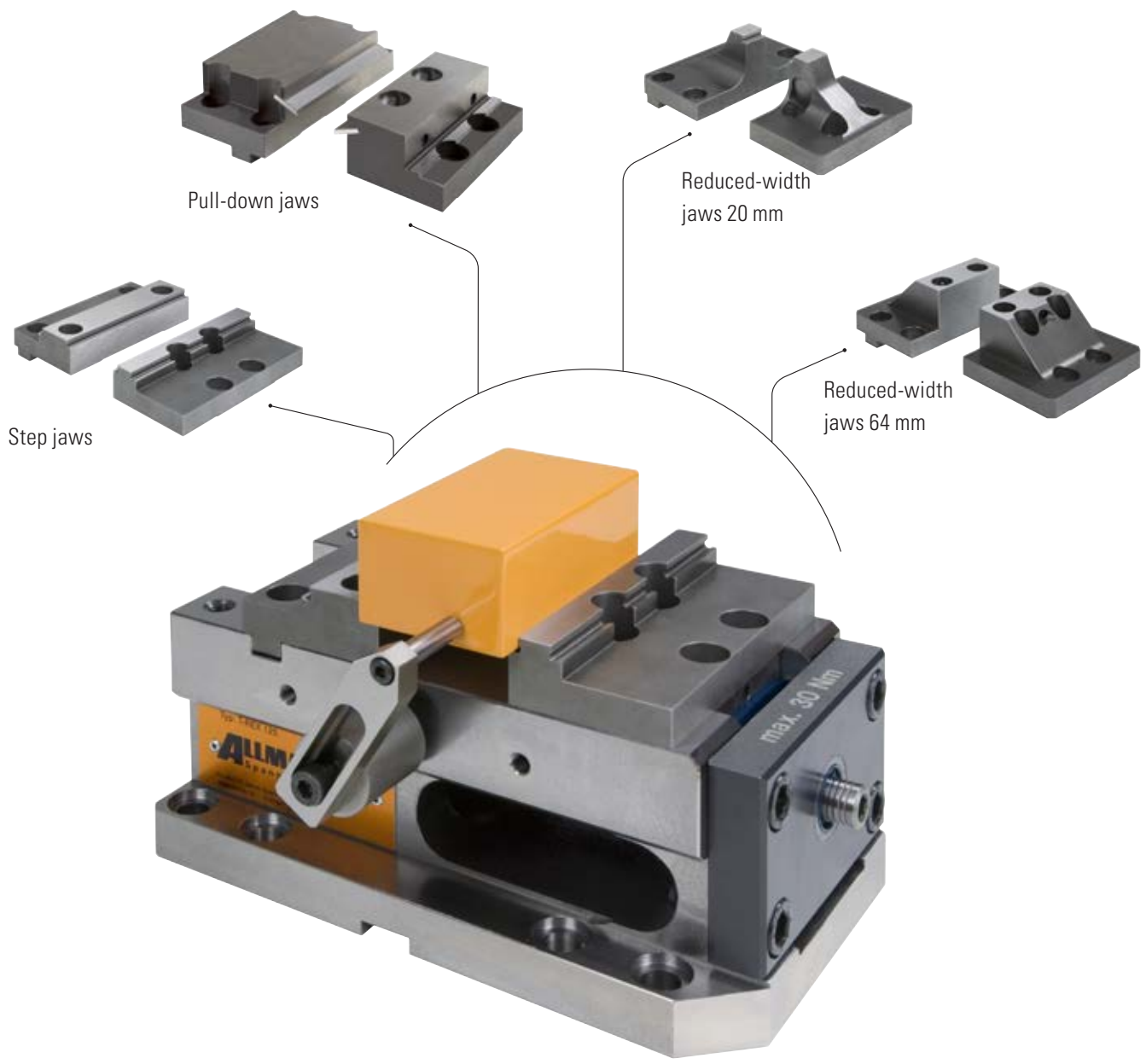
Jaw width		125
Dimensions / tolerances in mm	b	154
	c	100
	f	21
	i	130
	k	Ø 30 H8
	l	256
	n	20 H7
	t	Ø 13
	x	127
y	200	

Jaw width	125
Max. torque in Nm	30
Max. clamping force in kN	40
Weight in kg	18

Spindle cross-section



ALLMATIC GRIPP – MECHANICAL/T-REX



Pull-down jaws

Reduced-width
jaws 20 mm

Step jaws

Reduced-width
jaws 64 mm

For conventional clamping of workpieces

On the following pages you will find a wide range of jaws suitable for clamping pre-machined workpieces.



For clamping complex unmachined parts

Varying types of unmachined parts can be clamped quickly and securely using the support jaws and the reduced-width jaws. Jaws for gripper clamping can be found on the following pages.

Gripper clamping:

- Support jaws are used to mount different gripper studs (threaded gripper studs or universal gripper set)
- Gripper studs can be screwed onto grid plates in variable positions to securely clamp a wide variety of workpiece geometries
- Additional pivot function of the movable clamping jaw compensates for non-parallel clamping surfaces and is necessary for clamping uneven workpieces

CLAMPING RANGES – T-REX

Support jaws with gripper studs

You can find the clamping ranges of the other T-REX jaws for conventional clamping on the following pages of accessories



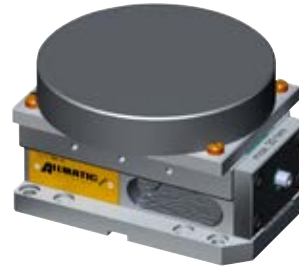
min. clamping range	26 mm
min. clamping width	73 mm



max. clamping range	185 mm
max. clamping width	at least 150 mm or larger



min. clamping range	Ø 80 mm
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max. clamping range	Ø 190 mm
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Support jaws with universal gripper set



min. clamping range	0 mm
min. clamping width	88 mm



max. clamping range	152 mm
max. clamping width	at least 165 mm or larger



min. clamping range	Ø 100 mm
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max. clamping range	Ø 160 mm
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APPLICATION EXAMPLES – T-REX



Application examples

1. The T-REX support jaws and the universal gripper set permit clamping and machining of very complex unmachined parts.
2. The T-REX vice with console and support jaws for gripper studs permits extremely adaptable clamping possibilities.
3. Perfect clamping solutions for use in mould making.
4. The T-REX vice guarantees secure clamping in difficult situations and for horizontal machining.
5. Efficient clamping of unmachined parts with the T-REX vice on horizontal machining centres opens up new possibilities.
6. Fully integrated into the machines working area, the T-REX is an absolutely reliable clamping device for unmachined and pre-machined workpieces.

ALLMATIC GRIPP –mechanical / T-REX version (accessories)

Support jaws for gripper studs



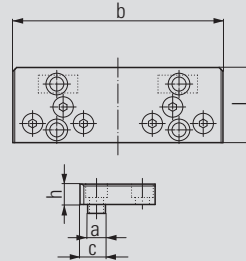
- Material: hardened steel
- For mounting various studs (pointed/smooth)
- Front surface can be used as clamping surface (hardened, ground and polished)

Pivot jaw:

- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- Studs (pointed/smooth) **not** included

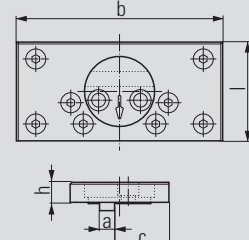
Dimensions of the individual items of the gripper set can be found at www.allmatic.de

Order no. fixed:
6921884005042



Jaw width	125
Dimensions in mm	
a	14
b	165
c	20
h	16
l	59

Order no. movable, pivot:
6921884072042



Jaw width	125
Dimensions in mm	
a	12
b	165
c	43.5
h	16
l	79



Please order gripper studs separately.

Support jaws for universal gripper set



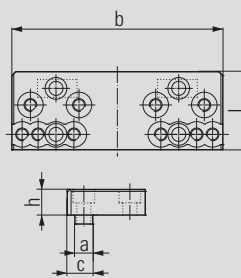
- Material: hardened steel
- For mounting various studs (pointed/smooth)
- Front surface can be used as clamping surface (hardened, ground and polished)

Pivot jaw:

- For clamping uneven workpieces
- To compensate for non-parallel clamping surfaces
- Gripper set **not** included

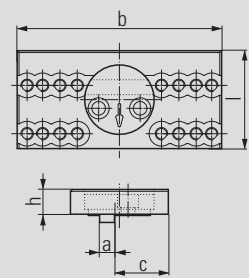
Dimensions of the individual items of the gripper set can be found at www.allmatic.de

Order no. fixed:
6921884005242



Jaw width	125
Dimensions in mm	
a	14
b	165
c	20
h	20
l	61

Order no. movable, pivot:
6921884072242



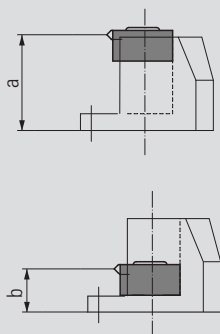
Jaw width	125
Dimensions in mm	
a	12
b	165
c	35.5
h	20
l	79



Please order universal gripper set separately.

ALLMATIC GRIPP – mechanical / T-REX version (accessories)

Universal gripper set



Order no. 6921884027031

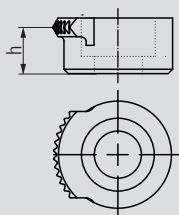
Jaw width	125	
Dimensions in mm	a	40
	b	18

- For clamping complex unmachined parts
- The individual elements of the universal gripper set can be reworked in order to vary both gripper height and support height of the workpiece

Comprising:

- 4 x gripper studs 6921884026000
- 4 x gripper stud mounts 6921884072000
- 4 x supports 6921884028000
- 8 x shims
- Support bolts
- M10 fastening bolts in various lengths
- M6 threaded pins in various lengths
- Socket screw wrench
- Storage case

Gripper stud

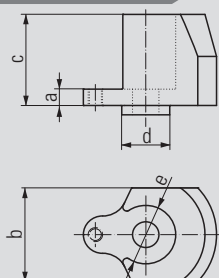


Order no. 6921884026000

Dimensions in mm	h	11
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- Gripper stud for universal gripper set

Gripper stud mount

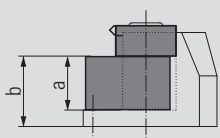
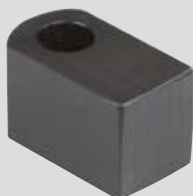


Order no. 6921884072000

Dimensions in mm	a	7
	b	40
	c	39
	d	Ø 20
	e	Ø 25

- Mount for gripper stud 2306/001

Support



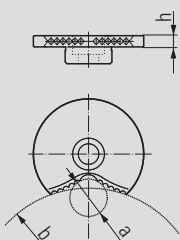
Order no. 6921884028000

Dimensions in mm	a	22
	b	29

- Support for universal gripper set

ALLMATIC GRIPP – mechanical / T-REX version (accessories)

Prismatic gripper

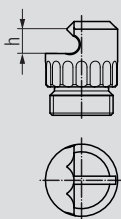


Order no. 6921884029031

Dimensions in mm		
a	Ø 20	
b	Ø 120	
h	6	

- Replaces gripper stud 2306/001 in the universal gripper set
- Special shape distributes the applied clamping force – particularly advantageous for clamping workpieces for which fits have to be made

Gripper stud, pointed

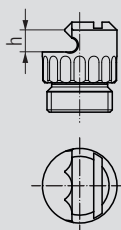


Order no. 6921884036000

Dimensions in mm		
h	5.5	

- For clamping unmachined parts
- Minimum clamping edge loss
- Gripping height: adjustable from 4.5 to 6.0 mm

Gripper stud, low-level

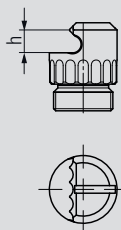


Order no. 6921884036100

Dimensions in mm		
h	5	

- For clamping unmachined parts
- Minimum clamping edge loss
- Gripping height: adjustable from 3.0 to 4.5 mm

Gripper stud, four-point

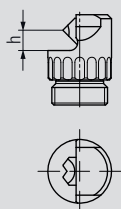


Order no. 6921884036500

Dimensions in mm		
h	5,4	

- For clamping unmachined parts
- For soft materials like aluminum
- Minimum clamping edge loss
- Clamping height: adjustable from 4.5 mm to 6.0 mm

Gripper stud, carbide coated



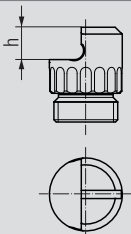
Order no. 6921884036841

Dimensions in mm		
h	5,1	

- For clamping unmachined parts
- For high quality coated materials and flame cuts
- Minimum clamping edge loss
- Clamping height: adjustable from 4.2 mm to 5.7 mm

ALLMATIC GRIPP – mechanical / T-REX version (accessories)

Clamping insert, smooth

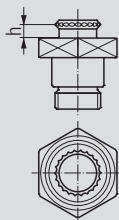


Order no. 6921884037000

Dimensions in mm	h	7
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- With carbide coating for clamping pre-machined or hardened workpieces

Gripper stud, round



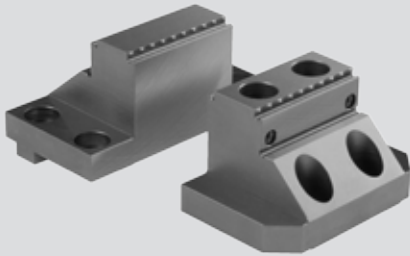
Order no. 6921884038000

Dimensions in mm	h	4
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- For clamping unmachined parts
- For through-drilling close to the edge
- Offers 6 mm space below workpiece

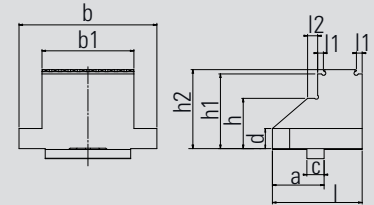
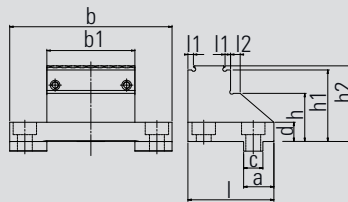
ALLMATIC GRIPP – mechanical / T-REX version (accessories)

Jaw 64 mm, with integrated gripper row

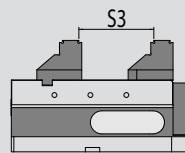
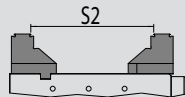
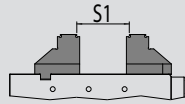


Order no. fixed:
6921884034031

Order no. movable:
6921534036031



- For rectangular workpieces (sawn material) ≤ 0.5 mm
- Rigid design to prevent vibrations when parts are clamped upright
- Additional clamping surfaces, ground on both sides
- For five-sided machining, ensuring best possible accessibility to the workpiece
- Positive locking through penetration of the centres into the material
- Minimal lost clamping margin of approx. 3 mm.
- Suitable for material strength of up to 1000 N/mm²



Jaw width		125
Dimensions in mm	a	22
	b	118
	b1	64
	c	14
	d	14
	h	35
	h1	52
	h2	55
	l	62,5
	l1	4
l2	7	

Jaw width		125
Dimensions in mm	a	36
	b	96
	b1	64
	c	12
	d	14
	h	35
	h1	52
	h2	55
	l	62,5
	l1	4
l2	7	

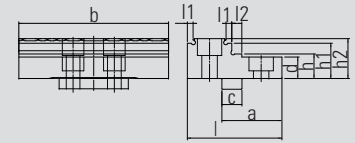
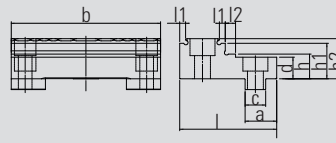
Clamping range S1	10 - 71
Clamping range S2	90 - 169
Clamping range S3	40 - 105

Gripper jaw with integrated gripper row

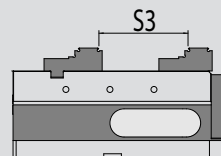
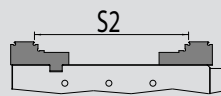
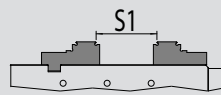


Order no. fixed:
6921884034931

Order no. movable:
6921534036931



- For rectangular workpieces (sawn material) ≤ 0.5 mm
- Rigid design to prevent vibrations when parts are clamped upright
- Additional clamping surfaces, ground on both sides
- For five-sided machining, ensuring best possible accessibility to the workpiece
- Positive locking through penetration of the centres into the material
- Minimal lost clamping margin of approx. 4 mm.
- Suitable for material strength of up to 1000 N/mm²



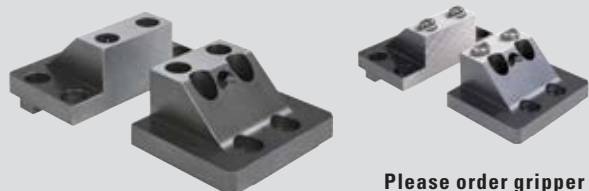
Jaw width		125
Dimensions in mm	a	21,5
	b	118
	c	14
	d	14
	h	16
	h1	23
	h2	26
	l	66
	l1	4
	l2	7

Jaw width		125
Dimensions in mm	a	34
	b	118
	c	12
	d	14
	h	16
	h1	23
	h2	26
	l	60,6
	l1	4
	l2	7

Clamping range S1	10 - 67
Clamping range S2	94 - 173
Clamping range S3	38 - 101

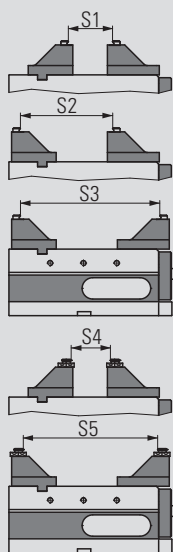
ALLMATIC GRIPP – mechanical / T-REX version (accessories)

Reduced-width jaws, 64 mm

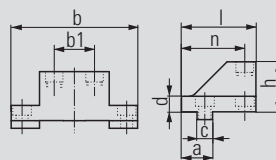


Please order gripper studs separately.

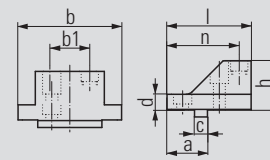
- Material: hardened steel
- Allows unhindered access to the workpiece, even with short tools
- For clamping small to medium-sized workpieces
- The clamping of unmachined parts (incl. round material) is supported via 2 adjustable gripper studs in each case (gripper studs not supplied with the jaws)
- Jaws with Click system for parallels
- Front surface can be used as clamping surface (hardened, ground and polished)
- Studs (pointed/smooth) **not** included



Order no. fixed:
6921884040140



Order no. movable:
6921884040040



Jaw width	125
Dimensions in mm	
a	28
b	116
b1	37
c	14
d	14
h	45
l	67
n	56

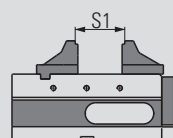
Jaw width	125
Dimensions in mm	
a	37.5
b	96
b1	37
c	12
d	14
h	45
l	79
n	67

Clamping range S1	21 – 68
Clamping range S2	66 – 138
Clamping range S3	131 – 209
Clamping range S4	21 – 68
Clamping range S5	131 – 209

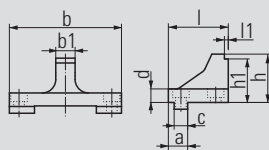
Reduced-width jaws, 20 mm



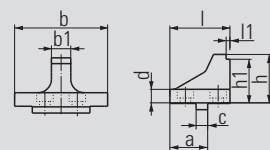
- Material: Hardened steel
- For clamping parallel pre-machined small workpieces
- Further enhanced accessibility to the workpiece thanks to slim, tall shape – also optimal for short tools
- Front surface (step) additionally carbide-coated to ensure secure clamping – holding force increased by at least a factor of 2 compared to smooth clamping surfaces



Order no. fixed:
6921884041141



Order no. movable:
6921884041041



Jaw width	125
Dimensions in mm	
a	20
b	116
b1	20
c	14
d	14
h	50
h1	45
l	62
l1	4

Jaw width	125
Dimensions in mm	
a	39
b	96
b1	20
c	12
d	14
h	50
h1	45
l	62
l1	4

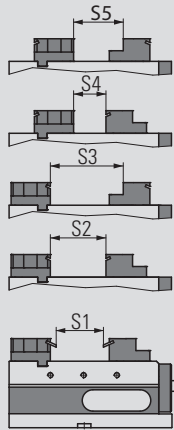
Clamping range S1	9 – 75
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ALLMATIC GRIPP – mechanical / T-REX version (accessories)

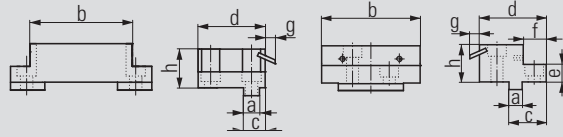
Universal pull-down jaws



- Material: hardened steel
- Reduced-width jaws 90 mm
- Ground and polished clamping surfaces
- Pull-down with ground and polished spring leaves for machined and unmachined clamping surfaces
- 1-Click spring leaves
- High clamping accuracy for parallel and accurate angle machining



Order no. fixed: 6921884106031 Order no. movable: 6921884102031



Jaw width	125	
Dimensions in mm	a	14
	b	90
	c	19
	d	59
	g	8,8
	h	34

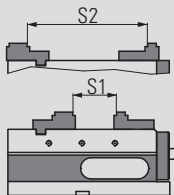
Jaw width	125	
Dimensions in mm	a	12
	b	90
	c	34
	d	61
	e	16
	f	21
	g	8,8
	h	34

Clamping range S1	0 – 82
Clamping range S2	18 – 100
Clamping range S3	44 – 126
Clamping range S4	0 – 65
Clamping range S5	23 – 88

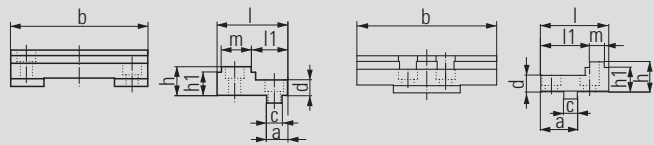
Step jaws HM - coated



- Material: hardened steel
- For clamping parallel pre-machined workpieces
- Clamping surfaces (step) additionally carbide – coated to ensure secure clamping – this increases the holding force by a factor of at least 2 compared to smooth clamping surface



Order no. fixed: 6921884006041 Order no. movable: 6921884002041



Jaw width	125	
Abmessungen in mm	a	19
	b	124,4
	c	14
	d	14
	h	26
	h1	21
	l	64
	l1	33
	m	27

Jaw width	125	
Abmessungen in mm	a	32,5
	b	124,4
	c	12
	d	14
	h	26
	h1	21
	l	60,5
	l1	43,5
	m	13

Clamping range S1	9 – 67
Clamping range S2	100 – 183

ALLMATIC GRIPP – mechanical / T-REX version (accessories)

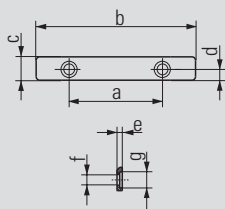
Spring leaves (pair)



Order no. 6921884103031

- Hardened spring leaves
- Spring leaves (spare) for the pull-down jaws (see left)

Parallels (pair)



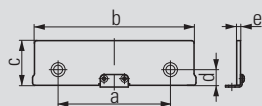
Order no. 6921475013031

Jaw width	90	
Dimensions in mm	a	52
	b	89
	c	13
	d	6
	e	3
	f	Ø 6
	g	Ø 9

- Suitable only for the universal pull-down jaws
- For parallel raising of workpieces
- Hardened, ground and polished parallels

- Bolt-on parallels
- For the high side of the jaws

Click parallels (pair)



Order no. 6921175029042

Jaw width	90	
Dimensions in mm	a	48
	b	90
	c	29
	d	8.75
	e	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels

- Parallels with Click system
- For the high side of the jaws

Click parallels (pair)



Order no. 6921175016042

Jaw width	90	
Dimensions in mm	a	48
	b	90
	c	16
	d	8.75
	e	3

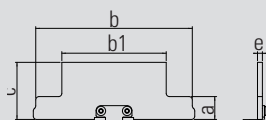
- For parallel raising of workpieces
- Hardened, ground and polished parallels

- Parallels with Click system
- For the high side of the jaws

ALLMATIC GRIPP – mechanical / T-REX version (accessories)

Click parallels (pair)

Order no. 6921535035042



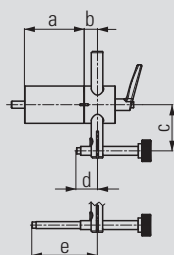
Jaw width	90	
Dimensions in mm	a	14
	b	96
	b1	64
	c	35
	e	3

- For parallel raising of workpieces
- Hardened, ground and polished parallels

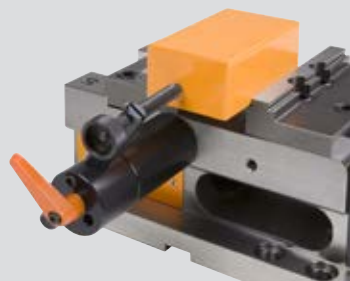
- Parallels with Click system
- For the high side of jaw

Workpiece stop

Order no. 6921285650144



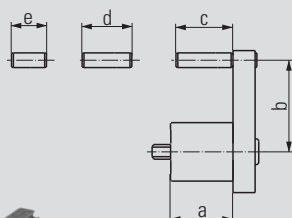
Dimensions in mm	a	67
	b	15
	c	33 – 92
	d	12 – 63,5
	e	53,5 – 113,5



- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Position of the third workpiece axis can be preset and clamped
- Workpiece stop can be swivelled away once the workpiece has been clamped
- This allows the stop side of the workpiece to also be machined (repeating accuracy: ± 0.01)

Workpiece stop

Order no. 6921685670042



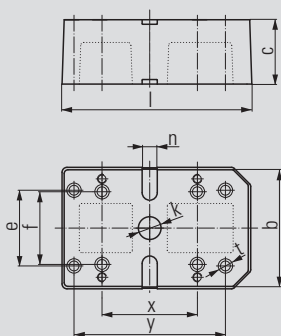
Dimensions in mm	a	34
	b	27 – 59
	c	31
	d	27
	e	19



- Can be mounted on either side of the vice in the designated positions
- M8 fastening thread
- Can be pre-mounted with various fixed dimensions
- Position of the third workpiece axis can be preset

ALLMATIC GRIPP – mechanical / T-REX version (accessories)

Console



Order no. 6921885009042

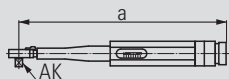
Jaw width	125	
Dimensions in mm	b	154
	c	85
	e	100
	f	96
	l	250
	n	20 H7
	k	Ø 30 H7
	t	13
	x	125.5
	y	200

- Material: GG30
- For raising the T-REX 125 vice
- Improvement of accessibility for five-sided machining
- The mounting hole pattern of T-REX and console are not in alignment

Scope of supply:

- Console incl. fixing bolt
- 2 socket screw wrenches
- 4 bolts

Torque wrench



Order no. 0651114113188

Dimensions in mm	a	307
	AK (Drive square)	3/8"

- Can be preset to 10 – 60 Nm
- For use on the high-pressure gripper spindles T-REX, TITAN and DUO Plus 125

Aligning and fixing set



Order no. – see table

T-slot/ thread	Order no.
12/M10	6921285600031
14/M12	6921285601031
16/M14	6921285602031
18/M16	6921285603031
20/M16	6921285606031
22/M16	6921285607031

- For aligning (positioning) and fastening the vice on pallet and machine table
- Size according to T-slot or thread in the machine table