MANOK

Small but powerful

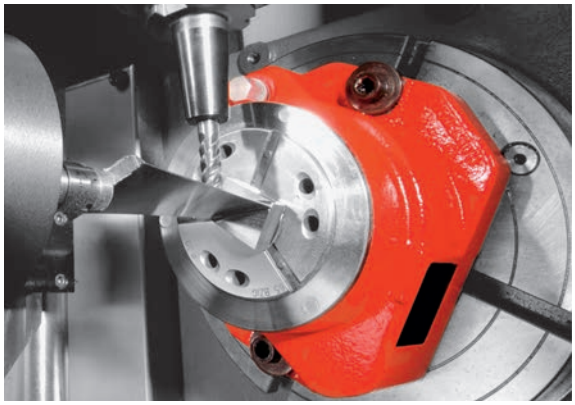
Manual stationary chuck MANOK

It isn't just the price-performance ratio of MANOK that is impressive. With its incredible holding power, precision and rigidity, MANOK has already surprised many users who never would have imagined that this kind of quality could be found in a manual clamping device. In addition, you can also mount an end-stop to the MANOK in no time at all: Simply fasten the inside end-stop directly onto your machine tool table or mount a front end-stop on the face of the clamping taper. That's it!

MANOK is not only practical and economical, but it is also extremely versatile. For instance, the integrated actuation lever makes this possible by functioning as an additional force accumulator and acts as an anti-vibration device during milling.

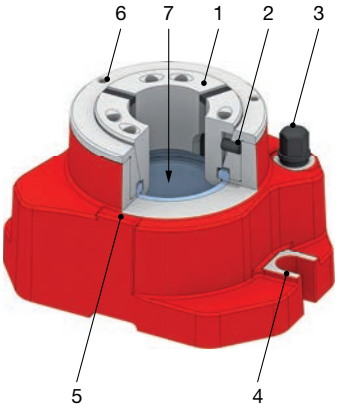
Key advantages

- Easy set-up
- Sensitive manual clamping is possible
- Ideal for 5-sided machining
- Clamping is possible with workpiece end-stop or front end-stop
- Absolute versatile implementation on machining centers, measuring machines, slotters, broaching machines, drilling machines, laser marking machines etc.
- Workpiece stabilization through axial draw force applied against the workpiece end-stop

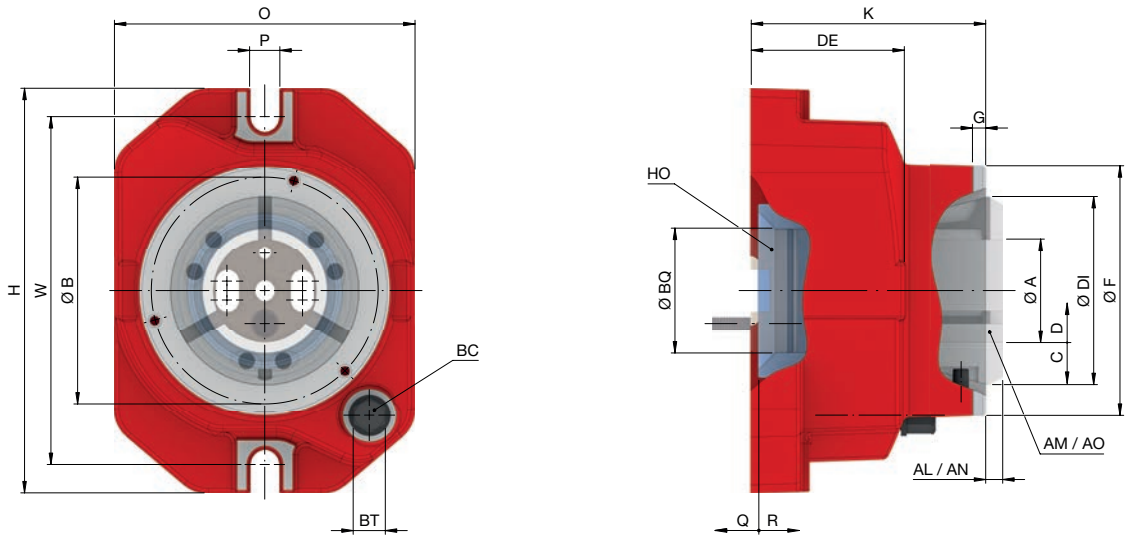


MANOK manual stationary chuck in use.
Photo: OEM Berthold Hermle

Manual stationary chuck MANOK in detail

Designation	
1 Clamping head with hardened steel segments joined in a vulcanization process 2 Torsional safety lock of the clamping head 3 Manual actuation via hexagonal nut 4 Mounting groove 5 Supporting surface for additional holding clamps 6 Reception for front end-stop 7 Full passage available	

Manual stationary chuck MANOK. Technical data and order overview



Size		42	52	65	80	100
Clamping range [mm]	A	**3 – 42**	**3 – 52**	**3 – 65**	**4 – 80**	**15 – 100**
Repeatability ≤ [mm]		0,010				
Max. radial clamping force [kN]		80	94	105	115	150
Max. axial drawtube force [pull / push] [kN]		35	40	45	50	65
Max. actuating torque [Nm]	BC	50	60	70	60	80
Bolt hole distance [mm]	W	184			236	
Release stroke in Ø [mm]	C	0,6				2
RPM n max. [1/min.]		60				
Reserve stroke in Ø [mm]	D	1				1,5
Reserve stroke axial [mm]	Q	2				3
Release stroke axial [mm]	R	2,5			5	
Location front end-stop	F	Ø 132 f7			Ø 178 f7	
Centering length [mm]	G	7			11,5	
Bolt hole circle end-stop	B	LK Ø 120 [3 x M6]			LK Ø 165 [3 x M6]	
Ø Capacity [mm]	BQ	56		66	80,5	102
Length [mm]	H	214			264	
Overall height [mm]	K	124			140	
Width [mm]	O	159			210	
Screw connection width [mm]	P	16			16,6	
Clamping edge height [mm]	DE	81			93	
Wrench size [SW]	BT	17				
Head Ø [mm]	DI	80		99,5	115	144,5
Clamping head serrated	AM	SK 42 BZI	SK 52 BZI	SK 65 BZI	SK 80 BZI	SK 100 BZ
Clamping head protrusion length serrated [mm]	AL	9	4	9	4	0
Clamping head smooth	AO	SK 42 BZIG	SK 52 BZIG	SK 65 BZIG	SK 80 BZIG	SK 100 BZG
Clamping head protrusion length smooth [mm]	AN	4				0
Workpiece end-stop	HO	available as accessory				
Weight [kg]		14,3	14,1	12,9	22,3	21,6
In stock		✔	✔	✔	✔	✔
Material no.		10001427	10001426	10001425	10001430	10001424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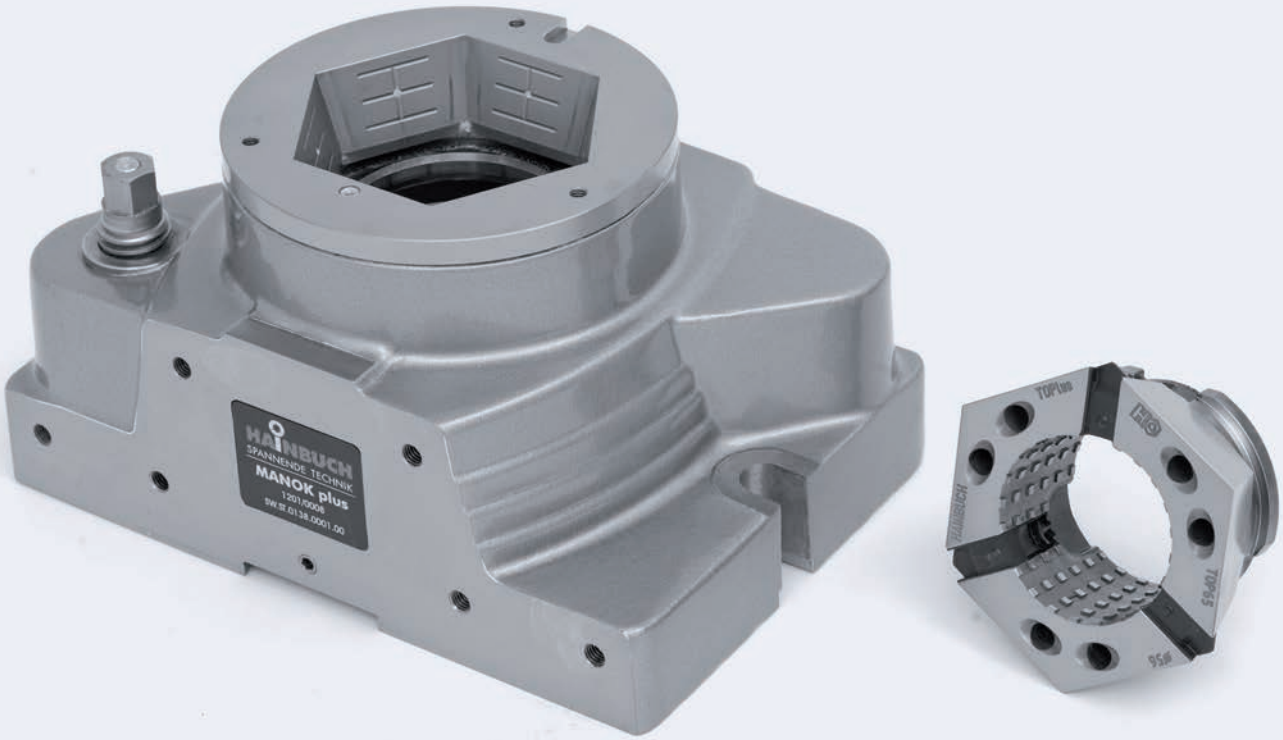
Scope of delivery

- Stationary chuck
- Actuation tool

MANOK plus

Incredibly versatile

HAINBUCH SYSTEM



MANOK plus, the extended variant of our manual MANOK stationary chuck differs through use of adaptation elements. For example, many more clamping possibilities are available to you in combination with the MANDO Adapt mandrel-in-chuck or the jaw module for even larger clamping diameters.

And most recent: Due to the optional lightweight CFRP design, with the MANOK plus CFK you can save half of the weight. The lightweights are easy to set-up and particularly well-suited for milling machines and machining centers with small load weights. Plus they protect machine components, which ultimately helps the machine accuracy. When loading manually or with a handling system, often the only possible solution is a lightweight stationary chuck.

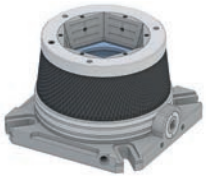
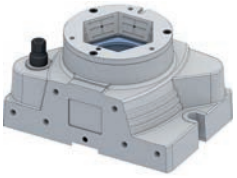
Key advantages

- Also available in a CFRP lightweight design
- Sensitive manual clamping is possible
- Workpiece stabilization through axial draw force applied against the workpiece end-stop
- Ideal for 5-sided machining
- Adaptation devices possible [HAINBUCH SYSTEM]

MANOK plus manual stationary chuck in use

Manual stationary chuck MANOK plus

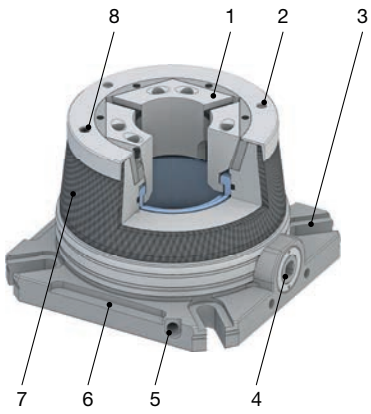
MANOK plus at a glance

	MANOK plus CFK	MANOK plus
		
Description	Hand-actuated lightweight clamping device	Manual stationary chuck
Variant	SE [hexagonal] / RD [round]	SE [hexagonal] / RD [round]
Advantages	■ Made of carbon fiber ■ As much as 60 % lighter than the standard model	■ Lateral set-up on optional baseplate is possible
Clamping elements	 Clamping head SE  Clamping head RD	 Clamping head SE  Clamping head RD
Adaptations	 MANDO Adapt T211 SE / RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE / RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE / RD [Adaptation for jaw clamping]  Magnet module SE / RD [Adaptation for magnetic clamping]	 MANDO Adapt T211 SE / RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE / RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE / RD [Adaptation for jaw clamping]  Magnet module SE / RD [Adaptation for magnetic clamping

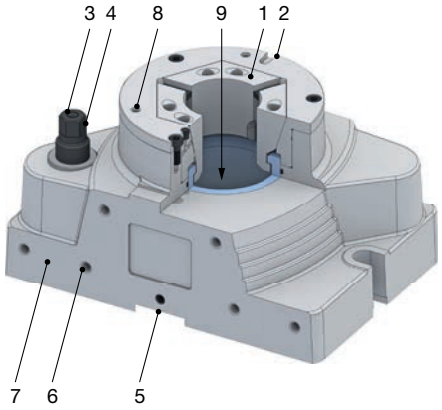
Manual stationary chuck MANOK plus CFK SE in detail

Designation

1 Clamping head with hexagonal geometry for optimal chuck seal and greater clamping force
2 Reception for front end-stop
3 Mounting groove
4 Manual actuation
5 Clamping screw for base end-stop
6 Supporting surface for additional holding clamps
7 Chuck body made of carbon fiber
8 Grease nipple



Manual stationary chuck MANOK plus SE in detail

Designation	
1 Clamping head with hexagonal geometry for optimal chuck seal and greater clamping force 2 Reception for front end-stop with guide groove for radial alignment 3 Central grease nipple, optimal draw-in force due to perfect lubrication 4 Manual actuation via hexagonal nut 5 Guide groove for table alignment 6 Thread for mounting end-stops or for horizontal clamping set-up 7 Ground surface for horizontal set-up 8 Reception for front end-stop 9 Full passage after removal of the base end-stop that is accessible from the outside	

Order overview.
Manual stationary chuck MANOK plus CFK SE / RD

				Clamping elements and adaptations				
								
Product line	Size	Material no.	In stock	Clamping head SE Page 422	MANDO Adapt T211 SE Page 274	MANDO Adapt T212 SE Page 280	Jaw module SE Page 316	Magnet module SE Page 332
SE	52	10000484	-	✔	✔	✔		✔
	65	10000485	-	✔	✔	✔	✔	✔
Product line	Size	Material no.	In stock	Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	Jaw module RD Page 316	Magnet module RD Page 332
RD	52	10000482	-	✔	✔	✔		✔
	65	10000483	-	✔	✔	✔	✔	✔

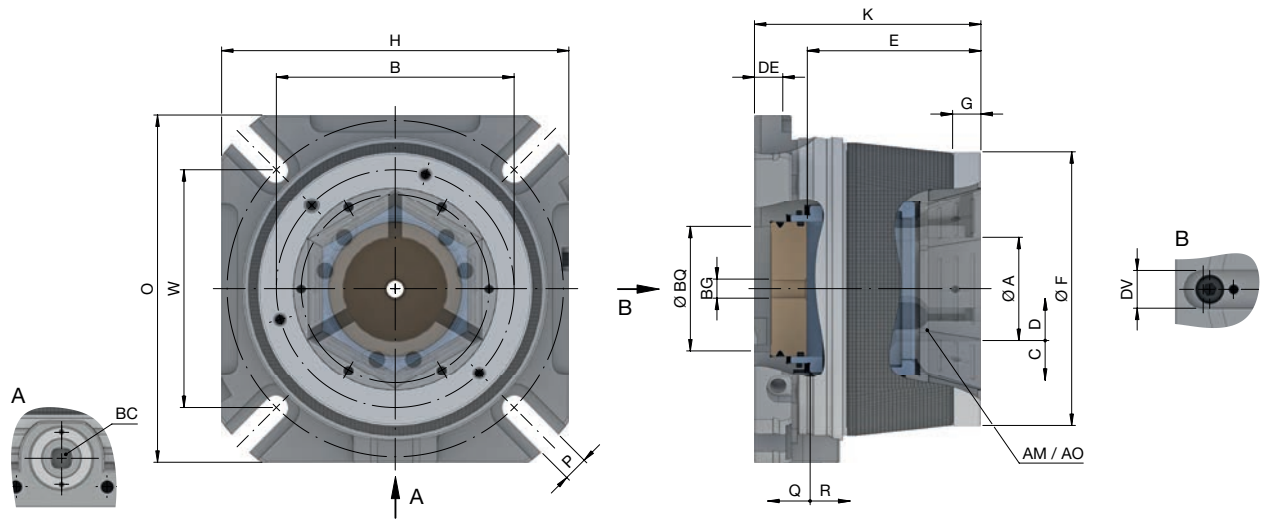
Detailed technical data follows.

Order overview.
Manual stationary chuck MANOK plus SE / RD

				Clamping elements and adaptations				
								
Product line	Size	Material no.	In stock	Clamping head SE Page 422	MANDO Adapt T211 SE Page 274	MANDO Adapt T212 SE Page 280	Jaw module SE Page 316	Magnet module SE Page 332
SE	65	10001429	✔	✔	✔	✔	✔	✔
Product line	Size	Material no.	In stock	Clamping head RD Page 430	MANDO Adapt T211 RD Page 290	MANDO Adapt T212 RD Page 296	Jaw module RD Page 316	Magnet module RD Page 332
RD	65	10001428	✔	✔	✔	✔	✔	✔

Detailed technical data follows.

Manual stationary chuck MANOK plus CFK SE. Technical data



Product line		SE	
Size		**52**	**65**
Clamping range [mm]	A	3 – 52	3 – 65
Repeatability ≤ [mm]		0,010	
Max. radial clamping force [kN]		108	120
Max. axial drawtube force [pull / push] [kN]		40	45
Max. actuating torque [Nm]	BC	75	90
Release stroke in Ø [mm]	C	0,6	
RPM n max. [1/min.]		60	
Reserve stroke in Ø [mm]	D	1	
Reserve stroke axial [mm]	Q	2	
Release stroke axial [mm]	R	2,5	
Location front end-stop	F	Ø 125 f7	Ø 145 f7
Centering length [mm]	G	15	
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]
End-stop depth [mm]	E	90	92
End-stop thread size [M]	BG	10	12
Ø Capacity [mm]	BQ	53	66
Length [mm]	H	161	184
Overall height [mm]	K	115	120
Width [mm]	O	161	184
Screw connection width [mm]	P	13	
Clamping edge height [mm]	DE	15	
Bolt hole distance [mm]	W	120	126
Groove seat	DV	14 H7	20 H7
Clamping head serrated	AM	TOP 52	TOP 65
Clamping head smooth	AO	TOP 52 G	TOP 65 G
Weight [kg]		7	10,3
In stock		-	-
Material no.		10000484	10000485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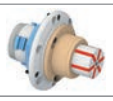
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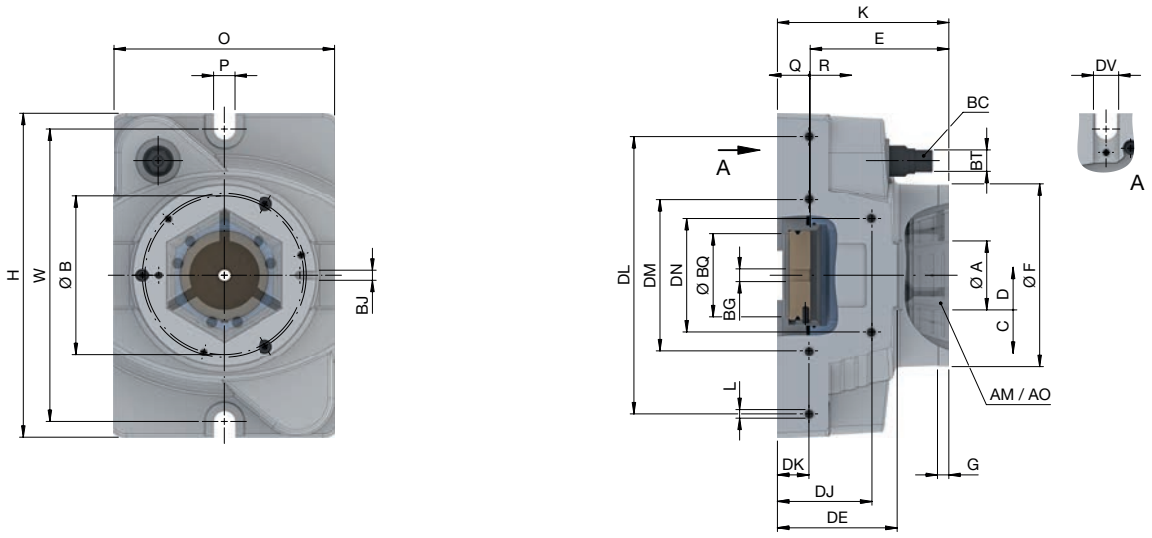
Scope of delivery

- Stationary chuck
- Base end-stop
- Actuation tool

Manual stationary chuck MANOK plus SE. Technical data



Product line		SE
Size		**65**
Clamping range [mm]	A	3 – 65
Repeatability ≤ [mm]		0,010
Max. radial clamping force [kN]		120
Max. axial drawtube force [pull / push] [kN]		45
Max. actuating torque [Nm]	BC	100
Release stroke in Ø [mm]	C	0,6
RPM n max. [1/min.]		60
Reserve stroke in Ø [mm]	D	1
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5
Location front end-stop	F	Ø 145 f7
Centering length [mm]	G	9
Bolt hole circle end-stop	B	LK Ø 126 [3 x M6]
Groove width [mm]	BJ	8 H7
End-stop depth [mm]	E	110
End-stop thread size [M]	BG	12
Ø Capacity [mm]	BQ	66
Length [mm]	H	257
Overall height [mm]	K	136
Width [mm]	O	175
Screw connection width [mm]	P	17
Clamping edge height [mm]	DE	95
Thread size [M]	L	8
Screw-on height 1 [mm]	DJ	75
Screw-on height 2 [mm]	DK	25
Screw connection spacing 1 [mm]	DL	220
Screw connection spacing 2 [mm]	DM	120
Screw connection spacing 3 [mm]	DN	90
Bolt hole distance [mm]	W	232
Groove seat	DV	20 H7
Wrench size [SW]	BT	17
Clamping head serrated	AM	TOP 65
Clamping head smooth	AO	TOP 65 G
Weight [kg]		23,5
In stock		✔
Material no.		10001429



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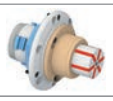
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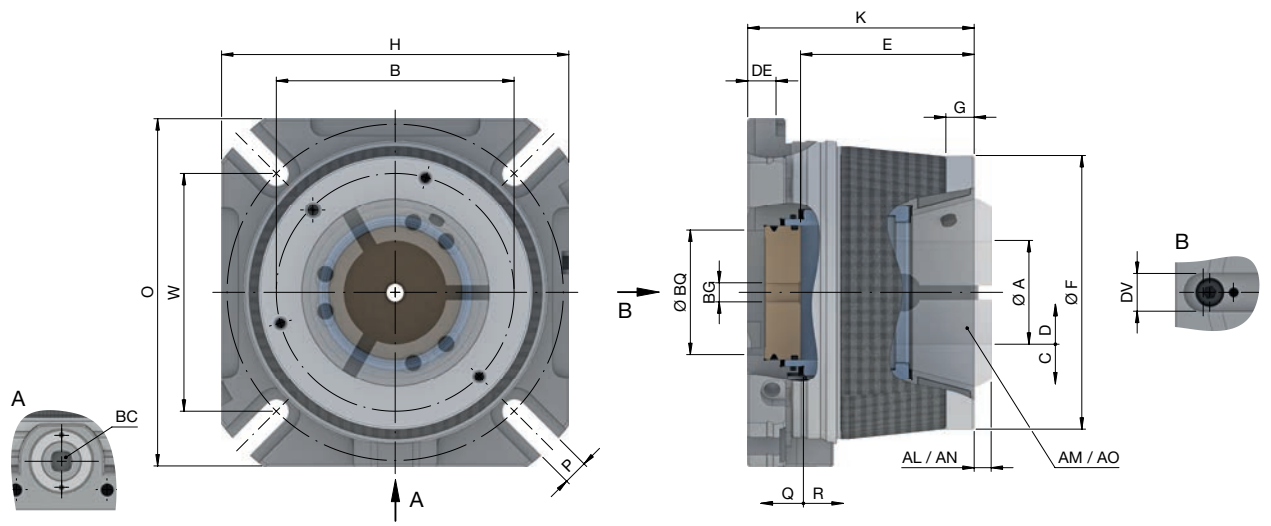
Scope of delivery

- Stationary chuck
- Base end-stop
- Actuation tool

Manual stationary chuck MANOK plus CFK RD. Technical data



Product line		RD	
Size		**52**	**65**
Clamping range [mm]	A	3 – 52	3 – 65
Repeatability ≤ [mm]		0,010	
Max. radial clamping force [kN]		94	105
Max. axial drawtube force [pull / push] [kN]		40	45
Max. actuating torque [Nm]	BC	75	90
Release stroke in Ø [mm]	C	0,6	
RPM n max. [1/min.]		60	
Reserve stroke in Ø [mm]	D	1	
Reserve stroke axial [mm]	Q	2	
Release stroke axial [mm]	R	2,5	
Location front end-stop	F	Ø 125 f7	Ø 145 f7
Centering length [mm]	G	15	
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]
End-stop depth [mm]	E	90	92
End-stop thread size [M]	BG	10	12
Ø Capacity [mm]	BQ	53	66
Length [mm]	H	161	184
Overall height [mm]	K	115	120
Width [mm]	O	161	184
Screw connection width [mm]	P	13	
Clamping edge height [mm]	DE	15	
Bolt hole distance [mm]	W	120	126
Groove seat	DV	14 H7	20 H7
Clamping head serrated	AM	SK 52 BZI	
Clamping head protrusion length serrated [mm]	AL	4	9
Clamping head smooth	AO	SK 52 BZIG	SK 65 BZIG
Clamping head protrusion length smooth [mm]	AN	4	
Weight [kg]		7	10,3
In stock		-	-
Material no.		10000482	10000483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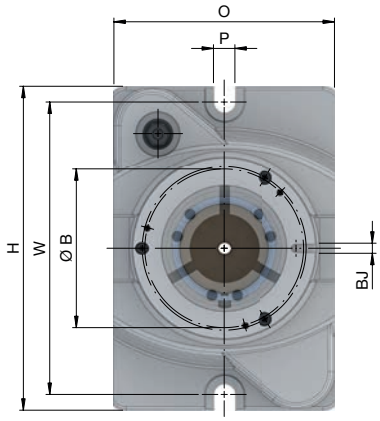
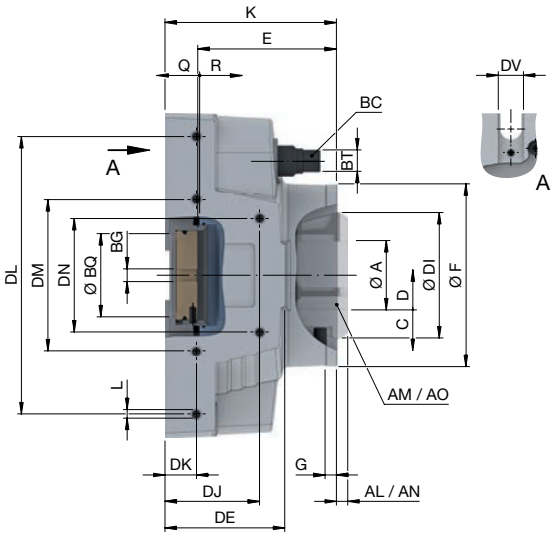
Scope of delivery

- Stationary chuck
- Base end-stop
- Actuation tool

Manual stationary chuck MANOK plus RD. Technical data





Product line		RD
Size		**65**
Clamping range [mm]	A	3 – 65
Repeatability ≤ [mm]		0,010
Max. radial clamping force [kN]		105
Max. axial drawtube force [pull / push] [kN]		45
Max. actuating torque [Nm]	BC	100
Release stroke in Ø [mm]	C	0,6
RPM n max. [1/min.]		60
Reserve stroke in Ø [mm]	D	1
Reserve stroke axial [mm]	Q	2
Release stroke axial [mm]	R	2,5
Location front end-stop	F	Ø 145 f7
Centering length [mm]	G	9
Bolt hole circle end-stop	B	LK Ø 126 [3 x M6]
Groove width [mm]	BJ	8 H7
End-stop depth [mm]	E	110
End-stop thread size [M]	BG	12
Ø Capacity [mm]	BQ	66
Length [mm]	H	257
Overall height [mm]	K	136
Width [mm]	O	175
Screw connection width [mm]	P	17
Clamping edge height [mm]	DE	95
Thread size [M]	L	8
Screw-on height 1 [mm]	DJ	75
Screw-on height 2 [mm]	DK	25
Screw connection spacing 1 [mm]	DL	220
Screw connection spacing 2 [mm]	DM	120
Screw connection spacing 3 [mm]	DN	90
Bolt hole distance [mm]	W	232
Groove seat	DV	20 H7
Wrench size [SW]	BT	17
Head Ø [mm]	DI	99,5
Clamping head serrated	AM	SK 65 BZI
Clamping head protrusion length serrated [mm]	AL	9
Clamping head smooth	AO	SK 65 BZIG
Clamping head protrusion length smooth [mm]	AN	4
Weight [kg]		23,5
In stock		✔
Material no.		10001428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Scope of delivery

- Stationary chuck
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