



MANDO Adapt

Mandrel-in-clamping-device





ADAPTATION CLAMPING DEVICES **MANDO Adapt [mandrel adaptation]**

Change-over from O.D. clamping to perfect I.D. clamping, without changing the clamping device? No problem with MANDO Adapt. Place the mandrel in the mounted clamping device, tighten three screws and lock the mandrel in the clamping device. In this process the mandrel engages in the coupling of the clamping device via a sophisticated mechanism, where otherwise the clamping head engages. MANDO Adapt is attractive with extreme rigidity and precision. For rotating products, run-out of 0.005 mm between chuck taper and mandrel taper can be achieved. For stationary clamping devices repeatability of 0.003 mm is possible. And best of all, this can be accomplished without alignment.

Ingeniously simple and effective, genuine HAINBUCH!

Key advantages

- Extremely fast conversion without detachment of the basic clamping device [1 – 2 min.]
- Large clamping range and vibration dampening due to vulcanized clamping elements
- Standard segmented clamping bushings and work-piece end-stops for machining to size available

ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt at a glance

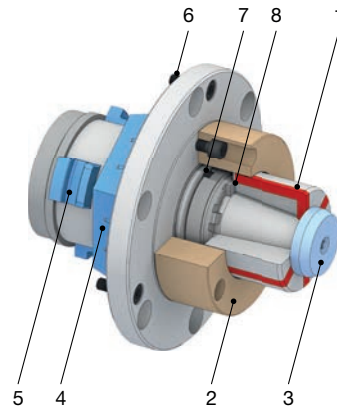
	MANDO Adapt T211	MANDO Adapt T212	MANDO Adapt T812
			
Description	Mandrel-in-clamping-device, with draw bolt / pull-back	Mandrel-in-clamping-device, without draw bolt / pull-back	Mandrel-in-clamping-device, without draw bolt / deadlength
Sizes	0, 1, 2, 3, 4	XXS, XS, S, 0, 1, 2, 3, 4, 5, 6, 7	XS, S, 0, 1, 2, 3, 4
Clamping range of all sizes [mm]	20 – 120	8 – 190	13 – 100
Variant	SE [hexagonal], RD [round]	SE [hexagonal], RD [round]	RD [round]
Actuation	Draw	Draw	Pressure
Advantages	■ Workpiece stabilization through axial draw force applied against the workpiece end-stop ■ Less expensive segmented clamping bushings and end-stops compared to MANDO T212	■ Workpiece stabilization through axial draw force applied against the workpiece end-stop ■ Clamping without draw bolt, consequently ideal for blind bores	■ Radial clamping, without pull-back – ideal for pick-off the main spindle ■ Clamping without draw bolt, consequently ideal for blind bores



MANDO Adapt T211 SE in detail

Designation

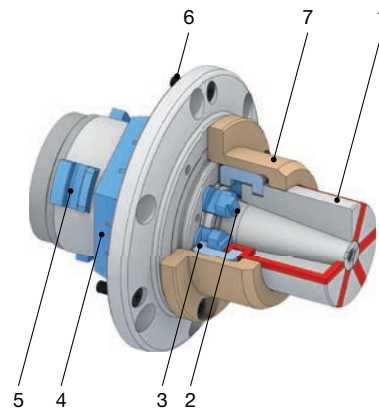
- 1 Vulcanized segmented clamping bushing made of case-hardened steel [60 HRC]
- 2 End-stop
- 3 Draw bolt
- 4 CENTREX system for μm -precise use without adjustment
- 5 Coupling: Mandrel locks automatically when the draw bolt is screwed in
- 6 Mounting screws for quick change-over
- 7 Integrated, and thus optimal forced release of the clamping
- 8 Torsional safety lock of segmented clamping bushing



MANDO Adapt T212 SE in detail

Designation

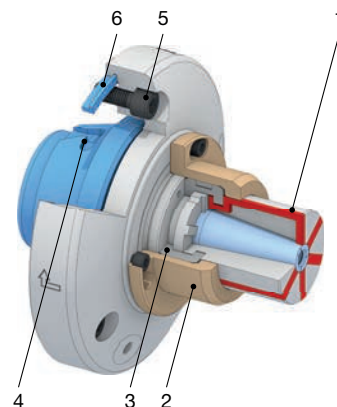
- 1 Vulcanized segmented clamping bushing made of case-hardened steel [60 HRC]
- 2 High rigidity due to one-piece crown coupling with integrated entrainment of the segmented clamping bushing
- 3 Coupling ring for fast changing of the segmented clamping bushing
- 4 CENTREX system for μm -precise use without adjustment
- 5 Coupling: Mandrel is locked via separate key
- 6 Mounting screws for quick change-over
- 7 End-stop



MANDO Adapt T812 RD in detail

Designation

- 1 Vulcanized segmented clamping bushing made of case-hardened steel [60 HRC]
- 2 End-stop
- 3 Coupling ring for fast changing of the segmented clamping bushing
- 4 Bayonet coupling
- 5 Mounting screws for quick change-over
- 6 CENTREX system for μm -precise use without adjustment



ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T211 SE. Order overview

Suitable for



Size	Clamping range [mm]	Adap-tation size	Material no.	In stock	TOPlus mini pull-back Page 26	TOPlus premium pull-back Page 46	TOPlus combi pull-back Page 58	TOPlus modular Page 58	TOROK SE Page 122	HYDROK SE Page 252	MANOK plus SE Page 244
0	20 – 28	52	10000999	-	✓	✓					
			10001574	✓			✓	✓	✓	✓	✓
		65	10001002	✓	✓	✓					
			10001577	✓			✓	✓	✓	✓	✓
		80	10017061	✓	✓	✓					
			10001007	✓							
			10001582	✓			✓	✓	✓	✓	✓
1	26 – 38	52	10001000	-	✓	✓					
			10001575	✓			✓	✓	✓	✓	✓
		65	10001003	✓	✓	✓					
			10001578	✓			✓	✓	✓	✓	✓
		80	10017067	✓	✓	✓					
			10001008	✓							
			10001583	✓			✓	✓	✓	✓	✓
2	36 – 54	52	10001001	-	✓	✓					
			10001576	✓			✓	✓	✓	✓	✓
		65	10001004	✓	✓	✓					
			10001579	✓			✓	✓	✓	✓	✓
		80	10017068	✓	✓	✓					
			10001009	✓							
			10001584	✓			✓	✓	✓	✓	✓
3	50 – 80	65	10001005	✓	✓	✓					
			10001580	✓			✓	✓	✓	✓	✓
		80	10017069	✓	✓	✓					
			10001010	✓							
		100	10001585	✓			✓	✓	✓	✓	✓
4	69 – 120	65	10001006	✓	✓	✓					
			10001581	✓			✓	✓	✓	✓	✓
		80	10017070	✓	✓	✓					
			10001011	✓							
		100	10001586	✓			✓	✓	✓	✓	✓

Detailed technical data follows.

Scope of delivery

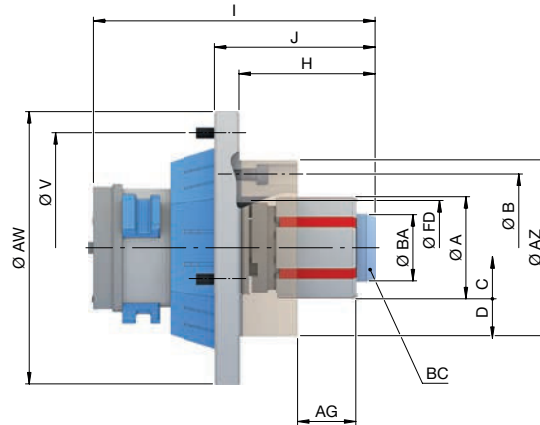
- Adaptation mandrel
- Draw bolt



ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T211 SE. Technical data



Size	0							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A	20 – 28						
Run-out ≤ [mm]	0,010							
Max. radial clamping force [kN]	42							
Max. axial drawtube force [pull / push] [kN]	10							
Max. clamping length [mm]	AG	22						
Release stroke in Ø [mm]	C	0,4						
Reserve stroke in Ø [mm]	D	0,3						
Range / recommended workpiece tolerance [mm]	± 0,25							
RPM n max. [1/min.]	7000		6000		5500	5000		
Max. actuating torque [Nm]	BC	10						
Draw bolt Ø [mm]	BA	19						
Reception workpiece end-stop	FD	Ø 32 f7						
End-stop outer Ø [mm]	AZ	65						
Bolt hole circle end-stop	B	LK Ø 50 [3 x M6]						
Length [mm]	H	42,3	42					
Total length [mm]	I	109	119			129		
Height [mm]	J	55						
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	119	125	129	144	150	183	215
Weight [kg]	2,2		3,3	3,4	5	8,1	9	
In stock	-	✓	✓	✓	✓	✓	✓	
Material no.	10000999	10001574	10001002	10001577	10017061	10001007	10001582	

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

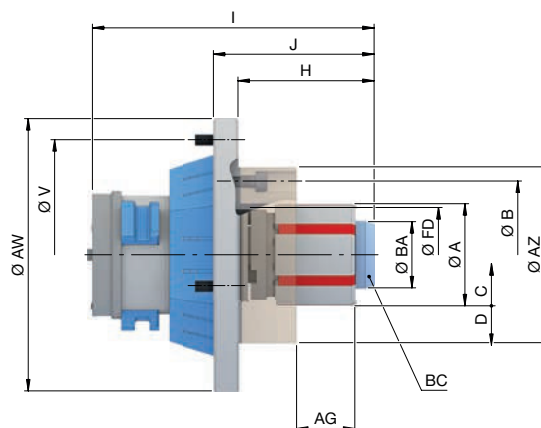


ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T211 SE. Technical data



Size	1						
Adaptation size	52		65		80	100	
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium
Clamping range [mm]	A	26 – 38					
Run-out ≤ [mm]	0,010						
Max. radial clamping force [kN]	42						
Max. axial drawtube force [pull / push] [kN]	10						
Max. clamping length [mm]	AG	26					
Release stroke in Ø [mm]	C	0,4					
Reserve stroke in Ø [mm]	D	0,3					
Range / recommended workpiece tolerance [mm]	± 0,25						
RPM n max. [1/min.]	7000		6000		5500	5000	
Max. actuating torque [Nm]	BC	20					
Draw bolt Ø [mm]	BA	25					
Reception workpiece end-stop	FD	Ø 41 f7					
End-stop outer Ø [mm]	AZ	69					
Bolt hole circle end-stop	B	LK Ø 55 [3 x M6]					
Length [mm]	H	52				51,5	
Total length [mm]	I	119	129			139	
Height [mm]	J	65					
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]
Outer Ø [mm]	AW	119	125	129	144	150	183
Weight [kg]	2,3		3,4	3,5	5	8,3	9,2
In stock	-	✓	✓	✓	✓	✓	✓
Material no.	10001000	10001575	10001003	10001578	10017067	10001008	10001583

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



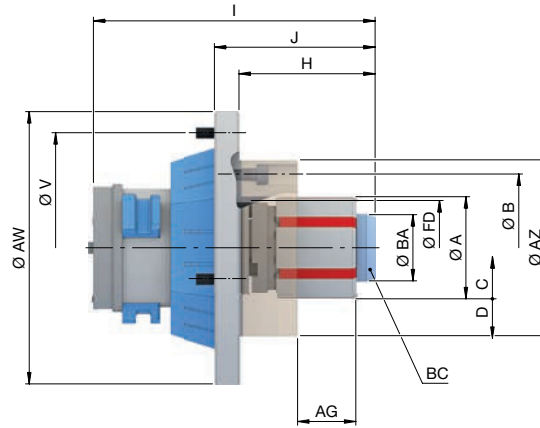
Segmented clamping bushings Page 448	Accessory overview Page 478



ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T211 SE. Technical data



Size	2							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A	36 – 54						
Run-out ≤ [mm]	0,010							
Max. radial clamping force [kN]	85							
Max. axial drawtube force [pull / push] [kN]	20							
Max. clamping length [mm]	AG	43						
Release stroke in Ø [mm]	C	0,4	0,3		0,5		0,3	
Reserve stroke in Ø [mm]	D	0,3	0,5		0,3		0,5	
Range / recommended workpiece tolerance [mm]	± 0,25							
RPM n max. [1/min.]	7000		6000		5500	5000		
Max. actuating torque [Nm]	BC	25						
Draw bolt Ø [mm]	BA	35						
Reception workpiece end-stop	FD	Ø 50 f7						
End-stop outer Ø [mm]	AZ	93						
Bolt hole circle end-stop	B	LK Ø 78 [3 x M6]						
Length [mm]	H	72,3	72			71,5		
Total length [mm]	I	139	149			159		
Height [mm]	J	85						
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	119	125	129	144	150	183	215
Weight [kg]		2,6	3,7	3,8	5	8,6	9,5	
In stock		-	✓	✓	✓	✓	✓	✓
Material no.		10001001	10001576	10001004	10001579	10017068	10001009	10001584

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

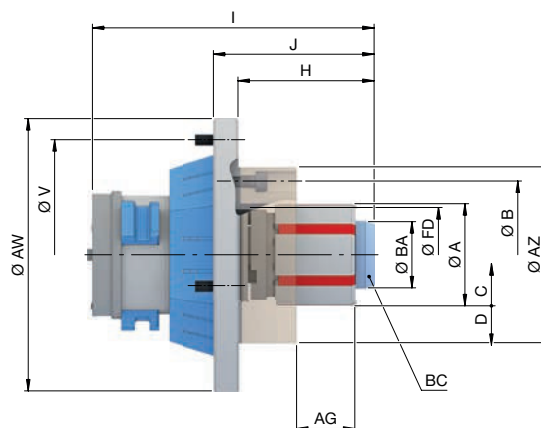


ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T211 SE. Technical data

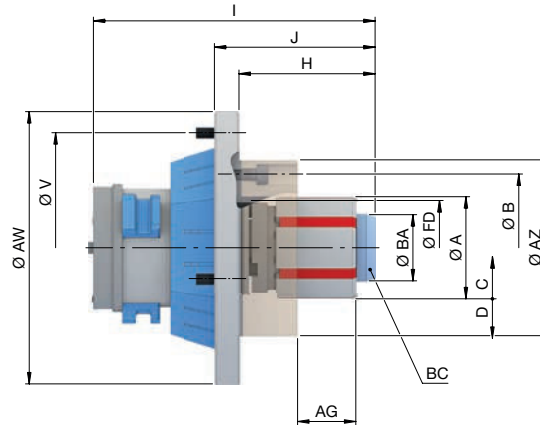


Size	3				
Adaptation size	65		80	100	
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium
Clamping range [mm]	A	50 – 80			
Run-out ≤ [mm]		0,010			
Max. radial clamping force [kN]		105			
Max. axial drawtube force [pull / push] [kN]		25			
Max. clamping length [mm]	AG	49			
Release stroke in Ø [mm]	C	0,5			
Reserve stroke in Ø [mm]	D	0,4			
Range / recommended workpiece tolerance [mm]		± 0,35			
RPM n max. [1/min.]		6000	5500	5000	
Max. actuating torque [Nm]	BC	55			
Draw bolt Ø [mm]	BA	49			
Reception workpiece end-stop	FD	Ø 65 f7			
End-stop outer Ø [mm]	AZ	96			
Bolt hole circle end-stop	B	LK Ø 80 [3 x M6]			
Length [mm]	H	82	81,5		
Total length [mm]	I	159	169		
Height [mm]	J	95			
Bolt hole circle	V	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8] LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	129	144	150	183 215
Weight [kg]		4,4	4,5	6	9,3 10,2
In stock		✓	✓	✓	✓
Material no.		10001005	10001580	10017069	10001010 10001585



ADAPTATION CLAMPING DEVICES MANDO Adapt [mandrel adaptation]

MANDO Adapt T211 SE. Technical data



Size	4				
Adaptation size	65		80	100	
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium
Clamping range [mm]	A	69 – 120			
Run-out ≤ [mm]	0,010				
Max. radial clamping force [kN]	150				
Max. axial drawtube force [pull / push] [kN]	35				
Max. clamping length [mm]	AG	59			
Release stroke in Ø [mm]	C	0,5			
Reserve stroke in Ø [mm]	D	0,6		0,5	
Range / recommended workpiece tolerance [mm]	± 0,4				
RPM n max. [1/min.]	6000		5500	5000	
Max. actuating torque [Nm]	BC	65			
Draw bolt Ø [mm]	BA	68			
Reception workpiece end-stop	FD	Ø 78 f7			
End-stop outer Ø [mm]	AZ	120			
Bolt hole circle end-stop	B	LK Ø 90 [3 x M6]			
Length [mm]	H	97		96,5	
Total length [mm]	I	174		184	
Height [mm]	J	110			
Bolt hole circle	V	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8] LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	129	144	150	183 215
Weight [kg]		5,4	5,5	7	10,2 11,1
In stock		✓	✓	✓	✓
Material no.		10001006	10001581	10017070	10001011 10001586

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

For size 4, clamping range 101 – 120 mm, a max. speed of 4200 RPM applies.



ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T212 SE. Order overview

Suitable for



Size	Clamping range [mm]	Adap-tation size	Material no.	In stock	TOPlus mini pull-back Page 26	TOPlus premium pull-back Page 46	TOPlus combi pull-back Page 58	TOPlus modular Page 58	TOROK SE Page 122	HYDROK SE Page 252	MANOK plus SE Page 244
XXS	8 – 13	52	10001012	-	✓	✓					
			10001648	-			✓	✓	✓	✓	✓
		65	10001018	✓	✓	✓					
			10001656	✓			✓	✓	✓	✓	✓
		100	10017071	-	✓	✓					
			10001026	-							
			10001664	-			✓	✓	✓	✓	✓
XS	13 – 19	52	10001013	-	✓	✓					
			10001647	✓			✓	✓	✓	✓	✓
		65	10001019	✓	✓	✓					
			10001655	✓			✓	✓	✓	✓	✓
		100	10017072	✓	✓	✓					
			10001027	✓							
			10001663	✓			✓	✓	✓	✓	✓
S	16 – 21	52	10001014	-	✓	✓					
			10001646	✓			✓	✓	✓	✓	✓
		65	10001020	✓	✓	✓					
			10001654	✓			✓	✓	✓	✓	✓
		100	10017073	✓	✓	✓					
			10001028	✓							
			10001662	✓			✓	✓	✓	✓	✓
O	20 – 28	52	10001015	-	✓	✓					
			10001645	-			✓	✓	✓	✓	✓
		65	10001021	✓	✓	✓					
			10001653	✓			✓	✓	✓	✓	✓
		100	10017074	✓	✓	✓					
			10001029	✓							
			10001661	✓			✓	✓	✓	✓	✓

Detailed technical data follows.



ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T212 SE. Order overview

					Suitable for						
											
Size	Clamping range [mm]	Adap-tation size	Material no.	In stock	TOPlus mini pull-back Page 26	TOPlus premium pull-back Page 46	TOPlus combi pull-back Page 58	TOPlus modular Page 58	TOROK SE Page 122	HYDROK SE Page 252	MANOK plus SE Page 244
1	26 – 38	52	10001016	-	✓	✓					
			10001644	✓			✓	✓	✓	✓	✓
		65	10001022	✓	✓	✓					
			10001652	✓			✓	✓	✓	✓	✓
		80	10017075	✓	✓	✓					
		100	10001030	✓							
			10001660	✓			✓	✓	✓	✓	✓
2	36 – 54	52	10001017	-	✓	✓					
			10001643	✓			✓	✓	✓	✓	✓
		65	10001023	✓	✓	✓					
			10001651	✓			✓	✓	✓	✓	✓
		80	10017076	✓	✓	✓					
		100	10001031	✓	✓	✓					
			10001659	✓			✓	✓	✓	✓	✓
3	50 – 80	65	10001024	✓	✓	✓					
			10001650	✓			✓	✓	✓	✓	✓
		80	10017077	✓	✓	✓					
		100	10001032	✓							
			10001658	✓			✓	✓	✓	✓	✓
4	69 – 100	65	10001025	✓	✓	✓					
			10001649	✓			✓	✓	✓	✓	✓
		80	10017078	✓	✓	✓					
		100	10001033	✓							
			10001657	✓			✓	✓	✓	✓	✓

Detailed technical data follows.

Scope of delivery

- Adaptation mandrel
- Coupling ring
- Mounting aid depending on size

Adaptation
clamping devices

Measuring tech-
nology/ Automation

Quick change-
over systems

Special solutions

Clamping elements/
Accessories

Services

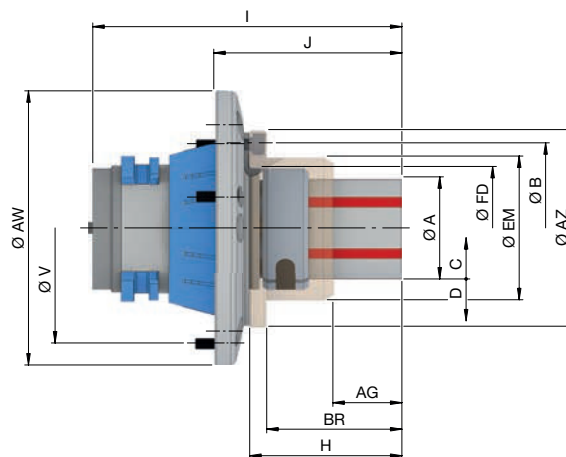
Multi spindles

ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T212 SE. Technical data



Size	XXS							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A	8 – 13						
Run-out ≤ [mm]		0,020						
Release stroke in Ø [mm]	C	0,2						
Reserve stroke in Ø [mm]	D	0,2						
Range / recommended workpiece tolerance [mm]		± 0,15						
Max. clamping length [mm]	AG	12,9						
Max. axial drawtube force [pull / push] [kN]		10						
Max. radial clamping force [kN]		42						
RPM n max. [1/min.]		7000	6000		5500	5000		
Reception workpiece end-stop	FD	Ø 34 f7						
Bolt hole circle end-stop	B	LK Ø 53 [3 x M5]						
End-stop outer Ø [mm]	AZ	65						
Depth [mm]	BR	37,5						
End-stop outer Ø 2 [mm]	EM	41						
Length [mm]	H	45,5						
Total length [mm]	I	124,3	127,5		124,5	139		
Height [mm]	J	71	64,5		61	65,5		
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8] LK Ø 180 [3 x M8]	
Outer Ø [mm]	AW	119	125	129	145	150	183 215	
Weight [kg]		3	3,6	3,8	5	9	10	
In stock		-	-	✓	✓	-	-	
Material no.		10001012	10001648	10001018	10001656	10017071	10001026 10001664	

Please note: The maximum clamping length [AG] varies from 6 to 12.9 mm depending on the clamping diameter.

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

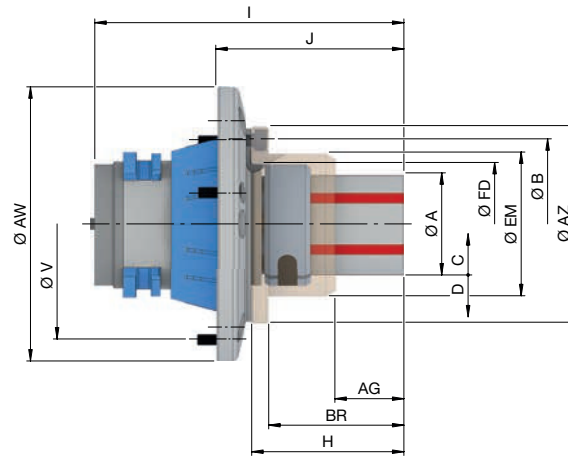




ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T212 SE. Technical data



Size		XS						
Adaptation size		52		65		80	100	
Suitable for		TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium
Clamping range [mm]	A	13 – 19						
Run-out ≤ [mm]		0,020						
Release stroke in Ø [mm]	C	0,4					0,5	
Reserve stroke in Ø [mm]	D	0,3						
Range / recommended workpiece tolerance [mm]		± 0,25						
Max. clamping length [mm]	AG	14						
Max. axial drawtube force [pull / push] [kN]		10						
Max. radial clamping force [kN]		42						
RPM n max. [1/min.]		7000		6000		5500		5000
Reception workpiece end-stop	FD	Ø 36 f7						
Bolt hole circle end-stop	B	LK Ø 53 [3 x M5]						
End-stop outer Ø [mm]	AZ	65						
Depth [mm]	BR	37,5						
End-stop outer Ø 2 [mm]	EM	42						
Length [mm]	H	45,5						
Total length [mm]	I	125		128		125		139,5
Height [mm]	J	71		64,5		61		65,5
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M6]
Outer Ø [mm]	AW	119	125	129	145	150	183	215
Weight [kg]		3		3,6	3,8	5	9	10
In stock		-	✓	✓	✓	✓	✓	✓
Material no.		10001013	10001647	10001019	10001655	10017072	10001027	10001663

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

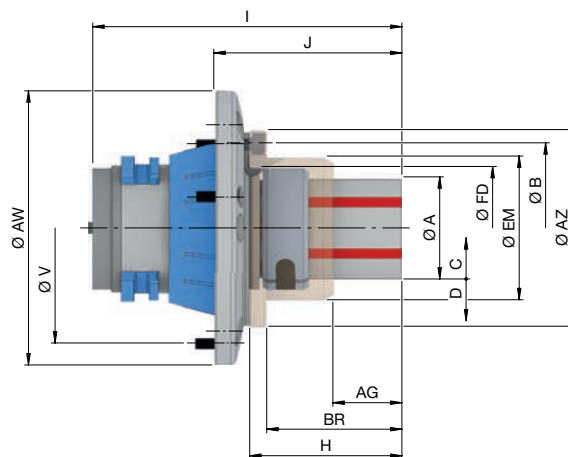


ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T212 SE. Technical data



Size	S							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A	16 – 21						
Run-out ≤ [mm]	0,020							
Release stroke in Ø [mm]	C	0,4				0,5		
Reserve stroke in Ø [mm]	D	0,3						
Range / recommended workpiece tolerance [mm]	± 0,25							
Max. clamping length [mm]	AG	15						
Max. axial drawtube force pull / push [kN]	10							
Max. radial clamping force [kN]	42							
RPM n max. [1/min.]	7000		6000		5500	5000		
Reception workpiece end-stop	FD	Ø 39 f7						
Bolt hole circle end-stop	B	LK Ø 57 [3 x M5]						
End-stop outer Ø [mm]	AZ	70						
Depth [mm]	BR	39,5						
End-stop outer Ø 2 [mm]	EM	45						
Length [mm]	H	47,5						
Total length [mm]	I	127		130		127	141,5	
Height [mm]	J	73		66,5		63	67,5	
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	119	125	129	145	150	183	215
Weight [kg]	3		3,7	4	5,1	9,1	10	
In stock	-	✓	✓	✓	✓	✓	✓	✓
Material no.	10001014	10001646	10001020	10001654	10017073	10001028	10001662	

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

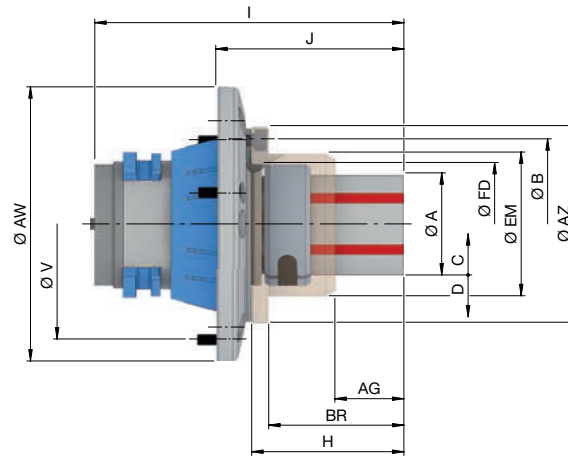




ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T212 SE. Technical data



Size	0							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A	20 – 28						
Run-out ≤ [mm]	0,010							
Release stroke in Ø [mm]	C	0,4				0,5		
Reserve stroke in Ø [mm]	D	0,3						
Range / recommended workpiece tolerance [mm]	± 0,25							
Max. clamping length [mm]	AG	21						
Max. axial drawtube force [pull / push] [kN]	10							
Max. radial clamping force [kN]	42							
RPM n max. [1/min.]	7000		6000		5500	5000		
Reception workpiece end-stop	FD	Ø 47 f7						
Bolt hole circle end-stop	B	LK Ø 70 [3 x M6]						
End-stop outer Ø [mm]	AZ	90						
Depth [mm]	BR	49,5						
End-stop outer Ø 2 [mm]	EM	56						
Length [mm]	H	58,5						
Total length [mm]	I	138		141		138	152,5	
Height [mm]	J	84		77,5		74	78,5	
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	119	125	129	145	150	183	215
Weight [kg]		3,6	3,4	4,2	4,3	5,5	9,6	10,5
In stock		-	-	✓	✓	✓	✓	✓
Material no.		10001015	10001645	10001021	10001653	10017074	10001029	10001661

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

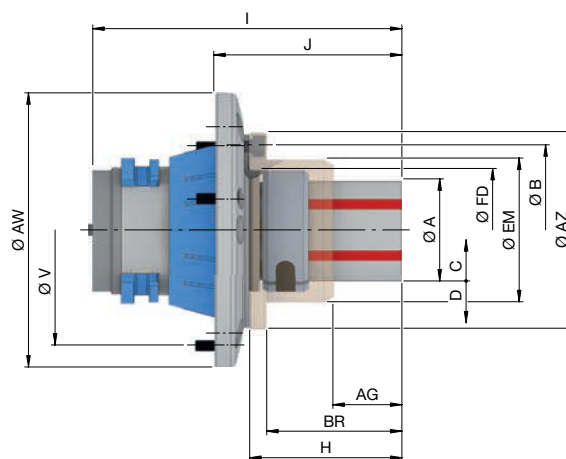


ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T212 SE. Technical data



Size	1							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A	26 – 38						
Run-out ≤ [mm]	0,010							
Release stroke in Ø [mm]	C	0,4	0,5					
Reserve stroke in Ø [mm]	D	0,3						
Range / recommended workpiece tolerance [mm]	± 0,25							
Max. clamping length [mm]	AG	25						
Max. axial drawtube force [pull / push] [kN]	10							
Max. radial clamping force [kN]	42							
RPM n max. [1/min.]	7000		6000		5500	5000		
Reception workpiece end-stop	FD	Ø 55 f7						
Bolt hole circle end-stop	B	LK Ø 75 [3 x M6]						
End-stop outer Ø [mm]	AZ	90						
Depth [mm]	BR	55,5						
End-stop outer Ø 2 [mm]	EM	62						
Length [mm]	H	64,5						
Total length [mm]	I	139	147,5		144	158,5		
Height [mm]	J	85	83,5		80	84,5		
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	119	125	129	145	150	183	215
Weight [kg]	3,2		4,3	4,5	5,6	9,7	10,6	
In stock	-	✓	✓	✓	✓	✓	✓	
Material no.	10001016	10001644	10001022	10001652	10017075	10001030	10001660	

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

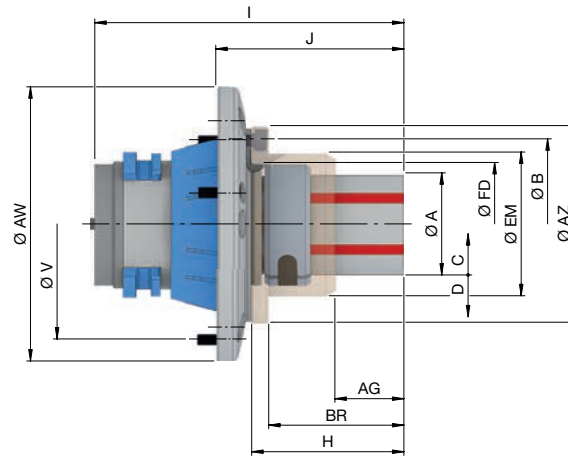




ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T212 SE. Technical data



Size	2							
Adaptation size	52		65		80	100		
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium	
Clamping range [mm]	A	36 – 54						
Run-out ≤ [mm]	0,010							
Release stroke in Ø [mm]	C	0,4	0,5					
Reserve stroke in Ø [mm]	D	0,3						
Range / recommended workpiece tolerance [mm]	± 0,25							
Max. clamping length [mm]	AG	40						
Max. axial drawtube force [pull / push] [kN]	20							
Max. radial clamping force [kN]	85							
RPM n max. [1/min.]	7000		6000		5500	5000		
Reception workpiece end-stop	FD	Ø 65 f7						
Bolt hole circle end-stop	B	LK Ø 90 [3 x M6]						
End-stop outer Ø [mm]	AZ	104						
Depth [mm]	BR	71,5						
End-stop outer Ø 2 [mm]	EM	75						
Length [mm]	H	80,5						
Total length [mm]	I	155	163,5		158	174,5		
Height [mm]	J	101	99,5		94	100,5		
Bolt hole circle	V	LK Ø 105 [3 x M8]	LK Ø 107 [3 x M6]	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	119	125	129	145	150	183	215
Weight [kg]		4	3,9	5	5,2	6	10,3	11,3
In stock		-	✓	✓	✓	✓	✓	✓
Material no.		10001017	10001643	10001023	10001651	10017076	10001031	10001659

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

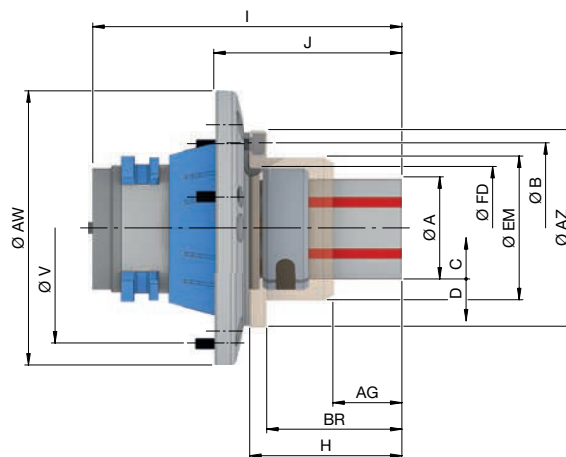


ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T212 SE. Technical data



Size	3				
Adaptation size	65		80	100	
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium
Clamping range [mm]	A	50 – 80			
Run-out ≤ [mm]		0,010			
Release stroke in Ø [mm]	C	0,5			
Reserve stroke in Ø [mm]	D	0,4	0,3	0,4	
Range / recommended workpiece tolerance [mm]		± 0,35			
Max. clamping length [mm]	AG	44,5			
Max. axial drawtube force [pull / push] [kN]		25			
Max. radial clamping force [kN]		105			
RPM n max. [1/min.]		6000	5500	5000	
Reception workpiece end-stop	FD	Ø 83 f7			
Bolt hole circle end-stop	B	LK Ø 104 [3 x M6]			
End-stop outer Ø [mm]	AZ	120			
Depth [mm]	BR	78			
End-stop outer Ø 2 [mm]	EM	92,5			
Length [mm]	H	87,5			
Total length [mm]	I	170,5	166	181,5	
Height [mm]	J	106,5	102	107,5	
Bolt hole circle	V	LK Ø 112 [3 x M8]	LK Ø 126 [3 x M6]	LK Ø 130 [3 x M8]	LK Ø 160 [3 x M8]
Outer Ø [mm]	AW	129	145	150	215
Weight [kg]		5,9	6	6,7	12
In stock		✓	✓	✓	✓
Material no.		10001024	10001650	10017077	10001032
					10001658

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



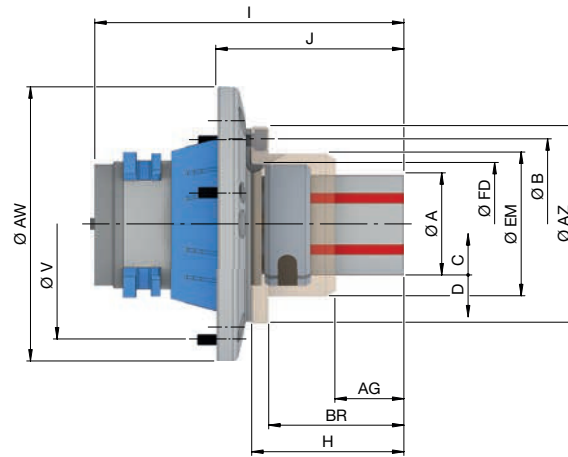
Segmented clamping bushings Page 448	Accessory overview Page 478



ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T212 SE. Technical data



Size	4				
Adaptation size	65		80	100	
Suitable for	TOPlus mini / premium	all except TOPlus mini / premium	TOPlus mini / premium	TOPlus mini / premium	all except TOPlus mini / premium
Clamping range [mm]	A				
Run-out ≤ [mm]	69 – 100				
Release stroke in Ø [mm]	0,010				
Reserve stroke in Ø [mm]	0,5				
Range / recommended workpiece tolerance [mm]	D				
Max. clamping length [mm]	0,4				
Max. axial drawtube force [pull / push] [kN]	± 0,4				
Max. radial clamping force [kN]	AG				
RPM n max. [1/min.]	52,5				
Reception workpiece end-stop	FD				
Bolt hole circle end-stop	B				
End-stop outer Ø [mm]	AZ				
Depth [mm]	BR				
End-stop outer Ø 2 [mm]	EM				
Length [mm]	H				
Total length [mm]	I				
Height [mm]	J				
Bolt hole circle	V				
Outer Ø [mm]	AW				
Weight [kg]					
In stock					
Material no.					

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



Adaptation clamping devices

Measuring technology / Automation

Quick change-over systems

Special solutions

Clamping elements / Accessories

Services

Multi spindles

ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T211 RD. Order overview

					Suitable for					
Size	Clamping range [mm]	Adaptation size	Material no.	In stock						
					SPANNTOP mini pull-back Page 72	SPANNTOP combi pull-back Page 92	SPANNTOP modular Page 92	TOROK RD Page 122	HYDROK RD Page 252	MANOK plus RD Page 244
0	20 – 28	42	10001561	✓						
		52	10001558	✓						
		65	10001550	✓	✓	✓	✓	✓	✓	✓
		80	10001540	✓						
		100	10001549	✓						
1	26 – 38	42	10001563	-						
		52	10001559	✓						
		65	10001551	✓	✓	✓	✓	✓	✓	✓
		80	10001541	✓						
		100	10001545	✓						
2	36 – 54	42	10001562	-						
		52	10001560	✓						
		65	10001552	✓	✓	✓	✓	✓	✓	✓
		80	10001542	✓						
		100	10001546	✓						
3	50 – 80	65	10001553	✓						
		80	10001543	✓	✓	✓	✓	✓	✓	✓
		100	10001547	✓						
4	69 – 120	65	10001554	✓						
		80	10001544	✓	✓	✓	✓	✓	✓	✓
		100	10001548	✓						

Detailed technical data follows.

Scope of delivery

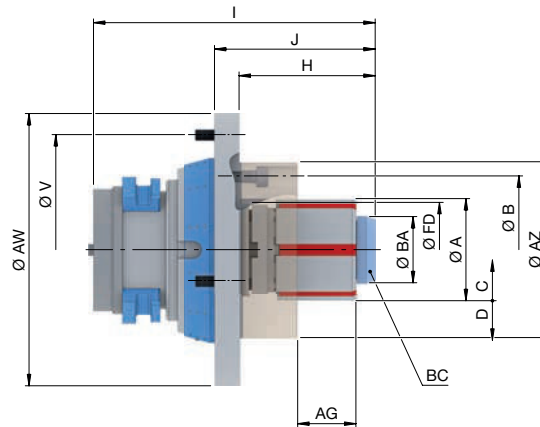
- Adaptation mandrel
- Draw bolt



ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T211 RD. Technical data



Size	0				
Adaptation size	42	52	65	80	100
Clamping range [mm]	20 – 28				
Run-out ≤ [mm]	0,010				
Max. radial clamping force [kN]	42				
Max. axial drawtube force [pull / push] [kN]	10				
Max. clamping length [mm]	22				
Release stroke in Ø [mm]	0,4				
Reserve stroke in Ø [mm]	0,3				
Range / recommended workpiece tolerance [mm]	± 0,25				
RPM n max. [1/min.]	7000				
Max. actuating torque [Nm]	10				
Draw bolt Ø [mm]	19				
Reception workpiece end-stop	Ø 32 f7				
End-stop outer Ø [mm]	65				
Bolt hole circle end-stop	LK Ø 50 [3 x M6]				
Length [mm]	42,3				
Total length [mm]	106	109	119	129	129
Height [mm]	55				
Bolt hole circle	LK Ø 107 [3 x M6]				
Outer Ø [mm]	125				
Weight [kg]	2,1	2,2	3,7	4,9	9,2
In stock	✓	✓	✓	✓	✓
Material no.	10001561	10001558	10001550	10001540	10001549

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

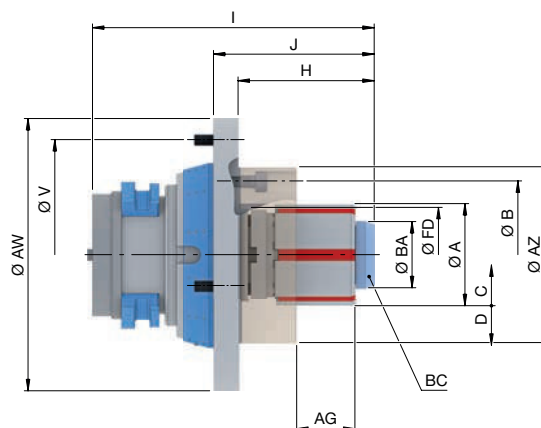
Segmented clamping bushings Page 442	Adaptation ring Page 508	Accessory overview Page 478

ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T211 RD. Technical data



Size	1					
Adaptation size	42	52	65	80	100	
Clamping range [mm]	A	26 – 38				
Run-out ≤ [mm]		0,010				
Max. radial clamping force [kN]		42				
Max. axial drawtube force [pull / push] [kN]		10				
Max. clamping length [mm]	AG	25,4	26			
Release stroke in Ø [mm]	C	0,4				
Reserve stroke in Ø [mm]	D	0,3				
Range / recommended workpiece tolerance [mm]		± 0,25				
RPM n max. [1/min.]		7000	6000	5500	5000	
Max. actuating torque [Nm]	BC	20				
Draw bolt Ø [mm]	BA	25				
Reception workpiece end-stop	FD	Ø 41 f7				
End-stop outer Ø [mm]	AZ	69				
Bolt hole circle end-stop	B	LK Ø 55 [3 x M6]				
Length [mm]	H	52,3	52	51,5		
Total length [mm]	I	116	119	129	139	
Height [mm]	J	65				
Bolt hole circle	V	LK Ø 107 [3 x M6]		LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	125		144	160	215
Weight [kg]		2,2	2,4	3,7	5	9,3
In stock		-	✓	✓	✓	✓
Material no.		10001563	10001559	10001551	10001541	10001545

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



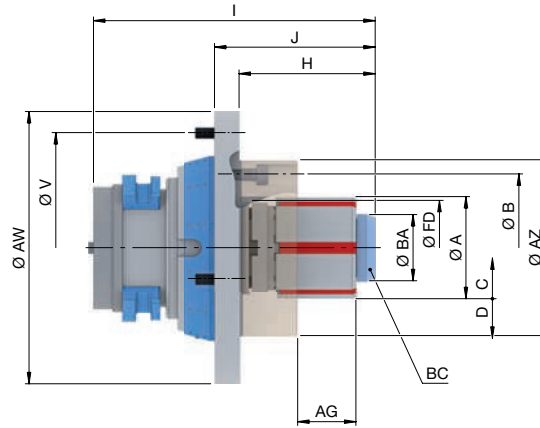
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ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T211 RD. Technical data



Size	2				
Adaptation size	42	52	65	80	100
Clamping range [mm]	36 – 54				
Run-out ≤ [mm]	0,010				
Max. radial clamping force [kN]	85				
Max. axial drawtube force [pull / push] [kN]	20				
Max. clamping length [mm]	43	42,4		43	
Release stroke in Ø [mm]	0,4			0,5	
Reserve stroke in Ø [mm]	0,3				
Range / recommended workpiece tolerance [mm]	± 0,25				
RPM n max. [1/min.]	7000		6000	5500	5000
Max. actuating torque [Nm]	25				
Draw bolt Ø [mm]	35				
Reception workpiece end-stop	Ø 50 f7				
End-stop outer Ø [mm]	93				
Bolt hole circle end-stop	LK Ø 78 [3 x M6]				
Length [mm]	72,3		72		71,5
Total length [mm]	136	139	149		159
Height [mm]	85				
Bolt hole circle	LK Ø 107 [3 x M6]		LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Outer Ø [mm]	125		144	160	215
Weight [kg]	2,5	2,7	4	5,3	9,6
In stock	-	✓	✓	✓	✓
Material no.	10001562	10001560	10001552	10001542	10001546

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

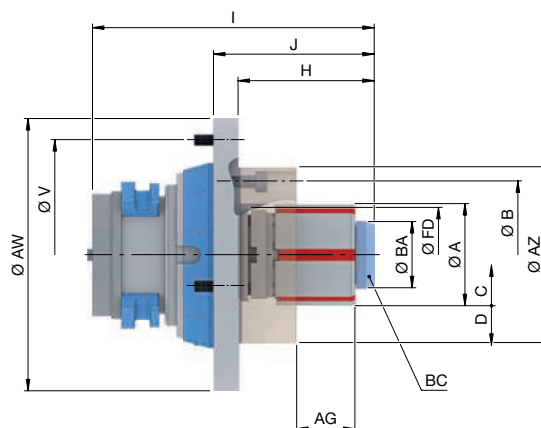
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ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T211 RD. Technical data



Size	3			
Adaptation size	65	80	100	
Clamping range [mm]	A	50 – 80		
Run-out ≤ [mm]		0,010		
Max. radial clamping force [kN]		105		
Max. axial drawtube force [pull / push] [kN]		25		
Max. clamping length [mm]	AG	49		
Release stroke in Ø [mm]	C	0,5		
Reserve stroke in Ø [mm]	D	0,4		
Range / recommended workpiece tolerance [mm]		± 0,35		
RPM n max. [1/min.]		6000	5500	5000
Max. actuating torque [Nm]	BC	55		
Draw bolt Ø [mm]	BA	49		
Reception workpiece end-stop	FD	Ø 65 f7		
End-stop outer Ø [mm]	AZ	96		
Bolt hole circle end-stop	B	LK Ø 80 [3 x M6]		
Length [mm]	H	82	81,5	
Total length [mm]	I	159	169	
Height [mm]	J	95		
Bolt hole circle	V	LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	144	160	215
Weight [kg]		4,7	6	10,3
In stock		✓	✓	✓
Material no.		10001553	10001543	10001547

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

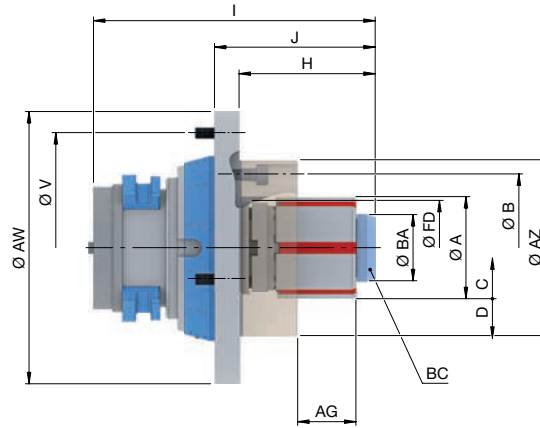




ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T211 RD. Technical data



Size	4		
Adaptation size	65	80	100
Clamping range [mm]	A	69 – 120	
Run-out ≤ [mm]		0,010	
Max. radial clamping force [kN]		150	
Max. axial drawtube force [pull / push] [kN]		35	
Max. clamping length [mm]	AG	59	
Release stroke in Ø [mm]	C	0,5	
Reserve stroke in Ø [mm]	D	0,6	
Range / recommended workpiece tolerance [mm]		± 0,4	
RPM n max. [1/min.]	6000	5500	5000
Max. actuating torque [Nm]	BC	65	
Draw bolt Ø [mm]	BA	68	
Reception workpiece end-stop	FD	Ø 78 f7	
End-stop outer Ø [mm]	AZ	120	
Bolt hole circle end-stop	B	LK Ø 90 [3 x M6]	
Length [mm]	H	97	96,5
Total length [mm]	I	174	184
Height [mm]	J	110	
Bolt hole circle	V	LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]
Outer Ø [mm]	AW	144	160
Weight [kg]		5,7	6,9
In stock		✓	✓
Material no.	10001554	10001544	10001548

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

For size 4, clamping range 101 – 120 mm, a max. speed of 4200 RPM applies.

Segmented clamping bushings Page 442	Adaptation ring Page 508	Accessory overview Page 478

ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T212 RD. Order overview

					Suitable for					
Size	Clamping range [mm]	Adaptation size	Material no.	In stock						
					SPANNTOP mini pull-back Page 72	SPANNTOP combi pull-back Page 92	SPANNTOP modular Page 92	TOROK RD Page 122	HYDROK RD Page 252	MANOK plus RD Page 244
XXS	8 – 13	42	10001619	-						
		52	10001620	-						
		65	10001621	✓	✓	✓	✓	✓	✓	✓
		80	10001622	-						
		100	10001623	-						
XS	13 – 19	42	10001618	✓						
		52	10001588	✓						
		65	10001593	✓	✓	✓	✓	✓	✓	✓
		80	10001600	✓						
		100	10001607	✓						
S	16 – 21	42	10001614	✓						
		52	10001589	✓						
		65	10001594	✓	✓	✓	✓	✓	✓	✓
		80	10001601	✓						
		100	10001608	✓						
0	20 – 28	42	10001615	✓						
		52	10001590	✓						
		65	10001595	✓	✓	✓	✓	✓	✓	✓
		80	10001602	✓						
		100	10001609	✓						
1	26 – 38	42	10001617	✓						
		52	10001591	✓						
		65	10001596	✓	✓	✓	✓	✓	✓	✓
		80	10001603	✓						
		100	10001610	✓						
2	36 – 54	42	10001616	✓						
		52	10001592	✓						
		65	10001597	✓	✓	✓	✓	✓	✓	✓
		80	10001604	✓						
		100	10001611	✓						
3	50 – 80	65	10001598	✓						
		80	10001605	✓	✓	✓	✓	✓	✓	✓
		100	10001612	✓						
		125	10001624	-						
4	69 – 100	65	10001599	✓						
		80	10001606	✓	✓	✓	✓	✓	✓	✓
		100	10001613	✓						
		125	10001625	-						
5	100 – 130	125	10001626	✓		✓	✓			
6	130 – 160	125	10001627	-		✓	✓			
7	160 – 190	125	10001628	✓		✓	✓			

Detailed technical data below.

Please note: SPANNTOP nova 125 is only compatible with MANDO Adapt manufactured in 2015 or later.

Scope of delivery

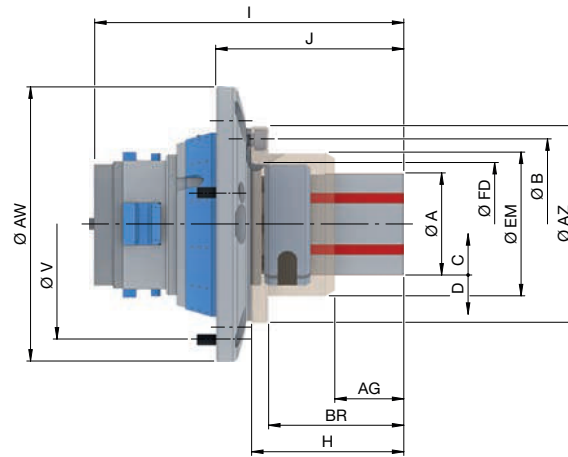
- Adaptation mandrel
- Coupling ring
- Mounting aid depending on size



ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T212 RD. Technical data



Size	XXS				
Adaptation size	42	52	65	80	100
Clamping range [mm]	A				
Run-out ≤ [mm]	8 – 13				
Release stroke in Ø [mm]	C				
Reserve stroke in Ø [mm]	D				
Range / recommended workpiece tolerance [mm]	± 0,15				
Max. clamping length [mm]	AG				
Max. axial drawtube force [pull / push] [kN]	10				
Max. radial clamping force [kN]	42				
RPM n max. [1/min.]	7000				
Reception workpiece end-stop	FD				
Bolt hole circle end-stop	B				
End-stop outer Ø [mm]	AZ				
Depth [mm]	BR				
End-stop outer Ø 2 [mm]	EM				
Length [mm]	H				
Total length [mm]	I	124,5	124,3	127,5	124,5
Height [mm]	J	71	64,5	61	65,5
Bolt hole circle	V	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Outer Ø [mm]	AW	125	145	160	215
Weight [kg]		2,8	2,9	4,1	5
In stock		-	✓	-	-
Material no.		10001619	10001620	10001621	10001622
				10001622	10001623

Please note: The maximum clamping length [AG] varies from 6 to 12.9 mm depending on the clamping diameter.

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

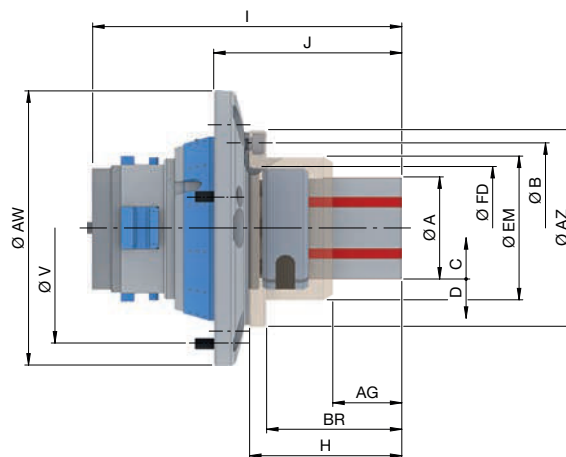
Segmented clamping bushings Page 442	Adaptation ring Page 508	Accessory overview Page 478

ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T212 RD. Technical data



Size	XS				
Adaptation size	42	52	65	80	100
Clamping range [mm]	13 – 19				
Run-out ≤ [mm]	0,020				
Release stroke in Ø [mm]	0,4				
Reserve stroke in Ø [mm]	0,3				
Range / recommended workpiece tolerance [mm]	± 0,25				
Max. clamping length [mm]	14				
Max. axial drawtube force [pull / push] [kN]	10				
Max. radial clamping force [kN]	42				
RPM n max. [1/min.]	7000		6000	5500	5000
Reception workpiece end-stop	Ø 36 f7				
Bolt hole circle end-stop	LK Ø 53 [3 x M5]				
End-stop outer Ø [mm]	65				
Depth [mm]	37,5				
End-stop outer Ø 2 [mm]	42				
Length [mm]	45,5				
Total length [mm]	125		128	125	139,5
Height [mm]	71		64,5	61	65,5
Bolt hole circle	LK Ø 107 [3 x M6]		LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]
Outer Ø [mm]	125		145	160	215
Weight [kg]	2,8	3	4	5	10,1
In stock	✓	✓	✓	✓	✓
Material no.	10001618	10001588	10001593	10001600	10001607

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



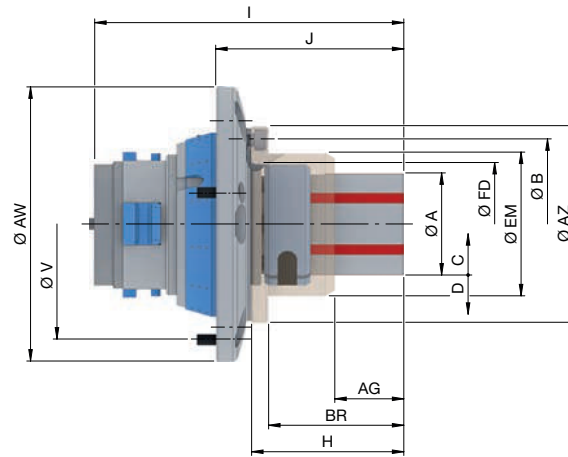
Segmented clamping bushings Page 442	Adaptation ring Page 508	Accessory overview Page 478



ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T212 RD. Technical data



Size	S				
Adaptation size	42	52	65	80	100
Clamping range [mm]	A				
Run-out ≤ [mm]	16 – 21				
Release stroke in Ø [mm]	0,020				
Reserve stroke in Ø [mm]	0,4				
Range / recommended workpiece tolerance [mm]	C				
Max. clamping length [mm]	D				
Max. axial drawtube force [pull / push] [kN]	± 0,25				
Max. radial clamping force [kN]	AG				
RPM n max. [1/min.]	15				
Reception workpiece end-stop	10				
Bolt hole circle end-stop	42				
End-stop outer Ø [mm]	7000				
Depth [mm]	6000				
End-stop outer Ø 2 [mm]	5500				
Length [mm]	5000				
Total length [mm]	Ø 39 f7				
Height [mm]	LK Ø 57 [3 x M5]				
Bolt hole circle	B				
Outer Ø [mm]	AZ				
Weight [kg]	70				
In stock	39,5				
Material no.	45				
	47,5				
	124				
	127				
	130				
	127				
	141,5				
	73				
	66,5				
	63				
	67,5				
	LK Ø 107 [3 x M6]				
	LK Ø 126 [3 x M6]				
	LK Ø 139 [3 x M6]				
	LK Ø 180 [3 x M8]				
	145				
	160				
	215				
	3				
	3,1				
	4,1				
	5				
	10,2				
	✓				
	✓				
	✓				
	✓				
	10001614				
	10001589				
	10001594				
	10001601				
	10001608				

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

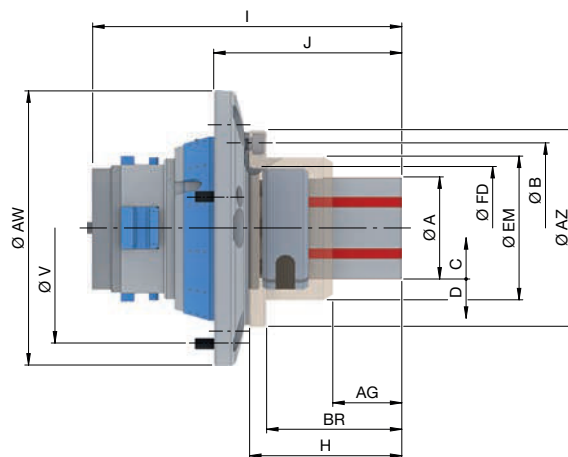


ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T212 RD. Technical data



Size	0				
Adaptation size	42	52	65	80	100
Clamping range [mm]	A				
Run-out ≤ [mm]	20 – 28				
Release stroke in Ø [mm]	0,010				
Reserve stroke in Ø [mm]	0,4				
Range / recommended workpiece tolerance [mm]	C				
Max. clamping length [mm]	D				
Max. axial drawtube force [pull / push] [kN]	± 0,25				
Max. radial clamping force [kN]	AG				
RPM n max. [1/min.]	21				
Reception workpiece end-stop	10				
Bolt hole circle end-stop	42				
End-stop outer Ø [mm]	FD				
Depth [mm]	Ø 47 f7				
End-stop outer Ø 2 [mm]	B				
Length [mm]	LK Ø 70 [3 x M6]				
Total length [mm]	AZ				
Height [mm]	90				
Bolt hole circle	BR				
Outer Ø [mm]	49,5				
Weight [kg]	EM				
In stock	56				
Material no.	H				
	58,5				
	I				
	138				
	J				
	84				
	V				
	LK Ø 107 [3 x M6]				
	AW				
	125				
	3,4				
	3,6				
	4,5				
	5,5				
	10,6				
	✓				
	✓				
	✓				
	✓				
	✓				
	10001615				
	10001590				
	10001595				
	10001602				
	10001609				

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

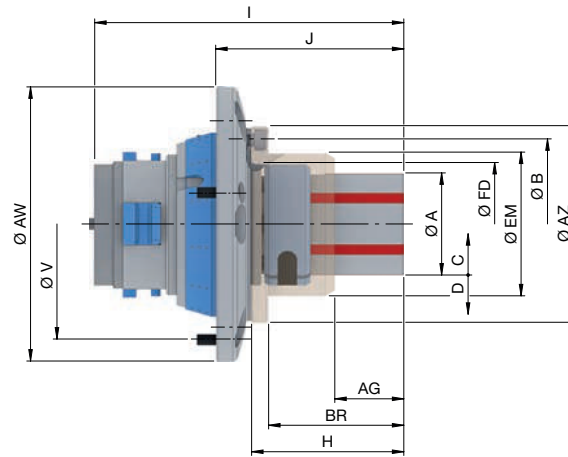




ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T212 RD. Technical data



Size	1				
Adaptation size	42	52	65	80	100
Clamping range [mm]	A				
Run-out ≤ [mm]	26 – 38				
Release stroke in Ø [mm]	0,010				
Reserve stroke in Ø [mm]	0,4				
Range / recommended workpiece tolerance [mm]	C				
Max. clamping length [mm]	D				
Max. axial drawtube force [pull / push] [kN]	± 0,25				
Max. radial clamping force [kN]	AG				
RPM n max. [1/min.]	25				
Reception workpiece end-stop	10				
Bolt hole circle end-stop	42				
End-stop outer Ø [mm]	FD				
Depth [mm]	Ø 55 f7				
End-stop outer Ø 2 [mm]	B				
Length [mm]	LK Ø 75 [3 x M6]				
Total length [mm]	90				
Height [mm]	136				
Bolt hole circle	139				
Outer Ø [mm]	147,5				
Weight [kg]	83,5				
In stock	80				
Material no.	10001617				
	10001591				
	10001596				
	10001603				
	10001610				

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

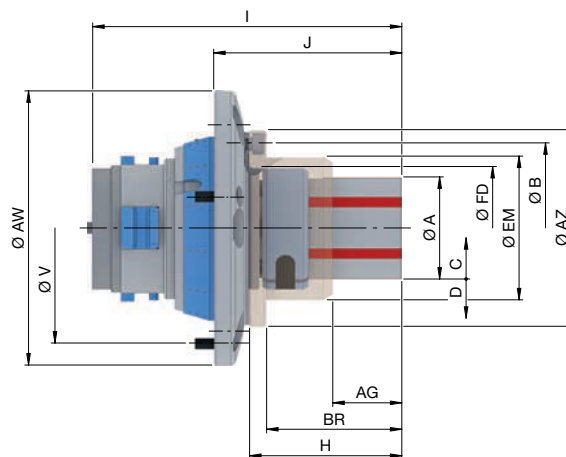


ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T212 RD. Technical data



Size	2				
Adaptation size	42	52	65	80	100
Clamping range [mm]	A				
Run-out ≤ [mm]	36 – 54				
Release stroke in Ø [mm]	0,010				
Reserve stroke in Ø [mm]	C				
Range / recommended workpiece tolerance [mm]	0,4				
Max. clamping length [mm]	D				
Max. axial drawtube force [pull / push] [kN]	0,3				
Max. radial clamping force [kN]	± 0,25				
RPM n max. [1/min.]	AG				
Reception workpiece end-stop	40				
Bolt hole circle end-stop	20				
End-stop outer Ø [mm]	85				
Depth [mm]	7000				
End-stop outer Ø 2 [mm]	6000				
Length [mm]	5500				
Total length [mm]	5000				
Height [mm]	Ø 65 f7				
Bolt hole circle	LK Ø 90 [3 x M6]				
Outer Ø [mm]	104				
Weight [kg]	71,5				
In stock	75				
Material no.	80,5				
	152				
	155				
	163,5				
	160,5				
	174,5				
	101				
	99,5				
	94				
	100,5				
	LK Ø 107 [3 x M6]				
	LK Ø 126 [3 x M6]				
	LK Ø 139 [3 x M6]				
	LK Ø 180 [3 x M8]				
	125				
	145				
	160				
	215				
	3,9				
	4				
	5,4				
	6				
	11,3				
	✓				
	✓				
	✓				
	✓				
	✓				
	10001616				
	10001592				
	10001597				
	10001604				
	10001611				

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

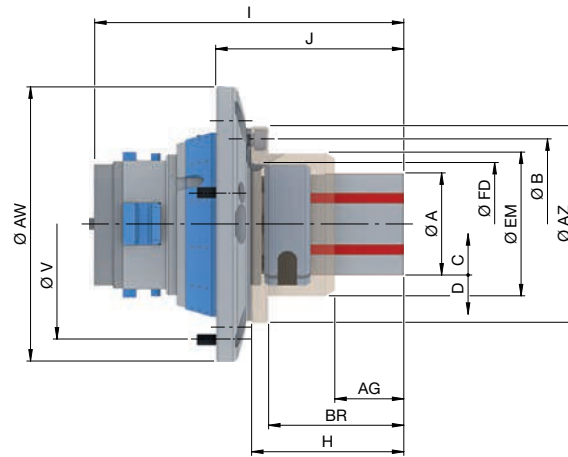




ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T212 RD. Technical data



Size	3			
Adaptation size	65	80	100	125
Clamping range [mm]	A			
Run-out ≤ [mm]	50 – 80			
Release stroke in Ø [mm]	0,010			
Reserve stroke in Ø [mm]	C			
Range / recommended workpiece tolerance [mm]	D			
Max. clamping length [mm]	0,4	0,3	0,4	0,4
Max. axial drawtube force [pull / push] [kN]	± 0,35			
Max. radial clamping force [kN]	AG			
RPM n max. [1/min.]	44,5			
Reception workpiece end-stop	FD			
Bolt hole circle end-stop	Ø 83 f7			
End-stop outer Ø [mm]	B			
Depth [mm]	LK Ø 104 [3 x M6]			
End-stop outer Ø 2 [mm]	AZ			
Length [mm]	120			
Total length [mm]	BR			
Height [mm]	EM			
Bolt hole circle	H			
Outer Ø [mm]	87,5			
Weight [kg]	I	J	K	L
In stock	170,5	168,5	181,5	200,5
Material no.	106,5	102	107,5	122,5
	LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]	LK Ø 208,5 [6 x M8]
	145	160	215	226
	6,2	7	12,2	24,3
	✓	✓	✓	-
	10001598	10001605	10001612	10001624

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



Adaptation
clamping devices

Measuring tech-
nology / Automation

Quick change-
over systems

Special solutions

Clamping elements /
Accessories

Services

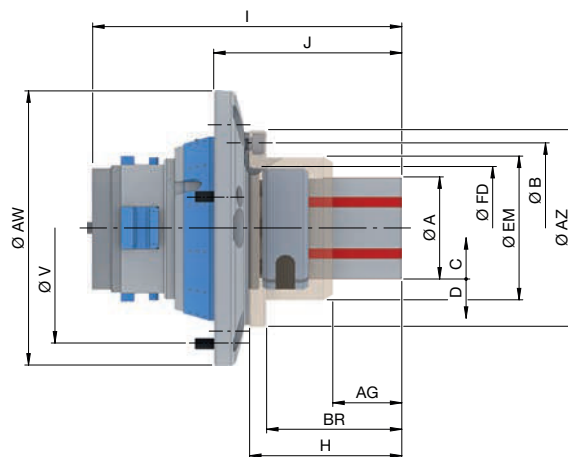
Multi spindles

ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T212 RD. Technical data



Size	4			
Adaptation size	65	80	100	125
Clamping range [mm]	A 69 – 100			
Run-out ≤ [mm]	0,010			
Release stroke in Ø [mm]	C 0,5			
Reserve stroke in Ø [mm]	D 0,6			
Range / recommended workpiece tolerance [mm]	0,5 ± 0,35 ± 0,4			
Max. clamping length [mm]	AG 52,5			
Max. axial drawtube force [pull / push] [kN]	35			
Max. radial clamping force [kN]	150			
RPM n max. [1/min.]	6000	5500	5000	3200
Reception workpiece end-stop	FD Ø 103 f7			
Bolt hole circle end-stop	B LK Ø 124 [3 x M6]			
End-stop outer Ø [mm]	AZ 138	138,5	138	138
Depth [mm]	BR 87,5	87,5	82,5	82,5
End-stop outer Ø 2 [mm]	EM 113			
Length [mm]	H 97,5			
Total length [mm]	I 180,5	176	191,5	210
Height [mm]	J 116,5	112	117,5	130
Bolt hole circle	V LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]	LK Ø 180 [3 x M8]	LK Ø 208,5 [6 x M8]
Outer Ø [mm]	AW 145	160	215	221,5
Weight [kg]	7,6	8,3	13,6	25
In stock	✓	✓	✓	-
Material no.	10001599	10001606	10001613	10001625

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Please note: SPANNTOP nova 125 is only compatible with MANDO Adapt manufactured in 2015 or later.

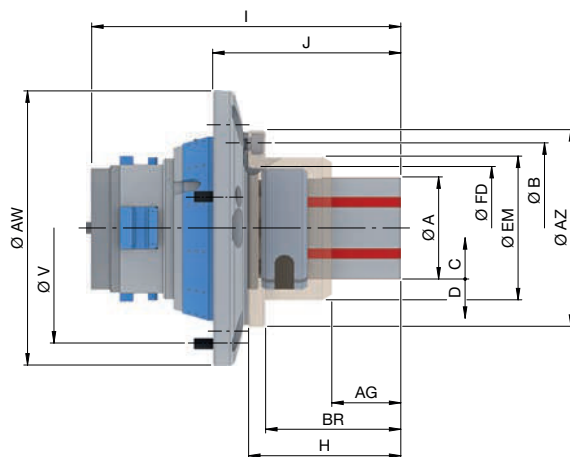
Segmented clamping bushings Page 442	Adaptation ring Page 508	Accessory overview Page 478



ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T212 RD. Technical data



Size	5
Adaptation size	125
Clamping range [mm]	A 100 – 130
Run-out ≤ [mm]	0,010
Release stroke in Ø [mm]	C 0,6
Reserve stroke in Ø [mm]	D 0,6
Range / recommended workpiece tolerance [mm]	± 0,45
Max. clamping length [mm]	AG 53
Max. axial drawtube force [pull / push] [kN]	40
Max. radial clamping force [kN]	170
RPM n max. [1/min.]	3200
Reception workpiece end-stop	FD Ø 140 f7
Bolt hole circle end-stop	B LK Ø 176 [3 x M8]
End-stop outer Ø [mm]	AZ 195
Depth [mm]	BR 99
End-stop outer Ø 2 [mm]	EM 160
Length [mm]	H 112
Total length [mm]	I 218
Height [mm]	J 140
Bolt hole circle	V LK Ø 208,5 [6 x M8]
Outer Ø [mm]	AW 228
Weight [kg]	24,3
In stock	✓
Material no.	10001626

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Please note: SPANNTOP nova 125 is only compatible with MANDO Adapt manufactured in 2015 or later.



Adaptation clamping devices

Measuring technology / Automation

Quick change-over systems

Special solutions

Clamping elements / Accessories

Services

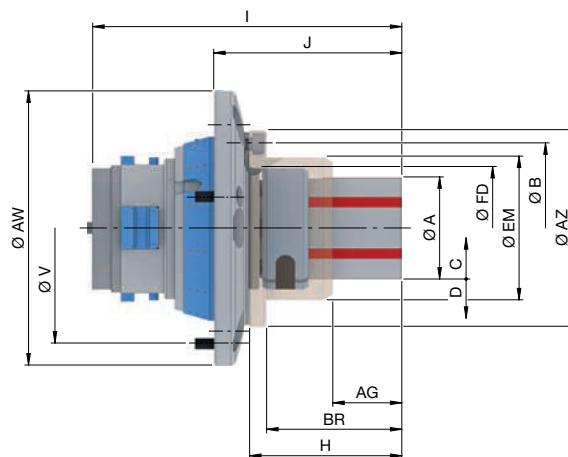
Multi spindles

ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T212 RD. Technical data



Size	6
Adaptation size	125
Clamping range [mm]	A 130 – 160
Run-out ≤ [mm]	0,010
Release stroke in Ø [mm]	C 0,6
Reserve stroke in Ø [mm]	D 0,6
Range / recommended workpiece tolerance [mm]	± 0,5
Max. clamping length [mm]	AG 61
Max. axial drawtube force [pull / push] [kN]	40
Max. radial clamping force [kN]	170
RPM n max. [1/min.]	3200
Reception workpiece end-stop	FD Ø 164 f7
Bolt hole circle end-stop	B LK Ø 200 [3 x M8]
End-stop outer Ø [mm]	AZ 226
Depth [mm]	BR 107,5
End-stop outer Ø 2 [mm]	EM 184
Length [mm]	H 121,5
Total length [mm]	I 227,5
Height [mm]	J 149,5
Bolt hole circle	V LK Ø 208,5 [6 x M8]
Outer Ø [mm]	AW 231
Weight [kg]	24,3
In stock	-
Material no.	10001627

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Please note: SPANNTOP nova 125 is only compatible with MANDO Adapt manufactured in 2015 or later.

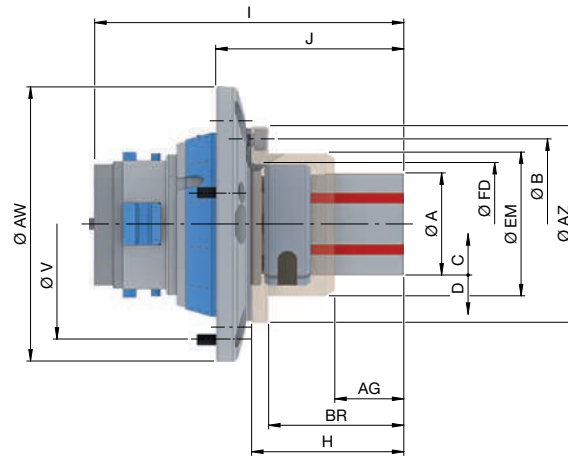




ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T212 RD. Technical data



Size	7
Adaptation size	125
Clamping range [mm]	A 160 – 190
Run-out ≤ [mm]	0,010
Release stroke in Ø [mm]	C 0,8
Reserve stroke in Ø [mm]	D 0,6
Range / recommended workpiece tolerance [mm]	± 0,5
Max. clamping length [mm]	AG 73
Max. axial drawtube force [pull / push] [kN]	40
Max. radial clamping force [kN]	170
RPM n max. [1/min.]	3200
Reception workpiece end-stop	FD Ø 192 f7
Bolt hole circle end-stop	B LK Ø 216 [3 x M8]
End-stop outer Ø [mm]	AZ 234
Depth [mm]	BR 101
End-stop outer Ø 2 [mm]	EM 212
Length [mm]	H 115
Total length [mm]	I 223
Height [mm]	J 145
Bolt hole circle	V LK Ø 208,5 [6 x M8]
Outer Ø [mm]	AW 234
Weight [kg]	24,3
In stock	✓
Material no.	10001628

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

Please note: SPANNTOP nova 125 is only compatible with MANDO Adapt manufactured in 2015 or later.



ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T812 RD. Order overview

Suitable for



Size	Clamping range [mm]	Adaptation size	Material no.	In stock	SPANNTOP mini deadlength Page 72	SPANNTOP nova combi deadlength Page 92
XS	13 – 19	42/52	10000469	-	✓	✓
		65	10000470	-		
		80	10000465	-		
S	16 – 21	42/52	10000461	-	✓	✓
		65	10000471	-		
		80	10000466	-		
0	20 – 28	42/52	10000472	-	✓	✓
		65	10000473	✓		
		80	10000467	-		
1	26 – 38	42/52	10000474	-	✓	✓
		65	10000475	✓		
		80	10000476	-		
2	36 – 54	42/52	10000462	-	✓	✓
		65	10000477	✓		
		80	10000478	-		
3	50 – 80	42/52	10000463	-	✓	✓
		65	10000479	✓		
		80	10000480	-		
4	69 – 100	65	10000481	-	✓	✓
		80	10000468	-		

Detailed technical data follows. Adaptation size 100 upon request.

Scope of delivery

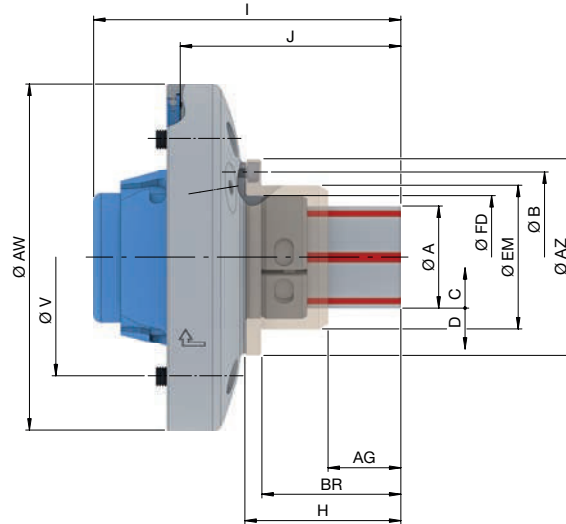
- Adaptation mandrel
- Support sleeve for SAD segmented clamping bushings
- Assembly wrench



ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T812 RD. Technical data



Size	XS		
Adaptation size	42/52	65	80
Clamping range [mm]	A	13 – 19	
Run-out ≤ [mm]		0,025	
Release stroke in Ø [mm]	C	0,4	
Reserve stroke in Ø [mm]	D	0,3	
Range / recommended workpiece tolerance [mm]		± 0,25	
Max. clamping length [mm]	AG	14	
Max. axial compression force [kN]		10	
Max. radial clamping force [kN]		42	
RPM n max. [1/min.]		7000	
Reception workpiece end-stop	FD	Ø 36 f7	
Bolt hole circle end-stop	B	LK Ø 53 [3 x M5]	
End-stop outer Ø [mm]	AZ	65	
Depth [mm]	BR	39,5	
End-stop outer Ø 2 [mm]	EM	42	
Length [mm]	H	47,5	
Total length [mm]	I	124,5	129,5
Height [mm]	J	83,7	
Bolt hole circle	V	LK Ø 125 [3 x M10]	LK Ø 145 [3 x M10]
Outer Ø [mm]	AW	166	183
Weight [kg]		7	10
In stock		-	-
Material no.	10000469	10000470	10000465

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

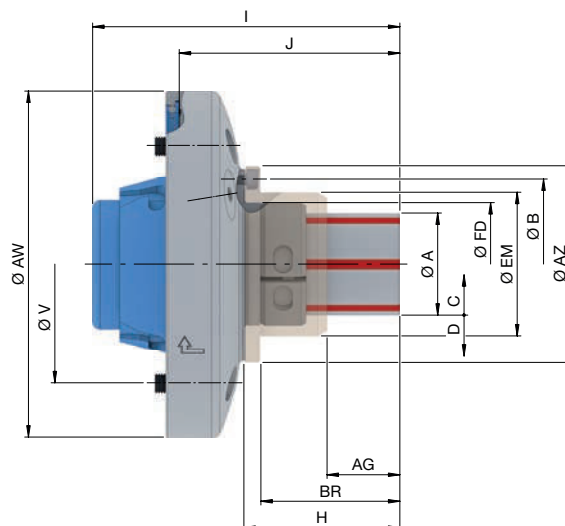


ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T812 RD. Technical data



Size	S		
Adaptation size	42/52	65	80
Clamping range [mm]	A	16 – 21	
Run-out ≤ [mm]		0,025	
Release stroke in Ø [mm]	C	0,4	
Reserve stroke in Ø [mm]	D	0,3	
Range / recommended workpiece tolerance [mm]		± 0,25	
Max. clamping length [mm]	AG	15	
Max. axial compression force [kN]		10	
Max. radial clamping force [kN]		42	
RPM n max. [1/min.]	7000	6000	7000
Reception workpiece end-stop	FD	Ø 39 f7	
Bolt hole circle end-stop	B	LK Ø 57 [3 x M5]	
End-stop outer Ø [mm]	AZ	70	
Depth [mm]	BR	41,5	
End-stop outer Ø 2 [mm]	EM	45	
Length [mm]	H	49,5	
Total length [mm]	I	126,5	131,5
Height [mm]	J	85,7	
Bolt hole circle	V	LK Ø 125 [3 x M10]	LK Ø 145 [3 x M10]
Outer Ø [mm]	AW	166	183
Weight [kg]		7	8
In stock		-	-
Material no.	10000461	10000471	10000466

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

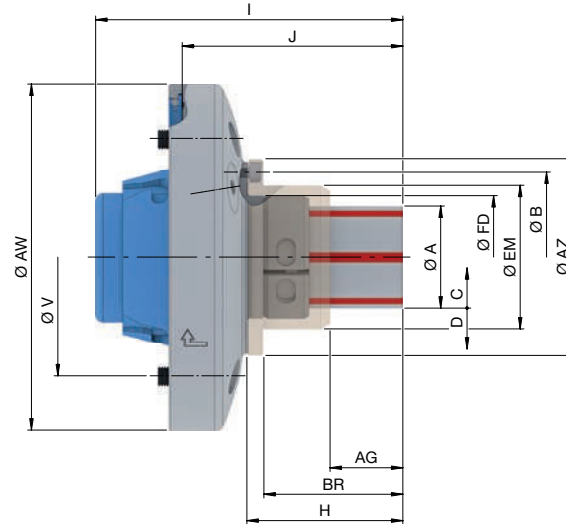
Segmented clamping bushings Page 442	Adaptation ring Page 508	Accessory overview Page 478



ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T812 RD. Technical data



Size	0		
Adaptation size	42/52	65	80
Clamping range [mm]	A	20 – 28	
Run-out ≤ [mm]		0,015	
Release stroke in Ø [mm]	C	0,4	
Reserve stroke in Ø [mm]	D	0,3	
Range / recommended workpiece tolerance [mm]		± 0,25	
Max. clamping length [mm]	AG	21	
Max. axial compression force [kN]		10	
Max. radial clamping force [kN]		42	
RPM n max. [1/min.]	7000	6000	7000
Reception workpiece end-stop	FD	Ø 47 f7	
Bolt hole circle end-stop	B	LK Ø 70 [3 x M6]	
End-stop outer Ø [mm]	AZ	90	
Depth [mm]	BR	51,5	
End-stop outer Ø 2 [mm]	EM	54	
Length [mm]	H	60,5	
Total length [mm]	I	135,5	140,5
Height [mm]	J	94,7	
Bolt hole circle	V	LK Ø 125 [3 x M10]	LK Ø 145 [3 x M10]
Outer Ø [mm]	AW	166	183
Weight [kg]		8	11
In stock		-	-
Material no.	10000472	10000473	10000467

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



Adaptation
clamping devices

Measuring tech-
nology / Automation

Quick change-
over systems

Special solutions

Clamping elements /
Accessories

Services

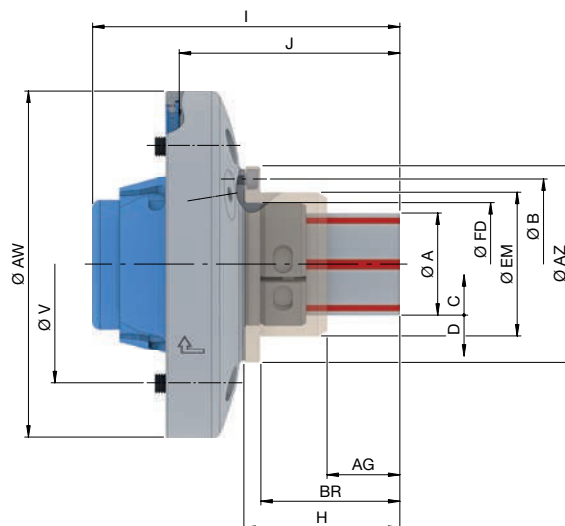
Multi spindles

ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T812 RD. Technical data



Size	1		
Adaptation size	42/52	65	80
Clamping range [mm]	26 – 38		
Run-out ≤ [mm]	0,015		
Release stroke in Ø [mm]	C	0,4	0,5
Reserve stroke in Ø [mm]	D	0,3	0,4
Range / recommended workpiece tolerance [mm]	± 0,25	± 0,35	
Max. clamping length [mm]	AG	25	
Max. axial compression force [kN]		10	
Max. radial clamping force [kN]		42	
RPM n max. [1/min.]	7000	6000	7000
Reception workpiece end-stop	FD	Ø 55 f7	
Bolt hole circle end-stop	B	LK Ø 75 [3 x M6]	
End-stop outer Ø [mm]	AZ	90	
Depth [mm]	BR	57,5	
End-stop outer Ø 2 [mm]	EM	62	
Length [mm]	H	66,5	
Total length [mm]	I	140,5	145,5
Height [mm]	J	99,7	
Bolt hole circle	V	LK Ø 125 [3 x M10]	LK Ø 145 [3 x M10]
Outer Ø [mm]	AW	166	183
Weight [kg]		8	9
In stock		-	✓
Material no.	10000474	10000475	10000476

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

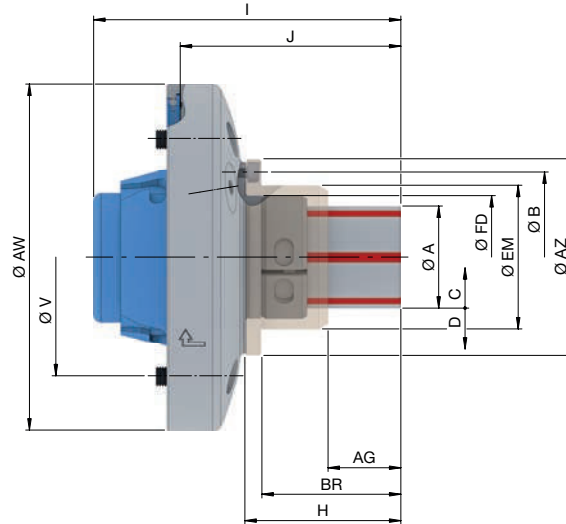




ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T812 RD. Technical data



Size	2		
Adaptation size	42/52	65	80
Clamping range [mm]	A		
Run-out ≤ [mm]	36 – 54		
Release stroke in Ø [mm]	0,015		
Reserve stroke in Ø [mm]	C	0,4	0,5
Range / recommended workpiece tolerance [mm]	D	0,3	0,4
Max. clamping length [mm]	AG	± 0,25	± 0,3
Max. axial compression force [kN]	40		
Max. radial clamping force [kN]	20		
RPM n max. [1/min.]	85		
Reception workpiece end-stop	FD	7000	Ø 65 f7
Bolt hole circle end-stop	B	LK Ø 90 [3 x M6]	
End-stop outer Ø [mm]	AZ	104	
Depth [mm]	BR	73,5	
End-stop outer Ø 2 [mm]	EM	76	
Length [mm]	H	82,5	
Total length [mm]	I	157,5	162,5
Height [mm]	J	116,7	
Bolt hole circle	V	LK Ø 125 [3 x M10]	LK Ø 145 [3 x M10]
Outer Ø [mm]	AW	166	183
Weight [kg]		9	10
In stock		-	11
Material no.	10000462	10000477	10000478

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



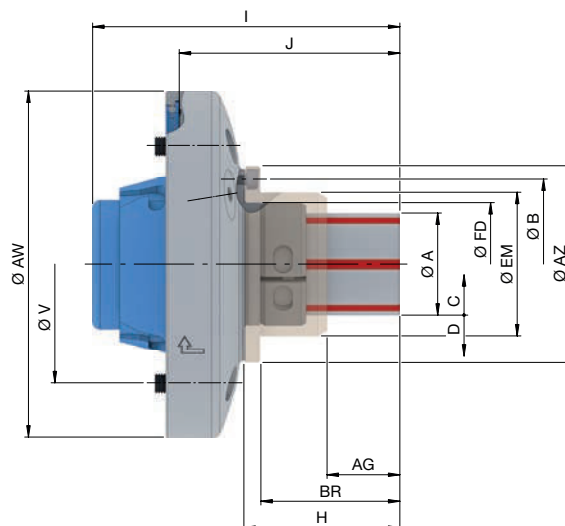
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ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]



MANDO Adapt T812 RD. Technical data



Size	3		
Adaptation size	42/52	65	80
Clamping range [mm]	A		
Run-out ≤ [mm]	50 – 80		
Release stroke in Ø [mm]	0,015		
Reserve stroke in Ø [mm]	C		
Range / recommended workpiece tolerance [mm]	D		
Max. clamping length [mm]	± 0,35		
Max. axial compression force [kN]	AG		
Max. radial clamping force [kN]	44,5		
RPM n max. [1/min.]	25		
Reception workpiece end-stop	105		
Bolt hole circle end-stop	FD		
End-stop outer Ø [mm]	Ø 83 f7		
Depth [mm]	B		
End-stop outer Ø 2 [mm]	LK Ø 104 [3 x M6]		
Length [mm]	120		
Total length [mm]	BR		
Height [mm]	105		
Bolt hole circle	EM		
Outer Ø [mm]	H		
Weight [kg]	89,5		
In stock	I		
Material no.	164,5		
	169,5		
	123,7		
	LK Ø 125 [3 x M10]		
	LK Ø 145 [3 x M10]		
	LK Ø 160 [3 x M10]		
	166		
	183		
	202		
	9		
	11		
	12		
	-		
	10000463		
	10000479		
	10000480		

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.

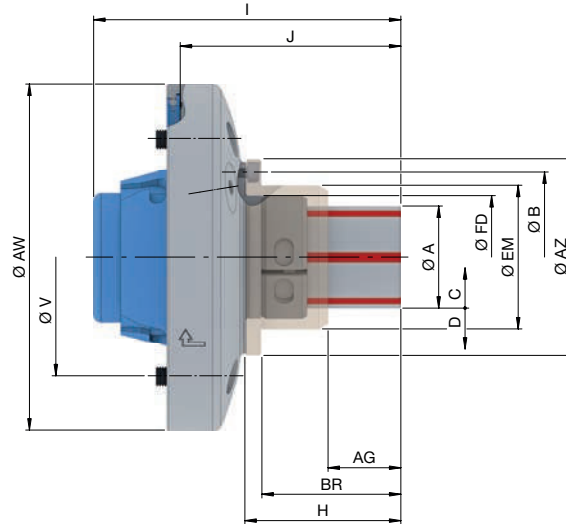
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ADAPTATION CLAMPING DEVICES

MANDO Adapt [mandrel adaptation]

MANDO Adapt T812 RD. Technical data



Size	4	
Adaptation size	65	80
Clamping range [mm]	A	69 – 100
Run-out ≤ [mm]		0,015
Release stroke in Ø [mm]	C	0,5
Reserve stroke in Ø [mm]	D	0,4
Range / recommended workpiece tolerance [mm]		± 0,35
Max. clamping length [mm]	AG	52,5
Max. axial compression force [kN]		35
Max. radial clamping force [kN]		150
RPM n max. [1/min.]		6000
Reception workpiece end-stop	FD	Ø 103 f7
Bolt hole circle end-stop	B	LK Ø 124 [3 x M6]
End-stop outer Ø [mm]	AZ	138
Depth [mm]	BR	90,5
End-stop outer Ø 2 [mm]	EM	124
Length [mm]	H	100
Total length [mm]		179,5
Height [mm]	J	133,7
Bolt hole circle	V	LK Ø 145 [3 x M10]
Outer Ø [mm]	AW	183
Weight [kg]		12
In stock		-
Material no.	10000481	10000468

Mounting precision for rotating clamping devices: Run-out ≤ 0.005 mm between chuck and adaptation clamping device. Run-out errors on the chuck must also be taken into consideration. Mounting repeatability for stationary clamping devices: ≤ 0.003 mm on the adaptation clamping device.



		
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