DEMMELER® 3D welding tables
DEMMELER® Manipulators
DEMMELER® COBOT WeldSpace 4.0®

demmeler®

THE welding table
THE ORIGINAL

Debaenst
LASTECHNIEK

Original 3D welding tables and automation solutions from the inventor

Highly productive and flexible solutions for welding production

DEMMELER SYSTEM COMPATBILITY



EN

www.demmeler.com

Debaenst Lastechniek



CLAMPING WITHOUT COMPROMISING

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

We offer you a very wide product portfolio of 3D clamping systems – perfectly tailored to your requirements.
You therefore have the right solution for every one of your challenges.

DEMMELER has been creating innovative solutions for machinery and plant construction for over 60 years now.
These set global standards. This is also backed up by countless global patents and awards for our products.
Our technological advantage based on intensive development work is the reason for many customers' collaboration, often spanning decades.









60 years
est. 1961

PREMIUM QUALITY
MADE IN GERMANY

DEMMELER Maschinenbau GmbH & Co. KG · Alpenstraße 10 · 87751 Heimertingen/Germany
Personally liable partner: Johannes Demmeler · DEMMELER Maschinenbau Verwaltungs GmbH/Heimertingen
Memmingen County Court/HRB 13149 · Managing Director: Johannes DEMMELER · Place of jurisdiction: Memmingen
Memmingen Country Court/HRA 11517 · VAT ID no. DE 812 035 092

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→ **Highly automated vertical range of manufacture**
→ **Best delivery capability**

Welcome to DEMMELER – the inventor of the original 3D welding table

Dear business partners and customers,

We are delighted to present to you our high-quality and unique products – some of which are also patented – in a compact, clearly structured format over around 300 pages. Starting with the proven original DEMMELER® quality welding tables in system sizes D28, D22 and D16, including a sophisticated, incredibly durable and extensive range of DEMMELER® accessories, which you can order in coordinated sets or can compile individually from our wide selection to meet your requirements. If you have something bigger in mind, there are no limits when you use our floor plates or rail systems with patented sliding leg system.

You can expect the very highest standards from workspaces that are equipped with our tools. Our Ergonomix M manipulator series promises the best ergonomics and comes with the largest swivel range on the market – 180° – as standard. We offer partly automated, highly productive and modern workspaces with our new, ultra innovative robot and COBOT WeldSpace 4.0® systems. This is an important step towards continuing to make welding workstations economical and attractive in future.

DEMMELER® original products retain their value, so you are choosing quality without compromising.
Your investment in a successful future.

Kind regards,
Johannes Demmeler
Managing Partner

By phone: **+49 (0) 83 35 / 98 59-0**
By e-mail: **sales@demmeler.com**
or in the online shop: **www.demmeler.com**

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FROM THE BEGINNING –

PIONEERING SPIRIT, AMBITION AND STRONG VALUES.

2009
Ergonomix M® manipulator series –
the specialist for ergonomic welding work

1990
3D welding tables –
THE original for over 30 years





1975 Manufacture of rotary tilting tables

1990 Development of the world's first 3D work table and welding table systems

1998 Development and manufacture of the first robot-based tool arena with 300 tools

2001 Start of the production of basic components for machine tools

2005 Development and manufacture of the first NC turning and sliding table

2009 Development and manufacture of the Ergonomix MANIPULATOR

2010 Development and manufacture of carousel rotary tables

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DEMMELER inventions that span the globe – we have been setting innovative standards in welding production for over 30 years.

In 1961, Ludwig Demmeler founded the company in a garage at the age of 19. With ideas, courage and great commitment, the company has been able to develop very successfully up to the present day. **In 2014, Ludwig Demmeler received the Federal Cross of Merit of the Federal Republic of Germany for his entrepreneurial success and for his important voluntary work as a local master craftsman.** The second generation, Johannes Demmeler, has been working in the company since 1990 and has been responsible for the success of the group as managing director since 2001.
DEMMELER set the standard on the market as an important milestone **back in 1990 with the invention of the 3D clamping system and D28 3D welding table.** Originally intended for the company's own production processes, the fixture system proved to be a quantum leap in metalworking and is now an international standard for trade and industry due to the many possible applications and combinations. Today, DEMMELER operates with the **highest vertical range of manufacture and highly automated processes**, on more than 40,000 m² of factory space. The company's growth was accompanied by several **product developments and patents**, which were first created only for their own production facilities. Once they have been put through their paces, we deliver these products to tens of thousands of customers worldwide. In addition to the **3D clamping system, these also include the turning, tilting and carousel rotary tables, as well as three-axis manipulators, tool arenas and machine tool components**. With our unique new development, the **COBOT WeldSpace 4.0®**, we have succeeded in developing a perfect product that professionalises welding workstations, starting with small and medium-sized companies, despite the shortage of skilled workers, and thus makes them ready for the future. In the future, you can continue to rely on our **quality and the innovation of the original, made by DEMMELER**, to achieve the best results.

WORLD INNOVATION
THE FUTURE OF WELDING

60 years
est. 1961



2021
COBOT WeldSpace 4.0 – the professional COBOT welding automation solution


2011 Development and production of the ROBOTIX manipulator


2012 Development and production of the PPC clamping bolt


2013 Development and production of turning units up to 25 t


2014 Development and production of rotary tables with pallet changeover systems


2015 Development and production of the 3D welding table system D22


2017 Development and production of direct-drive rotary tables

NEW

2020 New development and production of the COBOT WeldSpace 4.0® – a welding cell for automated welding

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Alongside outstanding 3D welding tables – what you can expect from us





Unparalleled product benefits

+ **Excellent value for money**
  The multifunctional tool means that you need far less equipment to clamp your workpieces. So you save both money and storage space.

+ **Optimum access to the workpiece – ergonomically designed**
  This saves time in production and increases quality. The multifunctional tool can be set up in such a way that it takes up the smallest amount of space on the table. The rest of the tool can be adapted so that it "disappears" under the surface of the table inside the practical "clever toolbox".

+ **Extremely long service life for a return on your investment**
  Through top "Made in Germany" quality, we reduce life-cycle costs and ensure the longest service life for our products.

+ **All products are made in-house – in Germany**
  As the inventor of the 3D clamping system, all of our highly automated manufacturing processes are performed in-house at our Heimertingen site. We set up our systems ourselves and so we are our own most critical customer.

+ **Professionals work with DEMMELER**
  We supply high-quality clamping systems which make work fun. Made by professionals for professionals!

+ **Find out information and order online**
  For more information about our wide range of products, please visit our website at www.demmeler.com.

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Globally linked

With our global distribution network, we can be found wherever our solutions can help make production more efficient. We use on-site consultations to develop tailor-made solutions in partnership with our customers. Always in line with the philosophy: You have a need, we have the solution! Our customers around the world benefit from our wealth of knowledge acquired throughout numerous successful projects.

A reliable partner by your side

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

Subscribe to our YouTube channel for many example products and applications.

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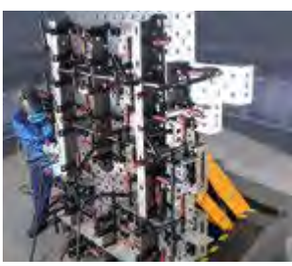
WELDING TABLES
THE ORIGINAL
FROM THE INVENTOR
BY DEMMELER

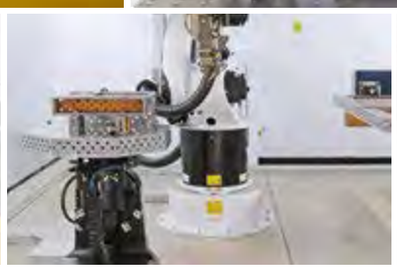
THE 3D CLAMPING SYSTEM FROM DEMMELER. THE ORIGINAL.

ONE SYSTEM FOR VARIOUS TASKS

Nowadays, solutions need to perfectly fulfil various tasks. Ideally as a complete solution, a modular, coordinated system. This is why we continuously optimise our products to meet the needs of all relevant industries. This results in innovative and efficient solutions which perfectly fulfil their intended purpose. Robust and reliable. Efficient and economical. Modular and versatile. That's the 3D clamping system from DEMMELER.







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THE STANDARD SOLUTION FOR INDUSTRY AND TRADE.

Automation

Machinery and plant construction

Steel constructions/ metal constructions

Vehicle construction

Shipbuilding

Aircraft construction










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OUR 3D CLAMPING SY
TO MEET YOUR REQUI

The 3D clamping system from DEMMELER. Unlimited possibilities.

No matter the scale of your projects. As a provider of systems and solutions, DEMMELER doesn't aim to offer everything that is possible but rather only what a user needs for their individual requirements. A system that can be integrated and extended without any hassle and actually offers added value. And therefore a system that makes a difference. The 3D clamping system from DEMMELER. Unlimited possibilities.





1 **It couldn't be simpler**
Simple handling, modular and durable. Our wide product range of 3D clamping systems is perfectly tailored to meet your requirements.

2 **More freedom for your work**
If the component is larger, the worktop of the 3D welding table can easily be extended with the system components from DEMMELER.

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STEM GROWS
REMENTS



3

When you have something big in mind

You have access to the comprehensive selection of DEMMELER accessories to set up your clamping fixtures on the rail system too, and can combine all system components.



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SIMPLY PERFECT. THE EXTENSIVE RANGE OF ACCESSORIES FROM DEMMELER.

Accessories from DEMMELER offer maximum freedom and flexibility in everyday work. Achieve results precisely and economically – with the product range that is perfectly tailored to all purposes, you have the ideal solution for any task.







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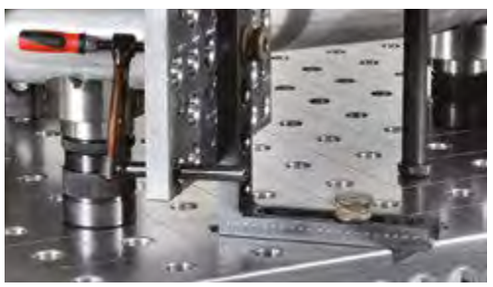



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DEMMELER®
3D welding tables

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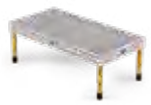
Overview of leg versions 24

D28



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3D measuring, assembly and adjustment table
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Table legs
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Scissor lift
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Connecting frame Pivoting leg
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D22



PROFIPremiumLINE (PP)
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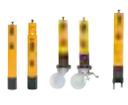

Table legs
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PROFIEcoLINE (PE)
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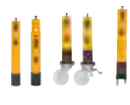

Table legs
page 45

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Sophisticated down to the smallest detail – product highlights

Welding results

When using the 3D clamping system, the optimum flow of electricity between the electrode/filler wire and earth connection is vitally important for the welding results. That is why DEMMELER optimises the material properties of its welding tables and accessories and guarantees outstanding precision for optimum form fits. Although hardened welding tables are even more robust and better protected against weld spatter, their conductivity tends to be reduced. Here again, DEMMELER has developed optimum solutions in the form of the DEMONT 760 M and DEMONT 890 M versions. That's how DEMMELER ensures optimum conditions for ideal welding results!

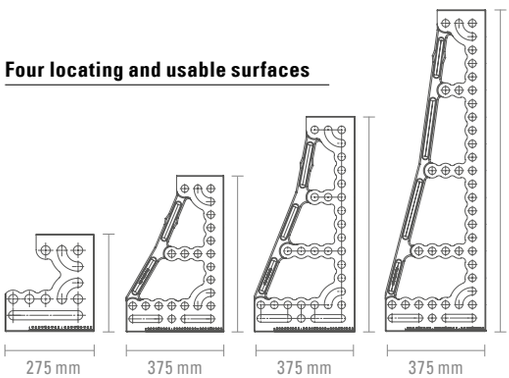
DEMONT 760 M and DEMONT 890 M ①
Excellent conductivity for optimum welding results,
extremely tough design and outstanding protection against weld spatter
SOLID standard hardness ②
Outstanding conductivity for optimum welding results,
tough design and good protection against weld spatter



PROFIPremiumLINE locating and clamping angles

The aluminium titanium design is lightweight enough to permit optimised, extremely simple handling. Only by using the patented PPC clamping bolt is it possible to clamp the angles without causing wear. This results an unlimited service life.
The kidney-shaped 90° system groove makes continuous angle adjustment possible. The extended face plate and increased number of cross braces provide additional bores for clamping. The precision scaling makes adjustment much easier.

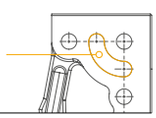
Four locating and usable surfaces



Angle heights, aluminium titanium:
300, 600, 800 and 1200 mm

Angle heights, hardened cast:
300, 600 and 800 mm

Reinforcements in the corners with a 90° system groove in the shape of a kidney allow continuously variable use, even with angular adjustment



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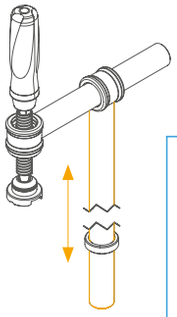


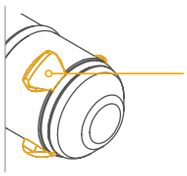
Screw clamp

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



PPC bolts – the perfect connection

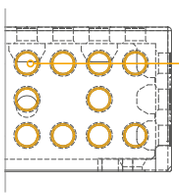
- Self-centring, force-fitting and low-wear clamping
- Very quick clamping and releasing
- Force-fitting through full-area contact
- Reduces material wear
- Minimal susceptibility to dirt
- Extremely tough – guaranteeing a long service life



Even force distribution across the polygonal bolts reduces bore hole wear compared to conventional bolts. The cone clamping system achieves a support surface that is 100 times larger.

Intelligent system grid

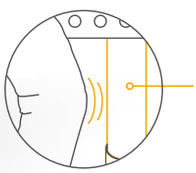
Thanks to the three-row drilling pattern on the side post, DEMMELER welding tables can be extended on a modular basis – and offer outstanding stability, toughness and a very high load-bearing capacity.



Additional bores in the side posts for even more clamping options

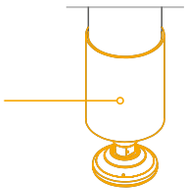
Pivoting leg

The extremely solid design ensures a very high load-bearing capacity – 3000 kg per leg. The leg sleeve prevents pinching and reduces wear of the tube assembly. This also provides a convenient way of using the earth connection. It also protects the threaded spindle against dirt and wear. Precision adjustment is possible and fixing is stable and simple.



Pivoting leg based on round tube, unlike square table legs does not get caught on or collide with the edges of the table legs.

Leg sleeves prevent pinching of the welding tube and protect the threaded spindle against dirt.



The ideal welding table for every application

The system sizes of the 3D clamping system from DEMMELER!

Ø 28

For everyday, large welded constructions



D28 PROFIPremiumLINE (PP)
- 50 x 50 mm grid
- Three-row bore pattern on the table side plates
- 50 mm grid in the top and bottom rows
- Additional 100 mm grid in the centre



D28 PROFIPlusLINE (PL)
- 100 x 100 mm diagonal grid
- Three-row bore pattern on the table side plates
- 50 mm grid in the top and bottom rows
- Additional 100 mm grid in the centre

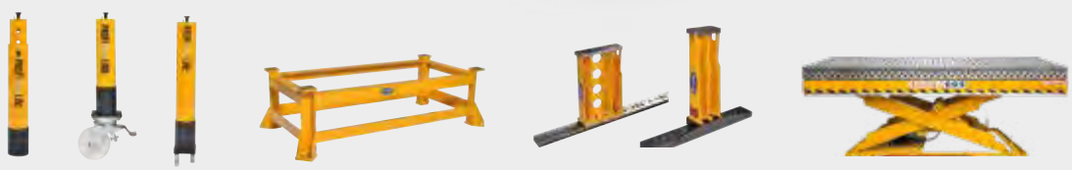


D28 PROFIEcoLINE (PE)
- 100 x 100 mm grid
- Three-row bore pattern on the table side plates
- 50 mm grid in the top and bottom rows
- Additional 100 mm grid in the centre



D28 HobbyLINE (H)
- 100 x 100 mm grid
- Worktop approx. 25 mm high with system bores in a 100 mm x 100 mm grid





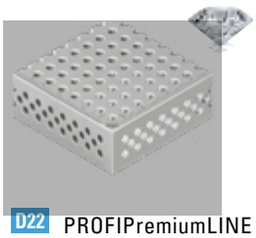
Compatible table legs and clamping options

Debaenst Lastechniek

Optimum positioning of the workpiece not only makes work more accurate but also much more effective. In addition to their hardness, system tables from DEMMELER have clear advantages over conventional tables. Original 3D welding tables from DEMMELER stand out due to their extreme robustness and durability. With the specially optimised DEMONT hardening process, you get the best surface properties with a hardness of up to 890 Vickers – making them wear-free and even more durable.

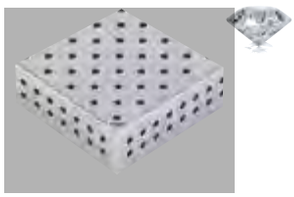
Ø 22

For simple and medium-duty applications



D22 PROFIPremiumLINE (PP)

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



D22 PROFIPlusLINE (PL)

- 100 x 100 mm diagonal grid
- Two-row bore pattern on the table side plates, 50 mm grid

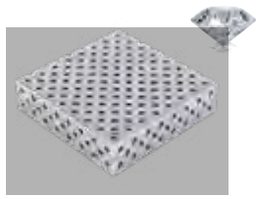




Compatible table legs

Ø 16

For delicate applications



D16 PROFIPlusLINE (PL)

- 50 x 50 mm diagonal grid
- Three-row bore pattern on the table side plates, 50 mm grid in the top, middle and bottom rows



D16 PROFIEcoLINE (PE)

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





Compatible table legs

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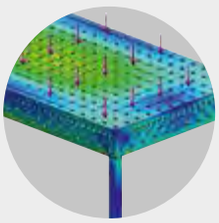
The benefits of a 3D clamping system from DEMMELER!

These include intelligent system grids, axis designations with precision scaling, additional bores and protective countersinks for optimum protection of tools and table surfaces.





Max. load
All of our welding tables are generously sized, super sturdy and generally optimised with FEM calculations.



Precision scaling
Axis designation in x and y directions. Precision scaling included as standard.



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



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



Standard leg
The extremely robust design ensures a very high load-bearing capacity – 3000 kg per leg. The leg sleeve prevents pinching and reduces wear of the tube assembly. This also provides a convenient way of using the earth connection. It also protects the threaded spindle against dirt and wear. Precision adjustment is possible and fixing is stable and simple.

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DEMONT 890 M
Hardened high-alloy steel up to 890 Vickers

DEMONT 760 M
High-strength hardened steel up to 760 Vickers

SOLID
High-strength base material

THE tough ones from DEMMELER – for the toughest requirements

When using the 3D clamping system, the optimum flow of electricity between the electrode/filler wire and earth connection is vitally important for the welding results. That is why DEMMELER optimises the material properties of its welding tables and accessories and guarantees outstanding precision for optimum form fits. Although hardened welding tables are even more robust and better protected against weld spatter, their conductivity tends to be reduced. Here again, DEMMELER has developed optimum solutions in the form of the DEMONT 760 M and DEMONT 890 M versions. That's how DEMMELER ensures optimum conditions for ideal welding results!

DEMONT 760 M and 890 M
Excellent conductivity for optimum welding results, extremely tough design and outstanding protection against weld spatter.

SOLID
Outstanding conductivity for optimum welding results, tough design and good protection against weld spatter.

		DEMONT 890 M	DEMONT 760 M	SOLID
Load	High bearing loads	◆◆◆◆◆	◆◆◆◆◆	◆◆◆◆◆
Evenness	For outstanding tool quality	◆◆◆◆◆	◆◆◆◆	◆◆◆◆◆
Conductivity	For optimum welding results when using the earth connection	◆◆◆◆	◆◆◆◆	◆◆◆◆◆
Base hardness	For high impact resistance	◆◆◆◆◆	◆◆◆◆	◆◆◆
Surface hardness	Resistant to weld spatter	◆◆◆◆◆	◆◆◆◆	◆◆◆

◆◆◆◆◆ = outstanding
◆ = adequate

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Table legs for your welding table.



D28 D22 D16

Standard leg

- Pivoting legs, with ± 30 mm precision adjustment
- Stable M30 threaded spindle
- The leg sleeve protects the threaded spindle against dirt and prevents pinching of the tube assembly
- Also suitable as a support leg in combination with horizontal U-shaped spacer block from a length of 1 m
- Including countersunk mounting screw M24 x 60
- Powder-coated leg tube

To order a standard leg, page 45

D28 D22 D16

Telescopic leg

- Pivoting legs, with ± 30 mm precision adjustment
- Stable M30 threaded spindle
- The leg sleeve protects the threaded spindle against dirt and prevents pinching of the tube assembly
- Telescopic adjustment range of 350 mm in 50 mm increments
- For flexible height adjustment of the welding table
- Including countersunk mounting screw M24 x 60
- Powder-coated leg tube

To order a telescopic leg, page 45

D28 D22 D16

Heavy-duty wheel leg

- With ± 30 mm precision adjustment
- Stable M30 threaded spindle
- The leg sleeve protects the threaded spindle against dirt and prevents pinching of the tube assembly
- Robust design
- With 360° swivel castor
- Max. load capacity 600 kg
- Including countersunk mounting screw M24 x 60
- Powder-coated leg tube

To order a heavy-duty wheel leg, page 45

D28 D22 D16

Anchoring leg

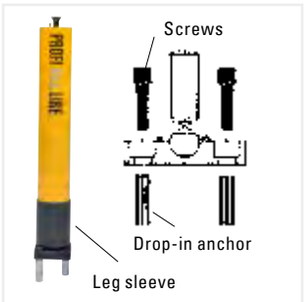
- With ± 30 mm precision adjustment
- Stable M30 threaded spindle
- The leg sleeve protects the threaded spindle against dirt and prevents pinching of the tube assembly
- For secure attachment to the floor of the production facility to protect against tension, pressure and movement (e.g. robot use)
- Including countersunk mounting screw M24 x 60 and, for secure anchoring to the floor, 2x drop-in anchors, 2x cap screws M16 x 40
- Powder-coated leg tube

To order an anchoring leg, page 45









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Connecting elements for a larger surface area and more space.



D28

Table leg for spacer block

- Connecting element between U-shaped spacer blocks or between 3D welding table and support and base rail
- Different set-up heights can be adapted to the workpiece by simply exchanging the table legs
- Available for D28

You can find detailed information about the product in the section about the rail system, page 104

D28

Sliding leg with castors

- Set-up system components can be moved without using lifting equipment or a crane
- Different set-up heights can be adapted to the workpiece by simply exchanging the table legs
- Highest load capacity in the working position because the leg is supported over its entire surface on the rail
- Available for D28

You can find detailed information about the product in the section about the rail system, page 105

D28

Connecting frame

- Precise positioning of 3D work tables using pivoting leg or in a lengthwise and crosswise direction on the support and base rail
- Available for D28

To order a connecting frame, page 49

D28

Scissor lift

- Continuously variable height adjustment
- With safety edge
- Fully adapted to 3D welding table D28
- Including manual control
- Internal/external power unit (depending on size)
- Available for D28

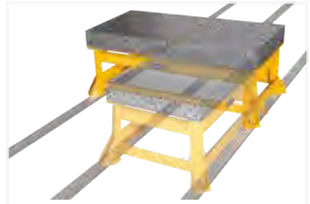
To order a scissor lift, page 48



Attachment to system components

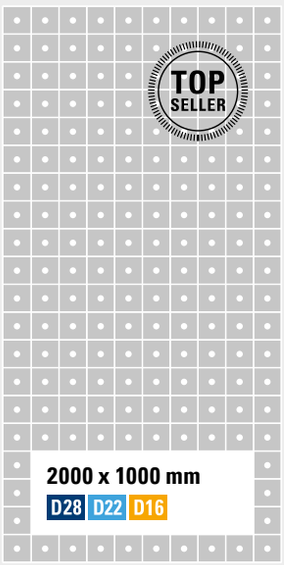


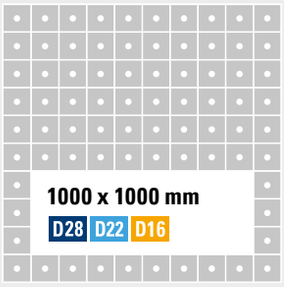
Mounted on roller bearings so as to be movable

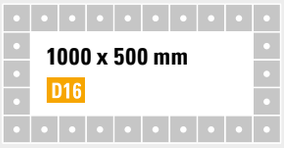


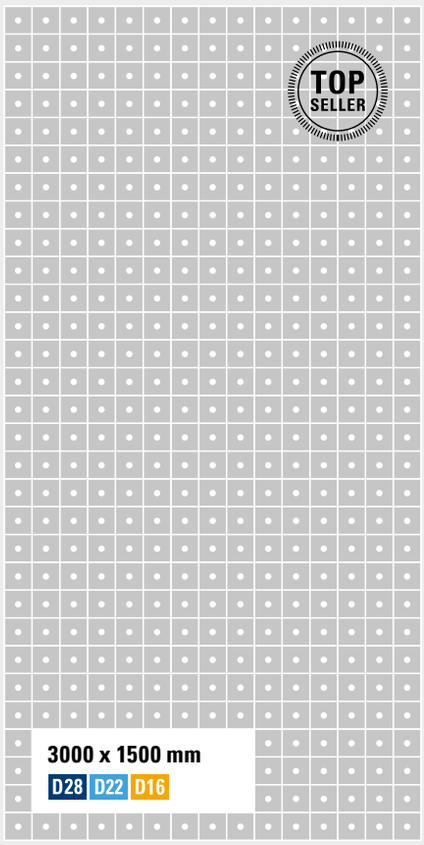
Set up in a lengthwise/ crosswise direction

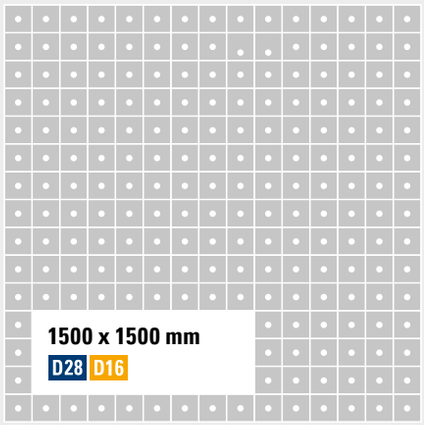


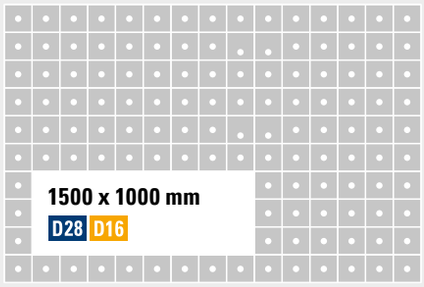


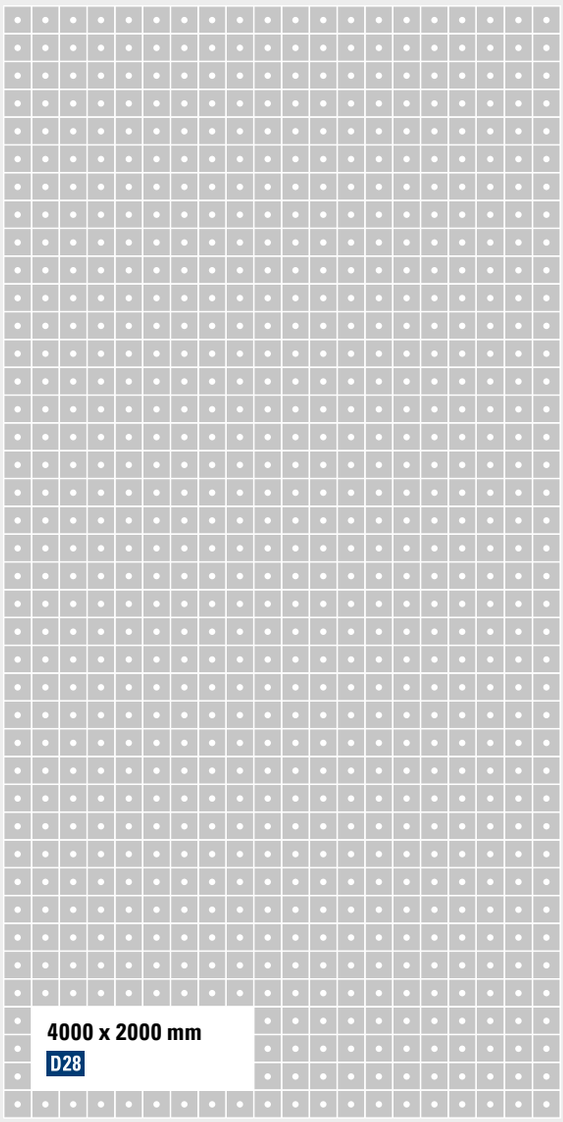


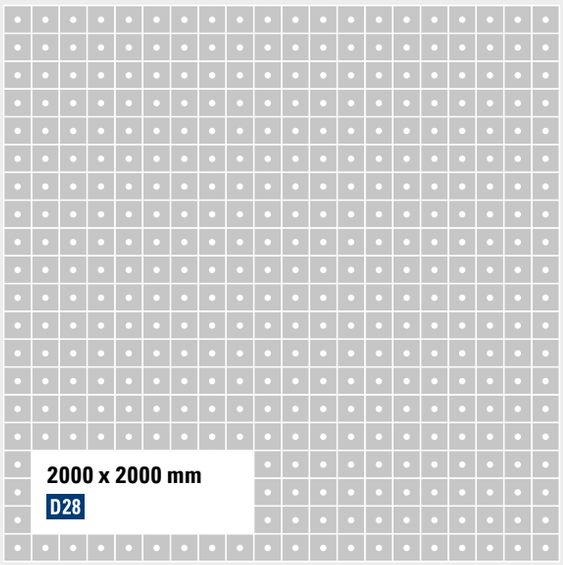












Debaenst Lastechniek

4800 x 2400 mm
D28

2400 x 1200 mm
D28 D22 D16

TOP SELLER

1200 x 1200 mm
D28 D16

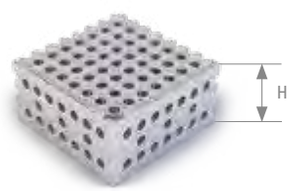
1200 x 800 mm
D28 D16

D28 Standard table sizes

L in mm	W in mm	H in mm
1000	1000	200
1200	800	200
1200	1200	200
1500	1000	200
1500	1500	200
2000	1000	200
2000	2000	200
2400	1200	200
3000	1500	200
4000	2000	200
4800	2400	200

D22 Standard table sizes

L in mm	W in mm	H in mm
1000	1000	150
2000	1000	150
2400	1200	150
3000	1500	150



D16 Standard table sizes

L in mm	W in mm	H in mm
1000	500	100
1000	1000	100
1200	800	100
1200	1200	100
1500	1000	100
1500	1500	100
2000	1000	100
2400	1200	100
3000*	1500	100

*Consisting of two
1500 x 1500 x 100 mm

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

Debaenst Lastechniek



Up to 400 % more clamping options.

DEMMELER® 3D welding tables D28 PROFIPremiumLINE (PP)

3D welding tables from DEMMELER. Well-equipped.

Max. load



Precision scaling



Protective countersink



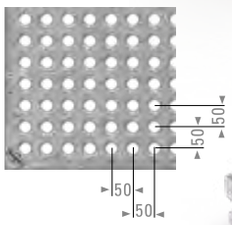
Leg sleeve

3D welding table D28 PROFIPremiumLINE (PP)

D28

- Worktop with D28 system bores in a **50 x 50 mm grid**, resulting in approx. 400% more clamping options than with PROFIEcoLINE and conventional welding tables and approx. 100% more clamping options than with PROFIPlusLINE
- Three-row bore pattern on the table side plates with D28 system bores: **50 mm grid in the top and bottom rows and an additional 100 mm grid in the centre**, almost doubling the options for extension and clamping
- Table sizes optionally available in hardened versions – DEMONT 760 M and DEMONT 890 M
- All system bores with protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous grid lines in X and Y directions, spaced 100 mm apart
- Precision scaling with millimetre graduation, also available with the DEMONT 760 M and DEMONT 890 M options
- Coordinate marking of the bores in the X and Y directions
- DEMMELER logo recessed in all four side plates
- Table legs with precision adjustment, round design with pivoting leg
- Leg sleeve to protect the tube assembly
- Special dimensions and optional drilling patterns (e.g. M16, M20, M24) possible on request
- The table is also available in a stainless steel version on request

WELDING TABLES THE ORIGINAL FROM THE INVENTOR BY DEMMELER



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



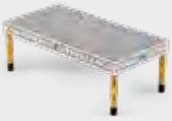
Three-row bore pattern with **50 mm grid in the top and bottom rows** and additional **100 mm grid in the centre**

Debaenst Lastechniek

The table sizes. With or without standard table legs.



3D welding table D28 PROFIPremiumLINE (PP) – without standard table legs					D28		
					SOLID	Hardened DEMONT 760 M	Hardened DEMONT 890 M
L x W in mm	H in mm	Approx. weight in kg	Max. load in kg	Number of legs	Item no.	Item no.	Item no.
1000 x 1000	200	290	–	No legs	PP28-01001-000	PP28-01001-500	PP28-01001-700
1200 x 800	200	280	–	No legs	PP28-11019-000	PP28-11019-500	PP28-11019-700
1200 x 1200	200	380	–	No legs	PP28-01056-000	PP28-01056-500	PP28-01056-700
1500 x 1000	200	390	–	No legs	PP28-01011-000	PP28-01011-500	PP28-01011-700
1500 x 1500	200	530	–	No legs	PP28-01031-000	PP28-01031-500	PP28-01031-700
2000 x 1000	200	500	–	No legs	PP28-01002-000	PP28-01002-500	PP28-01002-700
2000 x 2000	200	1000	–	No legs	PP28-01006-000	PP28-01006-500	PP28-01006-700
2400 x 1200	200	710	–	No legs	PP28-01003-000	PP28-01003-500	PP28-01003-700
3000 x 1500	200	1010	–	No legs	PP28-01004-000	PP28-01004-500	PP28-01004-700
4000 x 2000	200	1780	–	No legs	PP28-01005-000	PP28-01005-500	PP28-01005-700
4800 x 2400	200	2550	–	No legs	PP28-11085-000	PP28-11085-500	PP28-11085-700



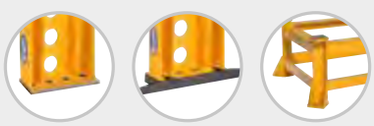
3D welding table D28 PROFIPremiumLINE (PP) – with standard table legs					D28		
					SOLID	Hardened DEMONT 760 M	Hardened DEMONT 890 M
L x W in mm	H in mm*	Approx. weight in kg	Max. load in kg	Number of legs	Item no.	Item no.	Item no.
1000 x 1000	850 ±30	324	12000	4	PP28-01001-001	PP28-01001-011	PP28-01001-021
1200 x 800	850 ±30	314	12000	4	PP28-11019-001	PP28-11019-011	PP28-11019-021
1200 x 1200	850 ±30	414	12000	4	PP28-01056-001	PP28-01056-011	PP28-01056-021
1500 x 1000	850 ±30	424	12000	4	PP28-01011-001	PP28-01011-011	PP28-01011-021
1500 x 1500	850 ±30	564	12000	4	PP28-01031-001	PP28-01031-011	PP28-01031-021
2000 x 1000	850 ±30	534	12000	4	PP28-01002-001	PP28-01002-011	PP28-01002-021
2000 x 2000	850 ±30	1034	12000	4	PP28-01006-001	PP28-01006-011	PP28-01006-021
2400 x 1200	850 ±30	744	12000	4	PP28-01003-001	PP28-01003-011	PP28-01003-021
3000 x 1500	850 ±30	1061	18000	6	PP28-01004-001	PP28-01004-011	PP28-01004-021
4000 x 2000	850 ±30	1831	18000	6	PP28-01005-001	PP28-01005-011	PP28-01005-021
4800 x 2400	850 ±30	2644	33000	11	PP28-11085-001	PP28-11085-011	PP28-11085-021

*The length of the standard table legs in the basic configuration is 650 mm ±30 mm.
The standard table legs are also available in a length of 750 mm ±30 mm, see page 45.

Different leg versions are possible for this system size D28



For more information and an overview of the table leg versions, see page 45 onwards



For table mounting versions for the rail system, see page 104 onwards

You can also find out about **the leg versions** and **connecting elements** online.



Our bestseller.

DEMMELER® 3D welding tables D28 PROFIPlusLINE (PL)

3D welding tables from DEMMELER. Well-equipped.

Max. load



Precision scaling



Protective countersink

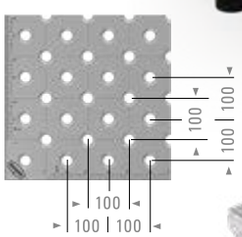


Leg sleeve

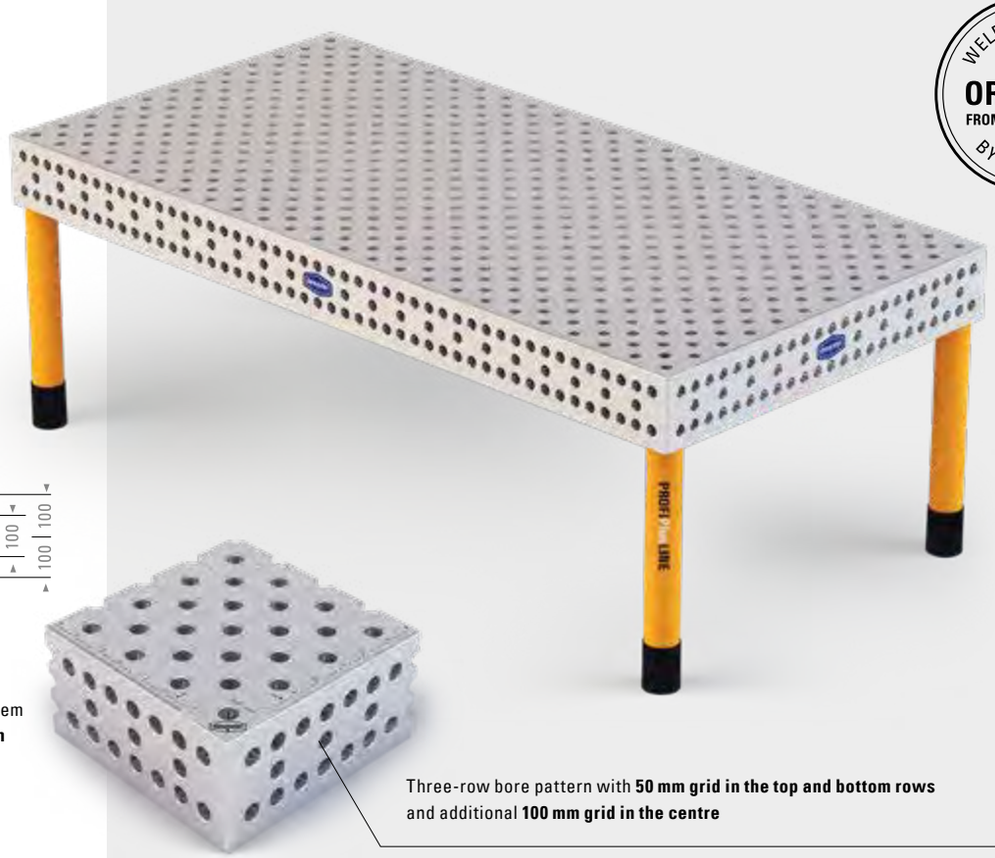
3D welding table D28 PROFIPlusLINE (PL)

D28

- Worktop with D28 system bores in a **100 x 100 mm double grid**, resulting in approx. 80% more clamping options than with PROFIEcoLINE and conventional welding tables
- Three-row bore pattern on the table side plates with D28 system bores: **50 mm grid in the top and bottom rows and an additional 100 mm grid in the centre**, almost doubling the options for extension and clamping
- Table sizes optionally available in hardened versions – DEMONT 760 M and DEMONT 890 M
- All system bores with protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous grid lines in X and Y directions, spaced 100 mm apart
- Precision scaling with millimetre graduation, also available with the DEMONT 760 M and DEMONT 890 M options
- Coordinate marking of the bores in the X and Y directions
- DEMMELER logo recessed in all four side plates
- Table legs with precision adjustment, round design with pivoting leg
- Leg sleeve to protect the tube assembly
- Special dimensions and optional drilling patterns (e.g. M16, M20, M24) possible on request
- The table is also available in a stainless steel version on request



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



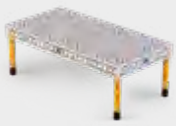
Three-row bore pattern with **50 mm grid in the top and bottom rows** and additional **100 mm grid in the centre**

Debaenst Lastechniek

The table sizes. With or without standard table legs.



3D welding table D28 PROFIPlusLINE (PL) – without standard table legs					D28		
					SOLID	Hardened DEMONT 760 M	Hardened DEMONT 890 M
L x W in mm	H in mm	Approx. weight in kg	Max. load in kg	Number of legs	Item no.	Item no.	Item no.
1000 x 1000	200	310	–	No legs	PL28-01001-000	PL28-01001-500	PL28-01001-700
1200 x 800	200	300	–	No legs	PL28-11019-000	PL28-11019-500	PL28-11019-700
1200 x 1200	200	410	–	No legs	PL28-01056-000	PL28-01056-500	PL28-01056-700
1500 x 1000	200	430	–	No legs	PL28-01011-000	PL28-01011-500	PL28-01011-700
1500 x 1500	200	590	–	No legs	PL28-01031-000	PL28-01031-500	PL28-01031-700
2000 x 1000	200	550	–	No legs	PL28-01002-000	PL28-01002-500	PL28-01002-700
2000 x 2000	200	1050	–	No legs	PL28-01006-000	PL28-01006-500	PL28-01006-700
2400 x 1200	200	790	–	No legs	PL28-01003-000	PL28-01003-500	PL28-01003-700
3000 x 1500	200	1150	–	No legs	PL28-01004-000	PL28-01004-500	PL28-01004-700
4000 x 2000	200	1980	–	No legs	PL28-01005-000	PL28-01005-500	PL28-01005-700
4800 x 2400	200	2830	–	No legs	PL28-11085-000	PL28-11085-500	PL28-11085-700



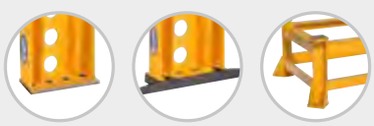
3D welding table D28 PROFIPlusLINE (PL) – with standard table legs					D28		
					SOLID	Hardened DEMONT 760 M	Hardened DEMONT 890 M
L x W in mm	H in mm*	Approx. weight in kg	Max. load in kg	Number of legs	Item no.	Item no.	Item no.
1000 x 1000	850 ±30	344	12000	4	PL28-01001-001	PL28-01001-011	PL28-01001-021
1200 x 800	850 ±30	334	12000	4	PL28-11019-001	PL28-11019-011	PL28-11019-021
1200 x 1200	850 ±30	444	12000	4	PL28-01056-001	PL28-01056-011	PL28-01056-021
1500 x 1000	850 ±30	464	12000	4	PL28-01011-001	PL28-01011-011	PL28-01011-021
1500 x 1500	850 ±30	624	12000	4	PL28-01031-001	PL28-01031-011	PL28-01031-021
2000 x 1000	850 ±30	584	12000	4	PL28-01002-001	PL28-01002-011	PL28-01002-021
2000 x 2000	850 ±30	1084	12000	4	PL28-01006-001	PL28-01006-011	PL28-01006-021
2400 x 1200	850 ±30	824	12000	4	PL28-01003-001	PL28-01003-011	PL28-01003-021
3000 x 1500	850 ±30	1201	18000	6	PL28-01004-001	PL28-01004-011	PL28-01004-021
4000 x 2000	850 ±30	2031	18000	6	PL28-01005-001	PL28-01005-011	PL28-01005-021
4800 x 2400	850 ±30	2925	33000	11	PL28-11085-001	PL28-11085-011	PL28-11085-021

*The length of the standard table legs in the basic configuration is 650 mm ±30 mm.
The standard table legs are also available in a length of 750 mm ±30 mm, see page 45.

Different leg versions are possible for this system size D28



For more information and an overview of the table leg versions, see page 45 onwards



For table mounting versions for the rail system, see page 104 onwards

You can also find out about **the leg versions** and **connecting elements** online.



Functional and versatile.

DEMMELER® 3D welding tables D28 PROFIEcoLINE (PE)

3D welding table D28 PROFIEcoLINE (PE)

D28

- Worktop with D28 system bores in a 100 x 100 mm grid
- Three-row bore pattern on the table side plates with D28 system bores: **50 mm grid in the top and bottom rows and an additional 100 mm grid in the centre**, almost doubling the options for extension and clamping
- Table sizes optionally available in hardened versions – DEMONT 760 M and DEMONT 890 M
- All system bores with protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous grid lines in X and Y directions, spaced 100 mm apart
- Precision scaling with millimetre graduation, also available with the DEMONT 760 M and DEMONT 890 M options
- Coordinate marking of the bores in the X and Y directions
- DEMMELER logo recessed in all four side plates
- Table legs with precision adjustment, round design with pivoting leg
- Leg sleeve to protect the tube assembly
- Special dimensions and optional drilling patterns (e.g. M16, M20, M24) possible on request
- The table is also available in a stainless steel version on request

3D welding tables from DEMMELER. Well-equipped.

Max. load



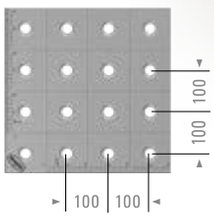
Precision scaling



Protective countersink



Leg sleeve



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

WELDING TABLES THE ORIGINAL FROM THE INVENTOR BY DEMMELER



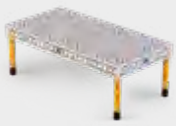
NEW: Three-row bore pattern with **50 mm grid in the top and bottom rows** and additional **100 mm grid in the centre**

Debaenst Lastechniek

The table sizes. With or without standard table legs.



3D welding table D28 PROFIEcoLINE (PE) – without standard table legs					D28		
					SOLID	Hardened DEMONT 760 M	Hardened DEMONT 890 M
L x W in mm	H in mm	Approx. weight in kg	Max. load in kg	Number of legs	Item no.	Item no.	Item no.
1000 x 1000	200	330	–	No legs	PE28-01001-000	PE28-01001-500	PE28-01001-700
1200 x 800	200	310	–	No legs	PE28-11019-000	PE28-11019-500	PE28-11019-700
1200 x 1200	200	430	–	No legs	PE28-01056-000	PE28-01056-500	PE28-01056-700
1500 x 1000	200	450	–	No legs	PE28-01011-000	PE28-01011-500	PE28-01011-700
1500 x 1500	200	610	–	No legs	PE28-01031-000	PE28-01031-500	PE28-01031-700
2000 x 1000	200	570	–	No legs	PE28-01002-000	PE28-01002-500	PE28-01002-700
2000 x 2000	200	1100	–	No legs	PE28-01006-000	PE28-01006-500	PE28-01006-700
2400 x 1200	200	820	–	No legs	PE28-01003-000	PE28-01003-500	PE28-01003-700
3000 x 1500	200	1180	–	No legs	PE28-01004-000	PE28-01004-500	PE28-01004-700
4000 x 2000	200	2090	–	No legs	PE28-01005-000	PE28-01005-500	PE28-01005-700
4800 x 2400	200	2980	–	No legs	PE28-11085-000	PE28-11085-500	PE28-11085-700



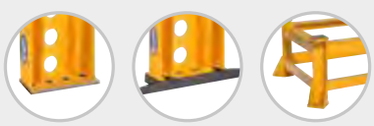
3D welding table D28 PROFIEcoLINE (PE) – with standard table legs					D28		
					SOLID	Hardened DEMONT 760 M	Hardened DEMONT 890 M
L x W in mm	H in mm*	Approx. weight in kg	Max. load in kg	Number of legs	Item no.	Item no.	Item no.
1000 x 1000	850 ±30	364	12000	4	PE28-01001-001	PE28-01001-011	PE28-01001-021
1200 x 800	850 ±30	344	12000	4	PE28-11019-001	PE28-11019-011	PE28-11019-021
1200 x 1200	850 ±30	464	12000	4	PE28-01056-001	PE28-01056-011	PE28-01056-021
1500 x 1000	850 ±30	484	12000	4	PE28-01011-001	PE28-01011-011	PE28-01011-021
1500 x 1500	850 ±30	644	12000	4	PE28-01031-001	PE28-01031-011	PE28-01031-021
2000 x 1000	850 ±30	604	12000	4	PE28-01002-001	PE28-01002-011	PE28-01002-021
2000 x 2000	850 ±30	1134	12000	4	PE28-01006-001	PE28-01006-011	PE28-01006-021
2400 x 1200	850 ±30	854	12000	4	PE28-01003-001	PE28-01003-011	PE28-01003-021
3000 x 1500	850 ±30	1231	18000	6	PE28-01004-001	PE28-01004-011	PE28-01004-021
4000 x 2000	850 ±30	2141	18000	6	PE28-01005-001	PE28-01005-011	PE28-01005-021
4800 x 2400	850 ±30	3074	33000	11	PE28-11085-001	PE28-11085-011	PE28-11085-021

*The length of the standard table legs in the basic configuration is 650 mm ±30 mm.
The standard table legs are also available in a length of 750 mm ±30 mm, see page 45.

Different leg versions are possible for this system size D28



For more information and an overview of the table leg versions, see page 45 onwards



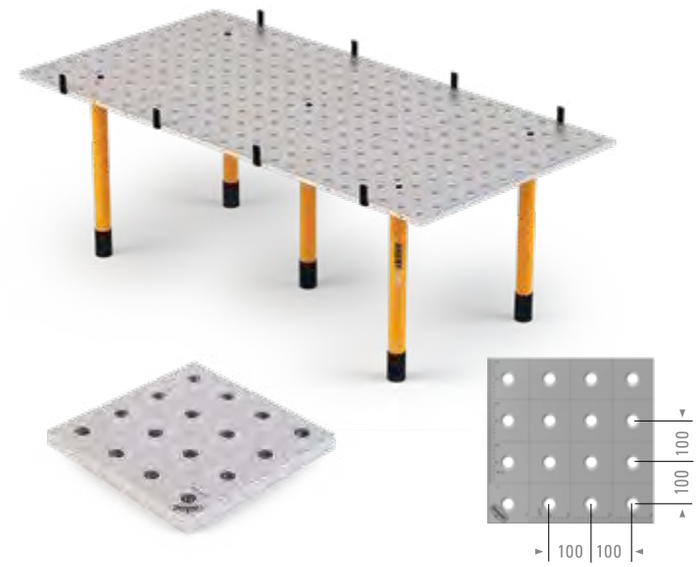
For table mounting versions for the rail system, see page 104 onwards

You can also find out about **the leg versions** and **connecting elements** online.

Board HobbyLINE (H) D28

D28

- Cost-effective alternative for low loads
- Worktop approx. 25 mm high with D28 system bores in a **100 mm x 100 mm grid**
- Accessories for all D28 system lines (PROFIEcoLINE, PROFI-PlusLINE and PROFIPremiumLINE) can be used on the worktop
- M8 tapped holes on all four sides of the worktop including eight outer stops with screw
- All system bores with protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Continuous grid lines in X and Y directions, spaced 100 mm apart
- Table legs with precision adjustment, round design with pivoting leg
- Leg sleeve to protect the tube assembly
- Special dimensions and optional drilling patterns (e.g. M16, M20, M24) possible on request. The table is also available in a stainless steel version on request.



Board HobbyLINE (H) D28 – without standard table legs

D28 | SOLID



L x W in mm	H in mm	Approx. weight in kg	Max. load in kg	Number of legs	Item no.
1000 x 1000	25	180	–	No legs	H28-01001-000
1200 x 800	25	180	–	No legs	H28-11019-000
1200 x 1200	25	260	–	No legs	H28-01056-000
1500 x 1000	25	270	–	No legs	H28-01011-000
2000 x 1000	25	360	–	No legs	H28-01002-000
2400 x 1200	25	510	–	No legs	H28-01003-000

Board HobbyLINE (H) D28 – with standard table legs

D28 | SOLID



L x W in mm	H in mm	Approx. weight in kg	Max. load in kg	Number of legs	Item no.
1000 x 1000	850 ±30	204	600	4	H28-01001-001
1200 x 800	850 ±30	204	600	4	H28-11019-001
1200 x 1200	850 ±30	284	600	4	H28-01056-001
1500 x 1000	850 ±30	300	600	5	H28-01011-001
2000 x 1000	850 ±30	390	600	5	H28-01002-001
2400 x 1200	850 ±30	540	600	5	H28-01003-001

Standard table leg D28 for Hobby board



H in mm	Approx. weight in kg	Item no.
826 ±30	6	PL16-10010-005

Different leg versions are possible for this system size D28



For additional leg versions, see page 45 onwards

3D welding tables from DEMMELER. Well-equipped.



Precision scaling



Protective countersink



Leg sleeve

Debaenst Lastechniek

3D measuring, assembly and adjustment table D28

D28

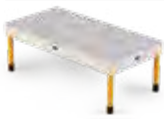
- Evenness 0.1 mm/m
- Outstanding precision for adjusting, measuring and assembling components
- Optimised outside table edges
- Including precision scaling/grid lines
- Improved table reinforcement through additional cross-ribs
- DEMMELER logo recessed in all four side plates



3D measuring, assembly and adjustment table D28 – without standard table legs

	L x W in mm	H in mm	Approx. weight in kg	Max. load in kg	Number of legs	D28 SOLID Item no.
	2000 x 1000	200	610	–	No legs	M28-01002-000
	2400 x 1200	200	890	–	No legs	M28-01003-000
	3000 x 1500	200	1300	–	No legs	M28-01004-000

3D measuring, assembly and adjustment table D28 – with standard table legs

	L x W in mm	H in mm*	Approx. weight in kg	Max. load in kg	Number of legs	D28 SOLID Item no.
	2000 x 1000	850 ±30	644	12000	4	M28-01002-001
	2400 x 1200	850 ±30	924	12000	4	M28-01003-001
	3000 x 1500	850 ±30	1354	18000	6	M28-01004-001

*The length of the standard table legs in the basic configuration is 650 mm ±30 mm.
The standard table legs are also available in a length of 750 mm ±30 mm, see page 45.

**3D welding tables from DEMMELER.
Well-equipped.**


Precision scaling


Evenness
0.1 mm/m


Leg sleeve

Different leg versions are possible for this system size D28





For additional leg versions, see page 45 onwards

Debaenst Lastechniek



Up to 200 % more clamping options.

DEMMELER® 3D welding tables D22 PROFIPremiumLINE (PP)

3D welding table D22 PROFIPremiumLINE (PP)

D22

- Worktop with D22 system bores in a **50 x 50 mm grid**, resulting in 200% more clamping options than with PROFIPlusLINE
- Three-row bore pattern on the table side plates with D22 system bore in a **50 x 50 mm diagonal grid**, doubling the expansion and clamping options
- Table sizes optionally available in a hardened version – DEMONT 760 M
- All system bores with protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous grid lines in X and Y directions, spaced 100 mm apart
- Precision scaling with millimetre division, including with the DEMONT 760 M option
- Coordinate marking of the bores in the X and Y directions
- DEMMELER logo recessed in all four side plates
- Table legs with precision adjustment, round design with pivoting leg
- Leg sleeve to protect the tube assembly
- Special dimensions and optional drilling patterns (e.g. M16, M20, M24) possible on request
- The table is also available in a stainless steel version on request

3D welding tables from DEMMELER. Well-equipped.

Max. load



Precision scaling



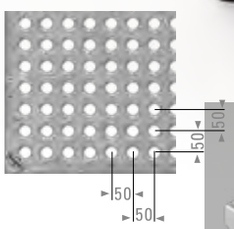
Protective countersink



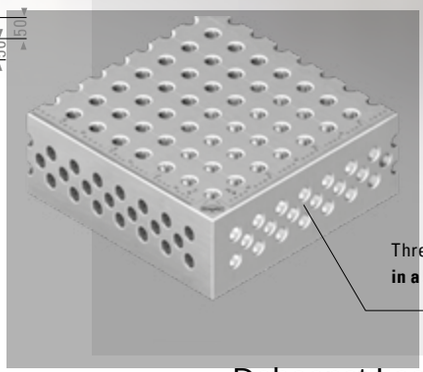
Leg sleeve

WELDING TABLES THE ORIGINAL FROM THE INVENTOR BY DEMMELER





Worktop with D22 system bores in a **50 x 50 mm grid**



Three-row bore pattern on the table side plates with D22 system bores **in a 50 x 50 mm diagonal grid**

Debaenst Lastechniek

The table sizes. With or without standard table legs.



3D welding table D22 PROFIPremiumLINE (PP) – without standard table legs

					D22	
					SOLID	Hardened DEMONT 760 M
L x W in mm	H in mm	Approx. weight in kg	Max. load in kg	Number of legs	Item no.	Item no.
1000 x 1000	150	200	–	No legs	PP22-01001-000	PP22-01001-500
2000 x 1000	150	350	–	No legs	PP22-01002-000	PP22-01002-500
2400 x 1200	150	500	–	No legs	PP22-01003-000	PP22-01003-500
3000 x 1500	150	735	–	No legs	PP22-01004-000	PP22-01004-500



3D welding table D22 PROFIPremiumLINE (PP) – with standard table legs

					D22	
					SOLID	Hardened DEMONT 760 M
L x W in mm	H in mm*	Approx. weight in kg	Max. load in kg	Number of legs	Item no.	Item no.
1000 x 1000	850 ±30	234	12000	4	PP22-01001-001	PP22-01001-011
2000 x 1000	850 ±30	423	12000	4	PP22-01002-001	PP22-01002-011
2400 x 1200	850 ±30	534	12000	4	PP22-01003-001	PP22-01003-011
3000 x 1500	850 ±30	786	18000	6	PP22-01004-001	PP22-01004-011

*The length of the standard table legs in the basic configuration is 700 mm ±30 mm.
The standard table legs are also available in a length of 800 mm ±30 mm, see page 45.

Different leg versions are possible for this system size D22



For more information and an overview of the table leg versions, see page 45 onwards

You can also find out about **the leg versions** online.



The all-rounder.

DEMMELER® 3D welding tables D22 PROFIPlusLINE (PL)

3D welding table D22 PROFIPlusLINE (PP)

D22

- Worktop with D22 system bores in a **100 x 100 mm diagonal grid**
- Two-row bore pattern on the table side plates with D22 system bores in a **50 mm grid**
- Table sizes optionally available in a hardened version – DEMONT 760 M
- All system bores with protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Improved table reinforcement through additional cross-ribs
- Continuous grid lines in X and Y directions, spaced 100 mm apart
- Precision scaling with millimetre division, including with the DEMONT 760 M option
- Coordinate marking of the bores in the X and Y directions
- DEMMELER logo recessed in all four side plates
- Table legs with precision adjustment, round design with pivoting leg
- Leg sleeve to protect the tube assembly
- Special dimensions and optional drilling patterns (e.g. M16, M20, M24) possible on request
- The table is also available in a stainless steel version on request

3D welding tables from DEMMELER. Well-equipped.

Max. load



Precision scaling



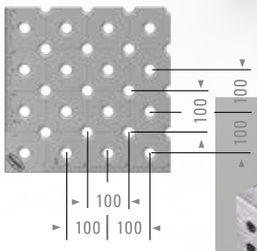
Protective countersink



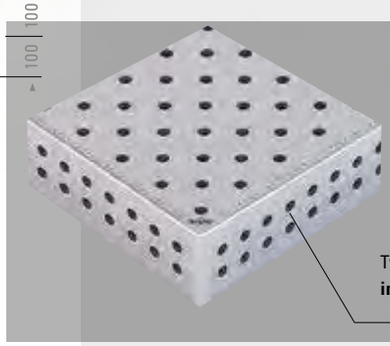
Leg sleeve

WELDING TABLES THE ORIGINAL FROM THE INVENTOR BY DEMMELER





Worktop with D22 system bores in a **100 x 100 mm diagonal grid**



Two-row bore pattern on the table side plates with D22 system bores **in a 50 mm grid**

Debaenst Lastechniek

The table sizes. With or without standard table legs.



3D welding table D22 PROFIPlusLINE (PL) – without standard table legs					D22	
					SOLID	Hardened DEMONT 760 M
L x W in mm	**H in mm**	**Approx. weight in kg**	**Max. load in kg**	**Number of legs**	**Item no.**	**Item no.**
1000 x 1000	150	210	–	No legs	PL22-01001-000	PL22-01001-500
2000 x 1000	150	375	–	No legs	PL22-01002-000	PL22-01002-500
2400 x 1200	150	535	–	No legs	PL22-01003-000	PL22-01003-500
3000 x 1500	150	785	–	No legs	PL22-01004-000	PL22-01004-500



3D welding table D22 PROFIPlusLINE (PL) – with standard table legs					D22	
					SOLID	Hardened DEMONT 760 M
L x W in mm	**H in mm***	**Approx. weight in kg**	**Max. load in kg**	**Number of legs**	**Item no.**	**Item no.**
1000 x 1000	850 ±30	244	12000	4	PL22-01001-001	PL22-01001-011
2000 x 1000	850 ±30	409	12000	4	PL22-01002-001	PL22-01002-011
2400 x 1200	850 ±30	569	12000	4	PL22-01003-001	PL22-01003-011
3000 x 1500	850 ±30	836	18000	6	PL22-01004-001	PL22-01004-011

*The length of the standard table legs in the basic configuration is 700 mm ±30 mm.
The standard table legs are also available in a length of 800 mm ±30 mm, see page 45.

Different leg versions are possible for this system size D22



For more information and an overview of the table leg versions, see page 45 onwards

You can also find out about **the leg versions** online.



Up to 80 % more clamping options.

DEMMELER® 3D welding tables D16 PROFIPlusLINE (PL)

3D welding tables from DEMMELER. Well-equipped.

Max. load



Precision scaling



Protective countersink



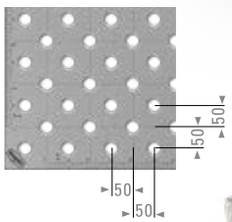
Leg sleeve

3D welding table D16 PROFIPlusLINE (PL)

D16

- Worktop with D16 system bores in a **50 x 50 mm double grid**, resulting in approx. 80% more clamping options than with PROFIEcoLINE and conventional welding tables
- Three-row bore pattern on the table side plates with D16 system bores, **50 mm grid in the top, middle and bottom rows**
- Table sizes optionally available in a hardened version – DEMONT 760 M
- All system bores with protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Continuous grid lines in X and Y directions, spaced 50 mm apart
- Precision scaling with millimetre division, including with the DEMONT 760 M option
- Coordinate marking of the bores in the X and Y directions
- DEMMELER logo recessed in all four side plates
- Table legs with precision adjustment, round design with pivoting leg
- Leg sleeve to protect the tube assembly
- Special dimensions and optional drilling patterns (e.g. M16, M20, M24) possible on request
- The table is also available in a stainless steel version on request

WELDING TABLES THE ORIGINAL FROM THE INVENTOR BY DEMMELER



Worktop with D16 system bores in a **50 x 50 mm double grid**



Three-row bore pattern on the table side plates with D16 system bores **in a 50 mm grid in the top, middle and bottom rows**

Debaenst Lastechniek

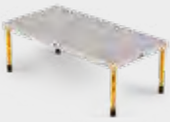
The table sizes. With or without standard table legs.



3D welding table D16 PROFIPlusLINE (PL) – without standard table legs

					D16	
					SOLID	Hardened DEMONT 760 M
L x W in mm	**H in mm**	**Approx. weight in kg**	**Max. load in kg**	**Number of legs**	**Item no.**	**Item no.**
1000 x 500	100	70	–	No legs	PL16-01000-000	PL16-01000-500
1000 x 1000	100	119	–	No legs	PL16-01001-000	PL16-01001-500
1200 x 800	100	123	–	No legs	PL16-11019-000	PL16-11019-500
1200 x 1200	100	162	–	No legs	PL16-01056-000	PL16-01056-500
1500 x 1000	100	179	–	No legs	PL16-01017-000	PL16-01017-500
1500 x 1500	100	253	–	No legs	PL16-01011-000	PL16-01011-500
2000 x 1000	100	229	–	No legs	PL16-01002-000	PL16-01002-500
2400 x 1200	100	326	–	No legs	PL16-01003-000	PL16-01003-500
3000** x 1500	100	506	–	No legs	PL16-01004-000	PL16-01004-500

**Consisting of two 1500 x 1500 x 100 mm



3D welding table D16 PROFIPlusLINE (PL) – with standard table legs

					D16	
					SOLID	Hardened DEMONT 760 M
L x W in mm	**H in mm***	**Approx. weight in kg**	**Max. load in kg**	**Number of legs**	**Item no.**	**Item no.**
1000 x 500	850 ±30	104	8000	4	PL16-01000-001	PL16-01000-011
1000 x 1000	850 ±30	154	8000	4	PL16-01001-001	PL16-01001-011
1200 x 800	850 ±30	154	8000	4	PL16-11019-001	PL16-11019-011
1200 x 1200	850 ±30	194	8000	4	PL16-01056-001	PL16-01056-011
1500 x 1000	850 ±30	204	8000	4	PL16-01017-001	PL16-01017-011
1500 x 1500	850 ±30	274	8000	4	PL16-01011-001	PL16-01011-011
2000 x 1000	850 ±30	264	8000	4	PL16-01002-001	PL16-01002-011
2400 x 1200	850 ±30	364	8000	4	PL16-01003-001	PL16-01003-011
3000** x 1500	850 ±30	548	16000	8	PL16-01004-001	PL16-01004-011

*The length of the standard table legs in the basic configuration is 750 mm ±30 mm.
The standard table legs are also available in a length of 850 mm ±30 mm, see page 45.

**Consisting of two 1500 x 1500 x 100 mm

Different leg versions are possible for this system size D16



For more information and an overview of the table leg versions, see page 45 onwards

You can also find out about **the leg versions** online.



For delicate applications.

DEMMELER® 3D welding tables D16 PROFIEcoLINE (PE)

3D welding table D16 PROFIEcoLINE (PE)

D16

- Worktop with D16 system bores in a **50 x 50 mm grid**
- Three-row bore pattern on the table side plates with D16 system bores, **50 mm grid in the top, middle and bottom rows**
- Table sizes optionally available in a hardened version – DEMONT 760 M
- All system bores with protective countersink, perfect design and ultimate functionality
- Optimised outside table edges
- Continuous grid lines in X and Y directions, spaced 50 mm apart
- Precision scaling with millimetre division, including with the DEMONT 760 M option
- Coordinate marking of the bores in the X and Y directions
- DEMMELER logo recessed in all four side plates
- Table legs with precision adjustment, round design with pivoting leg
- Leg sleeve to protect the tube assembly
- Special dimensions and optional drilling patterns (e.g. M16, M20, M24) possible on request
- The table is also available in a stainless steel version on request

3D welding tables from DEMMELER. Well-equipped.

Max. load



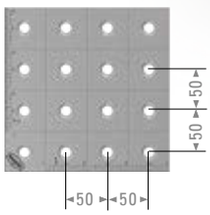
Precision scaling



Protective countersink



Leg sleeve



Worktop with D16 system bores **in a 50 x 50 mm grid**

WELDING TABLES THE ORIGINAL FROM THE INVENTOR BY DEMMELER



Three-row bore pattern on the table side plates with D16 system bores **in a 50 mm grid in the top, middle and bottom rows**

Debaenst Lastechniek

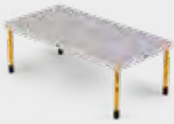
The table sizes. With or without standard table legs.



3D welding table D16 PROFIEcoLINE (PE) – without standard table legs

					D16	
					SOLID	Hardened DEMONT 760 M
L x W in mm	H in mm	Approx. weight in kg	Max. load in kg	Number of legs	Item no.	Item no.
1000 x 500	100	74	–	No legs	PE16-01000-000	PE16-01000-500
1000 x 1000	100	127	–	No legs	PE16-01001-000	PE16-01001-500
1200 x 800	100	131	–	No legs	PE16-11019-000	PE16-11019-500
1200 x 1200	100	173	–	No legs	PE16-01056-000	PE16-01056-500
1500 x 1000	100	190	–	No legs	PE16-01017-000	PE16-01017-500
1500 x 1500	100	270	–	No legs	PE16-01011-000	PE16-01011-500
2000 x 1000	100	238	–	No legs	PE16-01002-000	PE16-01002-500
2400 x 1200	100	347	–	No legs	PE16-01003-000	PE16-01003-500
3000** x 1500	100	540	–	No legs	PE16-01004-000	PE16-01004-500

**Consisting of two 1500 x 1500 x 100 mm



3D welding table D16 PROFIEcoLINE (PE) – with standard table legs

					D16	
					SOLID	Hardened DEMONT 760 M
L x W in mm	H in mm*	Approx. weight in kg	Max. load in kg	Number of legs	Item no.	Item no.
1000 x 500	850 ±30	109	8000	4	PE16-01000-001	PE16-01000-011
1000 x 1000	850 ±30	164	8000	4	PE16-01001-001	PE16-01001-011
1200 x 800	850 ±30	164	8000	4	PE16-11019-001	PE16-11019-011
1200 x 1200	850 ±30	204	8000	4	PE16-01056-001	PE16-01056-011
1500 x 1000	850 ±30	214	8000	4	PE16-01017-001	PE16-01017-011
1500 x 1500	850 ±30	284	8000	4	PE16-01011-001	PE16-01011-011
2000 x 1000	850 ±30	274	8000	4	PE16-01002-001	PE16-01002-011
2400 x 1200	850 ±30	384	8000	4	PE16-01003-001	PE16-01003-011
3000** x 1500	850 ±30	568	16000	8	PE16-01004-001	PE16-01004-011

*The length of the standard table legs in the basic configuration is 750 mm ±30 mm.
The standard table legs are also available in a length of 850 mm ±30 mm, see page 45.

**Consisting of two 1500 x 1500 x 100 mm

Different leg versions are possible for this system size D16

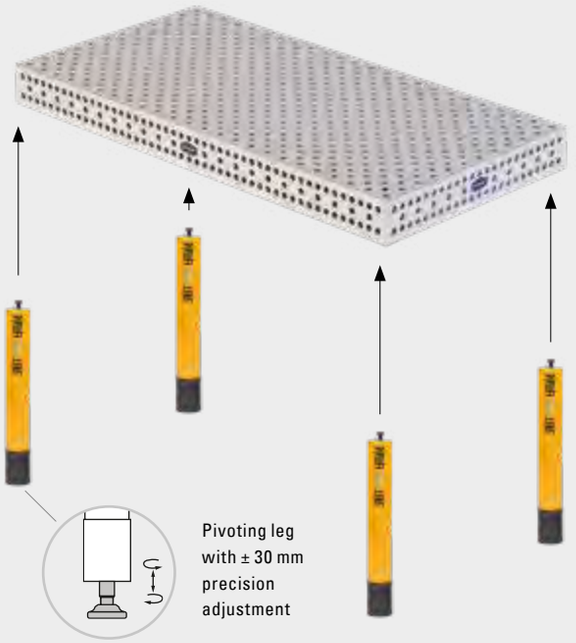


For more information and an overview of the table leg versions, see page 45 onwards

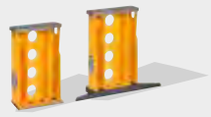
You can also find out about **the leg versions** online.

Legs you can rely on!

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



You can find compatible legs for setting up your system on the DEMMELER® rail system from page 96 onwards.





The right table legs for any application

	Standard leg			Telescopic leg			Heavy-duty wheel			Anchoring leg		
	D28	D22	D16	D28	D22	D16	D28	D22	D16	D28	D22	D16
PROFIPremiumLINE	●	●		●	●		●	●		●	●	
PROFIPLusLINE	●	●	●	●	●	●	●	●	●	●	●	●
PROFIEcoLINE	●		●	●		●	●		●	●		●
HobbyLINE	●			●			●			●		

Ordering example



A From page 28 onwards, select the required worktop, which results in order item **A**:
e.g. 1x **PL28-01031-000**



B From the right-hand side, choose
1. the required leg type
2. in the necessary quantity,
which results in order item **B**: **e.g.** 4x **PL28-10010-001**



C The two order item numbers make up your order from DEMMELER.
e.g. 1x **PL28-01031-000 (A)** + 4x **PL28-10010-001 (B)**

Debaenst Lastechniek

1. Table leg types

Standard leg



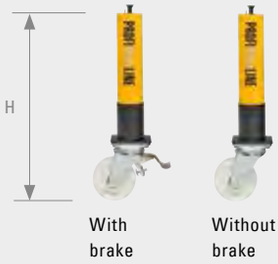
	D28	D22	D16
H in mm	650*1 ± 30	700 ± 30	750 ± 30
Weight in kg	6,3	6,6	5,3
Max. load in kg	3000	3000	2000
Item no.	PL28-10010-000	PL22-10010-000	PL16-10010-000
H in mm	750*1 ± 30	800 ± 30	850 ± 30
Weight in kg	6,9	7,2	5,7
Max. load in kg	3000	3000	2000
Item no.	PL28-10010-191	PL22-10010-007	PL16-10010-006

Telescopic leg



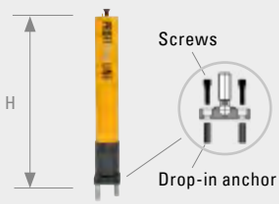
	D28	D22	D16
H in mm	550 to 900 ± 30	600 to 950 ± 30	550 to 900 ± 30
Weight in kg	10,2	10,6	6,12
Max. load in kg	3000	3000	2000
Item no.	PL28-10010-001	PL22-10010-001	PL16-10010-001

Heavy-duty wheel



	D28	D22	D16
H in mm	650*1 ± 30	700 ± 30	750 ± 30
Max. load in kg	600	600	300
Heavy-duty wheel with brake			
Weight in kg	10	10	8,6
Item no.	PL28-10010-002	PL22-10010-002	PL16-10010-002
Heavy-duty wheel without brake			
Weight in kg	9	9,4	8,15
Item no.	PL28-10010-003	PL22-10010-003	PL16-10010-003

Anchoring leg



	D28	D22	D16
H in mm	650*1 ± 30	700 ± 30	750 ± 30
Weight in kg	8,5	8,8	7,3
Max. load in kg	3000	3000	2000
Item no.	PL28-10010-004	PL22-10010-004	PL16-10010-004

2. Number of table legs for each table size

Table size	1000 x 500	1000 x 1000	1200 x 800	1200 x 1200	1500 x 1000	1500 x 1500	2000 x 1000	2000 x 2000	2400 x 1200	3000 x 1500	4000 x 2000	4800 x 2400
Standard leg	4	4	4	4	4	4	4	4	4	6*4	6	11
Telescopic leg	4	4	4	4	4	4	4	4	4	6*4	6	11
Heavy-duty wheel	2*2 + 2*3	2*2 + 2*3	2*2 + 2*3	2*2 + 2*3	2*2 + 2*3	2*2 + 2*3	2*2 + 2*3	2*2 + 2*3	2*2 + 2*3	2*2 + 4*3*4	2*2 + 4*3	2*2 + 9*3
Anchoring leg	4	4	4	4	4	4	4	4	4	6*4	6	11

*1 Other leg heights possible on request *2 Wheel with brake *3 Wheel without brake *4 D16 welding tables consisting of 2x 1500 x 1500 x 100; eight table legs are required in total

Debaenst Lastechniek

DEMMELER® 3D welding tables
Horizontal movement on the rail system

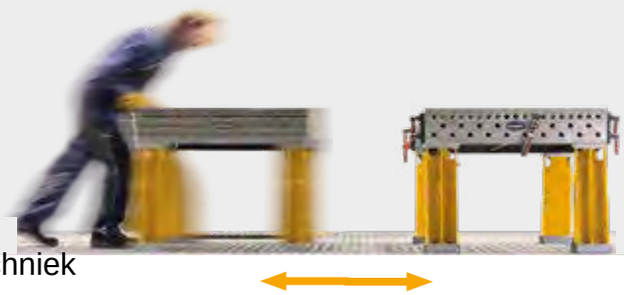


Both horizontally and vertically – clamp large components precisely and securely

Flexibly moving system components horizontally on the rail system

The versatility of the rail system allows you to flexibly extend or divide your workspaces, offering crucial advantages for varying component sizes or different work steps. The combination of 3D welding tables, spacer blocks and accessories results in countless clamping options. The patented DEMMELER® sliding legs with castors are easy to move on the DEMMELER® support and base rails and can be positioned with precision.

DEMMELER® sliding legs with castors make it possible to easily move set-up system components on the DEMMELER® rail system.



Debaenst Lastechniek



Scissor lifts for ergonomic work at the ideal height

In addition to various table legs, we also offer solutions for especially heavy components. Our scissor lift allows you to adjust the height of the welding and clamping table quickly and continuously. This enables every welding and assembly workstation to be lifted or lowered to the ideal height, individually adapting to different clamping situations.



Designed for loads up to max. 1–6 tonnes depending on the table size (minus the weight of the worktop)

Scissor lift with continuously variable height adjustment. Available in the standard table sizes.



Debaenst Lastechniek

Scissor lift

- Continuously variable height adjustment
- With safety edge
- Fully adapted to the 3D welding table
- Including manual control
- Internal/external power unit (depending on size)
- The mounting kit is not included in the scope of delivery

D28



WORK SMART

Scissor lift — D28



For table size in mm	Load capacity	H in mm	Approx. weight in kg	Item no.
1000 x 1000	1 t – table weight	385-1310	155	00016008
1200 x 800	1 t – table weight	200-900	300	00090594
1200 x 1200	2 t – table weight	200-900	530	00041421
1500 x 1000	2 t – table weight	200-1000	500	00040820
1500 x 1500	2 t – table weight	280-1080	620	00002460
2000 x 1000	2 t – table weight	230-1230	650	00000628
2000 x 2000	2 t – table weight	280-1280	950	00090591
2400 x 1200	2 t – table weight	260-1560	810	00000629
3000 x 1500	3 t – table weight	350-1950	1000	00000627
4000 x 2000	5 t – table weight	460-2060	2100	00019552
4800 x 2400	6 t – table weight	460-2060	2100	00090601

Other sizes available on request.



The scissor lift is available for all D28 standard table sizes



Practical manual control for height adjustment



Continuously adjustable height

Ordering example



A From page 28 onwards, select the required worktop, which results in order item **A**:
e.g. 1x **PL28-01003-700**

B From this page, select the compatible scissor lift, which results in order item **B**:
e.g. 1x **00000629**

C The two order item numbers make up your order from DEMMELER. The compatible mounting kit is offered to you automatically.
e.g. 1x **PL28-01003-700 (A)** + 1x **00000629 (B)**

Debaenst Lastechniek

Connecting frame

- Precise positioning of 3D welding tables is possible in a lengthwise and crosswise direction on the support and base rail
- Very stable design for extremely high loads
- You can find compatible worktops on page 102

D28



Connecting frame — D28



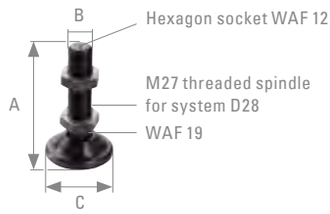
For table size in mm	Track width in mm	H in mm	Approx. weight in kg	Max. load in kg	Item no.
1000 x 1000	1000/1000	600	158	15000	PL00-02004-000
1200 x 1200					
1500 x 1000					
1500 x 1500					
2000 x 1000	2000/1000	600	229	15000	PL00-02004-001
2000 x 2000					
2400 x 1200					
3000 x 1500					
4000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

Other sizes available on request.

Pivoting leg M27

- The leg spindle can be used in any D28 system bore, for example to position the connecting frame or other system components on pivoting legs
- Scope of delivery: Sturdy M27 threaded spindle with ball head, pivoting leg disc and 2 x M27 nuts
- Not for table leg corners

D28



Pivoting leg M27 — D28



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



Compatible system accessories

Support and base rail
See page 98



Support and base rail XL
See page 98



Support and base rail DUO
See page 100



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Sets

D28	D22	D16
 **PROFIPremiumLINE sets 710, 720, 730, 740** from page 52	 **PROFIPlusLINE sets 710, 720, 730** from page 68	 **PROFIPlusLINE sets 155, 255, 720, 355** from page 72
 **PROFIPlusLINE sets 710, 720, 730, 740** from page 58		 **PROFIEcoLINE sets 710, 720, 730, 200, 300** from page 78
 **PROFIEcoLINE sets 710, 720, 730, 740** from page 64		

Debaenst Lastechniek

With PPC bolt

PROFIPremiumLINE set 710 D28



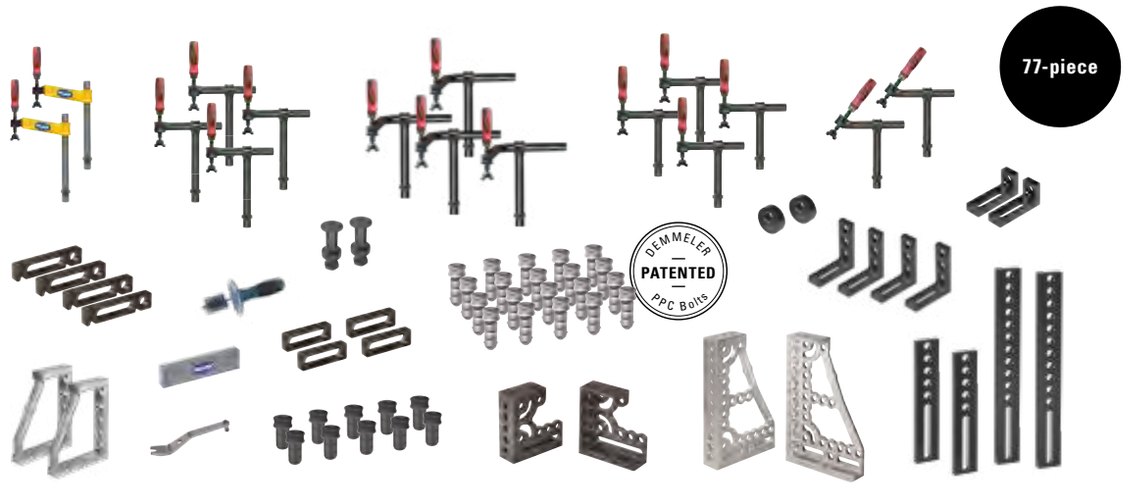
PROFIPremiumLINE set 710 D28		D28
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D28 PL, L175, bore/oblong hole	PE28-03001-000
1	Locating and clamping angle D28 PP 300, right	P28-03002-000
1	Locating and clamping angle D28 PP 300, left	P28-03002-001
4	Universal stop D28 large, L225, two notches	D28-05001-010
2	Stop bar D28, L500	D28-05003-000
4	Sliding stop D28, L150	D28-05015-000
6	Stop and positioning bolt D28	D28-06009-000
12	PPC bolt D28, short	D28-06025-000
2	Compensating screw clamp D28 200, L350, spindle	D28-07002-000
4	Screw clamp 180° D28, L270, spindle	D28-07005-000
4	Performance clamp D28, L270, spindle	D28-07009-033
1	Round brush D28, splash guard	D28-10002-000
1	Assembly lever, L250, WAF 14	D00-10016-001
	46-piece set	**P28-52000-710**

DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it's possible to use the accessories from the PROFIPremiumLINE set on a PROFIPlusLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

Debaenst Lastechniek

With PPC bolt

PROFIPremiumLINE set 720 D28



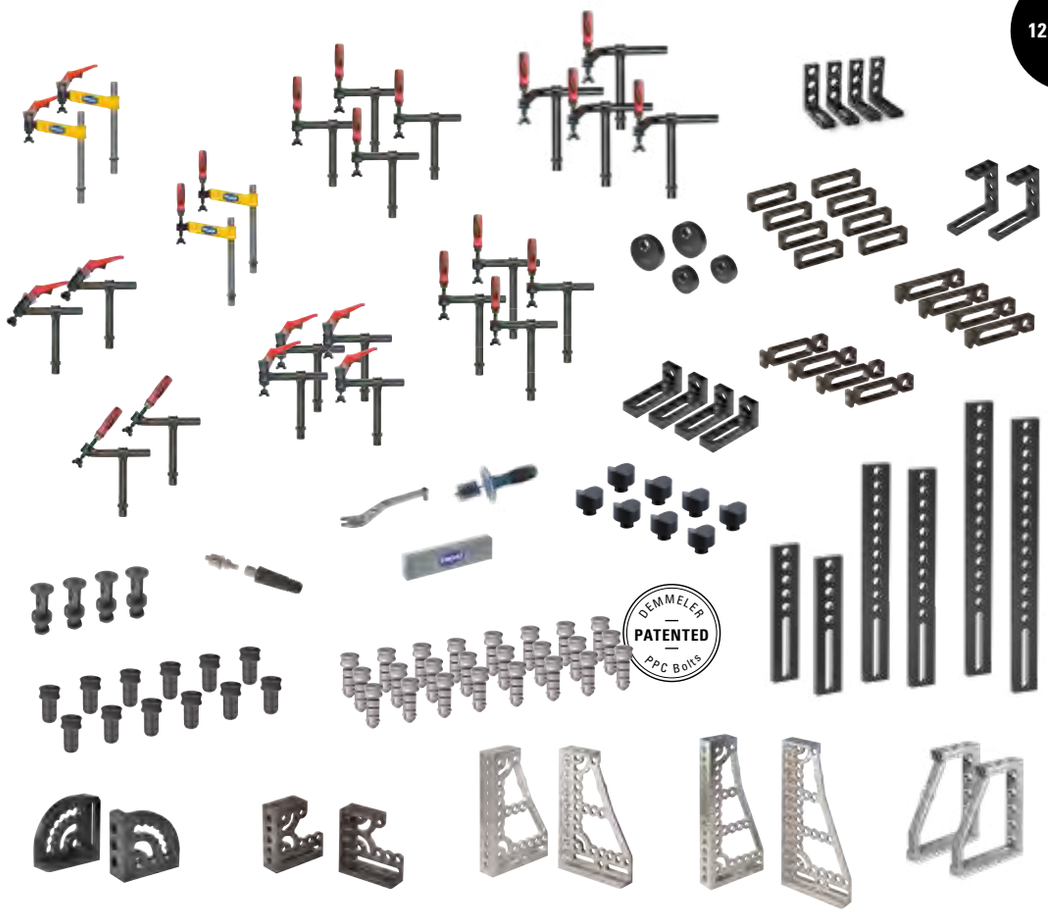
PROFIPremiumLINE set 720 D28		D28
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D28 PL, L175, bore/oblong hole	PE28-03001-000
2	Locating and clamping angle D28 PL small, L175, bore/oblong hole	D28-03001-005
2	Locating and clamping angle D28 PL, L300, aluminium titanium	PP28-03001-017
1	Locating and clamping angle D28 PP 300, right	P28-03002-000
1	Locating and clamping angle D28 PP 300, left	P28-03002-001
1	Locating and clamping angle D28 PP 600, right, aluminium titanium	P28-03003-002
1	Locating and clamping angle D28 PP 600, left, aluminium titanium	P28-03003-003
4	Universal stop D28 large, L225, two notches	D28-05001-010
2	Stop bar D28, L500	D28-05003-000
2	Stop bar D28, L800	D28-05003-001
2	Stop disc D28, Ø 100 mm	D28-05013-001
4	Sliding stop D28, L150	D28-05015-000
10	Stop and positioning bolt D28	D28-06009-000
20	PPC bolt D28, short, WAF 14	D28-06025-000
2	Compensating screw clamp D28 200, L350, spindle	D28-07002-000
4	Screw clamp 180° D28, L350, spindle	D28-07005-014
4	Screw clamp 180° D28, L500, spindle	D28-07005-033
2	Variable screw clamp 45° D28, L270, spindle	D28-07009-011
4	Performance clamp D28, L270, spindle	D28-07009-033
2	Support set with thread D28, 22–105 mm, continuously variable	D28-09001-005
1	Round brush D28, splash guard	D28-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Assembly lever, L250, WAF 14	D00-10016-001
	77-piece set	**P28-52000-720**

Debaenst Lastechniek

With PPC bolt

PROFIPremiumLINE set 730 D28

122-piece



DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it's possible to use the accessories from the PROFIPremiumLINE set on a PROFIPlusLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

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PROFIPremiumLINE set 730 D28		**D28**
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D28 PL, L175, bore/oblong hole	PE28-03001-000
4	Locating and clamping angle D28 PL small, L175, bore/oblong hole	D28-03001-005
1	Locating and clamping angle D28 PP 300, right	P28-03002-000
2	Locating and clamping angle D28 PL 200, with face plate	PL28-03001-015
2	Locating and clamping angle D28 PL, L300, aluminium titanium	PP28-03001-017
1	Locating and clamping angle D28 PP 300, left	P28-03002-001
1	Locating and clamping angle D28 PP 600, right, aluminium titanium	P28-03003-002
1	Locating and clamping angle D28 PP 600, left, aluminium titanium	P28-03003-003
1	Locating and clamping angle D28 PP 800, right, aluminium titanium	P28-03004-000
1	Locating and clamping angle D28 PP 800, left, aluminium titanium	P28-03004-001
4	Universal stop D28 large, L225, clamping bolt	D28-05001-001
4	Universal stop D28 large, L225, with two notches	D28-05001-010
2	Stop bar D28, L500	D28-05003-000
2	Stop bar D28, L800	D28-05003-001
2	Stop bar D28, L1000	D28-05003-008
2	Stop disc D28, Ø 75 mm	D28-05013-000
2	Stop disc D28, Ø 100 mm	D28-05013-001
1	Angle bracket D28 PL, L200, right, aluminium titanium	P28-05013-013
1	Angle bracket D28 PL, L200, left, aluminium titanium	P28-05013-014
8	Sliding stop D28, L150	D28-05015-000
24	PPC bolt D28, short, WAF 14	D28-06025-000
12	Stop and positioning bolt D28	D28-06009-000
2	Compensating screw clamp D28 150, L350, quick-action clamping cylinder	D28-07001-001
2	Compensating screw clamp D28 200, L350, spindle	D28-07002-000
4	Screw clamp 180° D28, L350, spindle	D28-07005-014
4	Screw clamp 180° D28, L350, quick-action clamping cylinder	D28-07005-015
4	Screw clamp 180° D28, L500, spindle	D28-07005-033
2	Variable screw clamp 45° D28, L270, spindle	D28-07009-011
2	Variable screw clamp 45° D28, L350, quick-action clamping cylinder	D28-07009-012
4	Performance clamp D28, L270, spindle	D28-07009-033
4	Support set with thread D28, 22–105 mm, continuously variable	D28-09001-005
8	V-block holder D28, Ø 58 mm	D28-09003-000
1	Round brush D28, splash guard	D28-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Earth connection D28/D22/D16	D00-10009-000
1	Assembly lever, L250, WAF 14	D00-10016-001
	122-piece set	**P28-52000-730**

Debaenst Lastechniek

With PPC bolt

PROFIPremiumLINE set 740 D28

158-piece



DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it's possible to use the accessories from the PROFIPremiumLINE set on a PROFIPlusLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

Debaenst Lastechniek

PROFIPremiumLINE set 740 D28		**D28**
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D28 PL, L175, bore/oblong hole	PE28-03001-000
4	Locating and clamping angle D28 PL small, L175, bore/oblong hole	D28-03001-005
2	Locating and clamping angle D28 PL 200, face plate	PL28-03001-015
2	Locating and clamping angle D28 PL, L300, aluminium titanium	PP28-03001-017
1	Locating and clamping angle D28 PP 300, right	P28-03002-000
1	Locating and clamping angle D28 PP 300, left	P28-03002-001
1	Locating and clamping angle D28 PP 600, right, aluminium titanium	P28-03003-002
1	Locating and clamping angle D28 PP 600, left, aluminium titanium	P28-03003-003
1	Locating and clamping angle D28 PP 800, right, aluminium titanium	P28-03004-000
1	Locating and clamping angle D28 PP 800, left, aluminium titanium	P28-03004-001
1	Locating and clamping angle D28 PP 1200, right, aluminium titanium	P28-03009-000
1	Locating and clamping angle D28 PP 1200, left, aluminium titanium	P28-03009-001
1	Universal pivot and tilt angle D28, right, aluminium titanium	D28-03007-004
1	Universal pivot and tilt angle D28, left, aluminium titanium	D28-03007-005
4	Universal stop D28 large, L225, clamping bolt	D28-05001-001
4	Universal stop D28 large, L225, two notches	D28-05001-010
2	Stop bar D28, L500	D28-05003-000
2	Stop bar D28, L800	D28-05003-001
2	Stop bar D28, L1000	D28-05003-008
2	Stop disc D28, Ø 75 mm	D28-05013-000
2	Stop disc D28, Ø 100 mm	D28-05013-001
1	Angle bracket D28 PL, L200, right, aluminium titanium	P28-05013-013
1	Angle bracket D28 PL, L200, left, aluminium titanium	P28-05013-014
8	Sliding stop D28, L150	D28-05015-000
16	Stop and positioning bolt D28	D28-06009-000
36	PPC bolt D28, short, WAF 14	D28-06025-000
4	PPC bolt D28, long, WAF 14	D28-06026-000
2	Compensating screw clamp D28 150, L350, quick-action clamping cylinder	D28-07001-001
2	Compensating screw clamp D28 200, L350, spindle	D28-07002-000
4	Screw clamp 180° D28, L350, spindle	D28-07005-014
4	Screw clamp 180° D28, L350, quick-action clamping cylinder	D28-07005-015
4	Screw clamp 180° D28, L500, spindle	D28-07005-033
2	Variable screw clamp 45° D28, L270, spindle	D28-07009-011
2	Variable screw clamp 45° D28, L350, quick-action clamping cylinder	D28-07009-012
4	Performance clamp D28, L270, spindle	D28-07009-033
4	Performance clamp D28, L270, quick-action clamping cylinder	D28-07009-035
4	11-piece support set D28, 5–100 mm	D28-09001-000
4	Support set with thread D28, 22–105 mm, continuously variable	D28-09001-005
8	V-block holder D28, Ø 58 mm	D28-09003-000
1	Round brush D28, splash guard	D28-10002-000
1	Pump bottle with 1 l of protective spray	D00-10005-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Hex key WAF 14, ball head	D28-10008-000
1	Earth connection D28/D22/D16	D00-10009-000
1	Assembly lever, L250, WAF 14	D00-10016-001
1	Accessory cart D28	D28-11001-000
1	Electric screwdriver with quick-change coupling	D28-13050-000
	158-piece set	**P28-52000-740**

Debaenst Lastechniek

PROFIPlusLINE set 710 D28

44-piece



PROFIPlusLINE set 710 D28		D28
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D28 PL, L175, bore/oblong hole	PE28-03001-000
2	Locating and clamping angle D28 PL large, L275, bore/oblong hole	PE28-03008-000
4	Universal stop D28 large, L225, with four notches	D28-05001-000
2	Universal stop D28 L300	D28-05009-000
4	Sliding stop D28, L150	D28-05015-000
12	PC bolt D28, short, WAF 14	D28-06001-000
6	Stop and positioning bolt D28	D28-06009-000
4	Compensating screw clamp D28 200, L350, spindle	D28-07002-000
4	Variable screw clamp 45° D28, L270, spindle	D28-07009-000
1	Round brush D28, splash guard	D28-10002-000
1	Assembly lever, L250, WAF 14	D00-10016-001
	44-piece set	**D28-52000-710**



Set with PPC bolts

Set also available with PPC bolts instead of PC bolts.
Set with PPC bolts ➔ Item no. D28-52000-711

DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it is possible to use the accessories from the PROFIPlusLINE set on a PROFIEcoLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

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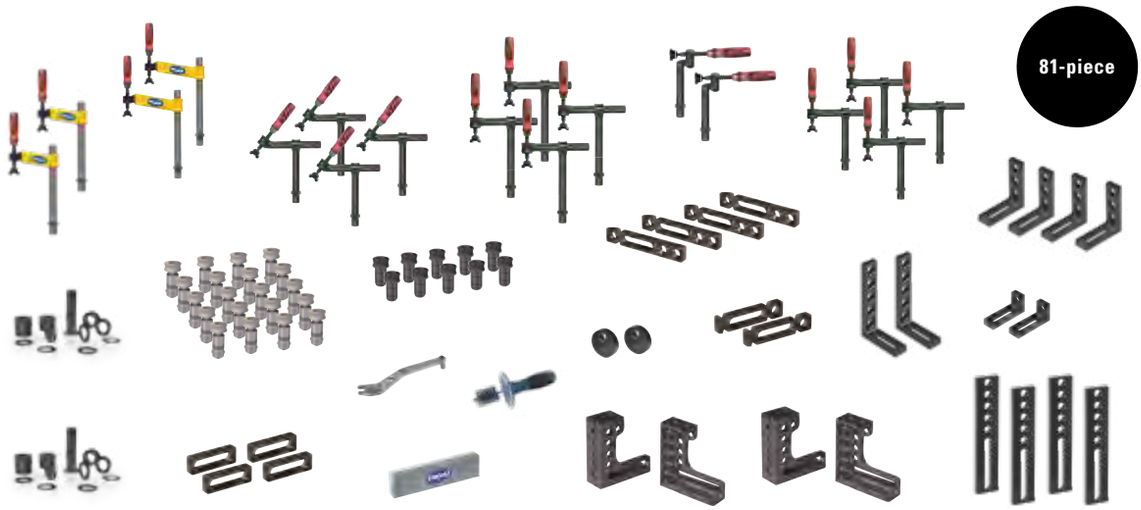
PROFIPlusLINE set 720 D28



PROFIPlusLINE set 720 D28		D28
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D28 PL, L175, bore/oblong hole	PE28-03001-000
2	Locating and clamping angle D28 PL small, L175, bore/oblong hole	D28-03001-005
2	Locating and clamping angle D28 PL 300, right	PL28-03002-000
2	Locating and clamping angle D28 PL 300, left	PL28-03002-001
2	Locating and clamping angle D28 PL large, L275, bore/oblong hole	PE28-03008-000
2	Universal stop D28 large, L225, with four notches	D28-05001-000
4	Stop bar D28, L500	D28-05003-000
4	Universal stop D28 L300	D28-05009-000
2	Stop disc D28, Ø 100 mm	D28-05013-001
4	Sliding stop D28, L150	D28-05015-000
20	PC bolt D28, short, WAF 14	D28-06001-000
10	Stop and positioning bolt D28	D28-06009-000
2	Compensating screw clamp D28 150, L350, spindle	D28-07001-000
2	Compensating screw clamp D28 200, L350, spindle	D28-07002-000
4	Screw clamp 180° D28, L270, spindle	D28-07005-000
4	Screw clamp 180° D28, L350, spindle	D28-07005-014
2	Variable screw clamp 90° D28, L150, spindle	D28-07008-000
4	Variable screw clamp 45° D28, L270, spindle	D28-07009-000
2	11-piece support set D28, 5–100 mm	D28-09001-000
1	Round brush D28, splash guard	D28-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Assembly lever, L250, WAF 14	D00-10016-001
	81-piece set	**D28-52000-720**



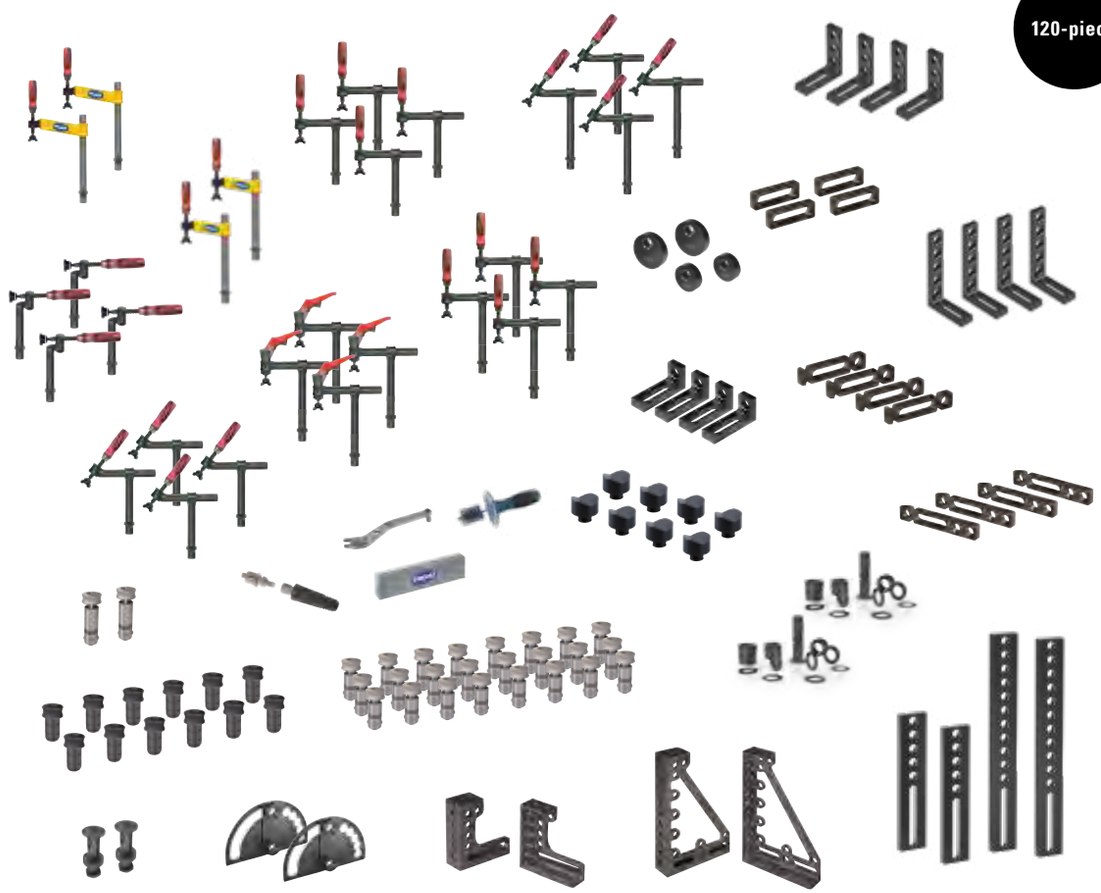
Set with PPC bolts

Set also available with PPC bolts instead of PC bolts.
Set with PPC bolts ➔ Item no. D28-52000-721

Debaenst Lastechniek

PROFIPlusLINE set 730 D28

120-piece





Set with PPC bolts

Set also available with PPC bolts instead of PC bolts.
Set with PPC bolts ➔ Item no. D28-52000-731

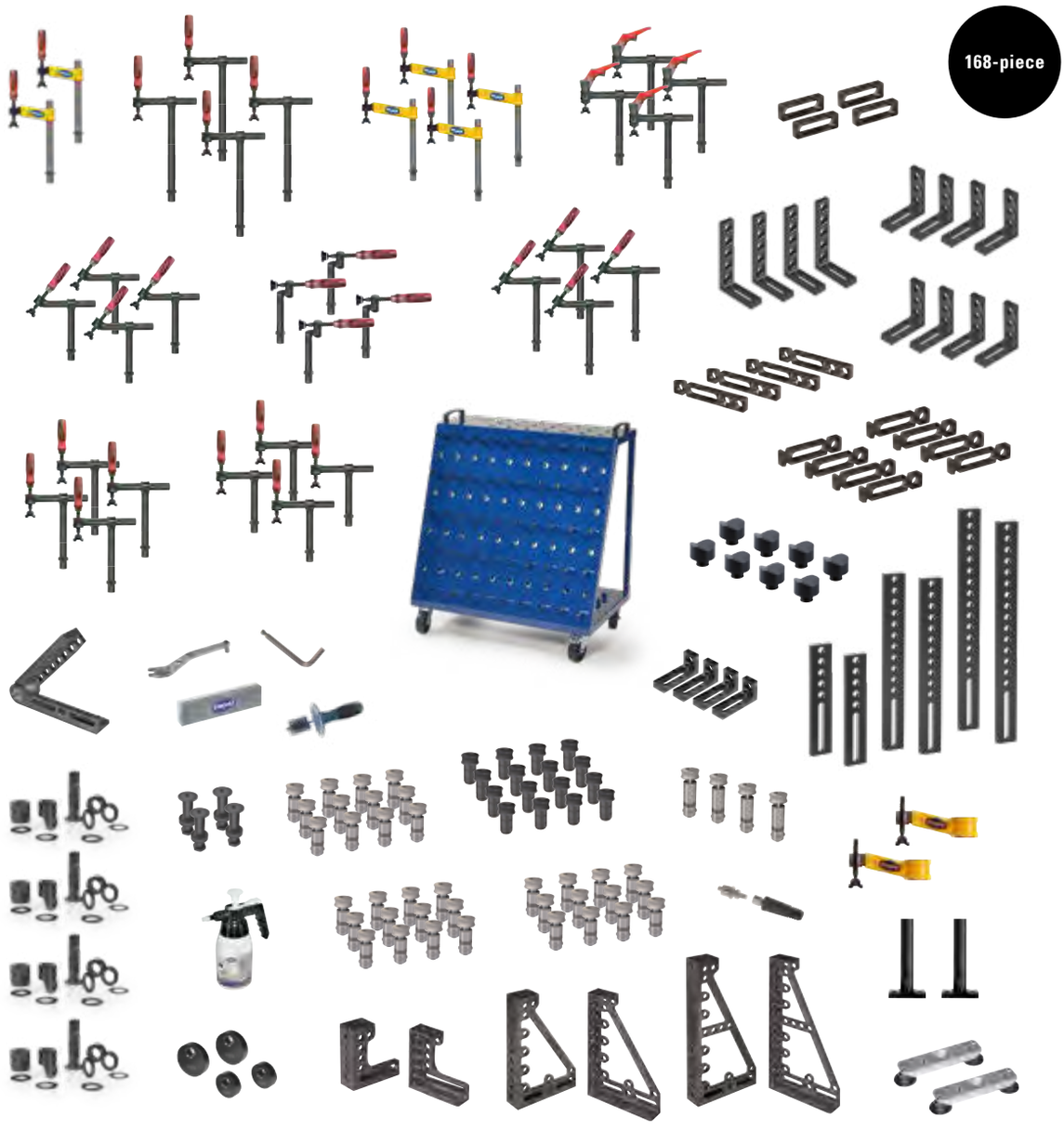
DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it is possible to use the accessories from the PROFIPlusLINE set on a PROFIEcoLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

Debaenst Lastechniek

PROFIPlusLINE set 730 D28		**D28**
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D28 PL, L175, bore/oblong hole	PE28-03001-000
4	Locating and clamping angle D28 PL small, L175, bore/oblong hole	D28-03001-005
1	Locating and clamping angle D28 PL 300, right	PL28-03002-000
1	Locating and clamping angle D28 PL 300, left	PL28-03002-001
1	Locating and clamping angle D28 PL 600, right	PL28-03003-000
1	Locating and clamping angle D28 PL 600, left	PL28-03003-001
4	Locating and clamping angle D28 PL large, L275, bore/oblong hole	PE28-03008-000
4	Universal stop D28 large, L225, with four notches	D28-05001-000
2	Stop bar D28, L500	D28-05003-000
2	Stop bar D28, L800	D28-05003-001
4	Universal stop D28 L300	D28-05009-000
2	Stop disc D28, Ø 75 mm	D28-05013-000
2	Stop disc D28, Ø 100 mm	D28-05013-001
2	Angle-setting template D28	D28-05013-010
4	Sliding stop D28, L150	D28-05015-000
24	PC bolt D28, short, WAF 14	D28-06001-000
2	PC bolt D28, long, WAF 14	D28-06002-000
12	Stop and positioning bolt D28	D28-06009-000
2	Compensating screw clamp D28 150, L350, spindle	D28-07001-000
2	Compensating screw clamp D28 200, L350, spindle	D28-07002-000
4	Screw clamp 180° D28, L270, spindle	D28-07005-000
4	Screw clamp 180° D28, L350, spindle	D28-07005-014
4	Screw clamp 180° D28, L350, quick-action clamping cylinder	D28-07005-015
4	Variable screw clamp 90° D28, L150, spindle	D28-07008-000
4	Variable screw clamp 45° D28, L270, spindle	D28-07009-000
4	Variable screw clamp 45° D28, L270, spindle	D28-07009-011
2	11-piece support set D28, 5–100 mm	D28-09001-000
2	Support set with thread D28, 22–105 mm, continuously variable	D28-09001-005
8	V-block holder D28, Ø 58 mm	D28-09003-000
1	Round brush D28, splash guard	D28-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Earth connection D28/D22/D16	D00-10009-000
1	Assembly lever, L250, WAF 14	D00-10016-001
	120-piece set	**D28-52000-730**

Debaenst Lastechniek

PROFIPlusLINE set 740 D28



Set with PPC bolts

Set also available with PPC bolts instead of PC bolts.
Set with PPC bolts ➔ Item no. D28-52000-741

DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it's possible to use the accessories from the PROFIPremiumLINE set on a PROFIPlusLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

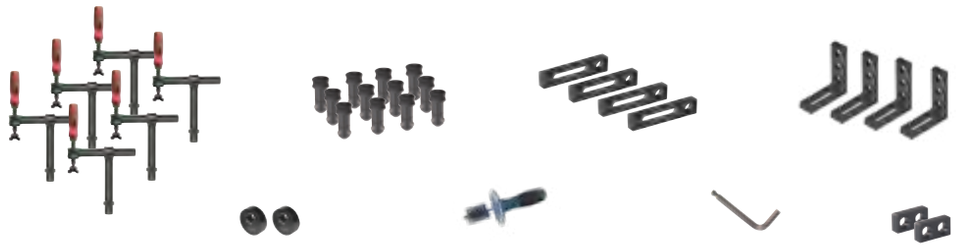
Debaenst Lastechniek

PROFIPlusLINE set 740 D28		**D28**
Quantity	**Description**	**Item no.**
8	Locating and clamping angle D28 PL, L175, bore/oblong hole	PE28-03001-000
4	Locating and clamping angle D28 PL small, L175, bore/oblong hole	D28-03001-005
1	Locating and clamping angle D28 PL 300, right	PL28-03002-000
1	Locating and clamping angle D28 PL 300, left	PL28-03002-001
1	Locating and clamping angle D28 PL 600, right	PL28-03003-000
1	Locating and clamping angle D28 PL 600, left	PL28-03003-001
1	Locating and clamping angle D28 PL 800, right	PL28-03004-000
1	Locating and clamping angle D28 PL 800, left	PL28-03004-001
1	Universal pivot and tilt angle D28, right	D28-03007-000
4	Locating and clamping angle D28 PL large, L275, bore/oblong hole	PE28-03008-000
8	Universal stop D28 large, L225, with four notches	D28-05001-000
2	Stop bar D28, L500	D28-05003-000
2	Stop bar D28, L800	D28-05003-001
2	Stop bar D28, L1000	D28-05003-008
2	Multi-clamping and support tower D28, L 1000	D28-05006-000
2	Compensating clamping arm D28, short spindle	D28-05007-000
4	Universal stop D28 L300	D28-05009-000
2	Stop disc D28, Ø 75 mm	D28-05013-000
2	Stop disc D28, Ø 100 mm	D28-05013-001
4	Sliding stop D28, L150	D28-05015-000
36	PC bolt D28, short, WAF 14	D28-06001-000
4	PC bolt D28, long, WAF 14	D28-06002-000
16	Stop and positioning bolt D28	D28-06009-000
2	Compensating screw clamp D28 150, L350, spindle	D28-07001-000
4	Compensating screw clamp D28 200, L350, spindle	D28-07002-000
4	Screw clamp 180° D28, L270, spindle	D28-07005-000
4	Screw clamp 180° D28, L350, spindle	D28-07005-014
4	Screw clamp 180° D28, L350, quick-action clamping cylinder	D28-07005-015
4	Screw clamp 180° D28, L500, spindle	D28-07005-033
4	Variable screw clamp 90° D28, L150, spindle	D28-07008-000
4	Variable screw clamp 45° D28, L270, spindle	D28-07009-000
4	Variable screw clamp 45° D28, L270, spindle	D28-07009-011
2	2P. Clamping bridge D28 with two clamping pads, steel	D28-07018-000
4	11-piece support set D28, 5–100 mm	D28-09001-000
4	Support set with thread D28, 22–105 mm, continuously variable	D28-09001-005
8	V-block holder D28, Ø 58 mm	D28-09003-000
1	Round brush D28, splash guard	D28-10002-000
1	Pump bottle with 1 l of protective spray	D00-10005-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Hex key WAF 14, ball head	D28-10008-000
1	Earth connection D28/D22/D16	D00-10009-000
1	Assembly lever, L250, WAF 14	D00-10016-001
1	Accessory cart D28	D28-11001-000
	168-piece set	**D28-52000-740**

Debaenst Lastechniek

PROFIEcoLINE set 710 D28

32-piece



PROFIEcoLINE set 710 D28		D28
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D28 PL, L175, bore/oblong hole	PE28-03001-000
4	Universal stop D28 PE large, L225	E28-05001-000
2	Universal stop D28 PE small, L100	E28-05002-000
2	Stop disc D28, Ø 100 mm	D28-05013-001
12	EcoLINE bolt D28, short, WAF 8	E28-06001-000
6	Screw clamp 180° D28, L270, spindle	D28-07005-000
1	Round brush D28, splash guard	D28-10002-000
1	Hex key WAF 8, ball head	D28-10008-005
	32-piece set	**E28-52000-710**



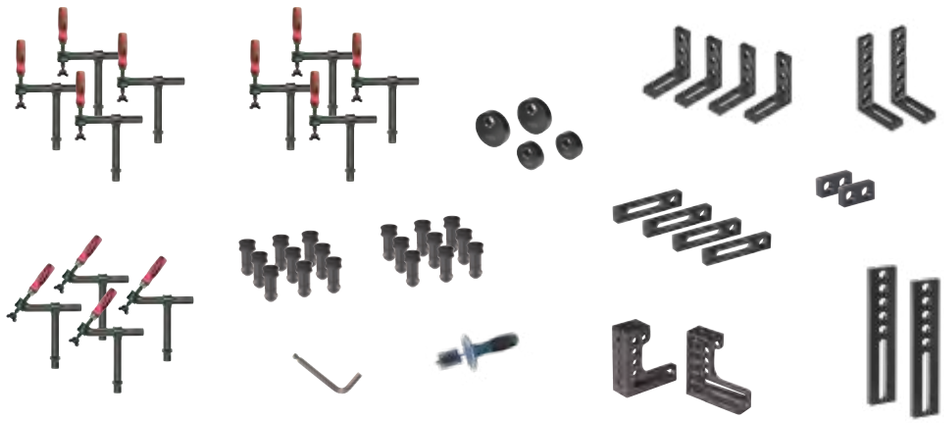
Set with PC or PPC bolts

Set also available with PC or PPC bolts instead of EcoLINE bolts:
Set with PC bolts[1]: ➔ Item no. E28-52000-711
Set with PPC bolts[2]: ➔ Item no. E28-52000-712

DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it's possible to use the accessories from the PROFIEcoLINE set on a PROFIPlusLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

Debaenst Lastechniek

PROFIEcoLINE set 720 D28



52-piece

PROFIEcoLINE set 720 D28		D28
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D28 PL, L175, bore/oblong hole	PE28-03001-000
1	Locating and clamping angle D28 PL 300, right	PL28-03002-000
1	Locating and clamping angle D28 PL 300, left	PL28-03002-001
2	Locating and clamping angle D28 PL large, L275, bore/oblong hole	PE28-03008-000
4	Universal stop D28 PE large, L225	E28-05001-000
2	Universal stop D28 PE small, L100	E28-05002-000
2	Stop bar D28, L500	D28-05003-000
2	Stop disc D28, Ø 75 mm	D28-05013-000
2	Stop disc D28, Ø 100 mm	D28-05013-001
18	EcoLINE bolt D28, short, WAF 8	E28-06001-000
8	Screw clamp 180° D28, L270, spindle	D28-07005-000
4	Variable screw clamp 45° D28, L270, spindle	D28-07009-000
1	Round brush D28, splash guard	D28-10002-000
1	Hex key WAF 8, ball head	D28-10008-005
	52-piece set	**E28-52000-720**

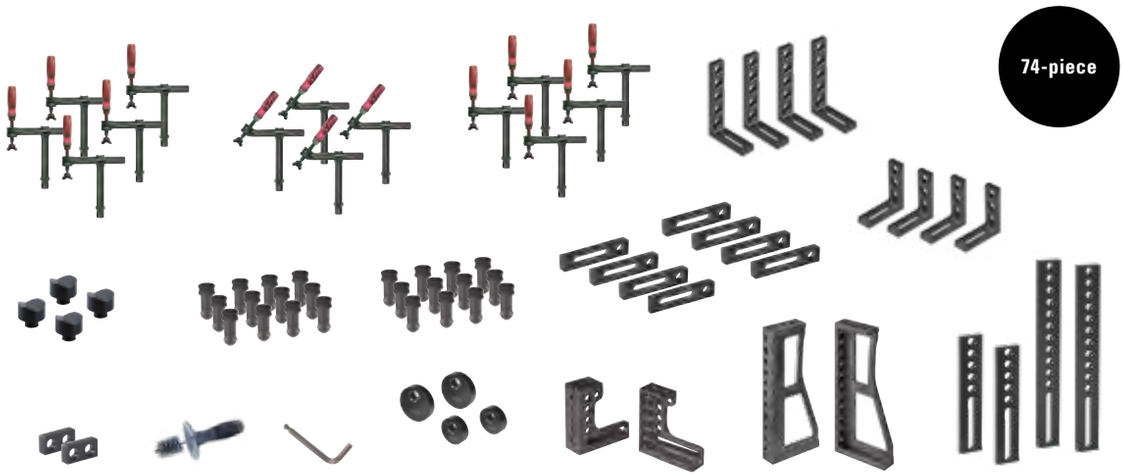


Set with PC or PPC bolts

Set also available with PC or PPC bolts instead of EcoLINE bolts:
Set with PC bolts[1]: ➔ Item no. E28-52000-721
Set with PPC bolts[2]: ➔ Item no. E28-52000-722

Debaenst Lastechniek

PROFIEcoLINE set 730 D28



PROFIEcoLINE set 730 D28		D28
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D28 PL, L175, bore/oblong hole	PE28-03001-000
1	Locating and clamping angle D28 PL 300, right	PL28-03002-000
1	Locating and clamping angle D28 PL 300, left	PL28-03002-001
1	Locating and clamping angle D28 PE 600, right	PE28-03003-000
1	Locating and clamping angle D28 PE 600, left	PE28-03003-001
4	Locating and clamping angle D28 PL large, L275, bore/oblong hole	PE28-03008-000
8	Universal stop D28 PE large, L225	E28-05001-000
2	Universal stop D28 PE small, L100	E28-05002-000
2	Stop bar D28, L500	D28-05003-000
2	Stop bar D28, L800	D28-05003-001
2	Stop disc D28, Ø 75 mm	D28-05013-000
2	Stop disc D28, Ø 100 mm	D28-05013-001
24	EcoLINE bolt D28, short, WAF 8	E28-06001-000
10	Screw clamp 180° D28, L270, spindle	D28-07005-000
4	Variable screw clamp 45° D28, L270, spindle	D28-07009-000
4	V-block holder D28, Ø 58 mm	D28-09003-000
1	Round brush D28, splash guard	D28-10002-000
1	Hex key WAF 8, ball head	D28-10008-005
	74-piece set	**E28-52000-730**



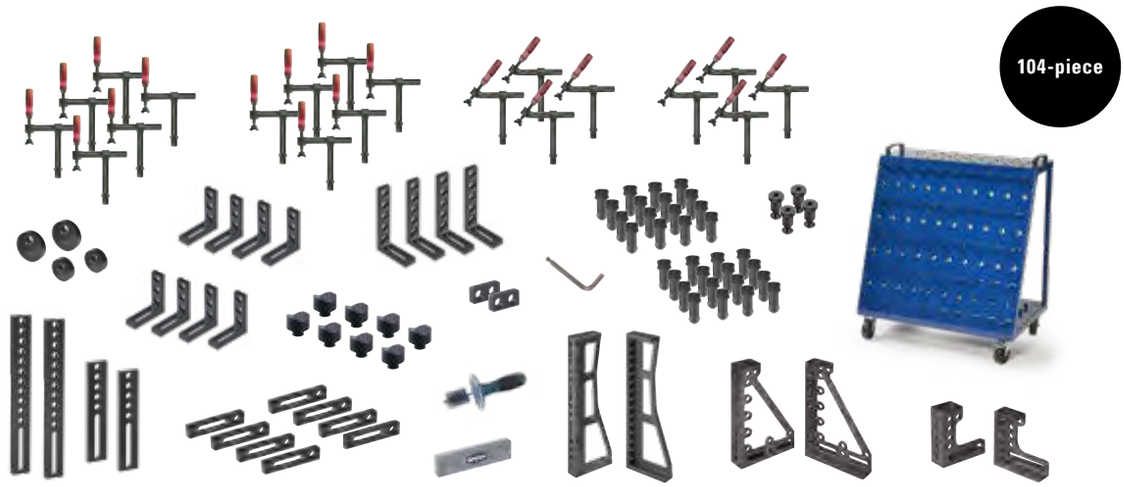
Set with PC or PPC bolts

Set also available with PC or PPC bolts instead of EcoLINE bolts:
Set with PC bolts[1]: ➔ Item no. E28-52000-731
Set with PPC bolts[2]: ➔ Item no. E28-52000-732

DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it's possible to use the accessories from the PROFIEcoLINE set on a PROFIPlusLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

Debaenst Lastechniek

PROFIEcoLINE set 740 D28



PROFIEcoLINE set 740 D28		D28
Quantity	**Description**	**Item no.**
8	Locating and clamping angle D28 PL, L175, bore/oblong hole	PE28-03001-000
1	Locating and clamping angle D28 PL 300, right	PL28-03002-000
1	Locating and clamping angle D28 PL 300, left	PL28-03002-001
1	Locating and clamping angle D28 PL 600, right	PL28-03003-000
1	Locating and clamping angle D28 PL 600, left	PL28-03003-001
1	Locating and clamping angle D28 PE 800, right	PE28-03004-000
1	Locating and clamping angle D28 PE 800, left	PE28-03004-001
4	Locating and clamping angle D28 PL large, L275, bore/oblong hole	PE28-03008-000
8	Universal stop D28 PE large, L225	E28-05001-000
2	Universal stop D28 PE small, L100	E28-05002-000
2	Stop bar D28, L500	D28-05003-000
2	Stop bar D28, L800	D28-05003-001
2	Stop disc D28, Ø 75 mm	D28-05013-000
2	Stop disc D28, Ø 100 mm	D28-05013-001
32	EcoLINE bolt D28, short, WAF 8	E28-06001-000
4	Connecting bush D28, short, screw	D28-06003-000
12	Screw clamp 180° D28, L270, spindle	D28-07005-000
8	Variable screw clamp 45° D28, L270, spindle	D28-07009-000
8	V-block holder D28, Ø 58 mm	D28-09003-000
1	Round brush D28, splash guard	D28-10002-000
1	Hex key WAF 8, ball head	D28-10008-005
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Accessory cart D28	D28-11001-000
	104-piece set	**E28-52000-740**



Set with PC or PPC bolts

Set also available with PC or PPC bolts instead of EcoLINE bolts:
Set with PC bolts[1]: ➔ Item no. E28-52000-741
Set with PPC bolts[2]: ➔ Item no. E28-52000-742

Debaenst Lastechniek

PROFIPlusLINE set 710 D22

26-piece



PROFIPlusLINE set 710 D22		D22
Quantity	**Description**	**Item no.**
4	Universal stop D22 large, L225, four notches	D22-05001-000
2	Universal stop D22 L300	D22-05009-000
4	Sliding stop D22, L150	D22-05015-000
10	EcoLINE bolt D22, short, WAF 6	E22-06025-000
4	Screw clamp 180° D22, L300, spindle	D22-07005-000
1	Round brush D22, splash guard	D22-10002-000
1	Assembly lever, L250, WAF 10	D22-10016-001
	26-piece set	**D22-52000-710**



Set with PPC bolts

Set also available with PPC bolts instead of EcoLINE bolts.
Set with PPC bolts ➔ Item no. D22-52000-711

DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it's possible to use the accessories from the PROFIPlusLINE set on a PROFIPremiumLINE table without any hassle.
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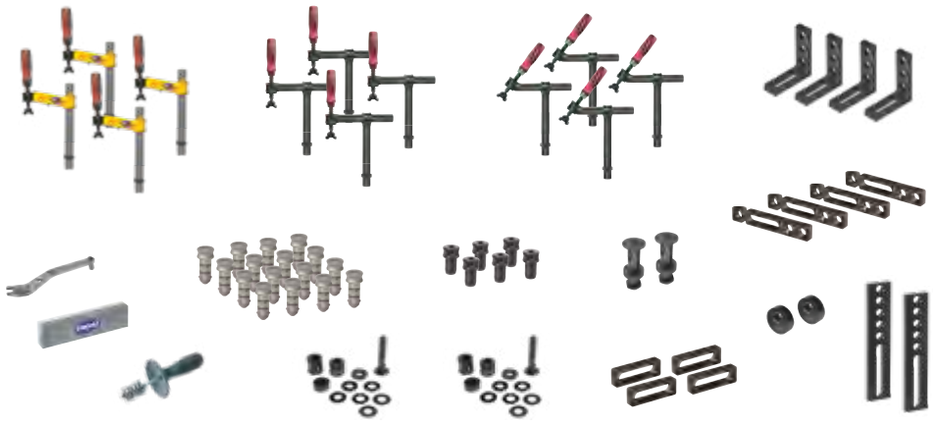
Debaenst Lastechniek

PROFIPlusLINE set 720 D22



57-piece

PROFIPlusLINE set 720 D22		D22
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D22 PL, L175, bore/oblong hole	PE22-03001-000
2	Stop bar D22, L500	D22-05003-000
4	Universal stop D22 L300	D22-05009-000
2	Stop disc D22, Ø 75 mm	D22-05013-000
4	Sliding stop D22, L150	D22-05015-000
6	Stop and positioning bolt D22	D22-06009-000
16	EcoLINE bolt D22, short, WAF 6	E22-06025-000
4	Compensating screw clamp D22, L300, spindle	D22-07001-000
4	Screw clamp 180° D22, L300, spindle	D22-07005-000
4	Variable screw clamp 45° D22, L300, spindle	D22-07009-000
2	11-piece support set D22, 5–100 mm	D22-09001-000
2	Support set with thread D22, 22–100 mm, continuously variable	D22-09001-005
1	Round brush D22, splash guard	D22-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Assembly lever, L250, WAF 10	D22-10016-001
	57-piece set	**D22-52000-720**



Set with PPC bolts

Set also available with PPC bolts instead of EcoLINE bolts.
Set with PPC bolts ➔ Item no. D22-52000-721

PROFIPlusLINE set 730 D22

77-piece





Set with PPC bolts

Set also available with PPC bolts instead of EcoLINE bolts.
Set with PPC bolts ➔ Item no. D22-52000-731

DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it's possible to use the accessories from the PROFIPlusLINE set on a PROFIPremiumLINE table without any hassle.
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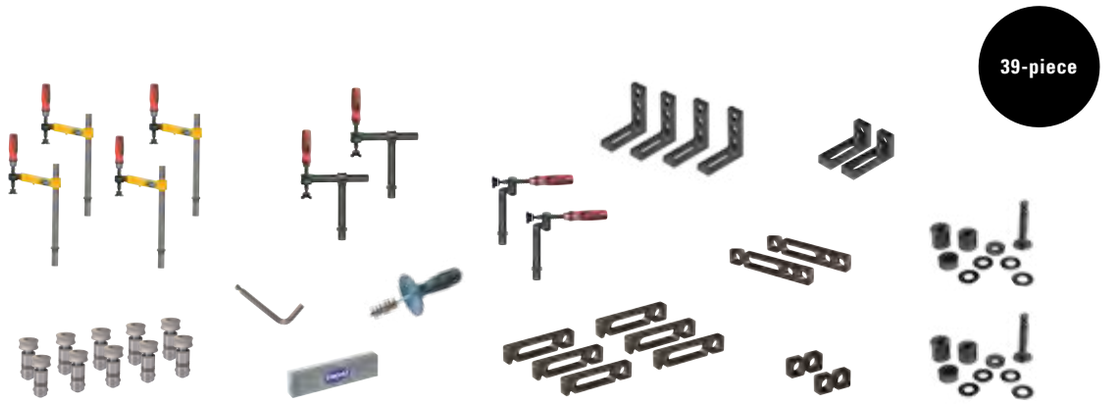
Debaenst Lastechniek

PROFIPlusLINE set 730 D22		**D22**
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D22 PL, L175, bore/oblong hole	PE22-03001-000
1	Locating and clamping angle D22 PE 500, right	PE22-03003-000
1	Locating and clamping angle D22 PE 500, left	PE22-03003-001
1	Locating and clamping angle D22 PE 750, right	PE22-03004-000
1	Locating and clamping angle D22 PE 750, left	PE22-03004-001
4	Universal stop D22 large, L225, four notches	D22-05001-000
2	Stop bar D22, L500	D22-05003-000
4	Universal stop D22 L300	D22-05009-000
2	Stop disc D22, Ø 75 mm	D22-05013-000
4	Sliding stop D22, L150	D22-05015-000
8	Stop and positioning bolt D22	D22-06009-000
20	EcoLINE bolt D22, short, WAF 6	E22-06025-000
4	EcoLINE bolt D22, long, WAF 6	E22-06026-000
6	Compensating screw clamp D22, L300, spindle	D22-07001-000
4	Screw clamp 180° D22, L300, spindle	D22-07005-000
4	Variable screw clamp 45° D22, L300, spindle	D22-07009-000
2	11-piece support set D22, 5–100 mm	D22-09001-000
2	Support set with thread D22, 22–100 mm, continuously variable	D22-09001-005
1	Round brush D22, splash guard	D22-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Assembly lever, L250, WAF 10	D22-10016-001
	77-piece set	**D22-52000-730**

Debaenst Lastechniek

PROFIPlusLINE set 155 D16

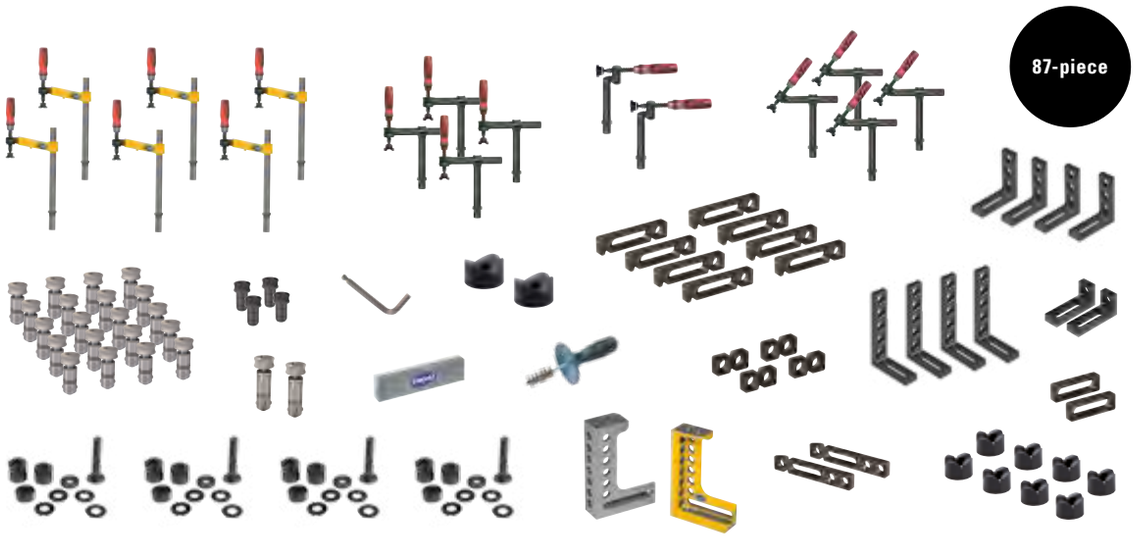


PROFIPlusLINE set 155 D16		D16
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D16 PL, L90, bore/oblong hole	D16-03001-000
2	Locating and clamping angle D16 PL small, L90, bore/oblong hole	D16-03001-002
6	Universal stop D16 large, L115, with two notches	D16-05001-004
2	Universal stop D16 small, L55	D16-05002-000
2	Universal stop D16 L165	D16-05009-000
10	PC bolt D16, short, WAF 8	D16-06001-000
4	Compensating screw clamp D16, L250, spindle	D16-07001-000
2	Screw clamp 180° D16, L130, spindle	D16-07005-000
2	Variable screw clamp 90° D16, L150, spindle	D16-07008-000
2	9-piece support set D16, 5–50 mm	D16-09001-000
1	Round brush D16, splash guard	D16-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Hex key WAF 8, ball head	D16-10008-000
	39-piece set	**D16-52000-155**

DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it is possible to use the accessories from the PROFIPlusLINE set on a PROFIEcoLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

Debaenst Lastechniek

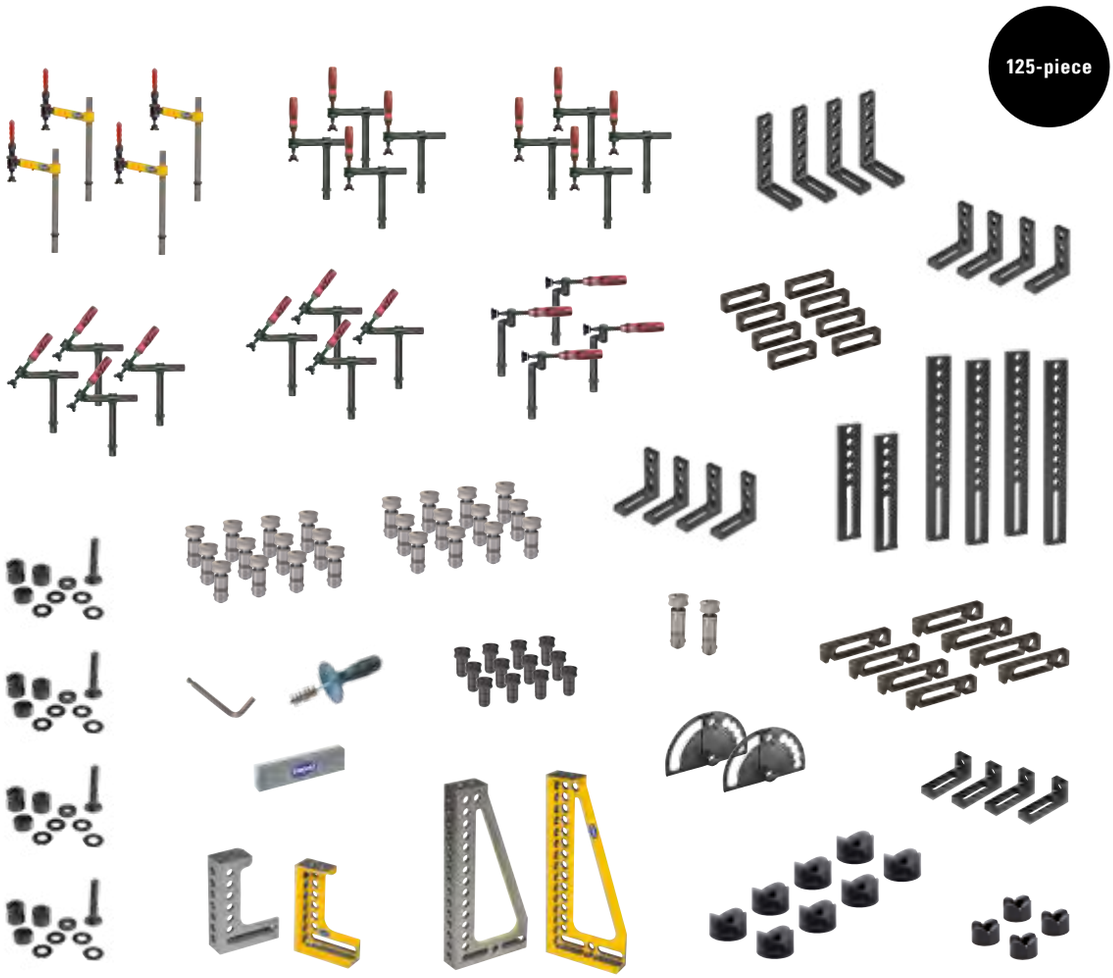
PROFIPlusLINE set 255 D16



PROFIPlusLINE set 255 D16		D16
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D16 PL, L90, bore/oblong hole	D16-03001-000
2	Locating and clamping angle D16 PL small, L90, bore/oblong hole	D16-03001-002
1	Locating and clamping angle D16 PL 200, right	D16-03002-000
1	Locating and clamping angle D16 PL 200, left	D16-03002-001
4	Locating and clamping angle D16 PL large, L140, bore/oblong hole	D16-03008-000
8	Universal stop D16 large, L115, with two notches	D16-05001-004
4	Universal stop D16 small, L55	D16-05002-000
2	Universal stop D16 L165	D16-05009-000
2	Sliding stop, L150	D16-05015-000
20	PC bolt D16, short, WAF 8	D16-06001-000
2	PC bolt D16, long, WAF 8	D16-06002-000
4	Stop and positioning bolt D16	D16-06009-000
6	Compensating screw clamp D16, L250, spindle	D16-07001-000
4	Screw clamp 180° D16, L130, spindle	D16-07005-000
2	Variable screw clamp 90° D16, L150, spindle	D16-07008-000
4	Variable screw clamp 45° D16, L130, spindle	D16-07009-000
4	9-piece support set D16, 5–50 mm	D16-09001-000
8	V-block holder D16, Ø 50 mm	D16-09004-000
2	V-block holder D16, Ø 80 mm	D16-09003-000
1	Round brush D16, splash guard	D16-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Hex key WAF 8, ball head	D16-10008-000
	87-piece set	**D16-52000-255**

Debaenst Lastechniek

PROFIPlusLINE set 720 D16



DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it is possible to use the accessories from the PROFIPlusLINE set on a PROFIEcoLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

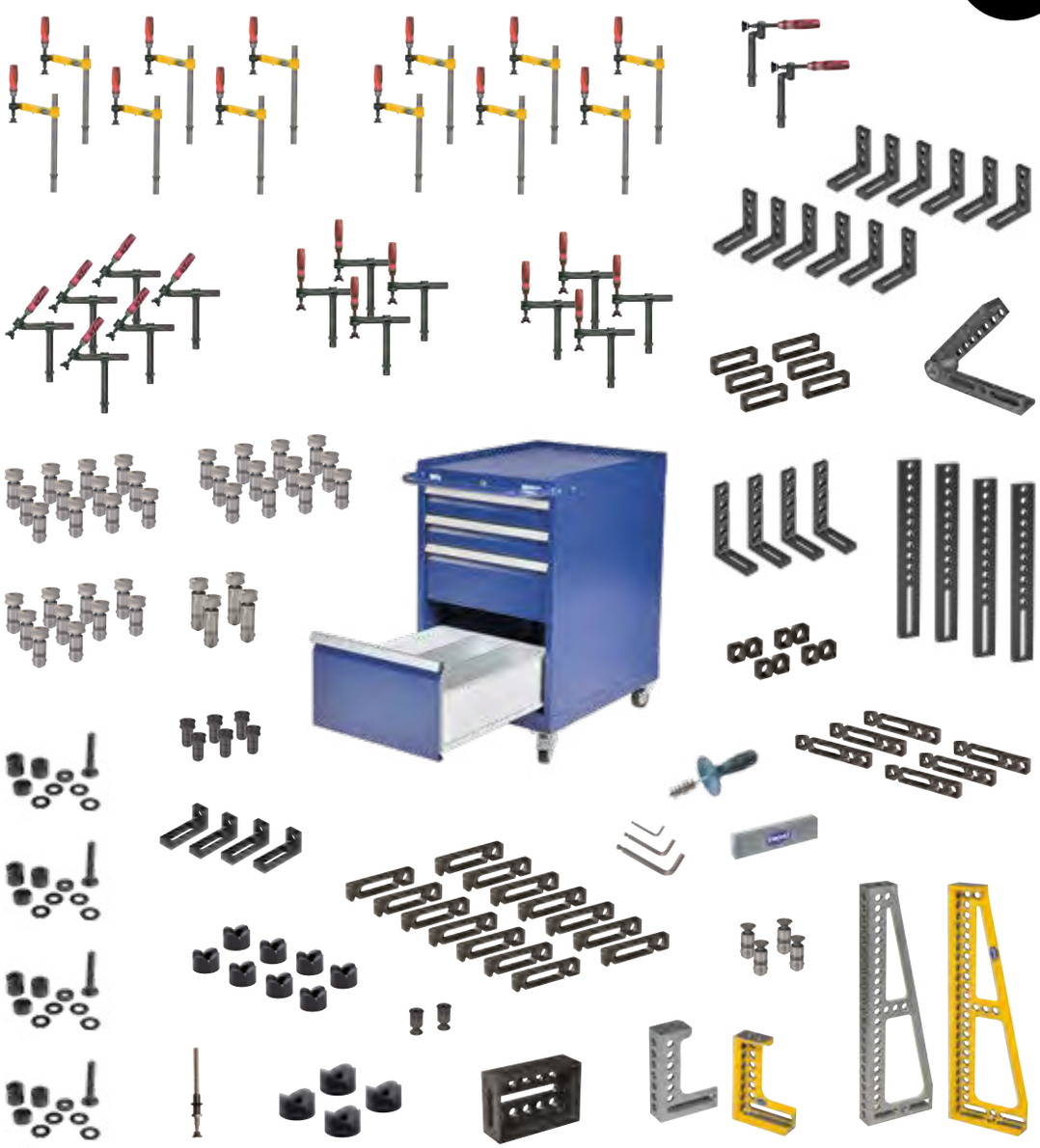
Debaenst Lastechniek

PROFIPlusLINE set 720 D16		**D16**
Quantity	**Description**	**Item no.**
8	Locating and clamping angle D16 PL, L90, bore/oblong hole	D16-03001-000
4	Locating and clamping angle D16 PL small, L90, bore/oblong hole	D16-03001-002
1	Locating and clamping angle D16 PL 200, right	D16-03002-000
1	Locating and clamping angle D16 PL 200, left	D16-03002-001
1	Locating and clamping angle D16 PL 400, right	D16-03003-000
1	Locating and clamping angle D16 PL 400, left	D16-03003-001
4	Locating and clamping angle D16 PL large, L140, bore/oblong hole	D16-03008-000
8	Universal stop D16 large, L115, two notches	D16-05001-004
2	Stop bar D16, L250	D16-05003-000
4	Stop bar D16, L400	D16-05003-001
2	Angle-setting template D16	D16-05013-010
8	Sliding stop, L150	D16-05015-000
24	PC bolt D16, short, WAF 8	D16-06001-000
2	PC bolt D16, long, WAF 8	D16-06002-000
12	Stop and positioning bolt D16	D16-06009-000
4	Compensating screw clamp D16, L250, quick-action clamping cylinder	D16-07001-001
8	Screw clamp 180° D16, L130, spindle	D16-07005-000
4	Variable screw clamp 90° D16, L150, spindle	D16-07008-000
8	Variable screw clamp 45° D16, L130, spindle	D16-07009-000
4	9-piece support set D16, 5–50 mm	D16-09001-000
4	V-block holder D16, Ø 50 mm	D16-09004-000
8	V-block holder D16, Ø 80 mm	D16-09003-000
1	Round brush D16, splash guard	D16-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Hex key WAF 8, ball head	D16-10008-000
	125-piece set	**D16-52000-720**

Debaenst Lastechniek

PROFIPlusLINE set 355 D16

161-piece



DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it is possible to use the accessories from the PROFIPlusLINE set on a PROFIEcoLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

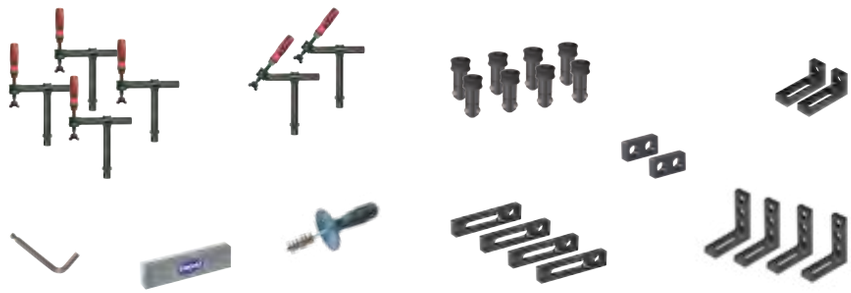
Debaenst Lastechniek

PROFIPlusLINE set 355 D16		**D16**
Quantity	**Description**	**Item no.**
12	Locating and clamping angle D16 PL, L90, bore/oblong hole	D16-03001-000
4	Locating and clamping angle D16 PL small, L90, bore/oblong hole	D16-03001-002
1	Locating and clamping angle D16 PL 200, right	D16-03002-000
1	Locating and clamping angle D16 PL 200, left	D16-03002-001
1	Locating and clamping angle D16 PL 600, right	D16-03004-000
1	Locating and clamping angle D16 PL 600, left	D16-03004-001
1	Support and clamping frame D16, L150, right	D16-03005-001
1	Universal pivot and tilt angle D16, right	D16-03007-000
4	Locating and clamping angle D16 PL large, L140, bore/oblong hole	D16-03008-000
14	Universal stop D16 large, L115, with two notches	D16-05001-004
4	Universal stop D16 small, L55	D16-05002-000
4	Stop bar D16, L400	D16-05003-001
6	Universal stop D16 L165	D16-05009-000
6	Sliding stop, L150	D16-05015-000
34	PC bolt D16, short, WAF 8	D16-06001-000
4	PC bolt D16, long, WAF 8	D16-06002-000
2	Connecting bush D16, short, screw, WAF 6	D16-06003-000
4	PC countersunk bolt D16, short, WAF 4	D16-06004-000
6	Stop and positioning bolt D16	D16-06009-000
12	Compensating screw clamp D16, L250, spindle	D16-07001-000
8	Screw clamp 180° D16, L130, spindle	D16-07005-000
2	Variable screw clamp 90° D16, L150, spindle	D16-07008-000
6	Variable screw clamp 45° D16, L130, spindle	D16-07009-000
4	9-piece support set D16, 5–50 mm	D16-09001-000
8	V-block holder D16, Ø 50 mm	D16-09004-000
4	V-block holder D16, Ø 80 mm	D16-09003-000
1	Adjusting spindle D16, L180, WAF 4	D16-09008-000
1	Round brush D16, splash guard	D16-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Hex key WAF 8, ball head	D16-10008-000
1	Hex key WAF 6, ball head	D16-10008-001
1	Hex key WAF 4, ball head	D16-10008-002
1	Tool trolley D16	D16-11001-000
	161-piece set	**D16-52000-355**

Debaenst Lastechniek

PROFIEcoLINE set 710 D16

29-piece



PROFIEcoLINE set 710 D16		D16
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D16 PE, L90, bore/oblong hole	E16-03001-000
2	Locating and clamping angle D16 PE small, L90, bore/oblong hole	E16-03001-002
4	Universal stop D16 PE large, L115	E16-05001-000
2	Universal stop D16 PE small, L55	E16-05002-000
8	EcoLINE bolt D16, short, WAF 5	E16-06001-000
4	Screw clamp 180° D16, L130, spindle	D16-07005-000
2	Variable screw clamp 45° D16, L130, spindle	D16-07009-000
1	Round brush D16, splash guard	D16-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Hex key WAF 5, ball head	E16-10008-000
	29-piece set	**E16-52000-710**



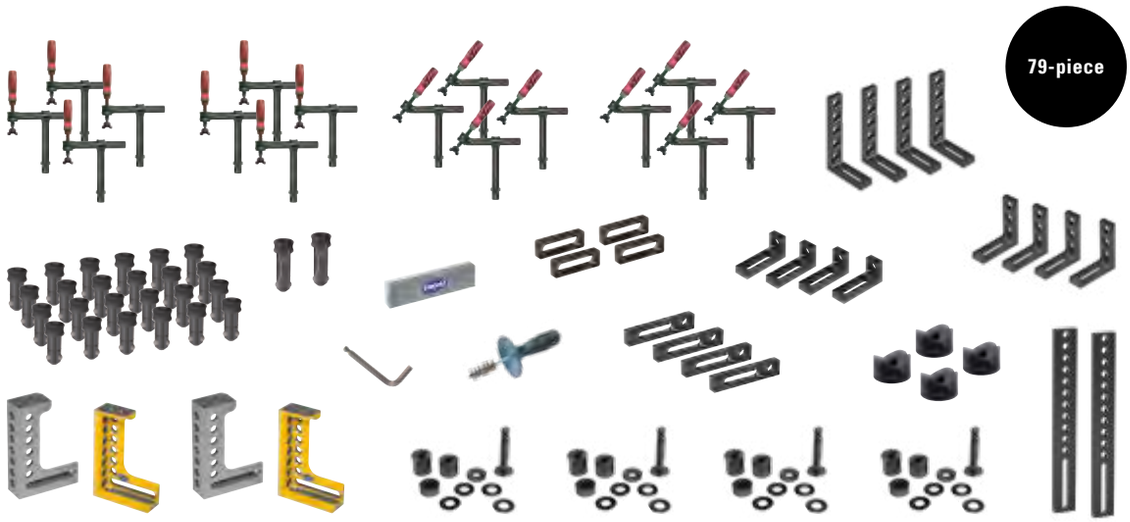
Set with PC bolts

Set also available with PC bolts instead of EcoLINE bolts.
Set with PC bolts ➔ Item no. E16-52000-711

DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it's possible to use the accessories from the PROFIEcoLINE set on a PROFIPlusLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

Debaenst Lastechniek

PROFIEcoLINE set 720 D16



PROFIEcoLINE set 720 D16		D16
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D16 PE, L90, bore/oblong hole	E16-03001-000
4	Locating and clamping angle D16 PE small, L90, bore/oblong hole	E16-03001-002
2	Locating and clamping angle D16 PL 200, right	D16-03002-000
2	Locating and clamping angle D16 PL 200, left	D16-03002-001
4	Locating and clamping angle D16 PL large, L140, bore/oblong hole	D16-03008-000
4	Universal stop D16 PE large, L115	E16-05001-000
2	Stop bar D16, L400	D16-05003-001
4	Sliding stop, L150	D16-05015-000
24	EcoLINE bolt D16, short, WAF 5	E16-06001-000
2	EcoLINE bolt D16, long, WAF 5	E16-06002-000
8	Screw clamp 180° D16, L130, spindle	D16-07005-000
8	Variable screw clamp 45° D16, L130, spindle	D16-07009-000
4	9-piece support set D16, 5–50 mm	D16-09001-000
4	V-block holder D16, Ø 80 mm	D16-09003-000
1	Round brush D16, splash guard	D16-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Hex key WAF 5, ball head	E16-10008-000
	79-piece set	**E16-52000-720**

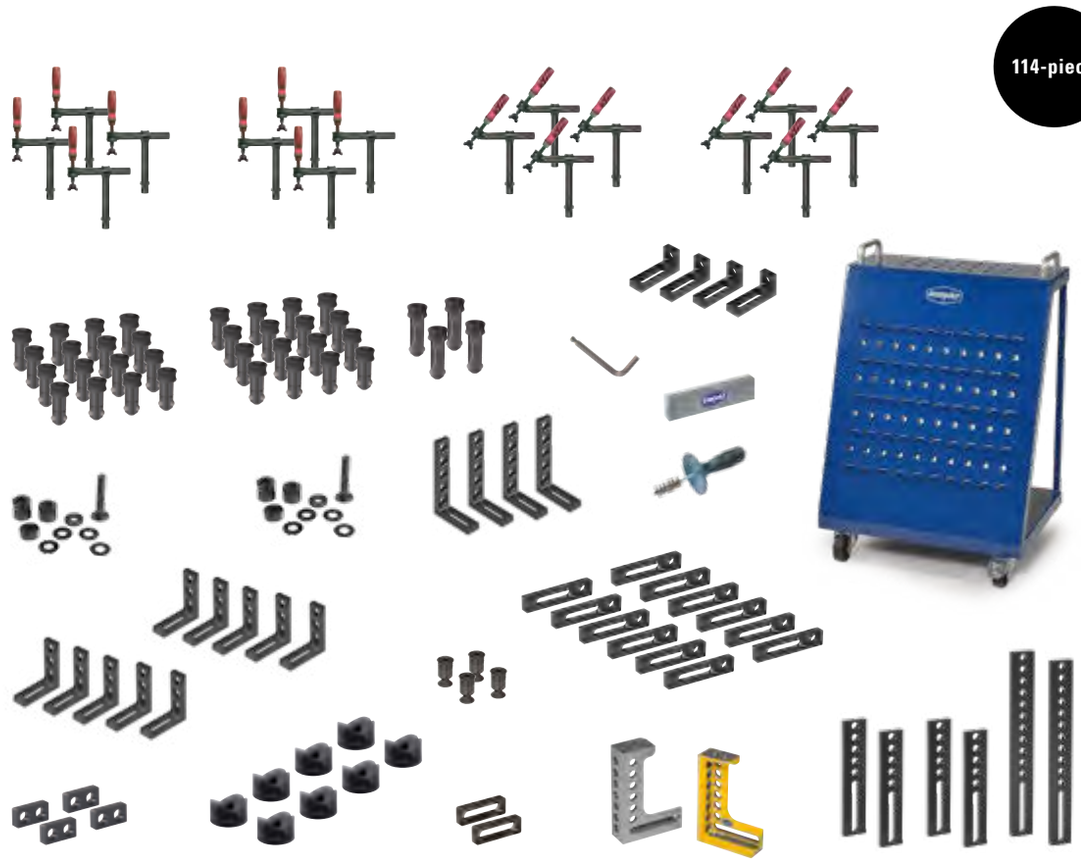


Set with PC bolts

Set also available with PC bolts instead of EcoLINE bolts.
Set with PC bolts ➔ Item no. E16-52000-721

Debaenst Lastechniek

PROFIEcoLINE set 730 D16





Set with PC bolts

Set also available with PC bolts instead of EcoLINE bolts.
Set with PC bolts ➔ Item no. E16-52000-731

DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it's possible to use the accessories from the PROFIEcoLINE set on a PROFIPlusLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

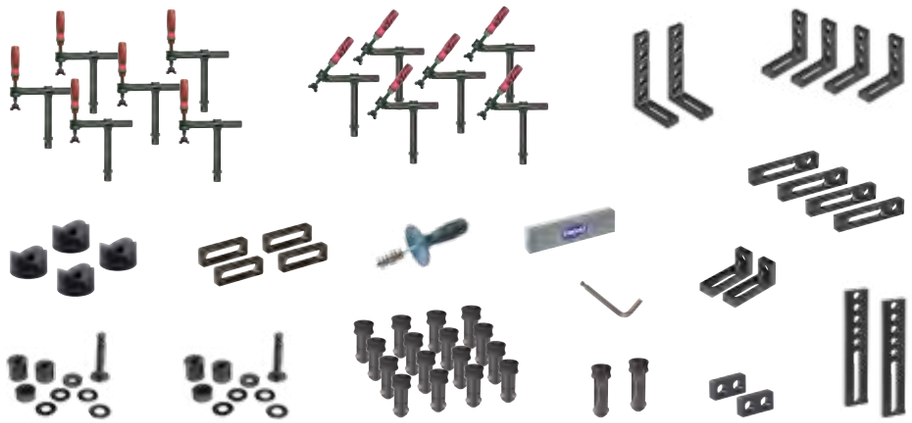
Debaenst Lastechniek

PROFIEcoLINE set 730 D16		**D16**
Quantity	**Description**	**Item no.**
10	Locating and clamping angle D16 PE, L90, bore/oblong hole	E16-03001-000
4	Locating and clamping angle D16 PE small, L90, bore/oblong hole	E16-03001-002
1	Locating and clamping angle D16 PL 200, right	D16-03002-000
1	Locating and clamping angle D16 PL 200, left	D16-03002-001
4	Locating and clamping angle D16 PL large, L140, bore/oblong hole	D16-03008-000
12	Universal stop D16 PE large, L115	E16-05001-000
4	Universal stop D16 PE small, L55	E16-05002-000
4	Stop bar D16, L250	D16-05003-000
2	Stop bar D16, L400	D16-05003-001
2	Sliding stop, L150	D16-05015-000
32	EcoLINE bolt D16, short, WAF 5	E16-06001-000
4	EcoLINE bolt D16, long, WAF 5	E16-06002-000
4	Connecting bush D16, short, screw, WAF 6	D16-06003-000
8	Screw clamp 180° D16, L130, spindle	D16-07005-000
8	Variable screw clamp 45° D16, L130, spindle	D16-07009-000
2	9-piece support set D16, 5–50 mm	D16-09001-000
8	V-block holder D16, Ø 80 mm	D16-09003-000
1	Round brush D16, splash guard	D16-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Hex key WAF 5, ball head	E16-10008-000
1	Accessory cart D16	D16-11001-002
	114-piece set	**E16-52000-730**

Debaenst Lastechniek

PROFIEcoLINE set 200 D16

59-piece



PROFIEcoLINE set 200 D16		D16
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D16 PE, L90, bore/oblong hole	E16-03001-000
2	Locating and clamping angle D16 PE small, L90, bore/oblong hole	E16-03001-002
2	Locating and clamping angle D16 PL large, L140, bore/oblong hole	D16-03008-000
4	Universal stop D16 PE large, L115	E16-05001-000
2	Universal stop D16 PE small, L55	E16-05002-000
2	Stop bar D16, L250	D16-05003-000
4	Sliding stop, L150	D16-05015-000
16	EcoLINE bolt D16, short, WAF 5	E16-06001-000
2	EcoLINE bolt D16, long, WAF 5	E16-06002-000
6	Screw clamp 180° D16, L130, spindle	D16-07005-000
6	Variable screw clamp 45° D16, L130, spindle	D16-07009-000
2	9-piece support set D16, 5–50 mm	D16-09001-000
4	V-block holder D16, Ø 80 mm	D16-09003-000
1	Round brush D16, splash guard	D16-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Hex key WAF 5, ball head	E16-10008-000
	59-piece set	**E16-52000-200**



Set with PC bolts

Set also available with PC bolts instead of EcoLINE bolts.
Set with PC bolts ➔ Item no. E16-52000-201

DEMMELER welding and clamping systems are modular and flexible. All sets and accessories can be used on the 3D welding tables within the system sizes. For instance, it's possible to use the accessories from the PROFIEcoLINE set on a PROFIPlusLINE table without any hassle.
What's more, you can individually assemble or add to your sets with the wide selection of DEMMELER accessories.

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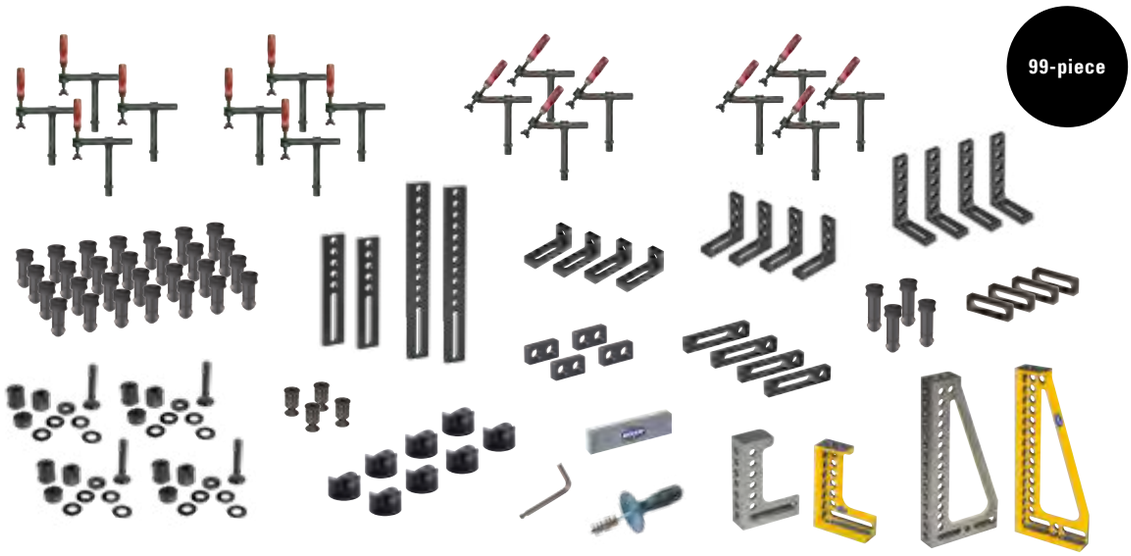
PROFIEcoLINE set 300 D16



PROFIEcoLINE set 300 D16		D16
Quantity	**Description**	**Item no.**
4	Locating and clamping angle D16 PE, L90, bore/oblong hole	E16-03001-000
4	Locating and clamping angle D16 PE small, L90, bore/oblong hole	E16-03001-002
1	Locating and clamping angle D16 PL 200, right	D16-03002-000
1	Locating and clamping angle D16 PL 200, left	D16-03002-001
1	Locating and clamping angle D16 PL 400, right	D16-03003-000
1	Locating and clamping angle D16 PL 400, left	D16-03003-001
4	Locating and clamping angle D16 PL large, L140, bore/oblong hole	D16-03008-000
4	Universal stop D16 PE large, L115	E16-05001-000
4	Universal stop D16 PE small, L55	E16-05002-000
2	Stop bar D16, L250	D16-05003-000
2	Stop bar D16, L400	D16-05003-001
4	Sliding stop, L150	D16-05015-000
28	EcoLINE bolt D16, short, WAF 5	E16-06001-000
4	EcoLINE bolt D16, long, WAF 5	E16-06002-000
4	Connecting bush D16, short, screw, WAF 6	D16-06003-000
8	Screw clamp 180° D16, L130, spindle	D16-07005-000
8	Variable screw clamp 45° D16, L130, spindle	D16-07009-000
4	9-piece support set D16, 5–50 mm	D16-09001-000
4	V-block holder D16, Ø 80 mm	D16-09003-000
1	Round brush D16, splash guard	D16-10002-000
1	Bench stone, L200, two-sided rough/fine	D00-10007-000
1	Hex key WAF 5, ball head	E16-10008-000
	99-piece set	**E16-52000-300**



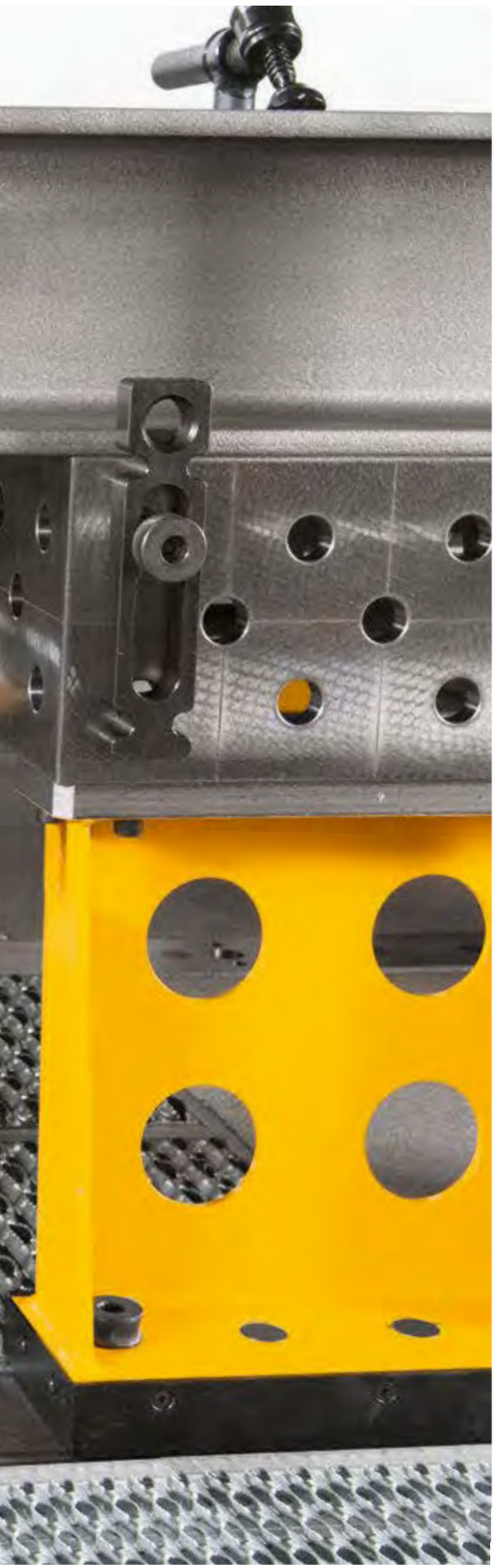
Set with PC bolts

Set also available with PC bolts instead of EcoLINE bolts.
Set with PC bolts ➔ Item no. E16-52000-301

Debaenst Lastechniek



Debaenst Lastechniek



DEMMELER® rail system

Product benefits	86
Planning and implementation	90
Overview of the rail system	92
Overview of connecting elements	96

Rail types

D28



Support and base rail
page 98



Support and base rail XL
page 98



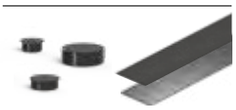
Support and base rail LINEAR
page 99



Base rail ROUND
page 99



Support and base rail DUO
page 100



Accessories
from page 100

Connecting elements

D28



Leg for spacer block
page 104



Sliding leg with castors
page 105



Guide carriage
page 106



Guide cartridge
page 107

Floor plates

D28



Clamping floor plate
page 112



Clamping floor plate XL
page 112



Clamping floor plate ProfiLINE
page 113

Debaenst Lastechniek

DEMMELER base rails – for when you have something big in mind!

Our flexible clamping system grows to meet your requirements. The modular structure of the base rail system offers you the greatest possible freedom for the production of larger than normal components. A grid system of any size adapted to your product range can be installed in your production hall. This provides you with a level installation surface over the entire area, including grid bores.



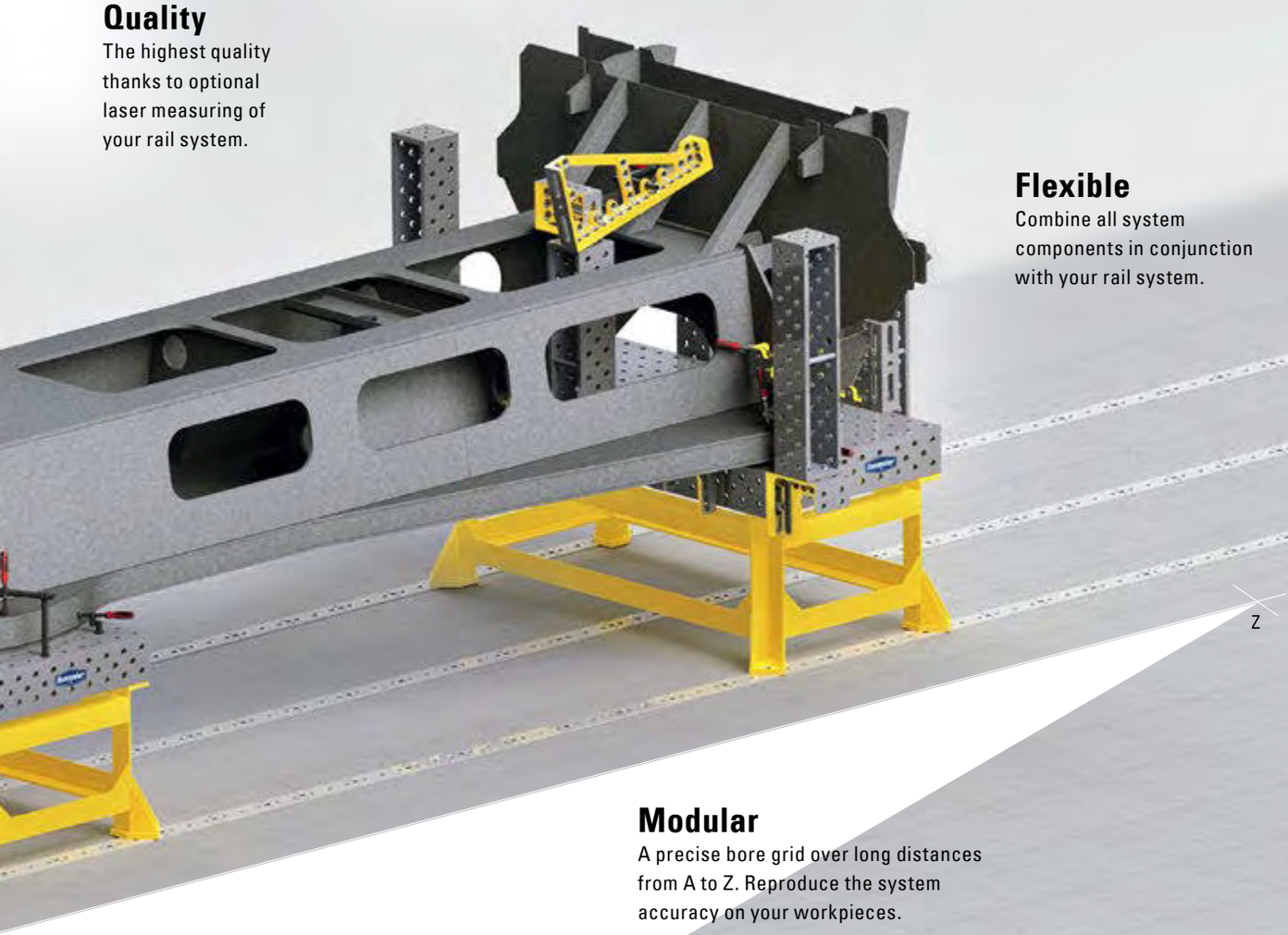
Accuracy

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

Debaenst Lastechniek

Quality

The highest quality thanks to optional laser measuring of your rail system.



Flexible

Combine all system components in conjunction with your rail system.

Modular

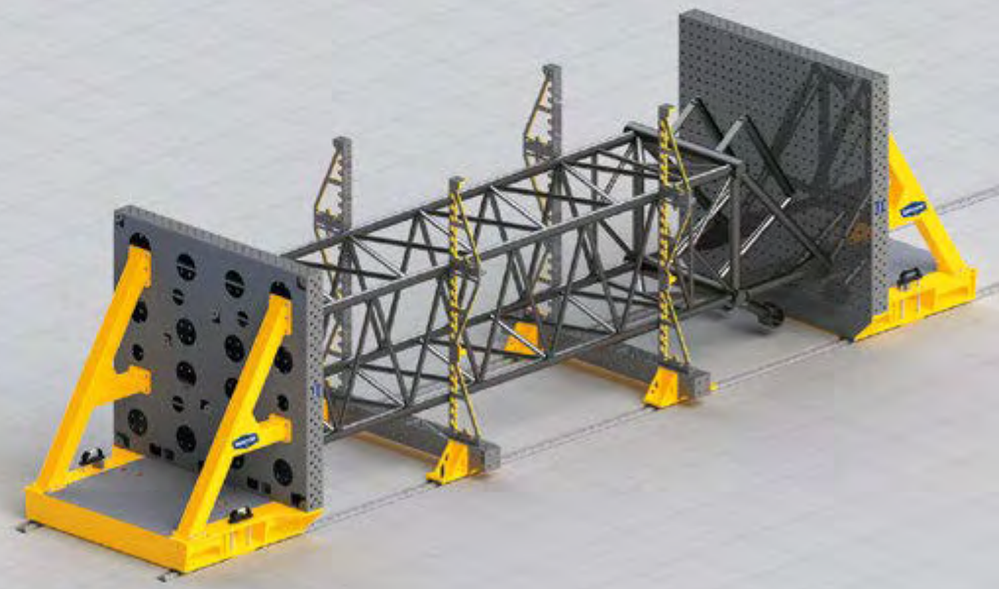
A precise bore grid over long distances from A to Z. Reproduce the system accuracy on your workpieces.

The rail system is installed according to your requirements. Several options are available to you, for example overfloor or underfloor installation. The advantage of underfloor installation is that the entire work area around the rail system is accessible for persons and vehicles. This accessibility makes work easier, reduces the risk of accidents and thereby boosts safety and increases efficiency in your manufacturing process. You have access to the comprehensive selection of DEMMELER accessories to set up your clamping fixtures on the rail system.

Debaenst Lastechniek

For projects that think outside the box

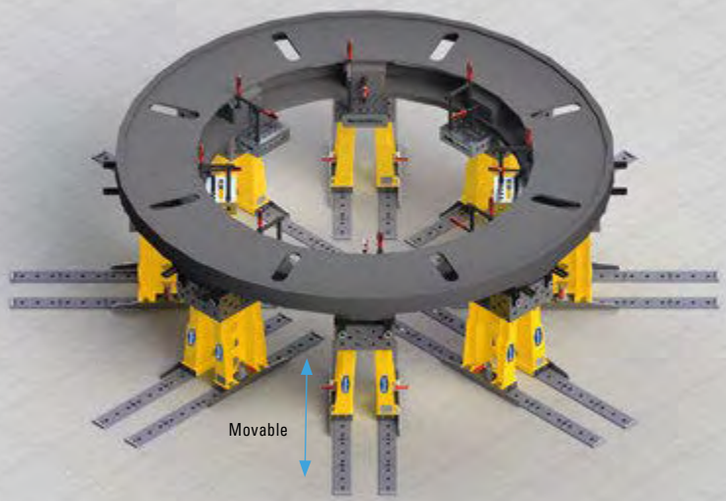
When you have big ambitions, like the company Liebherr, you need machinery to match. With the flexible base rail system, DEMMELER is the ideal partner for the world-renowned crane manufacturer. Thanks to modular extendibility, the base rail system is suitable for producing components with a length of 80 metres and more. The highest accuracy of fit is guaranteed thanks to minimal tolerances. This not only simplifies the hassle-free final assembly of the individual elements on the construction site, it also guarantees safe and smooth operation of the cranes.



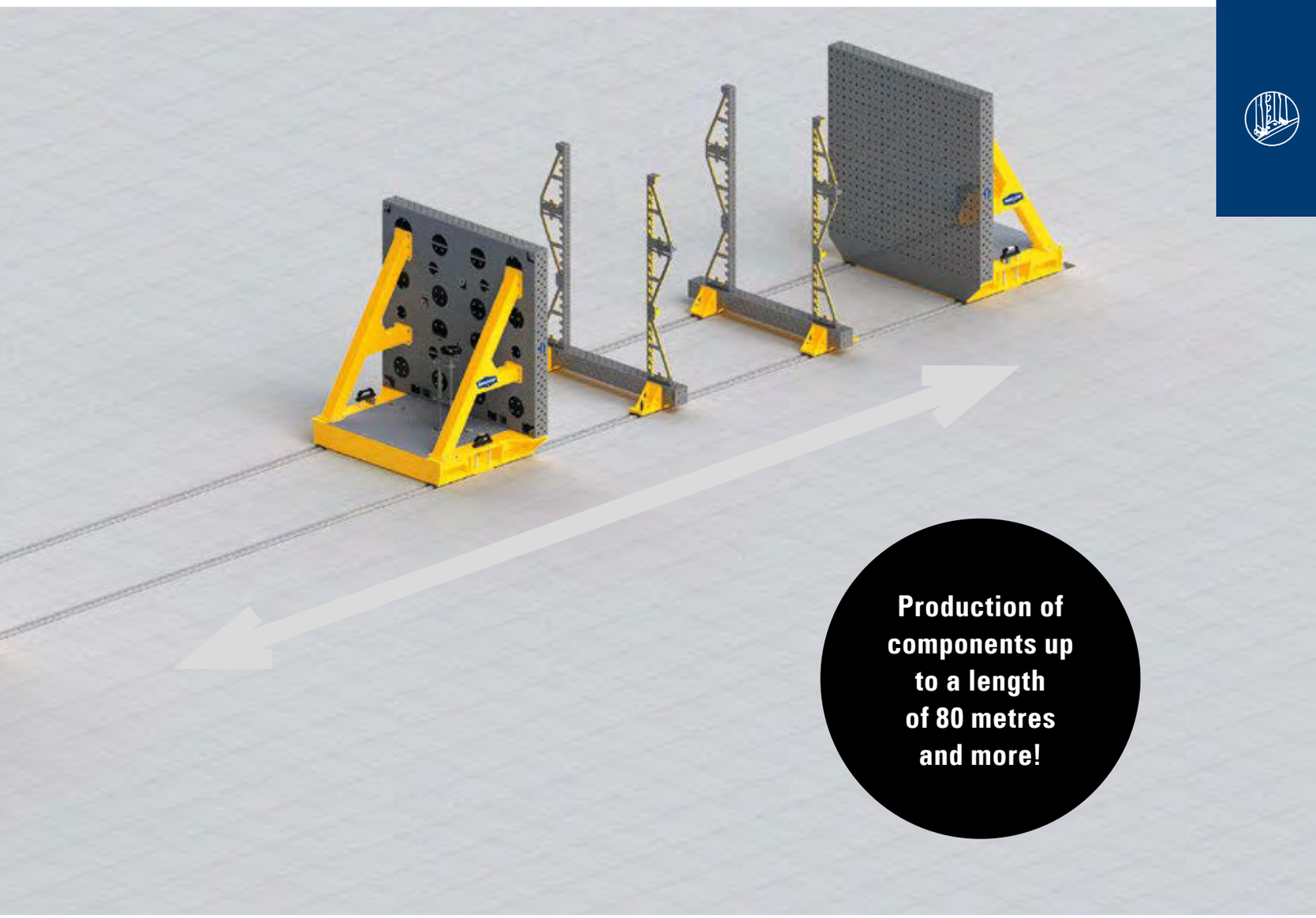
At the same time, using the sliding system reduces the set-up times for different component types. And with the comprehensive selection of accessories, countless fixtures can be created quickly and safely.

To make things run smoothly

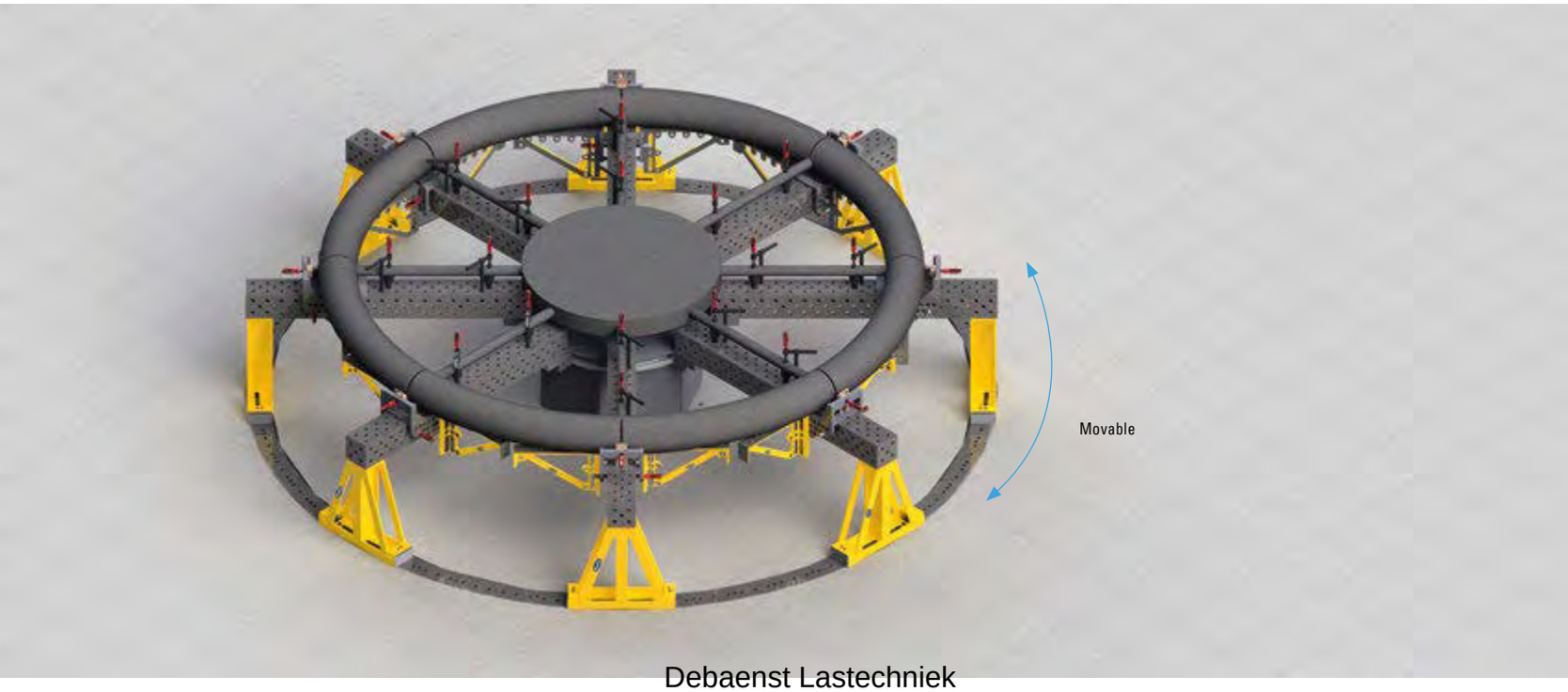
If your workpieces are round or circular, we have the right solution for you with the star-shaped arrangement of our modular rail system. Flexibly adapt the diameters of the clamping devices within the grid system.



Debaenst Lastechniek



Production of components up to a length of 80 metres and more!



Debaenst Lastechniek

Planning, installation and acceptance – everything from a single source!

The DEMMELER experts support you from planning your production facilities, right through to manufacturing. We incorporate our expertise from numerous successful projects. You receive support from our expert team, helping you make the right decisions starting in the planning phase. Experienced fitters and technicians will examine the floor characteristics and evenness on request, and offer tips on preparatory measures. Our assembly teams take care of professional installation and the alignment of the base rail system. Training for your production team guarantees proper use of the equipment.



Debaenst Lastechniek



Requirements are coordinated with the customer in close cooperation with our technicians and distribution partners. Give us the task and we will develop the right solution for you!

1 Assembly

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

2 Measuring

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

3 Acceptance

- Preparation of an acceptance report
- Handover to production
- Annual maintenance and inspections can be offered on request.



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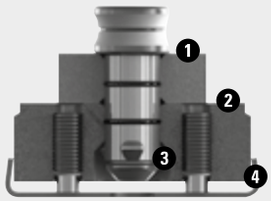
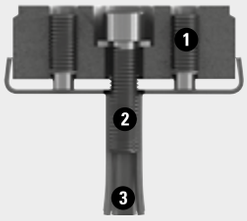
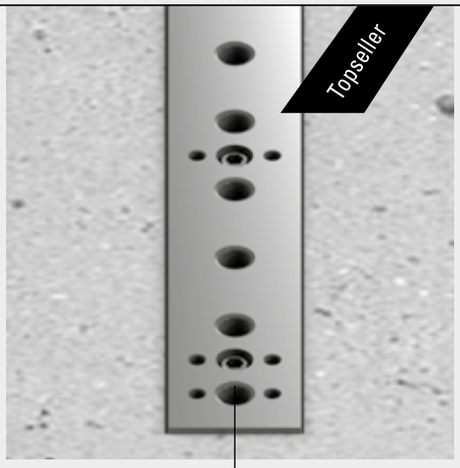


1 System component
2 Support and base rail
3 System bore
4 Shim



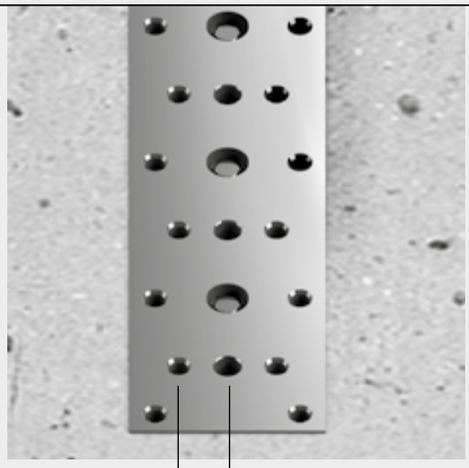
1 Set screw
2 Traction screw
3 Dowel

Support and base rail





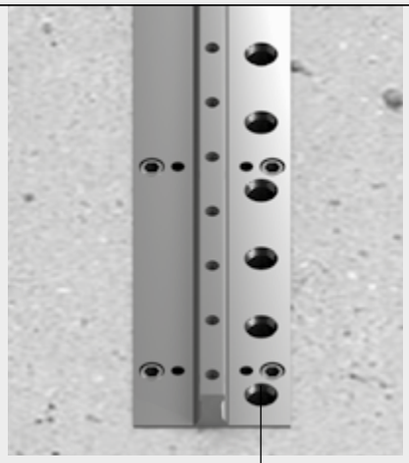
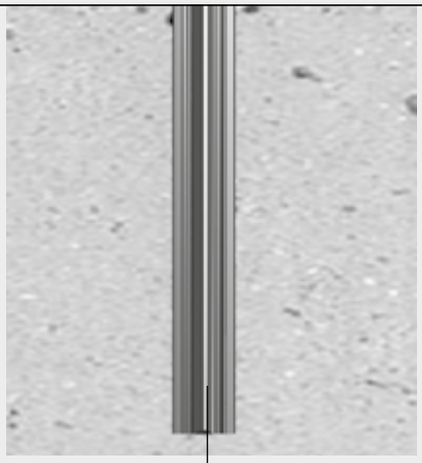
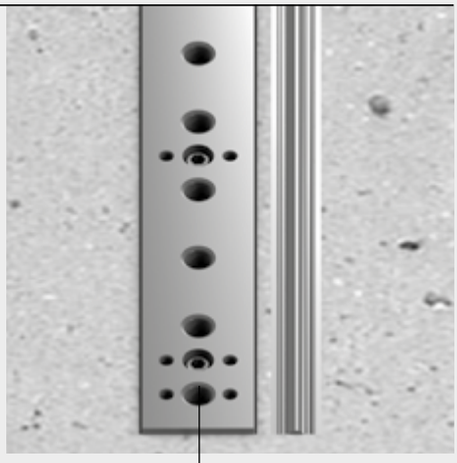
Support and base rail XL





Area of application	**Overfloor/underfloor**	**Overfloor/underfloor**
Description	• A modular system grid can be set up over large distances • Precise reference plane and clamping surfaces over the entire work area • Precise positioning thanks to D28 bores in a 100 mm grid • Suitable for all standard applications	• A modular system grid can be set up over very large distances • Precise reference plane and clamping surfaces over the entire work area • Precise positioning thanks to D28 bores and M24 threads in a 200 mm grid • Suitable for very heavy-duty use and for all standard applications • Bearing load approx. 80% higher than the standard support and base rail
Combination	All system components can be used thanks to the bore grid	All system components can be used thanks to the bore grid
Grid	D28 system bores every 100 mm	• D28 system bores every 200 mm • M24 tapped holes every 200 mm
Dimensions	Cross-section approx. 120 x 40 mm For details, see page 98	Cross-section approx. 200 x 50 mm For details, see page 98
Special features	• Use of sliding legs and connecting frames is possible • System components and 3D welding tables can also be set up directly on the rail • System components can easily be moved without using a crane thanks to sliding legs • Anchoring in the floor with dowel system • **Including screw set, dowels and shims**	• Table leg can be used for spacer blocks and connecting frames • System components and 3D welding tables can also be set up directly on the rail • Anchoring in the floor with dowel system • **Including screw set, dowels and shims**
Movement when loaded	–	–
Table leg versions	Table leg for spacer block, sliding leg, connecting frame, 3D welding table	Table leg for spacer block, sliding leg, connecting frame, 3D welding table

Debaenst Lastechniek

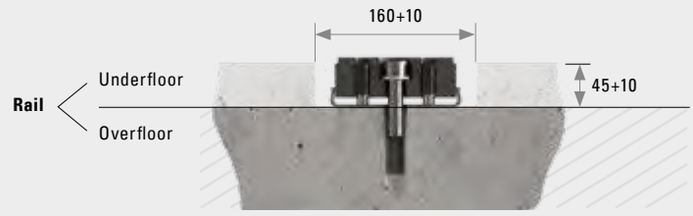
Support and base rail LINEAR	Base rail ROUND	Support and base rail DUO
		
D28	Ø 25	D28
		
Overfloor/underfloor	**Underfloor**	**Underfloor**
• A modular system grid can be set up over large distances • Precise reference plane and clamping surfaces over the entire work area • Set-up system components can even be moved when loaded • Set-up components can be set out in the system grid, enabling precise positioning	• A movement range can be set up over very large distances • Precise reference plane over the entire work area • Set-up system components can even be moved when loaded • Continuously variable positioning of set-up components • Pinning bushings possible for positioning in end positions/work areas	• A movement range can be set up over large distances • Precise reference plane and clamping surfaces over the entire work area • Set-up system components can even be moved when loaded • Precise positioning thanks to D28 bores in a 100 mm grid • Continuously variable positioning of set-up components
System components can be set up indirectly using legs or frames	System components can be set up indirectly using legs or frames	All system components can be used thanks to the bore grid
D28 system bores every 100 mm	Continuous without bore grid	• D28 system bores every 100 mm • Also continuous without bore grid
Cross-section approx. 160 x 40 mm For details, see page 99	Cross-section approx. 50 x 50 mm For details, see page 99	• Cross-section approx. 120 x 40 mm base rail • Cross-section approx. 50 x 50 mm, round rail For details, see page 100
• Suitable for pallet changeover systems in robot installations, for example • Hardened and ground version of the profile guide • Tip resistance thanks to wrap-around guide • System components, including workpiece, can easily be moved without using a crane • Anchoring in the floor with dowel system • **Including screw set, dowels and shims**	• Suitable for pallet changeover systems in robot installations, for example • Hardened and ground version of the guide shaft • System components, including workpiece, can easily be moved without using a crane • Anchoring in the floor by means of casting • Installation flush with the floor, no trip hazards • **The scope of delivery includes installation templates**	• Suitable for pallet changeover systems in robot installations, for example • Hardened and ground version of the guide shaft • System components, including workpiece, can easily be moved without using a crane • Anchoring using dowel system Casting in the floor • **Including screw set, dowels and shims**
Movement possible when loaded.	**Movement possible when loaded.**	**Movement possible when loaded.**
Guide carriage	Guide cartridge	Table leg for spacer block, sliding leg, connecting frame, 3D welding table, guide cartridge

Rail types ∨

Installation types ∨

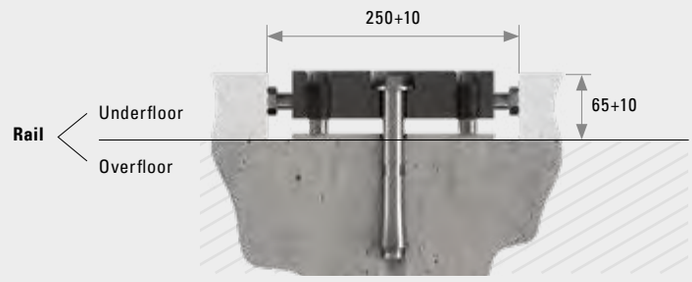


Support and base rail



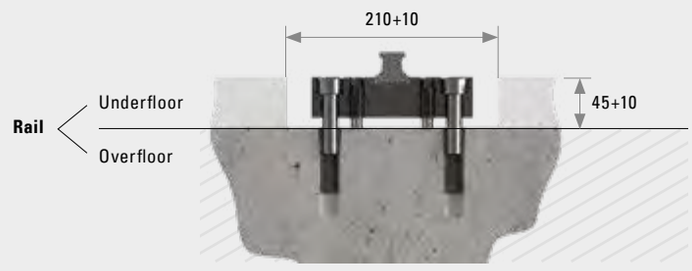


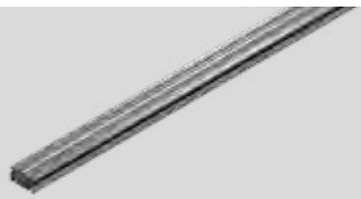
Support and base rail XL



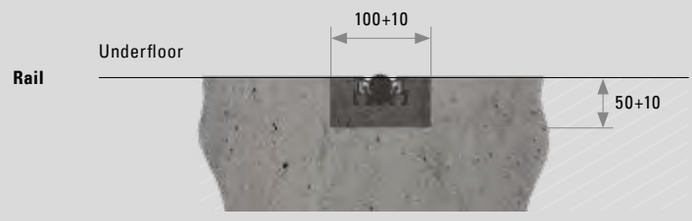


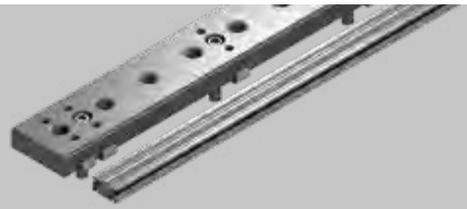
Support and base rail LINEAR



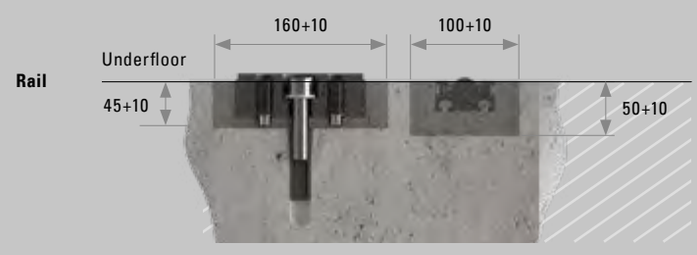


Base rail ROUND





Support and base rail DUO



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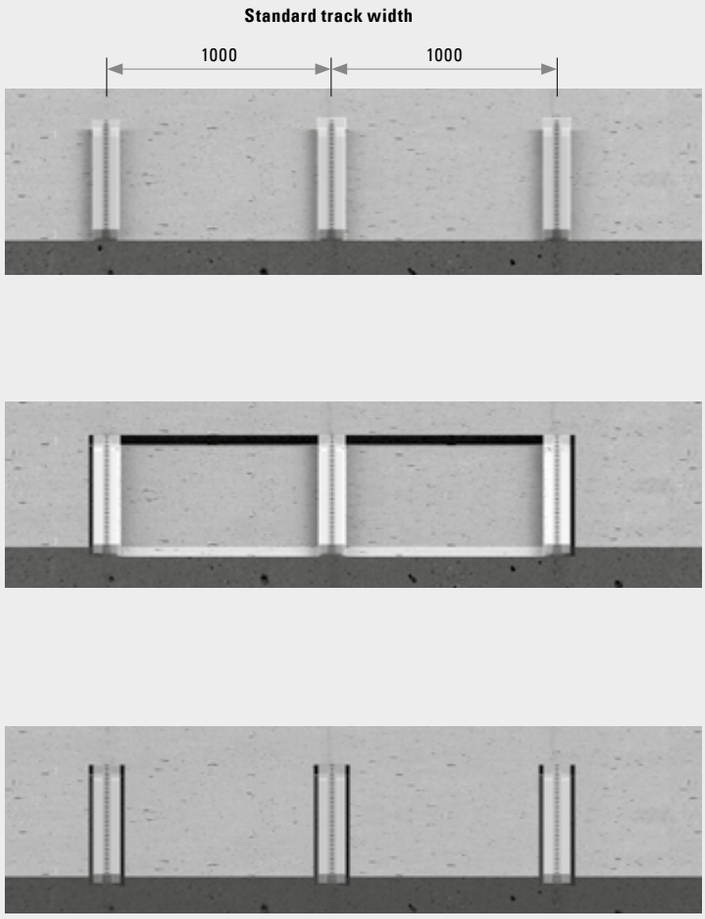
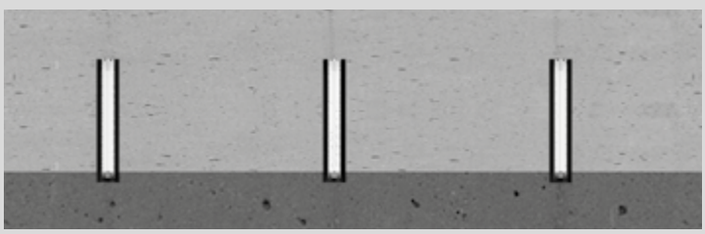
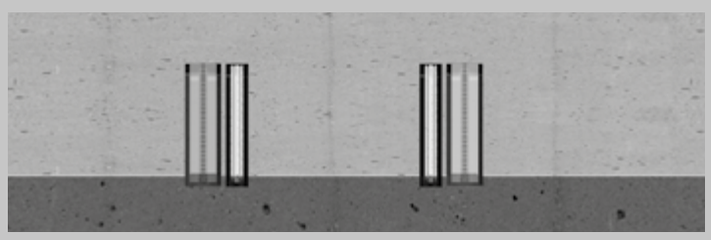
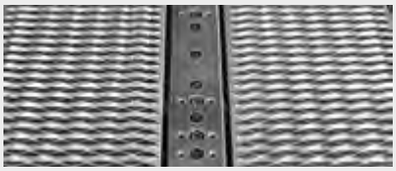
Production facility floor versions



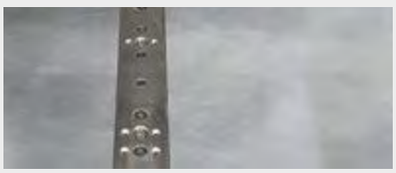




Equipment options *


Grate


Ramp


Casting

* Equipment available options on request.

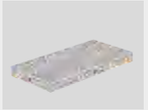
General information

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

Debaenst Lastechniek

Legs you can build on.

DEMMELER provides a coordinated range for every task. In addition to an wide choice of tools, a diverse range of sophisticated system accessories is required to produce components on our rail system. Our leg versions tailored to the different rail types and requirements form a secure connection between the rail and 3D clamping system. Exchangeable table legs and sliding legs with castors, for example, enable rapid adaptation to new tasks. Multifunctional guide carriages can be moved to the required position quickly yet precisely.

Rail types		Compatible leg versions as connecting elements					
		 Leg for spacer block	 Sliding leg	 Connection frame	 3D table/system components	 Guide carriage	 Guide cartridge
Support and base rail		•	•	•	•		
Support and base rail XL		•	•	•	•		
Support and base rail LINEAR						•	
Base rail ROUND							•
Support and base rail DUO		•	•	•	•		•

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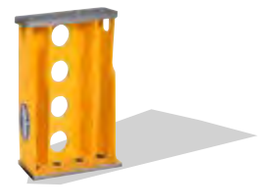
Leg versions

Function



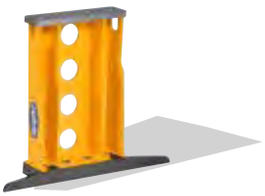
Leg for spacer block
(description and sizes, page 104)



The set-up heights can be adapted to the workpiece by simply exchanging the legs.



Attachment to system components



Sliding leg with castors
(description and sizes, page 105)



Set-up system components can be moved without using lifting equipment or a crane.



Roller



Tilt safety device



Connecting frame
(description and sizes, page 49)



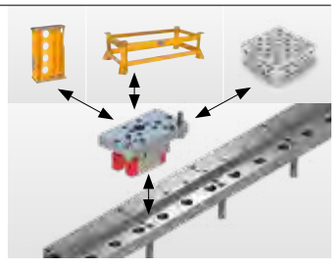
Set up in a lengthwise and crosswise direction.



Guide carriage
(description and sizes, page 106)



Set-up system components can be moved even under load.

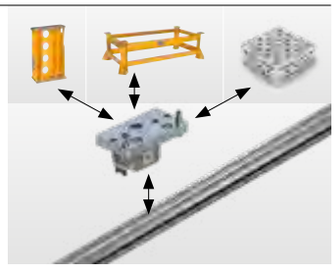




Guide cartridge
(description and sizes, page 107)

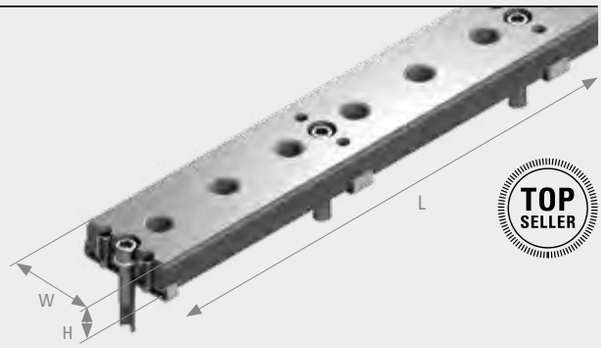


Set-up system components can be moved even under load.



Support and base rail

- A modular system grid can be set up over large distances
- Precise reference plane and clamping surfaces over the entire work area
- Precise positioning thanks to D28 bores in a 100 mm grid
- Suitable for all standard applications
- Screw set, dowels and shims are included in the scope of delivery
- Bearing load per metre up to 16 t
- Permissible tensile load in crack-free concrete 1.0 t per dowel



Support and base rail — **D28**



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

*Preferred lengths/other lengths available on request.



Connecting elements for support and base rail:
Table leg for spacer block, sliding leg, connecting frame, 3D welding table. Also see page 104 onwards.

Support and base rail XL

- A modular system grid can be set up over very large distances
- Precise reference plane and clamping surfaces over the entire work area
- Precise positioning thanks to D28 bores in a 200 mm grid
- Suitable for very heavy-duty use and all standard applications
- Screw set, dowels and shims are included in the scope of delivery
- Bearing load per metre up to 30 t
- Bearing load approx. 80% higher than the standard support and base rail
- Permissible tensile load in crack-free concrete 1.8 t per dowel

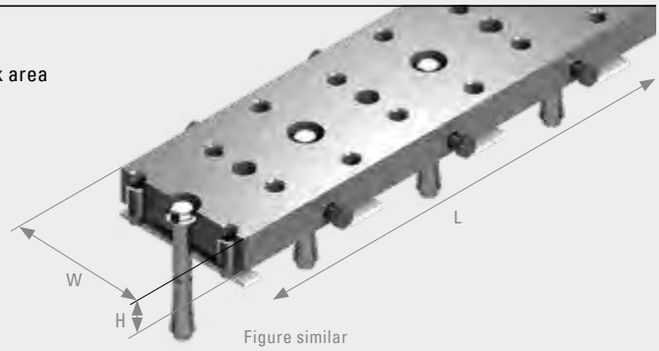


Figure similar

Support and base rail XL — **D28**



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

Other lengths available on request.

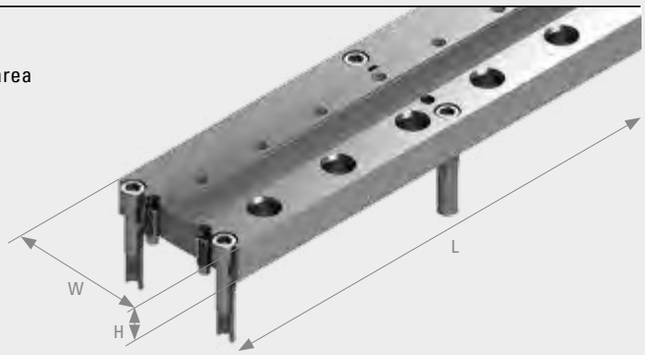


Connecting elements for support and base rail XL:
Table leg for spacer block, sliding leg, connecting frame, 3D welding table. Also see page 104 onwards.

Debaenst Lastechniek

Support and base rail LINEAR

- A modular system grid can be set up over large distances
- Precise reference plane and clamping surfaces over the entire work area
- The set-up system components can even be moved when loaded
- Tip resistance thanks to integrated wrap-around guide
- Hardened and ground version of the profile guide
- Set-up components can be set out in the system grid, enabling precise positioning
- Screw set, dowels and shims are included in the scope of delivery
- Bearing load per metre up to 16 t
- Permissible tensile load in crack-free concrete 1.0 t per dowel



Support and base rail LINEAR — **D28**



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

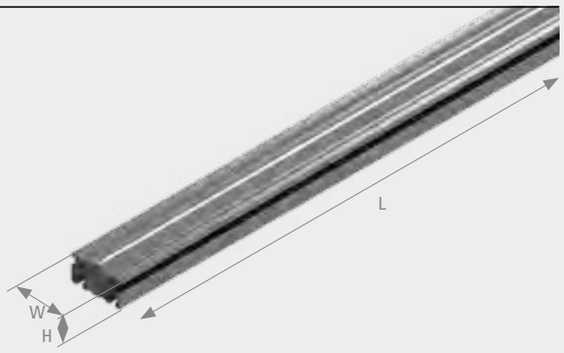
Other lengths available on request.



Connecting element for support and base rail LINEAR:
Guide carriage. Also see page 106 onwards.

Base rail ROUND

- A movement range can be set up over large distances
- Precise reference plane over the entire work area
- The set-up system components can even be moved when loaded
- Continuously variable positioning of set-up components
- Ideal for pallet changeover systems
- Pinning bushings for positioning in end positions/work areas, can be integrated into the floor
- Bearing load per metre up to 10 t



Base rail ROUND — **D28**



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

Other lengths available on request.



Connecting element for base rail ROUND:
Guide cartridge. Also see page 107 onwards.

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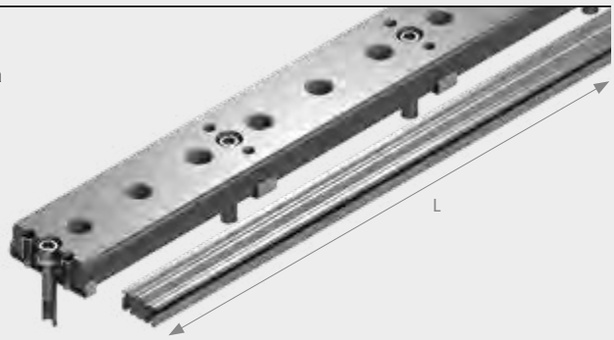
Support and base rail DUO

- A movement range can be set up over large distances
- Precise reference plane and clamping surfaces over the entire work area
- The set-up system components can even be moved when loaded
- Precise positioning thanks to D28 bores in a 100 mm grid
- Continuously variable positioning of set-up components
- Screw set, dowels and shims are included in the scope of delivery
- Bearing load per metre up to 20 t (depending on the number of guide cartridges)
- Permissible tensile load in crack-free concrete 1.0 t per dowel



Support and base rail DUO



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

Other lengths available on request.



Connecting elements for support and base rail DUO:
Table leg for spacer block, sliding leg, connecting frame, 3D welding table, guide cartridge.
Also see page 104 onwards.

Protecting the system bores against dirt

Fine-grooved rubber mat/cover plate

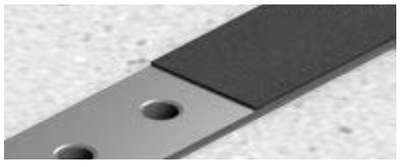
- Protects the system bores against dirt



Fine-grooved rubber mat



L in mm	D28 Item no.
1000	00092901



Cover plate



L in mm	D28 Item no.
1000	00092904



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Plug/cap/magnet

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



Plug

	Description	D28
	Plug D28	D28-10003-006
	10x plugs D28	D28-10003-007
	Plug, Ø 39 mm	00092929
	Plug M24	00068955



Cap

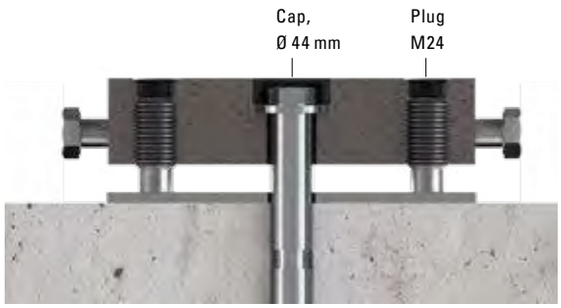
	Description	D28
	Cap, Ø 44 mm	00023584

Magnet

	Description	D28
	Magnet for plug D28, Ø 32 mm	D28-10003-002

Example applications: Plug/cap





Put your clamping system on the right track with the compatible legs

To be used on the rail system, the 3D welding tables must have additional bores on the underside for mounting the leg versions.
For this reason, please choose your 3D welding table with the corresponding item no. from the table below.

PROFIPremiumLINE (PP)



		SOLID	Hardened DEMONT 760 M	Hardened DEMONT 890 M
L x W in mm	**H in mm**	**Item no.**	**Item no.**	**Item no.**
1000 x 1000	200	PP28-01001-007	PP28-01001-017	PP28-01001-027
1200 x 1200	200	PP28-01056-007	PP28-01056-017	PP28-01056-027
1500 x 1000	200	PP28-01011-007	PP28-01011-017	PP28-01011-027
1500 x 1500	200	PP28-01031-007	PP28-01031-017	PP28-01031-027
2000 x 1000	200	PP28-01002-007	PP28-01002-017	PP28-01002-027
2000 x 2000	200	PP28-01006-007	PP28-01006-017	PP28-01006-027
2400 x 1200	200	PP28-01003-007	PP28-01003-017	PP28-01003-027
3000 x 1500	200	PP28-01004-007	PP28-01004-017	PP28-01004-027
4000 x 2000	200	PP28-01005-007	PP28-01005-017	PP28-01005-027
4800 x 2400	200	PP28-11085-007	PP28-11085-017	PP28-11085-027

PROFIPlusLINE (PL)



		SOLID	Hardened DEMONT 760 M	Hardened DEMONT 890 M
L x W in mm	**H in mm**	**Item no.**	**Item no.**	**Item no.**
1000 x 1000	200	PL28-01001-007	PL28-01001-017	PL28-01001-027
1200 x 1200	200	PL28-01056-007	PL28-01056-017	PL28-01056-027
1500 x 1000	200	PL28-01011-007	PL28-01011-017	PL28-01011-027
1500 x 1500	200	PL28-01031-007	PL28-01031-017	PL28-01031-027
2000 x 1000	200	PL28-01002-007	PL28-01002-017	PL28-01002-027
2000 x 2000	200	PL28-01006-007	PL28-01006-017	PL28-01006-027
2400 x 1200	200	PL28-01003-007	PL28-01003-017	PL28-01003-027
3000 x 1500	200	PL28-01004-007	PL28-01004-017	PL28-01004-027
4000 x 2000	200	PL28-01005-007	PL28-01005-017	PL28-01005-027
4800 x 2400	200	PL28-11085-007	PL28-11085-017	PL28-11085-027

PROFIEcoLINE (PE)



		SOLID	Hardened DEMONT 760 M	Hardened DEMONT 890 M
L x W in mm	**H in mm**	**Item no.**	**Item no.**	**Item no.**
1000 x 1000	200	PE28-01001-007	PE28-01001-017	PE28-01001-027
1200 x 1200	200	PE28-01056-007	PE28-01056-017	PE28-01056-027
1500 x 1000	200	PE28-01011-007	PE28-01011-017	PE28-01011-027
1500 x 1500	200	PE28-01031-007	PE28-01031-017	PE28-01031-027
2000 x 1000	200	PE28-01002-007	PE28-01002-017	PE28-01002-027
2000 x 2000	200	PE28-01006-007	PE28-01006-017	PE28-01006-027
2400 x 1200	200	PE28-01003-007	PE28-01003-017	PE28-01003-027
3000 x 1500	200	PE28-01004-007	PE28-01004-017	PE28-01004-027
4000 x 2000	200	PE28-01005-007	PE28-01005-017	PE28-01005-027
4800 x 2400	200	PE28-11085-007	PE28-11085-017	PE28-11085-027

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Ordering example:



A From page 102, select the required worktop, which results in order item **A**:

e.g. **1x PL28-01002-007**



B From this page, select the leg you want in the corresponding quantity, which results in order item **B**:

e.g. **4x D00-10017-000**



C The two order item numbers make up your order from DEMMELER.

e.g. **1x PL28-01002-007 (A)**
e.g. **4x D00-10017-000 (B)**



Connecting frame

D28

For table sizes	Connecting frame size	Weight in kg	Max. load in kg	Item no.
1000 x 1000 1200 x 1200 1500 x 1000 1500 x 1500	1000 x 1000 x 600	158	15000	PL00-02004-000
2000 x 1000 2000 x 2000 2400 x 1200 3000 x 1500 4000 x 2000	2000 x 1000 x 600	229	15000	PL00-02004-001
4000 x 2000 4800 x 2400	4000 x 2000 x 600	516	20000	PL00-02004-002



Leg for spacer block (for all table sizes)

D28

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



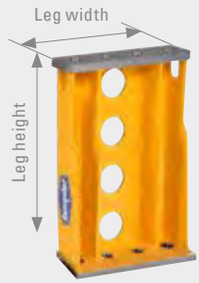
Sliding leg (for all table sizes)

D28

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

Leg for spacer block

- Connecting element between U-shaped spacer block or 3D welding table and support and base rail
- Different set-up heights can be adapted to the workpiece by simply exchanging the table legs
- Includes 2x fitted shoulder screws M12–16 H8 x 30 for attachment to system components



TOP SELLER

Leg for spacer block — **D28**



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

Other heights available on request. Observe internal safety guidelines when moving the system components.

Leg sizes:





Compatible with the following rail types: Support and base rail, support and base rail XL and DUO. Also see page 98 onwards.



Debaenst Lastechniek

System components are easy to move – with the patented DEMMELER® sliding legs with castors

DEMMELER PATENTED Shifting foot № 2892692

The castors of the patented DEMMELER® sliding legs lower when loaded. This means that the leg is in contact with the base rail across its entire surface. The welding current is not conducted by the rollers, preventing damage to the bearing.



Setting out and clamping
= working position

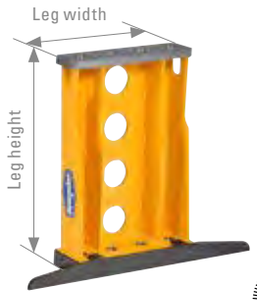


Spring-loaded lift
= movement position
(mounted on roller bearings so as to be movable)



Sliding leg with castors

- Set-up system components can be moved without using lifting equipment or a crane
- Different set-up heights can be adapted to the workpiece by simply exchanging the table legs
- Highest load capacity in the working position because the leg is supported over its entire surface on the rail
- Tilt safety device is included in the scope of delivery
- Includes 2x fitted shoulder screws M12–16 H8 x 30 for attachment to system components
- Ensure stability when moving system components



TOP SELLER

Sliding leg with castors — **D28**



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

Other heights available on request. Observe internal safety guidelines when moving the system components.
*Specified load in working position.

Leg sizes:



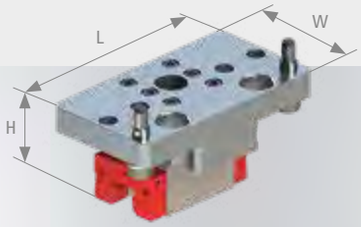


Compatible with the support and base rail. See also page 98.

Debaenst Lastechniek

Guide carriage

- Secured to prevent tipping thanks to wrap-around profile rail guide
- Scraper prevents accumulation of dirt on the rolling elements
- Cladding plate is included in the scope of delivery
- **Movement possible when loaded**



Guide carriage — **D28**

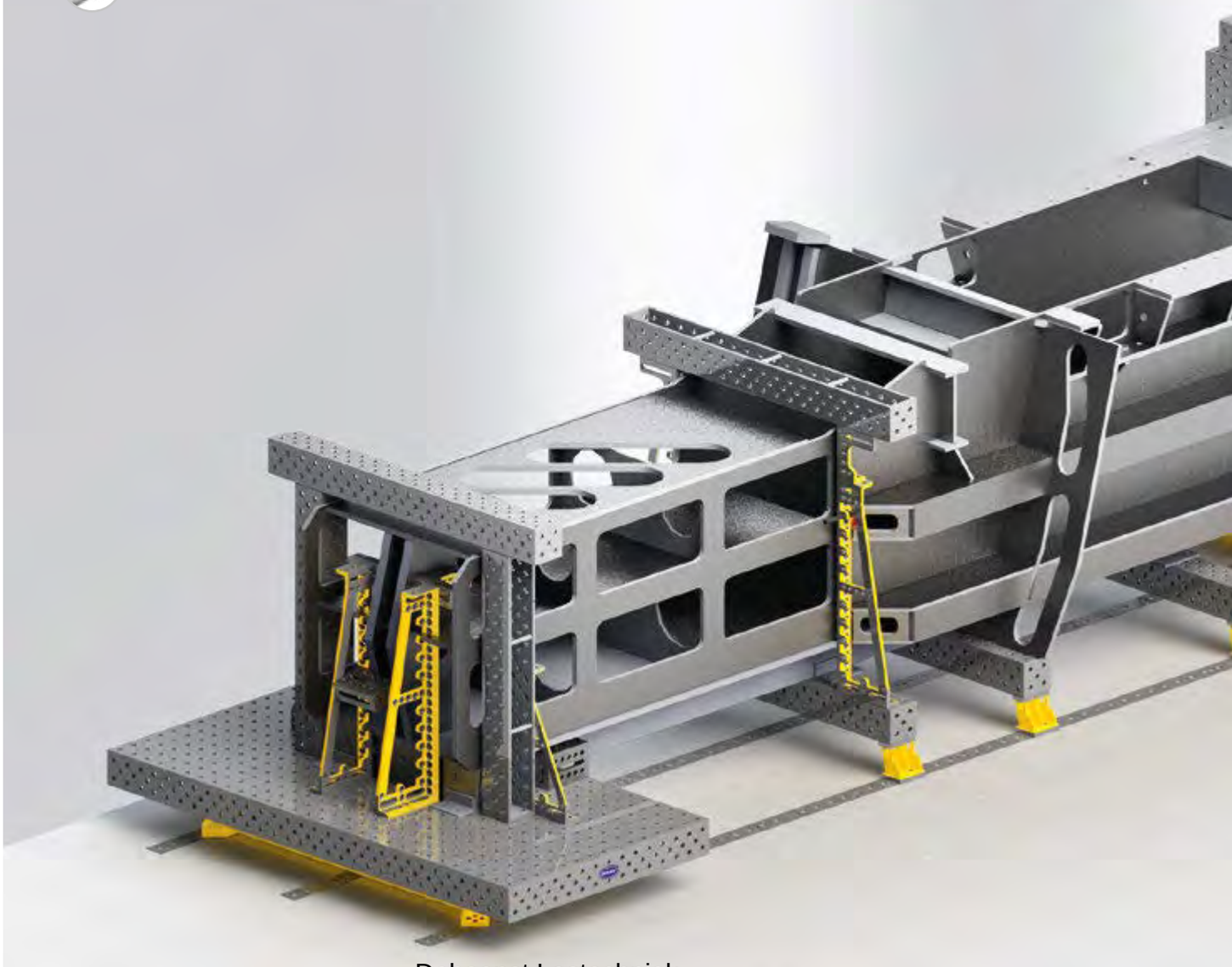


L in mm	W in mm	H in mm	Max. load in kg per guide carriage		Item no.
			Static	Dynamic	
200	110	100	8440	3870	D28-10018-000
400	110	100	16880	7740	D28-10018-001

Observe internal safety guidelines when moving the system components.



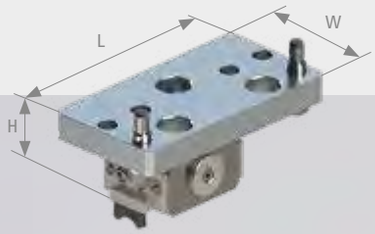
Compatible with the support and base rail LINEAR. See also page 99.



Debaenst Lastechniek

Guide cartridge

- Extremely smooth-running thanks to ball bearings
- Roller in hardened version
- High bearing load thanks to robust design
- Cladding plates are included in the scope of delivery
- Ensure stability when moving system components
- **Movement possible when loaded**



Guide cartridge — **D28**



L in mm	W in mm	H in mm	Max. load in kg per guide cartridge	Item no.
200	110	100	1640	D28-10019-000
400	110	100	3280	D28-10019-001

Observe internal safety guidelines when moving the system components.

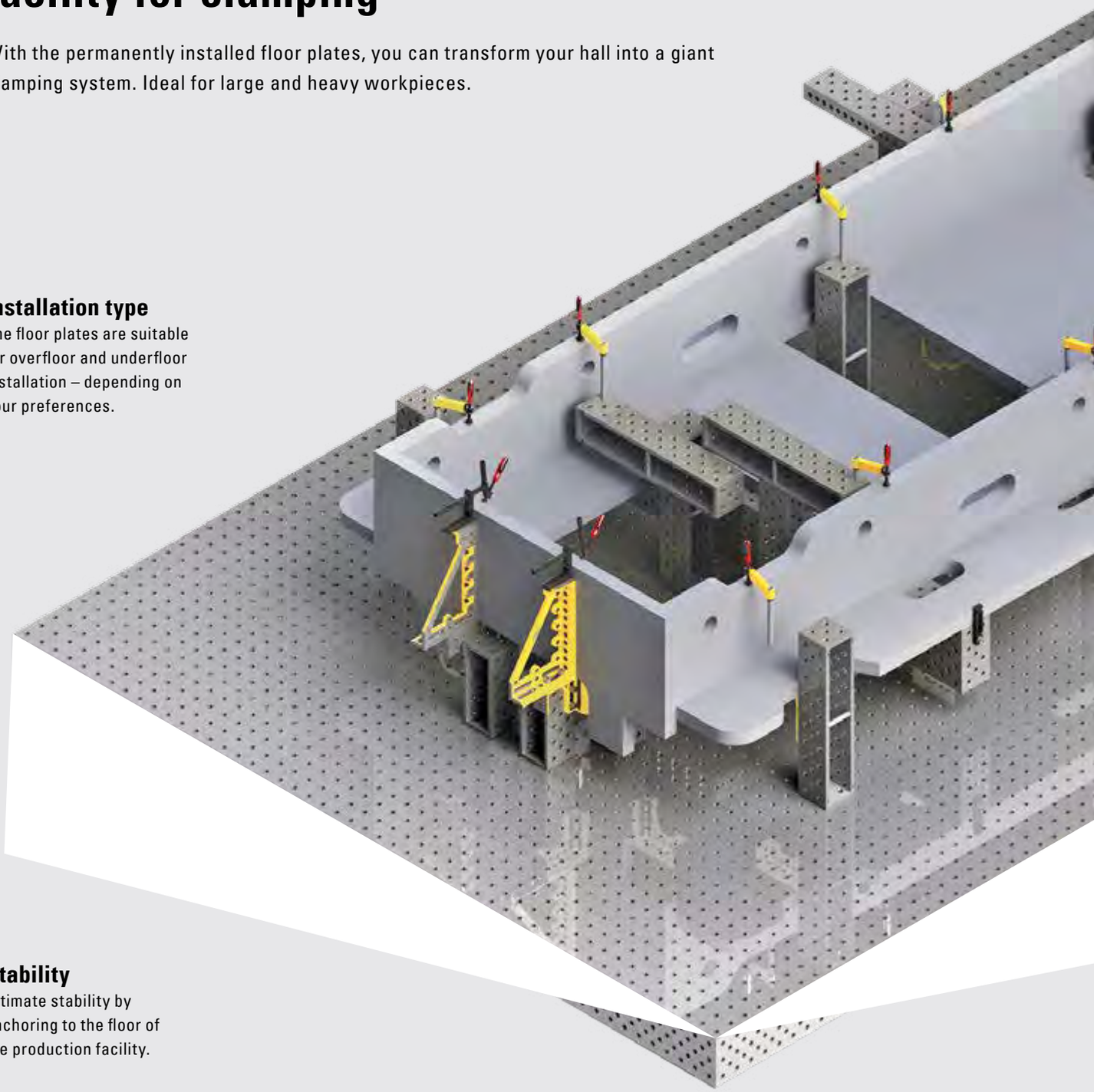


Compatible with the base rail ROUND. See also page 99.



Equipping the floor of the production facility for clamping

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



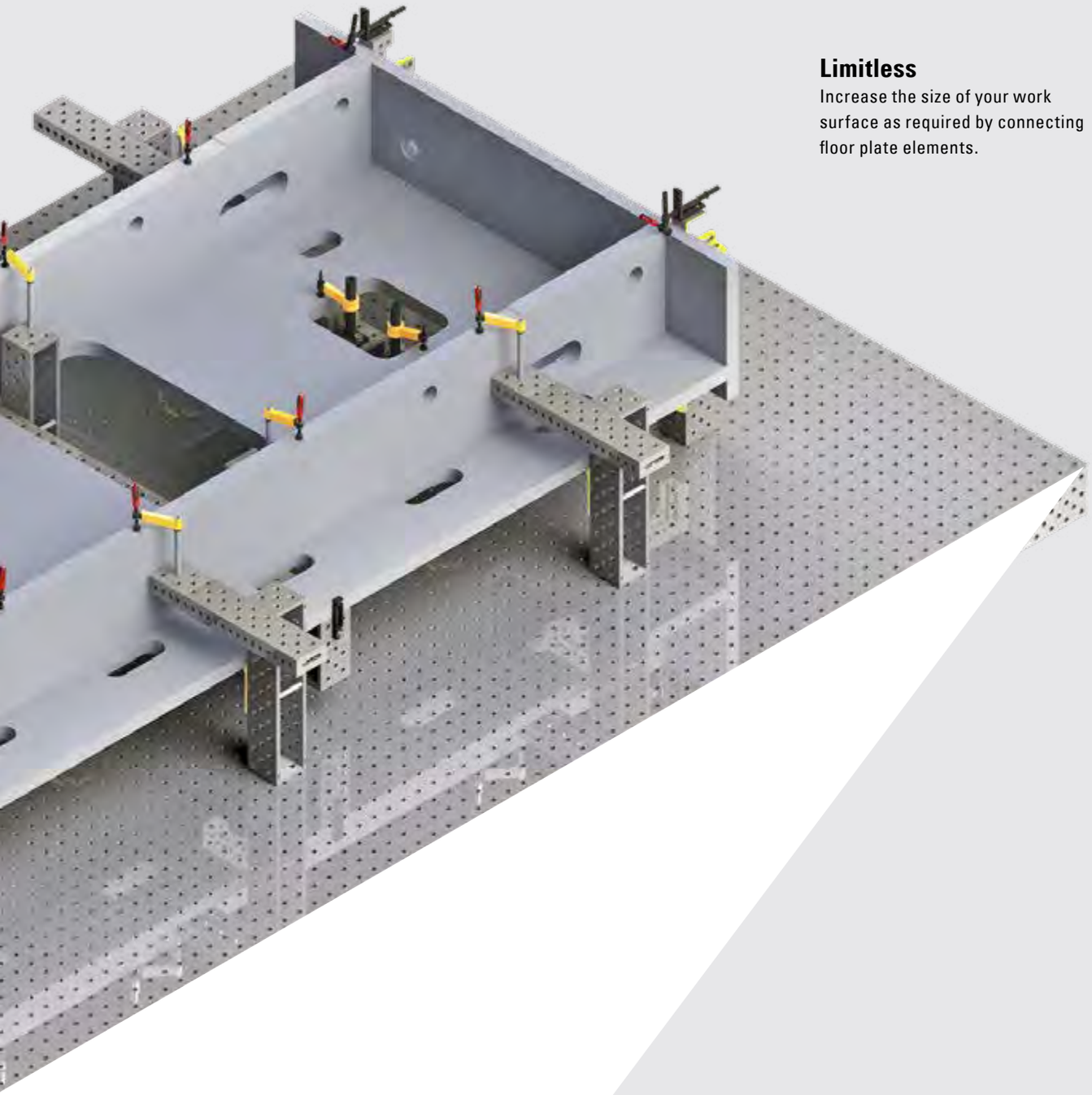
Installation type

The floor plates are suitable for overfloor and underfloor installation – depending on your preferences.

Stability

Ultimate stability by anchoring to the floor of the production facility.

Debaenst Lastechniek



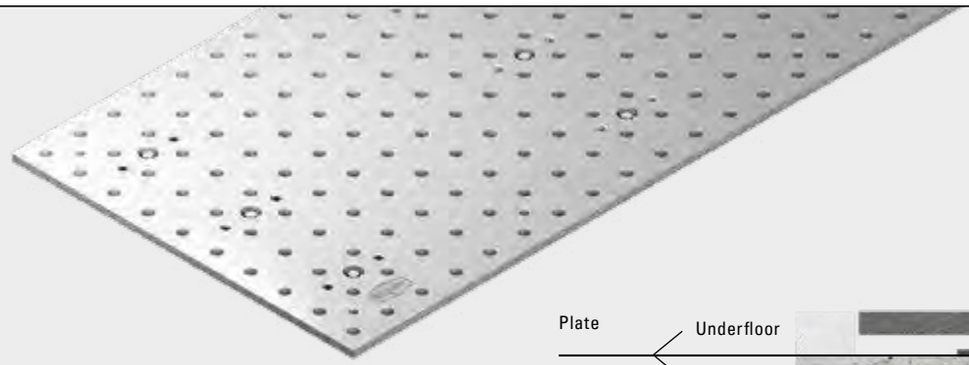
Limitless

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

Complexity

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

Clamping floor plate

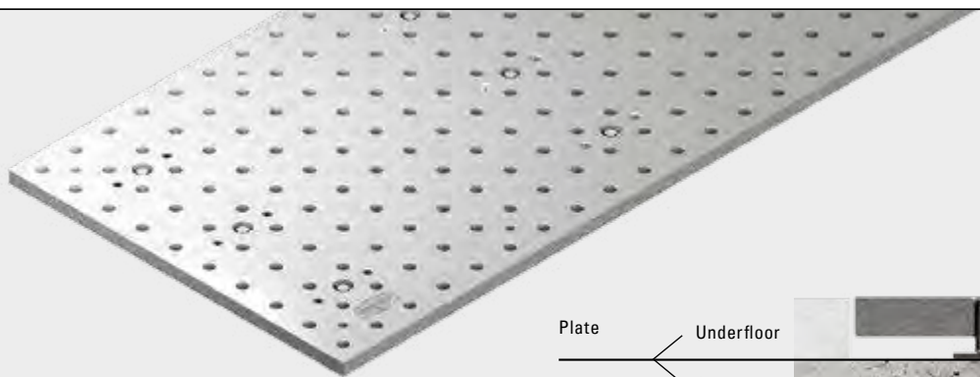


D28



Two-dimensional grid system for large, complex components

Clamping floor plate XL

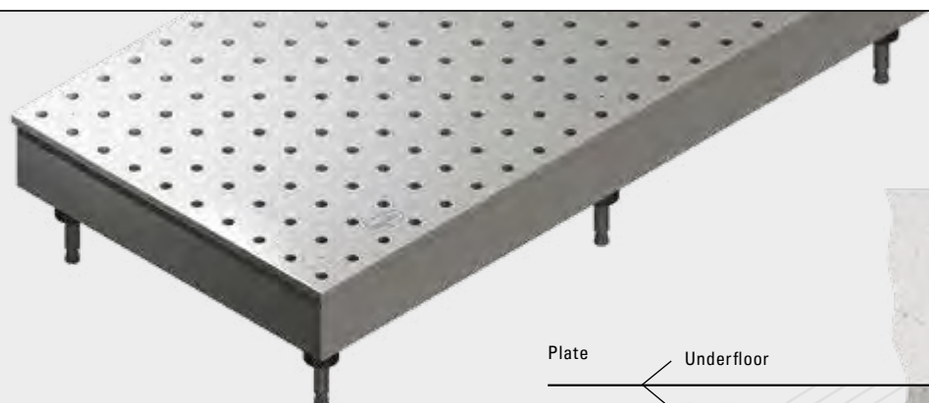


D28

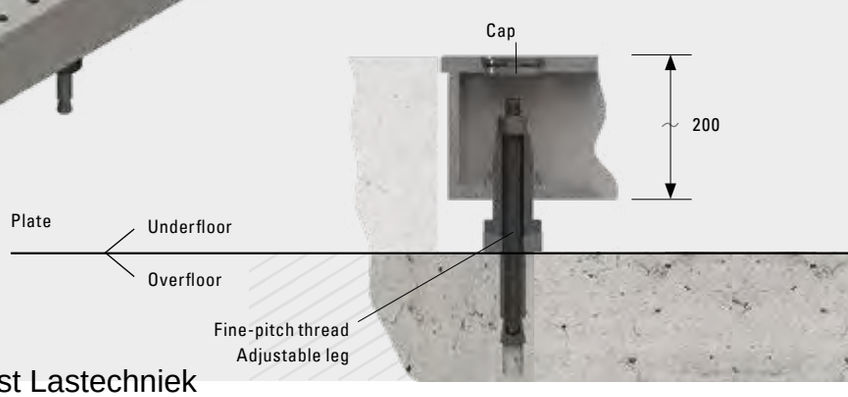


Two-dimensional grid system for large, complex components

Clamping floor plate ProfiLINE



D28



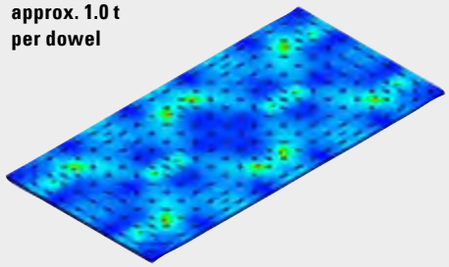
Two-dimensional grid system for extremely large, complex components

Debaenst Lastechniek

Bearing load approx.

5 t per m²

Permissible tensile load in crack-free concrete approx. 1.0 t per dowel



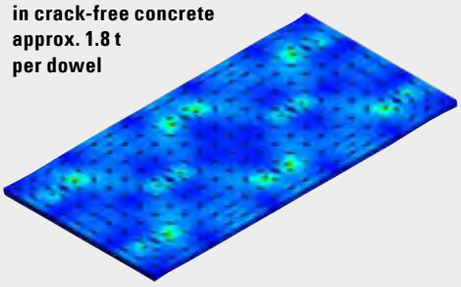


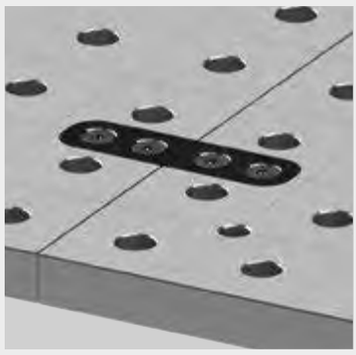
Connection/expansion of individual elements

Bearing load approx.

7.5 t per m²

Permissible tensile load in crack-free concrete approx. 1.8 t per dowel



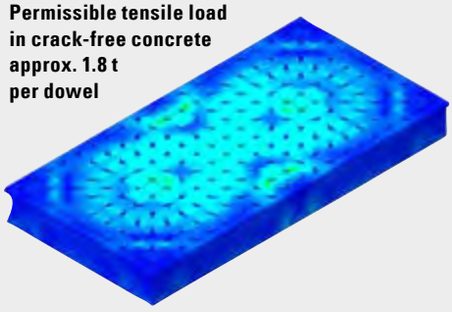


Connection/expansion of individual elements

Bearing load approx.

15 t per m²

Permissible tensile load in crack-free concrete approx. 1.8 t per dowel



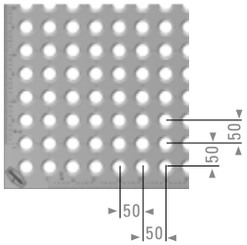


Connection/expansion of individual elements

Grid options

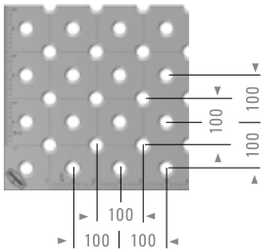
Various grid types are optionally possible

PROFIPremiumLINE (PP)



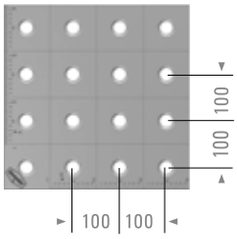
Worktop with D28 system bores in a 50 x 50 mm grid

PROFIPlusLINE (PL)



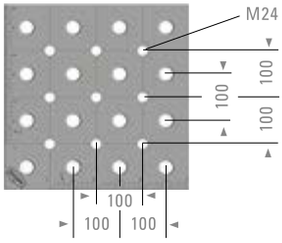
Worktop with D28 system bores in a 100 x 100 mm double grid

PROFIEcoLINE (PE)



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

PL-M24 grid

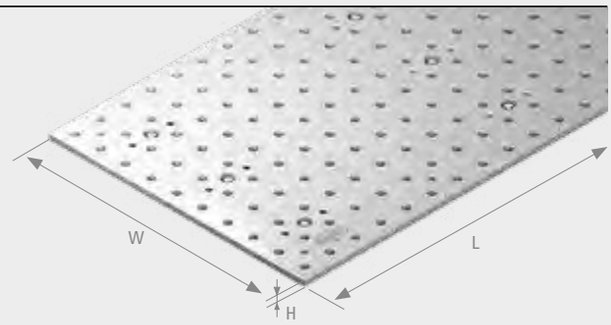


Worktop with D28 system bores in a 100 x 100 mm grid and additional M24 bores in a 100 x 100 mm grid

Debaenst Lastechniek

Clamping floor plate

- A modular system grid can be set up over large distances
- Precise reference plane and clamping surfaces over the entire work area
- Precise positioning thanks to D28 bores in a 100 mm grid
- Suitable for all standard applications
- Screw set, dowels and shims are included in the scope of delivery
- Bearing load per metre up to 16 t/bearing load approx. 5 t per m²
- Permissible tensile load in crack-free concrete 1.0 t per dowel
- You can find further details on page 110



Clamping floor plate — **D28**

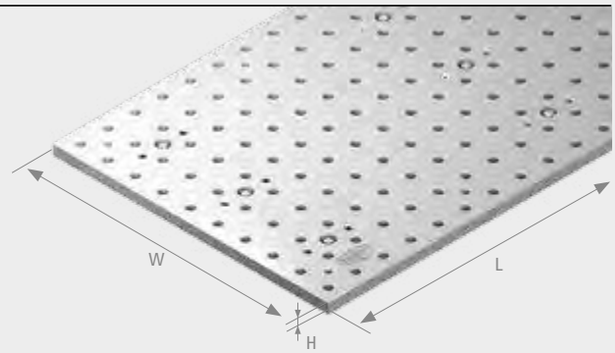


L in mm	W in mm	H in mm approx.	Item no.
1000	1000	23	D28-02010-000
1200	1200	23	D28-02010-001
1500	1000	23	D28-02010-002
1500	1500	23	D28-02010-003
2000	1000	23	D28-02010-004
2400	1200	23	D28-02010-005
3000	1500	23	D28-02010-006
4000	2000	23	D28-02010-007

Other sizes available on request.

Clamping floor plate XL

- Two-dimensional grid system for large, complex components
- Various grid types are optionally possible
- Includes screw set, dowels and shims
- 100 x 100 mm grid, D28 system bores
- Bearing load approx. 7.5 t per m²
- Permissible tensile load in crack-free concrete approx. 1.8 t per dowel
- You can find further details on page 110



Clamping floor plate XL — **D28**



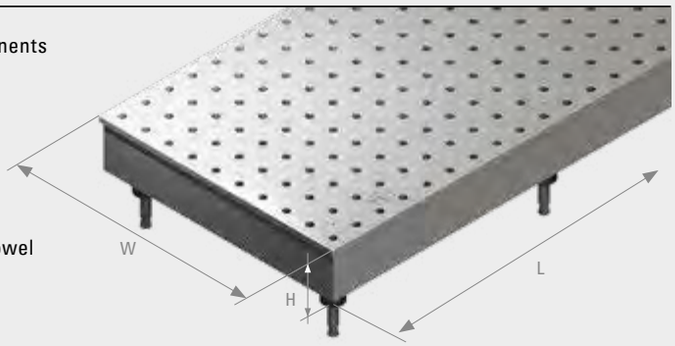
L in mm	W in mm	H in mm approx.	Item no.
1000	1000	37	D28-02011-000
1200	1200	37	D28-02011-001
1500	1000	37	D28-02011-002
1500	1500	37	D28-02011-003
2000	1000	37	D28-02011-004
2400	1200	37	D28-02011-005
3000	1500	37	D28-02011-006
4000	2000	37	D28-02011-007

Other sizes available on request.

Debaenst Lastechniek

Clamping floor plate ProfiLINE

- Two-dimensional grid system for extremely large, complex components
- Various grid types are optionally possible
- Can be extended as required
- Includes screw set, dowels and washers
- Fine-pitch thread adjusts legs for precise levelling
- Bearing load approx. 15 tonnes per m²
- 100 x 100 mm grid, D28 system bores
- Permissible tensile load in crack-free concrete approx. 1.8 t per dowel
- You can find further details on page 110



Clamping floor plate ProfiLINE



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

Other sizes available on request.



Debaenst Lastechniek



Debaenst Lastechniek

DEMMELER® bolts

Overview of clamping bolts 116
Product benefits of PPC bolts 118

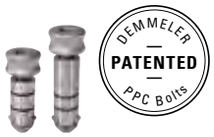
D28		D22	D16
 **PPC bolt** page 120	 **EcoLINE bolt** page 124	 **PPC bolt** page 120	 **PC bolt** page 122
 **PPC countersunk bolt** page 121	 **Stop and positioning bolt** page 126	 **PPC countersunk bolt** page 121	 **PC countersunk bolt** page 123
 **PC bolt** page 122	 **Connecting bushes** from page 127	 **EcoLINE bolt** page 125	 **EcoLINE bolt** page 124
 **PC countersunk bolt** page 123	 **Adapter** page 129	 **Stop and positioning bolt** page 126	 **Stop and positioning bolt** page 126
 **FCP bolt with handle** page 124	 **Interface plates** page 129	 **Connecting bushes with bolt** page 127	 **Connecting bushes** from page 127
		 **Adapter** page 129	 **Adapter** page 129
		 **Interface plates** page 129	 **Interface plates** page 129

Our clamping bolts for all of your applications

PPC countersunk bolt
Space-saving connecting element

ECO bolt
Basic version without clamping area

PPC bolt
Clamping protects the materials thanks to patented cone clamping system









	PPC bolt	PPC countersunk bolt	PC bolt	PC countersunk bolt
System sizes	D28 D22	D28 D22	D28 D16	D28 D16
Version	Short/long	Short/long	Short/long	Short/long
Use	**Reliable fixing** of workpieces with system components or on the welding table in a way that reduces material wear	**Space-saving connecting element that reduces material wear** for all system components on tables, perforated plates, etc.	**Reliable fixing** of workpieces with system components or on the welding table in a way that reduces material wear	**Space-saving connecting element** for all system components on tables, perforated plates, etc.

Short version = connecting two system components together or one system component on the welding table
Long version = connecting three system components together or two system components on the welding table

Debaenst Lastechniek



PC bolt
Even clamping
using five clamping balls

Clamping principles



PPC bolt
- Even force distribution across the polygonal bolts **reduces bore wear**
- Highest clamping force with large clamping stroke



PC bolt
- Clamping ball are in point contact with the bevel
- Highest clamping force with large clamping stroke



EcoLINE bolt
- Clamping ball are in point contact with the bevel
- Without clamping area

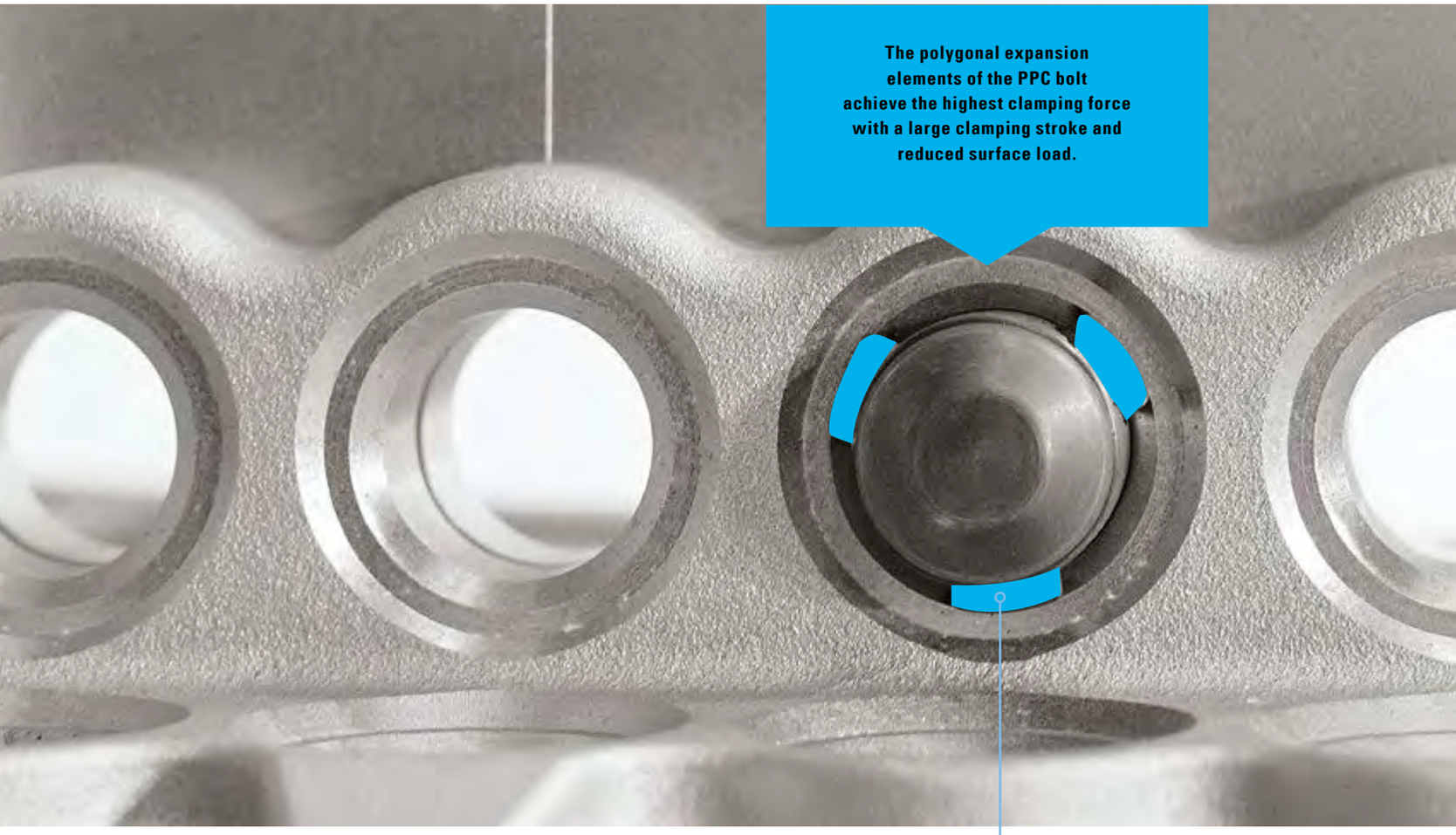








	EcoLINE bolt	Stop and positioning bolt	Connecting bushes with bolt	Connecting bush with collar
System sizes	D28 D22 D16	D28 D22 D16	D28 D22 D16	D28 D16
Version	Short/long	Short/long	Short/long	Short
Use	**Connecting element for all system components**	**For setting out the system components**, to fix them in position and as an adapter for D16 screw clamps	**Use as a long-term connection** for joining all system components or welding tables	**Long-term connection for joining** two system components (suitable for system bore/oblong hole)



The perfect connection

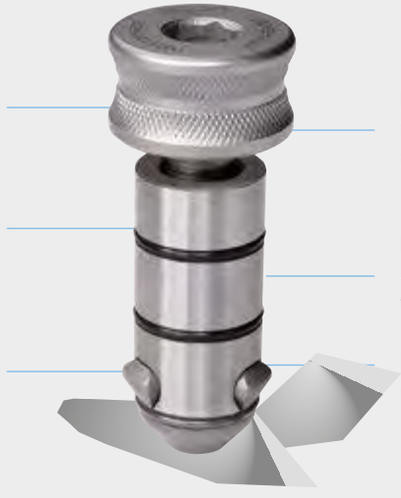
Self-centring, form-fitting and low-wear clamping – it's possible with the original DEMMELER® PPC clamping bolt

DEMMELER — PATENTED — PPC Bolts № 2569548

Very quick clamping and releasing of the clamping elements

Form-fitting thanks to full-area contact with the opposite locating surface

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

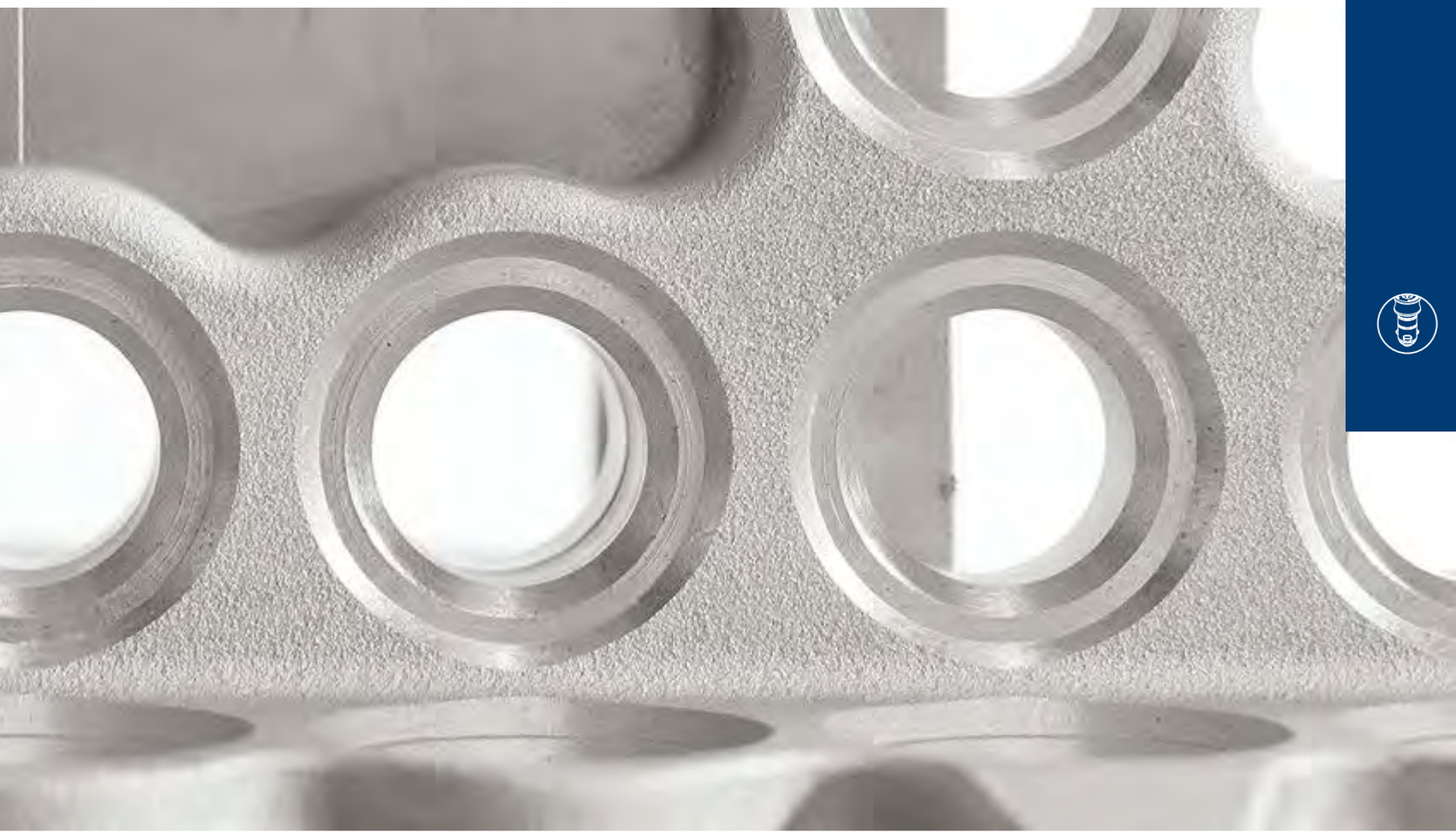


Minimal susceptibility to dirt because delicate parts such as clamp threads, etc. are fully encapsulated by O-rings

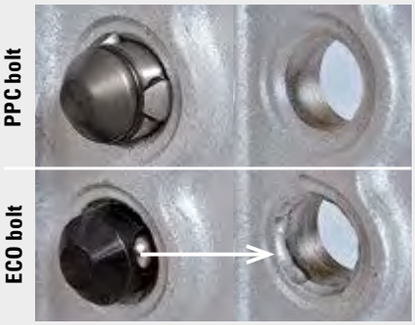
Extremely robust Made from high-quality hardened steel, maximum precision thanks to ground design

Long service life guaranteed in everyday applications

Debaenst Lastechniek



The cone clamping system of the DEMMELER PPC bolts makes the support surface 100 times larger. This results in much higher contact pressure, therefore securing workpieces more reliably. The even force distribution also reduces bore hole wear compared to conventional bolts.



Comparison of a spherical clamping bolt and the polygonal bolt from DEMMELER
Using the PPC bolt prevents serious damage to the bores that can be caused by spherical clamping bolts, for example with aluminium titanium blocks.



Debaenst Lastechniek

PPC bolt

- Highest clamping force with large clamping stroke. Polygonal expansion elements are full-faced, force-fitting and accurately self-centring, thereby reducing the surface load
- Self-locking, reduces material wear
- Straightforward, fast and safe handling
- Minimal susceptibility to dirt
- DEMMELER system lock for DEMMELER electric screwdriver for inserting and tightening as well as loosening and pulling
- With marking grooves for DEMMELER electric screwdrivers
- High-quality hardened steel, maximum precision thanks to ground design
- O-ring prevents simultaneous rotation while tightening and cleans the system bore at the same time



PPC bolt, short		D28	D22
	**The short version connects**	2 system components together or 1 system component on the welding table	
	Clamping area limits	41-47	31-34
	Ø A in mm	28-0,02	22-0,02
	B in mm	24	19
	Approx. weight in kg	0,5	0,3
	Tensile force	Max. 25 kN	Max. 18 kN
	Shear force	Max. 200 kN	Max. 100 kN
	Tightening torque	70 Nm	25 Nm
	Item no.	D28-06025-000	D22-06025-000



PPC bolt, long		D28	D22
	**The long version connects**	3 system components together or 2 system components on the welding table	
	Clamping area limits	66-72	49-52
	Ø A in mm	28-0,02	22-0,02
	B in mm	24	19
	Approx. weight in kg	0,6	0,3
	Tensile force	Max. 25 kN	Max. 18 kN
	Shear force	Max. 200 kN	Max. 100 kN
	Tightening torque	70 Nm	25 Nm
	Item no.	D28-06026-000	D22-06026-000



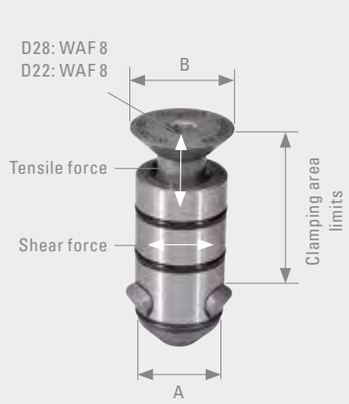
The specified loads must not be exceeded when using the clamping bolts.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

DEMMELER PATENTED PPC Bolts No 2569548

Debaenst Lastechniek

PPC countersunk bolt

- Made especially for DEMMELER electric screwdrivers
- Used for simultaneous clamping of two system components
- Easy, convenient clamping through optimised force distribution in the expansion segments
- Minimal susceptibility to dirt due to polygonal shape
- Standard at DEMMELER for a long service life: High-strength, hardened and ground
- With optimum force distribution, DEMMELER opens up a new dimension of possible applications
- Countersunk bolts may only be used in bores and not in oblong holes



PPC countersunk bolt, short	D28	D22
The short version connects	2 system components together or 1 system component on the welding table	
Clamping area limits	41-47	31-34
Ø A in mm	28-0,02	22
B in mm	32	25
Approx. weight in kg	0,3	0,2
Tensile force	Max. 10 kN	Max. 4 kN
Shear force	Max. 200 kN	Max. 100 kN
Tightening torque	50 Nm	15 Nm
Item no.	D28-06027-000	D22-06027-000



PPC countersunk bolt, long	D28	D22
The long version connects	3 system components together or 2 system components on the welding table	
Clamping area limits	66-72	49-52
Ø A in mm	28-0,02	22
B in mm	32	25
Approx. weight in kg	0,6	0,2
Tensile force	Max. 10 kN	Max. 4 kN
Shear force	Max. 200 kN	Max. 100 kN
Tightening torque	50 Nm	15 Nm
Item no.	D28-06028-000	D22-06028-000



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

DEMMELER PATENTED PPC Bolts № 2569548

PC bolt

- Connecting element for all system components on tables, perforated plates etc. or for special fixtures
- Very fast connection with large clamping stroke
- Very high clamping force due to planetary gear effect and by avoiding a double-start thread
- Force-fitting and form-fitting, O-ring for self-centring connection
- With clamping area
- Highest clamping force with large clamping stroke using a hex key (D28: WAF 14/D16: WAF 8) or torque wrench
- Turning the ergonomically shaped bolt head causes the balls of the patented PC bolt to make point contact with the bevel – turning it further clamps the original DEMMELER PC bolt
- High-quality hardened steel, maximum precision thanks to ground design
- O-rings prevent simultaneous rotation while tightening and clean the system bore at the same time



PC bolt, short



	D28	D16
The short version connects	2 system components together or 1 system component on the welding table	
Clamping area limits	41-47	22 -24
Ø A in mm	28-0,02	16-0,01
B in mm	20	12
Approx. weight in kg	0,40	0,08
Tensile force	Max. 25 kN	Max. 10 kN
Shear force	Max. 200 kN	Max. 50 kN
Tightening torque	70 Nm	20 Nm
Item no.	D28-06001-000	D16-06001-000



PC bolt, long



	D28	D16
The long version connects	3 system components together or 2 system components on the welding table	
Clamping area limits	63-72	34-36
Ø A in mm	28-0,02	16-0,01
B in mm	20	12
Approx. weight in kg	0,50	0,10
Tensile force	Max. 25 kN	Max. 10 kN
Shear force	Max. 200 kN	Max. 50 kN
Tightening torque	70 Nm	20 Nm
Item no.	D28-06002-000	D16-06002-000

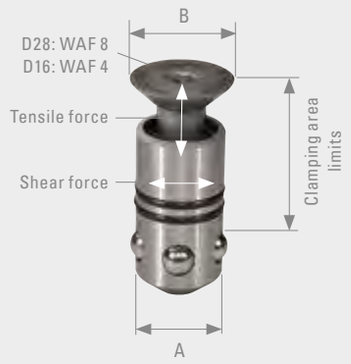


The specified loads must not be exceeded when using the clamping bolts.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

Debaenst Lastechniek

PC countersunk bolt

- Countersunk bolt head (no interfering edges)
- Only for connecting bores (not oblong holes)
- Clamping using a hex key (D28: WAF 8/D16: WAF 4) or torque wrench
- Countersunk bolts may only be used in bores and not in oblong holes



D28
D16

PC countersunk bolt, short	D28	D16
The short version connects	2 system components together or 1 system component on the welding table	
Clamping area limits	41-47	22-24
Ø A in mm	28-0,02	16-0,01
B in mm	31,6	19
Approx. weight in kg	0,25	0,04
Tensile force	Max. 10 kN	Max. 3 kN
Shear force	Max. 200 kN	Max. 50 kN
Tightening torque	50 Nm	10 Nm
Item no.	D28-06004-000	D16-06004-000



PC countersunk bolt, long	D28	D16
The long version connects	3 system components together or 2 system components on the welding table	
Clamping area limits	66-72	34-36
Ø A in mm	28-0,02	16-0,01
B in mm	31,6	19
Approx. weight in kg	0,36	0,06
Tensile force	Max. 10 kN	Max. 3 kN
Shear force	Max. 200 kN	Max. 50 kN
Tightening torque	50 Nm	10 Nm
Item no.	D28-06005-000	D16-06005-000

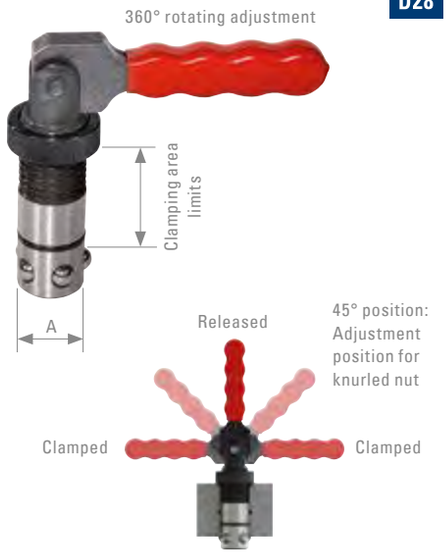


The specified loads must not be exceeded when using the clamping bolts.
The discharge of welding voltages, unfavourable leverage and impacts have to be avoided.

FCP bolt with handle

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

D28



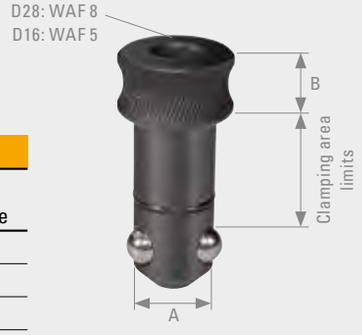
FCP bolt D28 with handle	D28
Clamping area limits	31-50
Ø A in mm	28-0,01
Approx. weight in kg	0,7
Item no.	D28-06007-000



EcoLINE bolt

- Connecting element for system components
- Basic version without clamping area

D28
D16



EcoLINE bolt, short		D28	D16
	The short version connects	2 system components together or 1 system component on the welding table	
	Clamping area limits	41-44	22
	Ø A in mm	28 -0,02	16 -0,01
	B in mm	20	12
	Approx. weight in kg	0,44	0,08
	Item no.	E28-06001-000	E16-06001-000



EcoLINE bolt, long		D16
	The long version connects	3 system components together or 2 system components on the welding table
	Clamping area limits	34
	Ø A in mm	16
	B in mm	12
	Approx. weight in kg	0,1
	Item no.	E16-06002-000



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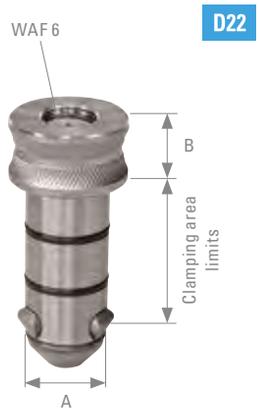
EcoLINE bolt

- Connecting element for system components
- Basic version without extended clamping area



EcoLINE bolt D22, short	D22
The short version connects	2 system components together or 1 system component on the welding table
Clamping area limits	32-33,5
Ø A in mm	22
B in mm	19
Approx. weight in kg	0,25
Tensile force	Max. 18 kN
Shear force	Max. 100 kN
Tightening torque	15 Nm
Item no.	E22-06025-000

EcoLINE bolt D22, long	D22
The long version connects	3 system components together or 2 system components on the welding table
Clamping area limits	50-51,5
Ø A in mm	22
B in mm	19
Approx. weight in kg	0,3
Tensile force	Max. 18 kN
Shear force	Max. 100 kN
Tightening torque	15 Nm
Item no.	E22-06026-000

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

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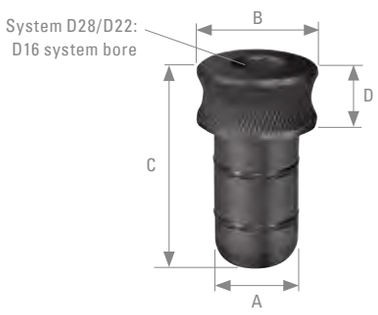
Stop and positioning bolt

- For setting out the system components
- For fixing system components in position, e.g. for blocks and stops, as a cost-effective replacement for a second clamping bolt
- Burnished



D28
D22
D16

Stop and positioning bolt D28	D28
Description	Also suitable as an adapter for D16 screw clamps thanks to D16 system bore in the head
Ø A in mm	28
Ø B in mm	40
C in mm	74
D in mm	23
Approx. weight in kg	0,4
Item no.	D28-06009-000



Stop and positioning bolt D22	D22
Description	Also suitable as an adapter for D16 screw clamps thanks to D16 system bore in the head
Ø A in mm	22
Ø B in mm	31
C in mm	52
D in mm	19
Approx. weight in kg	0,2
Item no.	D22-06009-000

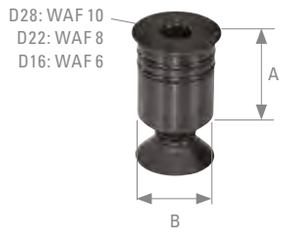


Stop and positioning bolt D16	D16
Ø A in mm	16
Ø B in mm	23
C in mm	37
D in mm	12
Approx. weight in kg	0,09
Item no.	D16-06009-000

Debaenst Lastechniek

Connecting bush with screw

- For use as long-term connection
- With self-centring countersunk head on both sides
- Suitable for system bores
- Clamping using a hex key
- Ideal for connecting welding tables with U-shaped spacer blocks
- Burnished
- Short version: Connects 2 system components together or 1 system component on the welding table
- Long version: Connects 3 system components together or 2 system components on the welding table



D28
D22
D16



Connecting bush D28, short, with screw	D28
A in mm	35,5
Ø B in mm	28
Approx. weight in kg	0,18
Item no.	D28-06003-000

Connecting bush D28, long, with screw	D28
A in mm	60
Ø B in mm	28
Approx. weight in kg	0,26
Item no.	D28-06006-000

Connecting bush D22, short, with screw	D22
A in mm	28,75
Ø B in mm	22
Approx. weight in kg	0,1
Item no.	D22-06003-000

Connecting bush D22, long, with screw	D22
A in mm	48
Ø B in mm	22
Approx. weight in kg	0,2
Item no.	D22-06006-000

Connecting bush D16, short, with screw	D16
A in mm	17
Ø B in mm	16
Approx. weight in kg	0,04
Item no.	D16-06003-000

Connecting bush D16, long, with screw	D16
A in mm	25
Ø B in mm	16
Approx. weight in kg	0,05
Item no.	D16-06006-000

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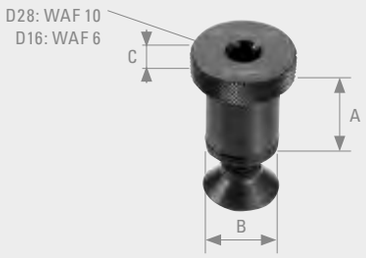
Connecting bush with collar

- For use as long-term connection
- For connecting two system components
- Suitable for system bore/oblong hole
- Clamping using a hex key (D28: WAF 10 and D16: WAF 6)



D28
D16

Connecting bush D28, short, with collar — D28



A in mm	Ø B in mm	C in mm	Approx. weight in kg	Item no.
35	28	10	0,26	D28-06003-003

Connecting bush D16, short, with collar — D16



A in mm	Ø B in mm	C in mm	Approx. weight in kg	Item no.
22	16	5	0,05	D16-06003-002



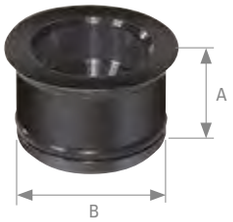
It doesn't get more modular than this.

Compatibility for tools from D28 | D22 | D16

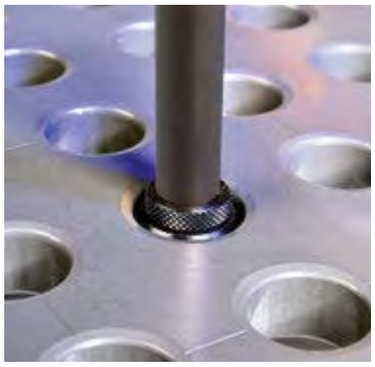
DEMMELER SYSTEM Compatibility

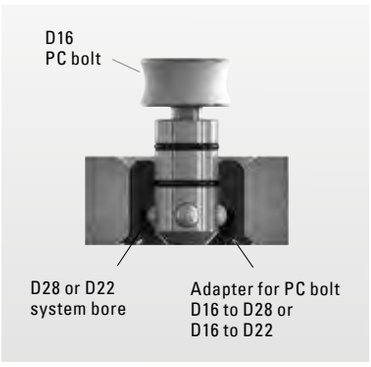
Adapter for PC bolt D16 to D28/D16 to D22

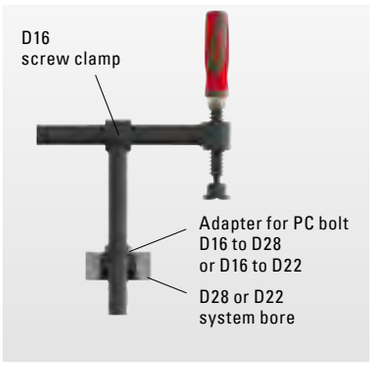
- Interface between system D28 and D16 or D22 and D16
- Fully compatible with system D28 and system D16 or D22 and D16
- Force-fitting and form-fitting thanks to O-ring, self-centring connection
- O-ring prevents simultaneous rotation while tightening
- O-ring cleans the system bore



D28
D22
D16







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Adapter for PC bolt D16 to D28 — D16 | D28



A in mm	B in mm	Approx. weight in kg	Item no.
20,5	28-0,02	0,05	D00-06010-002

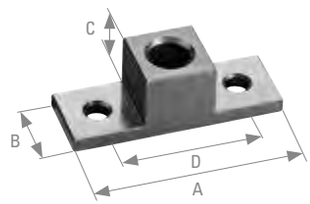
Adapter for PC bolt D16 to D22 — D16 | D22



A in mm	B in mm	Approx. weight in kg	Item no.
23	22	0,04	D00-06012-009

Interface plate

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



D28
D22
D16

Interface plate for clamping tubes D28 to D16 — D28 | D16



A in mm	B in mm	C in mm	D in mm	Approx. weight in kg	Item no.
150	50	50	100	1,04	D00-06015-000

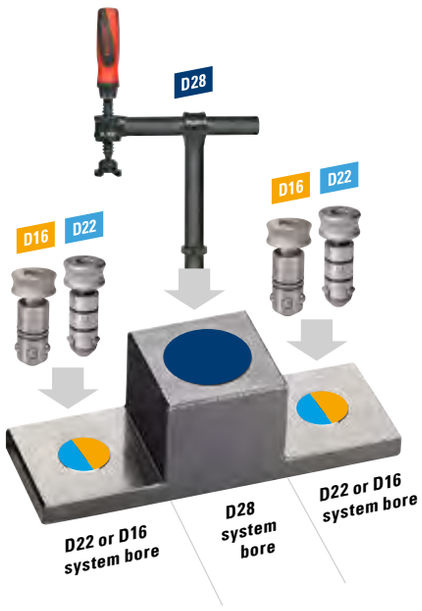
Interface plate for clamping tubes D28 to D22 — D28 | D22

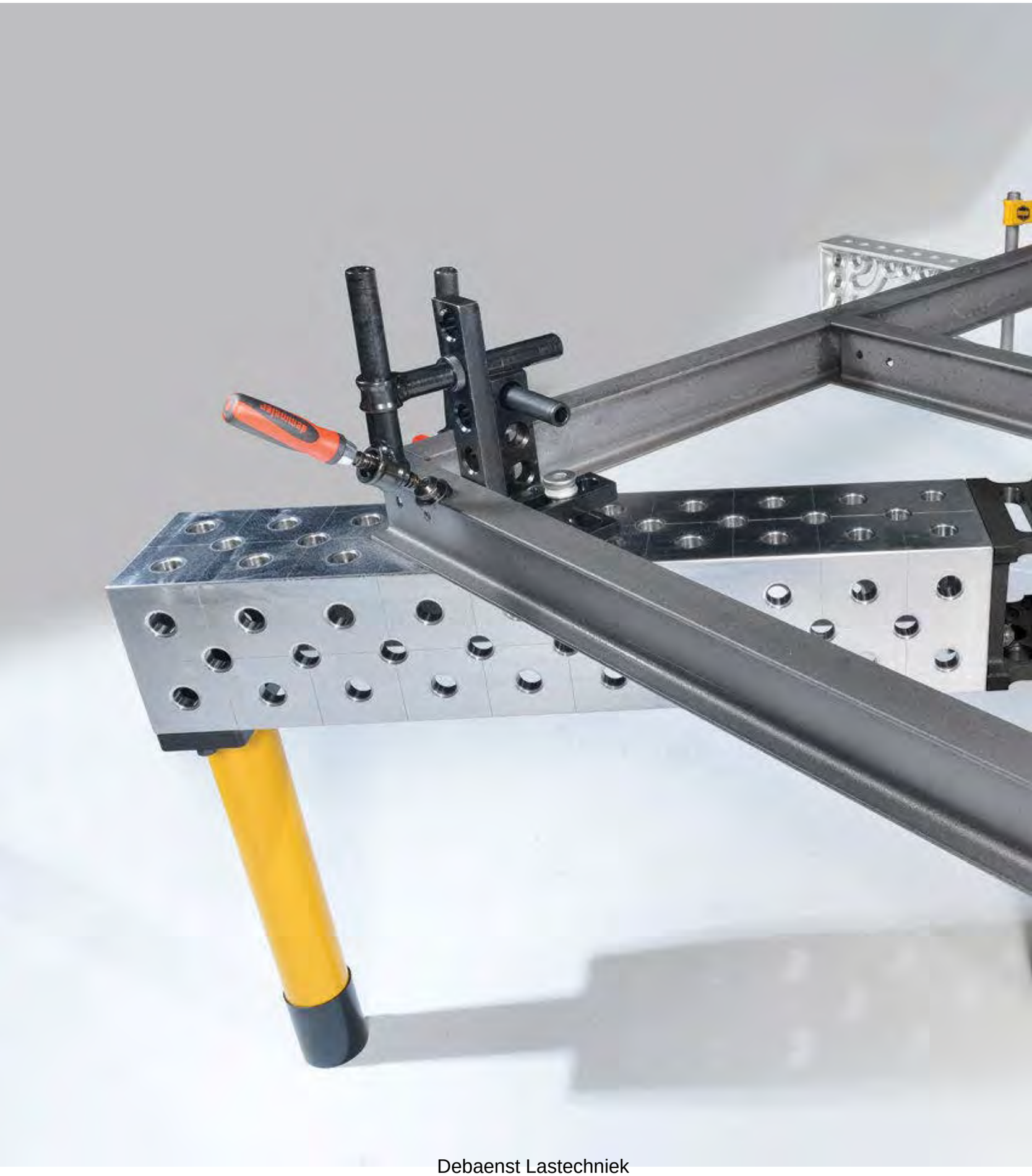


A in mm	B in mm	C in mm	D in mm	Approx. weight in kg	Item no.
150	50	50	100	1,2	D00-06015-001



Use clamps and V-blocks from system D28 in systems D22 and D16 too
The interface plate makes it possible for you to use clamps and V-blocks from system D28 in systems D22 and D16 too.





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DEMMELER® spacer blocks

Product benefits of the U-shaped spacer block 132

D28	D22	D16
 **U-shaped spacer block** from page 134	 **U-shaped spacer block** from page 136	 **U-shaped spacer block** page 138
 **Base plate for U-shaped spacer block** page 139	 **Base plate for U-shaped spacer block** page 139	 **Base plate for U-shaped spacer block** page 139
 **Sliding block** page 140		 **Support and clamping frame** page 142
 **L-shaped spacer block** page 140		 **Corner module** page 145
 **C-shaped spacer block** page 141		 **Clamping block** page 146
 **Support and clamping frame** from page 142		
 **Corner modules** from page 145		
 **Clamping rail** page 147		

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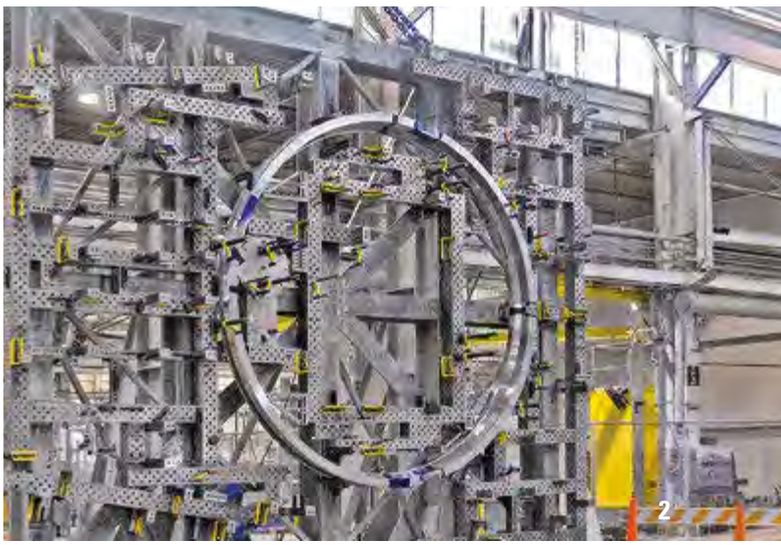
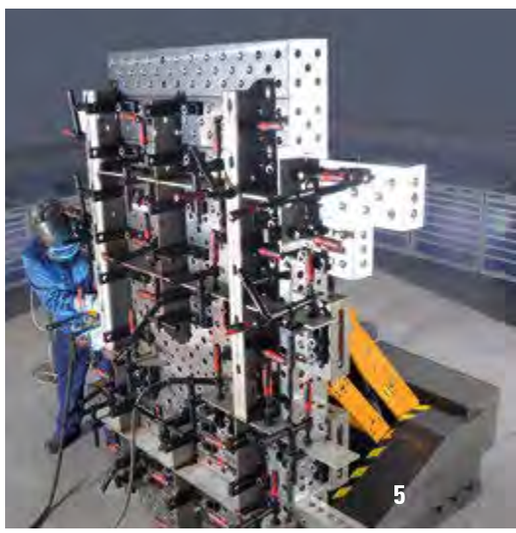
U-shaped spacer blocks grow to meet your requirements


1


2


3


4


5

1 Modular use on the rail system
2 Use for constructing fixtures
3 Setting up a frame
4 Modular fixtures
5 Use on manipulators

Debaenst Lastechniek

D28 D22 D16

You can make your production process more flexible with the U-shaped spacer blocks

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

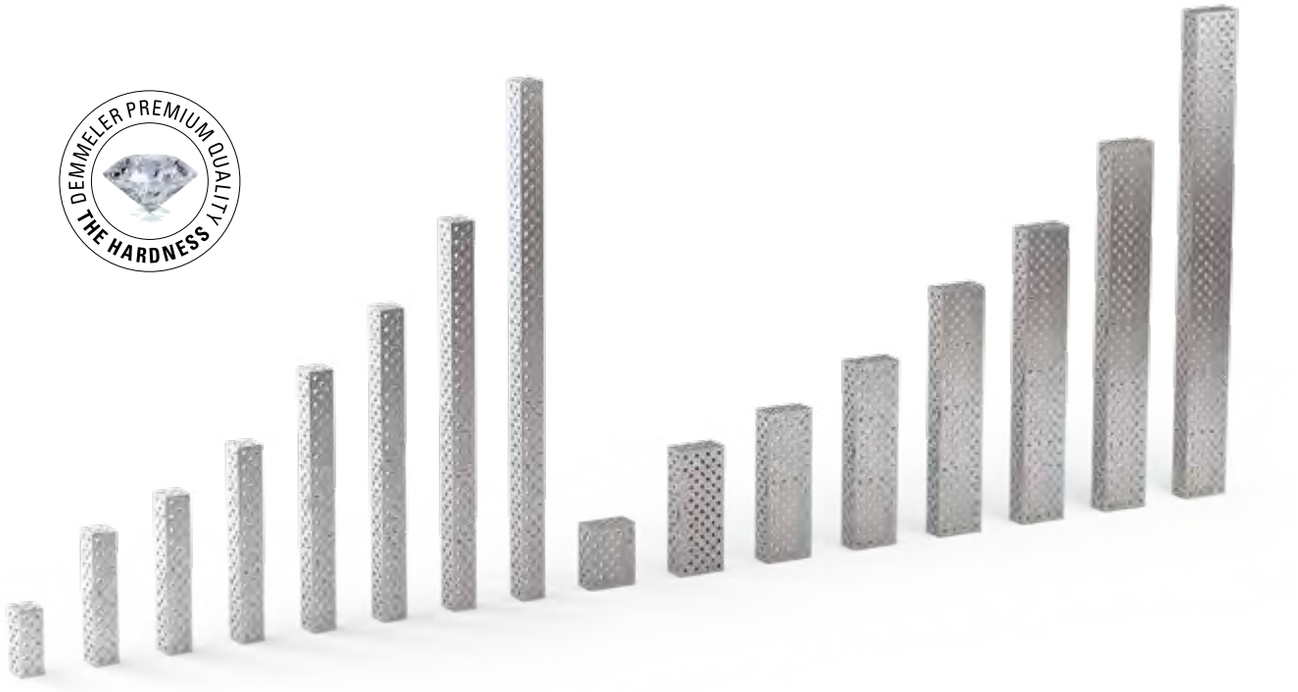




Table legs for the table extension
from a length of 1 m, mounting option



Table legs for use on the rail system
(for system D28 only)

- Available in different lengths and versions, depending on the system size
- Clamping surface: Five-sided
- With grid lines
- For use as a table extension
- From a length of 1 m, option to mount an additional support leg in conjunction with base plate
- Spacer blocks with hardened surfaces are protected against weld spatter adhesion, thus reducing wear

Additional options for system D28:

- Optimum use on rail system (page 98) in conjunction with D00-10017-xxx (page 104). Or to build a frame using D28-06003-000 connecting bushes
- Bore spacing for fitted shoulder screws, bottom, matched to base rail width 1000, 2000, 3000 and 4000 mm

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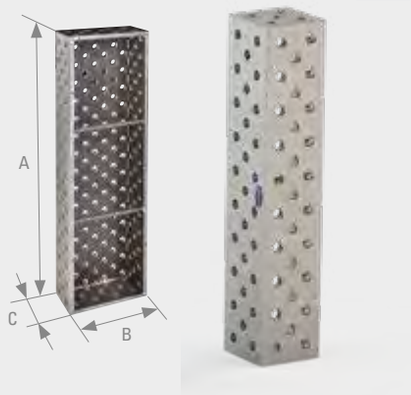
U-shaped spacer block D28, diagonal grid

D28

- For use as a table extension
- Clamping surface: Five-sided
- 100 x 100 mm diagonal grid, with grid lines
- Spacer blocks with hardened surfaces are protected against weld spatter adhesion, thus reducing wear

Additional options for system D28:

- Optimum use on rail system (page 98) in conjunction with D00-10017-xxx (page 104). Or to build a frame using D28-06003-000 connecting bushes
- For use as a table extension
- From a length of 1 m, option to mount an additional PL28-10010-xxx support leg in conjunction with 00060364 or 00060369 base plate
- Bore spacing for fitted shoulder screws, bottom, matched to base rail width 1000, 2000, 3000 and 4000 mm



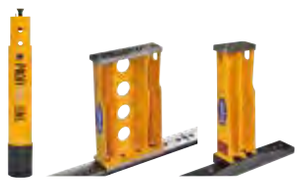
U-shaped spacer block D28, diagonal grid on face sides, steel/hardened steel					D28	
					Steel	Hardened DEMONT 760 M
	A in mm	B in mm	C in mm	Approx. weight in kg	Item no.	Item no.
 Open side	500	200	200	55	D28-04002-000	D28-04002-500
	1000	200	200	102	D28-04002-001	D28-04002-501
	1200	200	200	120	D28-04002-018	D28-04002-518
	1500	200	200	150	D28-04002-002	D28-04002-502
	2000	200	200	200	D28-04002-003	D28-04002-503
	2400	200	200	235	D28-04002-032	D28-04002-532
	3000	200	200	285	D28-04002-004	D28-04002-504
	4000	200	200	374	D28-04002-005	D28-04002-505
 Open side	500	400	200	81	D28-04002-211	D28-04002-511
	1000	400	200	149	D28-04002-222	D28-04002-522
	1200	400	200	174	D28-04002-223	D28-04002-523
	1500	400	200	215	D28-04002-224	D28-04002-524
	2000	400	200	272	D28-04002-225	D28-04002-525
	2400	400	200	320	D28-04002-226	D28-04002-526
	3000	400	200	400	D28-04002-227	D28-04002-527
	4000	400	200	526	D28-04002-228	D28-04002-528

Other dimensions available on request.

Compatible system accessories

D28

Table legs
See page 45 or page 104



D28

Base plate for U-shaped spacer block D28
See page 139





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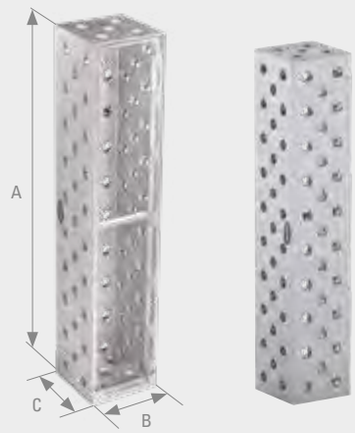
U-shaped spacer block D28, diagonal grid, aluminium titanium

Alu-Titan

D28

- For use as a table extension
- **Up to two-thirds lighter than steel but still stable**
- Also suitable for use in robot cells
- 100 x 100 mm diagonal grid, with grid lines
- Clamping surface: Five-sided



Additional options for system D28:

- Optimum use on rail system (page 98) in conjunction with D00-10017-xxx (page 104). Or to build a frame using D28-06003-000 connecting bushes
- From a length of 1 m, option to mount an additional PL28-10010-xxx support leg in conjunction with 00060364 base plate
- Bore spacing for fitted shoulder screws, bottom, matched to base rail width 1000 mm (with length of 1000 mm)
- Fitted bores with M12 thread to attach the table legs for the PL28-10017-xxx*1 spacer block/sliding leg or the 00060364 base plate with fitted shoulder screws (*1 see page 104)

U-shaped spacer block D28, face sides, diagonal grid, aluminium titanium

D28



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
500	200	200	20	D28-04002-270
1000	200	200	35	D28-04002-271

Other dimensions available on request.

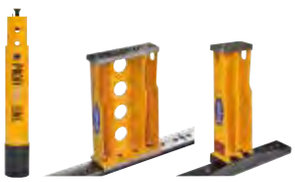




Compatible system accessories

D28

Table legs
See page 45
or page 104



D28

Base plate for U-shaped spacer block D28
See page 139





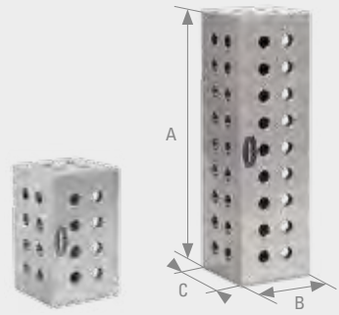


U-shaped spacer blocks are also suitable for use in automation solutions.

U-shaped spacer block D22, steel

- Hardened surface for reduced wear and protection against weld spatter adhesion
- For use as a table extension
- Clamping surface: Five-sided
- Grid lines
- 50 x 50 mm grid

D22



U-shaped spacer block D22, face sides, 50 x 50 mm grid, steel/hardened steel



				D22	
				Steel	Hardened DEMONT 760 M
A in mm	B in mm	C in mm	Approx. weight in kg	Item no.	Item no.
250	150	150	17	D22-04002-000	D22-04002-019
500	150	150	30	D22-04002-001	D22-04002-020
1000	150	150	55	D22-04002-002	D22-04002-021

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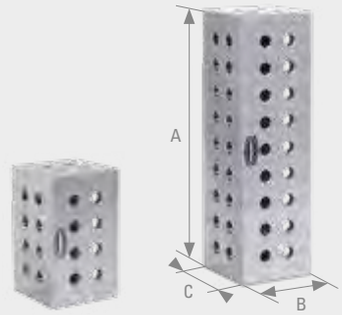
Alu-Titan

U-shaped spacer block D22, aluminium titanium

- **Up to two-thirds lighter than steel but still stable**
- Also suitable for use in robot cells
- Clamping surface: Five-sided
- Grid lines
- 50 x 50 mm grid

D22



U-shaped spacer block D22, face sides, 50 x 50 mm grid, aluminium titanium

D22



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
250	150	150	6,5	D22-04002-016
500	150	150	11,5	D22-04002-017
1000	150	150	20,5	D22-04002-018

Compatible system accessories

D22

Table legs
See page 45



D22

Base plate for U-shaped spacer block D22
See page 139



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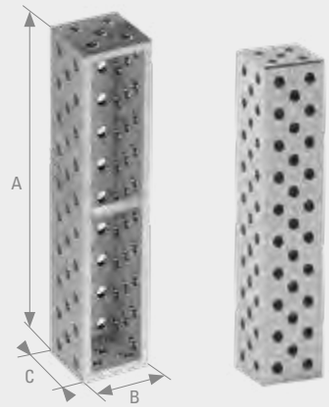
U-shaped spacer block D16, diagonal grid, steel

- For use as a table extension
- Use: Five-sided
- With grid lines
- Spacer blocks with hardened surfaces are protected against weld spatter adhesion, thus reducing wear
- 50 x 50 mm diagonal grid



D16

U-shaped spacer block D16
Face sides, 50 x 50 mm diagonal grid, steel/hardened steel



				D16	
				Steel	Hardened DEMONT 760 M
A in mm	B in mm	C in mm	Approx. weight in kg	Item no.	Item no.
500	100	100	13	D16-04002-000	D16-04002-300
1000	100	100	25	D16-04002-001	D16-04002-301
1500	100	100	37	D16-04002-002	D16-04002-302
2000	100	100	50	D16-04002-003	D16-04002-303

Other dimensions available on request.

U-shaped spacer block D16, steel

- For use as a table extension
- Use: Five-sided
- With grid lines
- Spacer blocks with hardened surfaces are protected against weld spatter adhesion, thus reducing wear
- 50 x 50 mm grid



D16

U-shaped spacer block D16,
face sides, 50 x 50 mm grid, steel/hardened steel



				D16	
				Steel	Hardened DEMONT 760 M
A in mm	B in mm	C in mm	Approx. weight in kg	Item no.	Item no.
500	100	150	20	D16-04003-026	D16-04003-326
1000	100	150	37	D16-04003-070	D16-04003-304
1500	100	150	55	D16-04003-071	D16-04003-323
2000	100	150	72	D16-04003-065	D16-04003-365

Other dimensions available on request.

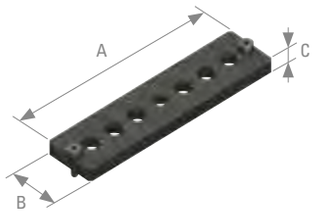
Debaenst Lastechniek

Give your spacer blocks a leg up.

Base plate D28 for U-shaped spacer blocks

- Base plate for U-shaped spacer block D28-04002-xxx
- For mounting the PL28-10010-xxx support leg from a length of 1 m
- Including 2x fitted shoulder screws M12–16 H8 x 30
- 2x fitted bores for fitted shoulder screws
- Bore for PL28-10010-xxx support leg (page 45).
  Other bores are D28 system bores

D28



Base plate D28 for U-shaped spacer blocks — D28



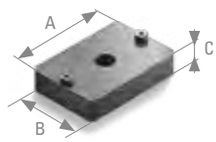
A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
200	100	25	3,6	00060364
400	100	25	7	00060369



Base plate D22 for U-shaped spacer blocks

- Base plate for U-shaped spacer block D22-04002-xxx
- For mounting the PL22-10010-xxx leg/table leg from a length of 1 m
- Including 2x fitted shoulder screws M8–10 H8 x 30
- 2x fitted bores for fitted shoulder screws
- Bore for PL22-10010-xxx support leg (page 45)

D22



Base plate D22 for U-shaped spacer blocks — D22



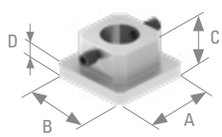
A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
150	100	25	2,8	00108898



Base plate D16 for U-shaped spacer blocks

- Base plate for D16-04002-xxx and D16-04003-xxx U-shaped spacer blocks
- For mounting the PL16-10010-xxx support leg
- Including 2x mounting bolts

D16



Base plate D16 for U-shaped spacer blocks — D16



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
95	95	50	0,7	00097469



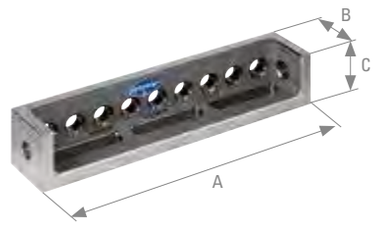
Debaenst Lastechniek

These spacer blocks are suitable for flexible use, can function as a table extension and table connection, and are also suitable for vertical structures.

Sliding block D28, steel

- Used as a bridge between locating and clamping angles or 3D welding tables
- Can be used on four sides as a stop strip or table extension
- For use with confined installation space
- Numerous possible applications thanks to system bores and oblong holes
- With grid lines

D28



Sliding block D28, steel — D28



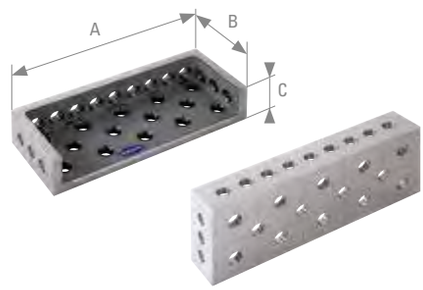
A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
500	100	100	15	D28-04004-000

Other dimensions available on request.

L-shaped spacer block D28, steel

- Table extension/table connection for several 3D welding tables
- Third axis for extension as clamping tower or laterally as precise table stop
- Connection of system components
- Use: Four-sided
- With grid lines

D28



L-shaped spacer block D28, steel — D28



A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
500	200	100	26	100 x 100 diagonal grid	D28-04001-000
1000	200	100	52	100 x 100 diagonal grid	D28-04001-001

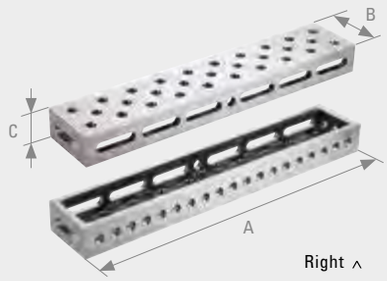
Other dimensions available on request.

Debaenst Lastechniek

C-shaped spacer block D28, steel

- Table extension between two 3D welding tables using D28-06003-000 connecting bushes
- Permanent screw connection
- Connection of system components
- As a table stop
- Continuously adjustable thanks to oblong holes
- Use: Five-sided
- With grid lines

D28



Right ∧



Left ∧

C-shaped spacer block D28, steel, right — **D28**



A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
500	200	100	31	100 x 100 diagonal grid, right	D28-04003-010
1000	200	100	58	100 x 100 diagonal grid, right	D28-04003-011

C-shaped spacer block D28, steel, left — **D28**



A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
500	200	100	31	100 x 100 diagonal grid, left	D28-04003-002
1000	200	100	58	100 x 100 diagonal grid, left	D28-04003-003

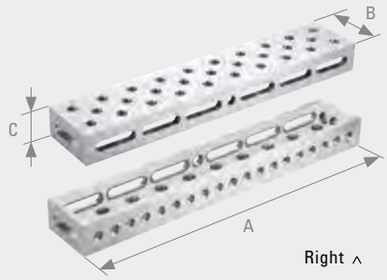
Other dimensions available on request.

C-shaped spacer block D28, aluminium titanium

Alu-Titan

- High-strength aluminium titanium alloy for approx. 60% weight reduction
- Approx. 10% higher bending strength compared to cast iron
- Table extension between two 3D welding tables using D28-06003-000 connecting bushes with permanent screw connection
- Connection of system components
- As a table stop
- Continuously adjustable thanks to oblong holes
- Use: Five-sided
- With grid lines

D28



Right ∧



Left ∧

C-shaped spacer block D28, aluminium titanium, right — **D28**



A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
500	200	100	11	100 x 100 diagonal grid, right	D28-04003-025
1000	200	100	19	100 x 100 diagonal grid, right	D28-04003-027

C-shaped spacer block D28, aluminium titanium, left — **D28**

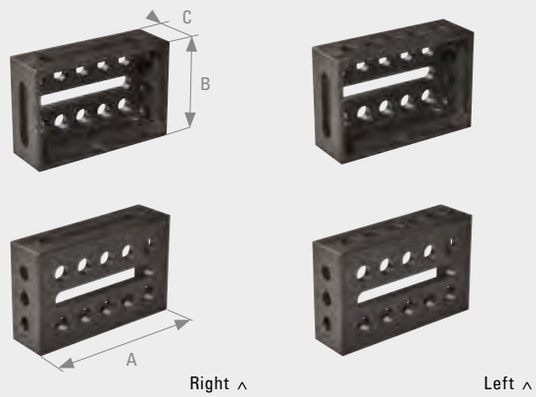


A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
500	200	100	11	100 x 100 diagonal grid, left	D28-04003-024
1000	200	100	19	100 x 100 diagonal grid, left	D28-04003-026

Debaenst Lastechniek

Support and clamping frame

- Five full clamping faces with system bores result in numerous possible applications
- As connecting elements between different system components
- Suitable for very versatile combinations:
  >> Using system bore
  >> Variable movement using oblong holes
- Made from one piece for excellent stability and durability
- Use as bracket or extension
- D28: hardened cast, D16: burnished cast
- With grid lines



D28
D16

Support and clamping frame, right	D28	D16
A in mm	300	150
B in mm	200	100
C in mm	100	50
Approx. weight in kg	16	2,1
Description	Right	Right
Item no.	D28-03005-001	D16-03005-001

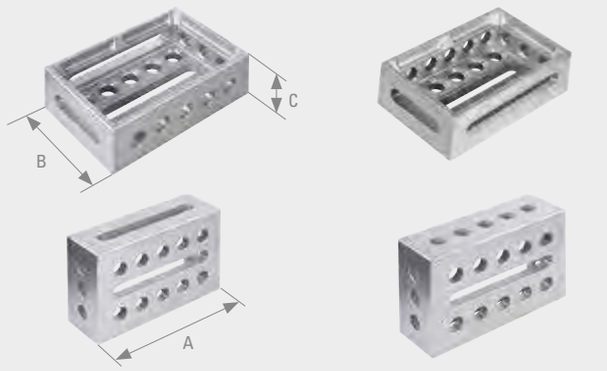


Support and clamping frame, left	D28	D16
A in mm	300	150
B in mm	200	100
C in mm	100	50
Approx. weight in kg	16	2,1
Description	Left	Left
Item no.	D28-03005-004	D16-03005-004

Debaenst Lastechniek

Support and clamping frame, aluminium titanium

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



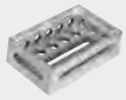
Right ^ Left ^

Support and clamping frame, aluminium titanium, right



	D28	D16
A in mm	300	150
B in mm	200	100
C in mm	100	50
Approx. weight in kg	5,80	0,78
Description	Right	Right
Item no.	D28-03005-011	D16-03005-010

Support and clamping frame, aluminium titanium, left



	D28	D16
A in mm	300	150
B in mm	200	100
C in mm	100	50
Approx. weight in kg	5,80	0,78
Description	Left	Left
Item no.	D28-03005-012	D16-03005-012

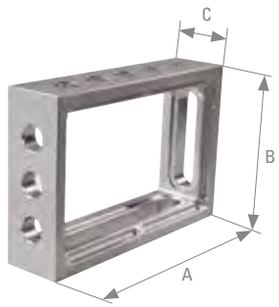
Debaenst Lastechniek

Support and clamping frame D28, aluminium titanium

Alu-Titan

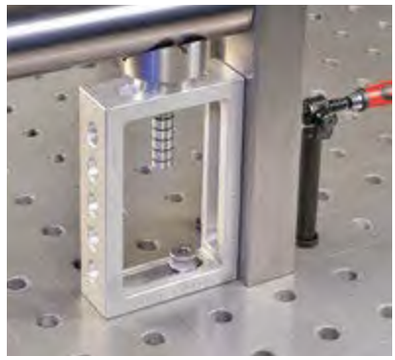
- Support and clamping frame made from high-strength aluminium titanium alloy
- Can be used on four sides, machined on six sides
- With oblong hole in X-Y and grid bore in X-Y direction
- Extremely variable
- The precision scaling in the X and Y directions meets all needs

D28



Support and clamping frame D28, aluminium titanium	D28
A in mm	300
B in mm	200
C in mm	75
Approx. weight in kg	3,1
Description	Right
Item no.	D28-03005-014

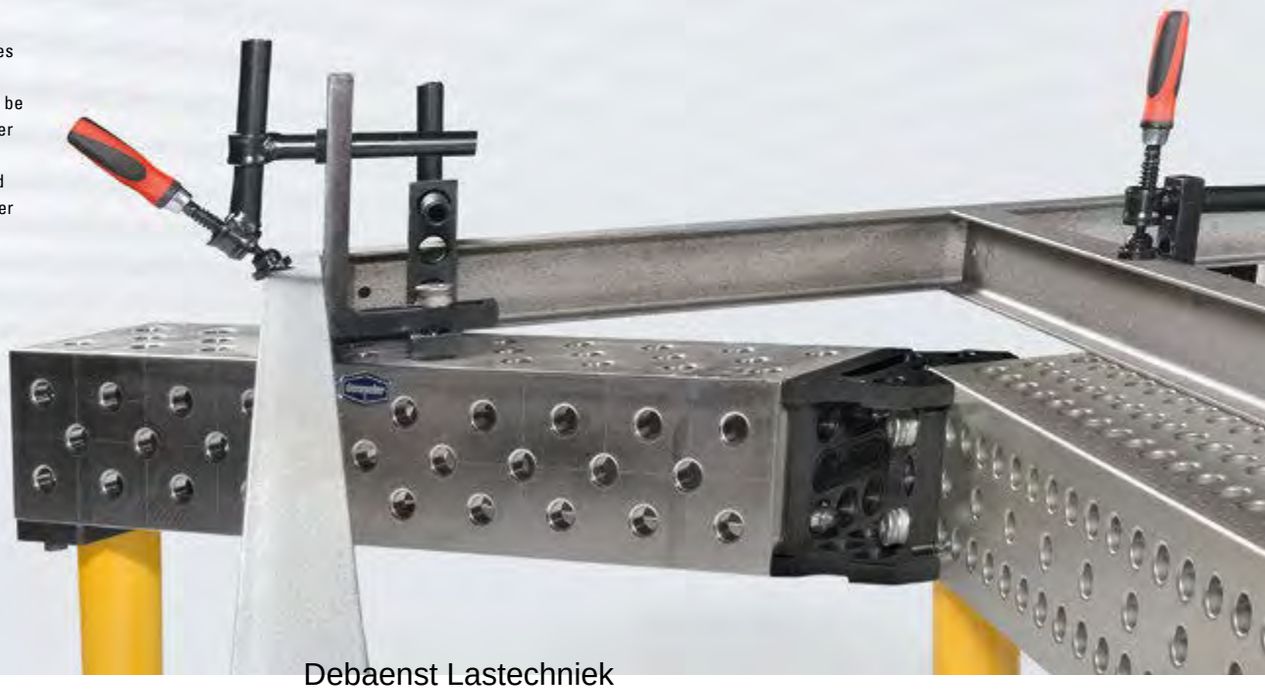




Diagonally extending welding tables

If the workpiece being machined is longer and wider, simply extend your clamping surface with the corner modules, together with the U-shaped spacer blocks or locating angles.

With the corner modules from DEMMELER, long profiles and beams can be clamped even on smaller welding tables. Install the corner modules and extend them with spacer blocks or locating and clamping angles.



Debaenst Lastechniek

Corner module

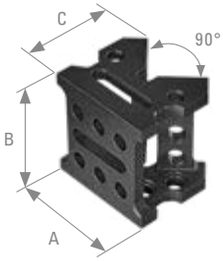
DEMONT 760 M
BLACK EDITION

- Diagonal table extension
- Can be used flexibly as a V-block, support, stop and much more
- D28: hardened cast, D16: burnished cast

D28
D16







Right ∧



Left ∧

Corner module, right	D28	D16
A in mm	200	100
B in mm	200	100
C in mm	170	85
Approx. weight in kg	13	1,9
Description	Right	Right
Item no.	D28-04005-000	D16-04005-000

Corner module, left	D28	D16
A in mm	200	100
B in mm	200	100
C in mm	170	85
Approx. weight in kg	13	1,9
Description	Left	Left
Item no.	D28-04005-003	D16-04005-003



Corner module D28, aluminium titanium

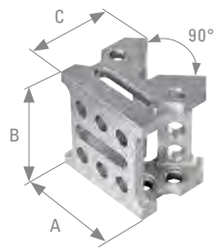
Alu-Titan

- High-strength aluminium titanium alloy for approx. 60% weight reduction and approx. 10% higher bending strength compared to cast iron
- Diagonal table extension
- Can be used flexibly as a V-block, support, stop and much more

D28







Right ^



Left ^

Corner module D28, aluminium titanium, right — D28



A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
200	200	170	4,9	Right	D28-04005-004

Corner module D28, aluminium titanium, left — D28

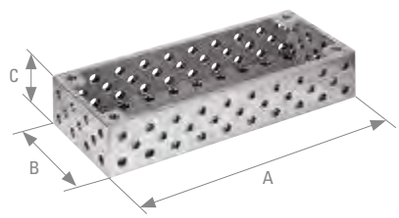


A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
200	200	170	4,9	Left	D28-04005-005

Clamping block D16

- Use: Five-sided
- Third axis for extension as clamping tower or laterally as precise table stop
- Connection of system components
- With grid lines

D16





Clamping block D16 L200 — D16



A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
500	200	100	19	50 x 50 grid	D16-04010-000

Clamping block D16 L500 — D16



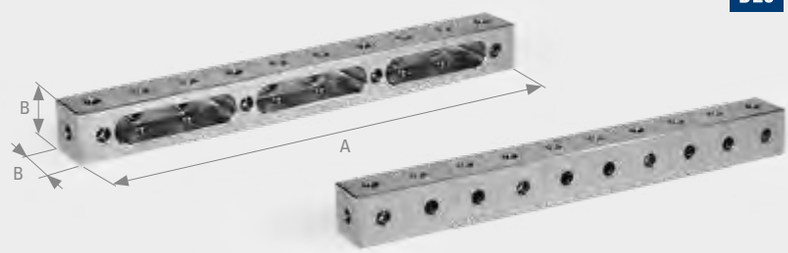
A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
500	500	100	39	50 x 50 grid	D16-04011-000

Debaenst Lastechniek

Clamping rail D28

- Six clamping faces
- Three rows of system bores, 100 x 100 mm grid
- With grid lines

D28



Clamping rail D28 L1000 — D28



A in mm	B in mm	Approx. weight in kg	Description	Item no.
1000	100	49	100 x 100 grid	D28-04010-001

Clamping rail D28 L2000 — D28



A in mm	B in mm	Approx. weight in kg	Description	Item no.
2000	100	97	100 x 100 grid	D28-04010-002

Clamping rail D28 L3000 — D28



A in mm	B in mm	Approx. weight in kg	Description	Item no.
1000	100	145	100 x 100 grid	D28-04010-003



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DEMMELER®
locating and clamping angles

Product benefits of the PROFIPremiumLINE angle series 150

Product benefits of the universal stop 166

D28



PROFIPremiumLINE locating and clamping angles, aluminium titanium
from page 152



Locating and clamping angles small
page 160



Mounting angles
page 165



Universal stop L300/L500
page 172



PROFIPremiumLINE locating and clamping angles, hardened cast
page 154



Locating and clamping angles
from page 161



Flat angle trim
page 165



Stop strip
page 173



PROFIPlusLINE locating and clamping angles, hardened cast
page 155



Locating and clamping angles large
page 162



Universal stop small
page 167



Contour stop
page 174



PROFIEcoLINE locating and clamping angles, hardened cast
page 157



Locating and clamping angles with face plate
page 163



Displacement stop
page 168



Angle-setting template
page 174



PROFIPremiumLINE locating and clamping angle 2000
page 158



Locating and clamping angles, aluminium titanium
page 164



PROFIEcoLINE Universal stop large
page 168



Adapter plate
page 175



Universal pivot and tilt angle
page 159



Angle bracket
page 164



Universal stop large
from page 170

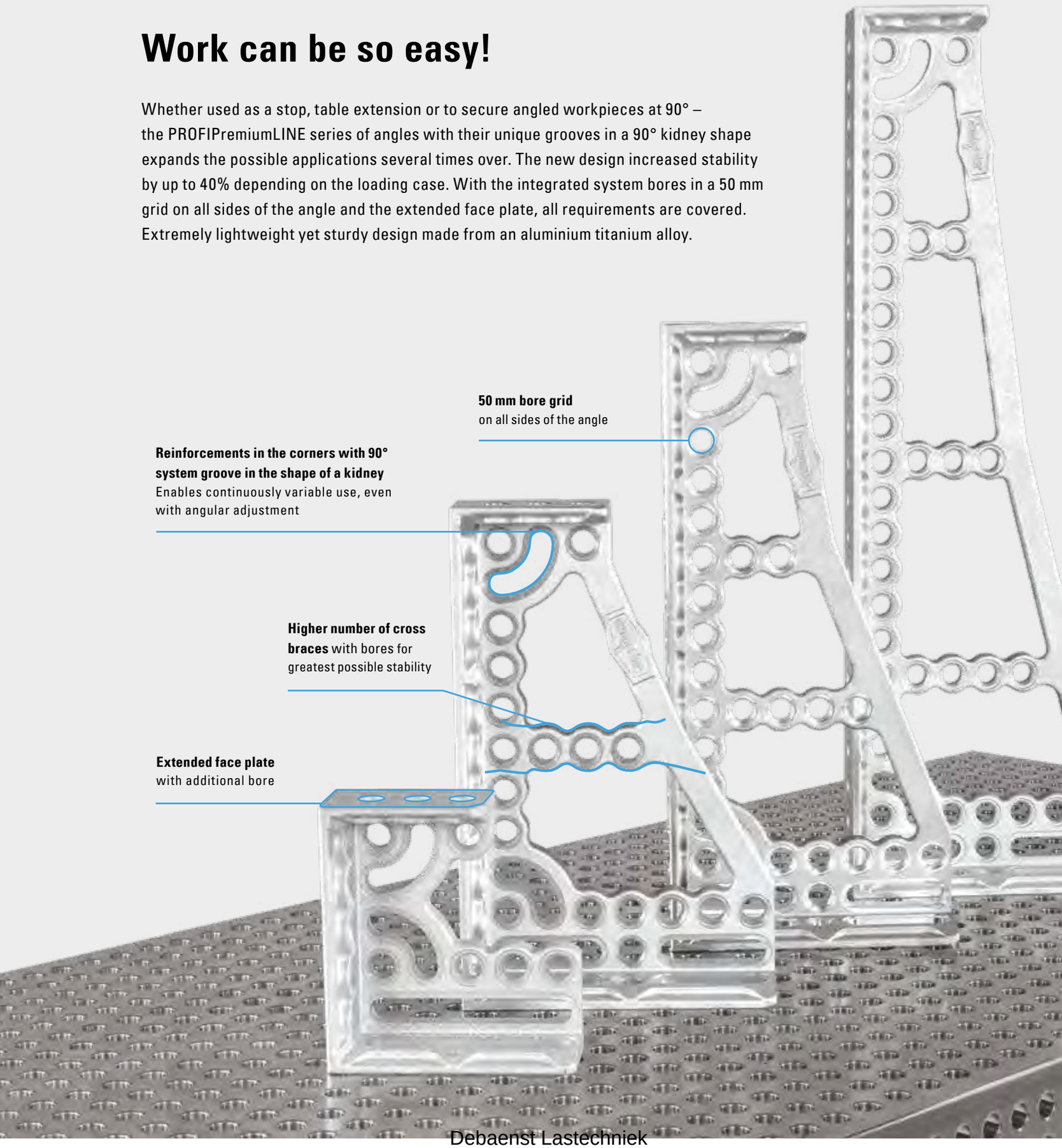


Stop disc
page 175

Debaenst Lastechniek

Work can be so easy!

Whether used as a stop, table extension or to secure angled workpieces at 90° – the PROFIPremiumLINE series of angles with their unique grooves in a 90° kidney shape expands the possible applications several times over. The new design increased stability by up to 40% depending on the loading case. With the integrated system bores in a 50 mm grid on all sides of the angle and the extended face plate, all requirements are covered. Extremely lightweight yet sturdy design made from an aluminium titanium alloy.



Debaenst Lastechniek



D22



PROFIPremiumLINE locating and clamping angles, aluminium titanium
page 153



PROFIEcoLINE locating and clamping angles, hardened cast
page 157



Locating and clamping angles, small
page 160



Locating and clamping angles
from page 161



Locating and clamping angles, aluminium titanium
page 164



Universal stop small
page 167



Sliding stop
page 168



Universal stop large
from page 169



Universal stop L300/L500
page 172



Stop bar
page 173



Stop disc
page 175

D16



PROFIPlusLINE locating and clamping angles, cast
page 156



Universal pivot and tilt angle
page 159



Locating and clamping angles small
page 160



Locating and clamping angles
from page 161



Locating and clamping angles large
page 162



Flat angle trim
page 165



Universal stop small
page 167



Sliding stop
page 168



PROFIEcoLINE universal stop large
page 168



Universal stop large
from page 169



Universal stop L165
page 172



Contour stop
page 174



Angle-setting template
page 174



Adapter plate
page 175



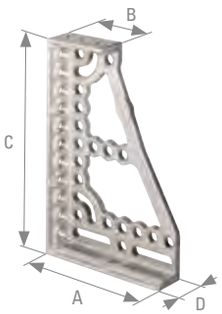
Stop disc
page 175

Debaenst Lastechniek

Alu-Titan

PROFIPremiumLINE locating and clamping angles, aluminium titanium

- Reinforcements in the corners with a 90° system groove in the shape of a kidney allow continuously variable use, even with angular adjustment
- 40% better rigidity
- Extended face plate with additional bore
- Bore grid at 50 mm intervals, also on all sides of the angle
- Four locating/usable surfaces
- 2x system groove in 90° kidney shape
- With precision scaling
- Anodised



D28
D22

WORK SMART

Locating and clamping angle D28 PP 300	D28	
Right / Left		
A in mm	275	275
B in mm	180	180
C in mm	300	300
D in mm	100	100
Approx. weight in kg	5,0	5,0
Description	Right	Left
Item no.	P28-03002-002	P28-03002-003



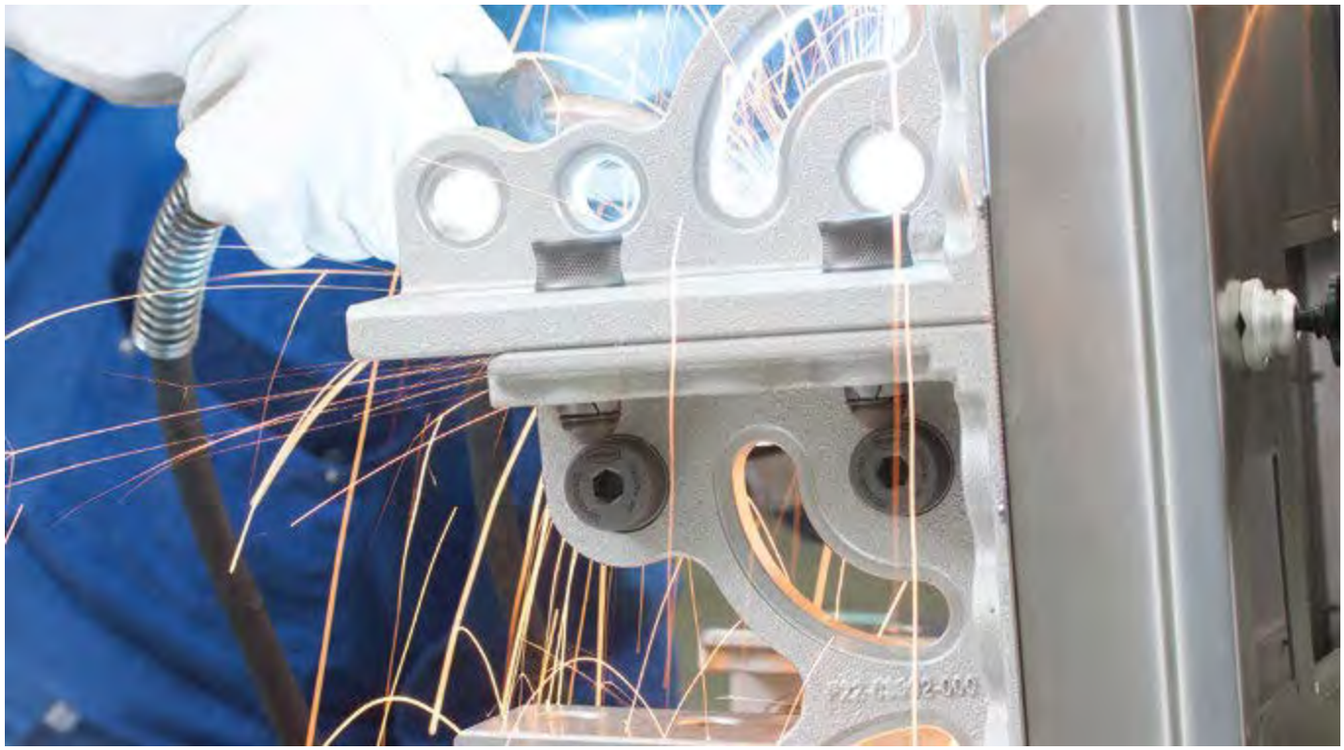
Locating and clamping angle D28 PP 600	D28	
Right / Left		
A in mm	375	375
B in mm	180	180
C in mm	600	600
D in mm	100	100
Approx. weight in kg	9,3	9,3
Description	Right	Left
Item no.	P28-03003-002	P28-03003-003

Locating and clamping angle D28 PP 800	D28	
Right / Left		
A in mm	375	375
B in mm	180	180
C in mm	800	800
D in mm	100	100
Approx. weight in kg	11,5	11,5
Description	Right	Left
Item no.	P28-03004-000	P28-03004-001



Locating and clamping angle D28 PP 1200	D28	
Right / Left		
A in mm	375	375
B in mm	180	180
C in mm	1200	1200
D in mm	100	100
Approx. weight in kg	15,3	15,3
Description	Right	Left
Item no.	P28-03009-000	P28-03009-001

Debaenst Lastechniek



Locating and clamping angle D22 PP 250		D22	
Right	Left		
			
A in mm		225	225
B in mm		180	180
C in mm		250	250
D in mm		80	80
Approx. weight in kg		3,3	3,3
Description		Right	Left
Item no.		P22-03002-002	P22-03002-003



Locating and clamping angle D22 PP 500		D22	
Right	Left		
			
A in mm		325	325
B in mm		180	180
C in mm		500	500
D in mm		80	80
Approx. weight in kg		6,4	6,4
Description		Right	Left
Item no.		P22-03003-002	P22-03003-003

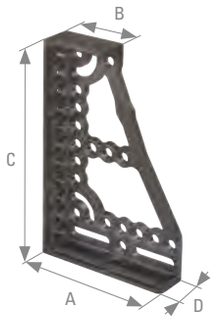
Locating and clamping angle D22 PP 750		D22	
Right	Left		
			
A in mm		325	325
B in mm		180	180
C in mm		750	750
D in mm		80	80
Approx. weight in kg		8,3	8,3
Description		Right	Left
Item no.		P22-03004-000	P22-03004-001

Locating and clamping angle D28 PROFIPremiumLINE, hardened casting

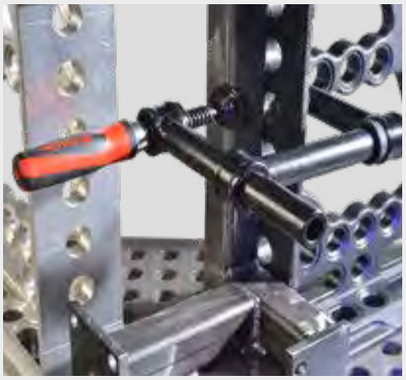
DEMONT 760 M
BLACK EDITION

D28

- Reinforcements in the corners with a 90° system groove in the shape of a kidney allow continuously variable use, even with angular adjustment
- 40% better rigidity
- Extended face plate with additional bore
- Bore grid at 50 mm intervals, also on all sides of the angle
- Four locating/usable surfaces
- 2x system groove in 90° kidney shape
- With precision scaling
- Hardened cast



Locating and clamping angle D28 PP 300	D28	
Right Left		
A in mm	275	275
B in mm	180	180
C in mm	300	300
D in mm	100	100
Approx. weight in kg	13,3	13,3
Description	Right	Left
Item no.	P28-03002-000	P28-03002-001



Locating and clamping angle D28 PP 600	D28	
Right Left		
A in mm	375	375
B in mm	180	180
C in mm	600	600
D in mm	100	100
Approx. weight in kg	27,3	27,3
Description	Right	Left
Item no.	P28-03003-000	P28-03003-001



Locating and clamping angle D28 PP 800	D28	
Right Left		
A in mm	375	375
B in mm	180	180
C in mm	800	800
D in mm	100	100
Approx. weight in kg	30,7	30,7
Description	Right	Right
Item no.	P28-03004-002	P28-03004-003

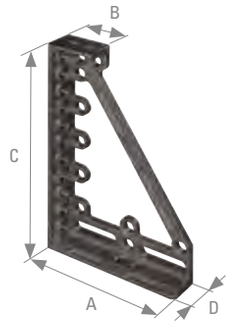
Debaenst Lastechniek

Locating and clamping angle D28 PROFIPlusLINE, hardened cast

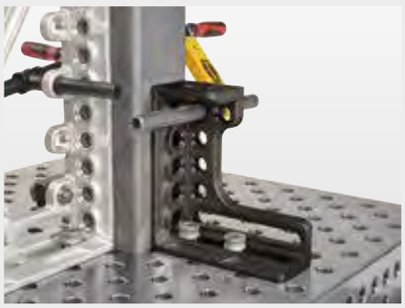
DEMONT 760 M
BLACK EDITION

D28

- Three full clamping faces with system bores
- With oblong holes for continuous adjustment
- Including precision scaling to adjust the mounting dimensions
- Improved sliding behaviour through the combination of cast iron on steel
- Grid lines reduce the set-up time
- With face plate for additional set-up system components
- Hardened cast: Ultimate stability and toughness
- With precision scaling and clamping strip
- With grid lines



Locating and clamping angle D28 PL 300	D28	
Right Left		
A in mm	275	275
B in mm	130	130
C in mm	300	300
D in mm	100	100
Approx. weight in kg	11,4	11,4
Description	Right	Left
Item no.	PL28-03002-000	PL28-03002-001



Locating and clamping angle D28 PL 600	D28	
Right Left		
A in mm	375	375
B in mm	130	130
C in mm	600	600
D in mm	100	100
Approx. weight in kg	19,9	19,9
Description	Right	Left
Item no.	PL28-03003-000	PL28-03003-001

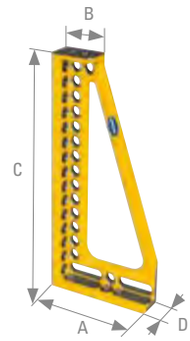


Locating and clamping angle D28 PL 800	D28	
Right Left		
A in mm	375	375
B in mm	130	130
C in mm	800	800
D in mm	100	100
Approx. weight in kg	24,5	24,5
Description	Right	Left
Item no.	PL28-03004-000	PL28-03004-001

Debaenst Lastechniek

Locating and clamping angle D16 PROFIPlusLINE, cast

- Three full clamping faces with system bores
- Oblong holes for continuous adjustment
- Improved sliding behaviour through the combination of cast iron on steel
- Grid lines reduce the set-up time
- With face plate for additional set-up system components
- Special cast: Ultimate stability and toughness
- Powder-coated



D16

Locating and clamping angle D16 PL 200		D16	
Right Left	**A in mm**	137,5	137,5
	**B in mm**	75	75
	C in mm	200	200
	D in mm	50	50
	Approx. weight in kg	1,7	1,7
	Description	Right	Left
	Item no.	D16-03002-000	D16-03002-001



Locating and clamping angle D16 PL 400		D16	
Right Left	**A in mm**	187,5	187,5
	**B in mm**	75	75
	C in mm	400	400
	D in mm	50	50
	Approx. weight in kg	4,0	4,0
	Description	Right	Left
	Item no.	D16-03003-000	D16-03003-001



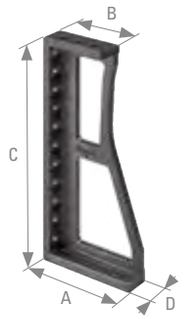
Locating and clamping angle D16 PL 600		D16	
Right Left	**A in mm**	187,5	187,5
	**B in mm**	75	75
	C in mm	600	600
	D in mm	50	50
	Approx. weight in kg	5,4	5,4
	Description	Right	Left
	Item no.	D16-03004-000	D16-03004-001

Debaenst Lastechniek

Locating and clamping angles PROFIEcoLINE, hardened cast

DEMONT 760 M
BLACK EDITION

- Eco series – reduced to the essentials, yet tremendously flexible
- System bores in a 50 mm grid
- Three usable locating faces for all common locating and clamping tasks
- Hardened cast
- Cost-effective version
- Three locating surfaces
- With face plate



D28
D22

Locating and clamping angle D28 PE 600		D28	
Right	Left		
			
	A in mm	275	275
	B in mm	190	190
	C in mm	600	600
	D in mm	80	80
	Approx. weight in kg	19	19
	Description	Right	Left
	Item no.	PE28-03003-000	PE28-03003-001

Locating and clamping angle D28 PE 800		D28	
Right	Left		
			
	A in mm	275	275
	B in mm	190	190
	C in mm	800	800
	D in mm	80	80
	Approx. weight in kg	24	24
	Description	Right	Left
	Item no.	PE28-03004-000	PE28-03004-001

Locating and clamping angle D22 PE 500		D22	
Right	Left		
			
	A in mm	275	275
	B in mm	175	175
	C in mm	500	500
	D in mm	80	80
	Approx. weight in kg	13,5	13,5
	Description	Right	Left
	Item no.	PE22-03003-000	PE22-03003-001

Locating and clamping angle D22 PE 750		D22	
Right	Left		
			
	A in mm	275	275
	B in mm	175	175
	C in mm	750	750
	D in mm	80	80
	Approx. weight in kg	18,5	18,5
	Description	Right	Left
	Item no.	PE22-03004-000	PE22-03004-001



Debaenst Lastechniek

Locating and clamping angle D28 PROFIPremiumLINE 2000

- For very large-scale and difficult applications
- Extremely sturdy design
- With system bores in a 100 mm double grid on all sides

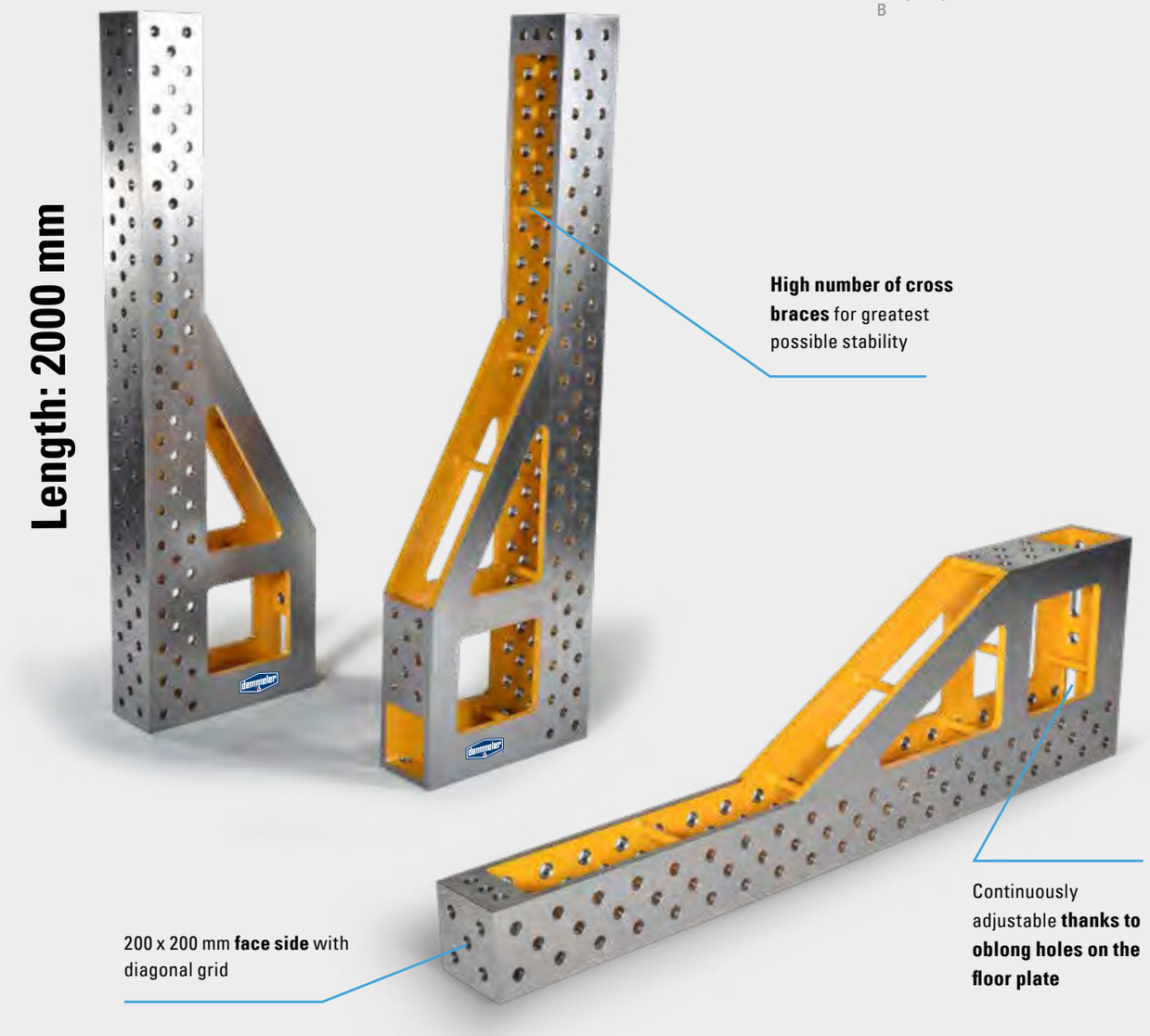
D28



Locating and clamping angle D28 PP 2000	D28
A in mm	600
B in mm	200
C in mm	2000
D in mm	200
Approx. weight in kg	272
Item no.	D28-50099-008



Length: 2000 mm



High number of cross braces for greatest possible stability

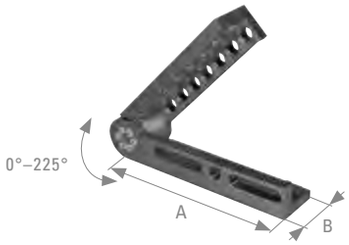
200 x 200 mm **face side** with diagonal grid

Continuously adjustable **thanks to oblong holes on the floor plate**

Debaenst Lastechniek

Universal pivot and tilt angle

- Continuously adjustable from 0° to 225° with precision scaling
- Hydromechanical clamping:
  >> Completely maintenance-free
  >> Holding force up to 1600 Nm torque
- Can be combined with other system components
- Can be used horizontally and vertically



D28
D16

Universal pivot and tilt angle D28, hardened cast

D28

Right Left



- Hardened cast
- With precision scaling

A in mm	B in mm	Approx. weight in kg	Description	Item no.
425	100	22	Right	D28-03007-000
425	100	22	Left	D28-03007-003

Universal pivot and tilt angle D28, aluminium titanium

D28

Right Left



- High-strength aluminium titanium alloy for approx. 60% weight reduction and approx. 10% higher bending strength compared to cast iron
- Anodised
- With precision scaling

A in mm	B in mm	Approx. weight in kg	Description	Item no.
425	100	9	Right	D28-03007-004
425	100	9	Left	D28-03007-005

Universal pivot and tilt angle D16, hardened steel

D16

Right Left



- Burnished steel
- Without precision scaling

A in mm	B in mm	Approx. weight in kg	Description	Item no.
225	50	3	Right	D16-03007-000
225	50	3	Left	D16-03007-003



Ideal for clamping workpieces with flexible alignments



Continuously adjustable from 0° to 225° with precision scaling



Maintenance-free hydromechanical clamping with high holding forces

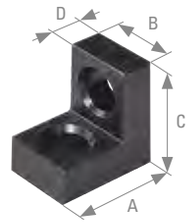
Debaenst Lastechniek

Locating and clamping angle PROFIPlusLINE small

DEMONT 760 M
BLACK EDITION

- Ideal for confined spaces
- The height of the support surfaces can be continuously adjusted, for example in conjunction with locating and clamping angles with oblong hole/oblong hole (page 161)

D28
D22
D16



Locating and clamping angle PL small, bore/bore



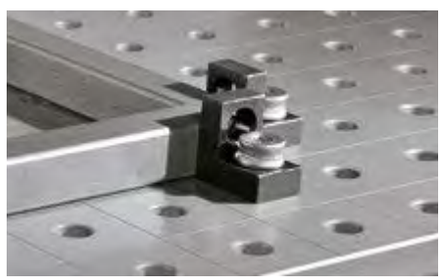
	D28	D22	D16
A in mm	75	75	37,5
B in mm	50	50	25
D in mm	25	18	12
Approx. weight in kg	0,98	0,9	0,12
Description	Hardened steel	Hardened steel	Burnished steel
Item no.	D28-03001-008	D22-03001-008	D16-03001-008

Locating and clamping angle PL small, bore/oblong hole



- Dimensions can be adjusted using grid lines on the 3D welding table
- Continuous adjustment and locking via oblong hole
- Combination of bore/oblong hole

	D28	D22	D16
A in mm	175	175	90
B in mm	50	50	25
C in mm	75	75	37,5
D in mm	25	18	12
Approx. weight in kg	1,4	1,1	0,16
Description	Hardened steel	Hardened steel	Burnished steel
Item no.	D28-03001-005	D22-03001-005	D16-03001-002



Locating and clamping angle small, bore/bore



Locating and clamping angle small, bore/oblong hole



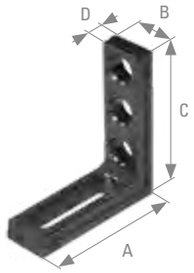
Locating and clamping angle, bore/bore

Debaenst Lastechniek

PROFIPlusLINE locating and clamping angles

DEMONT 760 M
BLACK EDITION

- Dimensions can be adjusted using grid lines on the 3D welding table
- Two full angle surfaces – therefore can be used from both sides
- Ideal for confined spaces
- Precision scaling on both sides



D28
D22
D16

Locating and clamping angle PL, bore/oblong hole



- Combination of system bores/oblong hole for numerous clamping options
- Compatible with all locating and clamping angles so that the oblong hole can be used to form a height-adjustable support

	D28	D22	D16
A in mm	175	175	90
B in mm	50	50	25
C in mm	175	175	90
D in mm	25	18	12
Approx. weight in kg	1,8	1,7	0,24
Description	Hardened cast	Hardened steel	Burnished steel
Item no.	PE28-03001-000	PE22-03001-000	D16-03001-000

Locating and clamping angle PL, oblong hole/oblong hole



- Continuous adjustment and locking
- Compatible with all locating and clamping angles so that both oblong holes can be used to form a height-adjustable support

	D28	D22	D16
A in mm	175	175	90
B in mm	50	50	25
C in mm	175	175	90
D in mm	25	18	12
Approx. weight in kg	1,5	1,5	0,20
Description	Hardened cast	Hardened steel	Burnished steel
Item no.	D28-03001-003	D22-03001-003	D16-03001-003

Locating and clamping angle PL, bore/bore



	D28	D22	D16
A in mm	175	175	90
B in mm	50	50	25
C in mm	175	175	90
D in mm	25	18	12
Approx. weight in kg	2,1	1,8	0,28
Description	Hardened cast	Hardened steel	Burnished steel
Item no.	D28-03001-004	D22-03001-004	D16-03001-004

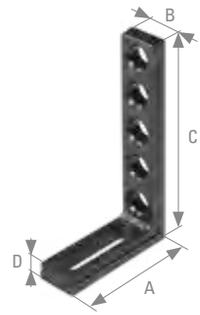
Debaenst Lastechniek

Locating and clamping angles PROFIEcoLINE large

DEMONT 760 M
BLACK EDITION

- Combination of system bores/oblong hole for numerous clamping options
- Precision scaling on both sides
- Two full angle surfaces – therefore can be used from both sides
- Dimensions can be adjusted using grid lines on the 3D welding table
- Compatible with all locating and clamping angles so that the oblong hole can be used to form a height-adjustable support

D28
D16



Locating and clamping angle PE large, bore/oblong hole



	D28	D16
A in mm	175	90
B in mm	50	25
C in mm	275	140
D in mm	25	12
Approx. weight in kg	2,4	0,32
Description	Hardened cast	Burnished steel
Item no.	PE28-03008-000	D16-03008-000



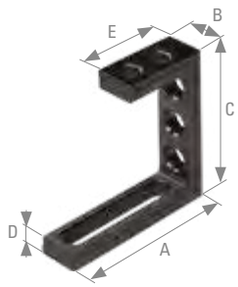
Debaenst Lastechniek

Locating and clamping angles PROFIPlusLINE with face plate

DEMONT 760 M
BLACK EDITION

- Extended face plate with two bores in the face plate
- Extended base plate with oblong hole, so can be moved in the grid
- Precision scaling on both sides
- Hardened cast

D28



Locating and clamping angle D28 PL 200 with face plate



	D28
A in mm	225
B in mm	50
C in mm	200
D in mm	25
E in mm	125
Approx. weight in kg	2,8
Description	Hardened cast
Item no.	PL28-03001-015



Locating and clamping angle D28 PL 300 with face plate



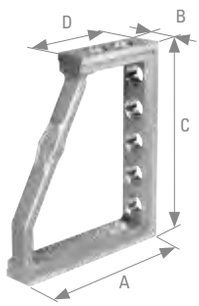
	D28
A in mm	175
B in mm	50
C in mm	300
D in mm	25
E in mm	125
Approx. weight in kg	3,2
Description	Hardened cast
Item no.	PL28-03001-016



Locating and clamping angles PROFIPlusLINE, aluminium titanium

Alu-Titan

- Extended face plate with two bores in the face plate
- Extended base plate with 150 oblong hole – therefore can be moved in the 50 mm grid
- Aluminium titanium

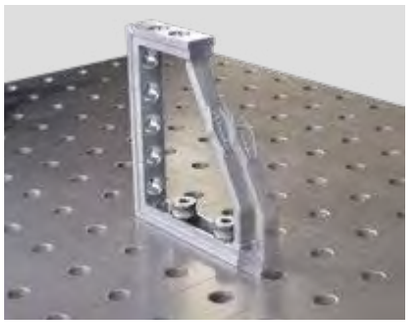


D28
D22

Locating and clamping angles PL, aluminium titanium



	D28	D22
A in mm	250	250
B in mm	50	50
C in mm	300	300
D in mm	150	150
Approx. weight in kg	1,8	1,7
Item no.	PP28-03001-017	PP22-03001-017

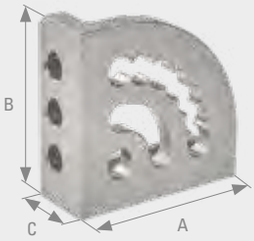


Angle bracket D28 PROFIPlusLINE

Alu-Titan

- Angle bracket with an incredible range of applications:
  Whether just as a stop, or for clamping angled parts
- Combination of free angle setting, form-fitting 15° increments or as 90° stop
- With precision scaling
- Aluminium titanium

D28

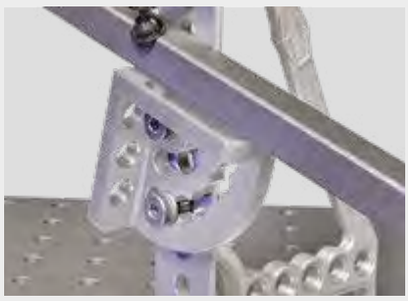


Angle bracket D28 PL

Right Left



	D28	
A in mm	200	200
B in mm	200	200
C in mm	75	75
Approx. weight in kg	7,3	7,3
Description	Right	Left
Item no.	P28-05013-013	P28-05013-014



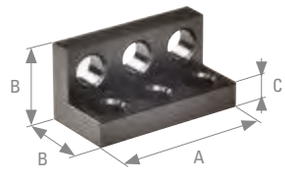
Debaenst Lastechniek

Mounting angle D28

DEMONT 760 M BLACK EDITION

- Strong connection of workpieces
- Very robust locating and locking angle for workpieces and system components
- Direct connection between 3D welding table and base rail
- Hardened steel

D28



Mounting angle D28	D28
A in mm	150
B in mm	75
C in mm	25
Approx. weight in kg	2,9
Description	Hardened steel
Item no.	D28-50003-000



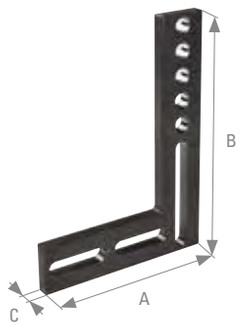
Can be connected to base rail

Flat angle trim

DEMONT 760 M BLACK EDITION

- Full locating surfaces inside and outside
- Many possibilities thanks to oblong holes and system bores
- Continuously movable using oblong holes

D28
D16



Flat angle trim	D28	D16
A in mm	375	187,5
B in mm	500	250
C in mm	25	12
Approx. weight in kg	12	1,46
Description	Hardened steel	Burnished steel
Item no.	D28-03006-000	D16-03006-000



A secure stop in every clamping situation

Universal stops offer ultimate flexibility

They are easy to use in confined work areas. Precision scaling as standard enables precision adjustment using grid lines. Stops can be continuously adjusted using a combination of system bore and oblong hole. This gives you an infinite variety of clamping options. DEMMELER PPC bolts ensure precise, continuous positioning in the table drilling pattern. For corner stops, additional notches are used for attachment.

- Simple fixing of all components
- Machining of all components in positions with absolutely zero play
- Controlled pre-tensioning and controlled adjustment



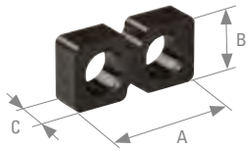
Debaenst Lastechniek

Universal stop small

DEMONT 760 M BLACK EDITION

- Preferred use in confined work areas
- Can also be used for corner connections thanks to notch

D28
D22
D16



Universal stop small, hardened steel	D28	D22	D16
A in mm	100	100	55
B in mm	50	50	25
C in mm	25	18	12
Approx. weight in kg	0,64	0,55	0,08
Description	Hardened steel	Hardened steel	Burnished steel
Item no.	D28-05002-000	D22-05002-000	D16-05002-000

Universal stop small, aluminium	D28	D16
A in mm	100	55
B in mm	50	25
C in mm	25	12
Approx. weight in kg	0,23	0,03
Description	Aluminium	Aluminium
Item no.	D28-05002-010	D16-05002-010

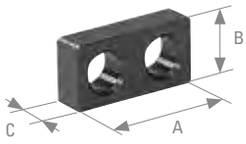


Universal stop PROFIEcoLINE small

DEMONT 760 M BLACK EDITION

- Preferred use in confined work areas
- Basic version

D28
D16



Universal stop PE small	D28	D16
A in mm	100	55
B in mm	50	25
C in mm	25	12
Approx. weight in kg	0,72	0,08
Description	Hardened steel	Burnished steel
Item no.	E28-05002-000	E16-05002-000



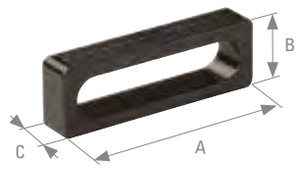
Debaenst Lastechniek

Sliding stop

DEMONT 760 M BLACK EDITION

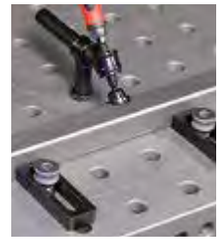
- Precision scaling on both sides
- Continuously adjustable with scale on both sides

D28
D22
D16



Sliding stop, steel	D28	D22	D16
A in mm	150	150	150
B in mm	50	50	25
C in mm	25	18	12
Approx. weight in kg	0,9	0,7	0,18
Description	Hardened steel	Hardened steel	Burnished steel
Item no.	D28-05015-000	D22-05015-000	D16-05015-000

Sliding stop, aluminium	D28	D16
A in mm	150	150
B in mm	50	25
C in mm	25	12
Approx. weight in kg	0,28	0,06
Description	Aluminium	Aluminium
Item no.	D28-05015-003	D16-05015-001

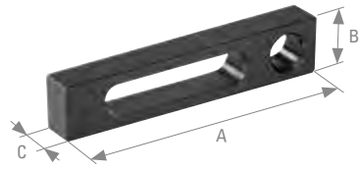


Universal stop PROFIEcoLINE large

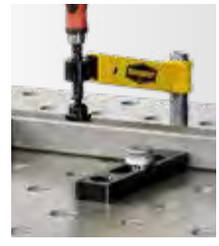
DEMONT 760 M BLACK EDITION

- Combination of system bore/oblong hole for numerous clamping options
- Basic version

D28
D16



Universal stop PE large	D28	D16
A in mm	225	115
B in mm	50	25
C in mm	25	12
Approx. weight in kg	1,4	0,16
Description	Hardened steel	Burnished steel
Item no.	E28-05001-000	E16-05001-000

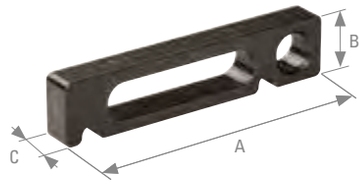


Debaenst Lastechniek

Universal stop large – with two notches

DEMONT 760 M
BLACK EDITION

- Combination of system bore/oblong hole for numerous clamping options
- Precision adjustment using grid lines is possible thanks to precision scaling
- 360° adjustable position
- Additional notches for attachment, ideal as a corner stop
- Continuous adjustment via oblong hole



D28
D22
D16

TOP SELLER

Universal stop large, steel, with two notches

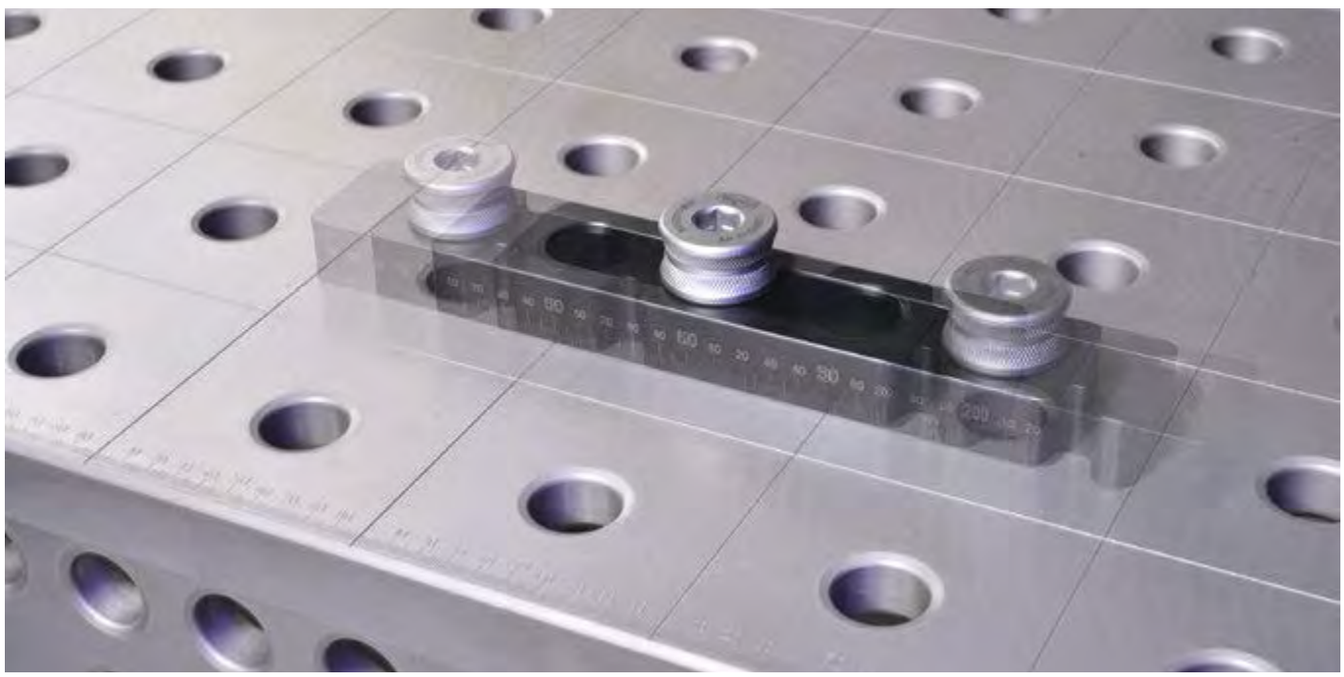


	D28	D22	D16
A in mm	225	225	115
B in mm	50	50	25
C in mm	25	18	12
Approx. weight in kg	1,32	1,1	0,14
Description	Hardened steel	Hardened steel	Burnished steel
Item no.	D28-05001-010	D22-05001-010	D16-05001-004

Universal stop large, aluminium, with two notches



	D28	D16
A in mm	225	115
B in mm	50	25
C in mm	25	12
Approx. weight in kg	0,47	0,05
Description	Aluminium	Aluminium
Item no.	D28-05001-021	D16-05001-012



Many installation and clamping options thanks to the combination of system bore and oblong hole.
The universal stop can be set out every 45° using the oblong hole in the 25 mm grid and in the angle position.

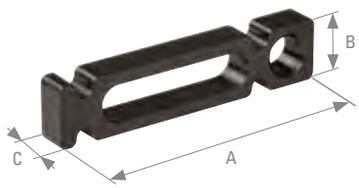
Debaenst Lastechniek

Universal stop large – with four notches

DEMONT 760 M
BLACK EDITION

- Combination of system bore/oblong hole for numerous clamping options
- Can be locked and fixed on five sides with PC bolt in a 25 mm grid in the table drilling pattern
- 360° adjustable positioning in 45° increments
- Continuously adjustable using the oblong hole

D28
D22
D16



Universal stop large, steel, with four notches



	D28	D22	D16
A in mm	225	225	115
B in mm	50	50	25
C in mm	25	18	12
Approx. weight in kg	1,2	1,0	0,14
Description	Hardened steel	Hardened steel	Burnished steel
Item no.	D28-05001-000	D22-05001-000	D16-05001-000

Universal stop large, aluminium, with four notches



	D28	D16
A in mm	225	115
B in mm	50	25
C in mm	25	12
Approx. weight in kg	0,44	0,05
Description	Aluminium	Aluminium
Item no.	D28-05001-022	D16-05001-010





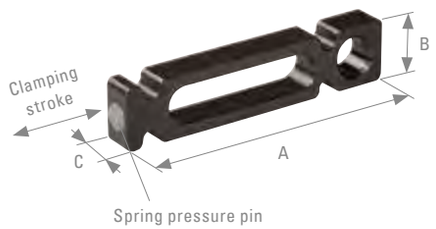
Debaenst Lastechniek

Universal stop large – with clamping bolt

DEMONT 760 M
BLACK EDITION

- Combination of system bore/oblong hole for numerous clamping options
- Can be locked and fixed on five sides with PC bolt in a 25 mm grid in the table drilling pattern
- 360° adjustable positioning in 45° increments
- Continuously adjustable using the oblong hole
- With additional spring pressure bolt especially for clamping sheet metal and moulded parts, so that no additional fixing of workpieces is necessary

D28
D16

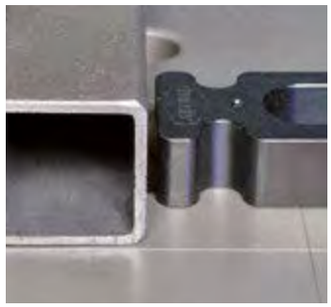


TOP SELLER

Universal stop large, steel, with clamping bolt



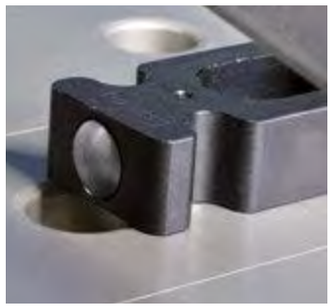
	D28	D16
A in mm	225	115
B in mm	50	25
C in mm	25	12
Approx. weight in kg	1,2	0,14
Clamping stroke in mm	3,5	2,0
Description	Hardened steel	Burnished steel
Item no.	D28-05001-001	D16-05001-001



Universal stop large, aluminium, with clamping bolt



	D28	D16
A in mm	225	115
B in mm	50	25
C in mm	25	12
Approx. weight in kg	0,45	0,05
Clamping stroke in mm	3,5	2,0
Description	Aluminium	Aluminium
Item no.	D28-05001-020	D16-05001-011



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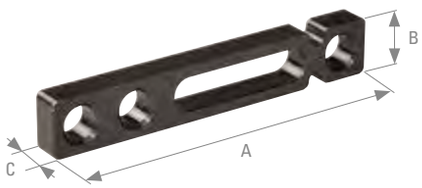
Universal stop L 165 / L 300 / L 500

DEMONT 760 M
BLACK EDITION

- Larger stop area than large universal stop
- Three or seven system bores
- For bridging larger locating surfaces
- As a lateral stop for large beams

D28
D22
D16



Universal stop D28, hardened steel — D28



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
300	50	25	1,8	D28-05009-000
500	50	25	3,22	D28-05009-008

Universal stop D28, aluminium — D28



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
300	50	25	0,63	D28-05009-013
500	50	25	1,14	D28-05009-014

Universal stop D22, hardened steel — D22



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
300	50	18	1,5	D22-05009-000
500	50	18	3,3	D22-05009-008

Universal stop D16 L165, burnished steel — D16



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
165	25	12	0,22	D16-05009-000

Universal stop D16 L165, aluminium — D16



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
165	25	12	0,07	D16-05009-010

Typical potential applications



As a lateral stop.



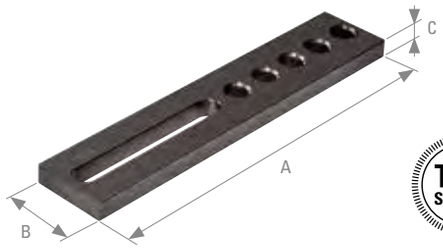
For bridging larger distances.

Debaenst Lastechniek

Stop bar

DEMONT 760 M
BLACK EDITION

- Combination of system bore/oblong hole for numerous clamping options
- Very long and sturdy design, resulting in a large locating surface for large components or long distances
- Continuous adjustment via oblong hole



D28
D22
D16

TOP SELLER

Stop bar D28, hardened steel

D28



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
500	100	25	8,0	D28-05003-000
800	100	25	13,0	D28-05003-001
1000	100	25	16,48	D28-05003-008

Stop bar D28, aluminium

D28



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
500	100	25	2,78	D28-05003-016
800	100	25	4,57	D28-05003-017
1000	100	25	5,76	D28-05003-018

Stop bar D22, hardened steel

D22



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
500	100	18	6,0	D22-05003-000

Stop bar D16, burnished steel

D16



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
250	50	12	0,90	D16-05003-000
400	50	12	1,48	D16-05003-001

Stop bar D16, aluminium

D16



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
250	50	12	0,3	D16-05003-010
400	50	12	0,5	D16-05003-011

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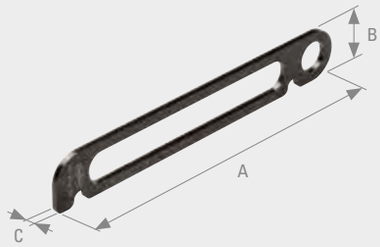
Contour stop

- Is used as a support element for lightweight workpieces
- Clamping via PC bolt and spacer washer from the support set
- Cost-effective
- With 1 mm precision scaling

D28
D16



Contour stop		D28	D16
	**A in mm**	325	187,5
	B in mm	50	25
	C in mm	6	6
	Approx. weight in kg	0,85	0,1
	Description	Hardened steel	Burnished steel
	Item no.	D28-05016-000	D16-05016-000

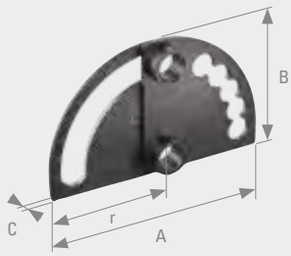


Angle-setting template

DEMONT 760 M
BLACK EDITION

- The angle-setting template is suitable for flexible use thanks to the 1° precision scaling on both sides
- Continuous 0–90°
- Fixed setting out 0–60°(15° increments)
- r = radius 125 mm

D28
D16



Angle-setting template D28, hardened steel					D28
	**A in mm**	**B in mm**	**C in mm**	**Approx. weight in kg**	**Item no.**
	250	150	12	1,2	D28-05013-010

Angle-setting template D16, burnished steel					D16
	**A in mm**	**B in mm**	**C in mm**	**Approx. weight in kg**	**Item no.**
	150	87,5	12	0,45	D16-05013-010

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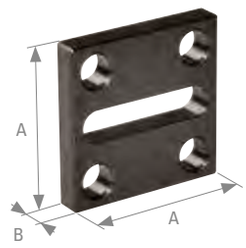
Adapter plate

DEMONT 760 M BLACK EDITION

- As an interface between the 3D system and individual components, i.e. for welding/screwing on special elements provided by the customer

D28
D16



Adapter plate	D28	D16
A in mm	150	75
B in mm	25	12
Approx. weight in kg	3,2	0,36
Description	Hardened steel	Burnished steel
Item no.	D28-05010-000	D16-05010-000

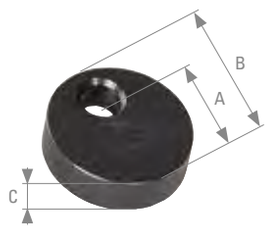


Stop disc

DEMONT 760 M BLACK EDITION

- Can be used as a stop or support
- Secured with PC bolt or connecting bush
- Continuous adjustment by turning (adjustment path A)
- Minimal space requirements

D28
D22
D16



Stop disc D28, hardened steel — D28

A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
50	75	25	1,2	Hardened steel	D28-05013-000
75	100	25	1,3	Hardened steel	D28-05013-001
50	75	25	1,3	Burnished steel	E28-05013-000

Stop disc D22, hardened steel — D22

A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
50	75	20	0,6	Hardened steel	D22-05013-000

Stop disc D16, hardened steel — D16

A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
37,5	50	12	0,17	Hardened steel	D16-05013-000
62,5	75	12	0,38	Hardened steel	D16-05013-001

Debaenst Lastechniek



Debaenst Lastechniek



DEMMELER® supports

Overview and product benefits 178

D28



Adjustment V-block
page 179



Adjustable spacer/ threaded support
page 179



Support set, 11-piece
page 180



Support set with thread
page 182



Taper fitting with thread
page 183



Taper fittings Ø 58 mm/ Ø 110 mm
from page 184



V-block holders
from page 186

D22



Support set, 11-piece
page 180



Support set with thread
page 182

D16



Support set, 9-piece
page 181



Support set with thread
page 182



V-block holder
from page 187

Debaenst Lastechniek

Precise positioning with the supports from DEMMELER

Always move your workpiece to the correct position precisely and quickly



Whether you have to fix angular or round components and compensate for them – the extensive product range can overcome any challenge. With the various support sets, which are compatible with each system size, you can compensate for high differences of up to 0.1 mm relative to the corresponding support surface, depending on requirements. The pressure and support tapers from DEMMELER make it possible to mount tubes up to an inner diameter of 105 mm.

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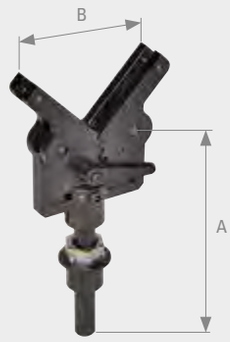
Adjustment V-block D28

- Eccentric setting via sliding plate
- Flexible angle adjustment from 90° to 180°
- Fixed at the required height with clamping bush
- Synchronous adjustment via toothing



D28

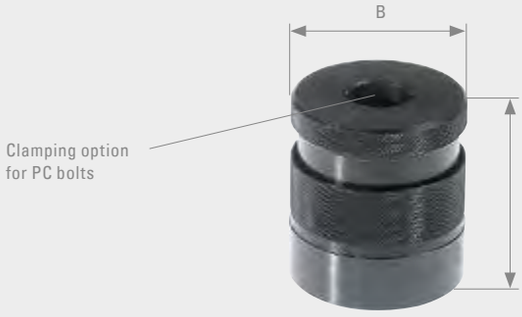
Adjustment V-block D28	D28
A in mm	200
B in mm	100
Approx. weight in kg	1,4
Description	Adjustment V-block
Item no.	D28-09015-000





Adjustable spacer/threaded support D28

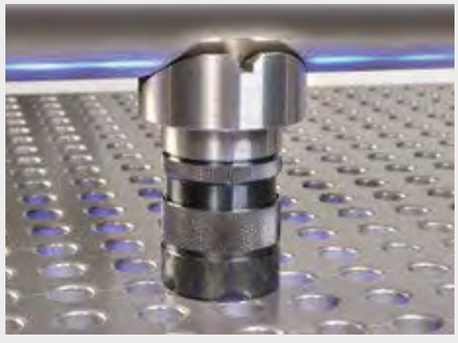
- The height of the support can be continuously adjusted from 75 to 95 mm
- Especially well-suited to V-block holders with mounting mandrel for direct insertion in the adjustable spacer
- Stops, etc. can also be clamped in the system bore using a PC bolt



D28

Adjustable spacer/threaded support D28	D28
A in mm	75-95
Ø B in mm	80
Approx. weight in kg	2,50
Description	With adjustment path A
Item no.	D28-09009-000





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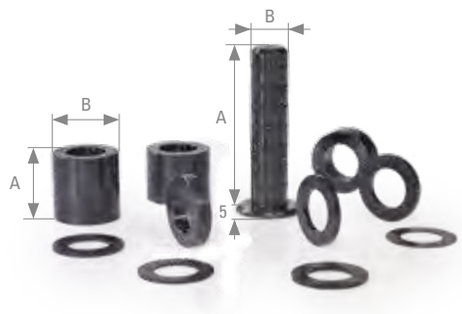
Support set

- Height compensation in mm range
- Smallest increment 1 mm
- Including 1/10 inch disc (2.54 mm)
- With dimensions of the compensating discs
- Mounting mandrel to fit any system bore
- Self-locking thanks to O-Ring
- Precise positioning at the required height using support sleeves of different lengths



D28
D22
D16

Support set D28, 11-piece

D28



- To compensate for a 5 to 100 mm height difference relative to the corresponding support surface
- M12 thread on the top of the mounting mandrel available for customer-specific special elements on request

A in mm	Ø B in mm	Approx. weight in kg	Description	Item no.
120+5	28	1,96	**11-piece support set**	**D28-09001-000**
120+5	28	0,60	Individual support mandrel	
1	50	0,02	Support sleeve L1	
2	50	0,02	Support sleeve L2	
2,5	50	0,02	Support sleeve L2.5	
3	50	0,04	Support sleeve L2	
4	50	0,04	Support sleeve L4	
5	50	0,04	Support sleeve L4	
10	50	0,08	Support sleeve L10	
20	50	0,20	Support sleeve L20	
40	50	0,40	Support sleeve L20	
50	50	0,48	Support sleeve L20	

Support set D22, 11-piece

D22



- To compensate for a 5 to 100 mm height difference relative to the corresponding support surface

A in mm	Ø B in mm	Approx. weight in kg	Description	Item no.
120+5	22	2	**11-piece support set**	**D22-09001-000**
120+5	22	0,38	Individual support mandrel	
1	50	0,01	Support sleeve L1	
2	50	0,02	Support sleeve L2	
2,5	50	0,03	Support sleeve L2.5	
3	50	0,04	Support sleeve L2	
4	50	0,05	Support sleeve L4	
5	50	0,06	Support sleeve L4	
10	50	0,12	Support sleeve L10	
20	50	0,24	Support sleeve L20	
40	50	0,47	Support sleeve L20	
50	50	0,59	Support sleeve L20	

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Support set D16, 9-piece

D16

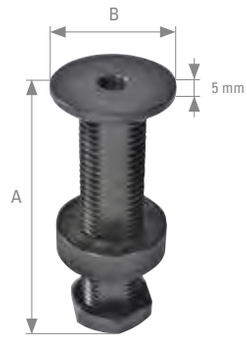


- To compensate for a 5 to 50 mm height difference relative to the corresponding support surface
- M8 thread on the top of the mounting mandrel available for customer-specific special elements on request

A in mm	Ø B in mm	Approx. weight in kg	Description	Item no.
55+5	16	0,220	**9-piece support set**	**D16-09001-000**
55+5	16	0,100	Individual support mandrel	
1	25	0,004	Support sleeve L1	
2	25	0,008	Support sleeve L2	
2,5	25	0,010	Support sleeve L2.5	
3	25	0,015	Support sleeve L2	
4	25	0,010	Support sleeve L4	
5	25	0,010	Support sleeve L4	
10	25	0,020	Support sleeve L10	
20	25	0,040	Support sleeve L20	

Support set with thread

- Continuous height compensation
- As a support surface on system components or directly on the table
- With 0.1 mm precision scaling
- Max. load 500 kg
- Burnished
- Including M28 (D28)/M22 (D22)/M16 x 2 (D16) counter nut



D28
D22
D16

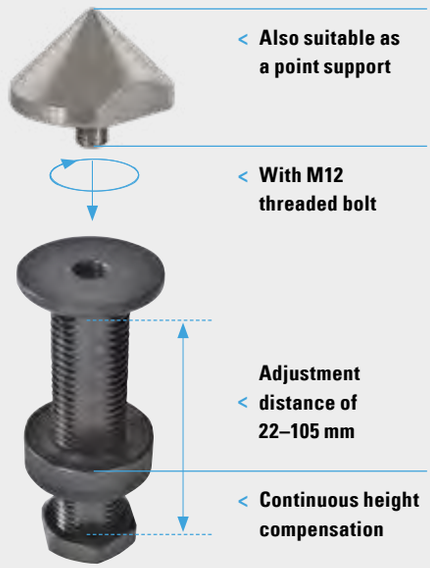
Support set with thread	D28	D22	D16
A in mm	120	120	95
Ø B in mm	50	45	25
Adjustment distance in mm	22-105	20-100	20-75
Approx. weight in kg	0,8	0,53	0,22
Item no.	D28-09001-005	D22-09001-005	D16-09001-005





DEMMELER taper fitting with thread combined with the support set with thread

The combination of taper fitting with thread and the support set with thread offers various options for fixing and compensating for your components. With continuously adjustable height compensation, ideal as a point support and also suitable for mounting tubes on the inner diameter.



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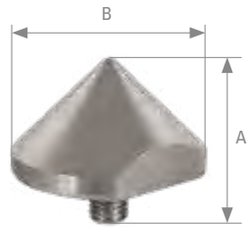
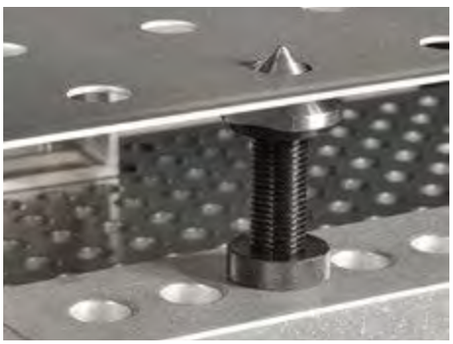
Taper fitting D28 with thread

- Taper fitting with M12 threaded bolt
- For mounting tubes on the inner diameter combined with the support set with thread, item no.: D28-09001-005
- Securing workpieces using reference bores
- Also for use as a point support
- Diameter range Ø 5 – 55 mm

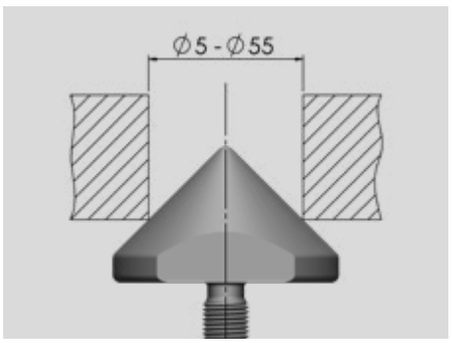
D28



Taper fitting D28 with thread, hardened steel	D28
A in mm	35
Ø B in mm	58
Approx. weight in kg	0,34
Angle	90°
Description	Hardened steel
Item no.	D28-09003-017



Taper fitting D28 with thread, stainless steel	D28
A in mm	35
Ø B in mm	58
Approx. weight in kg	0,34
Angle	90°
Description	Stainless steel
Item no.	D28-09003-018



Taper fitting D28 with thread, aluminium	D28
A in mm	35
Ø B in mm	58
Approx. weight in kg	0,12
Angle	90°
Description	Aluminium
Item no.	D28-09003-019

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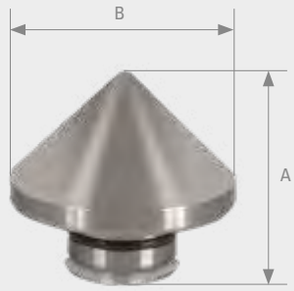
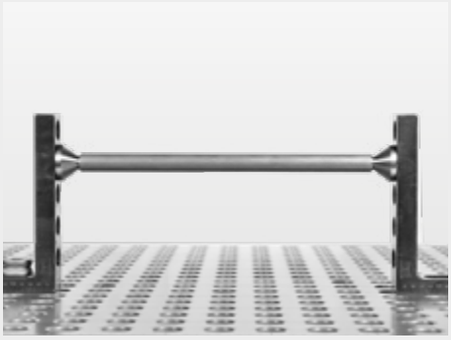
Taper fitting D28, Ø 58 mm

- Pressure and support taper to hold tubes by the inner diameter
- Screwed in with countersunk screw
- Diameter range Ø 5 – 55 mm

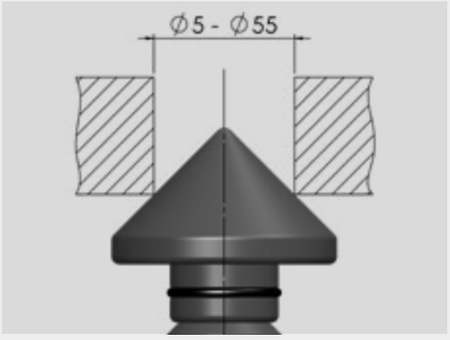


D28

Taper fitting D28, Ø 58 mm, hardened steel	D28
A in mm	35
Ø B in mm	58
Approx. weight in kg	0,37
Angle	90°
Description	Hardened steel
Item no.	D28-09003-011



Taper fitting D28, Ø 58 mm, stainless steel	D28
A in mm	35
Ø B in mm	58
Approx. weight in kg	0,37
Angle	90°
Description	Stainless steel
Item no.	D28-09003-012



Taper fitting D28, Ø 58 mm, aluminium	D28
A in mm	35
Ø B in mm	58
Approx. weight in kg	0,13
Angle	90°
Description	Aluminium
Item no.	D28-09003-013

Debaenst Lastechniek

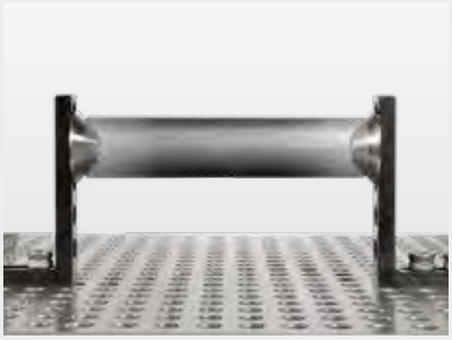
Taper fitting D28, Ø 110 mm

- Pressure and support taper to hold tubes by the inner or outer diameter
- Screwed in with countersunk screw
- Inner diameter range: Ø 50 – 105 mm
- Outer diameter range: Ø 10 – 30 mm

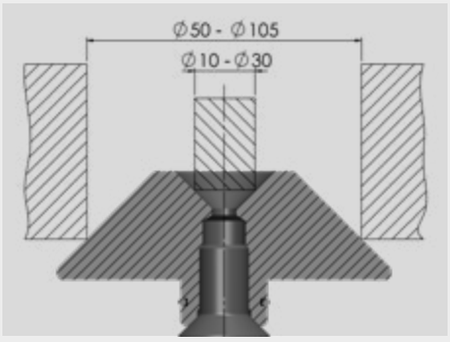
D28



Taper fitting D28, Ø 110 mm, hardened steel	D28
A in mm	35
Ø B in mm	110
Approx. weight in kg	1,44
Angle	90°
Description	Hardened steel
Item no.	D28-09003-014



Taper fitting D28, Ø 110 mm, stainless steel	D28
A in mm	35
Ø B in mm	110
Approx. weight in kg	1,44
Angle	90°
Description	Stainless steel
Item no.	D28-09003-015

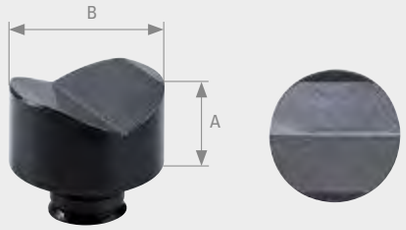


Taper fitting D28, Ø 110 mm, aluminium	D28
A in mm	35
Ø B in mm	110
Approx. weight in kg	0,49
Angle	90°
Description	Aluminium
Item no.	D28-09003-016

V-block holder D28, Ø 58 mm

- Precise mounting of tube elements
- Screwed in with countersunk screw
- For tube diameters up to 70 mm

D28



V-block holder D28, Ø 58 mm, burnished steel	D28
A in mm	35
Ø B in mm	58
Approx. weight in kg	0,68
Angle	130°
Description	Burnished steel
Item no.	D28-09003-000



V-block holder D28, Ø 58 mm, stainless steel	D28
A in mm	35
Ø B in mm	58
Approx. weight in kg	0,70
Angle	130°
Description	Stainless steel
Item no.	D28-09003-002

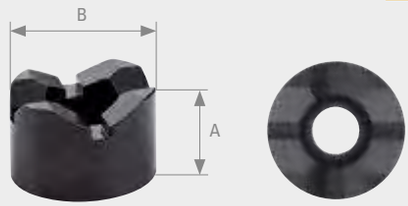
V-block holder D28, Ø 58 mm, POM	D28
A in mm	35
Ø B in mm	58
Approx. weight in kg	0,14
Angle	130°
Description	POM
Item no.	D28-09003-001

Debaenst Lastechniek

V-block holder D16, Ø 50 mm

- Screwed in with a PC bolt
- With double V-block for more options
- Also suitable for rectangular tubes

D16



V-block holder D16, Ø 50 mm, burnished steel	D16
A in mm	35
Ø B in mm	50
Approx. weight in kg	0,36
Angle	120°/90°
Description	Burnished steel
Item no.	D16-09004-000

V-block holder D16, Ø 50 mm, stainless steel	D16
A in mm	35
Ø B in mm	50
Approx. weight in kg	0,38
Angle	120°/90°
Description	Stainless steel
Item no.	D16-09004-002

V-block holder D16, Ø 50 mm, POM	D16
A in mm	35
Ø B in mm	50
Approx. weight in kg	0,06
Angle	120°/90°
Description	POM
Item no.	D16-09004-003

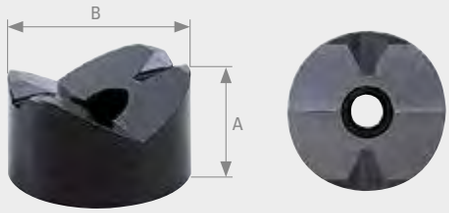


Debaenst Lastechniek

V-block holder D16, Ø 80 mm

- Screwed in with a PC bolt
- Double V-block for more options
- Also suitable for rectangular tubes

D16



V-block holder D16, Ø 80 mm, burnished steel	D16
	
A in mm	50
Ø B in mm	80
Approx. weight in kg	1,46
Angle	120°/90°
Description	Burnished steel
Item no.	D16-09003-000



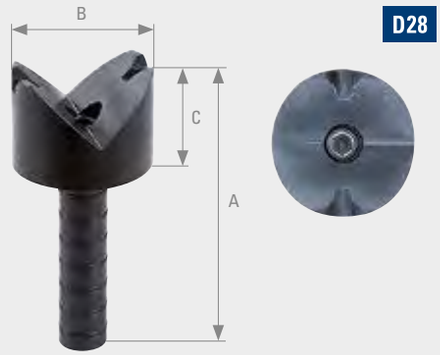
V-block holder D16, Ø 80 mm, stainless steel	D16
	
A in mm	50
Ø B in mm	80
Approx. weight in kg	1,46
Angle	120°/90°
Description	Stainless steel
Item no.	D16-09003-002

V-block holder D16, Ø 80 mm, POM	D16
	
A in mm	50
Ø B in mm	80
Approx. weight in kg	0,22
Angle	120°/90°
Description	POM
Item no.	D16-09003-003

Debaenst Lastechniek

V-block holder D28, Ø 80 mm with mounting mandrel

- With threaded support tower
- For tube diameters up to 100 mm
- Also suitable for rectangular tubes
- Double V-block for more options
- Height adjustment via support sleeves for mounting mandrel (page 180) or continuous adjustment using D28-09001-005 support set with thread (page 182) or with D28-09009-000 adjustable spacer (page 179)



D28

V-block holder D28, Ø 80 mm, burnished steel	D28
A in mm	180
Ø B in mm	80
C in mm	60
Approx. weight in kg	2,16
Angle	90°/90°
Description	Burnished steel
Item no.	D28-09004-000



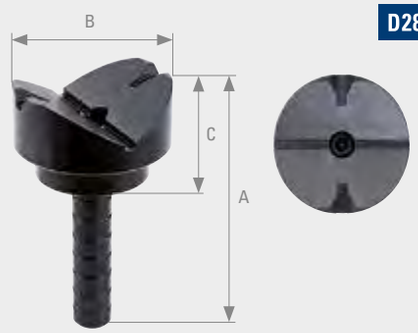
V-block holder D28, Ø 80 mm, stainless steel	D28
A in mm	180
Ø B in mm	80
C in mm	60
Approx. weight in kg	2,18
Angle	90°/90°
Description	Stainless steel
Item no.	D28-09004-003

V-block holder D28, Ø 80 mm, POM	D28
A in mm	180
Ø B in mm	80
C in mm	60
Approx. weight in kg	0,88
Angle	90°/90°
Description	POM
Item no.	D28-09004-001

Debaenst Lastechniek

V-block holder D28, Ø 110 mm with mounting mandrel

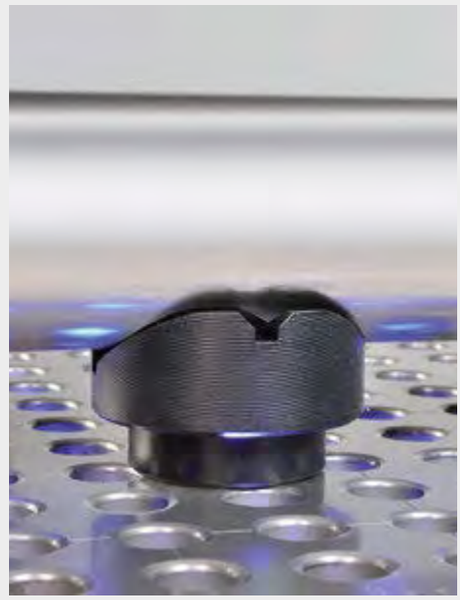
- Precise mounting of tube elements
- With threaded support tower
- For tube diameters up to 180 mm
- Double V-block for more options
- Height adjustment via support sleeves for mounting mandrel (page 180) or continuous adjustment using D28-09001-005 support set with thread (page 182) or with D28-09009-000 adjustable spacer (page 179)



D28

V-block holder D28, Ø 110 mm, burnished steel	D28
A in mm	190
Ø B in mm	110
C in mm	70
Approx. weight in kg	3,70
Angle	120°/90°
Description	Burnished steel
Item no.	D28-09005-000





V-block holder D28, Ø 110 mm, stainless steel	D28
A in mm	190
Ø B in mm	110
C in mm	70
Approx. weight in kg	3,82
Angle	120°/90°
Description	Stainless steel
Item no.	D28-09005-002



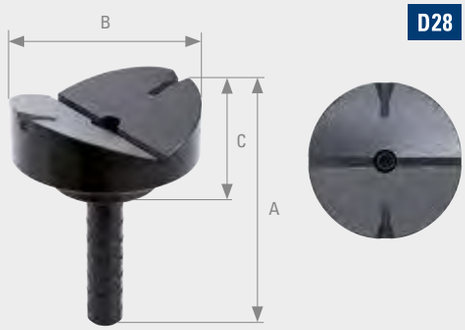
V-block holder D28, Ø 110 mm, POM	D28
A in mm	190
Ø B in mm	110
C in mm	70
Approx. weight in kg	1,10
Angle	120°/90°
Description	POM
Item no.	D28-09005-001



Debaenst Lastechniek

V-block holder D28, Ø 140 mm with mounting mandrel

- Precise mounting of tube elements
- With threaded support tower
- For tube diameters up to 400 mm
- Double V-block for more options
- Height adjustment via support sleeves for mounting mandrel (page 180) or continuous adjustment using D28-09001-005 support set with thread (page 182) or with D28-09009-000 adjustable spacer (page 179)



D28

V-block holder D28, Ø 140 mm, burnished steel	D28
	
A in mm	190
Ø B in mm	140
C in mm	70
Approx. weight in kg	5,22
Angle	140°/90°
Description	Burnished steel
Item no.	D28-09006-000



V-block holder D28, Ø 140 mm, stainless steel	D28
	
A in mm	190
Ø B in mm	140
C in mm	70
Approx. weight in kg	5,30
Angle	140°/90°
Description	Stainless steel
Item no.	D28-09006-002

V-block holder D28, Ø 140 mm, POM	D28
	
A in mm	190
Ø B in mm	140
C in mm	70
Approx. weight in kg	1,32
Angle	140°/90°
Description	POM
Item no.	D28-09006-001

Debaenst Lastechniek



Debaenst Lastechniek



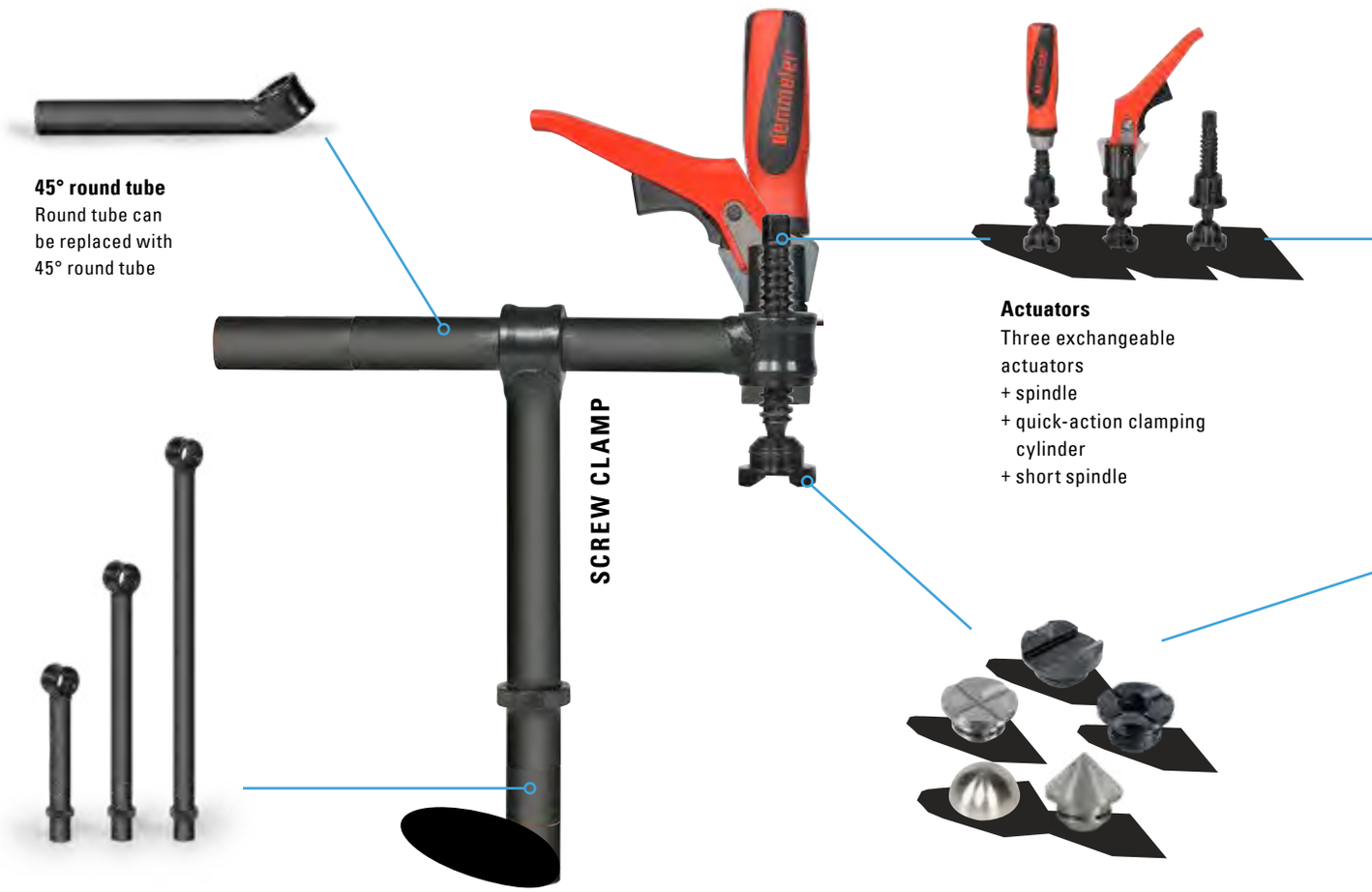
DEMMELER® clamps

Overview of clamps	194
Product benefits of the performance screw clamp	200
Quick-release toggle clamp, pneumatic toggle clamp and accessories	222

D28		D22	D16
 **Compensating screw clamp** page 196	 **Screw clamp 180°** page 202	 **Compensating screw clamp** page 198	 **Compensating screw clamp** page 199
 **Compensating clamping arm with short spindle** page 197	 **Variable screw clamp 90°** page 205	 **Screw clamp 180°** page 203	 **Screw clamp 180°** page 204
 **Multi-clamping and support tower** page 197	 **Variable screw clamp 45°** page 207	 **Variable screw clamp 45°** page 208	 **Variable screw clamp 90°** page 205
 **Performance screw clamp** page 201	 **Accessories** from page 210	 **Accessories** from page 210	 **Variable screw clamp 45°** page 209
			 **Accessories** from page 210

Flexible down to the details

Configure your clamp – from the length of the round tubes and the actuator through to the choice of the clamping pad



45° round tube
Round tube can be replaced with 45° round tube

Actuators
Three exchangeable actuators
+ spindle
+ quick-action clamping cylinder
+ short spindle

Round tubes
Round tubes of different lengths can be exchanged vertically and horizontally

Clamping pad
Rapid replacement of different clamping pads. No tools and no screws.

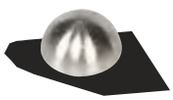
Clamping pad: The right support for every workpiece





Pressure and support pieces with V-block
Clamping of round/ rectangular tubes





Clamping pad with spherical shape
Clamping of corner profiles

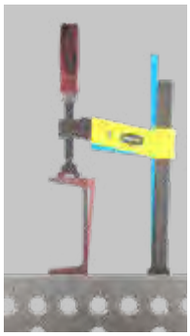
Debaenst Lastechniek

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

Compatibility with screw clamps and compensating screw clamps: The actuators and clamping pads can be used on both clamps



Difference equalisation





Difference equalisation stops the workpiece tipping

COMPENSATING SCREW CLAMP



Arm length
Exchangeable arm length



Round tubes
Round tubes of different lengths can be exchanged vertically





Pressure and support pieces with taper
Clamping of tubes with a diameter of 10–58 mm



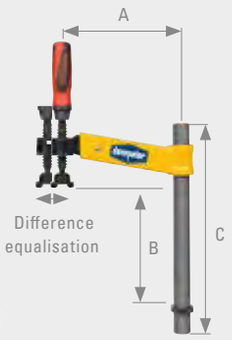


Adjusting spindle
Clamping in hard-to-reach positions

Debaenst Lastechniek

Compensating screw clamp D28

- For fast, powerful and accurately positioned clamping of many different workpieces
- For profiles that tend to tip
- With difference equalisation for accurately oriented and positioned workpiece clamping
- With adjusting ring for setting the required height
- Exchangeable actuator (e.g. spindle, short spindle or quick-action clamping cylinder)
- Clamping pad can be exchanged for clamping other materials such as stainless steel
- Clamping pad as standard – added value for your screw clamps
- Exchangeable clamping tubes, available in different lengths



D28

TOP SELLER

Compensating screw clamp D28 with spindle

D28



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
150	Max. 280	350	2,62	D28-07001-000
200	Max. 280	350	2,88	D28-07002-000

Compensating screw clamp D28 with quick-action clamping cylinder

D28



- Up to 5x faster clamping than with conventional screw clamps
- High clamping forces quickly and with little effort
- 360° swivelling lever avoids interfering edges
- Large clamping stroke: 9 mm

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
150	Max. 280	350	2,92	D28-07001-001
200	Max. 280	350	3,12	D28-07002-001

Compensating screw clamp D28 with short spindle

D28

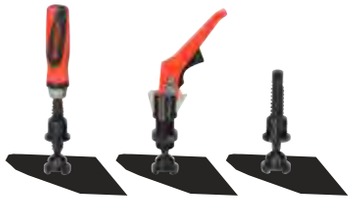


- Operation with open-ended spanner WAF 13
- Highly recommended for confined spaces

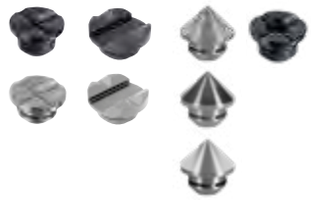
A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
150	Max. 280	350	2,54	D28-07001-002
200	Max. 280	350	2,74	D28-07002-002

Compatible system accessories

Exchangeable actuators
See page 210 onwards



Exchangeable taper and V-block holders
See page 212 onwards

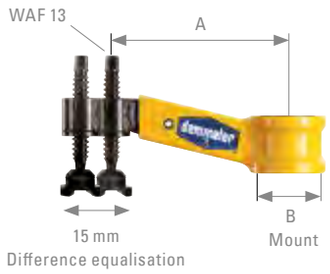


Debaenst Lastechniek



Compensating clamping arm with short spindle for heavy workpieces

- With difference equalisation for distortion-free workpiece clamping
- Used in combination with multi-clamping and support tower
- Very heavy-duty design
- Suitable for pre-tensioning heavy workpieces
- Fast and secure clamping
- Large adjustment range through combination with multi-clamping and support tower
- Clamping force approx. 20 kN
- Powder-coated



D28

Compensating clamping arm D28 with short spindle

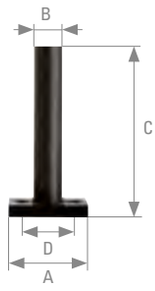
D28



A in mm	B in mm	Approx. weight in kg	Item no.
180	55	2,26	D28-05007-000

Multi-clamping and support tower

- For compensating clamping arm with short spindle
- Bolts to the table
- Very sturdy design
- Can be combined with other system components, such as stops, thanks to the system bore



D28

Multi-clamping and support tower D28

D28

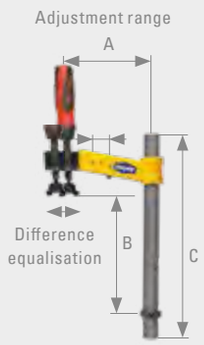


A in mm	B in mm	C in mm	D in mm	Approx. weight in kg	Item no.
150	55	200	100	4,00	D28-05004-003
150	55	350	100	5,30	D28-05004-000
150	55	700	100	8,38	D28-05005-000
150	55	1000	100	11,00	D28-05006-000

Debaenst Lastechniek

Compensating screw clamp D22

- For fast, powerful and accurately positioned clamping of many different workpieces
- For profiles that tend to tip
- With difference equalisation for accurately oriented and positioned workpiece clamping
- With adjusting ring for setting the required height
- Exchangeable actuator (e.g. spindle, short spindle or quick-action clamping cylinder)
- Clamping pad as standard – added value for your screw clamps



D22

Compensating screw clamp D22 with spindle

D22



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
125-150	Max. 210	300	1,5	D22-07001-000

Compensating screw clamp D22 with quick-action clamping cylinder

D22



- Up to 5x faster clamping than with conventional screw clamps
- High clamping forces quickly and with little effort
- 360° swivelling lever avoids interfering edges
- Large clamping stroke

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
125-150	Max. 210	300	1,8	D22-07001-001

Compensating screw clamp D22 with short spindle

D22

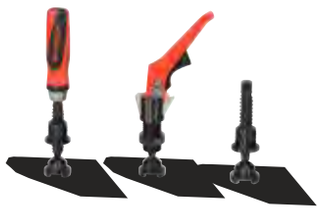


- Operation with open-ended spanner WAF 10
- Highly recommended for confined spaces

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
125-150	Max. 210	300	1,3	D22-07001-002

Compatible system accessories

Exchangeable actuators
See page 210 onwards



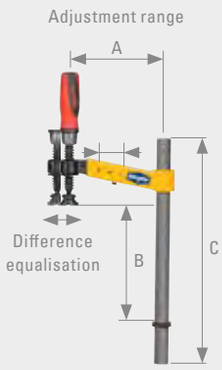
Clamping pad can be exchanged for a V-block
See page 212



Debaenst Lastechniek

Compensating screw clamp D16

- For fast, powerful and accurately positioned clamping of many different workpieces
- For profiles that tend to tip
- With difference equalisation for accurately oriented and positioned workpiece clamping
- With adjusting ring for setting the required height
- Exchangeable actuator (e.g. spindle, short spindle or quick-action clamping cylinder)
- Clamping pad can be exchanged for clamping other materials such as stainless steel
- Clamping pad as standard – added value for your screw clamps
- Exchangeable clamping tubes, available in different lengths



D16

Compensating screw clamp D16 with spindle

D16



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
100-125	Max. 200	250	0,66	D16-07001-000

Compensating screw clamp D16 with quick-action clamping cylinder

D16



- Up to 5x faster clamping than with conventional screw clamps
- High clamping forces quickly and with little effort
- 360° swivelling lever avoids interfering edges
- Large clamping stroke: 3.5 mm

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
100-125	Max. 200	250	0,68	D16-07001-001

Compensating screw clamp D16 with short spindle

D16

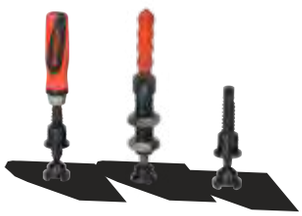


- Operation with open-ended spanner WAF 14
- Highly recommended for confined spaces

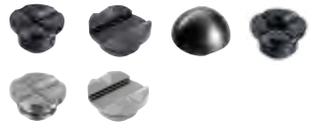
A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
100-125	Max. 200	250	0,6	D16-07001-002

Compatible system accessories

Exchangeable actuators
See page 210 onwards



Exchangeable spherical and V-block holders
See page 212 onwards



Debaenst Lastechniek

NEW DESIGN

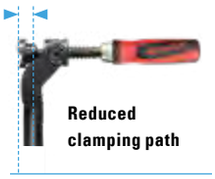
HIGH PERFORMANCE – perfect handling with the **DEMMELER performance screw clamp**

Continuous swivelling. Rotation through 360°. Universal applications made easy!

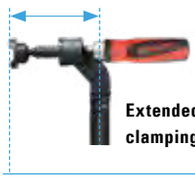




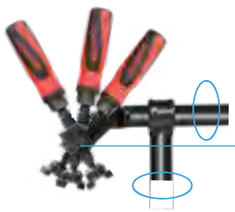
< Clamping spindle can be adjusted over 130 mm by rotating the retaining tube



Reduced clamping path



Extended clamping path



< Continuous swivelling and 360° rotating



< Can be folded together flat



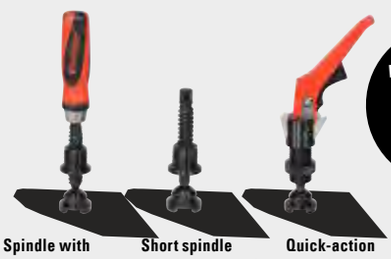
< Three exchangeable actuators (spindle, short spindle and quick-action clamping cylinder)

v Adjustable round tube

Max. 240 mm

Tube length
< 300 mm

^ Clamping pad with V-block: Self-centring clamping on the workpiece



Exchangeable spindle and quick-action clamping cylinder

Spindle with bushing and clamping pad
Item no.:
D28-07020-000

Short spindle with bushing and clamping pad
Item no.:
D28-07022-000

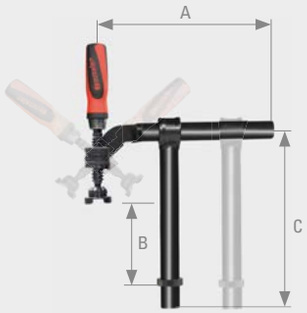
Quick-action clamping cylinder with clamping pad
Item no.:
D28-07021-004

Flexible down to the details. Thanks to its modular design, the performance screw clamp adapts perfectly to different clamping situations. The ability to continuously swivel and rotate through ±360° makes it possible to clamp round and rectangular workpieces horizontally/vertically and diagonally. Depending on the shape and characteristics of the item to be clamped, other pressure and support pieces are available for high-speed changeovers.

Debaenst Lastechniek

Performance screw clamp D28

- Universally usable for the horizontal/vertical and diagonal clamping of workpieces
- Continuous swivelling and 360° rotating
- Adjustment range of clamping spindle over 130 mm by rotating the retaining tube without having to move the clamp (previous version: 68 mm)
- Can be folded together flat (less storage space required)
- With three exchangeable actuators (spindle, short spindle and quick-action clamping cylinder)



D28

Performance screw clamp D28 with spindle



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
240	Max. 250	270	2,9	D28-07009-033
240	Max. 330	350	3,2	D28-07009-048
240	Max. 480	500	3,6	D28-07009-049

Performance screw clamp D28 with quick-action clamping cylinder



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
240	Max. 250	270	2,6	D28-07009-035
240	Max. 330	350	2,9	D28-07009-050
240	Max. 480	500	3,4	D28-07009-051

Performance screw clamp D28 with short spindle



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
240	Max. 250	270	2,2	D28-07009-034
240	Max. 330	350	2,5	D28-07009-053
240	Max. 480	500	3,0	D28-07009-054

Typical potential applications



Confined spaces. The DEMMELER performance screw clamp allows simple clamping even in hard-to-reach places. At the same time, the clamping pad with V-block ensures central force distribution.



Accurately positioned clamping. The performance screw clamp always provides a secure hold, even when workpieces are clamped at an angle. With continuous swivelling and 360° rotation, it adapts to every clamping situation.



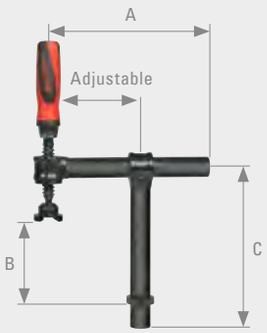
Extended adjustment range. Thanks to the new shape, it is possible to clamp nearby workpieces as well as workpieces at a greater distance from the next system bore without any hassle.

Debaenst Lastechniek

Screw clamp 180° D28

- With adjustable, robust round tube
- Each tube can be used individually
- Adjustable projection
- Can be inserted into system bores, eliminating unnecessary interfering edges
- Highest force transmission thanks to sturdy round tubes
- Entire clamping mechanism is exchangeable

TOP SELLER



D28

Screw clamp 180° D28 with spindle

D28



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
220	Max. 190	270	2,80	D28-07005-000
220	Max. 270	350	3,10	D28-07005-014
220	Max. 420	500	3,80	D28-07005-033

Screw clamp 180° D28 with quick-action clamping cylinder

D28



- Up to 5x faster clamping than with conventional screw clamps
- High clamping forces quickly and with little effort
- 360° swivelling lever avoids interfering edges
- Large clamping stroke: 9 mm

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
220	Max. 190	270	2,50	D28-07005-001
220	Max. 270	350	2,80	D28-07005-015
220	Max. 420	500	3,40	D28-07005-041

Screw clamp 180° D28 with short spindle

D28

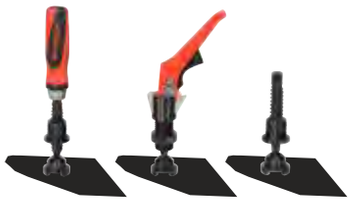


- Operation with open-ended spanner WAF 13
- Highly recommended for confined spaces

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
220	Max. 190	270	2,10	D28-07005-002
220	Max. 270	350	2,30	D28-07005-016
220	Max. 420	500	3,00	D28-07005-036

Compatible system accessories

Exchangeable actuators
See page 210 onwards



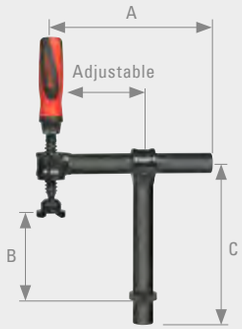
Exchangeable taper and V-block holders
See page 212 onwards



Debaenst Lastechniek

Screw clamp 180° D22

- With adjustable, robust round tube
- Each tube can be used individually
- Adjustable projection
- Can be inserted into system bores, eliminating unnecessary interfering edges
- Highest force transmission thanks to sturdy round tubes
- Entire clamping mechanism is exchangeable



D22

Screw clamp 180° D22 with spindle

D22



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
175	Max. 200	300	1,20	D22-07005-000

Screw clamp 180° D22 with quick-action clamping cylinder

D22



- Up to 5x faster clamping than with conventional screw clamps
- High clamping forces quickly and with little effort
- 360° swivelling lever avoids interfering edges
- Large clamping stroke

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
175	Max. 200	300	1,50	D22-07005-001

Screw clamp 180° D22 with short spindle

D22



- Operation with open-ended spanner WAF 10
- Highly recommended for confined spaces

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
175	Max. 200	300	2,10	D22-07005-004



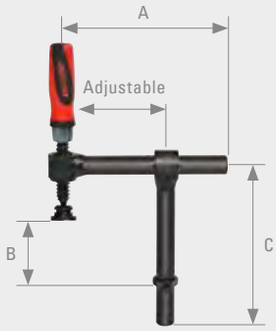




Debaenst Lastechniek

Screw clamp 180° D16

- With adjustable, robust round tube
- Each tube can be used individually
- Adjustable projection
- Can be inserted into system bores, eliminating unnecessary interfering edges
- Highest force transmission thanks to sturdy round tubes
- Entire clamping mechanism is exchangeable



D16

Screw clamp 180° D16 with spindle

D16



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
130	Max. 90	130	0,52	D16-07005-000

Screw clamp 180° D16 with quick-action clamping cylinder

D16



- Up to 5x faster clamping than with conventional screw clamps
- High clamping forces quickly and with little effort
- 360° swivelling lever avoids interfering edges
- Large clamping stroke: 3.5 mm

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
130	Max. 90	130	0,58	D16-07005-001

Screw clamp 180° D16 with short spindle

D16

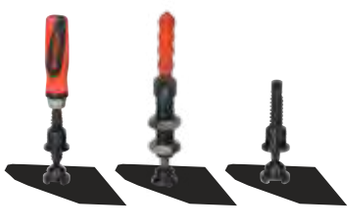


- Operation with open-ended spanner WAF 14
- Highly recommended for confined spaces

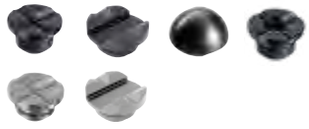
A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
130	Max. 90	130	0,50	D16-07005-002

Compatible system accessories

Exchangeable actuators
See page 210 onwards



Exchangeable spherical and V-block holders
See page 212 onwards

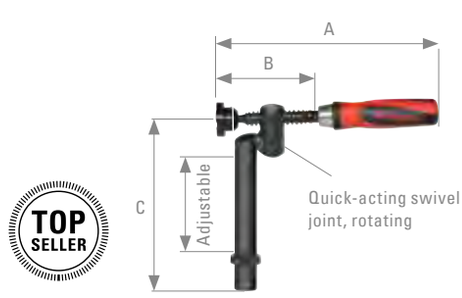


Debaenst Lastechniek



Variable screw clamp 90°

- Pressure direction 90° relative to the system bore
- Spindle stroke approx. 70 mm
- 180° quick-acting swivel joint with ball locking device in the joint
- With adjusting ring for setting the required height
- Clamping bridges can be used
- Highest force transmission thanks to sturdy round tube
- Exchangeable clamping pad



TOP SELLER

D28
D16

Variable screw clamp 90° D28

D28



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
250	Max. 100	220	1,22	D28-07008-000
250	Max. 100	350	1,65	D28-07008-010
250	Max. 100	500	2,08	D28-07008-012

Variable screw clamp 90° D16

D16



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
150	Max. 40	150	0,30	D16-07008-000

Perfect positioning on all locating surfaces

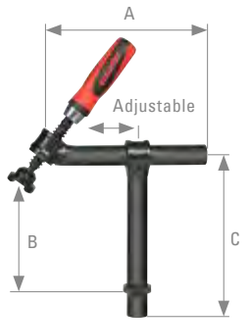
Thanks to the optimum effect of force
with the DEMMELER 45° variable screw clamp.



Debaenst Lastechniek

Variable screw clamp 45° D28

- Highest force transmission thanks to sturdy round tubes
- Ideal for clamping V-block profiles, as well as rectangular and square profiles
- Entire clamping mechanism is exchangeable
- Perfect positioning on all locating surfaces thanks to optimum effect of force



D28

Variable screw clamp 45° D28 with spindle

D28



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
220	Max. 190	270	2,80	D28-07009-000
220	Max. 270	350	3,00	D28-07009-011
220	Max. 420	500	3,70	D28-07009-026

Variable screw clamp 45° D28 with quick-action clamping cylinder D28

D28



- Up to 5x faster clamping than with conventional screw clamps
- High clamping forces quickly and with little effort
- 360° swivelling lever avoids interfering edges
- Large clamping stroke: 9 mm

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
220	Max. 190	270	2,50	D28-07009-001
220	Max. 270	350	2,70	D28-07009-012
220	Max. 420	500	3,20	D28-07009-027

Variable screw clamp 45° D28 with short spindle

D28

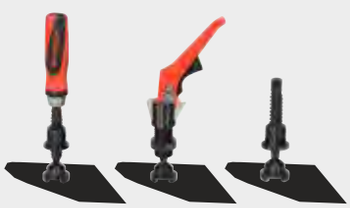


- Operation with open-ended spanner WAF 13
- Highly recommended for confined spaces

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
220	Max. 190	270	2,10	D28-07009-002
220	Max. 270	350	2,30	D28-07009-013
220	Max. 420	500	3,00	D28-07009-028

Compatible system accessories

Exchangeable actuators
See page 210 onwards



Exchangeable taper and V-block holders
See page 212 onwards



Debaenst Lastechniek

Variable screw clamp 45° D22

- Highest force transmission thanks to sturdy round tubes
- Ideal for clamping V-block profiles, as well as rectangular and square profiles
- Entire clamping mechanism is exchangeable
- Perfect positioning on all locating surfaces thanks to optimum effect of force



D22

Variable screw clamp 45° D22 with spindle

D22



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
175	Max. 200	300	1,20	D22-07009-000

Variable screw clamp 45° D22 with quick-action clamping cylinder D28

D22



- Up to 5x faster clamping than with conventional screw clamps
- High clamping forces quickly and with little effort
- 360° swivelling lever avoids interfering edges
- Large clamping stroke

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
175	Max. 200	300	1,50	D22-07009-001

Variable screw clamp 45° D22 with short spindle

D22

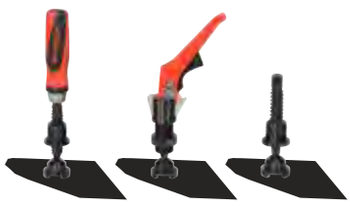


- Operation with open-ended spanner WAF 10
- Highly recommended for confined spaces

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
175	Max. 200	300	2,10	D22-07009-004

Compatible system accessories

Exchangeable actuators
See page 210 onwards



Clamping pad can be exchanged for a V-block
See page 212



Debaenst Lastechniek

Variable screw clamp 45° D16

- Highest force transmission thanks to sturdy round tubes
- Ideal for clamping V-block profiles, as well as rectangular and square profiles
- Entire clamping mechanism is exchangeable
- Perfect positioning on all locating surfaces thanks to optimum effect of force

D16



Variable screw clamp 45° D16 with spindle

D16



A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
130	Max. 90	130	0,50	D16-07009-000

Variable screw clamp 45° D16 with quick-action clamping cylinder D28

D16



- Up to 5x faster clamping than with conventional screw clamps
- High clamping forces quickly and with little effort
- 360° swivelling lever avoids interfering edges
- Large clamping stroke: 3.5 mm

A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
130	Max. 90	130	0,58	D16-07009-001

Variable screw clamp 45° D16 with short spindle

D16

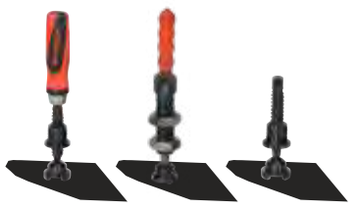


- Operation with open-ended spanner WAF 14
- Highly recommended for confined spaces

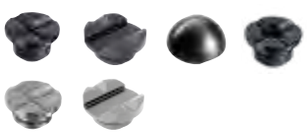
A in mm	B Clamp capacity in mm	C in mm	Approx. weight in kg	Item no.
130	Max. 90	130	0,46	D16-07009-002

Compatible system accessories

Exchangeable actuators
See page 210 onwards



Exchangeable spherical and V-block holders
See page 212 onwards



Debaenst Lastechniek





Intelligent solutions for a wide range of clamping tasks

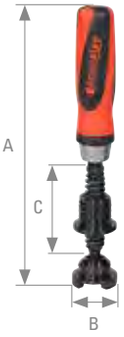
With the exchangeable actuators for all round tube clamps:

> Spindle
> Quick-action clamping cylinder
> Short spindle



Spindle with bushing and clamping pad

- High-quality two-component plastic handle
- Long threaded spindle
- Threaded bushing can be used in any system bore
- Clamping pad can be exchanged and used as a support in any system bore
- Suitable for pre-tensioning workpieces
- Slip-proof handle thanks to rubberised inserts
- Clamping with standard hex wrench



Clamping pad with cross V-block

D28
D22
D16

Spindle D28 with bushing and clamping pad — **D28**



A in mm	Ø B in mm	C in mm	Approx. weight in kg	Item no.
255	40	70	0,50	D28-07020-000

Spindle D22 with bushing and clamping pad — **D22**



A in mm	Ø B in mm	C in mm	Approx. weight in kg	Item no.
200	32	70	0,54	D22-07020-001

Spindle D16 with bushing and clamping pad — **D16**



A in mm	Ø B in mm	C in mm	Approx. weight in kg	Item no.
148	22	45	0,14	D16-07020-000

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Quick-action clamping cylinder with clamping pad

- Up to 5x faster clamping than with conventional screw clamps
- The locking mechanism ensures controlled, fast and vibration-proof clamping
- Large clamping stroke
- The self-centring support and pressure piece clamps the workpiece and can be exchanged
- The powder-coated clamping lever has a highly ergonomic shape
- The plastic-coated, non-slip release lever ensures a secure grip when releasing the clamp



Clamping pad with cross V-block

D28
D22
D16

Quick-action clamping cylinder D28 with clamping pad — D28



A in mm	Ø B in mm	C in mm	Approx. weight in kg	Item no.
approx. 105+9	40	70	0,88	D28-07021-004

Quick-action clamping cylinder D22 with clamping pad — D22



A in mm	Ø B in mm	C in mm	Approx. weight in kg	Item no.
approx. 90+9	32	70	0,60	D22-07021-001

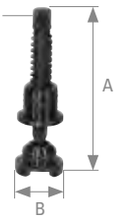
Quick-action clamping cylinder D16 with clamping pad — D16



A in mm	Ø B in mm	C in mm	Approx. weight in kg	Item no.
approx. 80+3	22	30	0,18	D16-07021-000

Short spindle with bushing and clamping pad

- Highly recommended for confined spaces
- Actuation with open-ended spanner WAF 13 (D28), WAF 10 (D22) or WAF 14 (D16)
- Direct use in system bores possible
- Ideal for pre-tensioning workpieces



Clamping pad with cross V-block

D28
D22
D16

Short spindle D28 with bushing and clamping pad — D28



A in mm	Ø B in mm	Approx. weight in kg	Item no.
138	40	0,36	D28-07022-000

Short spindle D22 with bushing and clamping pad — D22



A in mm	Ø B in mm	Approx. weight in kg	Item no.
110	32	0,20	D22-07022-000

Short spindle D16 with bushing and clamping pad — D16



A in mm	Ø B in mm	Approx. weight in kg	Item no.
70	22	0,10	D16-07022-000

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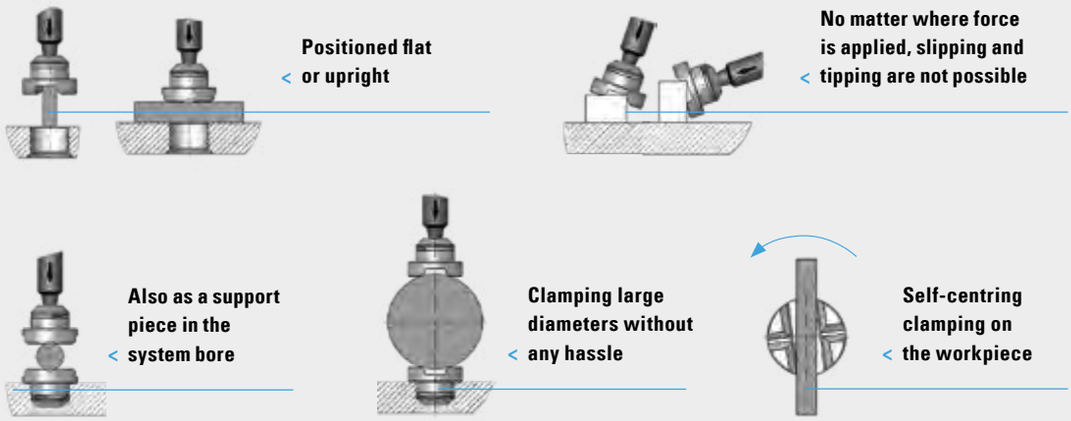
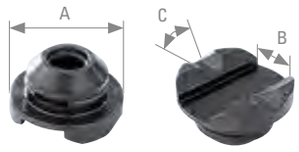
No slipping or tipping

when using the self-centring clamping pad with V-block



Pressure and support piece/clamping pad with V-block

- Rapid replacement: No tools, no screws
- O-ring prevents dirt from getting into the joint
- Produced in various materials
- Precisely supported on the workpiece thanks to pendulum compensation
- With cross V-block for clamping round/rectangular tubes
- Can also be used as a support in any system bore



D28
D22
D16

Clamping pad D28 with V-block, burnished steel — D28



Ø A in mm	B in mm	C in °	Approx. weight in kg	Quantity	Item no.
40	15,5	120	0,112	1 unit	D28-07011-022
40	15,5	120	1,12	10 units	D28-07011-023

Clamping pad D28 with V-block, aluminium — D28



Ø A in mm	B in mm	C in °	Approx. weight in kg	Quantity	Item no.
40	15,5	120	0,04	1 unit	D28-07011-025
40	15,5	120	0,4	10 units	D28-07011-026

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Clamping pad D22 with V-block, burnished steel — D22



Ø A in mm	B in mm	C in °	Approx. weight in kg	Quantity	Item no.
32	8 ,0	120	0,05	1 unit	D22-07011-001

Clamping pad D22 with V-block, aluminium — D22



Ø A in mm	B in mm	C in °	Approx. weight in kg	Quantity	Item no.
32	8,0	120	0,02	1 unit	D22-07011-000

Clamping pad D16 with V-block, burnished steel — D16

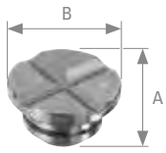


Ø A in mm	B in mm	C in °	Approx. weight in kg	Quantity	Item no.
22	8,0	120	0,1	1 unit	D16-07011-015
22	8,0	120	1	10 units	D16-07011-016

Pressure and support piece

- Rapid replacement: No tools, no screws
- O-ring prevents dirt from getting into the joint
- Produced in various materials
- Precisely supported on the workpiece thanks to pendulum compensation
- With cross V-block for clamping round/rectangular tubes
- Can also be used as a support in any system bore





D28
D16

Pressure and support piece D28, stainless steel — D28



A in mm	Ø B in mm	Approx. weight in kg	Item no.
22	40	0,10	D28-07011-001

Pressure and support piece D28, POM — D28



A in mm	Ø B in mm	Approx. weight in kg	Item no.
22	40	0,02	D28-07011-002

Pressure and support piece D16, burnished steel — D16



A in mm	Ø B in mm	Approx. weight in kg	Item no.
13	22	0,02	D16-07011-000

Pressure and support piece D16, stainless steel — D16



A in mm	Ø B in mm	Approx. weight in kg	Item no.
13	22	0,02	D16-07011-001

Pressure and support piece D16, POM — D16



A in mm	Ø B in mm	Approx. weight in kg	Item no.
13	22	0,004	D16-07011-002

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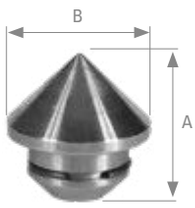
Pressure and support piece with taper

- Rapid replacement: No tools, no screws
- O-ring prevents dirt from getting into the joint
- Produced in various materials
- Precisely supported on the workpiece thanks to pendulum compensation
- With 90° taper to clamp tubes on the inner diameter Ø 10 – 58 mm

D28





Pressure and support piece D28 with taper, hardened steel



	D28
A in mm	40
Ø B in mm	40
Approx. weight in kg	0,16
Angle	90°
Description	Hardened steel
Item no.	D28-07011-027



Pressure and support piece D28 with taper, stainless steel

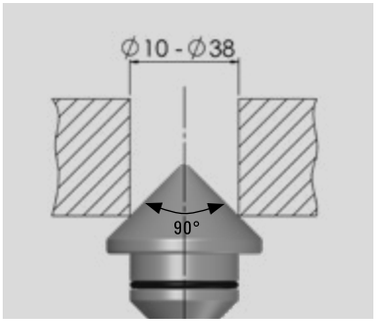


	D28
A in mm	40
Ø B in mm	40
Approx. weight in kg	0,16
Angle	90°
Description	Stainless steel
Item no.	D28-07011-028

Pressure and support piece D28 with taper, aluminium



	D28
A in mm	40
Ø B in mm	40
Approx. weight in kg	0,16
Angle	90°
Description	Aluminium
Item no.	D28-07011-029



Debaenst Lastechniek

Clamping pad with spherical shape

- Rapid replacement without tools, without screws
- O-ring prevents dirt from getting into the joint
- Produced in various materials
- With ball, specially for clamping corner profiles
- Clamping pad compensates for angle errors
- Precisely supported on the workpiece thanks to pendulum compensation

D28
D16



Clamping pad D28/D16 with spherical shape, burnished steel	D28	D16
A in mm	21,5	13
Ø B in mm	35	20
Approx. weight in kg	0,09	0,02
Description	Burnished steel	Burnished steel
Item no.	D28-07011-004	D16-07011-005

Clamping pad D28/D16 with spherical shape, stainless steel	D28	D16
A in mm	21,5	13
Ø B in mm	35	20
Approx. weight in kg	0,09	0,02
Description	Stainless steel	Stainless steel
Item no.	D28-07011-005	D16-07011-006

Clamping pad D28/D16 with spherical shape, POM	D28	D16
A in mm	21,5	13
Ø B in mm	35	20
Approx. weight in kg	0,08	0,004
Description	POM	POM
Item no.	D28-07011-006	D16-07011-007

Clamping pad D28/D16 with spherical shape, aluminium	D28	D16
A in mm	21,5	13
Ø B in mm	35	20
Approx. weight in kg	0,035	0,02
Description	Aluminium	Aluminium
Item no.	D28-07011-020	D16-07011-012

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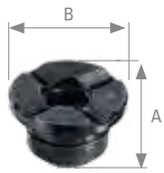
Clamping pad, steel double-sided

- Rapid replacement: No tools, no screws
- O-ring prevents dirt from getting into the joint
- Precisely supported on the workpiece thanks to pendulum compensation
- With cross V-block for clamping round/rectangular tubes
- Can also be used as a support in any system bore
- Can be used on both sides

D28





Clamping pad D28, steel double-sided — D28

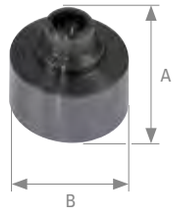


A in mm	Ø B in mm	Approx. weight in kg	Item no.
25	40	0,08	D28-07011-010

Clamping pad blank

- For customer-specific adaptation
- Mount for DEMMELER system screw clamps already present
- Burnished steel

D28



Clamping pad D28 blank, burnished steel — D28



A in mm	Ø B in mm	Approx. weight in kg	Item no.
35	50	0,32	D28-07014-000

Clamping pad D16 blank, burnished steel — D16

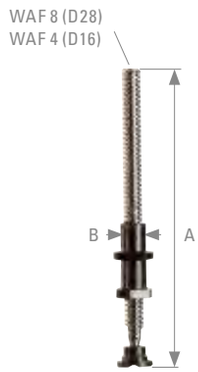


A in mm	Ø B in mm	Approx. weight in kg	Item no.
25	22	0,05	D16-07014-000

Adjusting spindle

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

D28
D16



Adjusting spindle D28 — D28



A in mm	B in mm	Approx. weight in kg	Item no.
255	28	0,78	D28-09008-000

Adjusting spindle D16 — D16



A in mm	B in mm	Approx. weight in kg	Item no.
180	16	0,18	D16-09008-000

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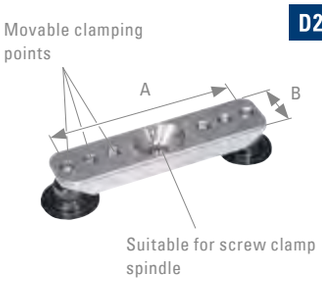
2P. Clamping bridge with two clamping pads, steel

- Two clamping points at the same time
- Clamping in hard-to-reach positions
- Simultaneous clamping of multiple components
- Clamping uneven surfaces or different heights through pendulum compensation
- Clamping pad distance can be shifted with self-locking ball pins
- Exchangeable clamping pad
- For attachment to any spherical mount
- Very stable shape
- Scope of delivery: Galvanised clamping bridge, two spherical pins and two clamping pads (steel)

D28



2P. Clamping bridge D28 with two clamping pads, steel — D28



A in mm	Ø B in mm	Approx. weight in kg	Item no.
130 / 97,5 / 65	35	0,56	D28-07018-000

VARIO adjusting ring for screw clamp round tubes

- For fixing screw clamps at a set height
- Included in the scope of delivery for all round tube screw clamps

D28
D16



Adjusting ring VARIO D28 for screw clamp round tubes — D28



A in mm	Ø B in mm	Approx. weight in kg	Item no.
10	28	0,05	D28-07003-000

Adjusting ring VARIO D16 for screw clamp round tubes — D16



A in mm	Ø B in mm	Approx. weight in kg	Item no.
6	16	0,01	D16-07003-000

Clamping tube

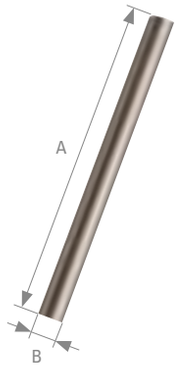
- Precision clamping tube to fit any system bore
- E.g. for compensating screw clamps (from page 196)

D28
D16

Clamping tube D28



A in mm	Ø B in mm	Approx. weight in kg	Item no.
200	28	0,57	D28-07004-000
350	28	1,00	D28-07004-001
600	28	1,70	D28-07004-002
1000	28	2,85	D28-07004-003



Clamping tube D16



A in mm	Ø B in mm	Approx. weight in kg	Item no.
125	16	0,30	D16-07004-000
250	16	0,30	D16-07004-001
600	16	0,75	D16-07004-002
1000	16	1,20	D16-07004-003

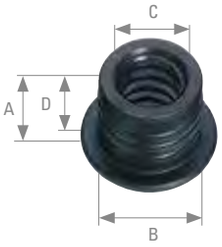
It doesn't get more modular than this.

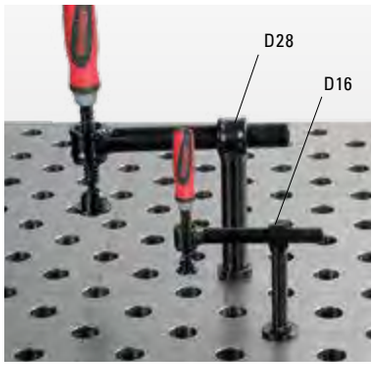
Compatibility for tools from D28 | D22 | D16

Reducer bushing D16 to D28/D16 to D22

- Used to mount Ø 16 mm screw clamps in D28 and D22 system bores
- The D16 quick-action clamping cylinder can be used in system D28 or D22
- Can be used as a support or stop simultaneously
- Threaded bushing for D28 or D22 screw clamp

D28
D22
D16









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Reducer bushing D16 to D28 — D16 / D28



A in mm	Ø B in mm	Ø C in mm	D in mm	Approx. weight in kg	Item no.
30	28	16	25	0,10	D00-06012-000

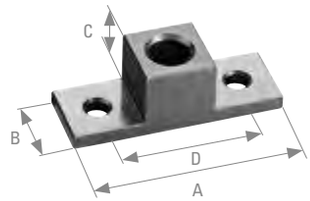
Reducer bushing D16 to D22 — D16 / D22



A in mm	Ø B in mm	Ø C in mm	D in mm	Approx. weight in kg	Item no.
28,5	22	16	25	0,07	D22-06012-001

Interface plates

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



D28
D22
D16

Interface plates for clamping tubes D28 to D16 — D28 / D16



A in mm	B in mm	C in mm	D in mm	Approx. weight in kg	Item no.
150	50	50	100	1,04	D00-06015-000

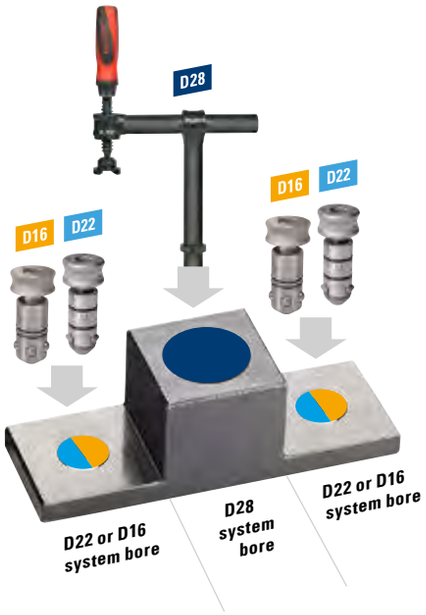
Interface plates for clamping tubes D28 to D22 — D28 / D22



A in mm	B in mm	C in mm	D in mm	Approx. weight in kg	Item no.
150	50	50	100	1,2	D00-06015-001



Use clamps and V-blocks from system D28 in systems D22 and D16 too
The interface plate makes it possible for you to use clamps and V-blocks from system D28 in systems D22 and D16 too.



Angle bushing 90°

- Can be used as a corner stop
- Axis spacing 50 mm

D28



Angle bushing 90° D28

D28

	A in °	Ø B in mm	Approx. weight in kg	Item no.
	90	28	0,30	D28-07034-000

Deflector bushing with precision scaling in 15° increments

- User-friendly 360° precision scaling
- Especially useful when used with variable clamps (from page 226)
- Can also be used in combination with short or normal spindle with threaded bushing
- Axis spacing: 38 mm

D28



Deflector bushing 90° D28 with precision scaling

D28

	A in mm	Ø B in mm	Approx. weight in kg	Item no.
	38	28	0,31	D28-07034-010

Deflector bushing 45° D28 with precision scaling

D28

	A in mm	Ø B in mm	Approx. weight in kg	Item no.
	38	28	0,31	D28-07035-010





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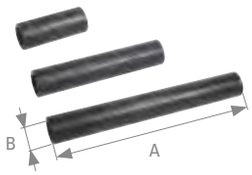
Adapter tube

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



D28
D16

Adapter tube D28 — D28



A in mm	Ø B in mm	Approx. weight in kg	Item no.
100	28 / 40	0,40	D28-09010-000
200	28 / 40	1,05	D28-09010-001
300	28 / 40	1,70	D28-09010-002

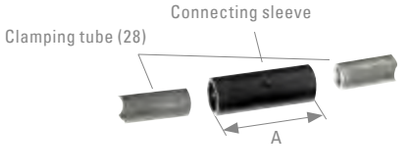
Adapter tube D16 — D16



A in mm	Ø B in mm	Approx. weight in kg	Item no.
100	16 / 28	0,34	D16-09010-000
200	16 / 28	0,80	D16-09010-001
300	16 / 28	1,20	D16-09010-002

Connecting sleeve

- As a connecting piece between two clamping tubes
- As a connecting piece between the screw clamp and clamping tube
- Burnished



D28

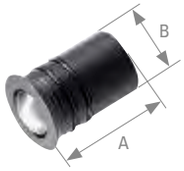
Connecting sleeve D28 — D28



A in mm	Ø B in mm	Approx. weight in kg	Item no.
100	28 / 38	0,40	D28-07010-000

Ball clamp bushing with countersunk head

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



D28

Ball clamp bushing D28 with countersunk head — D28



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



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Quick-release toggle clamp
Pneumatic toggle clamp

Quick-release toggle clamp		Pneumatic toggle clamp	Quick-release toggle clamp
D28		D28	D16
 **Variable clamp with threaded bushing** page 226	 **Vertical toggle clamp with adapter** page 228	 **Pneumatic toggle clamp XL** page 231	 **Variable clamp with adapter** page 226
 **Variable clamp with adapter** page 226	 **Vertical toggle clamp with universal stop** page 229	 **Pneumatic toggle clamp S** page 232	 **Vertical toggle clamp with adapter** page 228
 **Universal variable clamp** page 227	 **Horizontal toggle clamp with universal stop** page 230	 **Manifold with hand valve** page 233	 **Adapter for quick-release toggle clamp** page 230
 **Two-point clamp with adapter** page 228	 **Adapter for quick-release toggle clamp** page 230	 **Pressure booster** page 233	
		 **Magnetic clamps** page 233	



Variable clamp
Clamping with minimal set-up time



Vertical toggle clamp
Always a simple solution



Horizontal toggle clamp
Quick clamping
for large quantities

Debaenst Lastechniek

Quick-release toggle clamps from DEMMELER – manual or pneumatic

DEMMELER's range of manual or pneumatic quick-release toggle clamps is diverse enough to perform a wide variety of applications. Our extensive range includes the ideal clamping element for any requirement. The products stand out due to their durability in particular. Alongside favourable force and movement conditions, all products are easy to use in everyday applications. The entire range of mechanical clamping elements is designed to consistently reduce complexity and optimise processes with fast and simple clamping options.



Pneumatic toggle clamp
Automated clamping
for higher quantities

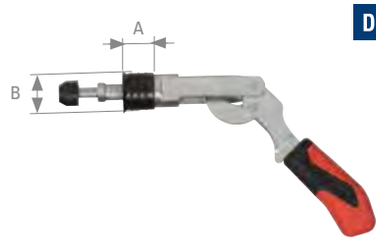


Magnetic clamp
Fast and easy positioning
of lightweight parts

Variable clamp with threaded bushing

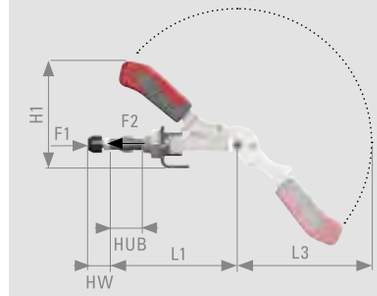
- Long push rod guide with mounting thread and nut
- Ergonomic, oil-resistant handle with large grip and soft component
- With tempered, galvanised clamping screw
- Including threaded bushing for use in system bores
- 32 mm stroke
- Galvanised and passivated clamp, burnished adapter

D28



Variable clamp D28 with threaded bushing	D28
A in mm	30
Ø B in mm	28
Approx. weight in kg	0,4
H1	110
L1	140
L3	129
HW	22 - 35
STROKE	32
F1 in kN	2,5
F2 in kN	2,5
Item no.	D28-08000-000

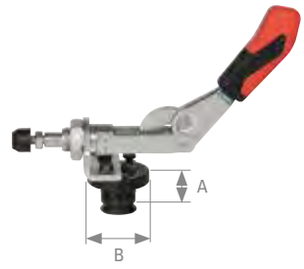




Variable clamp with adapter and countersunk screw

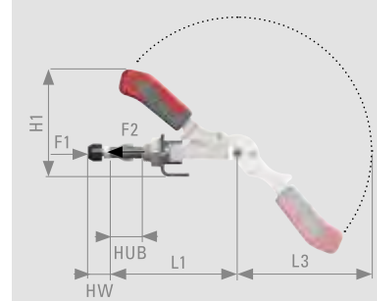
- Long push rod guide with mounting thread and nut
- Ergonomic, oil-resistant handle with large grip and soft component
- With tempered, galvanised clamping screw
- With adapter and countersunk screw to fit system bores
- Galvanised and passivated clamp, burnished adapter
- With universal stop for indirect mounting, therefore continuously adjustable

D28
D16



Variable clamp D28/D16 with adapter and countersunk screw	D28	D16
A in mm	27	15
Ø B in mm	50	38
Thread pitch in mm	32 x 20	24 x 16
Approx. weight in kg	0,74	0,22
H1	110	60
L1	140	91
L3	129	72
HW	22 - 35	12 - 20
STROKE	32	20
F1 in kN	2,5	1,0
F2 in kN	2,5	1,0
Item no.	D28-08002-000	D16-08002-000





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^ **Variable clamp with threaded bushing**



^ **Variable clamp with adapter and countersunk screw**

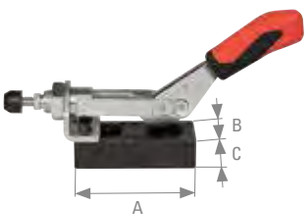


^ **Universal variable clamp**

Universal variable clamp (with universal stop)

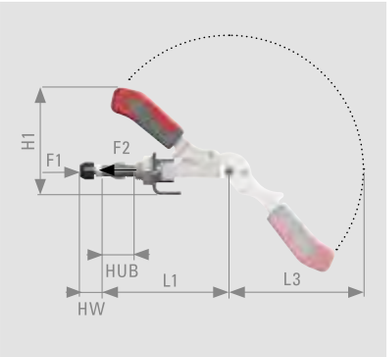
- Long push rod guide with mounting thread and nut
- Ergonomic, oil-resistant handle with large grip and soft component
- With tempered, galvanised clamping screw
- 32 mm stroke
- Including universal stop with thread for moving the variable clamp
- Galvanised and passivated clamp, burnished stop

D28





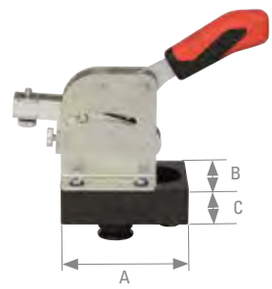
Universal variable clamp D28	D28
A in mm	100
B in mm	50
C in mm	25
Approx. weight in kg	1,08
H1	110
L1	140
L3	129
HW	22 - 35
STROKE	32
F1 in kN	2,5
F2 in kN	2,5
Item no.	D28-08001-010



Two-point clamp with adapter

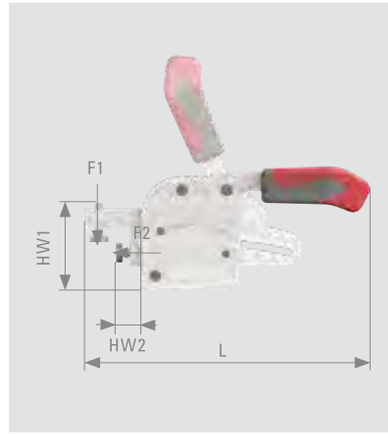
- Positioning and clamping in one process step:
  The combination clamp converts the movement of the lever arm into a horizontal and vertical clamping movement, so the workpiece is positioned and clamped simultaneously
- Robust and stable design
- Easy removal of the workpiece by fully retracting the clamping arm
- With adapter to fit system bores, continuously adjustable
- Galvanised and passivated clamp, burnished adapter

D28





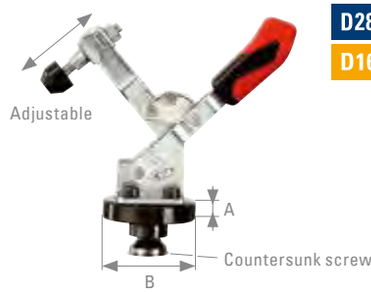
Two-point clamp D28 with adapter	D28
A in mm	100
B in mm	70
C in mm	30
Approx. weight in kg	1,8
H1	94
H2	87
L1	219
HW1	30 - 40
HW2	10 - 20
F1 in kN	2,0
F2 in kN	2,0
Item no.	D28-08007-000



Vertical toggle clamp with adapter and countersunk screw

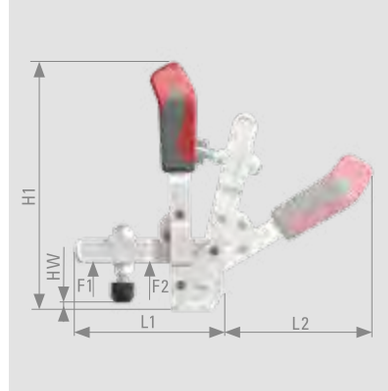
- With open support arm and horizontal leg
- Ergonomic, oil-resistant handle with large grip and soft component
- Safety clamping piece with finger guard
- Captive clamping screw at clamping arm end
- With adapter and countersunk screw to fit any system bore
- Clamping range 0–50 mm (D28) or 0–25 mm (D16)
- Galvanised and passivated clamp, burnished adapter
- With universal stop for indirect mounting, therefore continuously adjustable

D28
D16





Vertical toggle clamp D28/D16 with adapter and countersunk screw	D28	D16
A in mm	27	15
Ø B in mm	50	38
Thread pitch in mm	32 x 20	24 x 16
Approx. weight in kg	0,74	0,22
H1	186	98,5
L1	112	61
L2	112	59
HW	2 - 11	-4 - 2
F1 in kN	1,1	0,6
F2 in kN	2,5	1,1
Item no.	D28-08001-000	D16-08001-000



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Vertical toggle clamp with universal stop

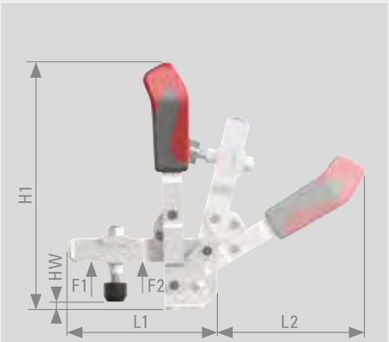
- With open support arm and horizontal leg
- Greased bearing points
- Ergonomic, oil-resistant handle with large grip and soft component
- Safety clamping piece with finger guard
- Captive clamping screw at clamping arm end
- Clamping range: 0–50 mm
- Including universal stop with thread for moving the vertical toggle clamp
- Galvanised and passivated clamp, burnished adapter

D28

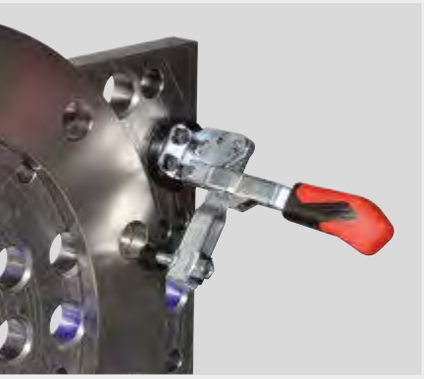


Vertical toggle clamp D28 with universal stop	D28
A in mm	100
B in mm	50
C in mm	25
Approx. weight in kg	0,98
H1	186
L1	112
L2	112
HW	2 - 11
F1 in kN	1,1
F2 in kN	2,5
Item no.	D28-08003-010





Vertical toggle clamp with adapter and countersunk screw



Vertical toggle clamp with universal stop



Two-point clamp with adapter

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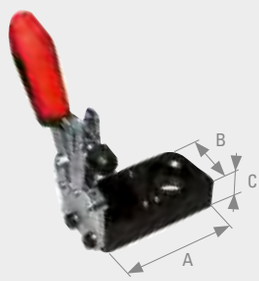
Horizontal toggle clamp with universal stop

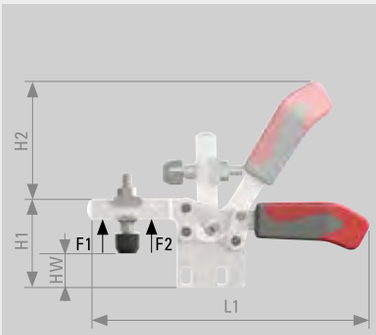
- With open support arm and vertical leg
- Greased bearing points
- Ergonomic, oil-resistant handle with large grip and soft component
- With captive clamping screw
- Including universal stop with thread for moving the horizontal toggle clamp
- Galvanised and passivated clamp, burnished stop

D28



Horizontal toggle clamp D28 with universal stop	D28
A in mm	100
B in mm	50
C in mm	25
Approx. weight in kg	0,98
H1	65
L1	86
L2	206
HW	14,5 - 26
F1 in kN	1,8
F2 in kN	2,5
Item no.	D28-08002-010





Adapter for quick-release toggle clamp with countersunk screw

- Adapter to mount conventional quick-release toggle clamps
- Scope of delivery:
  1x adapter,
  4x hexagon screw M6 x 12,
  1x countersunk screw M16 x 30

D28
D16



Adapter for quick-release toggle clamp D28/D16 with countersunk screw	D28	D16
A in mm	27	15
Ø B in mm	50	38
Thread pitch in mm	32 x 20	24 x 16
Approx. weight in kg	0,26	0,22
Item no.	D28-08005-000	D16-08005-000



Debaenst Lastechniek



NEW DESIGN



Mounting at the bottom
Flexible adjustment of the clamping stroke using the movable holder

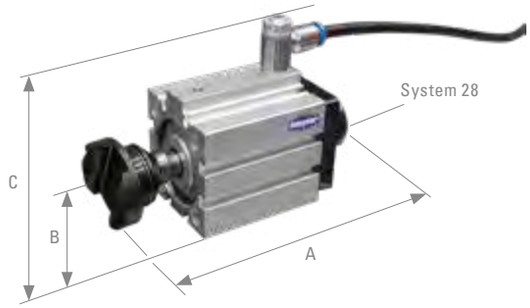


Mounting at the rear
Compact design for all clamping situations

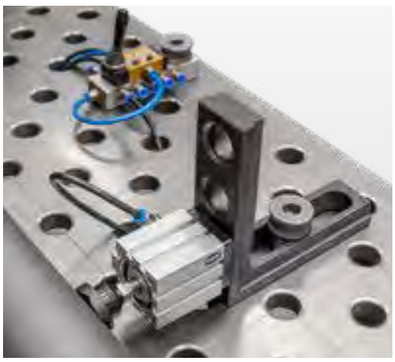
Pneumatic toggle clamp XL

- Single-acting pneumatic cylinder
- With compression spring retraction
- Including manual gate valve
- Fits all D28 system bores thanks to the mount
- Including continuously variable length adjustment (adjustment distance approx. 40 mm)
- Clamping stroke: 25 mm
- Force: F6 = approx. 500 N at 6 bar, F8 = approx. 680 N at 8 bar

D28



Pneumatic toggle clamp D28 XL	D28
A in mm	131,5
Ø B in mm	53
C in mm	87,2
Approx. weight in kg	1,74
Item no.	D28-13015-001



Pneumatic toggle clamp S

D28

- Single-acting pneumatic cylinder
- With compression spring retraction and 3/2-way valve
- Fits all D28 bores
- Stroke: 30 mm
- Force:
  F6 = 41 N at 6 bar
  F8 = 117 N at 8 bar
  F10 = 193 N at 10 bar
  F20 = 573 N at 20 bar
  F30 = 953 N at 30 bar
  F40 = 1146 N at 40 bar

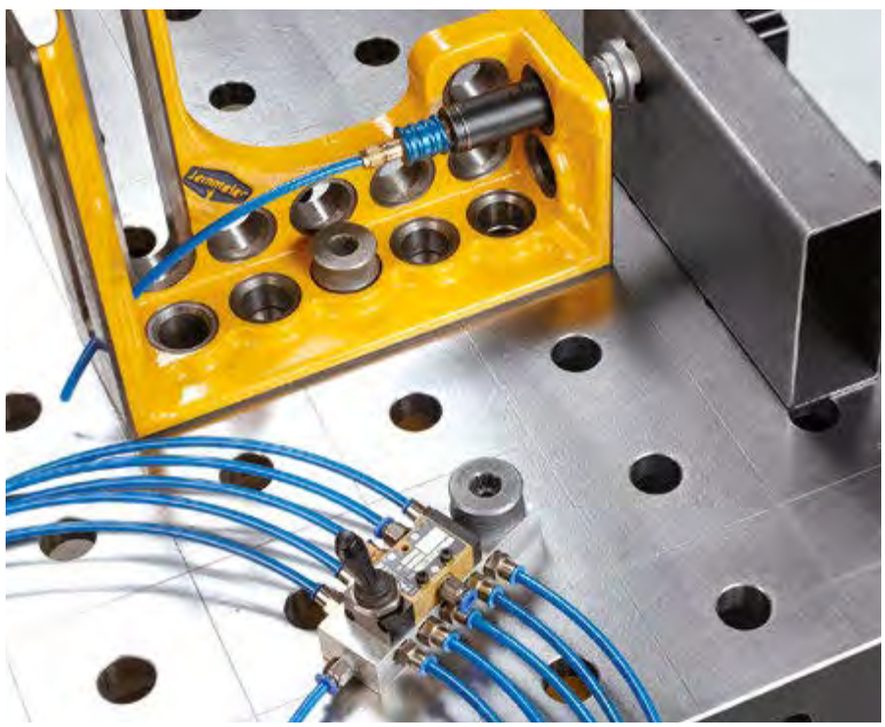


- Recommended accessory: Pressure booster page 233

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







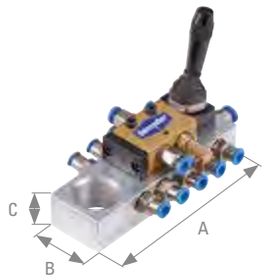




Manifold with hand valve

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

D28



Manifold D28 with hand valve

D28

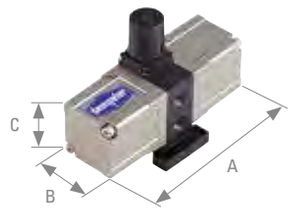


A in mm	B in mm	C in mm	Item no.
130	40	25	D28-13020-000

Pressure booster

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

D28



Pressure booster D28

D28

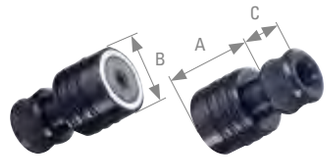


A in mm	B in mm	C in mm	Description	Item no.
150	50	65	2 : 1	D28-13020-001
200	150	140	4 : 1	D28-13020-002

Magnetic clamp

- Direct use in any system bore
- Holding force approx. 70 N

D28

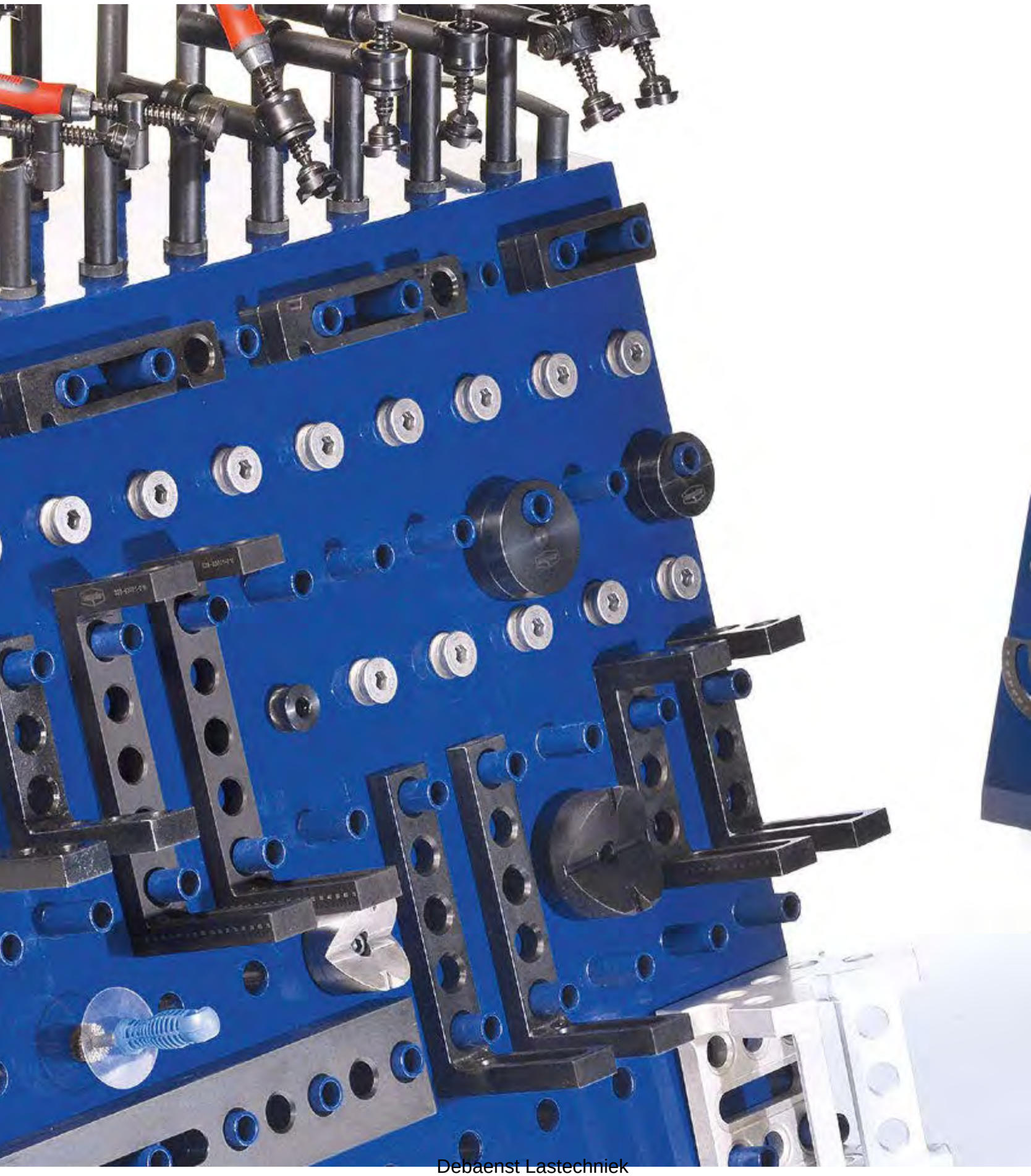


Magnetic clamp D28

D28



A in mm	Ø B in mm	C in mm	Approx. weight in kg	Item no.
24	28	25	0,16	D28-13001-002
47	28	25	0,26	D28-13001-003



Debaenst Lastechniek



DEMMELER®
system accessories

Workplace organisation 236

D28		D22	D16
 **clever toolbox** page 238	 **Protective spray** from page 247	 **clever toolbox** page 238	 **smart toolbox** page 241
 **smart toolbox** page 241	 **Cleaning/ maintenance** from page 248	 **Accessory cart** page 242	 **Accessory carts** from page 242
 **Accessory cart** page 242	 **Earth connection** page 249	 **Tools for clamping and releasing** from page 244	 **Tools for clamping and releasing** from page 244
 **Tarpaulin for accessory cart** page 243	 **Transport ring** page 251	 **Protective spray** from page 247	 **Protective spray** from page 247
 **Tool wall** page 244		 **Cleaning/ maintenance** from page 248	 **Cleaning/ maintenance** from page 248
 **Tools for clamping and releasing** from page 244		 **Earth connection** page 249	 **Earth connection** page 249
 **Electric screwdriver including accessory package** page 246		 **Transport ring** page 251	 **Transport ring** page 251

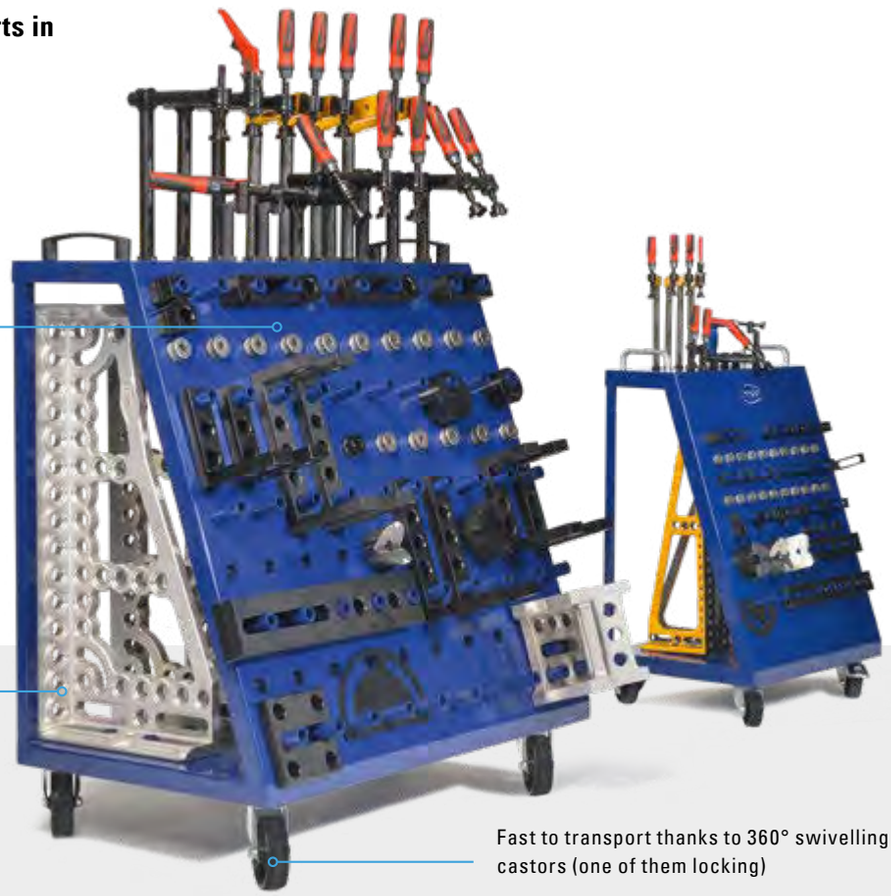
With the accessories from DEMMELER, your workplace is always perfectly organised

Workplace organisation is at least as important as precise tools. This ultimately offers almost unlimited potential. To ensure improved tidiness and organisation, DEMMELER's extensive range of table accessories is therefore available in all system sizes.

To make sure your tools are always where you need them

Mobile accessory carts in any system size

D28 D22 D16



Plenty of space for your system accessories

Large blocks and angles are safely and conveniently stored inside the cart

Fast to transport thanks to 360° swivelling castors (one of them locking)

Debaenst Lastechniek

System accessories and consumables

We ensure that you can continue to extend your system throughout its entire service life. We can provide you with the right tools for easily clamping and releasing the clamping bolts and with care products that reduce material wear.



Suitable tool storage options available for every system size

Practical drawer units offer a lot of storage space and protect your clamping accessories against dirt and weld spatter.



The **smart toolbox** is available with either two or three drawer elements and has a load capacity of up to 125 kg.

D28 D16

The **clever toolbox** can be mounted on all four sides and has a load capacity of up to 170 kg.

D28 D22



clever toolbox

Ingenious. A clever extendible accessory box! Saves space, saves time, protects tools and can be locked.



- **Mounting of the "clever toolbox" using connecting bushes on the side posts**
- **Older table models can be retrofitted**

10 bottom locking bolts are included in the scope of delivery.

clever toolbox

clever toolbox D28



A in mm	B in mm	C in mm	Approx. weight in kg	D28 Item no.
980	780	520	65	D28-11001-015

From a table size of 1000 x 1000 mm. The 3D welding table and system components are not included in the scope of delivery.

clever toolbox D22



A in mm	B in mm	C in mm	Approx. weight in kg	D22 Item no.
980	780	520	65	D22-11001-015

From a table size of 1000 x 1000 mm. The 3D welding table and system components are not included in the scope of delivery.

Debaenst Lastechniek



Methodical organisation



All blocks and angles can be stored in the grid system with locking bolts to save space.

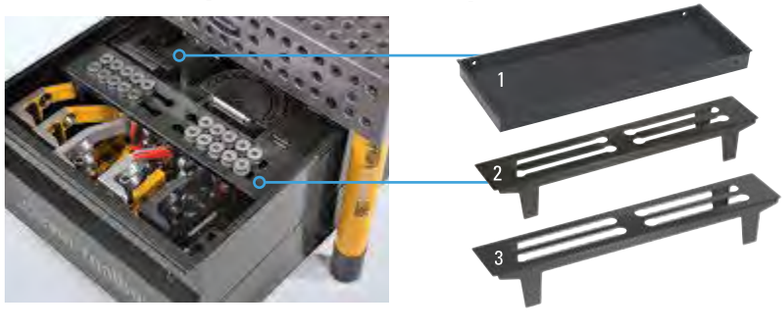


The "clever toolbox" can be mounted on all four sides and has a load capacity of up to 170 kg. Thanks to its ground clearance (10 cm), the "clever box" is readily accessible. The protective plate integrated under the table protects against dirt and weld spatter.



Locking bolts are not included in the scope of delivery.

Can additionally be ordered as an option



(1) Universal box and **(2)** bolt cartridge for PPC and PC bolts, which can be removed and moved. **(3)** Bolt cartridge for ECO bolts. Not included in the scope of delivery.

Universal box* D28/D22	D28	D22
Item no.	D28-11001-017	D22-11001-017



Side locking bolt* D28/D22	D28	D22
Item no.	D28-11001-023	D22-11001-023



Bolt cartridge* D28/D22	D28	D22
Item no.	D28-11001-016	D22-11001-016



Locking bolts D28/D22, bottom	D28	D22
Item no.	D28-11001-018	D22-11001-018



10 locking bolts, bottom, are included in the scope of delivery.

Eco bolt cartridge* D28	D28
Item no.	D28-11001-031

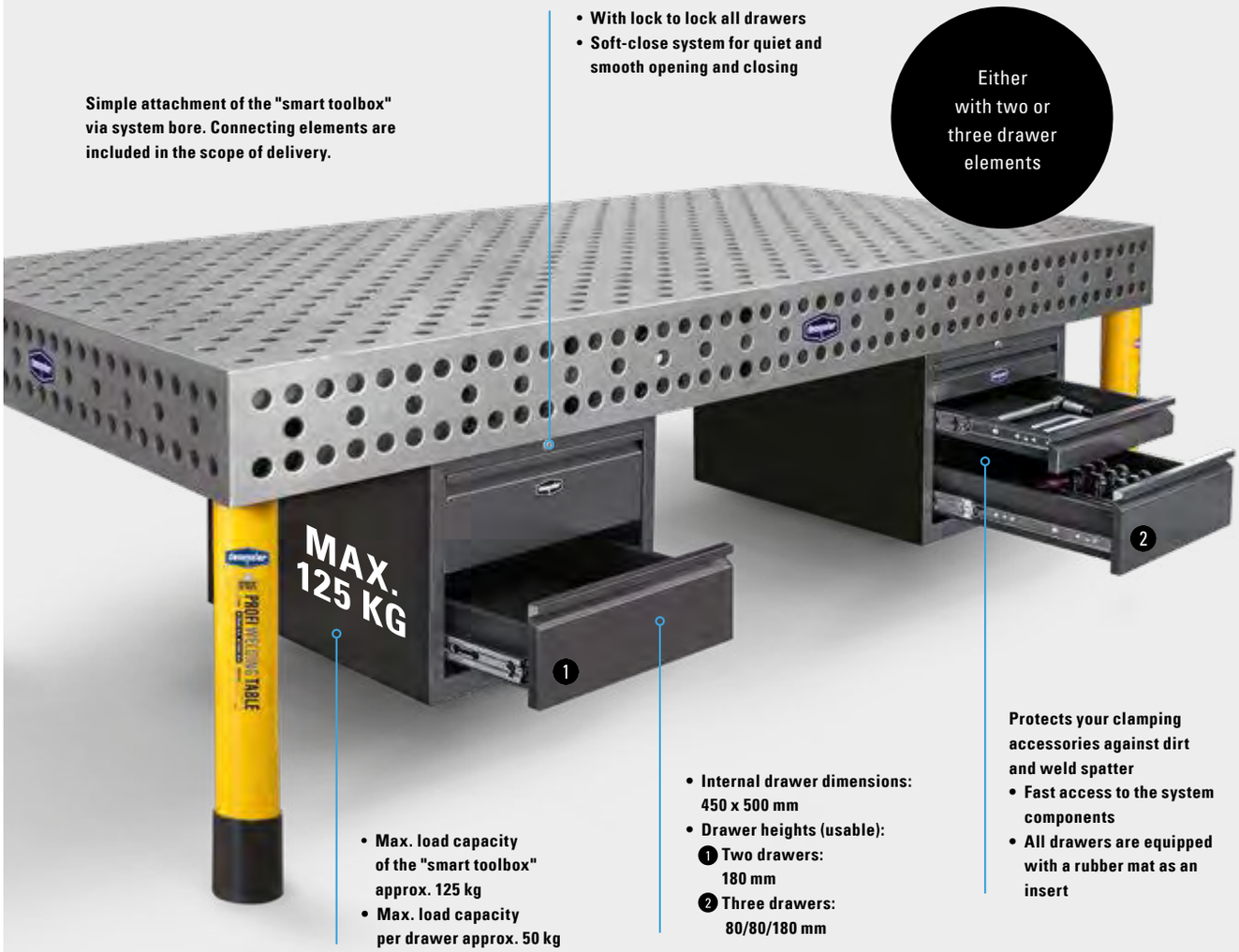


*Not included in the scope of delivery. Can be ordered as an option.

smart toolbox

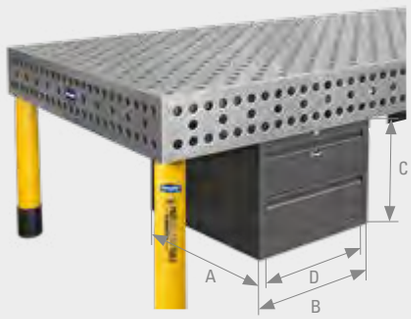
Whether in the workshop or in the production hall, a practical organisation and storage system is needed wherever tools, equipment and small parts are used. The robust drawer units from DEMMELER made from precisely machined sheet steel perfectly meet this requirement. They are the ideal complement to the "clever toolbox". The robust design is able to support bearing loads of up to max. 125 kg. The closed body reliably protects tools and small parts against dirt and weld spatter. At the same time, the drawers of different heights make optimal use of the available space, offering generous storage space.

Both model versions can be flexibly combined depending on the system size – D16 and D28. This is how you can design your workspace to meet the requirements of your business.



smart toolbox

- The ideal complement to the "clever toolbox"
- Robust drawer base units made of sheet steel
- Optionally with two or three drawer elements
- Generous storage space
- Reliably protects tools and small parts against dirt and weld spatter
- System components are not included in the scope of delivery



D28
D16

smart toolbox D28/D16 – with two drawers



A in mm	B in mm	C in mm	D in mm	D28 Item no.	D16 Item no.
640	575	485	515	D28-11001-032	D16-11001-032

smart toolbox D28/D16 – with three drawers



A in mm	B in mm	C in mm	D in mm	D28 Item no.	D16 Item no.
640	575	485	515	D28-11001-033	D16-11001-033





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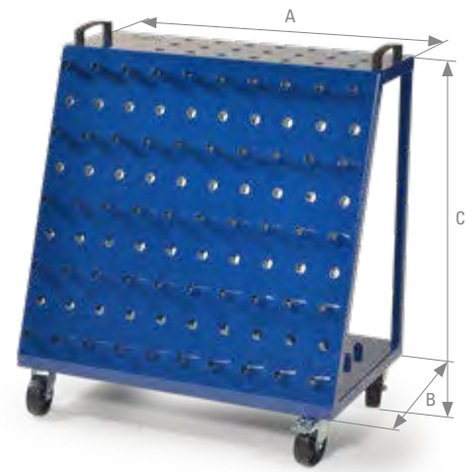
Accessory cart

- Creates a tidy and organised workspace
- Fast access to the system components
- Large blocks and angles are safely and conveniently stored inside the cart
- Fast to transport thanks to four sturdy 360° swivelling castors, one of them locking
- System components are not included in the scope of delivery

D28
D22
D16



View of back



Accessory cart D28 — D28



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
1000	650	1010	60	D28-11001-000

Accessory cart D22 — D22



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
800	503	1068	55	D22-11001-000

Accessory cart D16 — D16



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
600	450	870	35	D16-11001-002

Typical potential applications

D28





D16





Debaenst Lastechniek

Tarpaulin for accessory cart D28

- Very sturdy tarpaulin
- Protects your accessory cart against dirt and moisture
- Securely sewn at the corners
- Front with two robust zippers for removing the components at the front without having to take off the entire tarpaulin
- For D28-11001-000 accessory cart
- System components are not included in the scope of delivery

D28





Tarpaulin for accessory cart D28



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

Tool trolley D16

- Creates a tidy and organised workspace
- Fast access to the system components
- Four closed drawers protect the contents against dirt
- Lockable
- Mobile on four sturdy castors, two of them swivelling and locking

D16





System components are not included in the scope of delivery

Tool trolley D16



				D16
A in mm	**B in mm**	**C in mm**	**Approx. weight in kg**	**Item no.**
740	560	970	–	D16-11001-000

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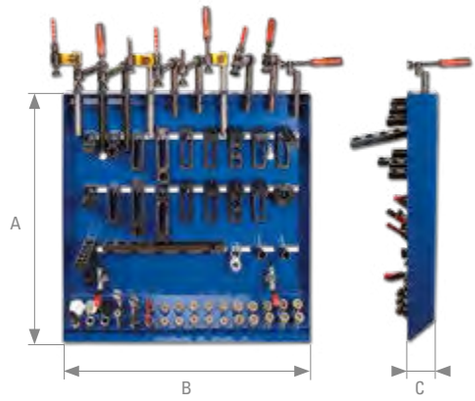
Tool wall for mounting on the wall or table

- Creates a tidy and organised workspace
- The tool wall can either be mounted on the table with two D28-06001-000 PC bolts (see page 122) or on the wall
- System components are not included in the scope of delivery

D28



Tool wall D28

D28



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
1010	1000	105	45	D28-11001-010

Clamping and releasing made easy.

Assembly lever

- Suitable for clamping and releasing PC and PPC bolts, for example
- For easy removal of PC bolts and PPC bolts
- Handle simultaneously used for pre-centring

D28
D22



Assembly lever D28/D22



	D28	D22
A in mm	250	250
B in mm	45	45
Approx. weight in kg	0,72	0,72
Item no.	D00-10016-001	D22-10016-001



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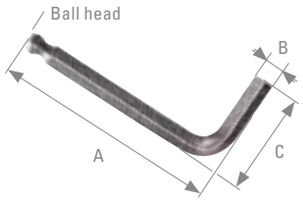
Hex key

- For PC bolt and compensating clamping arm with hexagon head
- Good accessibility thanks to additional ball head



D28
D22
D16



Hex key D28 — D28



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
104	WAF 8	42	0,06	D28-10008-005
112	WAF 10	55	0,10	D28-10008-001
150	WAF 14	69	0,26	D28-10008-000

Hex key D22 — D22



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
112	WAF 10	55	0,10	D22-10008-001

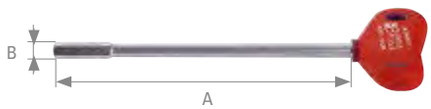
Hex key D16 — D16



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
71	WAF 4	25	0,01	D16-10008-002
94	WAF 6	38	0,02	D16-10008-001
104	WAF 8	42	0,06	D16-10008-000
75	WAF 5	35	0,02	E16-10008-000

Hex key with cross-handle

- Ergonomic handle for optimum tightening



D28
D22

Hex key D28 with cross-handle — D28



A in mm	B in mm	Approx. weight in kg	Item no.
150	WAF 8	0,12	D28-10008-004
200	WAF 10	0,18	D28-10008-003

Hex key D22 with cross-handle — D22



A in mm	B in mm	Approx. weight in kg	Item no.
200	WAF 10	0,18	D22-10008-003

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Electric screwdriver with quick-change coupling for the PPC bolt and accessories

- DeWALT 12 volt/2 AH electric screwdriver with three torque settings to choose from (fine, medium, strong), adapted to the new form-fitting DEMMELER quick coupling
- A longer runtime per battery charge and a very high torque (max. 168 Nm) with extremely compact dimensions and a very low weight
- The new professional 3/8" quick-change coupling from DEMMELER, suitable for PPC bolts with WAF 14 (alternatively also for PPC bolts with WAF 10)
- Hardened reducer bushing from WAF 14 to WAF 13 for tightening and releasing the short spindle from screw clamps, etc.
- D28 mm cleaning brush attachment for efficiently cleaning the system bores
- Practical carrying case for all accessories

D28



Electric screwdriver including accessory package — D28



Quantity	Description
1	DeWALT electric screwdriver including 1 battery charger + 2 batteries
1	New professional 3/8" quick coupling for PPC bolts
1	Hardened reducer bushing from WAF 14 to WAF 13
1	Mounting fixture for easy installation of the clamping ring
1	Manufacturer warranty/assembly information
1	Carrying case for all accessories
Quantity	**Maintenance accessories**
2	Cleaning brush attachment for system bore D28
Quantity	**Wearing parts**
20	O-rings compatible with PPC bolt D28
15	Small polygonal elements compatible with PPC bolt D28
10	Clamping rings compatible with PPC bolt D28
Item no.	D28-13050-000

Components of the accessory package are also available separately

Typical potential applications



Electric screwdriver of the latest generation with quick-change coupling for the PPC bolt: Clever form fit for safe and fast clamping and releasing of the patented PPC bolts with high torque.



User-friendly and effortless: The new DEMMELER system lock between the PPC bolt and impact screwdriver makes it possible to insert and tighten as well as loosen and remove the bolt using one hand.

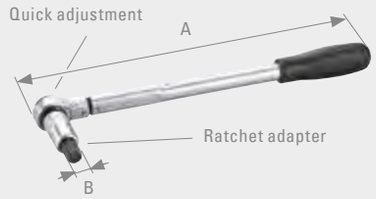


Maintenance can be performed easily and efficiently on the table and system bores thanks to the rotating round brush attachment.

Debaenst Lastechniek

Torque wrench

- Preset to D28: 70 Nm, D22: 25 Nm, D16: 20 Nm for controlled tightening of the bolts, preventing damage to the system bore and bolts caused by over-tightening
- Inc. 1x convertible ratchet adapter (left, right)
  D28: 1/2", D16: 3/8" and 2x D28 sockets: WAF 8 and WAF 14, D22: WAF 8, D16: WAF 4 and WAF 8



D28
D22
D16

Torque wrench D28/D22/D16	D28	D22	D16
A in mm	348	348	212
B in mm	WAF 8 / WAF 14	WAF 6 / WAF 8	WAF 4 / WAF 8
Approx. weight in kg	0,76	0,8	0,52
Item no.	D28-10015-000	D22-10015-000	D16-10015-000





Protection and maintenance.

Protective spray in a pump bottle

- Pressurised, sturdy design
- Including protective spray for the welding table, capacity: 1 litre
- Attention: Cannot be diluted with water.

Benefits for you
- Prevents the adhesion of weld spatter on the surface
- Temporary corrosion protection for around one day
- Good cleaning effect
- Non-flammable, biodegradable
- Does not contain solvents, silicone or VOC; does not require special labelling



D28
D22
D16

Protective spray in a pump bottle



A in mm	B in mm	Description	Item no.
280	100	Pump bottle without protective spray	D00-10004-000
280	100	Pump bottle with 1 litre of protective spray	D00-10005-000

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Protective spray in a canister

- Release agent for welding thin and/or pre-heated sheets and for multi-layer welding
- Protection for welding tables, system components, welding nozzles and other welding accessories
- Prevents the adhesion of weld spatter on the surface
- Temporary corrosion protection for around one day
- Good cleaning effect
- Non-flammable, biodegradable
- Does not contain solvents, silicone or VOC; does not require special labelling



D28
D22
D16

Areas of application
- For welding steel, stainless steel and aluminium

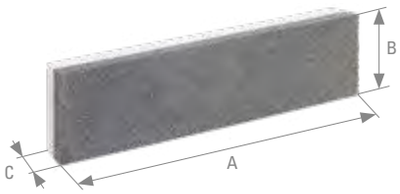
Protective spray in a canister



A in mm	B in mm	Description	Item no.
230	200	5-litre canister	D00-10006-000
310	200	10-litre canister	D00-10006-001
400	350	30-litre canister	D00-10006-002

Bench stone

- To care for the system surfaces of welding tables and system components



D28
D22
D16

Bench stone



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
200	50	25	0,56	D00-10007-000



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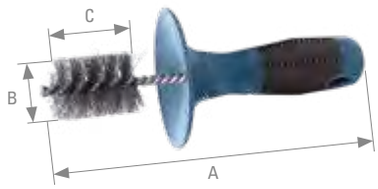
Round brushes

- For cleaning the system bores
- With splash guard



D28
D22
D16

Round brush D28

D28



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
165	28	40	0,15	D28-10002-000

Round brush D22

D22



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
165	22	40	0,12	D22-10002-000

Round brush D16

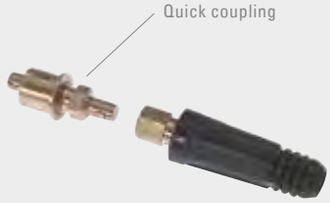
D16



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
165	16	40	0,10	D16-10002-000

Earth connection

- Fits in any system bore
- 100% contact, therefore no overheating of the earth cable >> high efficiency
- For cable cross-section of 50–70 mm², for loads up to 355 A with 100 % duty cycle, 400 A with 60 % duty cycle
- Simple and safe installation (without interfering edges)
- Compatible with commonly used earth cables



D28
D22
D16

Earth connection



Approx. weight in kg	Item no.
0,34	D00-10009-000

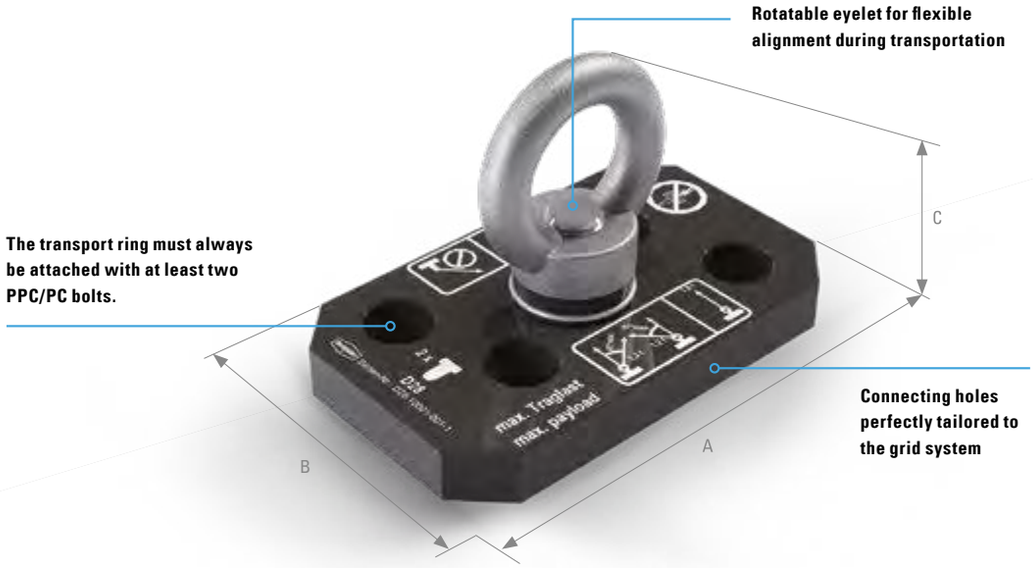


Debaenst Lastechniek

Fast, easy and safe transportation of all heavy system components
(e.g. welding table)

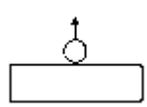
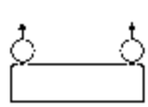
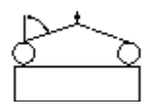
The transport ring for the DEMMELER 3D clamping system.

D28
D22
D16



- The transport ring must always be attached with at least two DEMMELER PPC/PC bolts.
- Countersunk bolts must not be used.
- Only use the transport ring for DEMMELER 3D systems.
- Internal operating instructions must be observed.
- Only undamaged transport rings and PPC/PC bolts may be used.
- The transport ring must be fixed in the centre of the worktop. If two transport rings are used, these must be fixed symmetrically in the centre of the worktop. The maximum diagonal pulling angle must not exceed 45° (see warnings)
- The general regulations for means of transport must be observed when using the transport ring.
- Depending on the application, the load capacity may be significantly reduced.
- The transport ring may only be loaded in the ring plane. Do not exceed the load capacity.
- Do not stand underneath suspended loads.
- Observe the warnings on the transport ring.

Max. transport weight in [t] for different attachment methods

Transport ring			
Tilt angle	0°	0°	0°–45°
Number of transport rings	1	2	2
D28 **System D28**	1.8 t	3.6 t	2.4 t
D22 **System D22**	1.8 t	3.6 t	2.4 t
D16 **System D16**	0.7 t	1.4 t	1.0 t

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Transport ring







Transport ring D28

D28



- The D28-10001-001 transport ring must always be attached with at least two DEMMELER PPC/PC bolts.
- Max. tightening torque for D28: 70 Nm (bolts are not included in the scope of delivery of the transport ring)
- Only undamaged transport rings and PPC/PC bolts may be used.

A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
200	120	129	4,7	D28-10001-001

Transport ring D22

D22



- The D22-10001-000 transport ring must always be attached with at least two DEMMELER PPC bolts.
- Max. tightening torque for D22: 25 Nm (bolts are not included in the scope of delivery of the transport ring)
- Only undamaged transport rings and PPC bolts may be used.

A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
200	120	130	4,1	D22-10001-000

Transport ring D16

D16



- The D16-1001-001 transport ring must always be attached with at least two DEMMELER PC bolts.
- Max. tightening torque for D16: 20 Nm (bolts are not included in the scope of delivery of the transport ring)
- Only undamaged transport rings and PC bolts may be used.

A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
200	120	84	2,8	D16-10001-001

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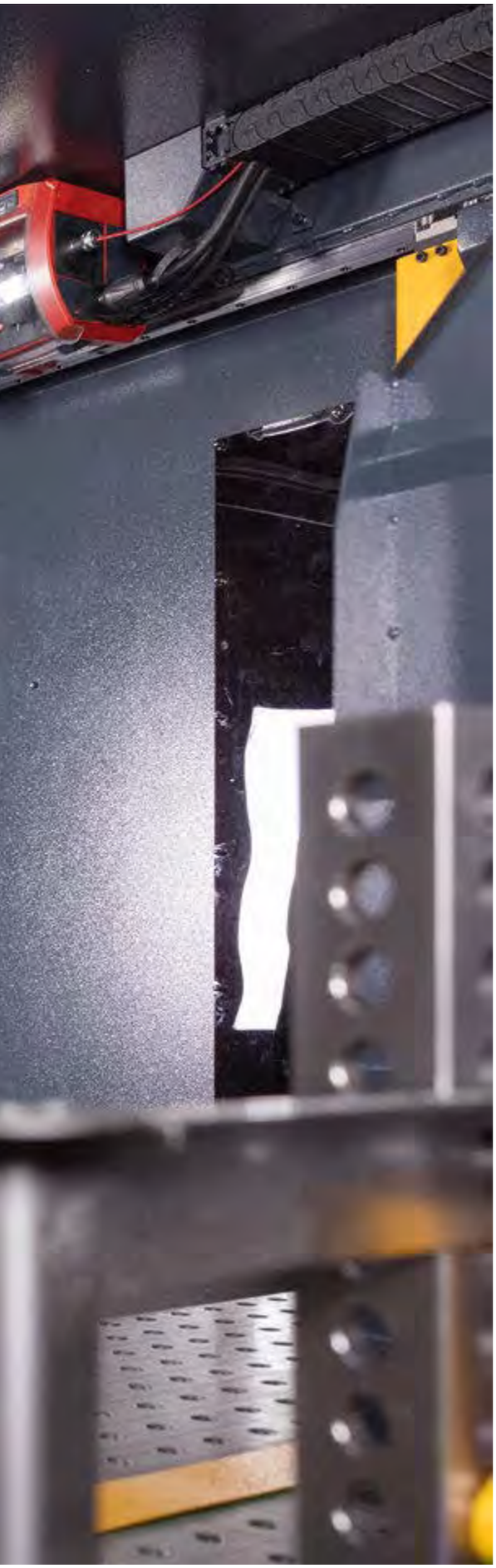

DEMMELER®
COBOT WeldSpace 4.0®

Automated welding in shuttle operation 254

Equipment 256



COBOT WeldSpace 4.0® basic cell
from page 256

Configuration options



Work tables for basic cell
page 258

Optional equipment options

Workspace extension



Equipment in SPACE A1/A2
page 259



Equipment in SPACE B
from page 259

Welding systems



Welding current sources for robotics applications
page 261



Optional accessories
from page 262



WeldSpace 4.0® software options
page 265

Debaenst Lastechniek



Visit our website at www.demmeler.com or simply scan the QR code for more information about the DEMMELER COBOT WeldSpace 4.0® and its equipment options.

The new COBOT WeldSpace 4.0® welding cell from DEMMELER comes with everything you need.

In the future, advances in digitalisation and automation will also change the processes in welding production. Particularly in the manual welding of classic sheet metal components, the new technology – welding with collaborative robots – can eliminate the need for valuable skilled workers to perform tiring routine and repetitive tasks. With the COBOT WeldSpace 4.0® from DEMMELER, even small and medium-sized companies can get to grips with automated and professional welding production in next to no time thanks to the fast commissioning and extremely simple programming. Whether individual parts, parts from series production, or small batch sizes with a large variety of parts, you save time in welding and reworking. The fully equipped welding cell with welding robot and welding technology offers unique modularity and flexibility in the smallest possible space with four possible workspaces – SPACE A, A1–A2 and Space B.

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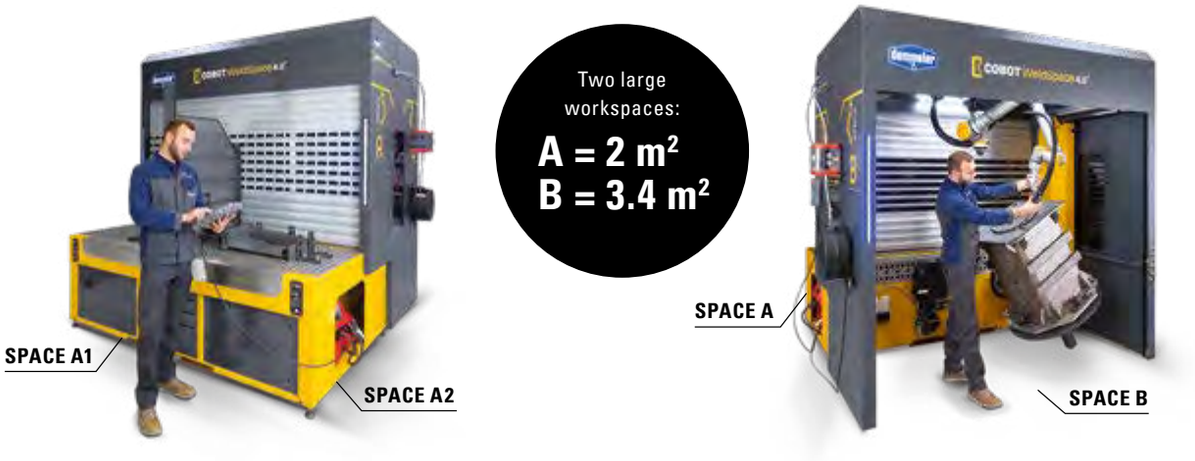
Four workspaces with perfect accessibility from all sides. Well-equipped with high-quality components and premium equipment.



The standard shuttle operation between the SPACE A and SPACE B workspaces with optional subdivision of the SPACE A workspace into A1 and A2 enables set-up, reclamping and welding to be performed in parallel. Depending on requirements, the SPACE B workspace can optionally be equipped with another DEMMELER 3D welding table with a maximum size of 2000 x 1000 mm or with a two-axis manipulator with a load capacity of up to 500 kg. This enables highly productive welding in the flat position.

Basic equipment

Universal Robots UR e-Series
Latest UR10e collaborative robot with six axes and force torque sensor mounted overhead on the support structure.

DEMMELER WeldSpace 4.0® software
Almost everything can be programmed with just three buttons on the multi-function handle.

DEMMELER 3D welding table
Available in all system sizes D16, D22 or D28 from DEMMELER.

Central control unit
The user interface of the WeldSpace 4.0® software guides you step by step to perfect welding results.

Shuttle operation parallel to main time
Shuttle operation between two large workspaces (SPACE A and SPACE B) parallel to main time as standard.

Movable gantry makes crane loading possible
Workpieces are easily loaded for set-up and reclamping, including by crane.

Special equipment

Two-axis manipulator
Modular two-axis manipulator with a load capacity of up to 500 kg for professional workpiece clamping and circumferential seam welding with the rotary axis.

Integrated and professional high-performance welding system
Fronius robot welding equipment

Torch cleaning station
Optimum and reliable cleaning of the gas nozzle ensures a reliable welding process and increases system availability.

Welding fume extraction system
Connection of a mobile or central welding fume extraction system.

Network camera
Check and document welding results by means of live transmission and videos. Access and control using a robust industrial tablet with preinstalled Fronius WeldConnect app.

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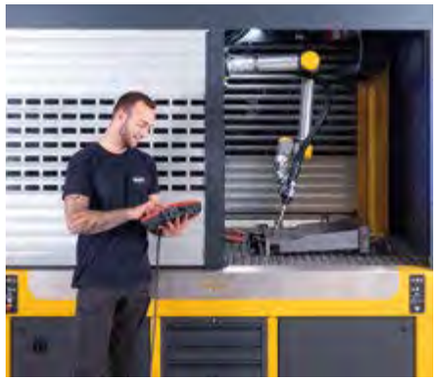
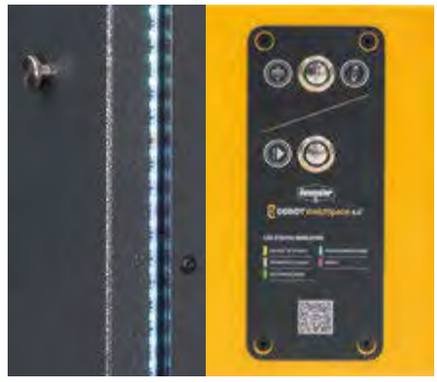
The complete package for a quick and professional introduction to automated welding



COBOT WeldSpace 4.0® – basic equipment

- Ready-to-operate cell with two large workspaces – SPACE A and SPACE B
- Automatically moving protective enclosure with two roller shutter doors (aluminium cladding with viewing elements made of protective welding glass)
- UR10e collaborative welding robot (mounted overhead). Not to be confused with the approx. € 6000 cheaper UR10 (old model).
  The UR10e offers the highest accuracy and reliability with maximum sensitivity. Eliminate the need for your staff to perform dirty, dangerous and monotonous work and increase productivity by saving time.
- UR control panel
- DEMMELER WeldSpace 4.0® software. Specially developed software with many functions which – together with the innovative three-button handle – takes the hassle out of creating complex welding programs. The software guides the operator intuitively through the menu and with the three-button handle, waypoints and spot welds can be transferred directly into the program. Planes can also be selected on the three-button handle to facilitate precise positioning at the selected point. Other functions such as FREEDRIVE (free movement of all axes), LIN (movement in one plane) and ROT (rotate around the ToolCenterPoint TCP) are a matter of course. An extensive job library that can be expanded at any time, in which parameters and characteristic curves for typical welding applications are stored, leads to the perfect welding result.
- Enabling button
- Smart toolbox with three lockable drawers
- Forklift pockets for easy transport
- Gas cylinder holder for up to two gas cylinders
- Connection options for a central production facility exhaust system on the left or right side and two at the top of the system
- LED strips on all side corners signify processes and machine statuses
- 3D work tables available in versions D16, D22 and D28

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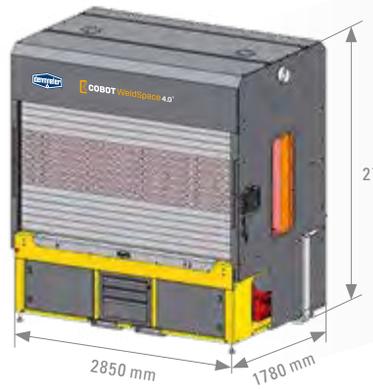
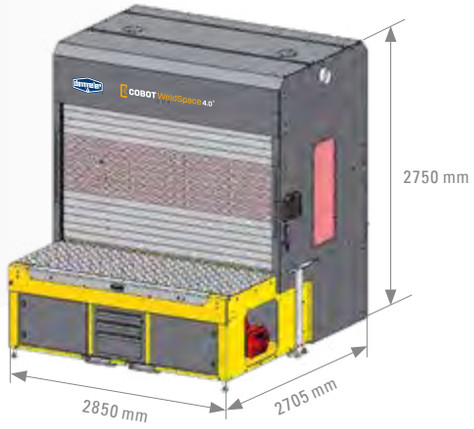
Enclosure when closed:
2850 × 1780 × 2750 mm



Enclosure when moving:
2850 × 2705 × 2750 mm



COBOT WeldSpace 4.0® basic cell





Dimensions	2850 x 1780 (2705 mm) x 2750 mm
Weight	Approx. 2325 kg
Electrical data	
Feed-in	3x 400 V/N/PE
Frequency	50 Hz
Operating voltage	400 V
Control voltage	24 V DC
External fuse	Max. 32 A slow-blow (up to 400 A welding current)
Rated current	30 A
Workspace SPACE A	
Dimensions	2300 x 875 x 1100 mm
Typical workpiece size	Workpiece size depends on workpiece geometry and welding torch accessibility
Max. load	3000 kg
COBOT UR10e series	
Type	Collaborative industrial robot arm
Number of axes	6
Load capacity	12.5 kg
Weight	33.5 kg
Working radius (ceiling mounting)	1300 mm
Repeatability	± 0.05 mm
Workspace SPACE B	
Dimensions	2300 x 1500 x 1750 mm
Typical workpiece size	Workpiece size depends on workpiece geometry and welding torch accessibility
Max. load	Floor load
Item no.	**00203831**

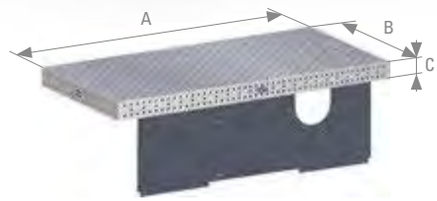
Choose your system size for the work table in SPACE A



SPACE A

3D welding table

- Only in conjunction with the 00203831 basic cell
- Hardened version DEMONT 760 M
- All system bores with protective countersink and ultimate functionality
- Precision scaling with millimetre graduation
- Coordinate marking of the bores in the X and Y directions
- Including mounting kit for COBOT WeldSpace 4.0® basic cell and sheet metal cladding



D28
D22
D16

COBOT WeldSpace 4.0® 3D welding table D28 PROFIPremiumLINE (PP) — D28



- Worktop with D28 system bores in a 50 x 50 mm grid
- Grid lines in X and Y alignment, 100 mm spacing throughout

A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
2400	1200	200	824	50 x 50 mm grid	00162637

COBOT WeldSpace 4.0® 3D welding table D22 PROFIPremiumLINE (PP) — D22



- Worktop with D22 system bores in a 50 x 50 mm grid
- Grid lines in X and Y alignment, 100 mm spacing throughout

A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
2400	1200	150	535	50 x 50 mm grid	00162638

COBOT WeldSpace 4.0® 3D welding table D16 PROFIEcoLINE (PE) — D16



- Worktop with D16 system bores in a 50 x 50 mm grid
- Grid lines in X and Y alignment, 50 mm spacing throughout

A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
2400	1200	100	347	50 x 50 mm grid	00162639

Equipment options to extend SPACE A into SPACE A1/A2

With this extension set, the SPACE A workspace can optionally be divided in the centre into two workspaces – SPACE A1 and SPACE A2. This makes it possible to operate the welding cell in three-station mode.





Additional roller shutter doors 3 and 4 with viewing elements

Partition wall

1 SPACE A in the loading status
2 SPACE A2 in the operating status

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Workspace A1/A2

- Two additional roller shutter doors (aluminium cladding with viewing elements made of welding protection glass) for workspaces A1 and A2
- Fast and easy-to-install partition wall (dimensions: A 935 x B 150 x C 1300 mm, weight: 18.5 kg)
- Automatic detection of the partition wall by the control system
- Dimensions per Workspace 1000 x 865 x 1100 mm
- Max. load per Workspace 1500 kg





D28 D22 D16

SPACE A

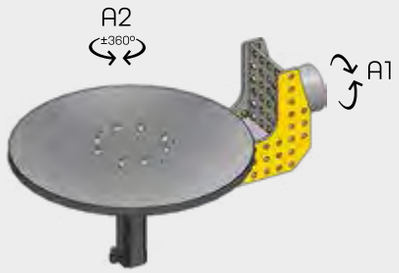
COBOT WeldSpace 4.0® extension set for Workspace A1/A2	D28	D22	D16
Set components:	**Item no.**	**Item no.**	**Item no.**
1x set of roller shutter doors 3 and 4, 1x partition wall, 4x PPC or PC bolts (depending on the system size of the work table)	00201313	00201311	00162716



Equipment options for SPACE B

Two-axis manipulator

- Powerful and fast two-axis manipulator with excellent repeatability for ideal positioning of the workpieces
- The height of axis 2 can be adjusted in a range of 150 mm (axis of rotation)
- Mount for D28, D22 and D16 clamping plates
- Bracket always with D16 system bores
- Galvanically isolated clamping plate
- Extensive range of DEMMELER accessories
- Earthing via double sliding contacts up to 500 A



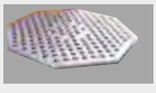
D28 D22 D16

SPACE B

COBOT WeldSpace 4.0® two-axis manipulator



Speed of manipulator axis 1/axis 2	0.01–7 rpm (in 0.02 rpm increments)
Axis 1 (swivel axis)	±190°
Axis 2 (axis of rotation)	±360°
Max. load capacity	500 kg
Weight	175 kg
Max. workpiece diameter	850 mm (with 360° rotation)
Max. workpiece length	1500 mm
Max. torque	1000 Nm
Item no. (two-axis manipulator for work table D28)	00161956
Item no. (two-axis manipulator for work table D22)	00161953
Item no. (two-axis manipulator for work table D16)	00200923



For the clamping plate for the two-axis manipulator, see page 260.

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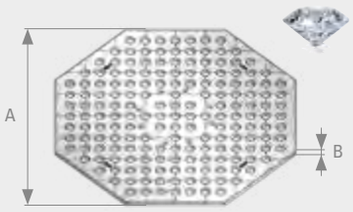
Choose your clamping plate D16, D22 or D28 for the two-axis manipulator



SPACE B

Clamping plates

- M8 tapped holes on the side
- Grid lines in X and Y alignment, 50 mm spacing throughout
- Hardened version DEMONT 760 M
- Tailored to the two-axis manipulator



D28
D22
D16

Clamping and adapter plate D28 — D28



A in mm	B in mm	Approx. weight in kg	Description	Item no.
WAF 800	25	95	50 x 50 mm grid	00162810

Clamping and adapter plate D22 — D22



A in mm	B in mm	Approx. weight in kg	Description	Item no.
WAF 800	17,5	67	50 x 50 mm grid	00162811

Clamping and adapter plate D16 — D16

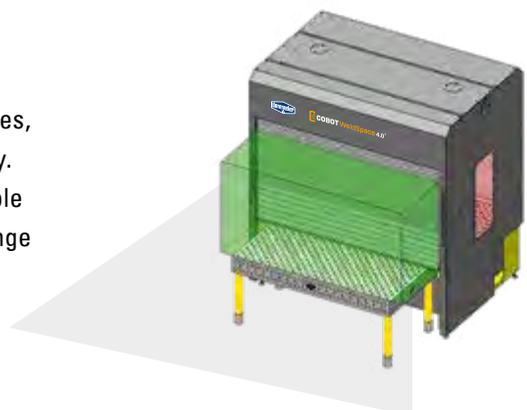


A in mm	B in mm	Approx. weight in kg	Description	Item no.
WAF 800	12	43	50 x 50 mm diagonal grid	00151601

SPACE B

Optional equipment for SPACE B

The SPACE B workspace offers room for larger components and fixtures, which can also be placed directly on the floor of the production facility. SPACE B can optionally be equipped with an additional 3D welding table (max. dimensions 2000 x 1000 mm). You can choose from the entire range of the DEMMELER 3D welding table and clamping system.



Perfectly coordinated welding processes

Welding systems

- Welding systems designed for the COBOT WeldSpace 4.0®
- Robot welding equipment from the Fronius brand
- The welding device is integrated in the table base unit to save space
- Only one main switch and power connection for the cell with welding system
- Extensive job libraries
- EMC emission class: A

Welding systems from the Fronius TPS400i series



Technical device data:

- Mains voltage: 3x 400 V/mains voltage tolerance: ±15 %
- Mains fuse: 32 A slow-blow
- Mains frequency: 50/60 Hz
- Cos phi: 0,99
- MIG/MAG welding current range: 3–400 A
- Welding current at 10 min/40 °C: 40% 400 A/60% 360 A/100% 320 A
- MIG/MAG output voltage: 14.2–34.0 V
- Open-circuit voltage: 73 V
- Protection class: IP23
- Power source of the TPS 400i: Current range 400 A



Optionally available:
Fronius RC Panel Pro control panel (with 5 m cable)
Item no. 00203955

	Fronius TPS400i 400 A Push water-cooled	Fronius TPS400i 400 A PushPull water-cooled	Fronius TPS400i 400 A CMT water-cooled
Integration and software extension of the DEMMELER WeldSpace 4.0® software Input of the welding jobs from the power source and simple selection using a list on the control panel	•	•	•
Welding packages: Standard welding package, Pulse welding package	•	•	•
CMT welding package	-	-	•
Interface for COBOT WeldSpace 4.0®	•	•	•
CU 1100i recirculating cooler	•	•	-
CU 1400i recirculating cooler	-	-	•
Intermediate tube assembly	•	•	•
W25i wire feed unit	•	•	•
SB SplitBox	-	•	•
Tube assembly	•	•	-
CMT tube assembly	-	-	•
Torch body MTB 400i R / 22° / L241 / H50	•	-	-
Torch body MTB 400i W R / 22° / L241 / H50 with additional drive for wire feed unit in the torch	-	•	-
Robacta Drive/CMT push/pull torch / 22° / L241 / H50	-	-	•
Torch holder for COBOT UR10e	•	•	•
Item no.	**00200728**	**00203951**	**00201304**

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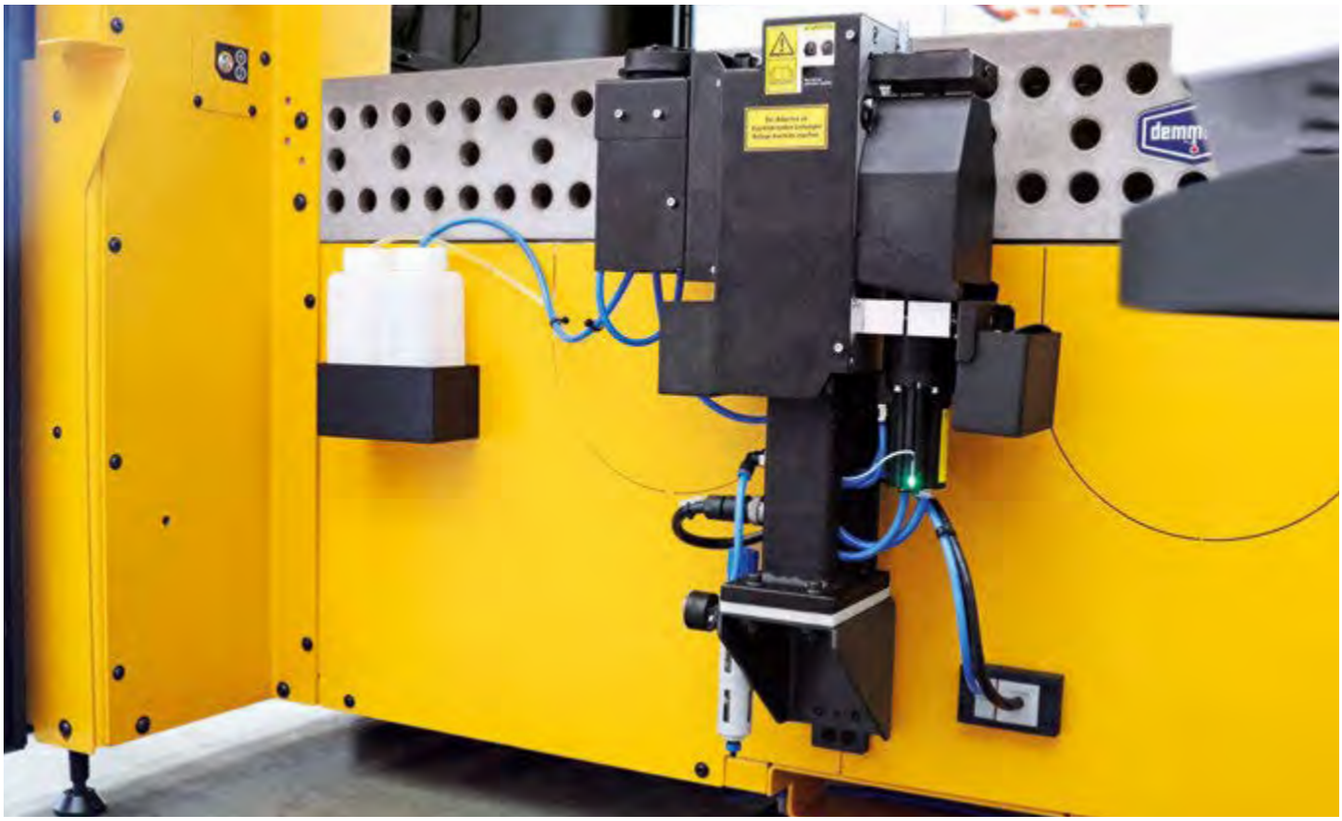
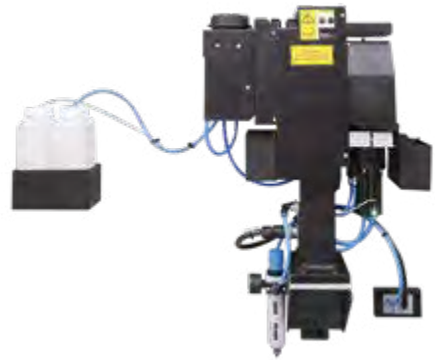


Torch cleaning station

Torch cleaning
- Cutter, specially adapted to the welding torch (item no. 00203883)
- Clamping V-blocks with diameter of 25 mm (item no. 00203884, others available on request)
- Powerful, high-quality air motor for powerful cleaning

Spraying unit
- Activated by the robot movement – no output necessary
- Highly efficient spray function, minimal consumption
- Excess anti-splash agent is collected in a container
- Fully protected for a clean environment and safe work areas

DAV wire cutter
- Powerful, reliable cutting device with sharp cutting action for starting an arc safely
- Hardened cutting blade for a long service life



COBOT WeldSpace 4.0® torch cleaning station



Air consumption	Approx. 400 l/min
Rated pressure	6 bar
Operating pressure	6–8 bar
Max. wire diameter at 6 bar	1.6 mm solid wire
Control voltage	24 V DC
Power consumption	2.8 W
Operating voltage	10–30 V DC
Continuous current	Max. 100 mA
Power consumption	Approx. 14 mA (4 V)
Item no.	00201320

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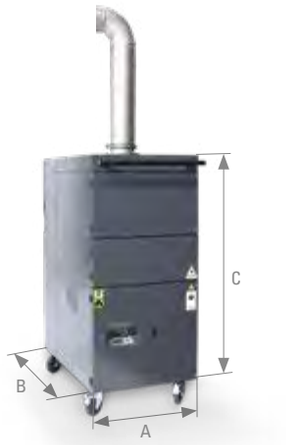
MobiAirClean D1 welding fume extraction system

- The automatic cleaning system makes the mobile filter system ideal for welding work which involves non-alloy and alloyed steels, galvanised materials and aluminium and produces a high volume of fumes
- MobiAirClean D1 meets the safety requirements for devices from welding fume class "W3" (high-alloy steels that contain > 30% nickel)
- The specially developed cleaning system for any type of dirt gives the filter cartridge good cleaning characteristics, ensuring optimum extraction performance during the entire operation
- Including spiral tube and connecting tube
- Length (A)/width (B)/height (C): 665/1100/1495 mm



COBOT WeldSpace 4.0® MobiAirClean D1 welding fume extraction system



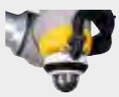
Fan output	1860 m^3/h
Stress	2900 Pa
Operating point	1100 m^3/h at 1900 Pa
Pre-filter	Baffle plate
Filter area	10 m^2
Filter cartridge	Dust class M
Motor power	1.1 kW
Input voltage	400 V/50 Hz
Power consumption	2.5 A
Noise level	Approx. 72 dB (A)
Current type	3Ph+N+PE
Weight	180 kg
Item no.	00204525

Network camera

- Check and document welding results by means of live transmission and videos
- Digital zoom
- With autofocus and wide dynamic range, ideal for difficult lighting conditions (welding light)



COBOT WeldSpace 4.0® network camera



Item no.	00208481



Robust industrial tablet (Android) for monitoring and documenting the welding processes via the network camera

- Preinstalled Fronius Weld Connect app
- Save tooling sheets

Item no. 00209144

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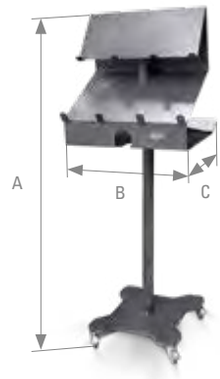
COBOT WeldSpace 4.0® control panel terminal

- Perfect storage option for the UR control panel, enabling button, Fronius panel and industrial tablet
- Holder for UR control panel and enabling button
- Extra heavy design prevents tipping over and, with the brakes on each castor, the terminal stays where you need it
- Four swivel castors with brakes



COBOT WeldSpace 4.0® control panel terminal



A in mm	B in mm	C in mm	Approx. weight in kg	Item no.
1382	520	403	38	00153455

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WeldSpace 4.0® software options

These tools simplify the work steps and guide you to perfect welding results

WELDSPACE 4.0®
SOFTWARE

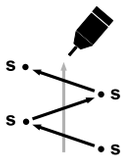
COBOT WeldSpace 4.0® "line seam" software option



- With this tool, you can create line seams or tack seams by entering the weld seam length and the gap, also circularly, without much programming effort
- With the COBOT, you only have to calibrate the start and end points of the weld seam; the tool takes care of the division of the line seams or tacking points

Item no. 00201676

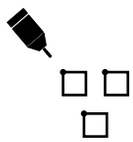
COBOT WeldSpace 4.0® "weave" software option



- With this tool, you can create perfect weave seams for linear as well as circular weld seams
- Simply calibrate the start and end points with the COBOT and enter the weave length and width, as well as the delay time, to define the weave seam
- This function can be used, for example, to create larger weld seams in one layer or to bridge gap seams

Item no. 00201677

COBOT WeldSpace 4.0® "several identical workpieces" software option



- This function is used to move and rotate individual seams and to have these programs executed in a different location
- This function can be used to program workpieces once and execute them several times (weld several identical workpieces). Please note that the seam and programming shift depends on the kinematics and tube guidance of the robot.

Item no. 00201674





Solutions for automated applications.

Clamping and adapter plates from DEMMELER for robot cell manipulators are designed for use when precise positioning of workpieces matters. And it goes without saying that you can use clamping accessories from DEMMELER in system sizes D28, D22 and D16.



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Debaenst Lastechniek

DEMMELER® manipulators and turning units



Ergonomix M®
Welding and assembly in the optimum position
page 268



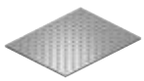
Robotix turning unit
Turns and lifts medium loads from 2 t to 14 t
page 270



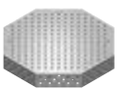
Robotix IP
Our specialist for heavy loads up to 40 t
page 272

Clamping and adapter plates for manipulators and turning units

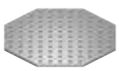
D28



Clamping and adapter plate
page 274



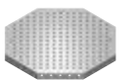
3D welding table Okto 200
page 275



Adapter plate Okto WAF
from page 274

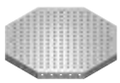


Clamping plates for flanges
from page 278



3D welding table Okto 100
page 275

D22

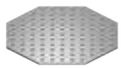


3D welding table Okto 100, aluminium titanium
page 277



Adapter plate
page 277

D16



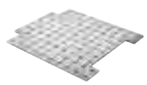
Adapter plate Okto WAF
page 274



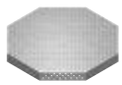
Base bridges
page 280



3D welding table Okto 50
page 276



Segmented grid plate
page 281



3D welding table Okto 100
page 276

Maximum flexibility during welding and assembly.

The size and bulkiness of workpieces often cause difficulties during welding, because not all points are easy to see. However, an optimal overview is a requirement for clean and error-free work. Due to their dimensions, workpieces have to be moved several times during the work process with a heavy device, usually a crane. Reduce this safety risk. The large 180° swivel range of the Ergonomix M® from DEMMELER has the crucial advantage of fully machining workpieces in a single clamping cycle without additional turning. There is no longer any need for repeated, time-consuming turning and rotating, for example using a crane. Staff always work in an ergonomically optimised working environment.





Protection of health and safety
- Ergonomic work that protects your back
- Improved workplace safety

Increased productivity and improved quality
- Maximum work area with minimised footprint
- Unparalleled swivel range up to 180°
- Consistent quality with optional calibration function to save reproducible sequences
- Higher melting deposition rate when welding, as most seams can be produced in the optimal position (flat position)
- Secure workpieces with the standard thread (M24) – also in conjunction with the proven 3D clamping system

Extensive range of equipment is available
- Various clamping and adapter plates available in different sizes and shapes

For more information about our DEMMELER Ergonomix M® manipulator range, please visit www.demmeler.com.



Debaenst Lastechniek



Ergonomix M® basic model

Description	M 2000/V1250	M 2000/V2500	M 2500/19000	M 4000
Bearing load (w/o worktop) [kg]	2000	2000	2500	4000
D=max. interference area at 180° (w/o worktop) [mm]	1000	1000	1000	1500
At height [mm]	650	650	650	520
Max. speed [rpm]	1,4	1,4	1,4	2
Min. speed [rpm]	0,75	0,2	0,2	0,2
Torque [Nm]	1250	2500	2500	5000
Tilt angle [°]	180	180	180	180
Tilting torque [Nm]	8000	8000	19000	32000
A=min. height (w/o worktop) [mm]	490	490	490	750
B=max. height at 180° swivel angle [mm]	970	970	970	983
C=max. height at 90° swivel angle [mm]	1480	1480	1480	1680
Pendant control station	✓	✓	✓	✓
10-speed control	✓	✓	✓	✓
Motors/rotary axis	1	2	2	2
Item no.	**M02-02000-006**	**M02-02000-007**	**M02-02000-047**	**M04-04000-000**

Specifications without worktop. Other equipment details available on request.

Features of the Ergonomix M® and optimal extension options

1 Control system
- with pendant control station 2
- with foot switch 3

4 Programming controller
M2000: Item no. Z00-01001-024
M4000: Item no. Z00-01001-025

5 Rotary feedthroughs
- for status queries, electrical:
  Item no. Z00-01004-005
- for pneumatic clamping fixtures:
  Item no. Z00-01004-008
- for hydraulic clamping fixtures:
  Item no. Z00-01004-009

6 Earth connection
- Max. 400 A at 60% ED:
  Item no. Z00-01000-002
- Max. 700 A at 60% ED:
  Item no. Z00-01000-009

7 Laser scanner
Item no. Z00-01010-001

● Standard equipment ○ Special equipment

Debaenst Lastechniek

NEW Robotix turning unit: Easily position heavy loads up to 14,000 kg

The Robotix turning unit from DEMMELER can be used to move long and heavy workpieces into the ideal position for welding and assembly work so that they can be lifted and lowered or turned in both directions using two electric lifting columns. Both of the turning unit's columns are mounted on the floor of the production facility. There is the option to mount the turning unit on the DEMMELER rail system. This allows the distance between the two face plates to be set to different workpiece sizes.

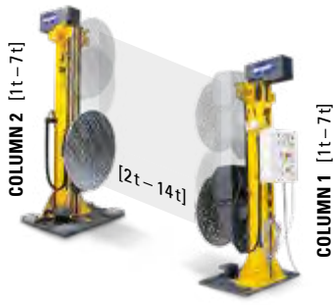
Benefits

- Ergonomic work that protects your back
- Improved workplace safety
- Ultimate productivity and improvement in quality thanks to the staff being in the ideal position for working
- Higher melting deposition rate when welding, as most seams can be produced in the optimal position (flat position)
- No need for time-consuming reclamping – the workpiece is lifted and turned in a single clamping cycle



For more information about the Robotix turning unit, please visit: www.demmeler.com.

Debaenst Lastechniek



Specifications without worktop.
Other equipment details available on request.

Basic model of the Robotix turning unit

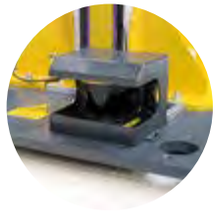
Description	WE 2000	WE 4000	WE 6000	WE 8000
Load capacity per column [kg]	1000	2000	3000	4000
Total load capacity [kg]	2000	4000	6000	8000
Standard height of rotation axis [mm]	540	600	600	600
Effective stroke [mm]	1700	1700	1700	1700
Turning radius [mm]	2240	2300	2300	2250
Torque [Nm]	2000	3000	6000	10000
Controller at control cabinet	✓	✓	✓	✓
Item no.	**I02-02000-050**	**I04-04000-050**	**I06-06000-050**	**I08-08000-050**

Description	WE 10000	WE 12000	WE 14000
Load capacity per column [kg]	5000	6000	7000
Total load capacity [kg]	10000	12000	14000
Standard height of rotation axis [mm]	600	600	600
Effective stroke [mm]	1700	1700	1700
Turning radius [mm]	2250	2250	2250
Torque [Nm]	10000	12000	12500
Controller at control cabinet	✓	✓	✓
Item no.	**I10-10000-050**	**I12-12000-050**	**I14-14000-050**

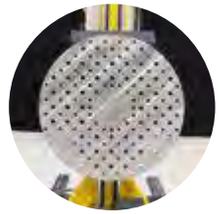


1 Controller at control cabinet
- Axis activation at the touch of a button
- Optional potentiometer, for setting the speed





2 Safety laser scanner
- Ensure both maximum safety and productivity
- Individually adaptable protection zone
- Display unit with monitor view/camera view and a clearly visible status LED for ultimate ease of use

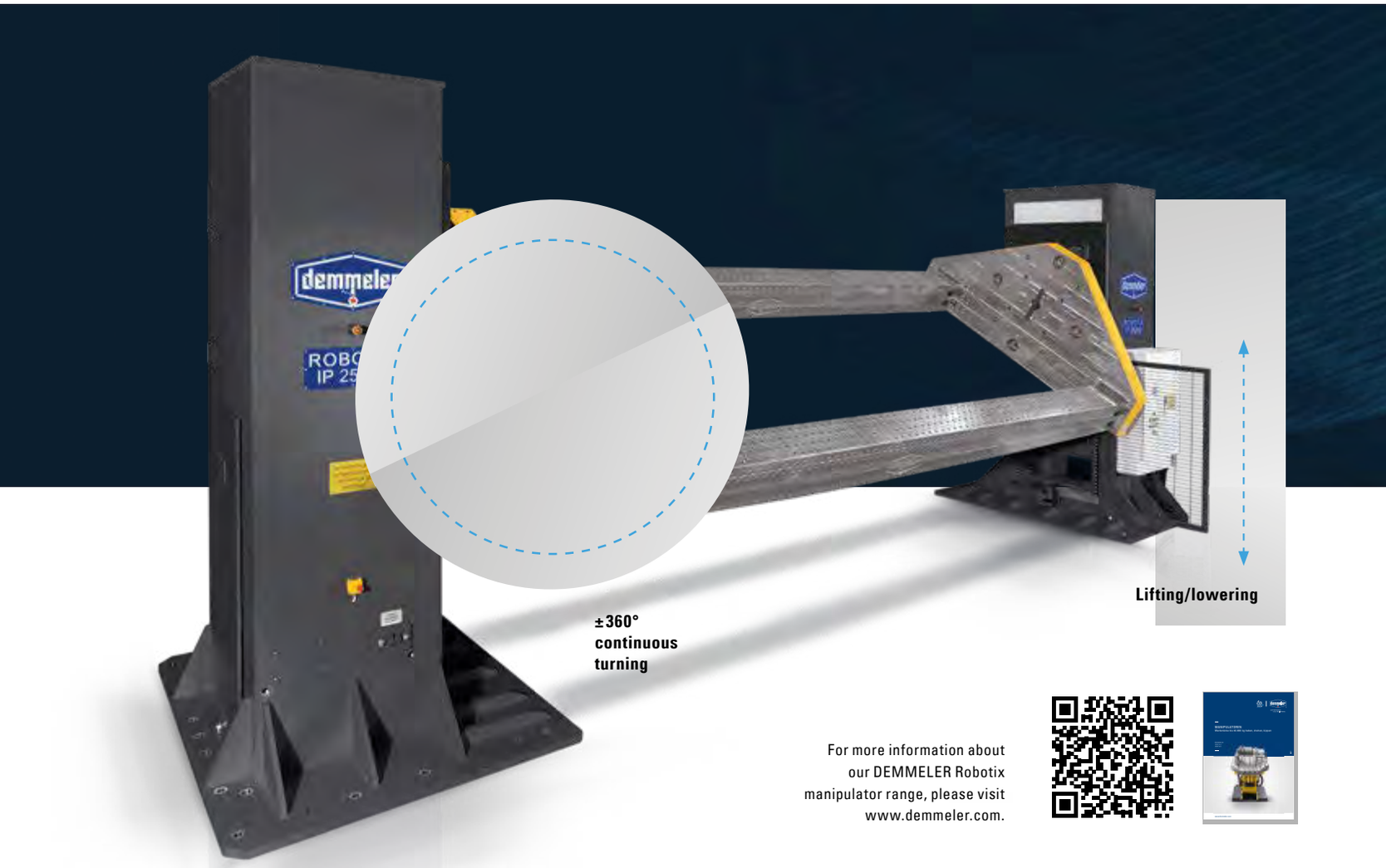


3 Adapter plates
Adapter plates with D28 system bores in a 100 x 100 mm grid and M24 thread are available as an option

Optional equipment versions (available on request)

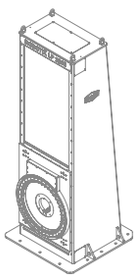
Adapter plates from dia. 600 to dia. 1500 mm
Slave lifting block is mobile and not stationary
Drive lifting block is mobile and not stationary
Welding current supply 350 A
LCD display on the control box
Variable frequency control of the rotary drive for continuously variable speed selection up to 12,500 Nm
Variable frequency control of the rotary drive for continuously variable speed selection above 20,000 Nm
Adjustable torque limit using friction clutch in the rotary drive
Area scanner for preventing the system from colliding with an obstacle or turning onto an obstacle
Effective stroke increased every 100 mm
Special flange plate or drilling pattern change

Debaenst Lastechniek



For more information about
our DEMMELER Robotix
manipulator range, please visit
www.demmeler.com.

When you have something big in mind. Lift and turn workpieces up to 40,000 kg.



Robotix basic device

Description	IP 20000	IP 40000
Bearing load (w/o worktop) [kg]	20000	40000
Lifting axis:		
Drive	servohydraulic	servohydraulic
Lifting speed [m/min]	1,5	1
Max. lifting height [mm]	2200	2450
Minimum height [mm]	1050	1050
Maximum height [mm]	3250	3500
Rotary axis 1/tilt axis:		
Min./max. speed [rpm]	0,2 – 1,0	0,2 – 1,0
Angle of rotation [°]	± 360 continuous turning	± 360 continuous turning
Torque [Nm]	24000	50000
Controller at control cabinet	✓	✓
Item no.	**I20-01000-100**	**I40-01000-100**

Specifications without worktop. Other equipment details available on request.

Debaenst Lastechniek





When you have big ambitions, you need machinery to match. With the Robotix IP manipulator, you can position your workpieces flexibly, manufacture efficiently and work ergonomically. In a relaxed posture, a welding seam can be welded far more precisely. Optimum positioning of the workpiece also achieves an ideal production process: No flowing of the welding material. We can offer you the right product among numerous solutions.

We develop, design and construct customised clamping fixtures for you on request

Optional equipment

Control options	**IP 20000**	**IP 40000**
Programming controller	Z10-W1000-102	Z20-W1000-102
Laser scanner	Z10-W1000-101	Z20-W1000-101
Connection as additional robot axis	Z10-W1000-103	Z20-W1000-103
Counter-support for rotary axis 1	Z10-W1000-108	Z20-W1000-108

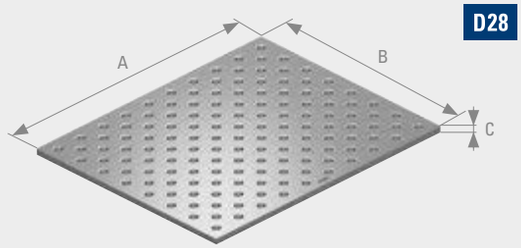
Positioning options	**IP 20000**	**IP 40000**
Preparation for assembly on DEMMELER rail system for each lifting column	Z10-W1000-109	Z20-W1000-109
DEMMELER rail system (per metre)	D28-W2003-000	D28-W2003-000

Additional options	**IP 20000**	**IP 40000**
Rotary feedthrough for status queries, electrical	Z10-W1000-104	Z20-W1000-104
Rotary feedthrough for pneumatic clamping fixtures	Z10-W1000-105	Z20-W1000-105
Rotary feedthrough for hydraulic clamping fixtures	Z10-W1000-106	Z20-W1000-106
Earth connection for welding device	Z10-W1000-107	Z20-W1000-107

Debaenst Lastechniek

Clamping and adapter plate

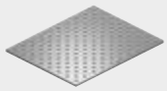
- The miniature welding table with grid lines
- Used in combination with 3D welding tables and rotary welding tables
- M8 thread on all sides, e.g. for stops
- Other dimensions available on request



D28

Adapter plate D28

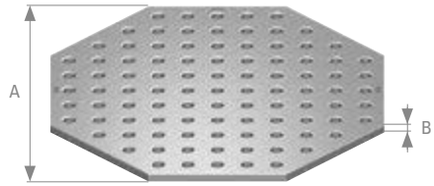
D28



A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
1000	800	25	150	100 x 100 mm diagonal grid	D28-02001-000

Adapter plate Okto WAF

- The miniature welding table with grid lines
- Used in combination with 3D welding tables and rotary welding tables
- M8 thread on all sides, e.g. for stops
- Other dimensions available on request



D28
D16

Adapter plate D28 Okto WAF

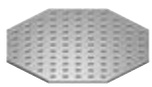
D28



A in mm	B in mm	Approx. weight in kg	Description	Item no.
WAF 600	25	55	100 x 100 mm diagonal grid	D28-02001-201
WAF 800	25	95	100 x 100 mm diagonal grid	D28-02001-202
WAF 1000	25	145	100 x 100 mm diagonal grid	D28-02001-203

Adapter plate D16 Okto WAF

D16



A in mm	B in mm	Approx. weight in kg	Description	Item no.
WAF 400	12	11	50 x 50 mm diagonal grid	D16-02100-106
WAF 600	12	25	50 x 50 mm diagonal grid	D16-02100-107
WAF 800	12	45	50 x 50 mm diagonal grid	D16-02100-108

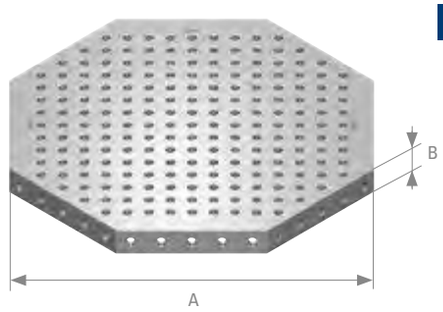
Debaenst Lastechniek

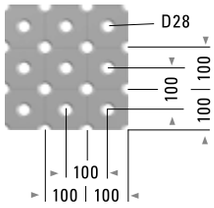
3D welding table D28 Okto WAF

- Preferred use on manipulators in robot cells
- Numerous clamping options on all nine clamping surfaces
- With 100 x 100 diagonal grid

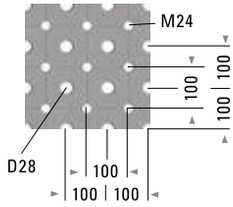
Other additional options available on request:
- High-strength aluminium titanium alloy, for approx. 60% weight reduction and approx. 10% higher bending strength
- With special connection drilling pattern, adapted to the face plate of your manipulator (please include manipulator type and drawing of the face plate with enquiry – can be offered for a surcharge)
- Prepared for table legs

D28



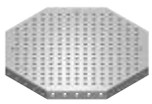


100 x 100 mm
diagonal grid



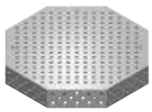
Optional:
Welding table with
100 x 100 mm diagonal grid
and M24 thread

3D welding table D28 Okto 100 WAF — D28



A in mm	B in mm	Approx. weight in kg	Description	Item no.
WAF 600	100	88	100 x 100 mm diagonal grid	PL28-11008-001
WAF 800	100	165	100 x 100 mm diagonal grid	PL28-01013-001
WAF 1000	100	210	100 x 100 mm diagonal grid	PL28-01038-001
WAF 1200	100	310	100 x 100 mm diagonal grid	PL28-01020-001
WAF 1400	100	450	100 x 100 mm diagonal grid	PL28-01087-001
WAF 1500	100	490	100 x 100 mm diagonal grid	PL28-01059-001
WAF 1600	100	540	100 x 100 mm diagonal grid	PL28-11036-001
WAF 1800	100	670	100 x 100 mm diagonal grid	PL28-01049-001
WAF 2000	100	795	100 x 100 mm diagonal grid	PL28-01058-001
WAF 3000	100	1650	100 x 100 mm diagonal grid	PL28-12010-001

3D welding table D28 Okto 200 WAF — D28



A in mm	B in mm	Approx. weight in kg	Description	Item no.
WAF 600	200	141,5	100 x 100 mm diagonal grid	PL28-11008-000
WAF 800	200	194	100 x 100 mm diagonal grid	PL28-01013-000
WAF 1000	200	340	100 x 100 mm diagonal grid	PL28-01038-000
WAF 1200	200	415	100 x 100 mm diagonal grid	PL28-01020-000
WAF 1400	200	515	100 x 100 mm diagonal grid	PL28-01087-000
WAF 1500	200	565	100 x 100 mm diagonal grid	PL28-01059-000
WAF 1600	200	675	100 x 100 mm diagonal grid	PL28-11036-000
WAF 1800	200	810	100 x 100 mm diagonal grid	PL28-01049-000
WAF 2000	200	980	100 x 100 mm diagonal grid	PL28-01058-000
WAF 3000	200	2000	100 x 100 mm diagonal grid	PL28-12010-000

Debaenst Lastechniek

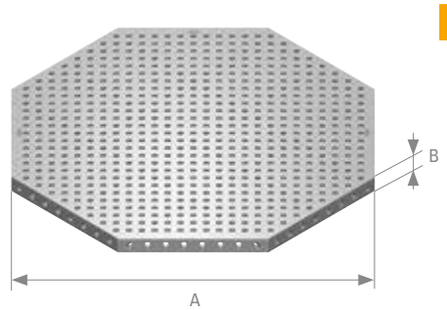


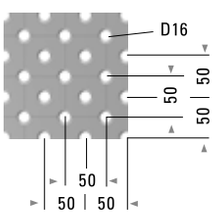
3D welding table D16 Okto WAF

- Preferred use on manipulators in robot cells
- Numerous clamping options on all nine clamping surfaces
- With 50 x 50 mm diagonal grid

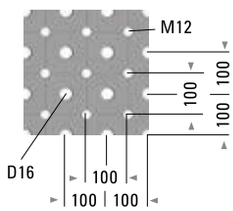
Other additional options available on request:
- High-strength aluminium titanium alloy, for approx. 60% weight reduction and approx. 10% higher bending strength
- With special connection drilling pattern, adapted to the face plate of your manipulator (please include manipulator type and drawing of the face plate with enquiry – can be offered for a surcharge)
- Prepared for table legs

D16





50 x 50 mm
diagonal grid



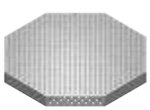
Optional:
Welding table with
50 x 50 mm diagonal grid
and M12 thread

3D welding table D16 Okto 50 WAF — D16



A in mm	B in mm	Approx. weight in kg	Description	Item no.
WAF 600	50	50	50 x 50 mm diagonal grid	PL16-01009-001
WAF 800	50	80	50 x 50 mm diagonal grid	PL16-01008-001
WAF 1000	50	110	50 x 50 mm diagonal grid	PL16-01024-001
WAF 1200	50	150	50 x 50 mm diagonal grid	PL16-01070-001

3D welding table D16 Okto 100 WAF — D16



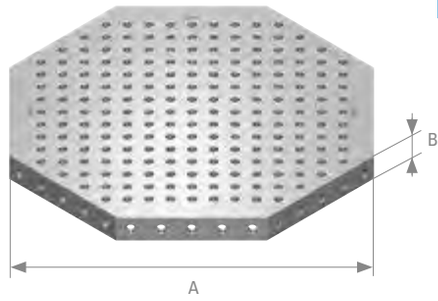
A in mm	B in mm	Approx. weight in kg	Description	Item no.
WAF 600	100	51	50 x 50 mm diagonal grid	PL16-01009-000
WAF 800	100	94	50 x 50 mm diagonal grid	PL16-01008-000
WAF 1000	100	140	50 x 50 mm diagonal grid	PL16-01024-000
WAF 1200	100	185	50 x 50 mm diagonal grid	PL16-01070-000

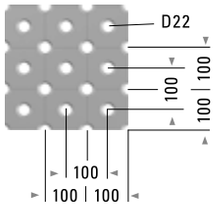
Debaenst Lastechniek

3D welding table D22 Okto 100 WAF

- Preferred use on manipulators in robot cells
- Numerous clamping options on all nine clamping surfaces
- In the D22 bore grid 100 x 100
- Diagonal bore produced in M16
- High-strength aluminium titanium alloy, for approx. 60% weight reduction and approx. 10% higher bending strength
- Together with the adapter plate, with special connection drilling pattern, adapted to the face plate of your manipulator (please include manipulator type and drawing of the face plate with your enquiry)

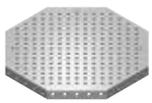
D22





100 x 100 mm
diagonal grid

3D welding table D22 Okto 100 WAF — D22



A in mm	B in mm	Approx. weight in kg	Description	Item no.
WAF 600	100	36,5	100 x 100 mm diagonal grid	PL22-11008-001
WAF 800	100	44,0	100 x 100 mm diagonal grid	PL22-01013-001
WAF 1000	100	62,5	100 x 100 mm diagonal grid	PL22-01038-001

Adapter plate

- Interface element for adaptation of the 3D welding table Okto 100 D22 to welding robot or manipulator
- Recommended for automation solutions and robotics applications
- Interface drilling pattern produced according to customer requirements
- Including mounting screws

D22



Adapter plate D22 — D22



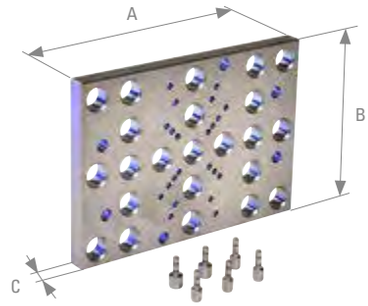
A in mm	Approx. weight in kg	Description	Item no.
WAF 600	30,5	Adapter plate for table WAF 600	00116157
WAF 800	65,0	Adapter plate for table WAF 800	00116159
WAF 1000	108,0	Adapter plate for table WAF 1000	00116160

Debaenst Lastechniek

Clamping plates for flanges DIN 2632/2633/2634/2635

- Pipe flanges can be quickly and precisely set out on the hole circle using attachment bolts and secured with the D28-08001-000 quick-release toggle clamp. In addition, D28 system bores are used to mount the system's clamping elements.
- Attachment bolts are included in the scope of delivery
- Marking of the hole circles
- Clamping plates for other flanges available on request

D28



Clamping plates for flanges DIN 2632/2633

D28



- DIN 2633 nominal diameters DN 15 – DN 200
- DIN 2632 nominal diameters DN 200
- Including attachment bolts: 2x dia. 13.8 mm, 2x dia. 17.8 mm, 2x dia. 21.8 mm

A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
350	250	25	12	Including attachment bolts	D28-02005-000

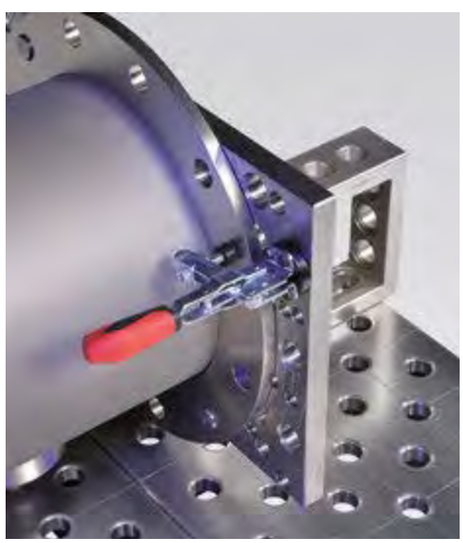
Clamping plates for flanges DIN 2632/2633/2634/2635

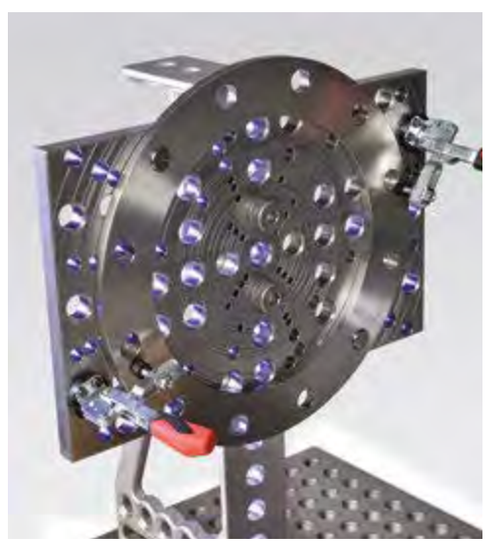
D28

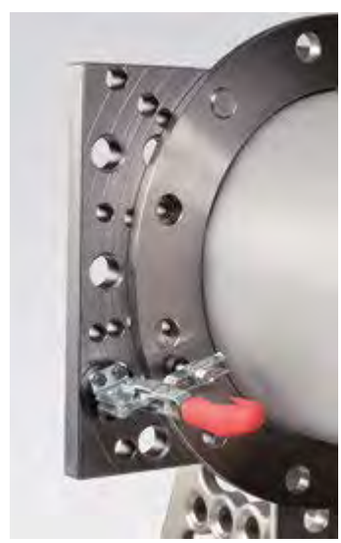


- DIN 2632 nominal diameters DN 200 – DN 400
- DIN 2633 nominal diameters DN 15 – DN 400
- DIN 2634 nominal diameters DN 200 – DN 400
- DIN 2635 nominal diameters DN 50 – DN 400
- Including attachment bolts: 2x dia. 13.8 mm, 2x dia. 17.8 mm, 2x dia. 21.8 mm, 2x dia. 25.8 mm, 2x dia. 29.8 mm, 2x dia. 32.8 mm, 2x dia. 35.8 mm, 2x dia. 38.8 mm

A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
550	350	25	30	Including attachment bolts	D28-02006-000





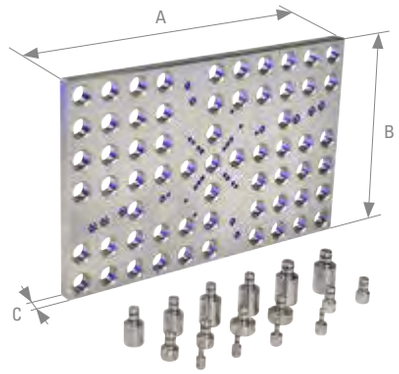


Debaenst Lastechniek

Clamping plates for ANSI flanges/JIS flanges

- Pipe flanges can be quickly and precisely set out on the hole circle using attachment bolts and secured with the D28-08001-000 quick-release toggle clamp. In addition, D28 system bores are used to mount the system's clamping elements.
- Attachment bolts are included in the scope of delivery
- Marking of the hole circles
- Clamping plates for other flanges available on request

D28



Clamping plates for ANSI flanges (ANSI standard B 16.5)



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

Clamping plates for JIS flanges



A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
350	250	25	12	JIS 5K – DN 10 – DN 225	D28-02005-018
550	350	25	30	JIS 5K – DN 10 – DN 450	D28-02006-034
350	250	25	17	JIS 10K – DN 10 – DN 225	D28-02005-019
550	350	25	30	JIS 10K – DN 10 – DN 450	D28-02006-005
350	250	25	12	JIS 16K/20K – DN 10 – DN 200	D28-02005-020
550	350	25	35	JIS 16K/20K – DN 10 – DN 400	D28-02006-035
350	250	25	12	JIS 30K – DN 10 – DN 200	D28-02005-021
550	350	25	30	JIS 30K – DN 10 – DN 350	D28-02006-036
350	250	25	12	JIS 40K – DN 10 – DN 150	D28-02005-022
550	350	25	30	JIS 40K – DN 10 – DN 350	D28-02006-037
350	250	25	12	JIS 63K – DN 10 – DN 150	D28-02005-023
550	350	25	30	JIS 63K – DN 10 – DN 350	D28-02006-038

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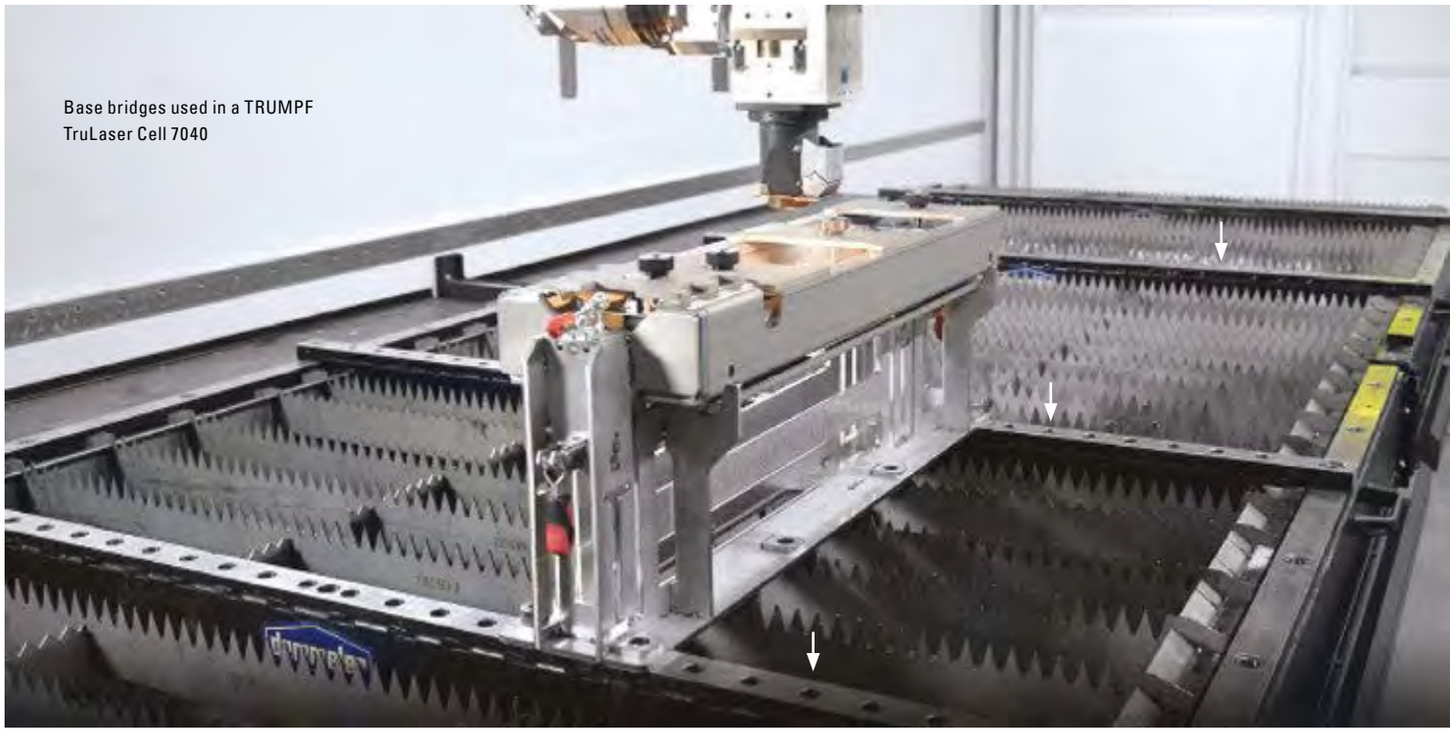
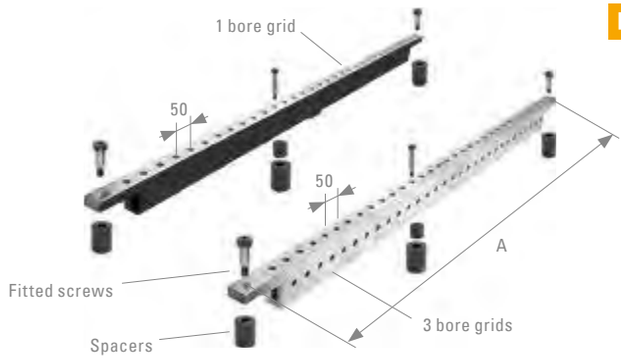


Base bridges used in a TRUMPF TruLaser Cell 7040

Base bridges

- Designed especially for use on laser machines (e.g. TRUMPF Lasercell 105, 1005, 6005, 7040)
- In conjunction with a D16-02100-000 segmented grid plate for many clamping options
- Direct mounting of clamping components possible
- Including assembly accessories such as fitted screws and spacers for mounting on the laser machine
- Grid lines every 50 mm, system bores every 50 mm



D16

Base bridges — D16

	A in mm	Approx. weight in kg	Description	Item no.
	1000	7	1 bore grid, for TRUMPF Lasercell 1000	D16-04100-002
	1366	16	1 bore grid, for TRUMPF Lasercell 105	D16-04100-010
	1500	17	1 bore grid, for TRUMPF Lasercell 7000	D16-04100-049
	1682	20	1 bore grid, for TRUMPF Lasercell 1005	D16-04100-009
	2182	24	1 bore grid, for TRUMPF Lasercell 6005	D16-04100-013
	1500	17	1 bore grid, for TRUMPF Lasercell 7040	D16-04100-027
	2000	22	1 bore grid, for TRUMPF Lasercell 7020	D16-04100-036
	2000	22	1 bore grid, for TRUMPF Lasercell 7000	D16-04100-050
	1366	30	3 bore grids, for TRUMPF Lasercell 105	D16-04100-008
	1682	36	3 bore grids, for TRUMPF Lasercell 1005	D16-04100-005
	2182	48	3 bore grids, for TRUMPF Lasercell 6005	D16-04100-012
	1500	30	3 bore grids, for TRUMPF Lasercell 7040	D16-04100-026

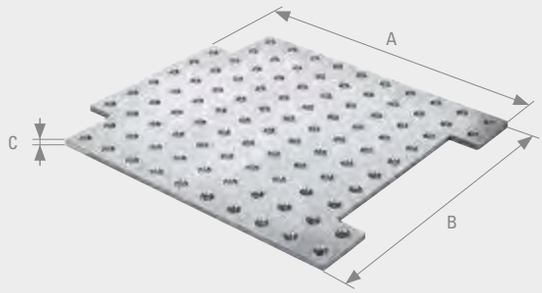
Other dimensions available on request. Figure similar.

Debaenst Lastechniek

Segmented grid plate

- Highly flexible clamping options thanks to 50 mm grid
- Nesting the contours inside each other enables a continuous clamping area
- Specially for use in conjunction with base bridges on 3D laser machines
- Grid lines every 50 mm

D16

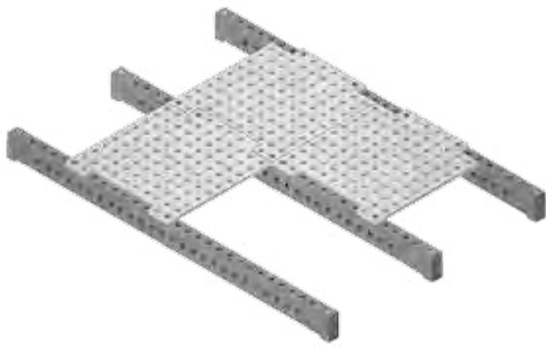


Segmented grid plate D16

D16



A in mm	B in mm	C in mm	Approx. weight in kg	Description	Item no.
548	498	12	22	50 x 50 mm grid	D16-02100-000



Segmented grid plates mounted on base bridges enable a continuous floor plate

Short PC countersunk bolts are used for mounting, see page 123




















Debaenst Lastechniek

DO YOU WANT TO KNOW HOW OUR PRODUCTS ARE USED IN PRACTICE?

Companies all over the world rely on DEMMELER to boost their productivity and improve safety and ergonomics at the workplace. The trust that they place in us and the positive feedback that we receive from them are the best testimony of how satisfied they are with our company. Here you can find a current selection of successful projects with companies from various different industries and a description of the impact DEMMELER has had on their everyday work.

Debaenst Lastechniek

Welding at the highest level with ultimate flexibility







Schulz Fördersysteme GmbH specialises in metalworking. In addition to sheet metal parts, edge parts and welded assemblies, the company also produces conveyor systems. Around 100 members of staff work for the brands Schulz Fördersysteme and Blechbearbeitung Thüringen at the Geratal site in Thüringen. As a certified specialist business in accordance with DIN EN 15085-2 CL1, Schulz Fördersysteme has a special responsibility for producing highly safety-relevant components for rail vehicles. The fact that the company sees itself as a system supplier with a high vertical range of manufacture is also evident from its state-of-the-art production processes.

A few months ago, the company also started to use a COBOT WeldSpace 4.0 from DEMMELER alongside a DEMMELER manipulator and rail system. With the new COBOT system, Schulz Fördersysteme can quickly and easily adapt to varying component geometries or sizes in production. In addition to being easy to program, the COBOT WeldSpace 4.0 is designed to reduce the physical exertion of welders. Welders are often forced to work in uncomfortable positions as the weld seams are frequently hard to reach. This is why the SPACE B workspace of the COBOT system was equipped with a two-axis manipulator: Workpieces up to 500 kg can be easily clamped in the ideal flat position. There is no longer a need for time-consuming reclamping of workpieces and, thanks to the manipulator's rotary axis, even circumferential seams can be welded without any problems.

"We are a contract manufacturer specialising in sheet metal machining for a range of different industries: Automotive, rail, machinery and plant construction, conveyor technology, furniture and metal construction. Our flexibility has always been one of our greatest strengths compared to our competitors," states Carsten Stein, Managing Director at Schulz Fördersysteme. DEMMELER assists us with its large variety of products, which can be used to produce small and medium batch sizes. We appreciate the excellent quality of DEMMELER products – and the outstanding service!"

SCHULZ FÖRDERSYSTEME GMBH

Blechbearbeitung Thüringen

SCHULZ FÖRDERSYSTEME GMBH
AN DER GLASHÜTTE 10
99330 GERATAL – GRÄFENRODA · GERMANY

Debaenst Lastechniek





Multiple parts, including different ones, can be welded simultaneously using the COBOT WeldSpace 4.0. The automatic enclosure movement makes it possible to work in multi-station mode. While the robot is welding on one side, the operator – protected by retractable roller doors with aluminium cladding and integrated welding protection glass – can set up and reclamp on the other side in parallel (two-station operation).

Debaenst Lastechniek





Vacuum sweeper combinations, lawn care machines, snowploughs or spreaders – kugelmann's strengths lie in the quality and expertise in solutions from a single source

© kugelmann

Debaenst Lastechniek

kugelmann*

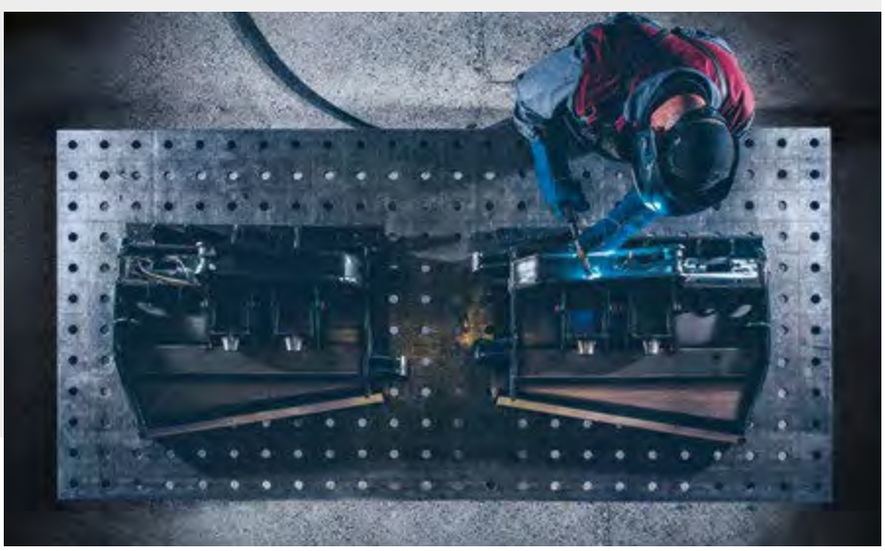
kugelmann Maschinenbau –
a family-run company from the Allgäu region with a focus on and tradition of municipal technology

"That's not our only reason for claiming to be 'different from the rest'." As a medium-sized family business with its roots in mechanical engineering, kugelmann has been present on the market since 1952 and continuously develops new technologies and optimises production with an extensive business area ranging from municipal to laser technology. Whether it's vacuum sweeper combinations, lawn care machines, snowploughs or spreaders – the company's strengths lie in the quality and expertise in solutions from a single source.

PIONEERING SOLUTIONS WITH A PASSION FOR DETAILS

The municipal machinery, including electronic control systems, hydraulics, mechanics and cladding, is entirely developed and manufactured at the production site in Germany. Thanks to the high vertical range of manufacture and the modern product facilities, both small and large series can be produced quickly and cost-effectively. The high quality of the products is the result of state-of-the-art processing of steel and sheet metal directly on site, as well as the company's philosophy of processing raw materials of the very highest quality and only manufacturing to order.





Constructions from kugelmann always have one thing in common: The ability to perfectly resolve customers' unique issues, while always remaining committed to keeping the promise to use the company's expertise in innovative mechanical engineering and to fulfil its high standards for perfect workmanship.

KUGELMANN MASCHINENBAU E.K.
GEWERBEPARK 1–5 · 87675 RETTENBACH AM AUERBERG · GERMANY

Debaenst Lastechniek



VOSS Fluid is a premium manufacturer and quality supplier of connecting systems for mobile and stationary hydraulics. The high quality standards that VOSS Fluid GmbH requires from its products are also reflected in its range of services. As a system partner for hydraulic systems, the extensive range of services is specifically designed to show users where there is the potential to make savings and initiate optimisation processes. For instance, the company offers full project support, from engineering through to special logistics services. Assembly audits are also part of our service portfolio, alongside hydraulic system consultation. The company is always aligned with the industry- and company-specific needs and specifications of its customers.

FLUID SYSTEMS IN LINE WITH THE HIGHEST QUALITY STANDARDS

"Making what's good even better" – true to this motto, experienced engineers and technicians work on innovative hydraulic components for a variety of applications at the headquarters in Wipperfürth. When developing products, the focus is on maximum process reliability. This is how the company creates products that impress across the board.

VOSS FLUID GMBH · LÜDENSCHEIDER STR. 52–54 · 51688 WIPPERFÜRTH · GERMANY

VOSS

Debaenst Lastechniek



Ready-to-install hydraulic lines

© VOSS Fluid

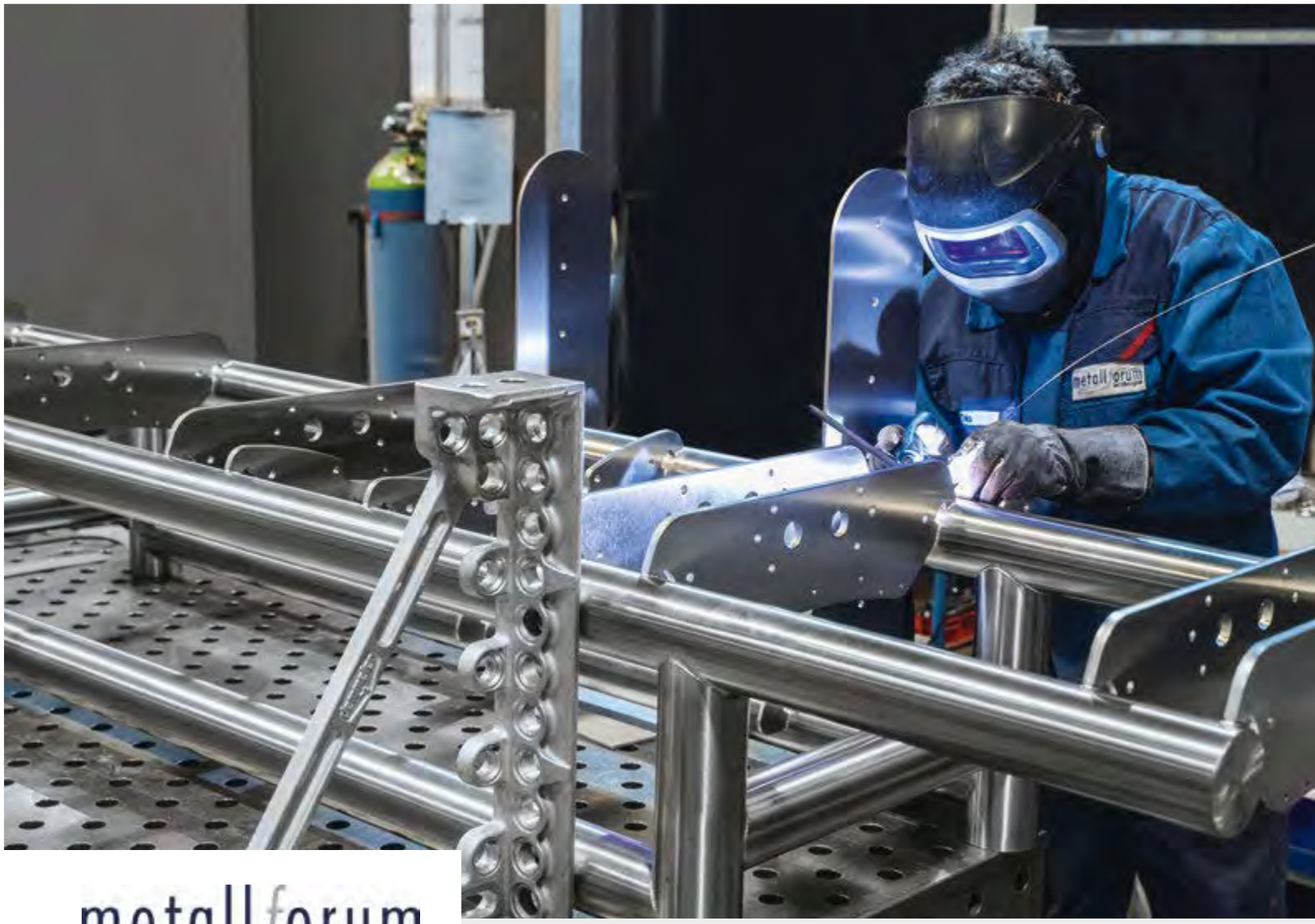


As a premium manufacturer, VOSS Fluid applies its high standards for individual components to the production of individually manufactured, ready-to-install hydraulic lines too.



The latest production technologies and a high degree of automation ensure a consistently high level of quality at VOSS Fluid.

Debaenst Lastechniek



metallforum
metallbau gmbh

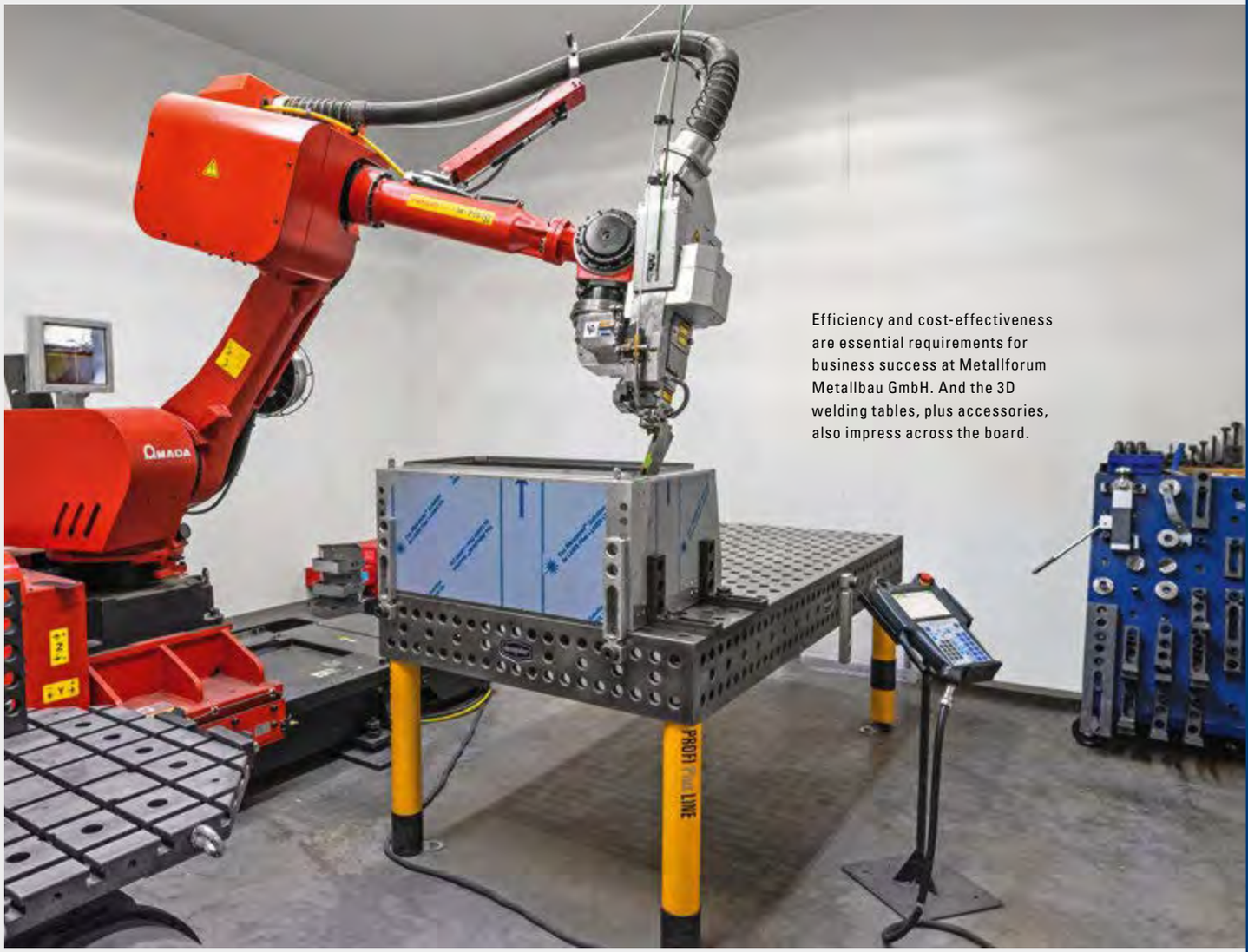
METALLFORUM METALLBAU GMBH · SIEMENSSTRASSE 16 · 31180 GIESEN · GERMANY

Production expertise as a success factor – tailor-made structures created from steel, stainless steel and aluminium, whether manufactured as individual parts or in series production

As an expert point of contact, Metallforum Metallbau GmbH produces structures made from steel, stainless steel and aluminium. With modern machinery and a high-achieving team of 20 members of staff and four trainees, the company offers an extensive range of products, including those from the sectors of vehicle construction, medium-voltage switchgear, tubular frames for mechanical engineering, components for road-rail vehicles, special constructions, billboards, control cabinets and much more in highly precise quality. The company also offers production processes such as laser cutting, CNC tube bending, welding and laser robot welding as a contract service provider.

By using the 3D clamping systems from DEMMELER and state-of-the-art machinery, Metallforum Metallbau GmbH in Ahrbergen is continuously expanding its expertise in production. This forms the foundation for the company's success, enabling it to effectively set itself apart from the competition as an efficient provider of solutions. "Quality is at the forefront of all our products," explains Jens Löchel, Managing Director at Metallforum Metallbau GmbH. "However, we are also characterised by our flexibility and fast response times, our first-class service and our punctuality." The company made a conscious decision to use the extensive DEMMELER clamping system for this.

Debaenst Lastechniek



Efficiency and cost-effectiveness are essential requirements for business success at Metallforum Metallbau GmbH. And the 3D welding tables, plus accessories, also impress across the board.





Stainless steel constructions are one of more than one thousand products to be produced by the company that was founded in 1996.

Debaenst Lastechniek



Debaenst Lastechniek



Precision and efficiency in individual and series production

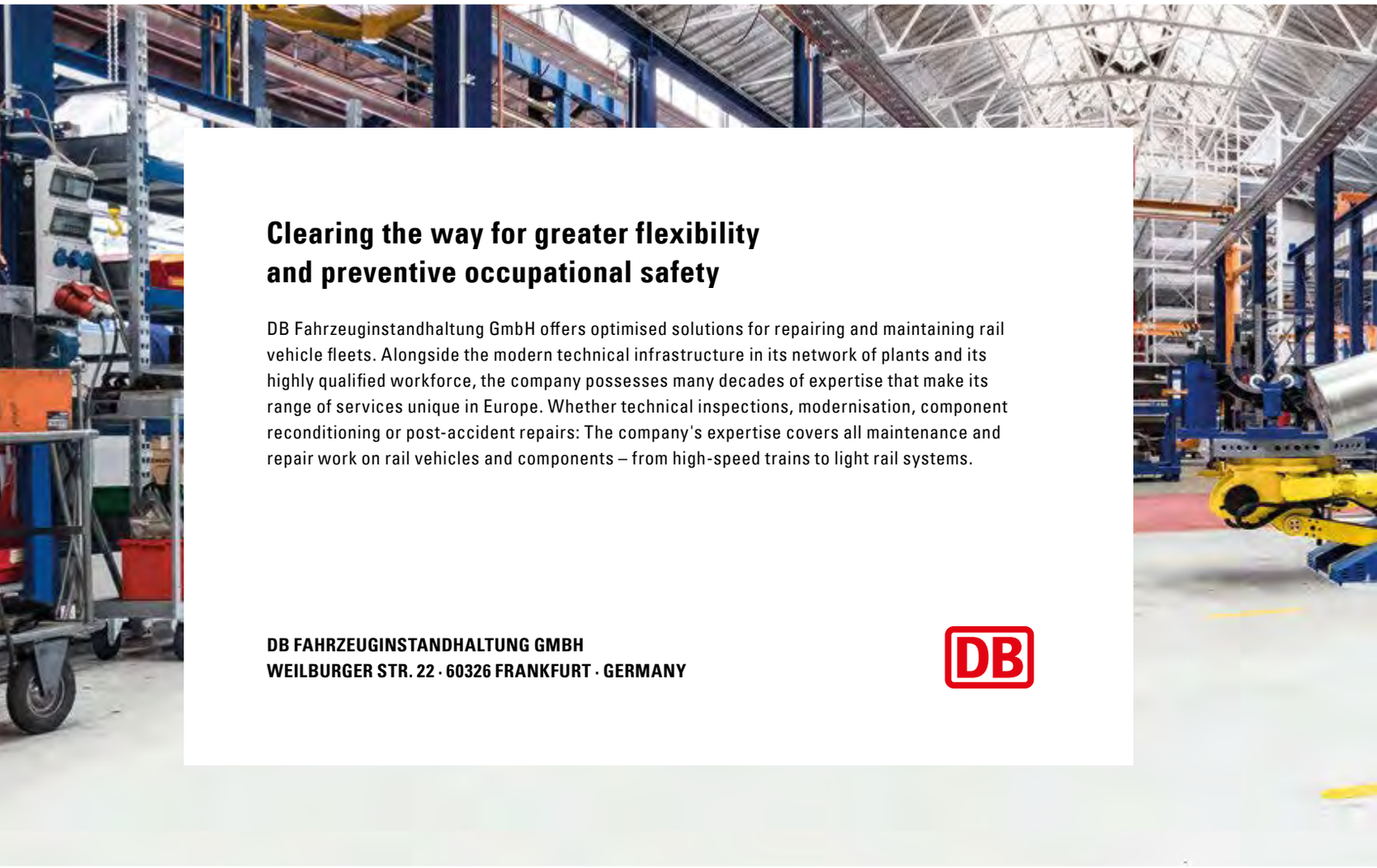
Braunholz Metallbau GmbH from Hanover focuses on the production of high-quality, customised individual products made from steel, weathering steel, stainless steel and aluminium, and the industrial series production of complete assemblies. The customers of the medium-sized company come from a wide variety of industries.

The extensive range of services available from Braunholz Metallbau not only requires experienced and expert employees, but also equipment that can be used flexibly. The company has been producing products on and using 3D clamping systems from DEMMELER for years now. The sophisticated and flexible system of welding tables and system accessories has proven itself across the board many times over. High-quality and economical production is based on the highest dimensional accuracy, including for repetitive process steps, and fast fitting of workpieces. The company is ideally positioned to meet the demands of today and the needs of tomorrow.

Braunholz metallbau GmbH
Zertifiziert nach: DIN EN 1090
meisterbetrieb schweißfachbetrieb

BRAUNHOLZ METALLBAU GMBH
DESBROCKHEIDERING 36 · 30419 HANOVER
GERMANY

Debaenst Lastechniek



Clearing the way for greater flexibility and preventive occupational safety

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

DB FAHRZEUGINSTANDHALTUNG GMBH
WEILBURGER STR. 22 · 60326 FRANKFURT · GERMANY

Excellent posture and maximum productivity



Thanks to the large working space, paired with a small footprint, the DEMMELER Ergonomix®M manipulator is the ideal addition to the state-of-the-art production facilities. Thanks to the patented swivel range of up to 180°, the workpieces can be fully assembled in one clamping cycle without additionally having to be turned over.



The manipulator, which boasts both angular and height adjustment capabilities, consistently moves even the highest loads into the ideal position, thus permitting an ergonomic working posture even during heavy-duty handling operations. The assembly operations can be carried out without tiring and with consistently high precision.

Debaenst Lastechniek



Assembling gear sets for urban trains demands flexibility. To ensure quick changeovers of equipment, heavy wheelsets and gears weighing up to two tonnes must be positioned precisely and safely.

Debaenst Lastechniek



GOLDHOFER – an eventful history

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

GREAT, GREATER, GOLDHOFER –
the Swabian company continuously pushes the limits of what is possible according to this motto. With modern design and production technologies, Goldhofer creates trendsetting and economical transport solutions ranging from trailers to semi-trailers, from aircraft tugs to modular heavy lorries.

GOLDHOFER AKTIENGESELLSCHAFT
DONAUSTRASSE 95 · 87700 MEMMINGEN · GERMANY

Goldhofer

Debaenst Lastechniek



Heavyweights for heavy-duty applications

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



Goldhofer is one of DEMMELER's customers who uses the entire product range, from basic welding tables to sliding legs and rail systems, through to manipulators – also in custom versions.



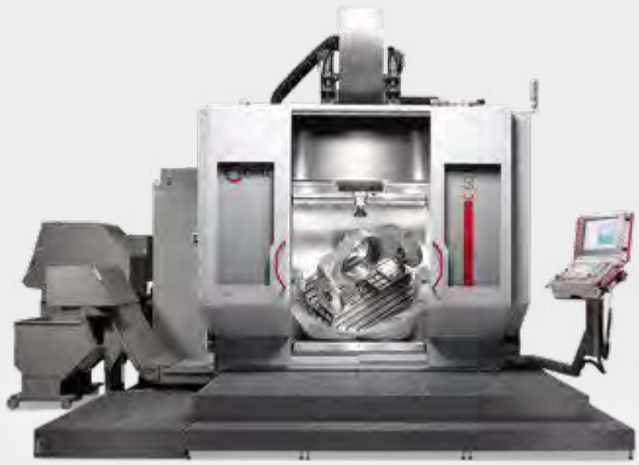
Production at Goldhofer can be almost be considered an overview of the numerous possible applications of DEMMELER solutions.

HERMLE – a name that is synonymous with high-precision machining centres around the world

With around 1000 highly motivated employees, Hermle is one of the leading manufacturers of high-precision machining centres and automation solutions, which occupy a leading national and international position. "Better milling" is Hermle's slogan for optimised results. This is because the proverbial Hermle precision has made the company an important machine manufacturer in many industries.

From large, complex components to miniature high-tech elements. From medical technology to motor racing, the Swabian company proves its expertise day after day. Based on customer requirements and the specific components being produced, Hermle also develops comprehensive solutions with perfectly harmonised tools, control systems and automation technologies.

MASCHINENFABRIK
BERTHOLD HERMLE AG
INDUSTRIESTRASSE 8–12
78559 GOSHEIM · GERMANY



C60 U



Debaenst Lastechniek



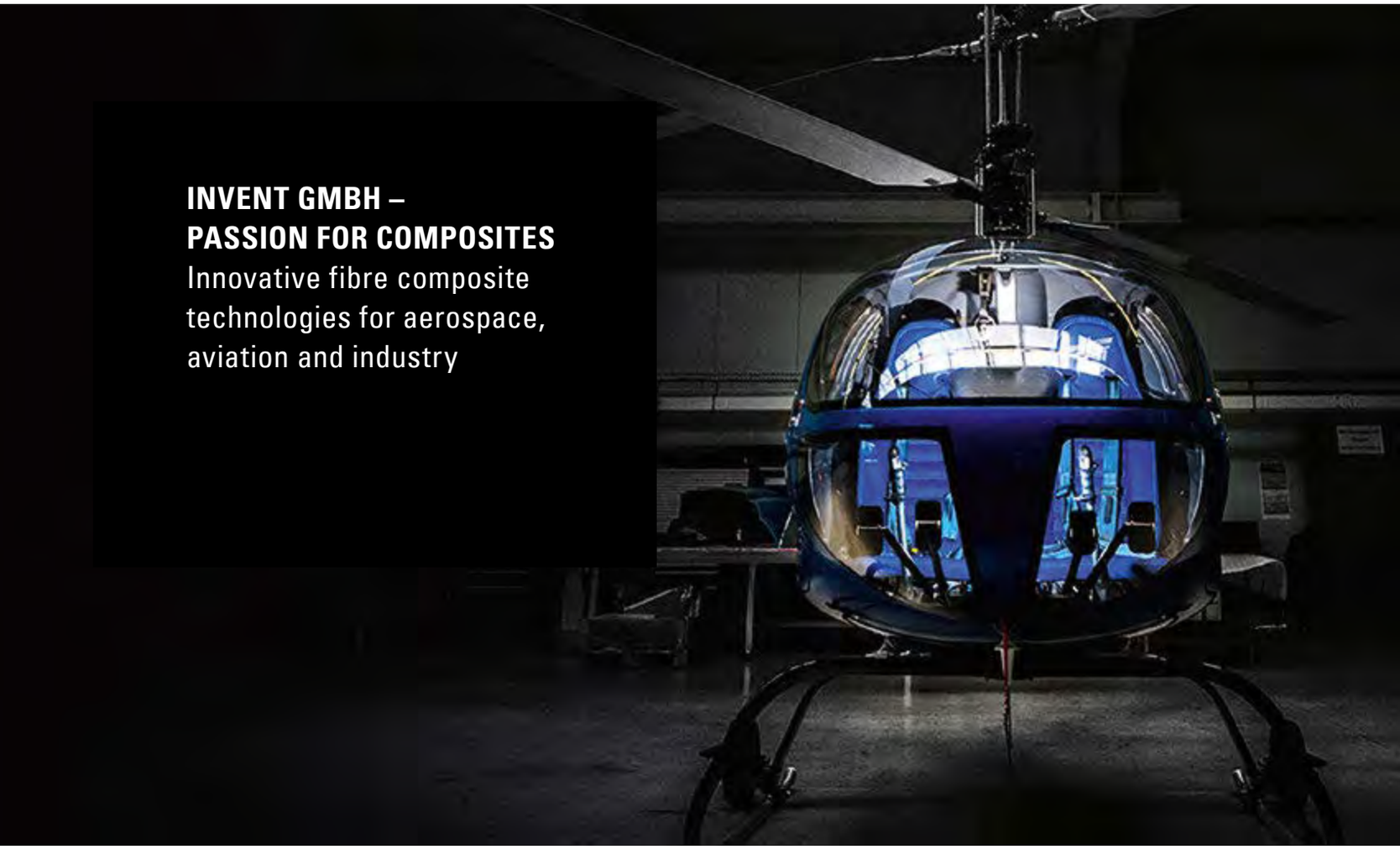




Productivity, precision and innovation are key characteristics of all Hermle products. Naturally this also applies to in-house production. The patented Ergonomix M® manipulator – with its swivel range of 180° – is capable of reproducibly positioning components weighing up to 1.5 t in assembly. Repeated, time-consuming rotating and turning of the workpieces, for example with a crane, are no longer necessary, greatly reducing non-productive time. The proven DEMMELER welding table systems with ergonomic scissor lift are used in welding too.

Mr Hipp (Head of Marketing at Hermle) also emphasises that the manipulators relieve the workers of heavy-duty handling tasks and enable them to work with an ergonomic posture. Assembly work can be carried out without tiring and with consistently high precision. Staff absences due to overexertion and illness are prevented as well. These are many good reasons in favour of the DEMMELER manipulators.

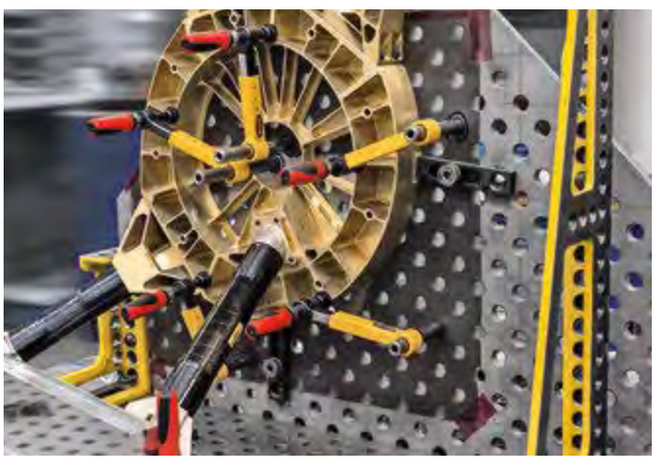
Debaenst Lastechniek



INVENT GMBH – PASSION FOR COMPOSITES

Innovative fibre composite technologies for aerospace, aviation and industry

Production of high-precision structural components with the DEMMELER 3D clamping system



As part of this complete package, the clamping system from DEMMELER is used. In many projects, composite parts are bonded with metal components with high precision. To do this, they are aligned and measured in relation to each other, which requires the flexibility and adaptability of the DEMMELER clamping system.



Thanks to the CAD database of all modules provided, these structures can be planned in detail, thus saving time and money. Even complex customer designs are precisely connected to the DEMMELER system using individually designed adapters.

Debaenst Lastechniek

Shaping the future sustainably: This requires ecologically pioneering and economically reasonable production of high-tech products made of fibre composites such as carbon fibre reinforced plastic (CFRP) or glass fibre reinforced plastic (GRP). Guaranteed to be suitable for the highest demands and use under extreme conditions. INVENT from Braunschweig can draw on many years of experience in the field of fibre composite technology. As an expert development partner, the company offers a comprehensive range of services.

TECHNOLOGICAL EXPERTISE IN ALL ASPECTS OF LIGHTWEIGHT CONSTRUCTION

As a recognised lightweight construction specialist for innovative fibre composite technologies in the aerospace, mechanical engineering, automotive, rail vehicle and shipbuilding industries, INVENT develops and produces high-precision structural components, from the initial idea through to series production. The company's own designers and constructors work very closely with a wide range of manufacturing specialists. This makes it possible to offer customers a complete package from a single source with regard to design, production planning, manufacturing processes, machining, joining and assembly, as well as painting and quality control.

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INVENT

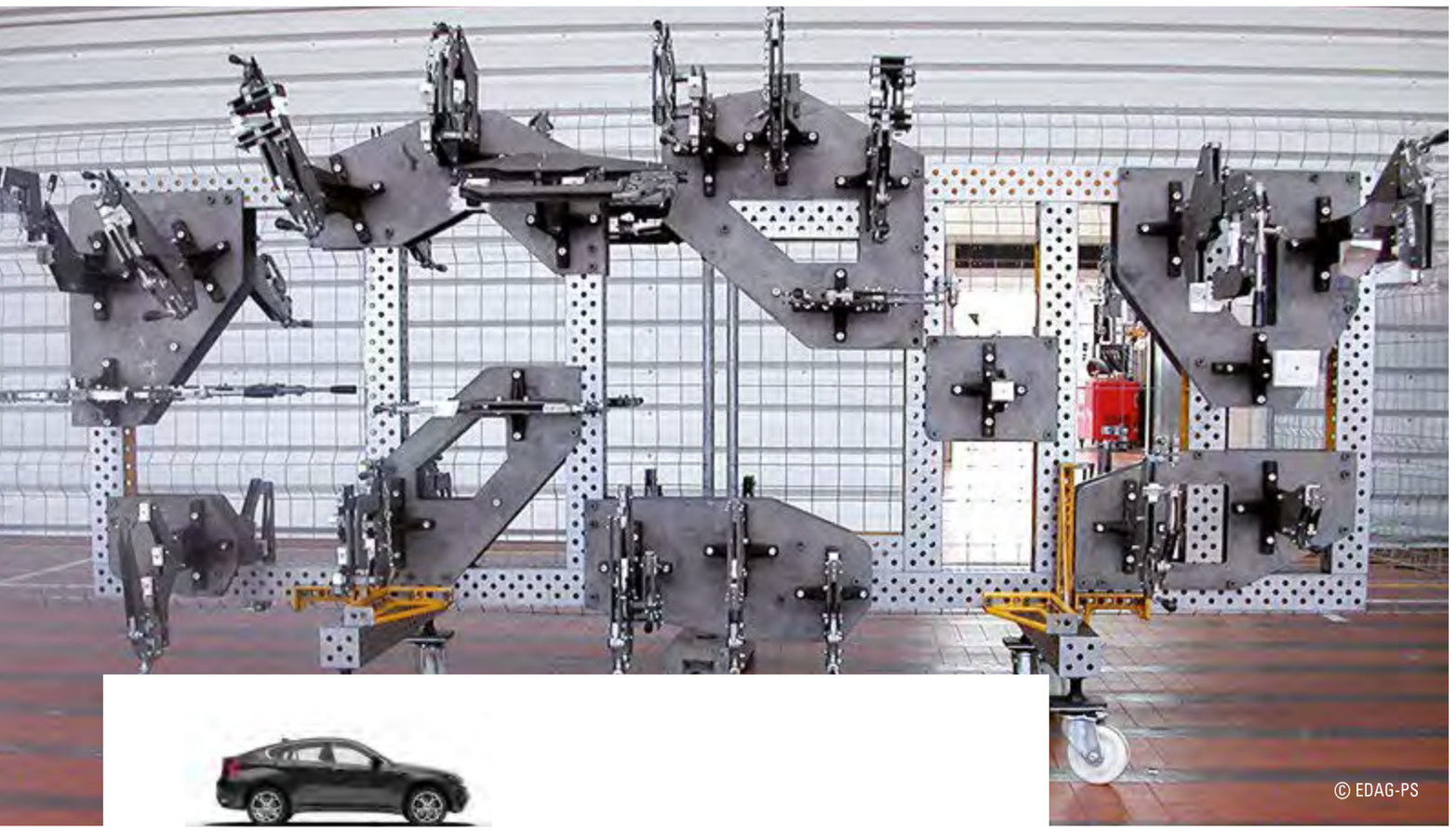


Using 3D measuring technology, it is also possible to align variable structures specifically with one another, which means that several configurations can be produced. DEMMELER COMPONENTS are used for this purpose.



On the other hand, due to the high dimensional accuracy of the drilling pattern, specially manufactured positioning systems can also be used flexibly.

Debaenst Lastechniek



Innovative tools for innovative solutions

EDAG Engineering AG is a globally active development partner for manufacturers of automobiles and rail vehicles. The experts at EDAG take an integrated approach and, beyond designing vehicle prototypes, plan the corresponding production facilities with the aim of providing effective solutions that optimise value creation. If you develop ideas that go beyond existing paradigms in the way that EDAG does, you require equipment to match. In other words: Flexible tradespeople need flexible tools.

Those in charge at EDAG have found the right workshop equipment for prototype building and plant construction in the form of the clamping and welding table solutions from DEMMELER. Especially since DEMMELER's development engineers are willing to explore new ideas and support customers along the way.





EDAG PRODUCTION SOLUTIONS

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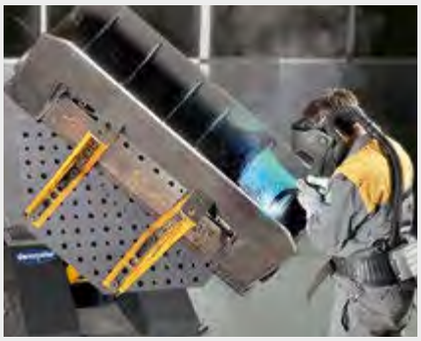
Precisely moving heavy loads – a Liebherr and DEMMELER speciality

When tonnes of weight hang from a hook, it is essential for crane components to have a solid construction. This is a huge challenge for the production of Liebherr cranes. Heavy workpieces must be moved effectively, safely and precisely. This is precisely what the DEMMELER manipulators were designed to do. Not only do they enable an effective manufacturing process, they also create an ergonomic workplace. An optimum working position prevents fatigue and thereby ensures quality – preventive occupational safety that pays off.

^ **Modular and mobile clamping fixtures –** lattice masts can be produced efficiently with the DEMMELER 3D clamping system.







LIEBHERR WERK NENZING GMBH
DR. HANS LIEBHERR STR. 1 · 6710 NENZING · AUSTRIA

Debaenst Lastechniek

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Heimertingen, 1st March 2022

Debaenst Lastechniek

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DEMMELER
Maschinenbau GmbH & Co. KG
Alpenstraße 10
87751 Heimertingen/Germany
Tel.: +49 8335 9859-0
sales@demmeler.com
www.demmeler.com

DEMMELER
Automatisierung & Roboter GmbH
Alpenstraße 10
87751 Heimertingen/Germany
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