A complete range for all operational requirements

- **MillTec GRIP**
  - 8 generation of a self-clamping force to the machine table equivalent to 25% of the nominal force of the system.
  - Each pole provides a remanent force of 1615 N to the workpiece and of 1156 N to the machine table.
  - The self-clamping function is supported to obtaining perfect stability and clamping authority.

- **MillTec Autocalump**
  - This is a version with double magnetic sector clamping elements capable of ensuring a stronger self-clamping force to the machine table.
  - Each pole can generate an holding force of 6156 N due to the workpiece and to the machine table.
  - However, only 40% of the latter magnetic force is activated during clamping phase; in other words, each pole presents reversed polarity and is activated during the unpredictable of the contact areas.
  - The remaining 20% of the poles remain not activated; in other words, the unpredictability of the contact areas and the eventual presence of polar extensions.
  - It generates a self-clamping force to the machine table.

- **MillTec Basic**
  - The self-clamping function to the machine table is not implemented in this version; in other words, each pole presents reversed polarity and is activated during obtaining perfect positioning stability, with no mechanical clamping elements.

The right choice

<table>
<thead>
<tr>
<th>Model</th>
<th>GRIP</th>
<th>AUTOCLAMP</th>
<th>BASIC</th>
</tr>
</thead>
<tbody>
<tr>
<td>Thickness</td>
<td>100%</td>
<td>80%</td>
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<tr>
<td>Weight</td>
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<td>NO</td>
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<td>Control</td>
<td>Mechanical</td>
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<tr>
<td>Force</td>
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<tr>
<td>Magnetic flux depth</td>
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<td>17mm</td>
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<tr>
<td>Size</td>
<td>MT 410 405 x 965 40 24.600</td>
<td>MT 408 405 x 800 32 19.700</td>
<td>MT 404 405 x 425 16 9.800</td>
</tr>
<tr>
<td>ST series</td>
<td>ST 100</td>
<td>ST 200</td>
<td>ST 300</td>
</tr>
<tr>
<td>Specifications</td>
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<td></td>
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<tr>
<td>Nominal force</td>
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<td>HD: 54 kN/m²</td>
<td>HD: 54 kN/m²</td>
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<td>Magnetic flux density</td>
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<td>HD: 270 mT</td>
<td>HD: 270 mT</td>
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<td>YES</td>
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<tr>
<td>Safety through power control</td>
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<td>YES</td>
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<tr>
<td>• Total safety</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• High power</td>
<td></td>
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<td></td>
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<tr>
<td>• Monolithic technology</td>
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<td></td>
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<tr>
<td>• Full metallic surface</td>
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<tr>
<td>• Low thickness and lightweight</td>
<td></td>
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<td></td>
</tr>
<tr>
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<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>• Total safety</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Electronic control units
MT series electronic control units are equipped with high power connectors to control the machine table.

**Mechanical connections**
MillTec modules are equipped with new waterproof connectors to ensure the highest reliability.

**Safety**
- Magnetic fl ux depth: 17mm
- Up to 16 kg/cm² in active magnetic area
- Over 75 Ton/m² in workpiece contact area

**Dimensions**
- MTGRIP: 60 x 42 kg/cm²
- MP: 54 x 24 kg/cm²
- MP 91: 54 x 22 kg/cm²
The Quadrupole technology patented by Tecnomagnete is represented in the image above. It shows the Permanent-electro magnets applied to the machine and a work holding system. The innovative clamping operation is achieved with the high magnetic mobility force (FMF) to operate safely even in case of inaccuracy or misalignment.

The bi-directional magnetic circuit

All 16 poles are energized by a double magnetic circuit design - Quadrupole - and can generate the highest level of magnetic induction into the steel with high magnetic mobility force (FMF) to operate safely even in case of inaccuracy or misalignment.

The quadrangular chessboard layout

It allows the magnetic flux flowing horizontally and vertically. Very few control inputs are concentrated in the polar area, thus in the surface that is clamped. Being all 16 poles absolutely identical, the magnetic circuit is perfectly balanced with no stop line, no magnetic interference and with constant and predictable performances (Ferrum Green area).

Innovative solutions

After the system has been activated by an electronic control unit, the work piece remote clamped with no lift, thanks to the constant power and no power supply, held only by the power of high energy permanent magnets. The system can be taken on board with a short electric pulse.

MillTec GRIP provides great advantages for operating a dramatic increase in productivity and quality.

MillTec GRIP revolutionizes the concept of magnetic clamping in milling machines and many others.

Now you can perform a real volumetric clamping, i.e. between the hemispheres and the work piece, and in two different axes under the magnetic field and the metallic surface.

The clamping force of the system to the machine table is 30% of the nominal force.

The reduced thickness and the reduced weight help to optimize the machine performance, increasing the durability and the tool security, but cycle times faster with less stress.

Magnetic clamping on injection molding, metal stamping and heavy duty machining operations.

The innovative magnetic system for milling applications such as die casting allows to achieve a wide range of strong and safe magnetic modules suitable for a wide variety of both high speed and heavy duty machining operations.

The magnetic clasping system is the ideal solution for applications with vertical and horizontal faces quickly and with minimum operations featuring column boring milling machines, or machining centers, as well as for tooling and toolbars on EDM systems.

Uniform clamping

When clamp with brackets and rails, workpieces are removed easily and quickly and multiple areas are needed to complete the machining cycle.

The quadrangular chessboard layout allows the magnetic flux flowing horizontally and vertically.

The system is, therefore, suitable for applications both with vertical and horizontal axes, guaranteeing an high performance.

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Magnetic clamping on injection molding, metal stamping and heavy duty machining operations.
The new force in magnetic clamping for milling

The Quadrupole technology patented by Technomagnete has been implemented for more than 25 years, proven on the Quadsystem. The Perpendicular-flux magnets applied to the machine table and the clamping plate ensure a stable clamping force against any possible bending or deformation of the system to the piece; this can reach 75 N/mm². The clamping force of the system to the machine table.

The bi-directional magnetic circuit
All N/S poles are energized by a double magnetic circuit strategy - Quadrupole - and can generate the highest level of magnetic induction into the steel with high magnetic induction force (BNI) to operate safely even in case of pole gap conditions. The reduced thickness and the reduced weight bring to optimize the magnetic performance, increasing the productivity and the tool speed, but cycle times remain with low stress.

Easy to use with the practial and immediate solid steel fast connector

MillTec GRIP offers great advantages for operating a dramatic increase in productivity and quality.


d) The system is ready for an immediate activation once the electronic control unit is connected to the system and the workpiece arrives on the machine table. The system is ready for an immediate activation once the electronic control unit is connected to the system and the workpiece arrives on the machine table.

The evolution of a success

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The new force in magnetic clamping for milling

The Quadropole technology patented by Tecnomagnete has been implemented for more than 30 years in the world’s leading drive positions. The Permanent-electro magnets applied in the machine tool work-holding systems, to achieve clamping or in reactive rotating, allow clamping to be obtained by a suitable combination of a magnetic system and the drive-holding systems, with impressive operational advantages highlighted by the latest technological research.

The bi-directional magnetic circuit

All N/S poles are energized by a double magnetic circuit effect - Van der Waals - and can guarantee the highest level of magnetic induction into the steel with high Magnetic motion forces (MMF) to operate safely even in case of deviation.

The complete clearing of all vibrations allows you to maximize the performances of uniform clamping of the magnetic system; this is achieved thanks to the permanent magnets, optimal machining speed and low consumption tests.

The reduced thickness and the reduced weight help to optimize the machine performances, increasing the durability and the load capacity, but cycles time faster with less stress.

Easy to use with the practical and immediate male and female connector.

MillTec GRIP offers great advantages for operating a dramatic increase in productivity and quality.

The innovative magnetic system for milling applications Milltec allows to offer a wide range of strong and safe magnetic modules suitable for a wide variety of both high speed and heavy duty machining operations.

The Milltec modules are the ideal solution for applications both with vertical and horizontal axis and even in milling centers incorporating column for milling machines, or machining centers, as well as rigid spindles and horizontal/vertical axis.

Uniform clamping

When set up with brackets and brasses, fittings are now easily accessible and multiple access are needed to complete the machining cycle.

The uniform metallic surface, full steel, with no vibrations!

The absence of assembled and moving parts (brackets, wedges, fast connectors, clamping extensions, etc.) allows for a full machining cycle in one setup, improving the tool accessibility on 5 faces thus allowing the full machining of profiles of work piece to be machined.

MillTec GRIP revolutionizes the concept of magnetic clamping in milling machine and machining centers.

You can perform a real uniform clamping of the entire work-piece without any parallelism or flatness, even in the most critical air-gap conditions.

The magnetically charged clamping surface makes easier the full machining cycle.

MillTec GRIP allows you to enhance the characteristics of uniform clamping of pieces of various thicknesses and shapes, in an infinite number of cycles.

No vibrations!

No vibrations!

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The shading coil technology makes the magnetic field suitable for different applications both with vertical and horizontal axis and even in milling centers incorporating column for milling machines, or machining centers, as well as rigid spindles and horizontal/vertical axis.

Set up and change over times are drastically reduced and are day to day operations keeping absolutely stable and with no vibrations.

The system is ready for a new generation of magnetic modules, independent mobile poles, independently movable and suitable for any kind of application and machining center.

Thin parts

The magnetic system for milling applications Milltec allows to offer a wide range of strong and safe magnetic modules suitable for a wide variety of both high speed and heavy duty machining operations.

The RMP pole extensions design does not permit any chip or any dust to penetrate inside, thus granting the best possible and constant performances even without any cleaning and maintenance.

MillTec GRIP is the ideal solution for applications both with vertical and horizontal axis and even in milling centers incorporating column for milling machines, or machining centers, as well as rigid spindles and horizontal/vertical axis.

The shaded double slit surface magnetization allows a better homogenization with a 3% improvement of the magnetic performance compared to traditional pole extensions with single slit surface.

Full machining in one setup

MillTec GRIP allows you to achieve stress release on all the work-piece remotely clamped with no time loss; constant power and no power consumption. Holded only by the power of high energy permanent magnets.

MillTec GRIP allows you to maximize the stability of the work-piece during the machining cycle and permit any chip or any dust to penetrate inside, thus granting the best possible and constant performances even without any cleaning and maintenance.

No waste, no flood, no heat generation, no power consumption.

Automatic shimming system

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The right choice for all operational requirements

**MillTec GRIP**
- Generates a self-clamping force in the machine table equivalent to 25% of the nominal force of the system.
- Each pole provides a nominal force of 615 daN to the workpiece and of 115 daN to the machine table.
- Milling elements are built supported to obtain perfect stability and clamping authority.

**MillTec Autoclamp**
- This is a version with a double magnetic sector capable of providing a self-clamping force to the machine tables.
- Each pole can generate a clamping force of 615 daN to the workpiece and 115 daN to the machine table.
- However, only 80% of the bottom magnetic force is transmitted during self-clamping phases of the system to the machine table.
- The remaining 20% of the poles present reversed polarity and is activated during DINA11 phases only to guarantee a perfect positioning stability, without any mechanical clamping elements.

**MillTec Basic**
- The self-clamping function to the machine table is not implemented in the version if fact the self-clamping begin is short circuiting through a dedicated side 2 connections, built into the bottom of the chuck.
- MillTec Basic must be fixed to the machine table through conventional mechanical clamping elements, as brackets or bolts.

The wide range of standard MillTec modules is ideal to configure different magnetic tables both for fixed layouts and pallet systems, horizontal and vertical.

### MillTec GRIP
- RT models are available in X DUO (High Density) version for standard machining operations, while HP (High Power) versions are available for heavy-duty machining operations with substantial gap conditions.

### MillTec Autoclamp
- ST series electronic control units are equipped with isolated output and control systems with feedback levels, to ease power consumption, with a red light as a visual signal ensuring reliability in time.
- A TCF version is used on the back side, to interface with machine PLC.
- The ST200 version, available from 200V to 400V, is standard to control modules of large dimensions and materials.
- The ST100 version at 230V is compact and light, is standard to control modules of large dimensions and materials.

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- The ST100 version at 230V is compact and light, is standard to control modules of large dimensions and materials.

### Modularities for any need
- The large range of MillTec GRIP modules can be used to configure different magnetic tables both for fixed layouts and pallet systems, horizontal and vertical.
- Modules can be fixed either to the electrodostatic side 2 or to the machine table when standard modules are not allowed in the workpieces of the chuck.

### MillTec GRIP
- Modules are equipped with own patented load cell technique, with an accuracy of ±0.5% in workpiece contact area.
- All the models are available in X DUO (High Density) version for standard machining operations, while HP (High Power) versions are available for heavy-duty machining operations with substantial gap conditions.

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The right choice

**MillTec Basic**

- MillTec GRIP
- MillTec Autoclamp
- MillTec Basic

A complete range for all operational requirements

**MillTec GRIP**

- 8 generation of self-clamping force in the machine table equivalent to 30% of the nominal force of the system.
- Each pole provides a nominal force of 615 daN at the workpiece and of 185 daN to the machine table.

**MillTec Autoclamp**

- This is a solution with double magnetic sector modular for heavy duty machining operations with substantial air-gap conditions.
- Through a dedicated plate, built into the machine table, 615 daN is transmitted to the workpiece and 185 daN to the machine table.

**MillTec Basic**

- The self-clamping function on the machine table is not implemented in this version. In fact the self-clamping force is transmitted through a dedicated plate built into the bottom of the chuck.
- MillTec Basic must be fixed to the machine table through conventional mechanical clamping elements, as brackets or bolts.

**GRIP**

- MillTec Basic
- MillTec GRIP
- MillTec Autoclamp

- Electronic control units
  - ST series control units are equipped with a RS232 and/or I/O connectors to control a wide range of devices.
  - ST series is equipped with the practical TC remote pendant.

- Safety through power
  - High power
  - Low thickness and lightweight
  - Full metallic surface
  - Monolithic technology

- Magnetic tables...
  - Magnetic flux depth: 17mm
  - 2 lateral slots to fix on machine table

- The remaining 20% of the poles present reversed polarity and are activated during auto-clamping phase to guarantee a perfect circulation.

- Distribution of the clamping force to the piece is always equal to the nominal force of the machine table.

- MillTec GRIP and MillTec Autoclamp self-clamping forces are always close to the highest mechanical loads due to the reference surface and the eventual presence of polar extensions.

- MillTec GRIP and MillTec Autoclamp self-clamping forces are always close to the nominal force of the magnetic flux circulation.

- The clamping force to the piece is always influenced by the variability operating space, the unpredictability of the contact areas and the eventual presence of polar extensions.

- In many operational situations the clamping force to the piece could be equal or greater than the clamping forces generated on the machine table.

- The ST200 version at 230V is compact and light, is powered with integral push button.

- The ST50 version, available from 240V to 400V, is suitable to control flanks of large dimensions and is equipped with the practical TC remote pendant.

- All standard models are equipped with new waterproof fast connectors ERGON series.