

## Grid type vacuum chucks

Modular Grid Chucks with  
standard sizes or  
made to order

### Applications

For simple shaped workpieces  
with a rough surface and heavy duty milling

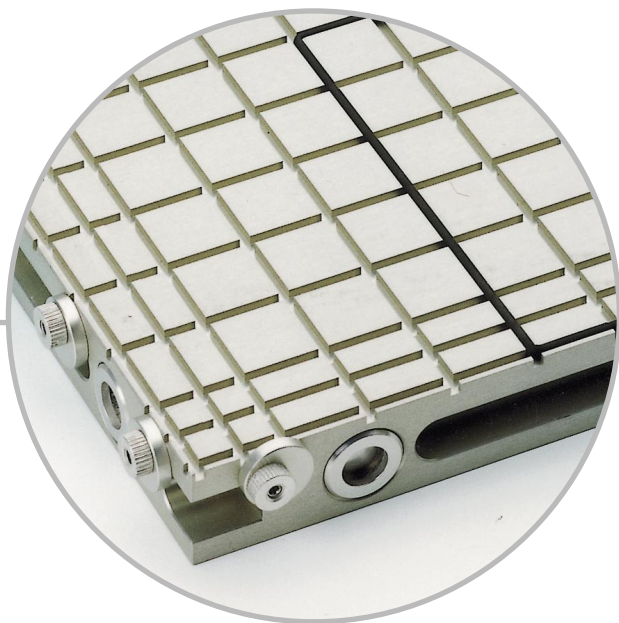
- Grinding
- Milling
- Turning

### Advantages

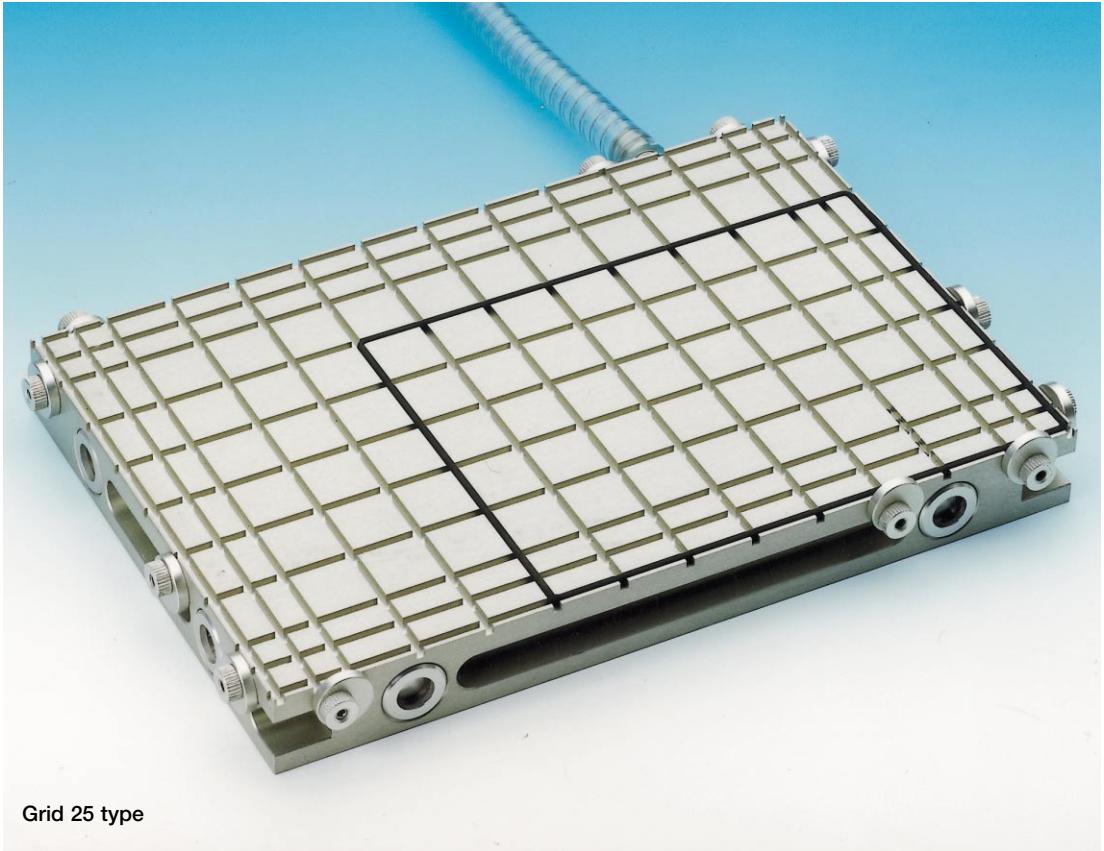
- Strong hold down force
- Universally applicable
- Secure clamping of rough workpieces  
due to the high friction properties
- The O-shaped seal evens out any irregularities  
between workpiece and chuck surface

### Handling

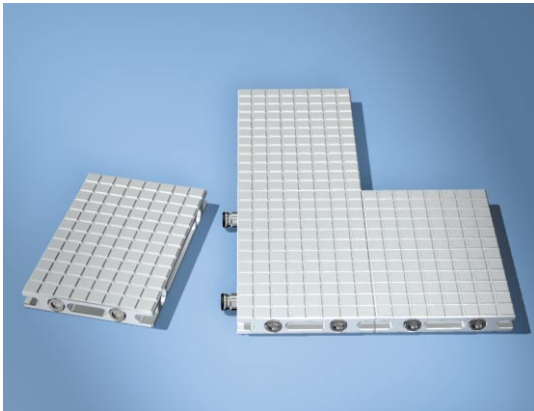
- Any shape or size of chuck made to measure
- Recommended grid size depends on  
workpiece contour and dimensions
- Clamping area defined by Polymer O-shaped seal
- Fine vacuum grid plates for  
extremely small workpieces in any form
- Acts as a base for many special solutions  
in connection with special vacuum adapter mats



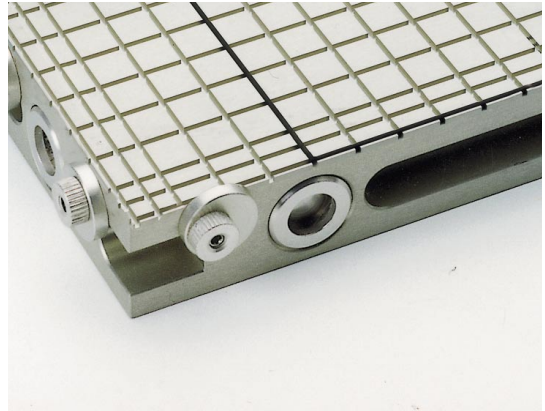
## Modular grid chucks



Grid 25 type



The modular concept allows connection of several vacuum chucks. The vacuum supply to each chuck continues through the connection elements.



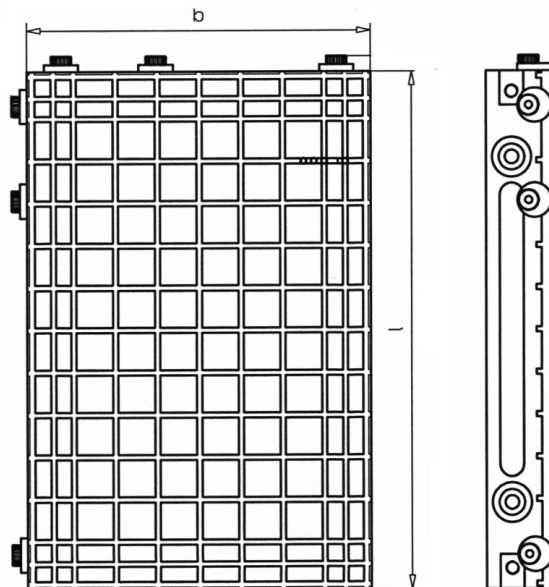
Grid 12,5 type

## Modular grid chucks

Witte grid chucks are manufactured in high-tensile aluminium.  
Steel versions are available on request.

### Supply includes:

- 1 x tail end
- 7 x blind plug
- 10 x O-ring
- 1 x plug, inside dia 12
- 10m O-shaped seal
- 2 Step heel clamps no.30617, alu
- 1m vacuum suction hose with wire spiral 18/12
- height adjustable, excentric end stops with discs



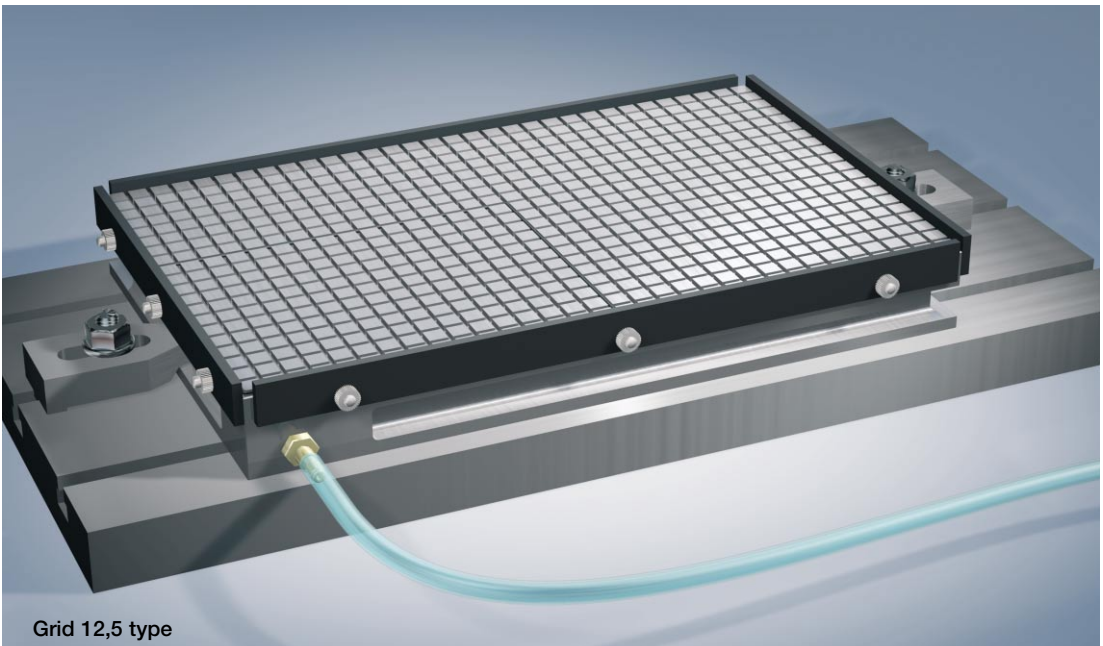
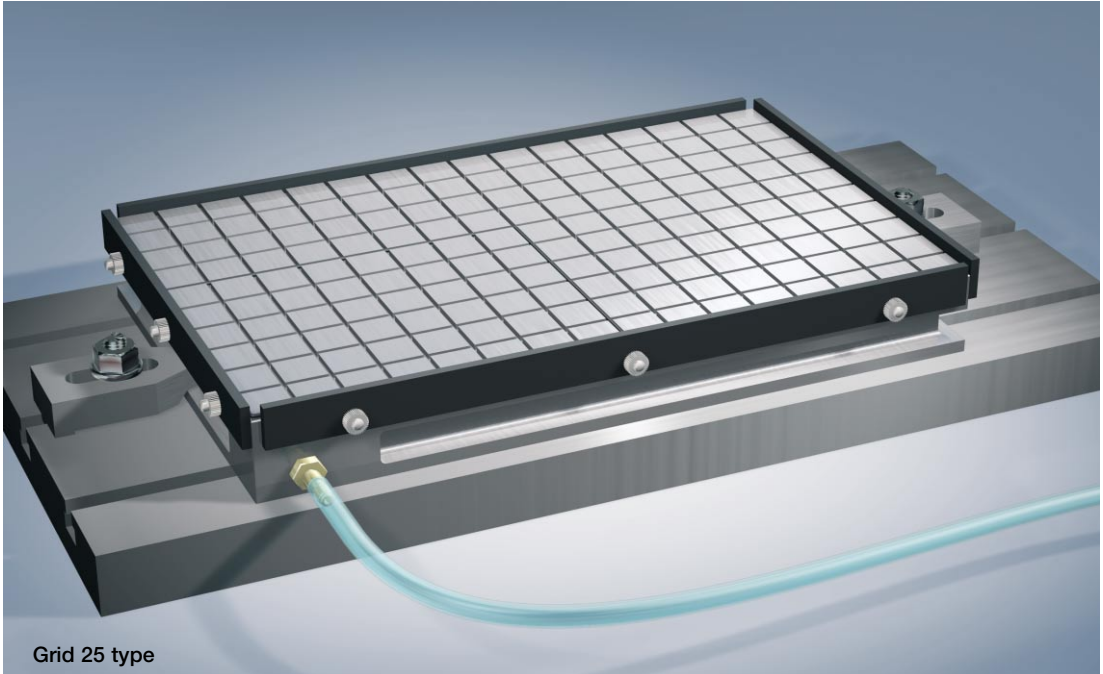
No.	Description/Grid	lxwxh	kg
82978	Grid type vacuum chuck, modular/25	300x200x32,5	5
84161	Grid type vacuum chuck, modular/25	300x400x32,5	10
84162	Grid type vacuum chuck, modular/25	600x400x32,5	20
89676	Grid type vacuum chuck, modular/12,5	300x200x32,5	5
90249	Grid type vacuum chuck, modular/12,5	400x300x32,5	10
92289	Grid type vacuum chuck, modular/12,5	600x400x32,5	20

Special dimensions available on request!

## Standard grid chucks

These tried and tested standard grid type vacuum chucks made by Witte are as described in the table on page 41 made of high tensile aluminium or steel.

The grid sizes are either 12,5 mm or 25 mm. The height adjustable rim assists the vacuum hold down force as well as a positioning aid



## Standard grid chucks

lxwxh (mm)	Aluminium			
	Grid 12.5 No	kg	Grid 25 No	kg
150x100x38	<b>80802</b>	1	<b>80214</b>	1
200x100x38	<b>80803</b>	2	<b>80215</b>	2
250x150x38	<b>80804</b>	3	<b>80216</b>	3
300x150x38	<b>80805</b>	4	<b>80217</b>	4
350x150x38	<b>80806</b>	5	<b>80218</b>	5
400x200x38	<b>80807</b>	8	<b>80219</b>	8
500x200x48	<b>80808</b>	13	<b>80220</b>	13
600x200x48	<b>80809</b>	15	<b>80221</b>	15
400x250x48	<b>80810</b>	13	<b>80222</b>	13
500x250x48	<b>80811</b>	16	<b>80223</b>	16
400x300x48	<b>80812</b>	15	<b>80224</b>	15
500x300x48	<b>80813</b>	20	<b>80225</b>	20
400x400x48	<b>80814</b>	21	<b>80374</b>	21
600x300x48	<b>80815</b>	23	<b>80226</b>	23
600x400x48	<b>80816</b>	31	<b>80376</b>	31
800x400x48	<b>80817</b>	41	<b>80227</b>	41
1000x500x48	<b>80818</b>	65	<b>80427</b>	65

Steel			
Grid 12.5 No	kg	Grid 25 No	kg
<b>80819</b>	4	<b>80228</b>	4
<b>80820</b>	6	<b>80229</b>	6
<b>80821</b>	11	<b>80230</b>	11
<b>80822</b>	13	<b>80231</b>	13
<b>80823</b>	15	<b>80232</b>	15
<b>80824</b>	24	<b>80233</b>	24
<b>80825</b>	37	<b>80234</b>	37
<b>80826</b>	45	<b>80235</b>	45
<b>80827</b>	37	<b>80236</b>	37
<b>80828</b>	47	<b>80237</b>	47
<b>80829</b>	45	<b>80238</b>	45
<b>80830</b>	56	<b>80239</b>	56
<b>80831</b>	60	<b>80375</b>	60
<b>80832</b>	67	<b>80240</b>	67
<b>80833</b>	90	<b>80377</b>	90
<b>80834</b>	121	<b>80241</b>	121
<b>80835</b>	192	<b>80426</b>	192

### Supply includes:

- 1 x tail end
- 1 x plug, inside dia 12
- 1m vacuum suction hose with wire spiral 18/12
- height adjustable end stops
- 10m O-shaped seal

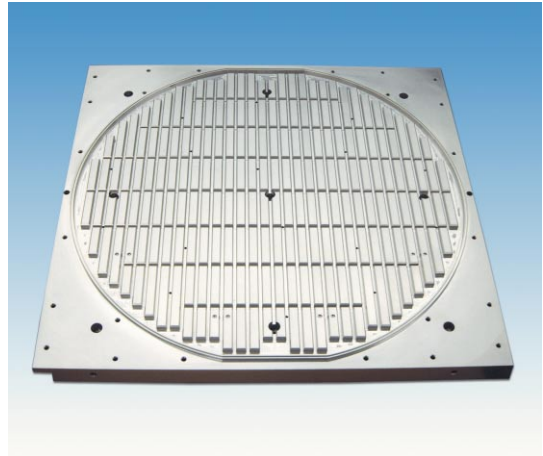
Special dimensions available on request!

## Custom built grid chucks

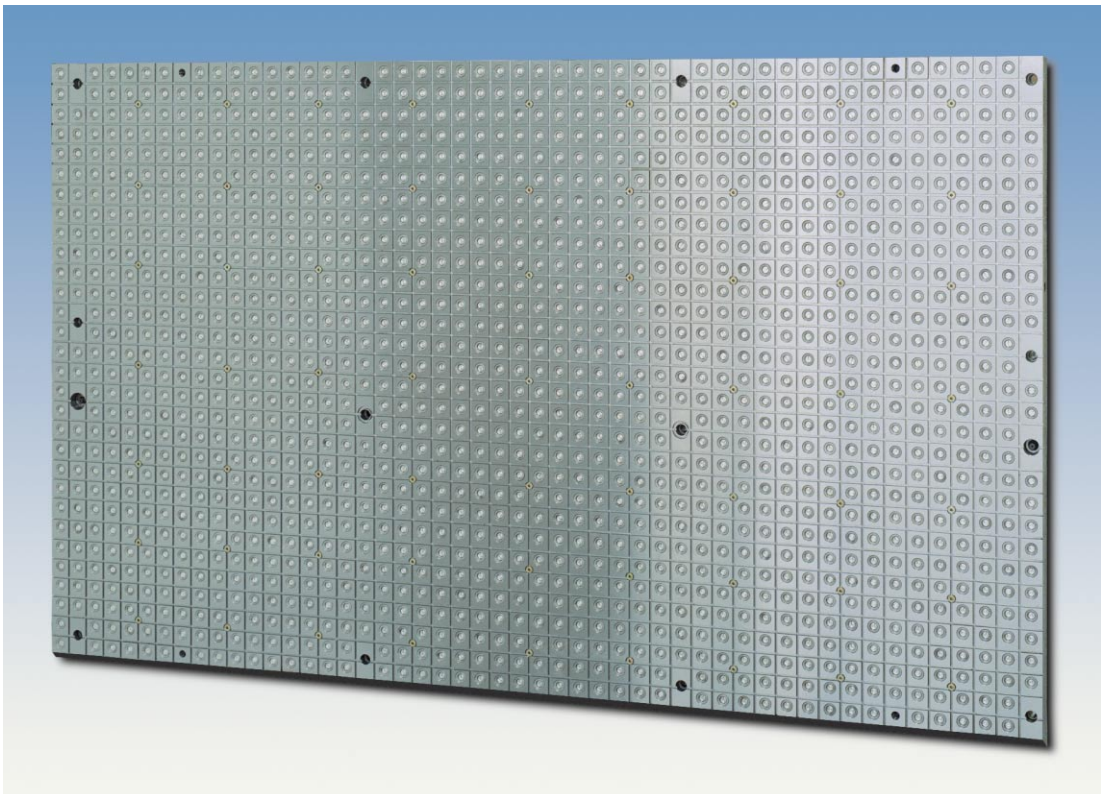
In addition to standard sizes shown here Witte grid type chucks are also custom built to suit your requirements up to dimensions of more than 40m<sup>2</sup>.

Dimensions of chuck and clamping area, grid size, slot width, downforce and best type of clamping surface are all details taken into account to supply a chuck which gives optimal results for the application in question. Use our inquiry form on page 43 or get in touch with our agent in your area or with us directly.

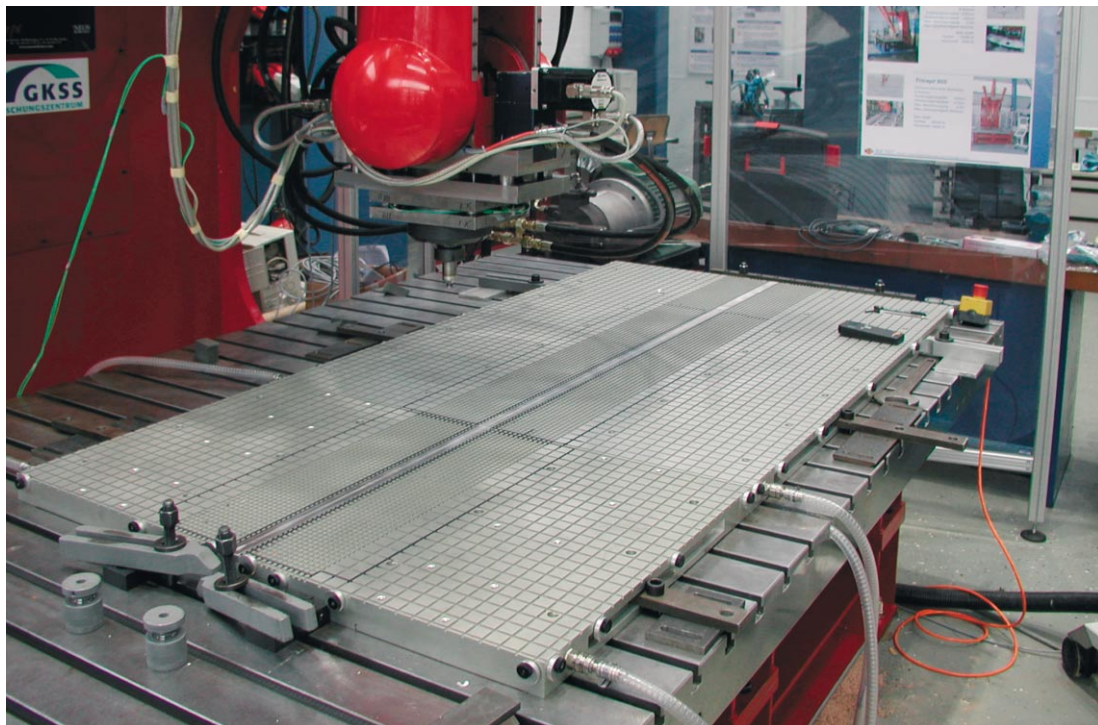
Chucks can be made according to a customers workpiece design drawing, we can help in finding the best way to clamp your workpiece



Customized vacuum plate for the aircraft industry, similar chucks have also been supplied for the Spacecraft industry



Special grid type chuck 1500x3000mm



Above: 2 piece vacuum grid chuck for application on friction stir welding machine

Below: Custom built 3D vacuum chuck for application on friction stir welding machine

