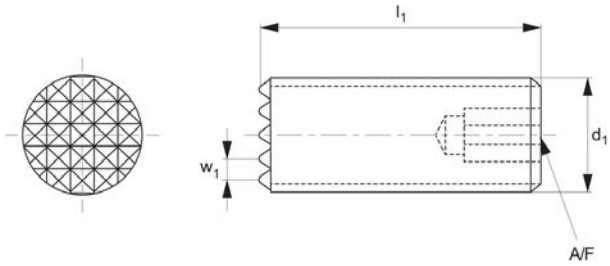


# 35510



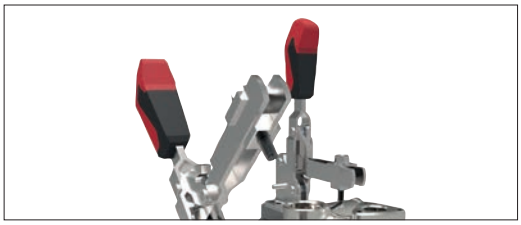
**Material**
Hardened tool steel to HRc 55-58, black oxide finish.

**Technical Notes**
These hardened tool steel gripping pads press down on to the surface of the clamped workpiece for safe holding without distortion. They are especially suitable where high load or clamping force is applied. Can be built into clamps, stops and fixtures as well as chucks, vices and robotic grippers for extra grip. Use a DIN 439B hex. nut for adjustment and securing.

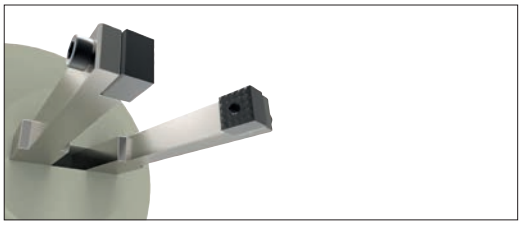
| Order No. | Tooth pattern | $l_1$ | $d_1$ | $w_1$ | A/F |
|---|---|---|---|---|---|
| 35510.W0001 | Extra Fine | 40 | M10x1,50 | 2,4x90° | 3 |
| 35510.W0002 | Fine | 25 | M12x1,75 | 3,2x90° | 5 |
| 35510.W0003 | Fine | 40 | M12x1,75 | 3,2x90° | 5 |
| 35510.W0004 | Fine | 40 | M16x2,00 | 3,2x90° | 6 |
| 35510.W0005 | Fine | 40 | M20x2,50 | 3,2x90° | 8 |

# Carbide & Hardened Steel Grippers & Inserts





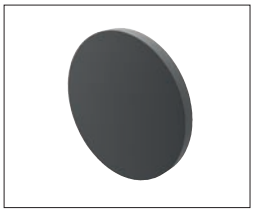
Grippers enhance workholding for multiple machining operations.



Grippers increase handling capability.

## Pads and Gripper Options

### Pads

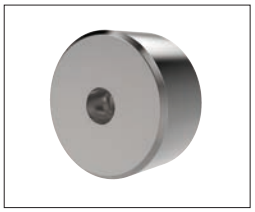


**Solid Carbide**

High impact carbide pads, can be brazed or bonded into place.

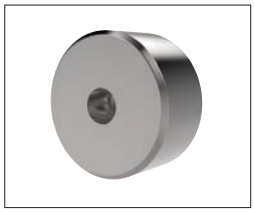
**Carbide Tipped**

Constructed with high impact carbide pad brazed to a heat treated alloy steel body. Mount via tapped hole or a flat on the outside diameter for set screw mounting.



**Hardened Steel**

Made from 8620 steel, carburized and hardened to Rc 58/60 1.2mm with black oxide finish. Mount via tapped or counter bored hole.

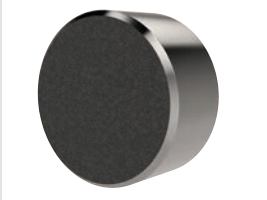


**Non-marking Thermoplast**

Made from white thermoplast. Mount via tapped or counter bored hole.

**Stainless Steel**

Pad from 17-4 stainless steel, hardened to Rc 43/46. Mount via tapped or counter bored hole.



**Abrasive Diamond Surface**

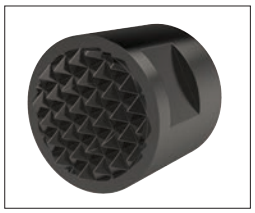
Abrasive surface permanently fused to a 17-4 stainless steel pad, hardened to Rc 43/46. The surface texture is comparable to a 100 grit abrasive. Mount via tapped or counter bored hole.

**Soft Urethane Surface**

Urethane surface is permanently bonded to a 300 series stainless steel pad. The urethane provides excellent protection against damage on delicate work surfaces. Tapped hole mounting.

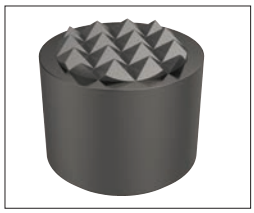
see our website for our full range:
wixroyd.com

### Grippers



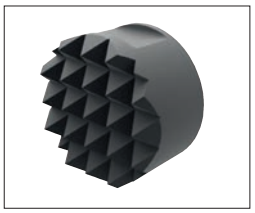
**High Speed Tool Steel**

Manufactured from M-2 high speed tool steel, hardened to Rc 60/62 with black oxide finish. Mount via tapped hole, counter bored hole or a flat on the outside diameter for set screw mounting.



**Carbide Tipped**

Constructed with high impact carbide pad brazed to a heat treated alloy steel body. Mounts via tapped hole or a flat on the outside diameter for set screw mounting.



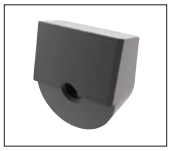
**Solid Carbide**

Manufactured from high impact carbide in a solid gripper pad or as a solid gripper body with a threaded brazed-in steel insert. Mount via tapped hole or a flat on the outside diameter for set screw mounting.

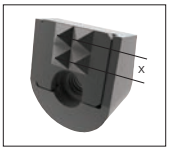


ov-W35300-A-T-W35980-A-T-specialist-gripping-pads-b-lnh - Updated - 28-10-2022

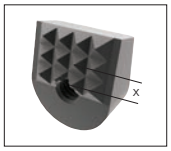
## Tooth Pattern Specifications



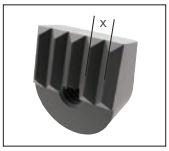
**Smooth**



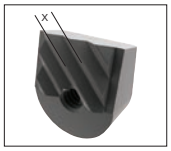

**4 Point**
**x = 3.429 x 90°**



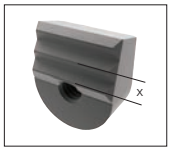

**Fine**
**x = 2.921 x 90°**




**Straight**
**x = 2.921 x 90°**



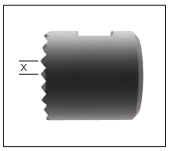

**Angular straight**
**x = 2.921 x 90°**



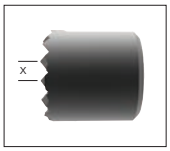

**3 Point/90° straight**
**x = 3.175 x 90°**

### Angular Grippers

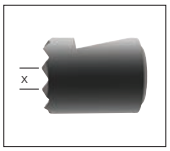
Our carbide and hardened steel grippers are available with a variety of tooth patterns, as specified on the product data tables.



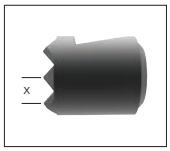

**Super Fine "SF"**
**x = 1.600 x 90°**



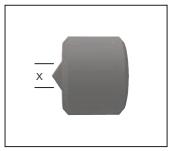

**Extra Fine "EF"**
**x = 2.387 x 90°**



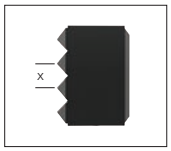

**Fine**
**x = 3.175 x 90°**




**Coarse**
**x = 4.775 x 90°**



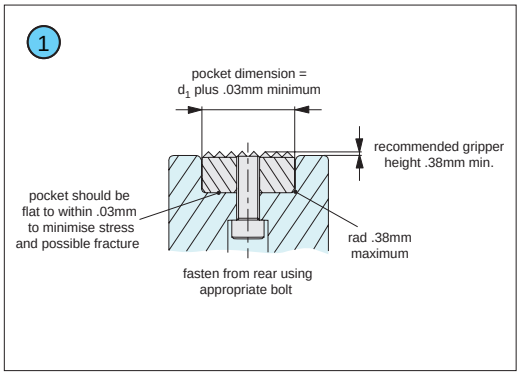

**Single point**
**x = 5.461 x 90°**

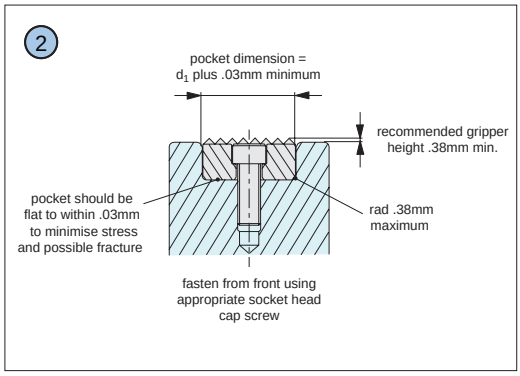


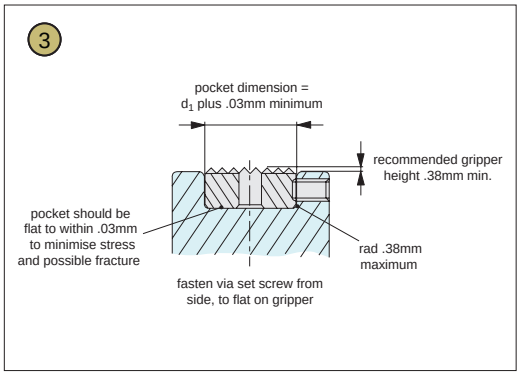

**4 Point square**
**x = 3.962 x 90°**

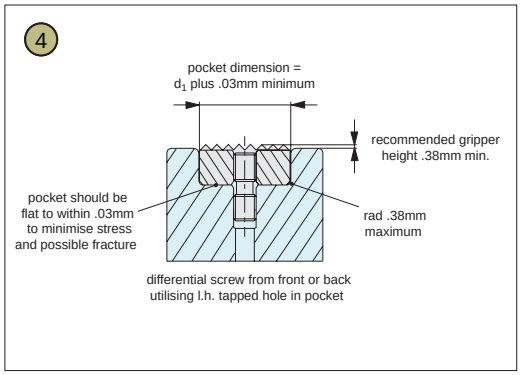
### Round/Square Grippers

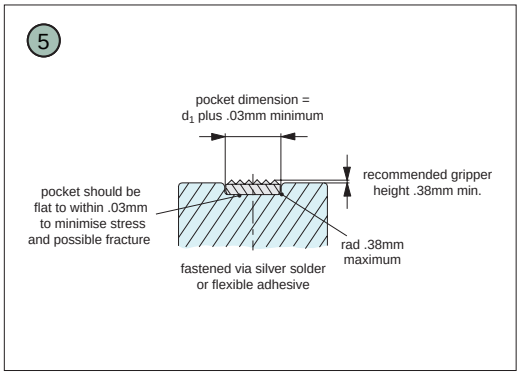
## Mounting options

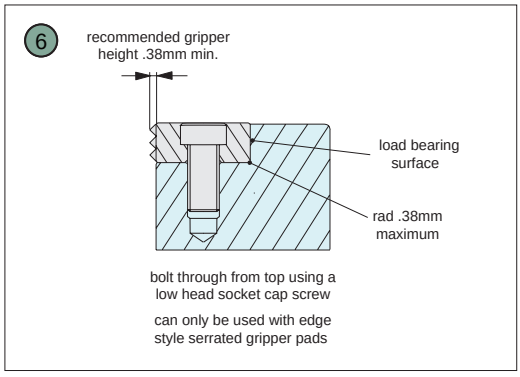



### Mounting Options for Carbide and Hardened Steel Grippers and Inserts.

Our carbide grippers and inserts can be installed in a number of different ways, the most suitable mounting method depends upon the specific insert – please refer to the product data table for specific information.

1. Round or square grippers and rest pads with tapped blind-hole or through hole tap.
2. Round or square grippers and rest pads with counter-bored hole.
3. Round grippers with flat on the O.D. for set screw mounting. Also square gripper mounting.
4. Round or square grippers with through tapped hole.
5. Round or square carbide pads.
6. Counter-bored edge grippers.



ov-W35300-A-T-W35520-A-T-technical-information-a-rmh - Updated - 28-10-2022

## A Range of Specialist Gripping Pads to Suit Your Application

### Urethane Coated

Unique urethane coat prevents marking of delicate components during machining or manipulation by robots. The urethane pad is permanently bonded to the stainless steel body of the gripping pad. With a bubbled texture, air is able to escape and hence avoid any suction action - enabling easy releasing of parts.

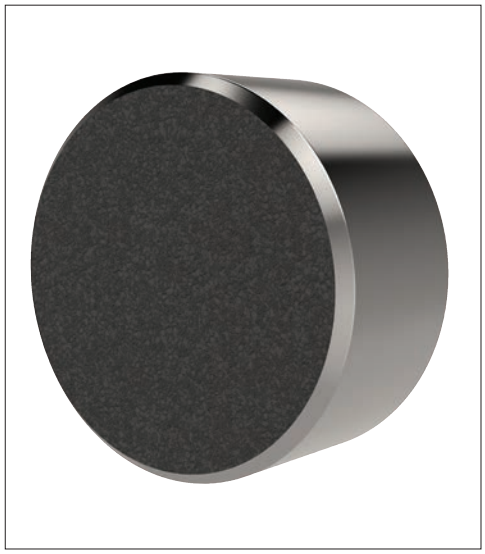
These are available in three different urethane durometers.

**35 durometer: Pencil rubber top**

**60 durometer: Car tyre**

**80 durometer: Skateboard wheel**

### Abrasive Diamond Coated

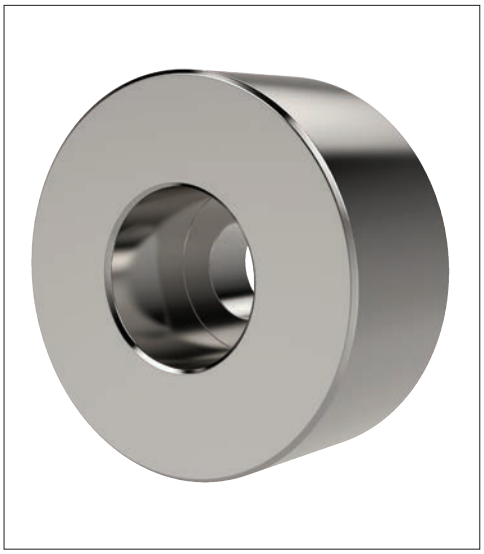


To improve handling of smooth or slippery components, with a minimum of clamping pressure, our abrasive diamond coated pads provide an excellent solution.

Diamond powders are permanently fused to a 17-4 stainless pad, to provide an abrasive surface comparable to 100 grit value.

**Sandpaper of 100 grit texture**

### Stainless Pads



Pads of 17-4 Stainless, hardened to RC 43/46 provide solutions to applications where material selection is of greater importance; for example nuclear or food processing or pharmaceutical applications.



ov-W35300-A-T-W35980-A-T-specialist-gripping-pads-a-1nh - Updated - 28-10-2022