



Clamping Force Tester

SCHUNK IFT

Assembly and Operating Manual

Imprint

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Technical changes:

We reserve the right to make alterations for the purpose of technical improvement.

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Dear Customer,

Thank you for trusting our products and our family-owned company, the leading technology supplier of robots and production machines.

Our team is always available to answer any questions on this product and other solutions. Ask us questions and challenge us. We will find a solution!

Best regards,

Your SCHUNK team

Customer Management

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Please read the operating manual in full and keep it close to the product.

Table of Contents

1	General instructions	5
1.1	Information about this manual	5
1.1.1	Presentation of Warning Labels	5
1.1.2	Applicable documents	6
1.2	Warranty	6
1.3	Scope of delivery	6
2	Basic safety notes	7
2.1	Intended use	7
2.2	Not intended use	7
2.3	Structural changes	7
2.4	Spare parts	8
2.5	Ambient conditions and operating conditions	8
2.6	Personnel qualification	8
2.7	Personal protective equipment	9
2.8	Instructions for safe operation	9
2.8.1	Constructional changes, attachments, or modifications	9
2.9	Transport	9
2.10	Malfunctions	9
2.11	Disposal	10
2.12	Fundamental dangers	10
2.12.1	Notes on particular risks	10
3	Technical Data	11
3.1	Tablet technical data	11
3.2	Measuring head technical data	11
4	Functional description and operation	12
4.1	Overview	12
4.2	Measuring head	12
4.2.1	General	12
4.2.2	Charging process / state of charge	13
4.2.3	Changing the clamping inserts	14
4.3	Tablet and app	15
4.3.1	Functional description of the tablet	15
4.3.2	Operating the App	16
4.3.3	Start screen	16
4.3.4	Measuring procedure	21
5	Calibration and recalibration	23
6	Charging adapter	24

7 Accessories	25
7.1 Measuring on compensating 4-jaw clamping devices.....	25
7.1.1 Scope of delivery	25
7.1.2 Assembly	26
7.1.3 Clamping force measurement	26
7.2 Extension set for large clamping diameters for 2-/3-/6-jaws	26
7.2.1 Scope of delivery	27
7.2.2 Assembly.....	27
7.2.3 Clamping force measurement	28
8 EU Declaration of Conformity	29

1 General instructions

1.1 Information about this manual

This manual contains important information for the safe, correct use of the product.

The manual is an integral part of the product and must be kept accessible for personnel at all times.

Personnel must have read and understood this manual before beginning any work. The observance of all safety notes in this manual is a prerequisite to ensure safe work processes. The illustrations in this manual are intended to provide a basic understanding and may deviate from the actual version. In addition to this manual, the following documents also apply, ▶ 1.1.2 [6].

1.1.1 Presentation of Warning Labels

To make risks clear, the following signal words and symbols are used for safety notes.



⚠ DANGER

Dangers for persons!

Non-observance will inevitably cause irreversible injury or death.



⚠ WARNING

Dangers for persons!

Non-observance can lead to irreversible injury and even death.



⚠ CAUTION

Dangers for persons!

Non-observance can cause minor injuries.

NOTICE

Material damage!

Information about avoiding material damage.

1.1.2 Applicable documents

- General terms of business *
- Catalog data sheet of the purchased product *

The documents labeled with an asterisk (*) can be downloaded from schunk.com/downloads.

1.2 Warranty

If the product is used as intended, the warranty is valid for 24 months from the ex-works delivery date under the following conditions:

- Observe the applicable documents, ▶ 1.1 [5]
- Observe the ambient conditions and operating conditions, ▶ 2.5 [8]
- Observance of the specified calibration intervals ▶ 5 [23].

Parts touching the workpiece and wearing parts are not part of the warranty.

1.3 Scope of delivery

- 1 Tablet incl. app
- 1 Measuring head
- 6 Intermediate pieces for Ø 72
- 6 Intermediate pieces for Ø 96
- 6 Intermediate pieces for Ø 136
- 1 Insertion aid
- 1 Stand for speed measurement
- 1 Charging adapter for tablet and measuring head
- 1 USB charging cable
- 1 Torx wrench
- 8 Screws for spacer

2 Basic safety notes

Risks to persons and property may arise from incorrect handling of this product if these instructions are disregarded.

Report any damage and defects immediately and repair without delay to keep the extent of the damage to a minimum and avoid compromising the safety of the product.

Only original SCHUNK spare parts may be used!

2.1 Intended use

The product is used for measuring clamping force on clamping devices in a machine tool. The measurement can be static (clamping force without speed of rotation) and dynamic (clamping force with speed of rotation).

- For dynamic measurement, the axis of rotation of the measuring head must always lie on the axis of rotation of the machine spindle.
- The product may only be used within the scope of its technical data.
- The product is intended for industrial and industry-oriented use.
- Appropriate use of the product includes compliance with all instructions in this manual.

2.2 Not intended use

The product is used inappropriately if, for example:

- the product is used with machines or clamping devices that are not designed to be used with it.
- the specified technical data for use of the product are exceeded.
- the product is used in working environments that are not permissible.
- the product is operated without protective equipment (only with dynamic measurement).
- system changes or external influence of the tablet by the operator.

2.3 Structural changes

Implementation of structural changes

Modifications, changes or reworking, e.g. additional threads, holes, or safety devices, can damage the product or impair its functionality or safety.

- Structural changes should only be made with the written approval of SCHUNK.

2.4 Spare parts

Use of unauthorized spare parts

Using unauthorized spare parts can endanger personnel and damage the product or cause it to malfunction.

- Only use original spare parts and spares authorized by SCHUNK.

2.5 Ambient conditions and operating conditions

Requirements for ambient and operating conditions

Incorrect ambient and operating conditions can make the product unsafe, leading to the risk of serious injuries, considerable material damage and/or a significant reduction to the product's life span.

- Make sure that the product is only used within its defined application parameters.
- The measuring head must have reached room temperature before measurement.

2.6 Personnel qualification

Inadequate qualification of personnel

Work on and with the product by inadequately qualified personnel can lead to serious injuries and considerable material damage.

- Order all work to be performed only by appropriately qualified personnel.
- Personnel must have read and understood the complete operating manual before beginning any work on the product.
- Observe national accident prevention regulations and the general safety notes.

The following personnel qualifications are required for the various types of work on the product:

Specialist personnel: Specialist personnel have the specialized training, knowledge, and experience to perform the tasks entrusted to them, to recognize and avoid potential dangers, and know the relevant standards and regulations.

Instructed personnel: Instructed persons have been instructed by the user regarding the tasks entrusted to them and the potential dangers of inappropriate behavior.

Manufacturer service personnel: The manufacturer's service personnel have the specialized training, knowledge, and experience to perform the work entrusted to them and to recognize and avoid potential dangers.

2.7 Personal protective equipment

Use of personal protective equipment

Personal protective equipment serves to protect staff in the event of a danger that may interfere with their health or safety at work.

2.8 Instructions for safe operation

Working in an incorrect manner

An incorrect manner of working can make the product unsafe and risk the danger of serious injuries and considerable material damages.

- Avoid any manner of working that may interfere with the function and operational safety of the product.
- Use the product as intended.
- Observe the safety notes and assembly instructions.
- Do not expose the product to any corrosive media. Products for special ambient conditions are excluded.
- Rectify malfunctions as soon as they occur.
- Observe the calibration intervals.
- Observe the current safety, accident prevention, and environmental protection regulations for the application field of the product.

2.8.1 Constructional changes, attachments, or modifications

Additional threads, bore holes or attachments which are not supplied as accessories by SCHUNK may affect safety. They may only be applied after obtaining the prior consent of SCHUNK.

2.9 Transport

The transport is performed exclusively in the original, specially adapted transport case.

2.10 Malfunctions

Behavior in case of malfunctions

- Immediately remove the product from operation and report the malfunction to the responsible departments/persons.
- Have appropriately trained personnel rectify the malfunction.
- Do not recommission the product until the malfunction has been rectified.
- Test the product after a malfunction to establish whether it still functions properly and no increased risks have arisen.

2.11 Disposal

Conduct during disposal

Incorrect handling during disposal can make the product unsafe and risks serious injuries and considerable material and environmental harm.

- Follow local regulations on dispatching product components for recycling or orderly disposal.
- Batteries and rechargeable batteries are subject to hazardous waste treatment and may only be disposed of by authorized specialist companies.

2.12 Fundamental dangers

General:

- Do not reach into the open mechanism or movement area of the product during operation.
- Never deactivate safety installations.
- Before commissioning the product, take appropriate protective measures to secure the danger zone.
- Technical data of the machine or the clamping device must not exceed the maximum permissible data of the measuring head.

2.12.1 Notes on particular risks



⚠ WARNING

Danger of crushing!

- Do not reach between moving parts (measuring head and jaw).
- Use an insertion aid for protection!



⚠ WARNING

Rotating parts!

When measuring during speed of rotation, the insertion aid must be removed before switching on the machine!



⚠ WARNING

Rotating parts!

When measuring during speed of rotation, the measuring head must be clamped firmly and plane-parallel to the axis of rotation.

3 Technical Data

3.1 Tablet technical data

Designation	Handset/tablet/App
Display size [inch]	10
Operating system	Android
Charger connection	USB-C
Operating temperature [°C]	0...40
Transmitting/receiving frequency [GHz]	2.4
Data exchange	MicroSD; USB-C

3.2 Measuring head technical data

Designation	Measuring head
Voltage supply	Internal energy accumulator
Energy accumulator capacity	approx. 1.5 h @ 100% d.c
Charging process	< 3 minutes
Charger connection	USB mini
Number of jaws	2, 3 or 6 jaws can be set
Force range of measurement [kN]	0...180 kN (2-jaws) 0...270 kN (3-jaws) 0...540 kN (6-jaws)
Force measurement accuracy	< 3% fsr
Speed of rotation measurement [rpm]	approx. 200...6000
Speed of rotation measurement accuracy	< 1% fsr
Clamping range [mm]	Ø72, Ø96, Ø136
Measured value transmission rate [ms]	500 ms
Dimensions [mm]	Ø68 / 58 x 63
Weight [kg]	0,7 (without extensions)
Operating temperature [C°]	0...40
Protection class	IP67
Transmission frequency [GHz]	2.4
Handset/measuring head distance	< 10 m (depending on ambient conditions)

4 Functional description and operation

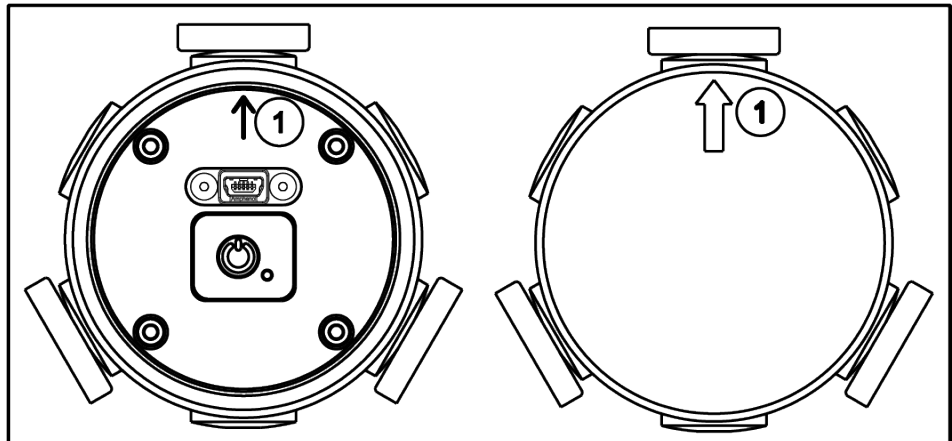
4.1 Overview

The operating principle of the measuring head is based on several internal strain gauges. The applied clamping force is converted into an electrical signal and evaluated by the electronics. A wireless data link transmits the data from the measuring head to the tablet and visualizes the measured values in the APP.

4.2 Measuring head

4.2.1 General

The measuring head consists of the base body with integrated sensor system and electronic processor, as well as the respective intermediate pieces for the clamping diameters $\varnothing 72$ mm, $\varnothing 96$ mm and $\varnothing 136$ mm. The arrow on the cover and also on the bottom of the measuring head symbolizes the measuring jaw, which must always rest on a jaw of the clamping device to be measured.



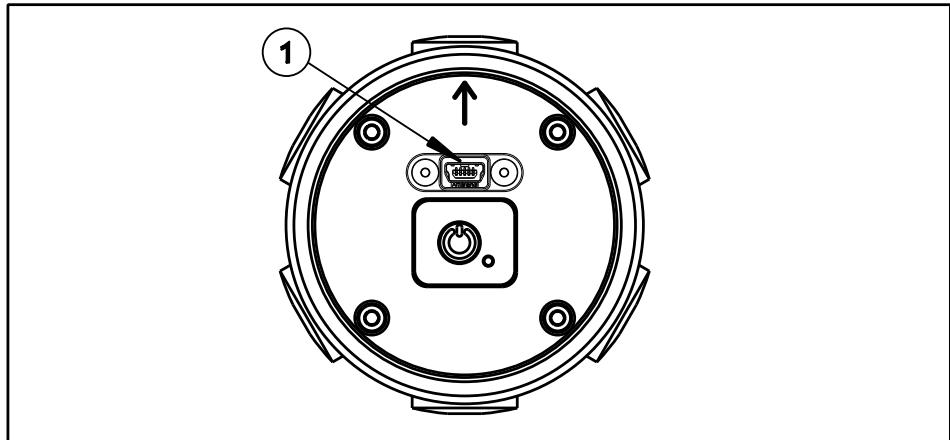
1 measuring jaw with indicator arrows

NOTICE

Measuring jaw always in force flow!
Otherwise the measured values are not meaningful.

4.2.2 Charging process / state of charge

A USB mini jack is located in the lid of the measuring head. This is used in conjunction with the USB mini cable supplied and charging adapter to charge the measuring head.



1 USB-mini measuring head charging socket

NOTICE

Danger of confusion!

Charging the tablet: USB-C

Charging the measuring head: USB mini



⚠ WARNING

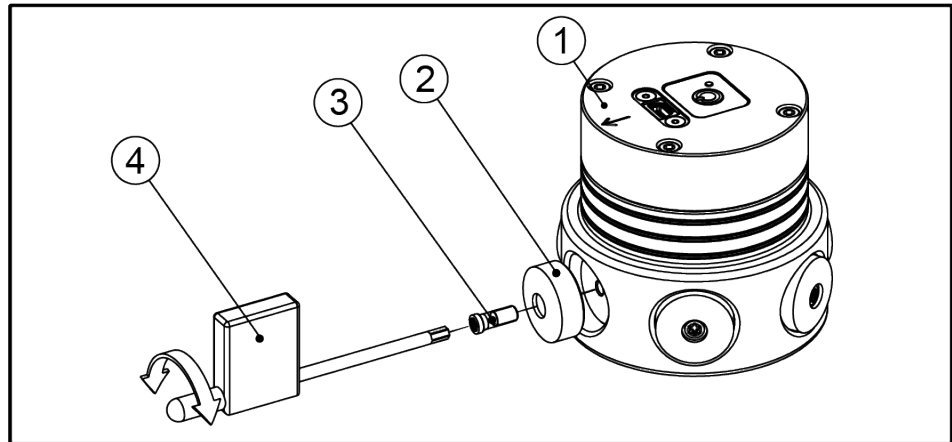
Damage by liquid!

The charging socket must be dry and free of dirt during the charging process.

The charging status is indicated by the LED integrated in the lid and within the APP. If the charge level is less than 15%, the LED on the measuring head flashes.

4.2.3 Changing the clamping inserts

The clamping inserts can be changed with the assembly key supplied. The clamping inserts for the clamping diameters $\varnothing 72$ mm, $\varnothing 96$ mm and $\varnothing 136$ mm are supplied.



- 1 Measuring head
- 2 Clamping insert
- 3 Fastening screw
- 4 Torx assembly key



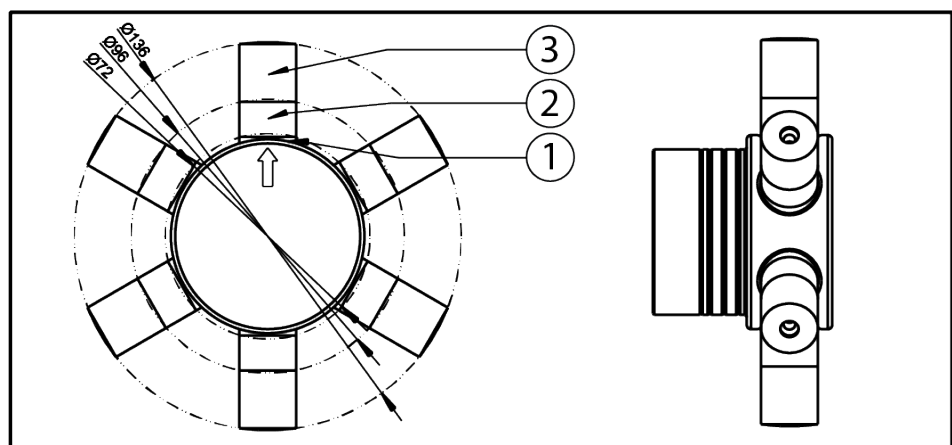
⚠ WARNING

Imbalance!

Only clamping inserts of the same length may be installed on the clamping force meter.

The clamping inserts must be arranged symmetrically.

(2 pieces at 180°; 3 pieces at 120°; 6 pieces at 60°)



- 1 Extension for $\varnothing 72$
- 2 Extension for $\varnothing 96$
- 3 Extension for $\varnothing 136$

4.3 Tablet and app



⚠ WARNING

Lithium-ion battery!

The product is equipped with a lithium-ion battery.

- Do not disassemble.
- Keep away from heat sources.
- Do not use in areas of increased radiation.

4.3.1 Functional description of the tablet

The supplied tablet is connected to the measuring head via the internal Bluetooth interface. The evaluation of the measured values is done with the pre-installed app.

The tablet is charged using the charging adapter and the USB-C cable supplied.

NOTICE

Danger of confusion!

Charging the tablet: USB-C.

Charging the measuring head: USB mini.



⚠ WARNING

Damage by liquid!

The charging socket must be dry and free of dirt during the charging process.



1 USB-C socket (charging & data exchange)


2 ON key

3 External memory card slot

4.3.2 Operating the App

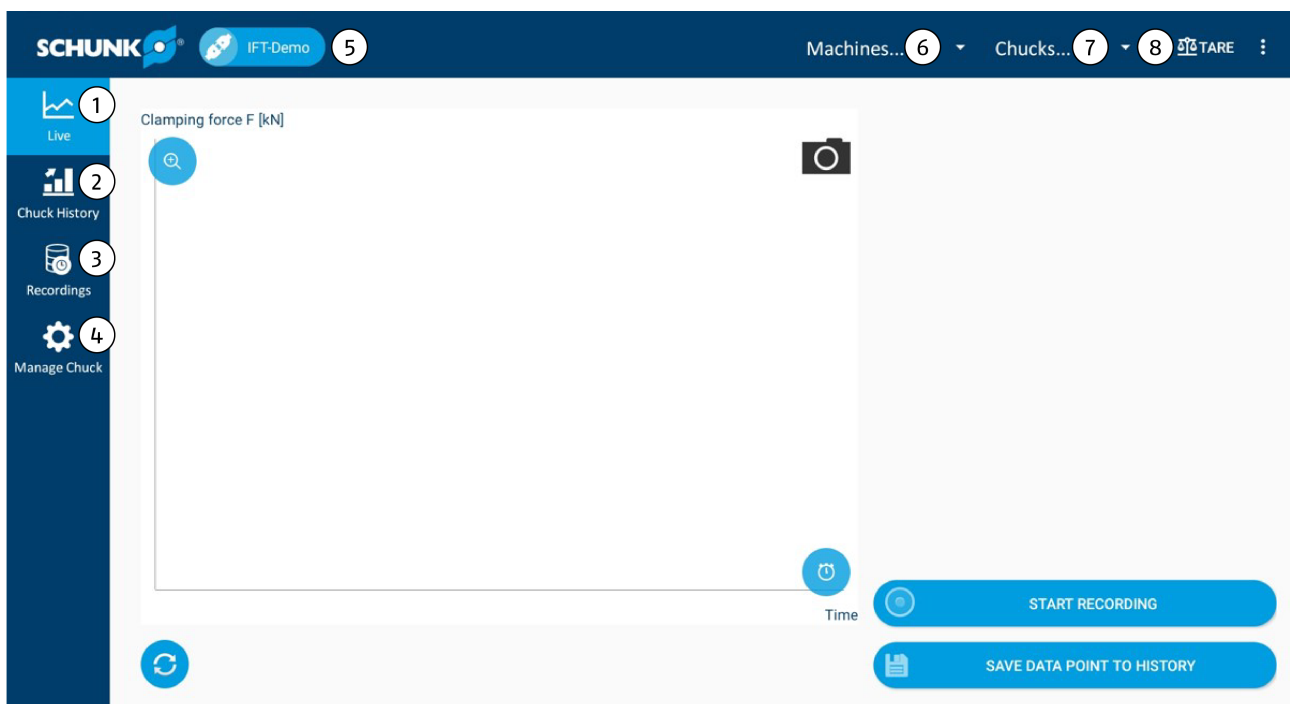
The pre-installed App is used to visualize the values of the measuring head.

4.3.2.1 Starting the App

The App for the clamping force meter is started via the App-Icon  on the start page.

4.3.3 Start screen

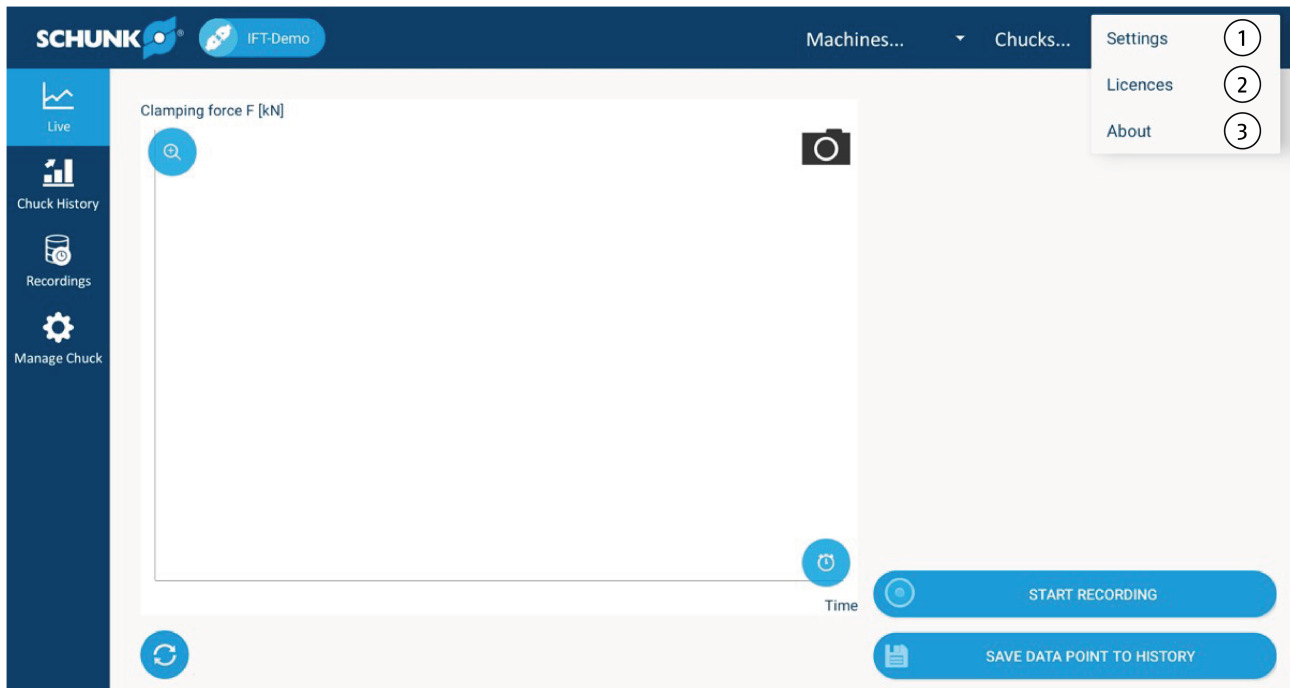
All relevant data can be visualized and edited on the start screen. The display with a diagram of the clamping force data points, showing all data points sent by the measuring head over time is defined as the standard.



- 1 Live measurement data
- 2 Measurements of already tested clamping devices
- 3 View previous measurements
- 4 Clamping device management
- 5 Connect measuring head display/measuring head
- 6 Select/create machine
- 7 Select/create clamping device
- 8 Tare function

4.3.3.1 Settings

The app can be customized via the additional settings. The following menu is opened by pressing the three dots at the top right:



- 1 Language & CSV export settings
- 2 License overview
- 3 Over

4.3.3.2 Connecting to the measuring head

The measuring head has a unique serial number on the bottom. This is also the designation in the radio network. The measuring head that is switched on can be selected and connected using item 5 on the start screen. As soon as the measuring head is connected, it is displayed on the start screen.

Sensors found

IFT-PS-BBDJ5356
00:0D:6F:64:2B:8F


IFT-CH-BBDK7305
84:71:27:AE:5B:E8

IFT-ST-BBGC4704
5C:02:72:99:C1:E8

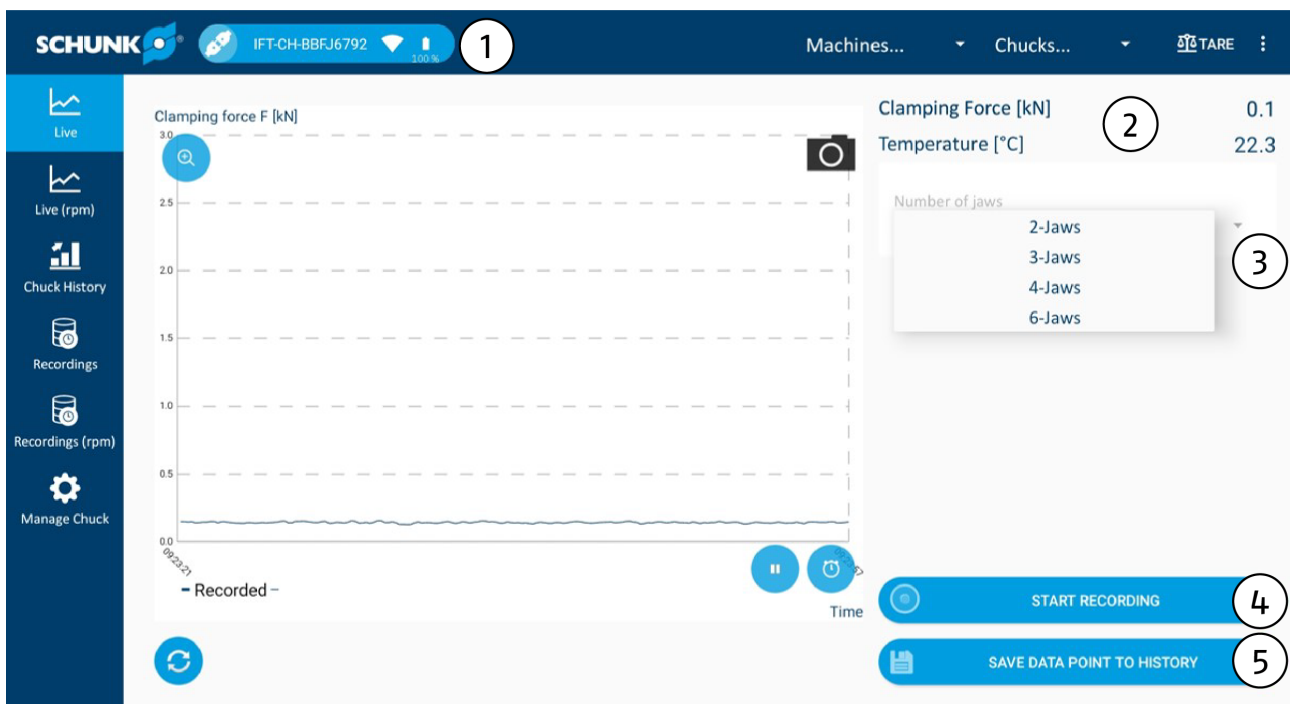
4.3.3.3 Tare function

Non-homogeneous temperature influences can cause the zero point to shift. Within certain limits, the zero point can be re-tared by the user. The following should be noted before doing so:

- Measuring head must be adjusted to room temperature
- Measuring head must not be loaded

The tare function can be called up on the start screen via the icon .

4.3.3.4 Main screen



- 1 Connected sensor type and battery level
- 2 Current measured values
- 3 Selection of the clamping method
- 4 Record values
- 5 Save recording in history

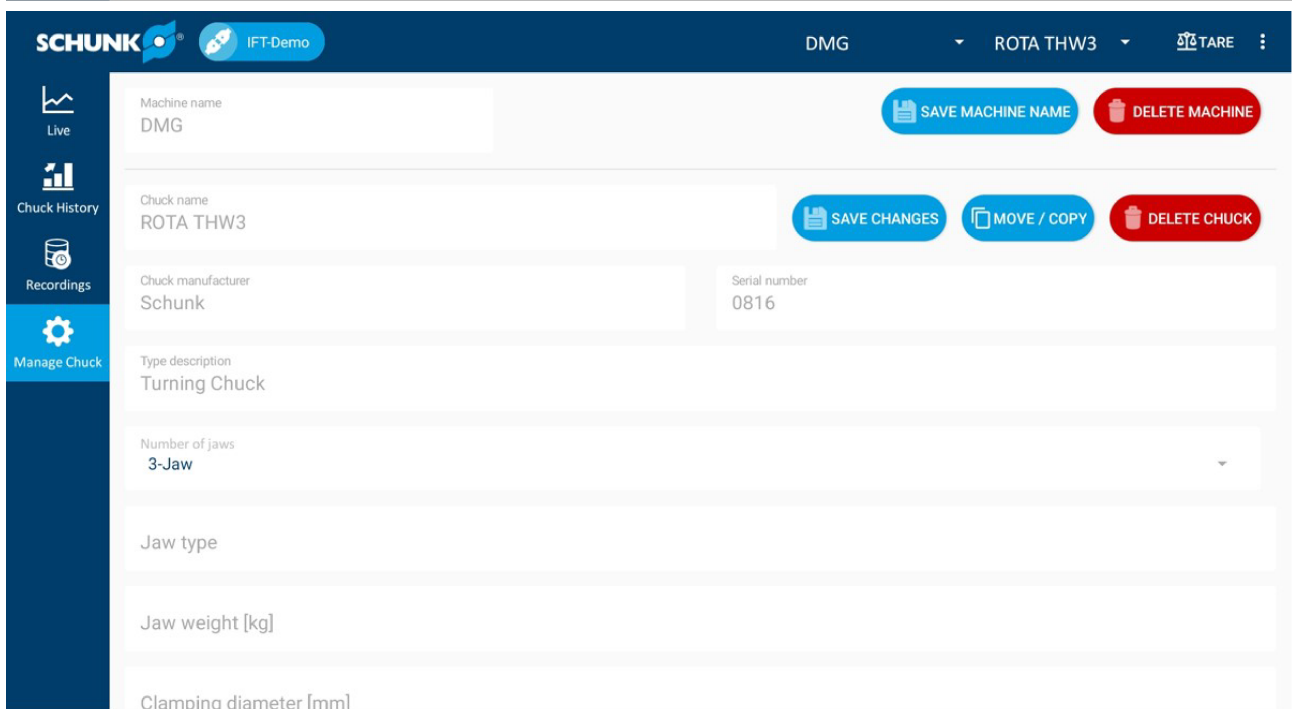
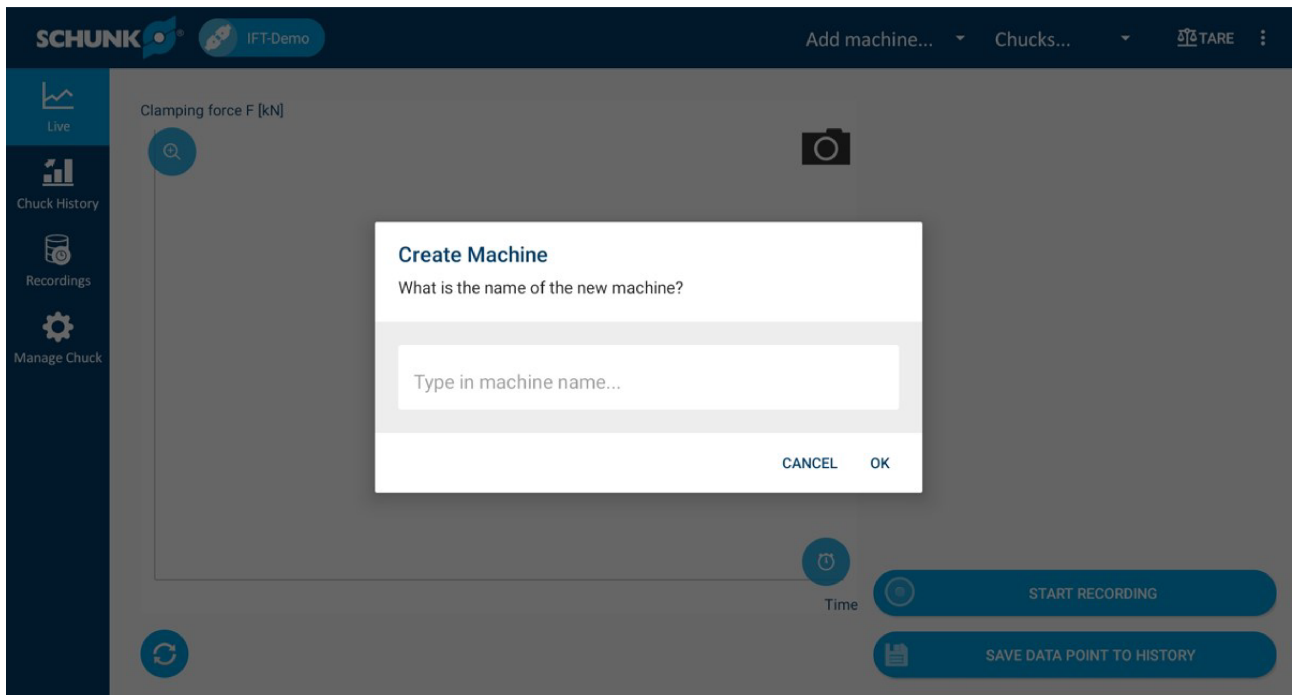
NOTICE

Ensure correct clamping method!

The correct entry of the clamping method must be checked. An incorrect entry leads to incorrect display values for the force value.

4.3.3.5 Set up the machine and clamping device

In order to save the measured values in the history, they must be able to be assigned to a machine and a clamping device. To do so, a machine and a clamping device must be created in the database via item 6 & item 7 on the start screen. The saved machines and clamping devices can be edited via item 4 on the start screen.

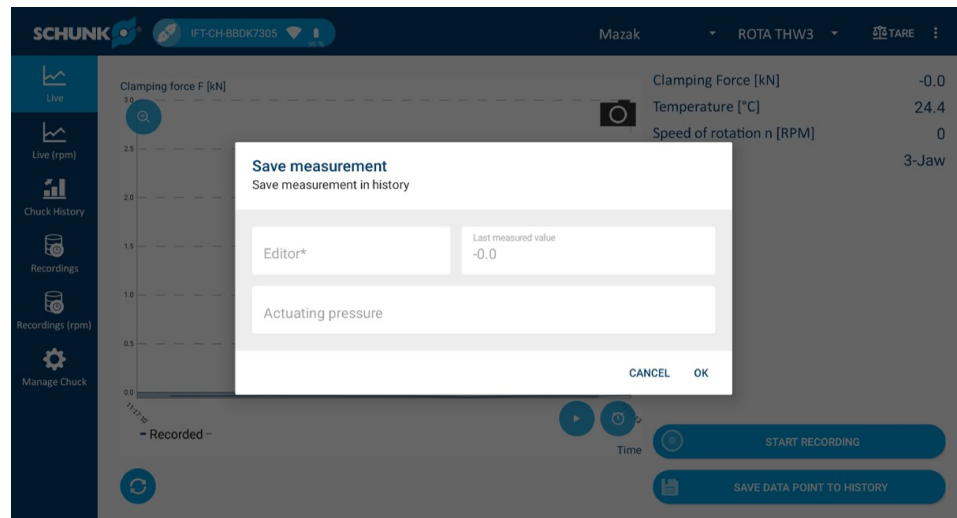


4.3.3.6 History

Values for machines and their clamping devices can be stored and archived in the history. The history of the measured values can be called up.

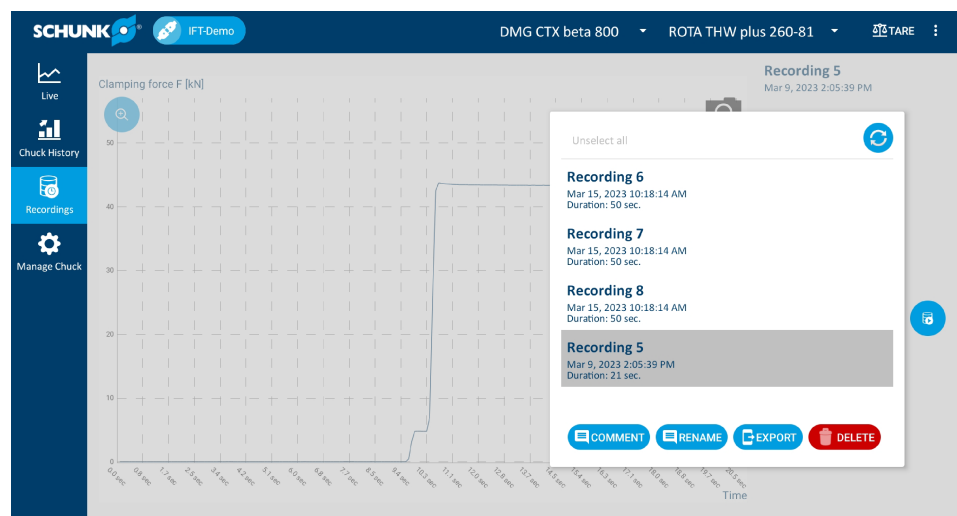
Save measured values in history:

The current value at the measuring head is saved via item 5 on the start screen. The mandatory "Editor" field has to be filled in. The entry is saved in the history by pressing "OK".



Recordings

For stored clamping devices, the previously archived measured values can be called up and visualized. The respective machine and the clamping device must be selected to do this. The saved entries can be selected via item 3 on the start screen. The stored data for the entry is displayed, the measured clamping force is then displayed in the diagram.



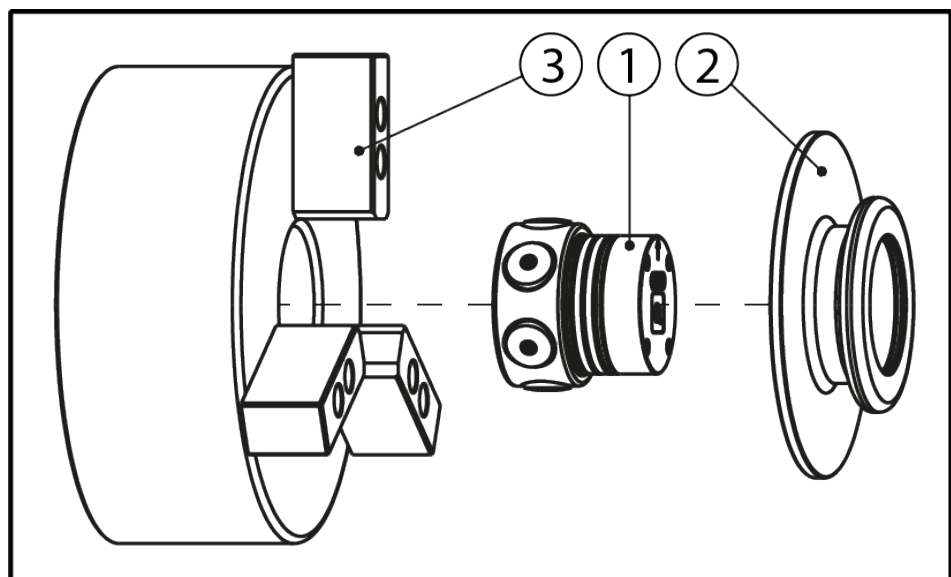
4.3.3.7 Exporting measurement data

For data backup, the current measurement data can be exported from the tablet. All of the individual measurement values can be exported from the recordings (item 3 on the start screen) or the data of several measurements for each machine – clamping device combination via the clamping device history (item 2 on the start screen). The measurement data file must be stored on a suitable external RAM data carrier. In addition to the measured values (clamping force/speed of rotation/temperature), the chuck type and serial number parameters as well as other optional parameters are also saved. SCHUNK recommends importing the data into an Excel spreadsheet via the "Data" tab using the "From Text/CSV" function. In the following import window, select the "Do not determine data types" option in the data type detection selection field.

4.3.4 Measuring procedure

4.3.4.1 Clamping force measurement without speed of rotation measurement

The clamping force can be determined with the measuring head for 2, 3, and 6-jaw chucks (and more with optional accessories). The sequence is explained using the example of a 3-jaw chuck and can similarly be applied to other lathe chucks. The insertion aid serves as a flat work surface on the jaws of the clamping device and protects the operator from injuries caused by crushing. When the clamping device is clamped, the insertion aid can be removed.



- | | |
|---|------------------|
| 1 | Measuring head |
| 2 | Insertion aid |
| 3 | Clamping devices |

⚠ WARNING

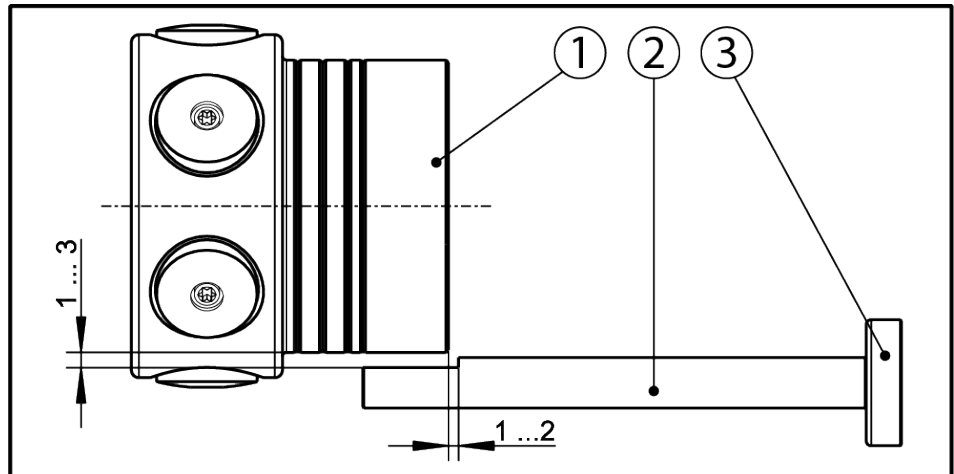
Danger of crushing!

- Do not reach between moving parts (measuring head and jaw).
- Use an insertion aid for protection.



4.3.4.2 Clamping force measurement with speed of rotation measurement

For clamping force measurement with speed of rotation measurement, the additional stand is necessary. This needs to be fitted close to the clamping head and secured to a fixed component of the machine during the speed of rotation measurement. The stand has a magnetic base for mounting. The distances between stand and measuring head are shown in the illustration.



- 1 Measuring head
- 2 Stand
- 3 Magnetic base



⚠ WARNING

Rotating parts!

When measuring during speed of rotation, the insertion aid must be removed before switching on the machine!



⚠ WARNING

Rotating parts!

When measuring during speed of rotation, the measuring head must be clamped firmly and plane-parallel to the axis of rotation.



⚠ WARNING

Rotating parts!

The charging cable must be removed from the measuring head during the measurement!

5 Calibration and recalibration

Before delivery the measuring head is carefully checked and calibrated at the factory. A calibration certificate is enclosed with the measuring instrument.

To ensure the measuring accuracy, the measuring head must be recalibrated annually. For this, the measuring head must be sent to SCHUNK with the tablet and case.

In case of strong zero drift due to material fatigue or overload, recalibration is necessary.

NOTICE

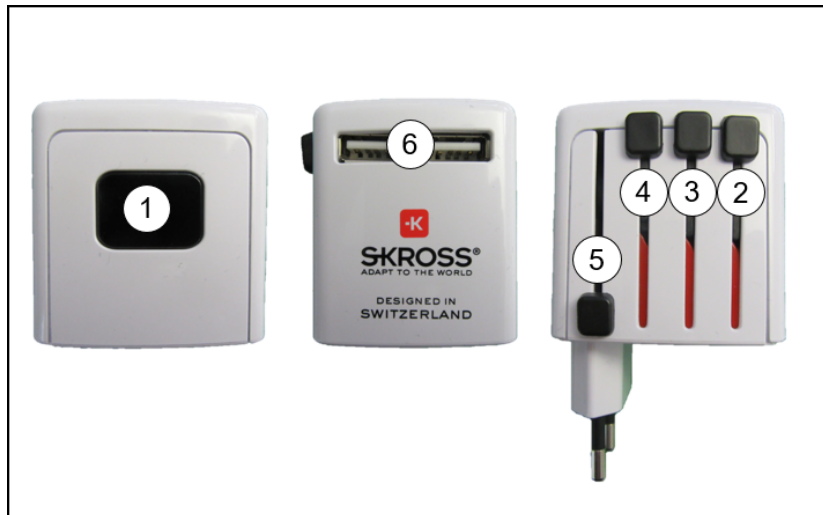
The SCHUNK IFT clamping force tester may not be serviced by the customer!

6 Charging adapter

With the "World USB Charger" charging adapter, the measuring head and the tablet can be charged in over 220 countries around the world.

Application:

- Before use, push the desired slide (2-5) forward until it snaps in (click).
- Connect the USB device to the charger.
- Connect the charger to the mains.
- After use, press the release button and move the slide fully to its initial position.



- | | |
|---|---|
| 1 | Unlock button |
| 2 | Slide for country-specific plugs – USA, Japan |
| 3 | Slide for country-specific plugs – Australia, China |
| 4 | Slide for country-specific plugs – UK |
| 5 | Slide for country-specific plugs – Euro |
| 6 | Dual USB output |

Technical data:

Input voltage	100 V – 250 V
Protection class	II
Output	5V / 2400 mA, 2x USB, shared

⚠ WARNING

Charger for temporary use!

Disconnect from the power supply after use.

⚠ WARNING

Do not expose the charger to liquids or humidity!

⚠ WARNING

Do not use with damaged housing!



7 Accessories

7.1 Measuring on compensating 4-jaw clamping devices

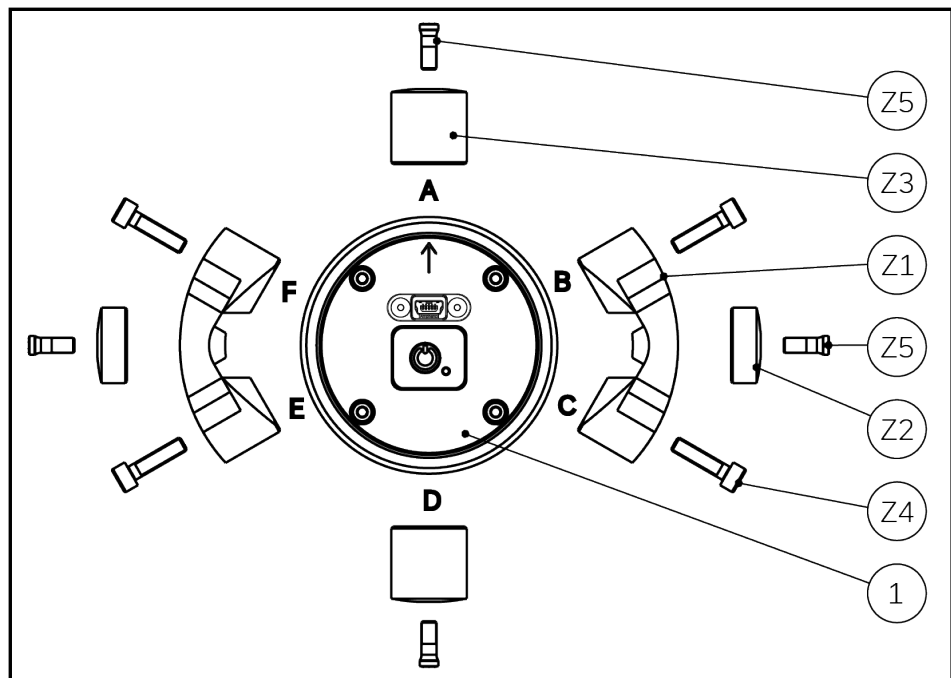
The standard measuring head covers the measurement on clamping devices with 2, 3, and 6 jaws. A measurement on a compensating clamping device with 4 jaws (e.g. ROTA-M flex 2+2) can be done using the optionally available set (mat. no. 1452686). To do so, the standard measuring head is used without intermediate stops.



⚠ WARNING

Use only possible with compensating clamping devices (e.g. ROTA-M flex 2+2). Measuring on clamping devices with 4 jaws without integrated compensation leads to inconsistent results.

7.1.1 Scope of delivery



Position	Description	Number of units
1	Measuring head	1
Z1	Bridge element	2
Z2	Adapter Ø20, long	2
Z3	Adapter Ø20, short	2
Z4	Screws for bridge element	4
Z5	Screws for adapter	4

7.1.2 Assembly

- Disassembly of the standard intermediate stops at the end points.
- Assembly of the adapter (item Z3) at end point "A" with screw (item Z5).

NOTICE

No bridge element may be screwed on at end point "A" ("arrow" mark, see ▶ 4.2.1 [□ 12]).

- Assembly of the adapter (pos. Z3) at end point "D2" with screw (pos. Z5).
- Assembly of the bridge elements (pos. Z1) at end point "B" – "C" and "E" – "F" with screws (pos. Z4).
- Assembly of the adapter (pos. Z2) in the center of the bridge element with screw (pos. Z5).

7.1.3 Clamping force measurement

Clamping force measurement is done identically to measuring the clamping force on 2, 3, and 6-jaw chucks ▶ 4.3.4 [□ 21].

Select the "4-jaw" clamping method in the settings ▶ 4.3.3.1 [□ 17] to correctly calculate the overall clamping force. The diameter for clamping force measurement is $\varnothing 96$ mm.

7.2 Extension set for large clamping diameters for 2-/3-/6-jaws

The standard measuring head covers the measurement of clamping diameters $\varnothing 72$ / $\varnothing 96$ / $\varnothing 136$. For larger clamping diameters, the extension set (ID no.: 1498512) must be used.



⚠ WARNING

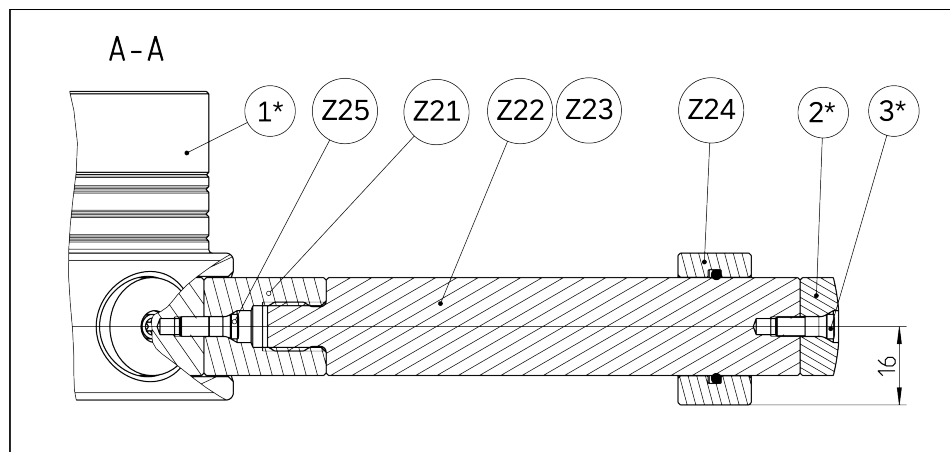
The maximum clamping forces indicated on the measuring head must not be exceeded.



⚠ WARNING

Only static clamping force measurement is allowed! During the measurement with the extension set, the chuck must not be operated under speed of rotation.

7.2.1 Scope of delivery



Position	Designation	Number of units
1*	IFT measuring head	0 (1)
Z21	Adapter	6
Z22 / Z23	Extension 1 / 2	6 / 6
Z24	Spacer	3
2*	Clamping insert	0 (6)
3*	Screw	0 (6)
Z25	Screw	6

* marked items are not included in the scope of delivery of the extension set. These can be found in the standard IFT.

7.2.2 Assembly

- Disassembly of the standard clamping inserts at the end stops
- Mounting the adapters (Item Z21) with screw (Item Z24). The number must be adapted to the respective clamping device (2-13-16-jaws)
- Mounting of extensions (Item Z22) (possible clamping diameters see table)



⚠ WARNING

The extensions (Item Z22) must be screwed onto the adapter (Item Z21) as far as the stop.

Risk of damage in case of non-compliance!

- Mounting of the standard clamping inserts (Item 2) with the screws (item 3) (for possible clamping diameters see table).
- Positioning of the spacer (2x180° / 3x120°) on the extensions Item Z22).

Clamping diameter

	VI	VII
A1	53 mm	53 mm
A2	97 mm	47 mm
A3 I	8 mm	8 mm
A3 II	20 mm	20 mm
A3 III	40 mm	40 mm
Measuring diameter I	316 mm	216 mm
Measuring diameter II	340 mm	240 mm
Measuring diameter III	380 mm	280 mm

7.2.3 Clamping force measurement

Clamping force measurement is done identically to measuring the clamping force on 2, 3, and 6-jaw chucks ▶ 4.3.4 [21].



⚠ WARNING

The maximum clamping force of the IFT measuring head must not be exceeded!

Risk of damage in case of non-compliance!



⚠ WARNING

Only static clamping force measurement is allowed! During measurement with the extension set, the chuck must not be operated under speed.

- Insert the clamping force measuring device plane-parallel to the chuck face. To do this, place the magnetic spacers on the chuck face (2 x 180°/3 x 120°)
- The radial position of the magnetic spacers can be varied
- Align the clamping points of the measuring head centrally to the jaws
- Carry out the measurement according to ▶ 4.3.4 [21]

8 EU Declaration of Conformity

in accordance with Directive 2014/30/EU (electromagnetic compatibility), Annex IV of the European Parliament and Council of 26 February 2014.

The manufacturer bears sole responsibility for issuing this EU declaration of conformity.

Hersteller/
Inverkehrbringer H.-D. SCHUNK GmbH & Co. Spanntechnik KG
Lothringer Str. 23
D-88512 Mengen

We hereby declare that the product described below is in conformity with the essential health and safety requirements of Directive 2014/30/EU in its design and construction and in the version placed on the market by us at the time of this declaration. The declaration is rendered invalid if modifications are made to the product.

Product designation Assembly and Operating Manual / SCHUNK IFT

ID number \$Additional company details\$

The subject of the declaration described above complies with the following harmonization legislation:

2011/65/EU RoHS Directive

European harmonized standards applied:

EN 61000-6-2: 2016-05 Electromagnetic compatibility (EMC) –
Generic standards – Immunity for industrial environments

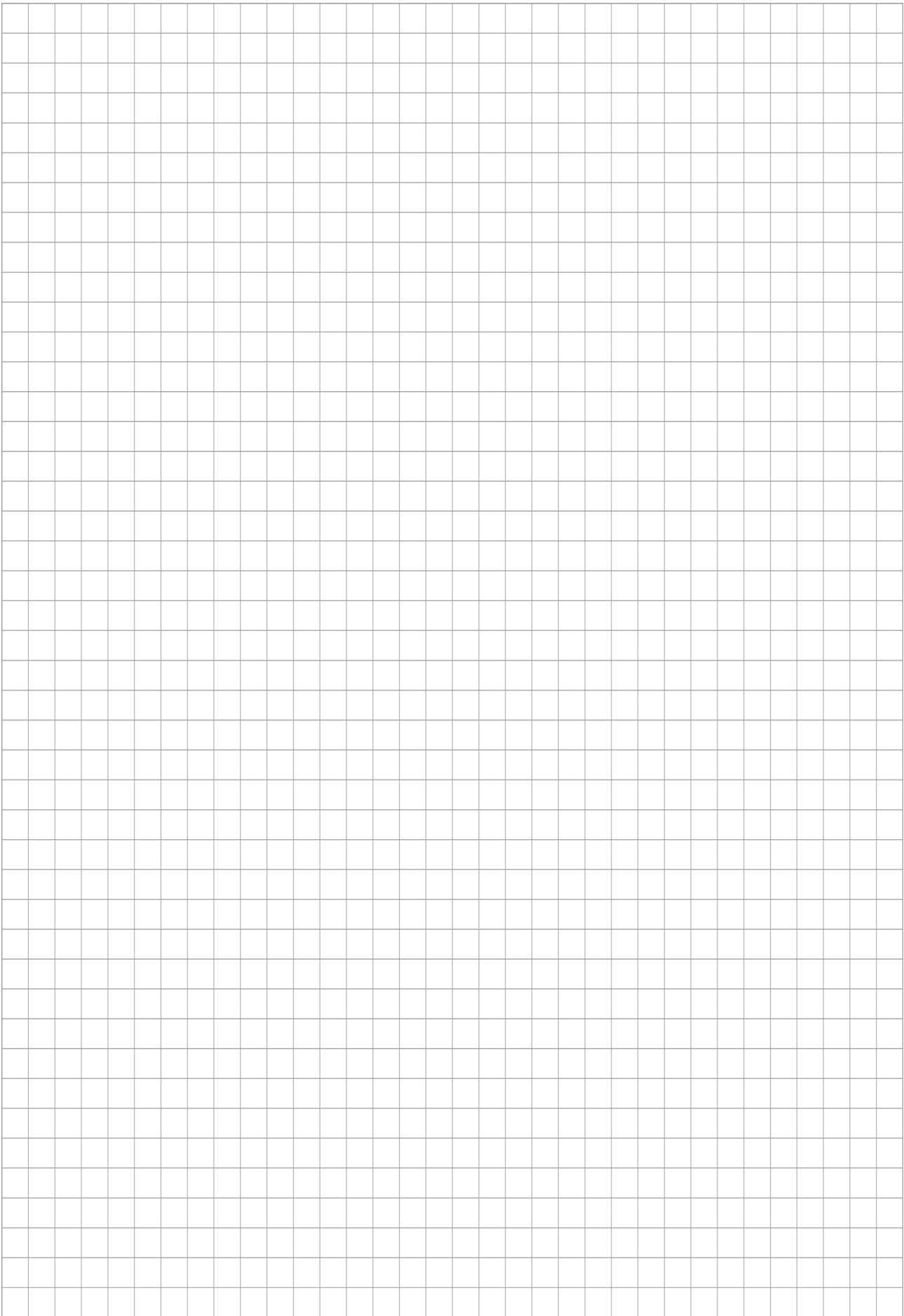
EN 61000-3-3: 2011-09 Electromagnetic compatibility (EMC) –
Generic standards– Interference emissions in residential,
commercial, industrial and light industrial environments

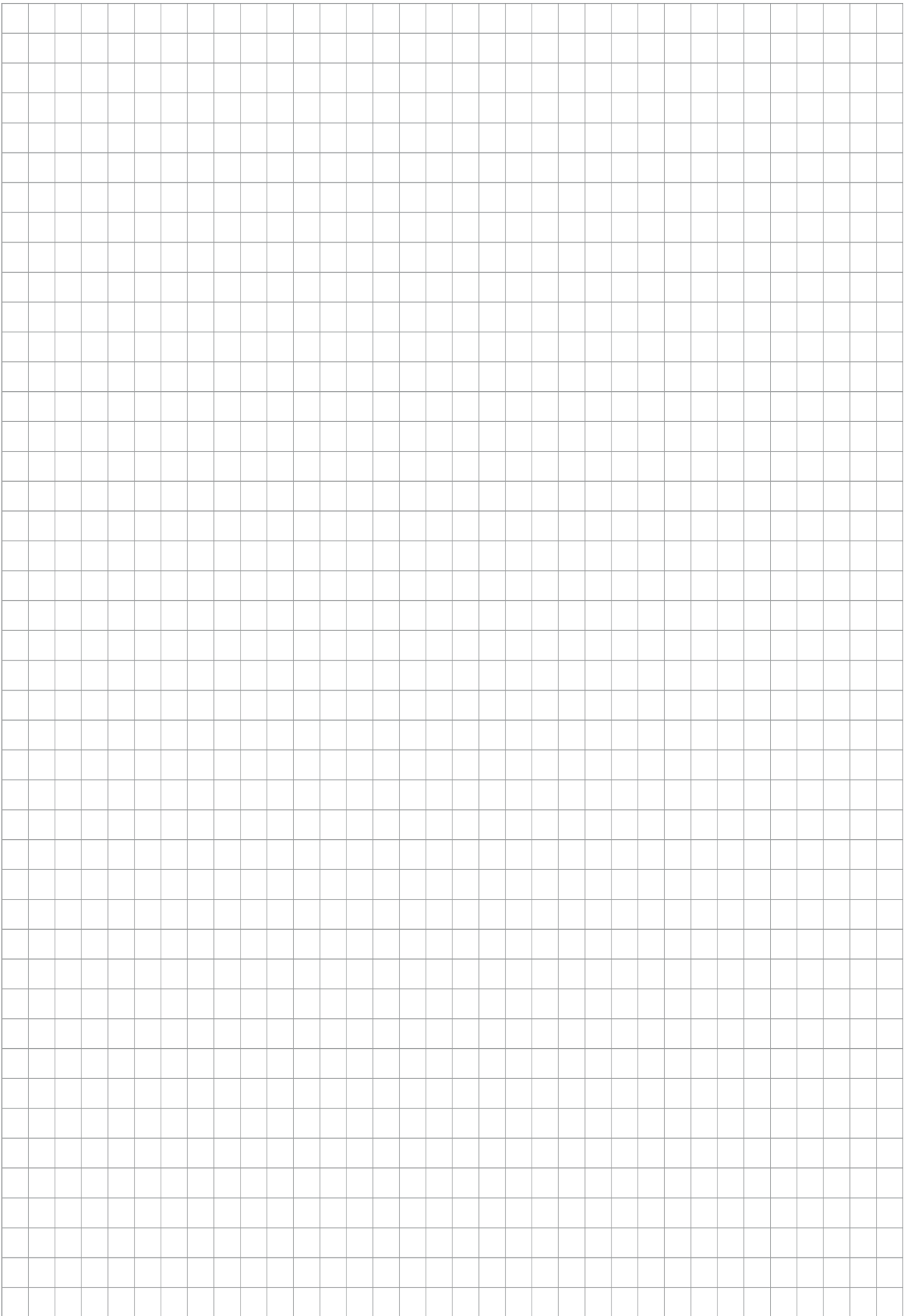
Person authorized to compile the technical documentation:
Philipp Schröder, Address: see manufacturer's address

Signature: see original declaration

Mengen, October 2022

p.p. Philipp Schröder; Head of Engineering Design







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