

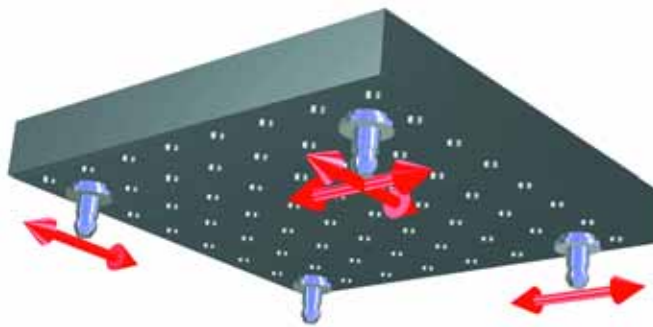


The critical contrasts between "stable clamping" and the required "flexibility for heat expansion" have been ideally solved with the Stark zero point mounting system.

There are 3 different retraction nipples:

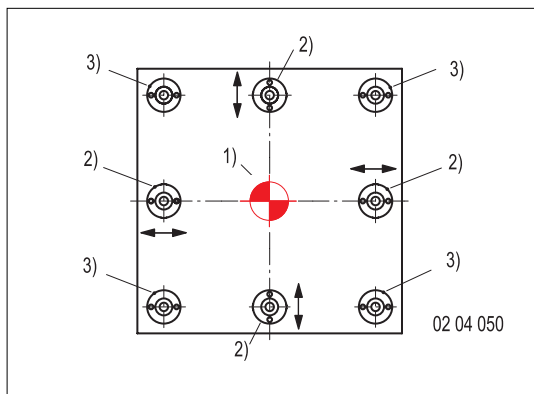
- a) Retraction nipple with zero point
- b) Retraction nipple with equalizer
- c) Retractable nipple without centering that can solve this problem.

Independent of the size of the pallet during the processing there is always the same zero point. The position of the retraction nipple with the zero point can be determined by yourself.

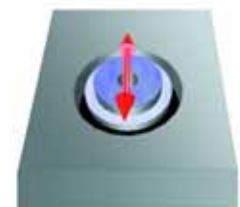
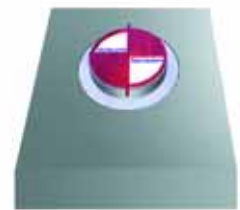


Examples:

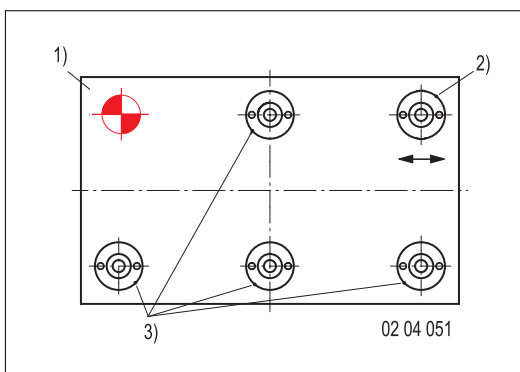
Here the retraction nipple with the zero point is in the middle of the pallet.



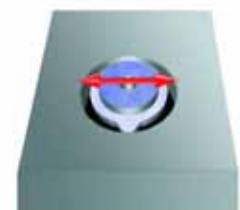
- 1) Retractable nipple with centering
- 2) Retractable nipple with equalizer
- 3) Retractable nipple without centering



Here the retraction nipple with the zero point is in the upper left corner of the pallet.



- 1) Retractable nipple with centering
- 2) Retractable nipple with equalizer
- 3) Retractable nipple without centering

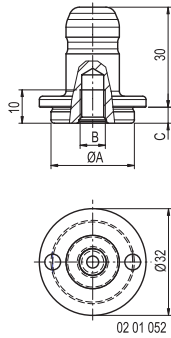


Retractable nipples



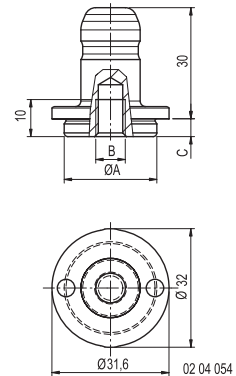
STARK

Retractable nipple with zero point for SPEEDY 1000



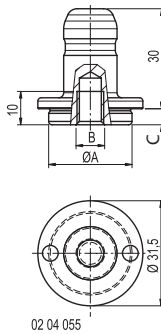
Order no.	ØA	B	C
804 209	25	M 8	4,8
804 219	16	M 8	4,8
804 226	25	M 8	19,8
804 228	16	M 8	19,8

Retractable nipple with equalizer for SPEEDY 1000



Order no.	ØA	B	C
804 230	25	M8	4,8
804 232	16	M8	4,8
804 234	25	M8	19,8
804 236	16	M8	19,8

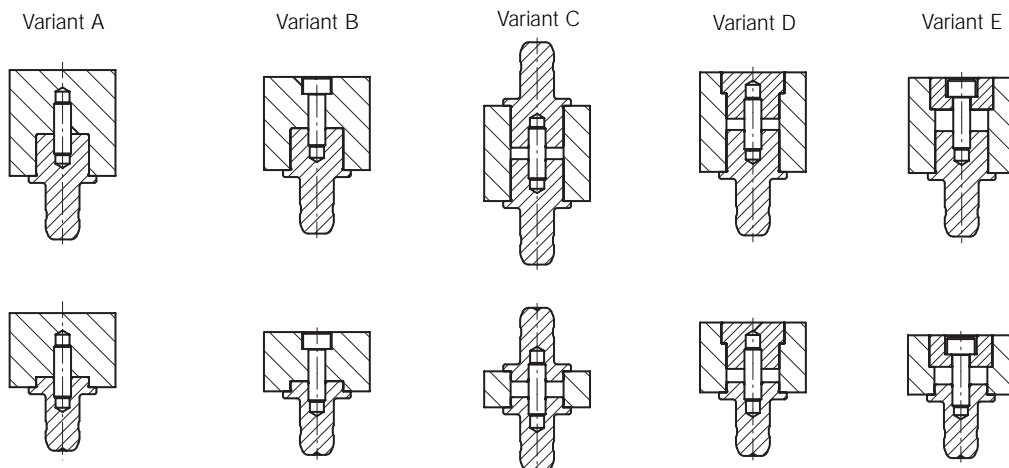
Retractable nipple without centering for SPEEDY 1000



Order no.	ØA	B	C
804 238	25	M8	4,8
804 240	16	M8	4,8
804 242	25	M8	19,8
804 244	16	M8	19,8

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Mounting examples



A and C are not possible with compensating variants.

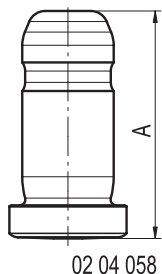
Retractable nipples



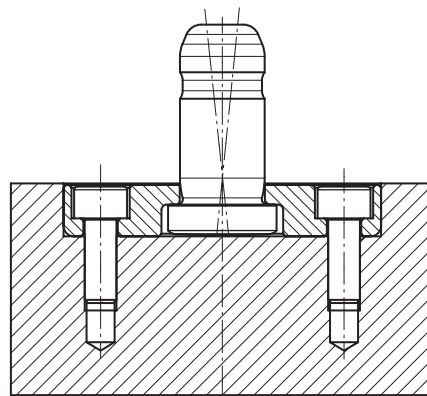
STARK

Retractable nipple for SPEEDY 1000 with flange

Mounting example - retractable nipple with flange



02 04 058



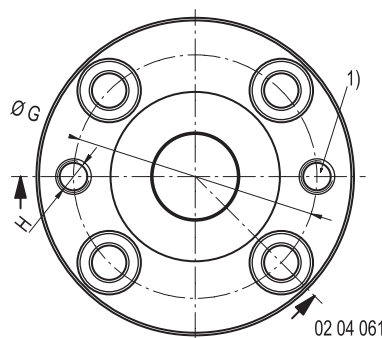
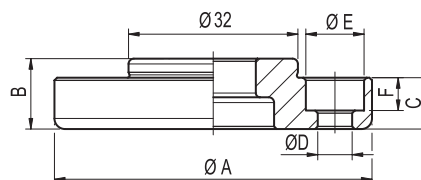
02 04 057

Order no.	A	suitable for
801 004	39,8	Flange \varnothing 60 SPEEDY 1000
801 009	44,8	Flange \varnothing 68 SPEEDY 1000

The retractable nipple is mounted flexibly to prevent jamming during a change of pallet (especially for heavy work pieces and large pallettes). It is used for the retraction phase of the pallet or workpiece only. Positioning and centering are done through zero point and equalization flange.

Zero point flange for SPEEDY 1000

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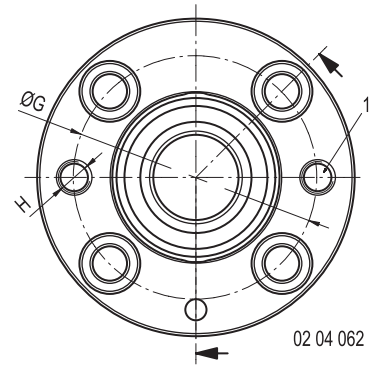
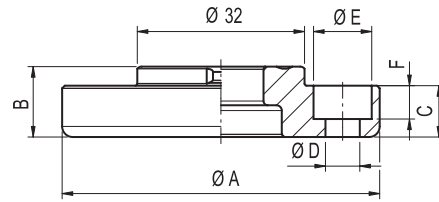
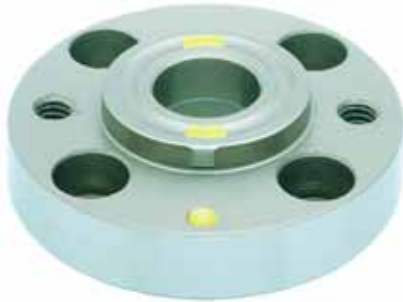
02 04 061

1) Tapped holes for extracting the press fit flange

Order no.	\varnothing A	B	C	\varnothing D	\varnothing E	F	\varnothing G	H	suitable for
801 006	60	13,3	9,7	6,5	11	6,3	46	M6	SPEEDY 1000
801 010	68	18,3	14,7	8,5	13,5	8,2	50	M8	SPEEDY 1000



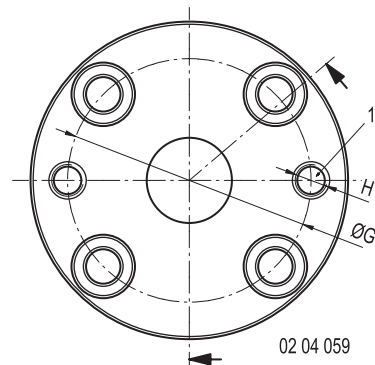
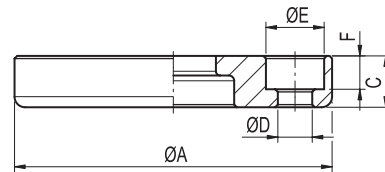
Equalizing flange for SPEEDY 1000



1) Tapped holes for extracting the press fit flange

Order no.	ØA	B	C	ØD	ØE	F	ØG	H	suitable for
801 007	60	13,3	9,7	6,5	11	6,3	46	M6	SPEEDY 1000
801 011	68	18,3	14,7	8,5	13,5	8,2	50	M8	SPEEDY 1000

Retraction flange for SPEEDY 1000

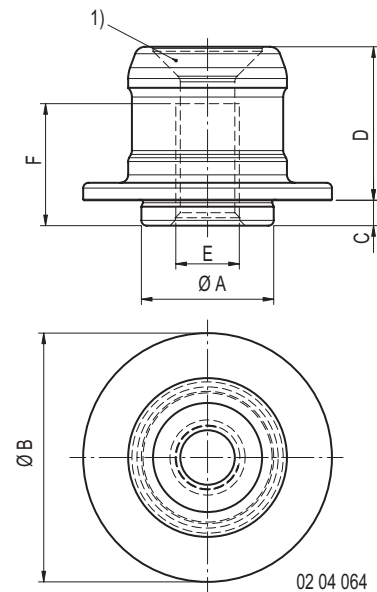


1) Tapped holes for extracting the press fit flange

Order no.	ØA	C	ØD	ØE	F	ØG	H	suitable for
801 008	60	9,7	6,5	11	6,3	46	M6	SPEEDY 1000
801 012	68	14,7	8,5	13,5	8,2	50	M8	SPEEDY 1000



Retractable nipple with zero point for SPEEDY 2000, 3000



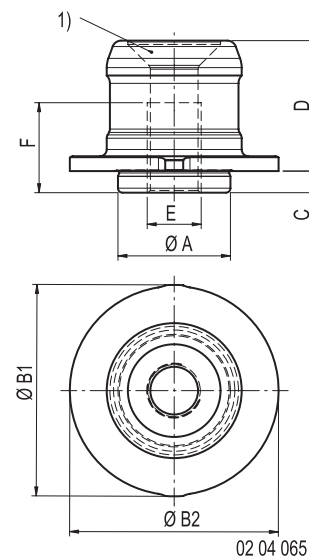
1) Recess for countersunk bolt DIN 7991

Order no.	ØA	ØB	C	D	E	F	Hexagon socket screw	Tightening torque [Nm]	suitable for
804 470	25	47	4,8	29	M12	20	M10 DIN 7991 / 10.9	45	SPEEDY 2000
804 474	25	47	14,8	29	M12	20	M10 DIN 7991 / 10.9	45	SPEEDY 2000
804 290	32	65	7,8	46	M16	25	M12 DIN 7991 / 10.9	75	SPEEDY 3000
804 291	25	65	7,8	46	M16	25	M12 DIN 7991 / 10.9	75	SPEEDY 3000

Other diameters (Ø A) upon request.

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Retractable nipple with equalizer for SPEEDY 2000, 3000



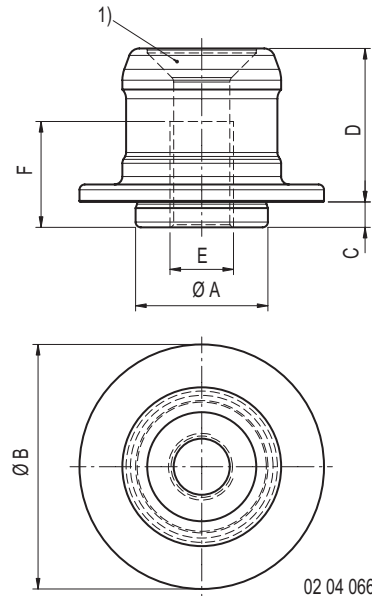
1) Recess for countersunk bolt DIN 7991

Order no.	ØA	ØB1	ØB2	C	D	E	F	Hexagon socket screw	Tightening torque [Nm]	suitable for
804 471	25	47	46,4	4,8	29	M12	20	M10 DIN 7991 / 10.9	45	SPEEDY 2000
804 476	25	47	46,4	14,8	29	M12	20	M10 DIN 7991 / 10.9	45	SPEEDY 2000
804 292	32	65	64,2	7,8	46	M16	25	M12 DIN 7991 / 10.9	75	SPEEDY 3000
804 293	25	65	64,2	7,8	46	M16	25	M12 DIN 7991 / 10.9	75	SPEEDY 3000

Other diameters (Ø A) upon request.



Retractable nipple without centering for SPEEDY 2000, 3000

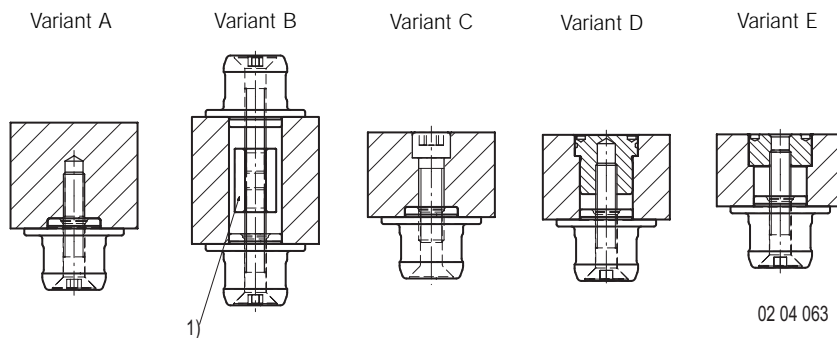


1) Recess for countersunk bolt DIN 7991

Order no.	$\varnothing A$	$\varnothing B$	C	D	E	F	Hexagon socket screw	Tightening torque [Nm] A,B,D,E C	suitable for
804 472	25	46,2	4,8	29	M12	20	M10 DIN 7991 / 10.9	45 55	SPEEDY 2000
804 478	25	46,2	14,8	29	M12	20	M10 DIN 7991 / 10.9	45 55	SPEEDY 2000
804 294	32	64	7,8	46	M16	25	M12 DIN 7991 / 10.9	75 110	SPEEDY 3000
804 295	25	64	7,8	46	M16	25	M12 DIN 7991 / 10.9	75 110	SPEEDY 3000

Other diameters ($\varnothing A$) upon request.

Mounting examples



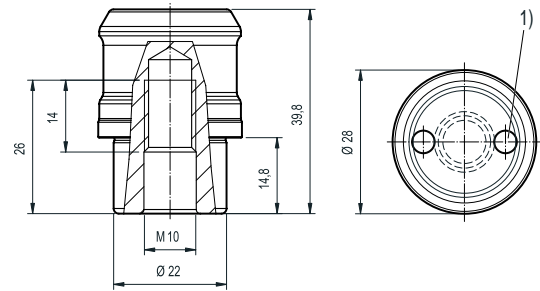
1) Nut DIN 6334

Retractable nipples



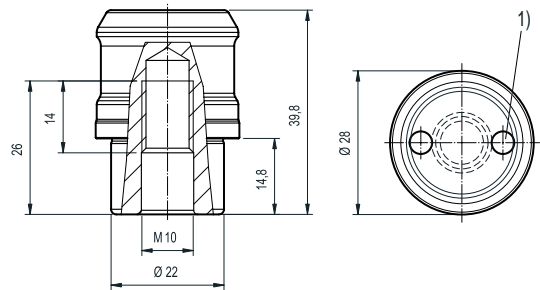
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Retractable nipple with zero point for SPEEDY Sweeper 2000



Order no.	Description
804 490	Retractable nipple with zero point

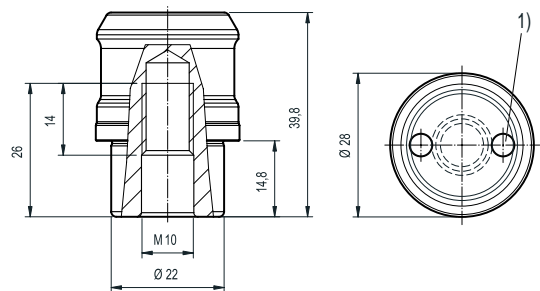
Retractable nipple with equalizer for SPEEDY Sweeper 2000



Order no.	Description
804 495	Retractable nipple with equalizer

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Retractable nipple without centering for SPEEDY Sweeper 2000



Order no.	Description
804 485	Retractable nipple without centering

1) For insertion, use the retractable nipple key!
Tightening torque 75 Nm

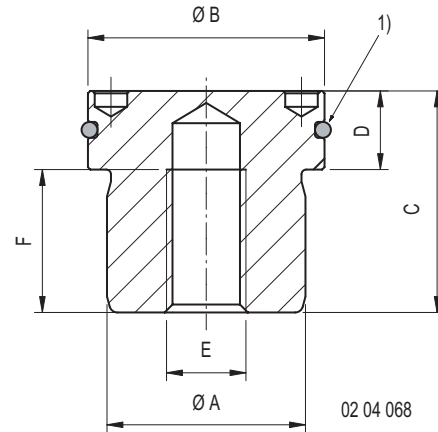
Retractable nipple key

Order no.	Description
804 247	Retractable nipple key to tighten the <i>Sweeper</i> nipples





Nipple fastening for variant D



1) O-ring

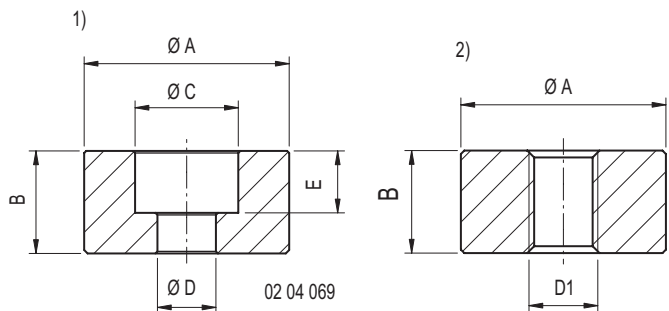
Order no.	ØA	ØB	C	D	E	F	suitable for
804 252	25	29,8	21,9	9,9	M8	13	SPEEDY 1000
804 253	16	19,8	21,9	9,9	M8	13	SPEEDY 1000
804 267	25	29,8	21,9	9,9	M10	13	SPEEDY 2000
804 262	32	37,8	27,9	9,9	M12	18	SPEEDY 3000
804 263	25	29,8	27,9	9,9	M12	18	SPEEDY 3000

Nipple fastening for variant E



1) for Speedy 1000

2) for Speedy 2000 and 3000



Order no.	ØA	B	ØC	ØD	F	suitable for
804 250	29,8	14,9	15	8,5	9	SPEEDY 1000
804 251	19,8	14,9	15	8,5	9	SPEEDY 1000
804 249	34,8	14,9	15	8,5	9	SPEEDY 1000
804 266	29,8	14,9	-	M10	-	SPEEDY 2000
804 264	37,8	17,9	-	M12	-	SPEEDY 3000
804 265	29,8	17,9	-	M12	-	SPEEDY 3000