



- Holding, clamping and braking of round material
- Wide choice of variants
- Any assembly position

# Clamping cartridges/units

Key features

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## At a glance

- The clamping cartridges/clamping units use spring force to hold round material in any desired position.
- Able to stop and hold material for long periods, even in applications involving varying loads, fluctuating operating pressure and system leaks.
- The clamping force is released by pressurising the clamping mechanism.
- Clamping cartridges and clamping units can be mounted in any position.
- They are not suitable for use as positioning devices.
- The clamping cartridge KP and the clamping units KPE, KEC, KEC-S are discrete components and are not intended for use as attachments for pneumatic cylinders.
- In their clamped state, the clamping cartridges and clamping units are not free of backlash when their piston rods are subjected to alternating loads.

## Selection aid

### Clamping cartridge KP

→ 1 / 10.5-4



- For in-house assembly of clamping units
- Not certified for use in safety-relevant control systems

### Clamping unit KPE

→ 1 / 10.5-6



- Ready-to-install combination of clamping cartridge KP and housing
- Versatile mounting options  
→ 1 / 10.5-7
- Not certified for use in safety-relevant control systems

### Clamping unit KEC

→ 1 / 10.5-8



- **For use as holding device (static application):**
  - Holding and clamping in the event of a power failure
  - Protection against pressure failure and pressure drop
  - Securing the piston rod during intermediate stops for process operations
- Mounting hole pattern to ISO 15552 (DIN ISO 6431)
- Not certified for use in safety-relevant control systems

### Clamping-unit cylinder KEC-...-S, for safety-related applications

→ 1 / 10.5-10



- **For use as holding device (static application):**
  - Holding and clamping in the event of a power failure
  - Protection against pressure failure and pressure drop
  - Securing of the piston rod during intermediate stops for process operations
- **For use as a braking device (dynamic application):**
  - Braking or stopping of movements
  - Suspension of movement upon entering a danger area
- Mounting hole pattern to ISO 15552 (DIN ISO 6431)
- When used as a braking device, the overtravel must be checked regularly
- For use in category 1 control systems to DIN EN 954-1 ("reliable component"). For use in higher categories, additional control measures are required
- Certified for use in safety-relevant control systems by the BG-Institute for Occupational Safety and Health (Berufsgenossenschaftlichen Institut für Arbeitssicherheit – BGIA) in Germany
- Products intended for use in safety-related applications must be selected, sized and arranged in accordance with the risk assessment (EN1050) as well as any other valid standards and regulations.

# Clamping cartridges/units

Key features and type codes

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## Requirements for the round material to be clamped

- Hardened steel:  
min. HRC 60 or hard-chromium  
plated, coating thickness  
min. 20 µm.
- Rolled steel:  
tensile strength > 650 N/mm<sup>2</sup>,  
hardness (HB30) > 175
- The nominal diameter must lie in  
the tolerance zone h8.
- The surface roughness R<sub>max</sub> must  
not exceed 2.5 µm.
- The specified holding forces refer  
to a static load. If these values are  
exceeded, slippage may occur.
- Dynamic forces occurring during  
operation must not exceed the  
static holding force.

## Type codes

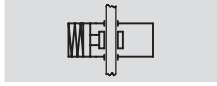
		KP	–	4	–	80	–	
<b>Type</b>								
KP	Clamping cartridge							
KPE	Clamping unit							
KEC								
<b>Round material to be clamped Ø [mm]</b>								
<b>Static holding force [N]</b>								
<b>Certification</b>								
S	Certified for use in safety-relevant control systems by the BG-Institute for Occupational Safety and Health (Berufsgenossenschaftlichen Institut für Arbeitssicherheit – BGIA) in Germany							

# Clamping cartridges KP

Technical data

FESTO

## Function



- Ø - Diameter of round material to be clamped:  
4 ... 32 mm
- ≡ - Force  
80 ... 7,500 N



Note

Additional measures are required for use in safety-related control systems; in Europe, for example, the standards listed under the EC Machinery Directive must be observed. Without

additional measures in accordance with statutory minimum requirements, the product is not suitable for use in safety-related sections of control systems.

General technical data										
For round material Ø	4	6	8	10	12	16	20	25	32	
Pneumatic connection	M5					G1/8				
Design	Tilting wedge mechanism									
Type of mounting	Via self-configured housing									
Clamping type with effective direction	At both ends									
	Clamping via spring force, air to release									
Static holding force [N]	80	180	350	350	600	1,000	1,400	2,000	5,000	7,500
Min. release pressure [bar]	3									
Assembly position	Any									
Product weight [g]	10	15	50	50	50	90	170	170	700	1,600

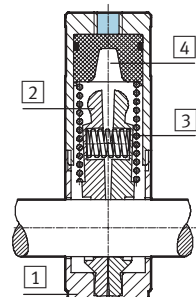
Operating and environmental conditions	
Operating medium	Filtered compressed air, lubricated or unlubricated
Operating pressure [bar]	≤ 10
Ambient temperature [°C]	-10 ... +80
Corrosion resistance class CRC <sup>1)</sup>	2

1) Corrosion resistance class 2 according to Festo standard 940 070

Components requiring moderate corrosion resistance. Externally visible parts with primarily decorative surface requirements which are in direct contact with a normal industrial environment or media such as coolants or lubricating agents.

## Materials

### Sectional view



Clamping cartridge		
1	Body	Anodised aluminium
2	Clamping plates	Brass
3	Spring	Spring steel
4	Piston	Polyacetal
-	Seals	Nitrile rubber, polyurethane

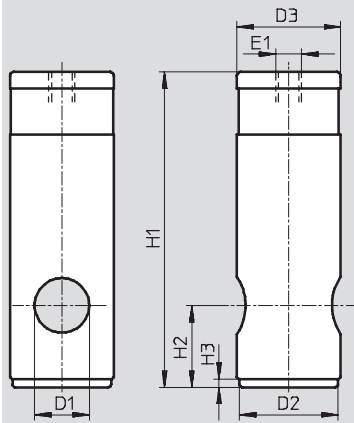
# Clamping cartridges KP

Technical data

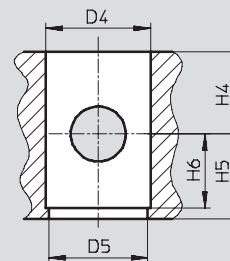
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## Dimensions and ordering data

Download CAD data → [www.festo.com/en/engineering](http://www.festo.com/en/engineering)



## Installation dimensions



Note

When installing the clamping cartridge in a housing, plain bearings must be installed on both sides of this housing.

For Ø [mm]	D1 Ø	D2 Ø h12	D3 Ø f9	D4 Ø D9	D5 Ø	E1	H1	H2
4	4	10	12	12	11	M5	28	7
6	6	14	16	16	15	M5	35	10
8	8	18	20	20	19	M5	62	17.5
10	10	18	20	20	19	M5	62	17.5
12	12	18	20	20	19	M5	62	17.5
16	16	22	24	24	23	G $\frac{1}{8}$	83	22
20	20	28	30	30	29	G $\frac{1}{8}$	100	25
	20	36	38	38	37	G $\frac{1}{8}$	115.5	30
25	25	46	48	48	47	G $\frac{1}{8}$	155	36
32	32	63	65	65	64	G $\frac{1}{8}$	195	55

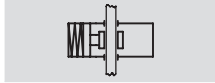
For Ø [mm]	H3	H4 min.	H5 min.	H6	Max. axial backlash of clamped round material	Weight [g]	Part No.	Type
4	2	9	7	6	0.2	10	178 452	KP-4-80
6	3	10	11	8	0.2	15	178 453	KP-6-180
8	3	18	18.5	15.5	0.25	50	178 454	KP-8-350
10	3	18	18.5	15.5	0.25	50	178 455	KP-10-350
12	3	18	18.5	15.5	0.25	50	178 456	KP-12-600
16	3	22	23	20	0.25	90	178 457	KP-16-1000
20	3	25	26	23	0.3	170	178 458	KP-20-1400
	3	30	31	28	0.3	170	178 459	KP-20-2000
25	3	36	37	34	0.3	700	178 460	KP-25-5000
32	3	55	56	53	0.3	1,600	178 461	KP-32-7500

# Clamping units KPE

Technical data

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Function



[www.festo.com/en/  
Spare\\_parts\\_service](http://www.festo.com/en/Spare_parts_service)



- Ø - Diameter  
of round material to be  
clamped:  
4 ... 32 mm

- ≡ - Force  
80 ... 7,500 N

- ≡ - Note

Additional measures are required for  
use in safety-related control systems;  
in Europe, for example, the standards  
listed under the EC Machinery  
Directive must be observed. Without

additional measures in accordance  
with statutory minimum require-  
ments, the product is not suitable for  
use in safety-related sections of  
control systems.

General technical data									
For round material Ø	4	6	8	10	12	16	20	25	32
Pneumatic connection	M5					G1/8			
Design	Tilting wedge mechanism								
Type of mounting	Via mounting thread Via through-holes								
Clamping type with effective direction	At both ends								
	Clamping via spring force, air to release								
Static holding force [N]	80	180	350	350	600	1,000	1,400	5,000	7,500
Max. axial backlash with clamped piston rod without load [mm]	0.2	0.3		0.5			0.7		1
Min. release pressure [bar]	3								
Assembly position	Any								
Product weight [g]	100	150	240	260	270	410	930	2,000	4,600

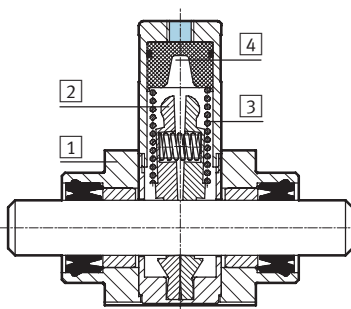
Operating and environmental conditions	
Operating medium	Filtered compressed air, lubricated or unlubricated
Operating pressure [bar]	≤ 10
Ambient temperature [°C]	-10 ... +80
Corrosion resistance class CRC <sup>1)</sup>	2

1) Corrosion resistance class 2 according to Festo standard 940 070

Components requiring moderate corrosion resistance. Externally visible parts with primarily decorative surface requirements which are in direct contact with a normal industrial environment or media such as coolants or lubricating agents.

## Materials

Sectional view



Clamping unit		
1	Housing	Anodised aluminium
2	Clamping plates	Brass
3	Spring	Spring steel
4	Piston	Polyacetal
–	Seals	Nitrile rubber, polyurethane

# Clamping units KPE

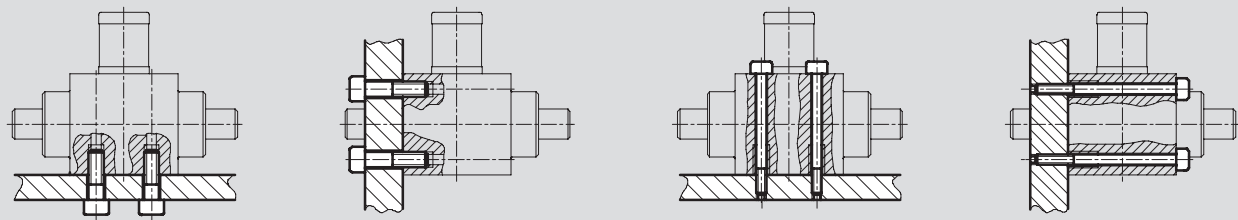
Technical data

FESTO

## Mounting options

Via mounting thread

Via through-holes

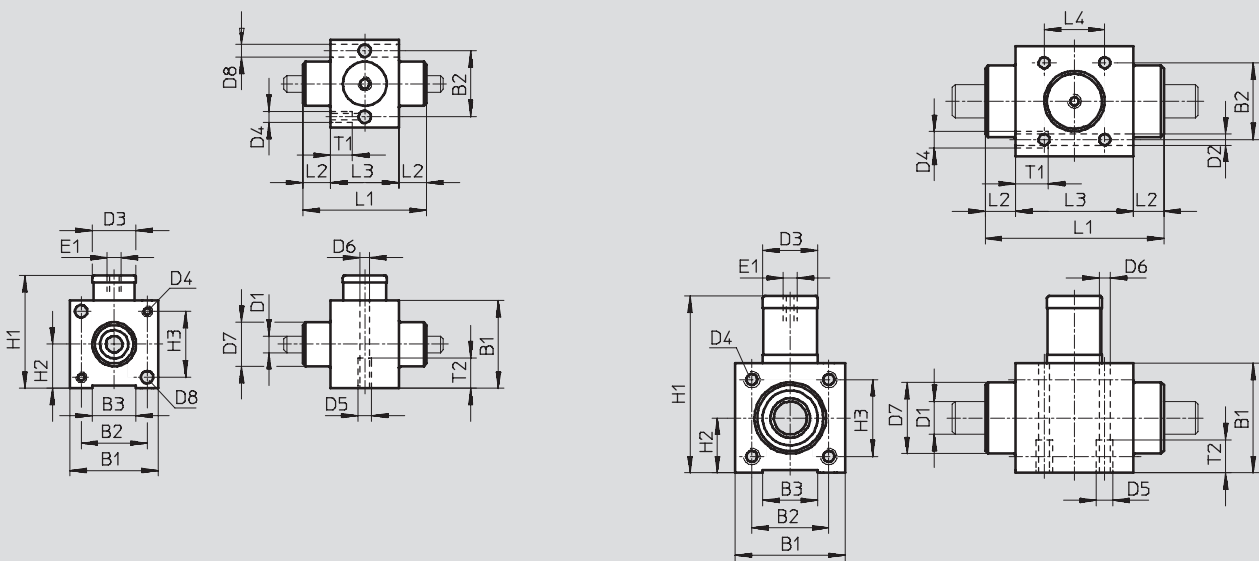


## Dimensions and ordering data

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For round material Ø 4 ... 6 mm

For round material Ø 8 ... 32 mm



For Ø	B1	B2	B3	D1 Ø	D2 Ø	D3 Ø	D4	D5	D6 Ø	D7 Ø d11	D8 Ø	E1	H1	H2
[mm]														
4	27	19.5	12	4	–	12	–	M5	4.2	12	4.5	M5	34.5	13.5
6	32	24	16	6	–	16	–	M5	4.2	16	4.5	M5	41	16
8	36	27	20	8	4.2	20	M5	M5	4.2	22	–	M5	62.5	18
10	36	27	20	10	4.2	20	M5	M5	4.2	22	–	M5	62.5	18
12	40	28	20	12	5.2	20	M6	M6	5.2	28	–	M5	64.5	20
16	45	32.5	25	16	5.2	24	M6	M6	5.2	32	–	G $\frac{1}{8}$	83.5	22.5
20	65	50	38	20	6.5	38	M8	M8	6.5	45	–	G $\frac{1}{8}$	118	32.5
25	88	65	50	25	8.5	48	M10	M10	8.5	55	–	G $\frac{1}{8}$	163	44
32	118	90	70	32	10.3	65	M12	M12	10.3	60	–	G $\frac{1}{8}$	199	59

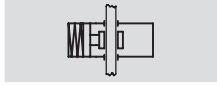
For Ø	H3	L1	L2	L3	L4	T1	T2	Max. axial backlash of clamped round material	Weight [g]	Part No.	Type
[mm]											
4	19.5	33	7.5	18	–	9	11	0.2	100	178 462	KPE-4
6	24	45	10	25	–	9	11	0.2	150	178 463	KPE-6
8	27	58	10	38	20	10	11	0.25	240	178 464	KPE-8
10	27	62	12	38	20	10	11	0.25	260	178 465	KPE-10
12	28	65	11	43	22	12	12	0.25	270	178 466	KPE-12
16	32.5	69	12.5	44	22	12	12	0.25	410	178 467	KPE-16
20	50	83	12.5	58	30	16	16	0.3	930	178 468	KPE-20
25	65	100	15	70	34	20	20	0.3	2,000	178 469	KPE-25
32	90	154	25	104	60	24	24	0.3	4,600	178 470	KPE-32

# Clamping units KEC

Technical data

FESTO

## Function



- Ø - Diameter of round material to be clamped:  
16 ... 25 mm

- ≡ - Force  
1,300 ... 8,000 N



- ≡ - Note

Additional measures are required for use in safety-related control systems; in Europe, for example, the standards listed under the EC Machinery Directive must be observed. Without

additional measures in accordance with statutory minimum requirements, the product is not suitable for use in safety-related sections of control systems.

General technical data			
For round material Ø	16	20	25
Pneumatic connection	G $\frac{1}{8}$	G $\frac{1}{4}$	G $\frac{3}{8}$
Type of mounting	Via accessories → 1 / 10.5-12		
Clamping type with effective direction	At both ends Clamping via spring force, air to release		
Static holding force	1,300	3,200	8,000
Min. release pressure [bar]	3.8		
Assembly position	Any		
Product weight [g]	1,860	4,515	16,760

Operating and environmental conditions	
Operating medium	Filtered compressed air, lubricated or unlubricated
Operating pressure [bar]	3.8 ... 10
Ambient temperature [°C]	-20 ... +80

- ≡ - Note

The specified holding force refers to a static load. If this value is exceeded, slippage may occur. Dynamic forces occurring during operation must not exceed the static holding force if

slippage is to be avoided. The clamping unit is backlash-free in the clamped condition if varying loads are applied to the piston rod.

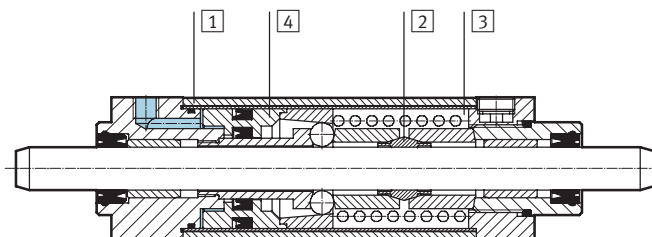
## Activation:

The clamping unit may only be released when equilibrium of forces is present on the piston rod. Otherwise there is a risk of accidents due to the

sudden movement of the piston rod. Blocking off the air supply at both ends (e.g. with a 5/3-way valve) does not provide any safety.

## Materials

### Sectional view



Clamping unit		
1	Housing	Wrought aluminium alloy
2	Clamping jaws	Tool steel
3	Spring	High-alloy steel
4	Piston	Wrought aluminium alloy
–	Seals	Nitrile rubber, polyurethane



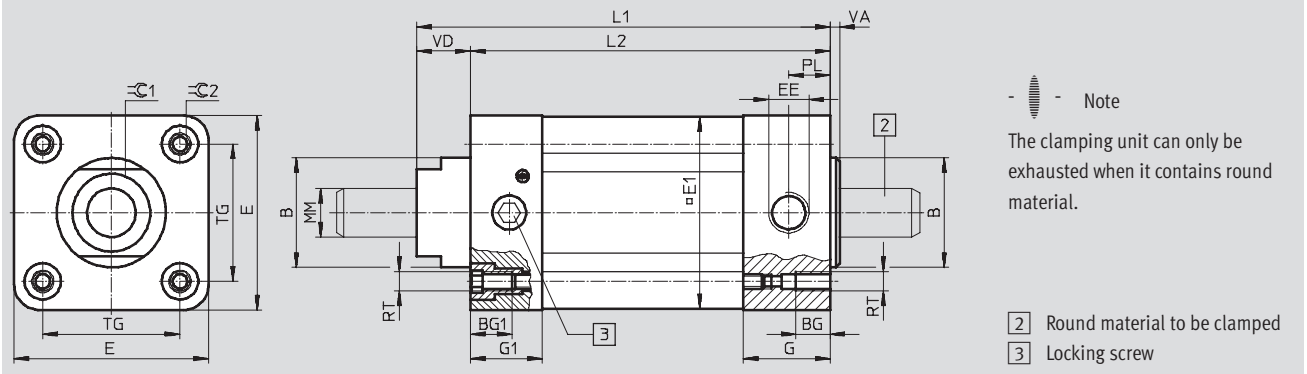
# Clamping units KEC

Technical data

FESTO

## Dimensions and ordering data

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For Ø [mm]	B Ø f8	BG	BG1	E	E1	EE	G	G1	L1	L2	MM Ø
16	35	15	15	54	53	G $\frac{1}{8}$	27	22	178	160	16
20	45	14	17	80	79	G $\frac{1}{4}$	30	29.5	208.5	187	20
25	55	17	17	126	126	G $\frac{3}{8}$	32.5	32.5	287	258	25

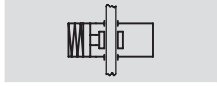
For Ø [mm]	PL	RT	TG	VA	VD	C1	C2	Weight [g]	Part No.	Type
16	13	M6	38	5.5	18	30	6	1,860	527 492	KEC-16
20	15.5	M8	56.5	6	21.5	36	8	4,515	527 493	KEC-20
25	17	M10	89	7	29	41	10	15,600	527 494	KEC-25

# Clamping units KEC-...-S

Technical data

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## Function



Ø - Diameter  
of round material to be  
clamped:  
16 ... 25 mm

≡ - Force  
1,300 ... 8,000 N



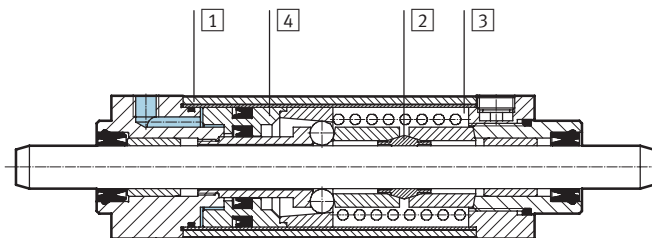
General technical data			
For round material Ø	16	20	25
Pneumatic connection	G $\frac{1}{8}$	G $\frac{1}{4}$	G $\frac{3}{8}$
Type of mounting	Via accessories → 1 / 10.5-12		
Clamping type with effective direction	At both ends Clamping via spring force, air to release		
Static holding force	1,300	3,200	8,000
Min. release pressure [bar]	3.8		
Assembly position	Any		
CE symbol	EU-compliant to directive 98/37/EC (machines)		
Safety category	Cat 1 to DIN EN 954-1		
Certification	BGIA (Berufsgenossenschaftliches Institut für Arbeitssicherheit – BG-Institute for Occupational Safety and Health)		
Product weight [g]	1,860	4,515	15,600

Operating and environmental conditions	
Operating medium	Filtered compressed air, lubricated or unlubricated
Operating pressure [bar]	3.8 ... 8
Max. permissible test pressure [bar]	10
Ambient temperature [°C]	-10 ... +60

<p>⚠ - Note</p> <p>The specified holding force refers to a static load. If this value is exceeded, slippage may occur. Dynamic forces occurring during operation must not exceed the static holding force if</p>			
<p>slippage is to be avoided. The clamping unit is backlash-free in the clamped condition if varying loads are applied to the piston rod.</p>		<p>Activation:</p> <p>The clamping unit may only be released when equilibrium of forces is present on the round material. Otherwise there is a risk of accidents due to the sudden movement of the round material. Blocking off the air supply at both ends (e.g. with a 5/3-way valve) does not provide any safety.</p>	

## Materials

Sectional view



Clamping unit	
1 Housing	Wrought aluminium alloy
2 Clamping jaws	Tool steel
3 Spring	High-alloy steel
4 Piston	Wrought aluminium alloy
- Seals	Nitrile rubber, polyurethane

# Clamping units KEC-...-S

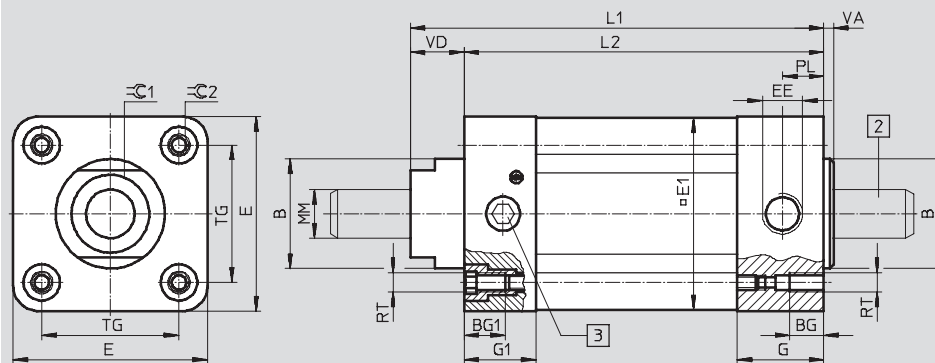
Technical data

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## Dimensions and ordering data

for use in safety-relevant control systems

Download CAD data → [www.festo.com/en/engineering](http://www.festo.com/en/engineering)



Note

The clamping unit can only be exhausted when it contains round material.

- 2 Round material to be clamped
- 3 Locking screw

For Ø [mm]	B Ø f8	BG	BG1	E	E1	EE	G	G1	L1	L2	MM Ø
16	35	15	15	54	53	G $\frac{1}{8}$	27	22	178	160	16
20	45	14	17	80	79	G $\frac{1}{4}$	30	29.5	208.5	187	20
25	55	17	17	126	126	G $\frac{3}{8}$	32.5	32.5	287	258	25

For Ø [mm]	PL	RT	TG	VA	VD	1	2	Weight [g]	Part No.	Type
16	13	M6	38	5.5	18	30	6	1,860	538 242	KEC-16-S
20	15.5	M8	56.5	6	21.5	36	8	4,515	538 243	KEC-20-S
25	17	M10	89	7	29	41	10	15,600	538 244	KEC-25-S



Note

The overtravel is the distance that the round material covers between exhausting of the clamping unit and coming to a standstill. It must be determined by the customer when setting up the machine and be compared with the calculated overtravel

(see DIN EN 999). For use in higher categories than category 1 to DIN 954-1, the overtravel must also be reached in the event of a fault. It is dependent on the environmental conditions and stress, e.g.:

- Operating pressure
- Nominal size of switching valve
- Line length
- Diameter of connecting line to clamping unit
- Load and speed

The overtravel can be reduced by attaching a quick exhaust valve to the supply port of the clamping unit.

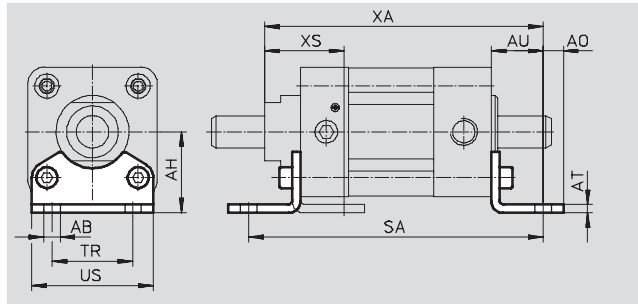
# Clamping units

Accessories

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## Foot mounting HNC

Material:  
Galvanised steel  
Free of copper, PTFE and silicone

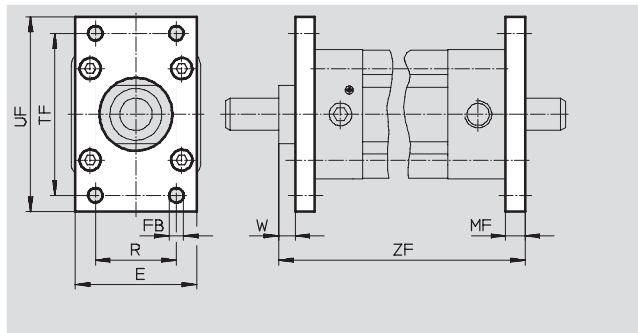


Dimensions and ordering data													
For Ø	AB Ø	AH	AO	AT	AU	SA	TR	US	XA	XS	CRC <sup>1)</sup>	Weight [g]	Part No. Type
[mm]													
16	10	36	9	5	28	216	36	54	206	42	2	180	174 370 HNC-40
20	10	50	12.5	6	32	251	50	75	240.5	48.5	2	405	174 372 HNC-63
25	14.5	71	17.5	6	41	340	75	110	328	64	2	1,000	174 374 HNC-100

- 1) Corrosion resistance class 2 according to Festo standard 940 070  
Components requiring moderate corrosion resistance. Externally visible parts with primarily decorative surface requirements which are in direct contact with a normal industrial environment or media such as coolants or lubricating agents

## Flange mounting FNC

Material:  
Galvanised steel  
Free of copper, PTFE and silicone



Dimensions and ordering data												
For Ø	E	FB Ø	MF	R	TF	UF	W	ZF	CRC <sup>1)</sup>	Weight	Part No.	Type
[mm]		H13								[g]		
16	54	9	10	36	72	90	8	188	2	280	174 377	FNC-40
20	75	9	12	50	100	120	9.5	220.5	2	690	174 379	FNC-63
25	110	14	16	75	150	175	13	303	2	2,400	174 381	FNC-100

- 1) Corrosion resistance class 2 according to Festo standard 940 070  
Components requiring moderate corrosion resistance. Externally visible parts with primarily decorative surface requirements which are in direct contact with a normal industrial environment or media such as coolants or lubricating agents